



# ADEX 160630 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 |       |           |           | 361 - 1608  |          |              |
| 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**