

DNMG.SF 432 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
GROUP	P01 - P15	M01 - M15	K05 - K20	N01 - N15	S01 - S15	H01 - H15
Sfm ft/min	312 - 623	213 - 443	246 - 492	459 - 2182	66 - 213	49 - 115
Fn Inch/rev	.005 - .011	.005 - .009	.005 - .011	.005 - .013	.005 - .009	.004 - .007
ap Inch	.031 - .118	.031 - .118	.031 - .118	.031 - .118	.031 - .094	.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 (RPM)	$S = \text{Sfm} * 12 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution)	$F = S * \text{Fn} = \text{feed per minute}$
F (IPM, inch per minute)	$F = S * Fz * n.\text{flutes} = \text{feed per minute}$
Sfm	$\text{Sfm} = S * D * \pi / 12$

TURNING CARBIDE INSERT