



SNGX 110416 Z4

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 Z4

This is aPVD coated fine grained WC-Co carbide within ISO-grade ranges P01 -P10/K01 -K10 and H05 -H15 for machining of steel, cast-iron and hardened material with SUPER8 high feed cutters.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10		K10			
Sfm ft/min	591 - 1312		558 - 1247			
Fz Inch/Z	0.0079 - 0.0591		0.0079 - 0.0591			
ap Inch	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

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