



ZDEW 120408 Z4



APPLICATION

- Suitable for machining steel and hard material
- Single-sided milling insert ZDEW 1204 with a plane rake surface, special shape and high-feed design for a maximum depth of cut of .063"

GRADE Z4

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P01-P10/K01-K10 and H05-H15 for machining of steel, cast-iron and hardened material with high feed cutters FEEDY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10		K10			H10
Sfm ft/min	509 - 1148		476 - 1083			98 - 230
Fn Inch/Z	0.0197 - 0.1181		0.0197 - 0.1181			0.0197 - 0.0827
ap Inch	0.012 - 0.063		0.012 - 0.063			0.012 - 0.044

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