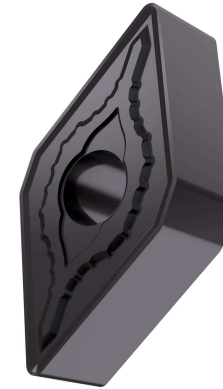


# DNMG.SM 432 ZSL12



## APPLICATION

- Suitable for fine to heavy machining of steels, stainless-steels, cast-irons and super-alloys
- 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/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
<b>GROUP</b>	P01 - P15	M01 - M15	K05 - K20	N01 - N15	S01 - S15	H01 - H15
<b>Sfm ft/min</b>	279 - 509	197 - 361	213 - 410	410 - 1772	66 - 180	49 - 98
<b>Fn Inch/rev</b>	.008 - .016	.009 - .014	.008 - .016	.008 - .019	.008 - .013	.005 - .008
<b>ap Inch</b>	.031 - .157	.031 - .157	.031 - .157	.031 - .157	.031 - .126	.016 - .039

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**