



RDHW 07T1MOT Z4

APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .0787"



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	951 - 1280		902 - 1214			180 - 246
Fn Inch/Z	0.0039 - 0.0079		0.0039 - 0.0079			0.0039 - 0.0055
ap Inch	0.02 - 0.079		0.02 - 0.079			0.016 - 0.028

LEGEND

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

FORMULA

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