



# GTN 3 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

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

