



KNUX 3331 R12 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	459 - 574	262 - 344	427 - 541			
Fn Inch/Z	0.0079 - 0.0098	0.0087 - 0.0089	0.0079 - 0.0098			
ap Inch	0.02 - 0.189	0.02 - 0.189	0.02 - 0.189			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT