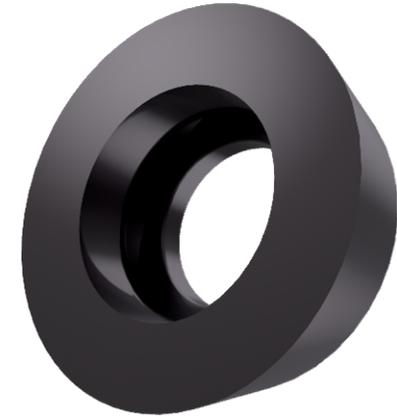




RDHW 0501MOE Z4

APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .0480"



GRADE Z4

This is a PVD coated WC-(Ti, Ta, Nb)C-Co carbide for machining with copy face mills TORY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			H15
Sfm ft/min	1050 - 1624		984 - 1542			197 - 312
Fn Inch/Z	0.002 - 0.0059		0.002 - 0.0059			0.002 - 0.0059
ap Inch	0.012 - 0.059		0.012 - 0.059			0.012 - 0.02

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT