



SEER 53 AFSN Z6P

APPLICATION

- Suitable for machining of steel and stainless-steel
- Single-sided milling insert SEER 53 with chip-breakers, square for a maximum depth of cut of .3543"



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	607 - 837	361 - 492	574 - 787		115 - 246	
Fn Inch/Z	0.0079 - 0.0157	0.0087 - 0.0142	0.0079 - 0.0157		0.0079 - 0.0126	
ap Inch	0.02 - 0.354	0.02 - 0.354	0.02 - 0.354		0.02 - 0.283	

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT