



RPEW 1204-MOSN Z5

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 Z5

This is a PVD coated fine grained WC-Co carbide within ISO-grade range K10-K25 for machining of cast-iron and hardened material

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			
Sfm ft/min	689 - 1083		640 - 1017			
Fn Inch/Z	0.0039 - 0.0157		0.0039 - 0.0157			
ap Inch	0.02 - 0.118		0.02 - 0.118			

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