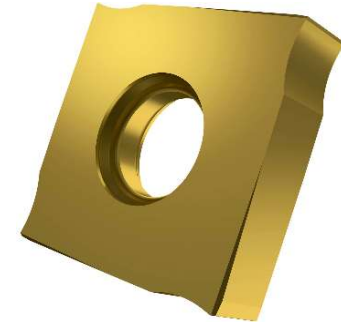




SNHX 12070 Z6P

APPLICATION

- Double-sided disc milling insert
- Thickness .276" for cutters 938...12mm



GRADE Z6P

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K25			
Sfm ft/min	771 - 1017	459 - 607	722 - 951			
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

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