



# RDHW 1003MOT Z4

## APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .0984"



## 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
<b>GROUP</b>	P15		K15			H15
<b>Sfm ft/min</b>	820 - 1263		771 - 1198			164 - 246
<b>Fn Inch/Z</b>	0.0039 - 0.0118		0.0039 - 0.0118			0.0039 - 0.0094
<b>ap Inch</b>	0.02 - 0.098		0.02 - 0.098			0.02 - 0.039

### LEGEND

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

### FORMULA

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

**MILLING CARBIDE INSERT**