



TPUN 322 Z6P

APPLICATION

- Suitable for machining steel and cast iron
- Single-sided positive turning insert, triangular with 11° clearance



GRADE Z6P

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	P30		K30			
Sfm ft/min	427 - 574		394 - 541			
Fn Inch/Z	0.0039 - 0.0079		0.0039 - 0.0079			
ap Inch	0.02 - 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

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

MILLING CARBIDE INSERT