



ZDCW 070304 Z5



APPLICATION

- Suitable for machining steel
- Single-sided milling insert ZDCW 0703 with a plane rake surface, special shape for a maximum depth of cut of .0394"

GRADE Z5

This is a PVD coated WC-Co carbide within ISO-grade range P30-P50 for machining of steel with high feed cutters FEEDY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35					
Sfm ft/min	656 - 1378					
Fn Inch/Z	0.0059 - 0.0591					
ap Inch	0.012 - 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