



TPUN 221 Z14



APPLICATION

- Suitable for machining steel and cast iron
- Single-sided TIN coated milling insert TPUN 22 with a plane rake surface, triangular for a maximum depth of cut of .4724

GRADE Z14

This is a PVD coated fine grained WC-Co carbide within ISO-grade range K20-K40 for machining of steel and cast-iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		K35			
Sfm ft/min	295 - 443		279 - 410			
Fn Inch/Z	0.0039 - 0.0079		0.0039 - 0.0079			
ap Inch	0.016 - 0.142		0.016 - 0.142			

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / 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 * π / 12