

APET.VM 1003 ZKX



APPLICATION

- Suitable for non ferrous material
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.

GRADE ZKX

with sharp cutting edges, uncoated fine grained WC-Co carbide and polished within ISO-grade range N10-N25 for machining of non-ferrous metal

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				N10 - N25		
Sfm ft/min				410 - 1608		
Fn Inch/Z				.002-.012		
ap Inch				.031 - .354		

LEGEND

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

FORMULA

S (RPM) = $Sfm * 12 / \pi / D$ = 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 = $S * D * \pi / 12$

MILLING CARBIDE INSERT