



XPHT 160412 Z6P

APPLICATION

- Suitable for machining steel and stainless steel and super alloy
- Single-sided milling insert XPHT 1604 with chip-breakers, 80° rhomboid for a maximum depth of cut of .5906", with .0472" corner radius



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	P25-P50	M20-M40	K20 - K40		S30	
Sfm ft/min	607 - 804	361 - 476	574 - 755		115 - 230	
Fn Inch/Z	.004-.010	.004-.010	.004-.010		.002 - .007	
ap Inch	.039-.512	.039-.512	.039-.512		.039-.409	

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