



# SEET 13T3 Z6P



## APPLICATION

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

## 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	705 - 1099	410 - 656			131 - 328	
Fn Inch/Z	0.0031 - 0.0118	0.0035 - 0.0106			0.0035 - 0.0083	
ap Inch	0.012 - 0.177	0.012 - 0.177			0.012 - 0.142	

### 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**