



XPET 0602AP Z6P



APPLICATION

- Drilling insert to fit the central pocket of 841 drilling bodies
- Square geometry for machining of steel and stainless-steel

GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P20-P35 and M15-M30 with a geometry for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30		S30	
Sfm ft/min	459 - 541	262 - 312	427 - 509		82 - 148	
Fn Inch/Z	0.002 - 0.006	0.003 - 0.006	0.002 - 0.006		0.003 - 0.004	
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 (RPM) = Sfm * 12 / π / 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 * π / 12