



HNGX.M 0604 Z6P

APPLICATION

- Suitable for machining steel and stainless steel
- Double-sided milling insert HNGX 0604, hexagonal for a maximum depth of cut of .1181"



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 stainlesssteel with face mills

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------------|-----------------|-----------------|-----------------|-------------|----------|--------------|
| GROUP | P35 | M30 | K30 | | | |
| Sfm ft/min | 804 - 968 | 476 - 574 | 755 - 919 | | | |
| Fz Inch/Z | 0.0051 - 0.0098 | 0.0051 - 0.0098 | 0.0051 - 0.0098 | | | |
| ap Inch | 0.024 - 0.118 | 0.024 - 0.118 | 0.024 - 0.118 | | | |

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT