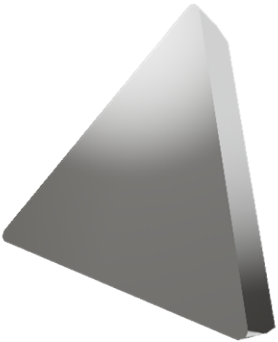




# TPUN 432 Z3F



## APPLICATION

- Suitable for machining steel
- Single-sided uncoated milling insert TPUN 43 with a plane rake surface, triangular for a maximum depth of cut of .669

## GRADE Z3F

This is an uncoated WC-(Ti, Ta, Nb)C-Co carbide suitable for machining steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30					
<b>Sfm ft/min</b>	197 - 279					
<b>Fn Inch/Z</b>	0.0039 - 0.0098					
<b>ap Inch</b>	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

<b>S (RPM)</b> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn= feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes= feed per minute
<b>Sfm</b> = S * D * π / 12