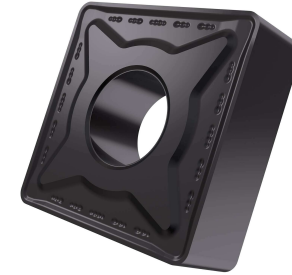


SNMG.RM 644 ZSL12



APPLICATION

- Suitable for medium to heavy machining of steels, stainless-steels and cast-irons
- 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 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		S01 -S15	
Sfm ft/min	443 - 673	312 - 476	344 - 541		98 - 230	
Fn Inch/rev	.012 - .032	.013 - .028	.012 - .032		.013 - .022	
ap Inch	.079 - .394	.079 - .394	.079 - .394		.079 - .315	

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