

## Inserts

Cat. No	Accuracy	Honing	Grades		
			Coated		Uncoated
			AH120	UX30	TH10
RDCN2004TN	C	With		●	
RDCN2004FN		Without			
RDCA2004TN		With		●	
RDCA2004FN		Without			
RDKN2004TN	K	With	●	●	
RDKN2004FN		Without			●

The above figure shows RD□N-type insert.

- RDCA type inserts have a hole.

Note: The inserts can be used for the former PS series.

## Standard cutting conditions

Work materials	Grades	Cutting speed V <sub>c</sub> (SFM)	Depth of cut: .016 - .039	Depth of cut: .060 - .118	Depth of cut: .157 - .236
			Feed per tooth f <sub>z</sub> (in/t)	Feed per tooth f <sub>z</sub> (in/t)	Feed per tooth f <sub>z</sub> (in/t)
Carbon steels, alloy steels (< 300HB)	AH120	500 ~ 820	.012 ~ .020	.008 ~ .012	.004 ~ .008
	UX30	260 ~ 500	.012 ~ .024		
Die steels (< 30HRC)	AH120	330 ~ 500	.008 ~ .016	.006 ~ .012	
	UX30	260 ~ 425	.010 ~ .020		
Grey cast irons, ductile cast irons	AH120	330 ~ 500	.012 ~ .024	.008 ~ .016	.004 ~ .010
	TH10	260 ~ 425			
Hardened steels (40 ~ 55HRC)	AH120	65 ~ 200	.004 ~ .008	.004 ~ .008	-
	UX30				

Note: Feed rate should be inversely proportional to depth of cut and selected depending on machine rigidity.