



XNEX 040304 Z4

APPLICATION

Double-sided milling insert, trigonal shape for a maximum depth of cut of .090". It is recommended for machining of steel and stainless steel. It fits 600 milling cutters.



GRADE Z4

- This is a PVD TiAlN coated fine grained WC-Co carbide within ISO-grade ranges P15-P20 and M10-M20 for machining of steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30					
Sfm ft/min	594					
Fz Inch/Z	0.005 - 0.012					
ap Inch	0.0197					

LEGEND

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

FORMULA

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