



SPKN 42 EDSR Z4



APPLICATION

- Suitable for machining 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 Z4

This is a MT-CVD coated WC-Co carbide within ISO-grade range K05-K25 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

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