



ZDEW 120408 Z5



APPLICATION

- Suitable for machining steel
- 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 Z5

This is a PVD coated WC-Co carbide within ISO-grade range P30-P50 for machining of steel with high feed cutters FEEDY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10					
Sfm ft/min	394 - 804					
Fn Inch/Z	0.0197 - 0.1181					
ap Inch	0.012 - 0.063					

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

S (RPM)	$S = \frac{Sfm * 12}{\pi * D}$ = rev per minute
F (IPR, inch per revolution)	$F = S * Fn$ = feed per minute
F (IPM, inch per minute)	$F = S * Fz * n.flutes$ = feed per minute
Sfm	$Sfm = S * D * \pi / 12$