



# SEET.VM 43 ZKX



## APPLICATION

- Suitable for machining of non ferrous material
- Single-sided milling insert SEET 43 with chip-breakers, square for a maximum depth of cut of .1772"

## GRADE ZKX

This is a geometry with sharp cutting edges, ZKX uncoated fine grained WC-Co carbide within ISO-grade range N10-N25 for machining of non-ferrous metal

|            | STEEL | STAINLESS | CAST IRON | NON FERROUS    | S.ALLOYS | HEAT TREATED |
|------------|-------|-----------|-----------|----------------|----------|--------------|
| GROUP      |       |           |           | K10            |          |              |
| Sfm ft/min |       |           |           | 410 - 1837     |          |              |
| Fn Inch/Z  |       |           |           | 0.002 - 0.0189 |          |              |
| ap Inch    |       |           |           | 0.008 - 0.177  |          |              |

### LEGEND

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

### FORMULA

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