



# APKT.PM 160431 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 | 640 - 837 | 377 - 492 | 607 - 787 |             | 115 - 246   |              |
| 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

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

**MILLING CARBIDE INSERT**