

# CNMG.SF 431 ZSL12



## APPLICATION

- Suitable for fine to medium machining of steels, stainless-steels, cast-irons, super alloys and hardened materials
- Continuous and interrupted cut



## GRADE ZSL12

This grade is a PVD coated extra fine grained WC-Co carbide within ISO ranges P01 - P15/M01 - M15/K05 - K20/S01 - S15 and H01 - H15, for fine to medium machining of steels, stainless-steels, cast-irons, super-alloys and hardened materials

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P01 - P15	M01 - M15	K05 - K20	N01 - N15	S01 - S15	H01 - H15
<b>Sfm ft/min</b>	328 - 689	230 - 492	262 - 541	492 - 2411	66 - 246	66 - 131
<b>Fn Inch/rev</b>	.004 - .010	.004 - .009	.004 - .010	.004 - .012	.004 - .008	.004 - .007
<b>ap Inch</b>	.016 - .106	.016 - .106	.016 - .106	.016 - .106	.016 - .085	.008 - .02

### LEGEND

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

### FORMULA

<b>S (RPM)</b> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn = feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes = feed per minute
<b>Sfm</b> = S * D * π / 12

## *TURNING CARBIDE INSERT*