



RC

06/ 08/ 12/ 16/ 20/ 25/ 32

CARBIDE INSERTS

RCGT	RCMT	RCMW	RCMX
118	118	120	121

CER INSERTS

RCGX CER
123

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
RCMT 1204MOE-RM3	SRDCN 3225 P 12-M

ISO TURNING – EXTERNAL

PRDCN EXT	PRSC(RL) EXT	SRDC(RL) EXT	SRDCN EXT
90° 40×40 50×50 124	27° 40×40 125	20×20 32×25 126	12×12 32×25 127
RC.. 20 25 32 118 – 123	RC.. 16 25 118 – 123	RC.. 08 118 – 123	RC.. 06 08 10 12 16 118 – 123
SRSC(RL) EXT	C.-SRDCN EXT		
27° 12×12 32×25 128	90° C4 C5 130		
RC.. 06 08 10 12 16 118 – 123	RC.. 10 12 118 – 123		

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

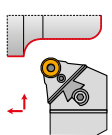


RC

06/ 08/ 12/ 16/ 20/ 25/ 32

ISO TURNING – HEAVY ROUGHING – EXTERNAL

KHP-RSCR/L + DKH(RL)

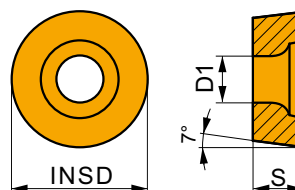
 DKHR+KHP-RSCR		RC..
		
		20
		25
	40×50	32
	60×80	
 131, 132		 118 – 123



RCGT

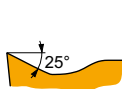


	INSD	D1	S
	[mm]	[mm]	[mm]
0803	8.0	3.40	3.18
1003	10.0	4.40	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



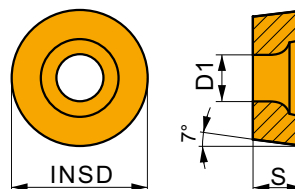
AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

RCGT 0803MOF-AL	HF7	—	—	—	—	—	—	—	—	—	285	1.20	1.0	—	—	—	—	—	—
	T0315	—	—	—	—	—	—	—	—	—	420	1.20	1.0	—	—	—	—	—	—
RCGT 1003MOF-AL	HF7	—	—	—	—	—	—	—	—	—	255	1.50	1.0	—	—	—	—	—	—
	T0315	—	—	—	—	—	—	—	—	—	390	1.50	1.0	—	—	—	—	—	—

RCMT

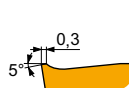


	INSD	D1	S
	[mm]	[mm]	[mm]
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76
1606	16.0	5.50	6.35
2006	20.0	6.50	6.35
2507	25.0	8.60	7.94



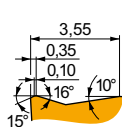
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



Geometry 37 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMT 1606MOS-37	T9315	—	165	0.60	3.0	—	—	—	155	0.60	3.0	—	—	—	—	—	—	—	—
	T9325	—	145	0.60	3.0	—	—	—	135	0.60	3.0	—	—	—	—	—	—	—	—



Geometry 371 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

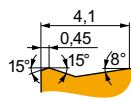
RCMT 2006MOS-371	T9315	—	145	0.80	3.0	—	—	—	135	0.80	3.0	—	—	—	—	—	—	—	—
	T9325	—	125	0.80	3.0	—	—	—	115	0.80	3.0	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



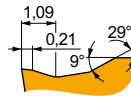
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



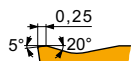
Geometry 372 for semi-rough to heavy-rough machining, continuous to interrupted cuts.

RCMT 2507M05-372	T9325	—	90	0.80	3.0	—	—	—	85	0.80	3.0	—	—	—	—	—	—	—	—	—
------------------	-------	---	----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---	---	---



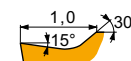
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

