

CNGG.SF 430 ZSL12



APPLICATION

- Suitable for fine machining of stainless steel and super-alloys
- Continuous cut



GRADE ZSL12

This 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		M10 - M25	K10 - K25	N10 - N25	S10 - S25	
Sfm ft/min		197 - 377	312 - 607	509 - 2264	82 - 230	
Fn Inch/rev		.003 - .004	.003 - .005	.003 - .006	.003 - .004	
ap Inch		.008 - .098	.008 - .098	.008 - .098	.008 - .079	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT