



XPET 1904AP 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	0.004 - 0.01	0.004 - 0.009	0.004 - 0.01		0.004 - 0.007	
ap Inch						

LEGEND

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

FORMULA

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