



RDHW 1604MOT Z5

APPLICATION

- Suitable for machining steel to empty pockets
- round insert for a maximum depth of cut of .1575"



GRADE Z5

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	P25 - P35					
Sfm ft/min	558 - 755					
Fn Inch/Z	0.0079 - 0.0157					
ap Inch	0.039 - 0.157					

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT