



SEKN 42 AFSN Z5

APPLICATION

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



GRADE Z5

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K25			H25
Sfm ft/min	623 - 886		591 - 837			115 - 164
Fn Inch/Z	0.0059 - 0.0157		0.0059 - 0.0157			0.0043 - 0.0102
ap Inch	0.039 - 0.256		0.039 - 0.256			0.016 - 0.059

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