



SEET 32.5 AFEN Z6P



APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .0787"

GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50/M20-M40 and S20-S30 for machining of steel, stainless-steel and superalloy with face mills 849

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M30			S30	
Sfm ft/min	705 - 1099	410 - 656			131 - 328	
Fn Inch/Z	0.0031 - 0.0118	0.0035 - 0.0106			0.0035 - 0.0083	
ap Inch	0.012 - 0.177	0.012 - 0.177			0.012 - 0.142	

LEGEND

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

FORMULA

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

