



CNMG.RM 432 ZSL12



APPLICATION

- Suitable for medium to heavy machining of steels, stainless-steels and cast-irons
- Continuous cutting conditions

GRADE ZSL12

This is a PVD coated extra fine grained WC-Co carbide within ISO ranges P01 - P15/M01 - M15 and K05 - K20, for medium to heavy machining of steels, stainless-steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P01-P15	M01-M15	K05-K20		S05-S20	
Sfm ft/min	459 - 673	328 - 476	361 - 541		98 - 230	
Fn Inch/rev	.008 - .020	.008 - .017	.008 - .020		.008 - .014	
ap Inch	.039 - .276	.039 - .276	.039 - .276		.039 - .220	

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