



Z22NR N60 Z6P



APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .0787"

GRADE Z6P

This is a PVD coated WC-(Ti, Ta, Nb)C-Co carbide for machining with copy face mills TORY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP						
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

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