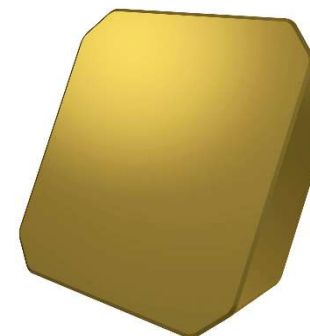




SEEN 43 AFSN Z6P

APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert SEEN 43 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

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

MILLING CARBIDE INSERT