



# GPN.M1T 3 Z6P

## APPLICATION

- Single 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  | 0.002 - 0.0059 | 0.0024 - 0.0055 | 0.002 - 0.0059 | 0.002 - 0.0071 | 0.0024 - 0.0043 |              |
| 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 (RPM)** =  $Sfm * 12 / \pi / D$  = rev per minute  
**F (IPR, inch per revolution)** =  $S * Fn$  = feed per minute  
**F (IPM, inch per minute)** =  $S * Fz * n.flutes$  = feed per minute  
**Sfm** =  $S * D * \pi / 12$

**CUT-OFF CARBIDE INSERT**