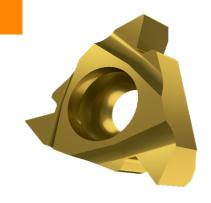


# **Z16NR 9UN Z6P**

## **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) Fz (ipt)	Feed per revolution
Fz (ipt)	Feed per tooth
ар	Depth of cut

### **FORMULA**

S (RPM) = Sfm \* 12 /  $\pi$  / 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 \*  $\pi$  / 12