

TCMT.FF 1.21.20 Z6P



APPLICATION

- Suitable for fine to medium machining of steels and cast-irons
- Continuous and interrupted cut



GRADE Z6P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and K20-K40, for fine to medium machining of steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40		K20 - K40			
Sfm ft/min	427 - 787		394 - 738			
Fn Inch/rev	.006 - .003		.006 - .003			
ap Inch	.006 - .078		.006 - .078			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT