



TPKN 32 PDSR Z5

APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert TPKN 32 with a plane rake surface, triangular for a maximum depth of cut of .4724",



GRADE Z5

This is a TIALN PVD coated fine grained WC-Co carbide

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------------|-----------------|-----------|-----------------|-------------|----------|--------------|
| GROUP | P30 | | K30 | | | |
| Sfm ft/min | 459 - 558 | | 427 - 525 | | | |
| Fn Inch/Z | 0.0079 - 0.0098 | | 0.0079 - 0.0098 | | | |
| ap Inch | 0.039 - 0.472 | | 0.039 - 0.472 | | | |

LEGEND

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

FORMULA

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