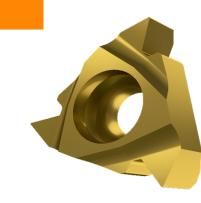


Z16ER 18UN Z6P

APPLICATION

- Suitable for threading operations

- Single-sided lay down carbide insert Tin Coated



GRADE Z6P

This is a 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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30	N30	S30	
Sfm ft/min	443 - 525	262 - 312	410 - 492	656 - 1837	82 - 148	
Fn Inch/Z						
ap Inch						

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / 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 * π / 12

LAY DOWN CARBIDE INSERT