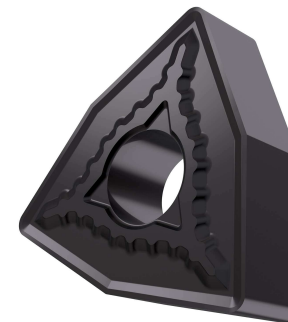


WNMG.SM 432 ZSL12



APPLICATION

- Suitable for fine to heavy machining of steels, stainless-steels, cast-irons and super-alloys
- 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 and S01 - S15, for fine to heavy machining of steels, stainless-steels, cast-irons and super-alloys

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P01 - P15	M01 - M15	K05 - K20	N01 - N15	S01 - S15	H01 - H15
Sfm ft/min	344 - 640	246 - 459	262 - 509	509 - 2231	82 - 230	66 - 115
Fn Inch/rev	.008 - .018	.009 - .016	.008 - .018	.008 - .021	.008 - .014	.005 - .009
ap Inch	.031 - .157	.031 - .157	.031 - .157	.031 - .157	.031 - .126	.016 - .039

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