



SNGX.M 110416 Z6P

APPLICATION

- Double-sided milling insert SNGX 1104, square for a maximum depth of cut of .670", with .062" corner radius, an indexing accuracy according to ISO-tolerance class-G and M geometry with rounded cutting edges



GRADE Z6P

- suitable for machining of steel, stainless steel and super alloy
- PVD coated WC-Co carbide within ISO-grade range P30-P50

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30			S30	
Sfm ft/min	574 - 1001	344 - 591			115 - 295	
Fz Inch/Z	.004 - .047	.004 - .042			.004 - .033	
ap Inch	.008 - .067	.008 - .067			.008 - .054	

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT