



TPKN 43 PDSR Z3F

APPLICATION

- Suitable for machining steel and cast iron
- Single-sided milling insert TPKN 2204 with a plane rake surface, triangular for a maximum depth of cut of .6693"



GRADE Z3F

This is a uncoated fine grained WC-Co carbide within ISO-grade range K20-K40 for machining of cast-iron and steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		K30			
Sfm ft/min	427 - 541		394 - 509			
Fn Inch/Z	0.0079 - 0.0118		0.0079 - 0.0118			
ap Inch	0.039 - 0.669		0.039 - 0.669			

LEGEND

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

FORMULA

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