



ADMX 070204 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		S30	
Sfm ft/min	558 - 886	328 - 525	525 - 837		98 - 262	
Fn Inch/Z	.001 - .005	.001 - .005	.001 - .005		.001 - .005	
ap Inch	.004 - .197	.004 - .197	.004 - .197		.004 - .157	

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT