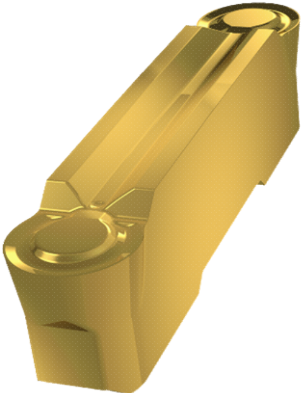




GPS 6 Z6P



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
GROUP	P30	M30	K30		S30	
Sfm ft/min	509 - 935	295 - 558	476 - 886		98 - 279	
Fn Inch/Z	0.0039 - 0.0197	0.0043 - 0.0177	0.0039 - 0.0197		0.0043 - 0.0138	
ap Inch	0.0197 - 0.0787	0.0197 - 0.0787	0.0197 - 0.0787		0.0197 - 0.063	

LEGEND

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

FORMULA

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