



ADEX 160604 ZKX

APPLICATION

- Suitable for non ferrous material as aluminum and plastic
- Suggested for interrupted or continuous condition



GRADE ZKX

This is uncoated and polished fine grained WC-Co carbide within ISO-grade range N10-N25 for machining of non-ferrous metal

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				N10		
Sfm ft/min				262 - 1548		
Fz Inch/Z				.002 - .014		
ap Inch				.012 - .512		

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT