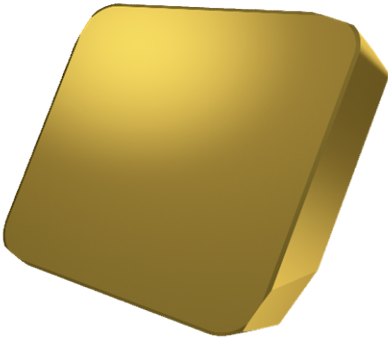




SPKN 42 EDER Z3



APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert SPKN 1203 with a plane rake surface, square for right hand cutting with a maximum depth of cut of .3543"

GRADE Z3

This is a TIN PVD coated fine grained WC-Co carbide insert

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K30			
Sfm ft/min	656 - 869		623 - 820			
Fn Inch/Z	0.0059 - 0.0118		0.0059 - 0.0118			
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 (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