



KNUX 3331 R11 Z14



APPLICATION

- Suitable for machining steel and hard material
- Special design negative turning insert, 55° parallelogram

GRADE Z14

This is MT-CVD coated WC-Co carbide within ISO ranges P20-P40 and M20-M35, for medium to heavy machining of steels and stainless-steels with a left handed turning tool

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|------------|-----------------|-----------------|-----------------|-------------|----------|--------------|
| GROUP | P30 | M30 | K30 | | | |
| Sfm ft/min | 722 - 968 | 262 - 344 | 673 - 919 | | | |
| Fn Inch/Z | 0.0059 - 0.0091 | 0.0087 - 0.0089 | 0.0059 - 0.0091 | | | |
| ap Inch | 0.02 - 0.157 | 0.02 - 0.189 | 0.02 - 0.157 | | | |

LEGEND

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

FORMULA

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