



KNUX 3332 L12 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	689 - 1066		640 - 1001			
Fn Inch/Z	0.0079 - 0.0197		0.0079 - 0.0197			
ap Inch	0.039 - 0.189		0.039 - 0.189			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT