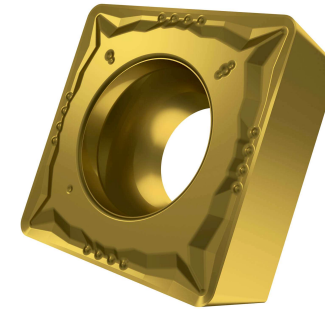


SCMT.FM 431 Z6P



APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous and interrupted cut



GRADE Z6P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20 - M35	K25 -K40	N25 - N40		
Sfm ft/min	476 - 656	279 - 394	443 - 623	705 - 2297		
Fn Inch/rev	.004 - .009	.004 - .008	.004 - .009	.004 - .010		
ap Inch	.016 - .157	.016 - .157	.016 - .157	.016 - .157		

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT