



# SPKN 42 ZC2



## APPLICATION

- Suitable for machining cast iron and finishing 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 ZC2

This is a uncoated CERMET within ISO-grade range K15-K30 for machining of cast-iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K10			
Sfm ft/min			279 - 377			
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 (RPM)** =  $Sfm * 12 / \pi / D$  = 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** =  $S * D * \pi / 12$

**MILLING CARBIDE INSERT**