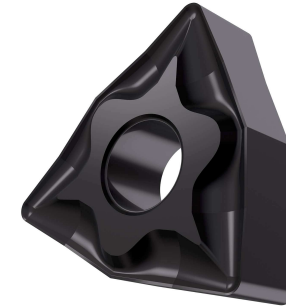


WNMG.NF 432 ZSL12



APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous and interrupted cut



GRADE ZSL12

This grade is a PVD coated extra fine grained WC-Co carbide within ISO ranges P01 - P15 and M01 - M15, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P01 - P15	M01 - M15	K01 - K15	N01 - N15	S01 - S15	
Sfm ft/min	427 - 738	295 - 525	328 - 591	640 - 2575	98 - 262	
Fn Inch/rev	.006 - .014	.007 - .012	.006 - .014	.006 - .017	.006 - .011	
ap Inch	.031 - .138	.031 - .138	.031 - .138	.031 - .138	.031 - .11	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT