



SNMX 1205 Z1

APPLICATION

- Double-sided milling insert, square with 8 corners for a maximum depth of cut of .394".



GRADE Z1

- This is a CVD ALN coated fine grained WC-Co carbide within ISO-grade ranges P10-P20 and K10-K20 for machining of steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			
Sfm ft/min	561		561			
Fz Inch/Z	0.0110 - 0.0079		0.0197 - 0.0071			
ap Inch	0.0394		0.0394			

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT