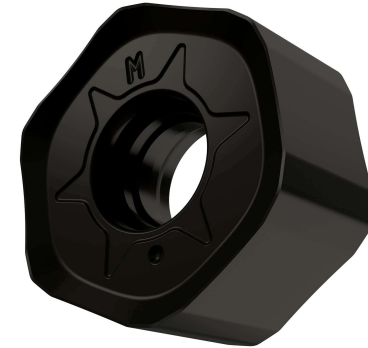




HNGX.M 0604 Z2

APPLICATION

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



GRADE Z2

This is a MT-CVD coated WC-Co carbide insert suitable for machining of steel with face mills

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20		K20			
Sfm ft/min	1083 - 1345		1017 - 1263			
Fz Inch/Z	0.0051 - 0.0098		0.0051 - 0.0098			
ap Inch	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 (RPM)	$S = \text{Sfm} * 12 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution)	$F = S * F_n = \text{feed per minute}$
F (IPM, inch per minute)	$F = S * F_z * n.\text{flutes} = \text{feed per minute}$
Sfm	$S = D * \pi / 12$

MILLING CARBIDE INSERT