



# RPM.Bar

## RODA PLUS

### GRADES

304/304L Plus	303 Plus	303 Cu	416 HT
316/316L Plus	416 Plus	304 Cu	

*Rev up productivity*

## RODA PRECISION MACHINING BAR

### Martensitic // Austenitic Stainless Steel

- Heat to heat consistency
- Eddy current tested
- Precision 1/2 Standard Tolerance
- DFARS compliant
- Ultrasonic testing available with mill orders
- Available Sizes 1/8" to 3-7/8" diameter
- We designed our Roda Precision Machining Bar, not only with superior machinability, but also with Accuracy Tolerances.

### TYPICAL SIZE TOLERANCES

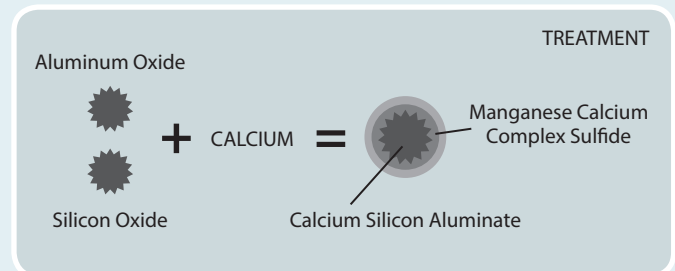
DIAMETER	RPM TOL.J9	VS	ASTM
1/4"	± 0.0006"		± 0.001"
7/16"	± 0.0007"		± 0.0015"
5/8"	± 0.001"		± 0.002"

### ATTRIBUTES

ITEM	RPM BAR
Out of Round	1/2 ° Tol.
Straightness	1/32" / 5ft
Length 12ft	+ 2" / -0"
Chamfer	45/30°

## HOW IT WORKS

Our calcium treated stainless steel is designed to promote superior maintainability.



## The Process

Calcium is added during the melt process and reacts with aluminum & silicon oxides, which are very hard and detrimental to the cutting edge of tools. The calcium envelopes these oxides in a Mn-Ca complex sulphide layer which neutralizes these abrasive characteristics.

## The Benefits

The complex inclusions created by the Calcium addition have a low melting point of about 1100°C. At high cutting speeds with carbide cutting tools, this temperature is easily achieved. Under these conditions, the Ca-Si complex inclusions melt, providing a lubricating "film" between the cutting tool and the material.

## The Results

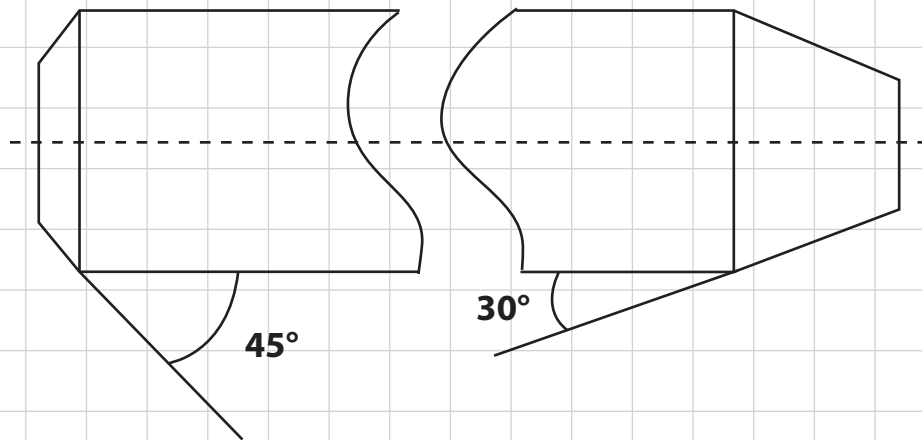
- Higher cutting speeds & feeds
- Increased tool life
- Better surface finish





# *RPM.Bar*

## CHAMFER DESIGN



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