



DPS 6 Z9

APPLICATION

- Double ended round grooving insert. Its chipbreaker is suggested for round grooving,
- The full radius geometry recommended to be used for machining of steel and cast iron.



GRADE Z9

This MT-CVD coated functionally graded WC-Co carbide within ISO-grade ranges P15-P35 and K15-K35 for machining of steel and cast-iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25	K20			
Sfm ft/min	476 - 1509	279 - 902	443 - 1427			
Fn Inch/Z	0.0028 - 0.0315	0.003 - 0.0283	0.0028 - 0.0315			
ap Inch	0.039 - 0.118	0.039 - 0.118	0.039 - 0.118			

LEGEND

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

FORMULA

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