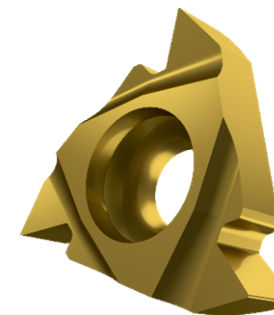




Z22EL 7UN Z6P

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 |
| ap | Depth of cut |

FORMULA

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