



TPKN 32 PDSR Z3F

APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert TPKN 32 with a plane rake surface, triangular for a maximum depth of cut of .4724",



GRADE Z3F

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		K30			
Sfm ft/min	459 - 558		427 - 525			
Fn Inch/Z	0.0079 - 0.0098		0.0079 - 0.0098			
ap Inch	0.039 - 0.472		0.039 - 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