



# RPEW 1204-MOSN Z6P

## APPLICATION

- Suitable for machining steel and hard material
- Single-sided milling insert RPEW 1204 with a plane rake surface, round for a maximum depth of cut of .1181"



## GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade range P35-K30 for machining of cast-iron and steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30		K30			H25
<b>Sfm ft/min</b>	755 - 1181		705 - 1115			148 - 230
<b>Fn Inch/Z</b>	0.0039 - 0.0157		0.0039 - 0.0157			0.0039 - 0.0079
<b>ap Inch</b>	0.02 - 0.118		0.02 - 0.118			0.016 - 0.047

### LEGEND

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

### FORMULA

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

**MILLING CARBIDE INSERT**