



XNEX 080608 ZKX

APPLICATION

Double-sided milling insert, trigonal shape for a maximum depth of cut of .320". It is recommended for medium to heavy machining of steel, cast iron and stainless steel. It fits 600 milling cutters.



GRADE ZKX

- This is an UNCOATED insert fine grained WC-Co carbide within ISO-grade ranges N15-N35 and K20-K40 for machining non ferrous material like aluminum

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				N20		
Sfm ft/min				902		
Fz Inch/Z				0.030 - 0.100		
ap Inch				0.0354		

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