



RPET 1204MO-S Z2

APPLICATION

- Suitable for machining of steel
- Round insert for a maximum depth of cut of .1181"



GRADE Z2

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 and M20 for machining of steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25	K20		S20	
Sfm ft/min	837 - 1296	492 - 771	787 - 1230		164 - 377	
Fn Inch/Z	0.0047 - 0.0157	0.0052 - 0.0142	0.0047 - 0.0157		0.0052 - 0.011	
ap Inch	0.02 - 0.118	0.02 - 0.118	0.02 - 0.118		0.02 - 0.094	

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