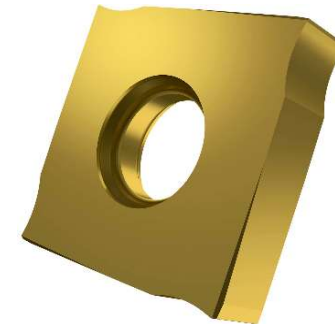




SNHX 11023 Z3

APPLICATION

- Double-sided disc milling insert
- Thickness .091" for cutters 938...4mm



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
GROUP	P30		K25			
Sfm ft/min	935 - 1394		886 - 1312			
Fz Inch/Z	0.0039 - 0.0157		0.0039 - 0.0157			
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	$Sfm = S * D * \pi / 12$