



GPR 3 Z6P

APPLICATION

- Suitable for machining steel and stainless steel
- 6° front angle to reduce pip and burr on the right hand side,



GRADE Z6P

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and K20 -K40 for machining of steel and stainless steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M30	K30			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.002 - 0.0079	0.0022 - 0.0071	0.002 - 0.0079			
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