



DPL 3 Z6P

APPLICATION

- Suitable for machining steel and stainless steel
- 6° front angle to reduce pip and burr on the left hand side,



GRADE Z6P

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and K20 -K40 for machining of steel and stainless steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M30	K30			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.002 - 0.0079	0.0022 - 0.0071	0.002 - 0.0079			
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) = $Sfm * 12 / \pi / D$ = 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 = $S * D * \pi / 12$

CUT-OFF CARBIDE INSERT