



TPUN 432 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	459 - 656		427 - 623			
Fn Inch/Z	0.0039 - 0.0098		0.0039 - 0.0098			
ap Inch	0.039 - 0.669		0.039 - 0.669			

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