



SEET 13T3 Z2



APPLICATION

- Suitable for machining steel
- Single-sided milling insert SEET 13T3 with chip-breakers, square for a maximum depth of cut of .177"

GRADE Z2

This is a MT-CVD coated WC-Co carbide for machining of steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25					
Sfm ft/min	968 - 1608					
Fn Inch/Z	0.0031 - 0.01					
ap Inch	0.012 - 0.177					

LEGEND

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

FORMULA

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