



SPKN 42 EDSR Z5



APPLICATION

- Suitable for machining steel and cast iron and hard material
- 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 Z5

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K30			H30
Sfm ft/min	656 - 869		623 - 820			131 - 164
Fn Inch/Z	0.0059 - 0.0118		0.0059 - 0.0118			0.0043 - 0.0079
ap Inch	0.039 - 0.354		0.039 - 0.354			0.016 - 0.059

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

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