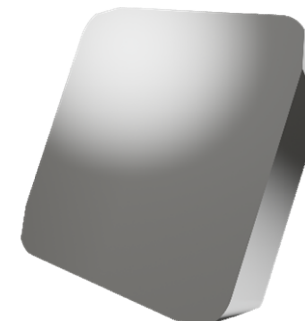




# SPKN 53 ZK1



## APPLICATION

- Suitable for machining cast iron
- Single-sided milling insert SPKN 1504 with a plane rake surface, square for right hand cutting with a maximum depth of cut of .5118"

## GRADE ZK1

This is a uncoated carbide 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			262 - 394			
Fn Inch/Z			0.004 - 0.014			
ap Inch			0.039 - 0.512			

### 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**