



# TPUN 431 Z14

## APPLICATION

- Suitable for machining steel and cast iron
- Single-sided TIN coated milling insert TPUN 43 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
<b>GROUP</b>	P35		K35			
<b>Sfm ft/min</b>	262 - 509		246 - 476			
<b>Fn Inch/Z</b>	0.0039 - 0.0138		0.0039 - 0.0138			
<b>ap Inch</b>	0.031 - 0.252		0.031 - 0.252			

### LEGEND

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

### FORMULA

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