



SEEN 42 AFSN Z6P



APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert SEEN 42 with a plane rake surface, square for a maximum depth of cut of .2559"

GRADE Z6P

This is a PVD coated fine grained WC-Co carbide suitable for roughing steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		K30			
Sfm ft/min	574 - 820		541 - 771			
Fn Inch/Z	0.0059 - 0.0157		0.0059 - 0.0157			
ap Inch	0.039 - 0.256		0.039 - 0.256			

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 / π / 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 * π / 12