



GPN.R 4 Z6P

APPLICATION

- Double ended parting and grooving insert
- The .R geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.



GRADE Z6P

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.0031 - 0.0098	0.0035 - 0.0089	0.0031 - 0.0098			
ap Inch						

LEGEND

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

FORMULA

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

CUT-OFF CARBIDE INSERT