



# GPS 5 Z6P



## APPLICATION

- Double ended parting and grooving insert full radius
- PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 - P40/M20 -M35 and K20 -K40 for machining of steel, stainless-steel and cast-iron.

## GRADE Z6P

This is a TIN PVD coated insert with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30	M30	K30		S30	
<b>Sfm ft/min</b>	509 - 869	295 - 509	476 - 820		98 - 246	
<b>Fn Inch/Z</b>	0.0047 - 0.0197	0.0051 - 0.0177	0.0047 - 0.0197		0.0051 - 0.0138	
<b>ap Inch</b>	0.0197 - 0.0984	0.0197 - 0.0984	0.0197 - 0.0984		0.0197 - 0.0787	

### 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