



TPMR .MB 322 Z14



APPLICATION

- Single-sided positive turning insert with chipbreaker
- Suggested to use on manual lather for machining of steels

GRADE Z14

This is a a MT-CVD TIN coated functionally graded WC-Co carbide within ISO range P20-P45, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K35			
Sfm ft/min	312 - 640	180 - 377	295 - 607			
Fn Inch/Z	0.0039 - 0.0157	0.0043 - 0.0142	0.0039 - 0.0157			
ap Inch	0.031 - 0.157	0.031 - 0.157	0.031 - 0.157			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT