



XDHW 060210 Z5

APPLICATION

- Suitable for machining steel
- Single-sided milling insert XDHW 0602 with a plane rake surface, 70° rhomboid for a maximum depth of cut of .0224"



GRADE Z5

This is a TiAlN PVD coated WC-(Ti, Ta, Nb)C-Co carbide

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30					
Sfm ft/min	558 - 1033					
Fn Inch/Z	0.002 - 0.0138					
ap Inch	0.008 - 0.039					

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution) = S * Fn= feed per minute
F (IPM, inch per minute) = S * Fz * n.flutes= feed per minute
Sfm = S * D * π / 12