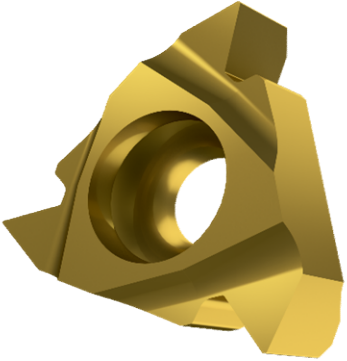




# Z16NL G60 Z5



## 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

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