



# XDHW 040110 Z5

## APPLICATION



- Suitable for machining steel
- Single-sided milling insert XDHW 10T3 with a plane rake surface, 70° rhomboid for a maximum depth of cut of .0114"

## GRADE Z5

This is a TiAlN PVD coated WC-(Ti, Ta, Nb)C-Co carbide

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30					
Sfm ft/min	623 - 1033					
Fn Inch/Z	0.002 - 0.0087					
ap Inch	0.008 - 0.039					

### LEGEND

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

### FORMULA

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