



GTN 2 Z3F

APPLICATION

- Suitable for machining steel on manual lathe.
- straight front angle for grooving or parting off



GRADE Z3F

This is an uncoated carbide insert for parting off on manual lathe.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		M25			
Sfm ft/min	225 - 332		219 - 399			
Fn Inch/Z	0.003 - 0.005		0.003 - 0.005			
ap Inch						

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