



# KNUX 3331 L11 Z11

## APPLICATION

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



## GRADE Z11

This is a MT-CVD coated WC-Co carbide within ISO range K10-K25, for fine to medium machining of cast-irons with a left handed turning tool

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K20			
Sfm ft/min	722 - 968		673 - 919			
Fn Inch/Z	0.0059 - 0.0091		0.0059 - 0.0091			
ap Inch	0.02 - 0.157		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

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

**TURNING CARBIDE INSERT**