



# GPL 3 Z6P



## APPLICATION

- Suitable for machining steel and stainless steel
- 6° front angle to reduce pip and burr on the left hand side,

## GRADE Z6P

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and K20 -K40 for machining of steel and stainless steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P35	M30	K30			
<b>Sfm ft/min</b>	230 - 427	131 - 246	213 - 394			
<b>Fn Inch/Z</b>	0.002 - 0.0079	0.0022 - 0.0071	0.002 - 0.0079			
<b>ap Inch</b>						

### LEGEND

<b>Sfm (Vc)</b>	<b>Surface Feet per Minute</b>
<b>Fn (ipr)</b>	<b>Feed per revolution</b>
<b>Fz (ipt)</b>	<b>Feed per tooth</b>
<b>ap</b>	<b>Depth of cut</b>

### FORMULA

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

# CUT-OFF CARBIDE INSERT