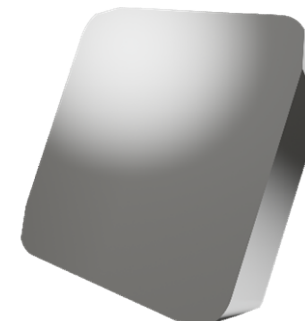




# SPKN 42 Z3F



## APPLICATION

- Suitable for machining steel
- 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 Z3F

This is a uncoated carbide within ISO-grade range P30 for machining of steel

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

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

**MILLING CARBIDE INSERT**