



# SNGX 110416 Z2

## 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 Z2

This is a MT-CVD coated WC-Co carbide within ISO-grade ranges P10 -P30 and K10 -K30 for machining of steel and cast-iron with SUPER8 high feed cutters

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P20		K20			S20
<b>Sfm ft/min</b>	673 - 1509		623 - 1427			131 - 295
<b>Fz Inch/Z</b>	0.0079 - 0.0502		0.0079 - 0.0502			0.0079 - 0.0351
<b>ap Inch</b>	0.008 - 0.067		0.008 - 0.067			0.008 - 0.047

### LEGEND

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

### FORMULA

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