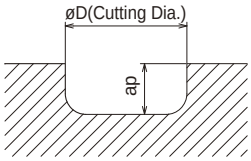
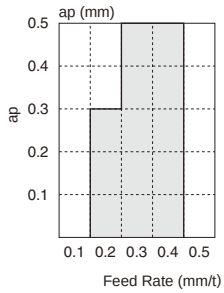
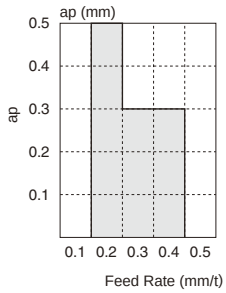
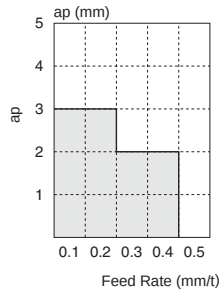
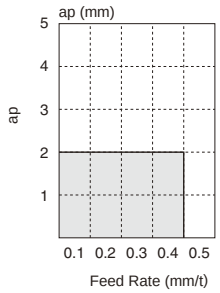
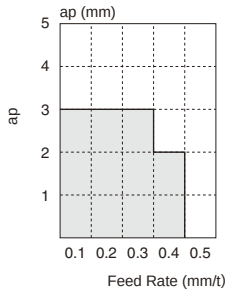
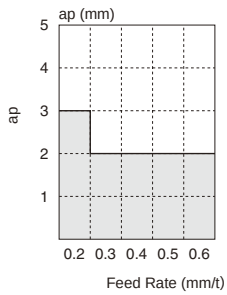
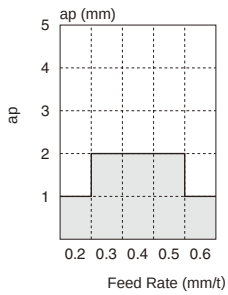
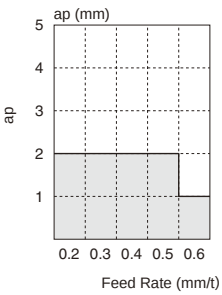
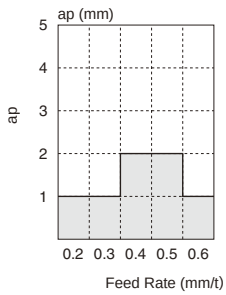
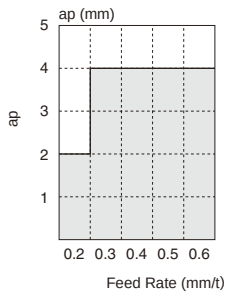
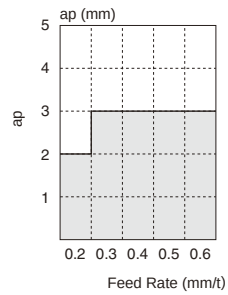
◆ Cutting Performance of Radius Mill (Long Shank type)

Workpiece Material	Slotting			
C50 (S50C)	 ●Cutting Conditions Tooholder: Standard Vc=120 ～150m/min (See below table) ap = varied fz= varied Dry Overhang Length = L_1 (See below table)			
Description				
08 type (RDMT08T2M0-H)	MRP012-S16-08-160 n=3980min^{-1} (Vc=150m/min) L_1=80mm 	MRP016-S16-08-160 n=2980min^{-1} (Vc=150m/min) L_1=80mm 	MRP020-S20-08-180 n=2390min^{-1} (Vc=150m/min) L_1=90mm 	
10 type (RPMT10T3M0)	MRP025-S25-10-3T-180 n=1910min^{-1} (Vc=150m/min) L_1=90mm 	MRP032-S32-10-4T-200 n=1490min^{-1} (Vc=150m/min) L_1=100mm 		
12 type (RPMT1204M0-H)	MRP032-S25-12-300 n=1490min^{-1} (Vc=150m/min) L_1=150mm 	MRP040-S32-12-300 n=1195min^{-1} (Vc=150m/min) L_1=150mm 	MRP040-S32-12-4T-200 n=1195min^{-1} (Vc=150m/min) L_1=100mm 	MRP050-S42-12-300 n=765min^{-1} (Vc=120m/min) L_1=150mm 
16 type (RPMT1606M0-H)	MRP040-S32-16-300 n=1195min^{-1} (Vc=150m/min) L_1=150mm 	MRP050-S42-16-300 n=765min^{-1} (Vc=120m/min) L_1=150mm 	MRP063-S42-16-300 n=605min^{-1} (Vc=120m/min) L_1=150mm