



# ADMX 070208 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
<b>GROUP</b>	P25 - P50	M20 - M40	K20 -K40		S30	
<b>Sfm ft/min</b>	637 - 1050	394 - 623	623 - 984		131 - 312	
<b>Fn Inch/Z</b>	.001 - .005	.001 - .005	.001 - .005		.001 - .005	
<b>ap Inch</b>	.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

<b>S (RPM)</b> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn= feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes= feed per minute
<b>Sfm</b> = S * D * π / 12