



APKT.PM 1003 Z6P

APPLICATION

- Suitable for machining of steel and stainless-steel
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.



GRADE Z6P

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	P25-P50	M20-M40	K20 - K40			
Sfm ft/min	853 - 1115	605 - 425	804 - 1050			
Fn Inch/Z	.004-.010	.004-.008	.004-.010			
ap Inch	.039-.512	.039-.454	.039-.512			

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 = $S * D * \pi / 12$

MILLING CARBIDE INSERT