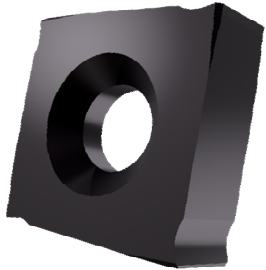




SNHX 12054 Z5



APPLICATION

- Double-sided disc milling insert
- Thickness .213" for cutters 938...10mm

GRADE Z5

This is a TiAlN 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
GROUP	P30	M30	K25			
Sfm ft/min	869 - 1165	509 - 689	820 - 1099			
Fz Inch/Z	0.0079 - 0.0197	0.0079 - 0.0197	0.0079 - 0.0197			
ap Inch						

LEGEND

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

FORMULA

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