



ADMX 11T304 Z6P



APPLICATION

- Suitable for steel and stainless steel and cast iron
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.

GRADE Z6P

This is a PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P50	M20 - M40	K20 -K40		S 30	
Sfm ft/min	525 - 705	312 - 410	492 - 656		98 - 197	
Fn Inch/Z	.004 - .007	.004 - .007	.004 - .007		.002 - .005	
ap Inch	.008 - .354	.008 - .354	.008 - .354		.008 - .283	

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