

VNMG.SF 332 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	279 - 541	197 - 377	213 - 427	410 - 1886	66 - 180	49 - 98
Fn Inch/rev	.005 - .010	.005 - .008	.005 - .010	.005 - .012	.005 - .008	.004 - .006
ap Inch	.031 - .098	.031 - .098	.031 - .098	.031 - .098	.031 - .079	.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)	= Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution)	= S * Fn = feed per minute
F (IPM, inch per minute)	= S * Fz * n.flutes = feed per minute
Sfm	= S * D * π / 12

TURNING CARBIDE INSERT