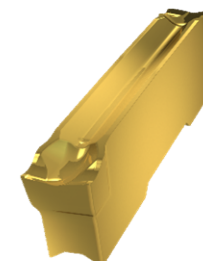




GPN.M 4 Z6P

APPLICATION

- Double ended parting and grooving insert
- The .M geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts



GRADE Z6P

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and M20 -M35 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30	N20	S30	
Sfm ft/min	230 - 427	131 - 246	213 - 394	344 - 1493	33 - 115	
Fn Inch/Z	0.0031 - 0.0071	0.0035 - 0.0063	0.0031 - 0.0071	0.0031 - 0.0087	0.0035 - 0.0055	
ap Inch						

LEGEND

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

FORMULA

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

CUT-OFF CARBIDE INSERT