



XNEX 080612 Z21



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 Z21

- This is a CVD TIN+ALN coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25		K20			
Sfm ft/min	634		590			
Fz Inch/Z	0.010 - 0.018		0.010 - 0.018			
ap Inch	0.0354		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