



Z16NL 13UN Z6P

APPLICATION

- Suitable for threading operations
- Single-sided lay down carbide insert Tin Coated



GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P40/M20-M35 and K20-K40 for machining of steel, stainless-steel and cast-iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30	N30	S30	
Sfm ft/min	443 - 525	262 - 312	410 - 492	656 - 1837	82 - 148	
Fn Inch/Z						
ap Inch						

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 = $S * D * \pi / 12$

LAY DOWN CARBIDE INSERT