



SPUN 422 Z14



APPLICATION

- Generic grade for steel
- Suitable for fine to heavy machining of steels and cast-irons

GRADE Z14

This is a TIN PVD coated carbide insert for fine to heavy machining of steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K30			
Sfm ft/min	607 - 869		574 - 820			
Fn Inch/Z	0.0039 - 0.0098		0.0039 - 0.0098			
ap Inch	0.039 - 0.354		0.039 - 0.354			

LEGEND

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

FORMULA

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