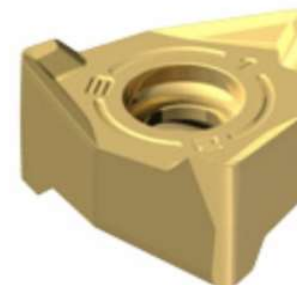




XNEX 080608 Z6C

APPLICATION

Double-sided milling insert, trigonal shape for a maximum depth of cut of .320". It is recommended for medium to heavy machining of steel, cast iron and stainless steel. It fits 600 milling cutters.



GRADE Z6C

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35				
Sfm ft/min	594	374				
Fz Inch/Z	0.007 - 0.014	0.007 - 0.014				
ap Inch	0.0354	0.0354				

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