



APKT.PM 160404 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		S30	
Sfm ft/min	459 - 607	262 - 361	427 - 574		82 - 180	
Fn Inch/Z	.004-.010	.004-.010	.004-.010		.002 - .007	
ap Inch	.039-.512	.039-.512	.039-.512		.039-.409	

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

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

MILLING CARBIDE INSERT