



OFKR 0704SN-M Z2

APPLICATION

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



GRADE Z2

This is a MT-CVD coated WC-Co carbide within ISO-grade range M30-M40 for machining of steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20	M20				
Sfm ft/min	640 - 1050	377 - 623				
Fn Inch/Z	0.0039 - 0.0118	0.0043 - 0.0106				
ap Inch	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