



SEHT 43 AFSN Z5



APPLICATION

- Suitable for machining of steel and stainless-steel
- Single-sided milling insert SEHT 43 with chip-breakers, square for a maximum depth of cut of .177"

GRADE Z5

This is a PVD TiAlN 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 - 919	410 - 541	656 - 869		131 - 262	
Fn Inch/Z	0.0079 - 0.0157	0.0079 - 0.0142	0.0079 - 0.0157		0.0083 - 0.0142	
ap Inch	0.039 - 0.256	0.039 - 0.256	0.039 - 0.256		0.039 - 0.205	

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

MILLING CARBIDE INSERT

