



# SNGX 110416 Z6P

## APPLICATION

Double-sided milling insert SNGX 1104, square for a maximum depth of cut of .670", with .062" corner radius, an indexing accuracy according to ISO-tolerance class-G and geometry with rounded cutting edges



## GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges M20-M40 and S20-S30 for machining. Suitable for machining of steel and stainless steel of stainless-steel and superalloy with high feed cutters

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30		K30			
<b>Sfm ft/min</b>	541 - 1115		509 - 1050			
<b>Fz Inch/Z</b>	0.0079 - 0.0591		0.0079 - 0.0591			
<b>ap Inch</b>	0.008 - 0.067		0.008 - 0.067			

### 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**