



SNGX.M 110416 Z5

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 Z5

- suitable for machining of steel and super alloy material
- PVD TIALN coated fine grained WC-Co carbide within ISO-grade ranges M20-M40 and S20-S30 for machining of stainless-steel and superalloy with high feed cutters

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30			S30	
Sfm ft/min	459 - 804	262 - 476			82 -230	
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 (RPM) = $Sfm * 12 / \pi / D$ = 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 = $S * D * \pi / 12$

MILLING CARBIDE INSERT