

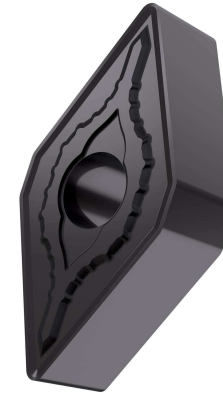
DNMG.SM 431 ZSL12



- Suitable for fine to heavy machining of steels, stainless-steels, cast-irons and super-alloys

- Continuous and interrupted cut

APPLICATION



GRADE ZSL12

This grade is a PVD coated extra fine grained WC-Co carbide within ISO ranges P01 - P15/M01 - M15/K05 - K20 and S01 - S15, for fine to heavy machining of steels, stainless-steels, cast-irons and super-alloys

	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	295 - 459	197 - 328	230 - 361	443 - 1608	66 - 164	49 - 82
Fn Inch/rev	.007 - .008	.007 - .007	.007 - .008	.007 - .009	.007 - .007	.005 - .006
ap Inch	.016 - .157	.016 - .157	.016 - .157	.016 - .157	.016 - .126	.008 - .02

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT