



RDHW 1604MOT Z4

APPLICATION

- Suitable for machining steel and hard material
- round insert for a maximum depth of cut of .1575"



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	738 - 1001		689 - 935			148 - 197
Fn Inch/Z	0.0079 - 0.0157		0.0079 - 0.0157			0.0047 - 0.0079
ap Inch	0.039 - 0.157		0.039 - 0.157			0.024 - 0.063

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT