Applicable Inserts

Part Number	Applicable Inserts ➡ B21		
	 Tough Edge	 Tough Edge	
MRP ...-08	RDMT08T2M0-H	-	-
...-10	-	-	RPMT10T3M0
...-12	-	RPMT1204M0-H	RPMT1204M0
...-16	-	RPMT1606M0-H	-
...-20	-	RPMT2006M0-H	-

Top Face

Low cutting force and good chip evacuation with new chipbreaker design. "-H" type insert has a second cutting edge next to the first cutting edge that adds edge strength.

Ratchet design prevents the insert's movement and holds the insert firmly in the insert pocket even during heavy machining.
(Only RPMT)

Bottom Face

Insert Part Number	Land at Edge	Applications	Notes
RPMT10T3M0 **RPMT1204M0**	No	Low Cutting Force	Even if the workpiece clamp is weak, or if the workpiece is thin, sharp cutting performance and less chattering is achieved.
RPMT08T2M0-H **RPMT1204M0-H** **RPMT1606M0-H** **RPMT2006M0-H**	Parallel Land 0.008" Width	Tough Edge	Used for General Roughing.

Recommended Cutting Conditions

Workpiece Material	Feed Rate fz (ipt)	Recommended Insert Grades (Cutting Speed Vc: sfm)			
		Cermet	MEGACOAT		Carbide
		TN100M	**PR1230**	**PR1210**	**KW10**
Carbon Steel	~0.024	★ 390~820	★ 390~820	-	-
Alloy Steel	~0.024	★ 330~590	★ 330~720	-	-
Mold Steel	~0.020	★ 330~590	★ 260~590	-	-
Stainless Steel	~0.016	☆ 390~660	★ 390~720	-	-
Cast Iron	~0.024	-	-	★ 330~720	☆ 260~490
Non-ferrous Metals	~0.024	-	-	-	★ 330~980

Notes) Reduce the D.O.C. by 20-50% when machining with long overhang length or using long shank types.

★: 1st Recommendation ☆: 2nd Recommendation