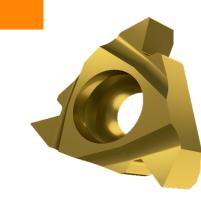


Z16ER 18UN Z6P

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