



CNMG.NF 431 ZSL12

APPLICATION

- Suitable fine to medium machining of steels and stainless-steels
- Continuous cutting conditions



GRADE ZSL12

This is a PVD coated extra fine grained WC-Co carbide within ISO ranges P01 - P15 and M01 - M15

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10	M10	K10	N10	S15	
Sfm ft/min	394 - 673	279 - 476	312 -541	591 - 2346	82 - 230	
Fn Inch/rev	.005 - .010	.005- .009	.005 - .010	.005 - .012	.005 - .008	
ap Inch	.016 - .118	.016 - .118	.016 - .118	.016 - .118	.016 - .094	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT