



ADMX 160604 Z6P

APPLICATION

- Suitable for steel and stainless steel
- 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		S30	
Sfm ft/min	476 - 673	279 - 394	443 - 623		82 - 197	
Fn Inch/Z	.004-.010	.001 - .005	.001 - .005		.001 - .005	
ap Inch	.012 - .512	.012 - .512	.012 - .512		.012 - .409	

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT