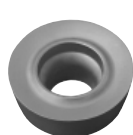
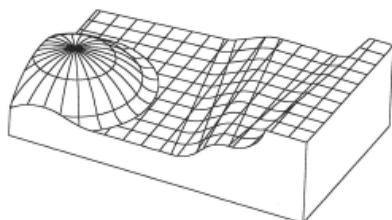


● Applicable Inserts

Applicable Inserts ➡ M20			
Toolholder			
			
MRP ...-08 ...-10 ...-12 ...-16 ...-20	RDMT08T2M0-H	-	-
	-	RPMT1204M0-H	RPMT10T3M0
	-	RPMT1606M0-H	RPMT1204M0
	-	RPMT2006M0-H	-
	-	-	-

Flexible Curved Facing



Top Face

Low cutting force and good chip evacuation by new chipbreaker design.
“-H” type insert has a land at the cutting edge which adds edge strength.

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

Bottom Face



Insert	Land at Edge	Features	Remarks
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 demonstrated.
RPMT08T2M0-H RPMT1204M0-H RPMT1606M0-H RPMT2006M0-H	Parallel Land 0.2mm Width	Tough Edge	Used in General Roughing.

◆ Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc: m/min)													
		Cermet			PVD Coated Carbide						Carbide		PCD		
		TN60	TN100M	TC60	PR630	PR730	PR830			PR660	PR905	PW30	KW10	KPD001	KPD010
Stainless Steel	~0.4		☆ 120~200			☆ 120~200				★ 100~180					
Carbon Steel	~0.6		★ 120~200			★ 120~200				☆ 100~180					
Alloy Steel	~0.6		★ 100~180			★ 100~180				☆ 80~150					
Mold Steel	~0.5		★ 100~180			★ 80~150				☆ 60~130					
Cast Iron	~0.6									★ 100~180		☆ 80~150			
Non-ferrous Metals	~0.6											★ 100~300			

Note) Reduce the ap by 20-50% when machining with long overhang length or using long shank types.

★ : 1st Recommendation ☆ : 2nd Recommendation

M



Milling