



# RPET 1204MO-S Z6P

## APPLICATION

- Suitable for machining of steel and stainless-steel
- Round insert for a maximum depth of cut of .1181"



## GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K30		S30	
Sfm ft/min	755 - 1148	443 - 689	705 - 1083		148 - 344	
Fn Inch/Z	0.0047 - 0.0157	0.0052 - 0.0142	0.0047 - 0.0157		0.0052 - 0.011	
ap Inch	0.02 - 0.118	0.02 - 0.118	0.02 - 0.118		0.02 - 0.094	

### LEGEND

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

### FORMULA

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

**MILLING CARBIDE INSERT**