



# Z16NR 18UN 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

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

**LAY DOWN CARBIDE INSERT**