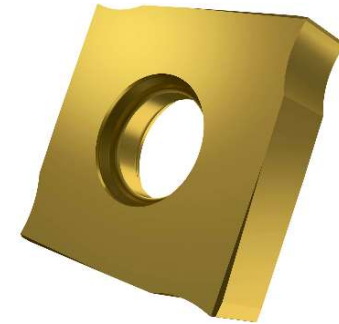




# SNHX 11027 Z3

## APPLICATION

- Double-sided disc milling insert
- Thickness .106" for cutters 938...5mm



## GRADE Z3

This is a TIN PVD coated fine grained WC-Co carbide within ISO-grade range P25-P50 for machining of steel with disc mills 938

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30		K25			
<b>Sfm ft/min</b>	886 - 1312		837 - 1247			
<b>Fz Inch/Z</b>	0.0039 - 0.0157		0.0039 - 0.0157			
<b>ap Inch</b>						

### LEGEND

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

### FORMULA

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