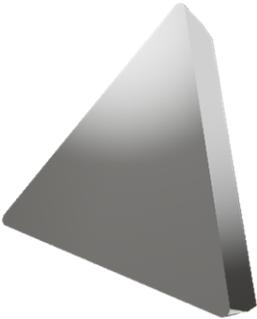




TPUN 321 Z3F



APPLICATION

- Suitable for machining steel
- Single-sided uncoated milling insert TPUN 32 with a plane rake surface, triangular for a maximum depth of cut of .4724

GRADE Z3F

This is an uncoated WC-(Ti, Ta, Nb)C-Co carbide suitable for steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K20			
Sfm ft/min	213 - 279		180 - 262			
Fn Inch/Z	0.0039 - 0.0079		0.0039 - 0.0079			
ap Inch	0.039 - 0.472		0.02 - 0.472			

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