



OFKR 0704SN-M Z6P

APPLICATION

- Suitable for machining steel and stainless steel
- Single-sided milling insert with chip-breakers, octagonal for a maximum depth of cut of .4724"



GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30			
Sfm ft/min	591 - 886	344 - 525	558 - 837			
Fn Inch/Z	0.0039 - 0.0118	0.0043 - 0.0106	0.0039 - 0.0118			
ap Inch	0.02 - 0.472	0.02 - 0.472	0.02 - 0.472			

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT