



SEER 42 AFSN Z6P

APPLICATION

- Suitable for machining of steel and stainless-steel
- Single-sided milling insert SEER 42 with chip-breakers, square for a maximum depth of cut of .2559"



GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K30		S35	
Sfm ft/min	640 - 853	377 - 509	607 - 804		115 - 246	
Fn Inch/Z	0.0079 - 0.0157	0.0087 - 0.0142	0.0079 - 0.0157		0.0079 - 0.0126	
ap Inch	0.039 - 0.256	0.039 - 0.256	0.039 - 0.256		0.039 - 0.205	

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

$S \text{ (RPM)} = Sfm * 12 / \pi / D = \text{rev per minute}$
 $F \text{ (IPR, inch per revolution)} = S * Fn = \text{feed per minute}$
 $F \text{ (IPM, inch per minute)} = S * Fz * n.\text{flutes} = \text{feed per minute}$
 $Sfm = S * D * \pi / 12$

MILLING CARBIDE INSERT