RCMT 0602M0E-FM	T7325	—	215	0.45	1.2	165	0.41	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	190	0.45	1.2	110	0.41	1.2	180	0.45	1.2	570	0.54	1.2	—	—	—	—	—
	T8430	—	200	0.45	1.2	110	0.41	1.2	165	0.45	1.2	555	0.54	1.2	—	—	—	—	—
	T9315	—	260	0.45	1.2	—	—	—	245	0.45	1.2	—	—	—	—	—	—	—	—
	T9325	—	235	0.45	1.2	140	0.41	1.2	220	0.45	1.2	—	—	—	—	—	—	—	—
RCMT 0803M0E-FM	T7325	—	190	0.60	1.6	145	0.54	1.6	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	170	0.60	1.6	100	0.54	1.6	160	0.60	1.6	510	0.72	1.6	—	—	—	—	—
	T8430	—	175	0.60	1.6	95	0.54	1.6	140	0.60	1.6	480	0.72	1.6	—	—	—	—	—
	T9315	—	225	0.60	1.6	—	—	—	210	0.60	1.6	—	—	—	—	—	—	—	—
	T9325	—	200	0.60	1.6	120	0.54	1.6	190	0.60	1.6	—	—	—	—	—	—	—	—
RCMT 10T3M0E-FM	T7325	—	185	0.65	1.7	140	0.59	1.7	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	165	0.65	1.7	95	0.59	1.7	155	0.65	1.7	495	0.78	1.7	—	—	—	—	—
	T8430	—	170	0.65	1.7	90	0.59	1.7	135	0.65	1.7	465	0.78	1.7	—	—	—	—	—
	T9315	—	220	0.65	1.7	—	—	—	205	0.65	1.7	—	—	—	—	—	—	—	—
	T9325	—	195	0.65	1.7	115	0.59	1.7	185	0.65	1.7	—	—	—	—	—	—	—	—
RCMT 1204M0E-FM	T7325	—	175	0.70	1.8	135	0.63	1.8	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	160	0.70	1.8	95	0.63	1.8	150	0.70	1.8	480	0.84	1.8	—	—	—	—	—
	T8430	—	155	0.70	1.8	85	0.63	1.8	130	0.70	1.8	435	0.84	1.8	—	—	—	—	—
	T9315	—	205	0.70	1.8	—	—	—	190	0.70	1.8	—	—	—	—	—	—	—	—
	T9325	—	190	0.70	1.8	110	0.63	1.8	180	0.70	1.8	—	—	—	—	—	—	—	—



RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

RCMT 0803M0E-RM3	T7325	—	185	0.50	1.3	140	0.45	1.3	—	—	—	—	—	—	—	—	—	—	—
	T9315	—	225	0.50	1.3	—	—	—	210	0.50	1.3	—	—	—	—	—	45	0.15	1.0
RCMT 1204M0E-RM3	H07	—	—	—	—	65	0.54	1.8	105	0.60	1.8	—	—	—	—	—	—	—	—
	T7325	—	165	0.60	1.8	125	0.54	1.8	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	150	0.60	1.8	90	0.54	1.8	140	0.60	1.8	—	—	—	—	—	30	0.15	1.0
	T8430	—	150	0.60	1.8	80	0.54	1.8	125	0.60	1.8	—	—	—	—	—	25	0.15	1.0
	T9315	—	205	0.60	1.8	—	—	—	190	0.60	1.8	—	—	—	—	—	40	0.15	1.0
RCMT 1606M0E-RM3	T7325	—	160	0.65	2.0	120	0.59	2.0	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	145	0.65	2.0	85	0.59	2.0	135	0.65	2.0	—	—	—	—	—	25	0.15	1.0
	T8430	—	145	0.65	2.0	80	0.59	2.0	120	0.65	2.0	—	—	—	—	—	25	0.15	1.0
	T9315	—	195	0.65	2.0	—	—	—	185	0.65	2.0	—	—	—	—	—	35	0.15	1.0
RCMT 2507M0E-RM3	H07	—	—	—	—	60	0.54	3.0	95	0.60	3.0	—	—	—	—	—	—	—	—



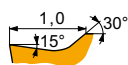
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

RCMT 0602M0E-UR	T6310	—	170	0.40	1.2	120	0.36	1.2	135	0.40	1.2	—	—	—	—	—	—	—	—
	T7325	—	190	0.40	1.2	145	0.36	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	170	0.40	1.2	100	0.36	1.2	160	0.40	1.2	—	—	—	—	—	—	—	—
	T8430	—	180	0.40	1.2	95	0.36	1.2	145	0.40	1.2	—	—	—	—	—	—	—	—
	T9315	—	240	0.40	1.2	—	—	—	225	0.40	1.2	—	—	—	—	—	—	—	—
	T9325	—	215	0.40	1.2	125	0.36	1.2	200	0.40	1.2	—	—	—	—	—	—	—	—



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



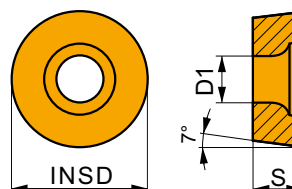
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

RCMT 0803MOE-UR	T6310	—	160	0.45	1.6	115	0.41	1.6	125	0.45	1.6	—	—	—	—	—	—	—	—	—
	T7325	—	180	0.45	1.6	140	0.41	1.6	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	160	0.45	1.6	95	0.41	1.6	150	0.45	1.6	—	—	—	—	—	—	—	—	—
	T8430	—	170	0.45	1.6	90	0.41	1.6	135	0.45	1.6	—	—	—	—	—	—	—	—	—
	T9315	—	220	0.45	1.6	—	—	—	205	0.45	1.6	—	—	—	—	—	—	—	—	—
	T9325	—	200	0.45	1.6	120	0.41	1.6	190	0.45	1.6	—	—	—	—	—	—	—	—	—
RCMT 10T3MOE-UR	T6310	—	160	0.50	1.4	115	0.45	1.4	125	0.50	1.4	—	—	—	—	—	—	—	—	—
	T7325	—	175	0.50	1.4	135	0.45	1.4	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	160	0.50	1.4	95	0.45	1.4	150	0.50	1.4	—	—	—	—	—	—	—	—	—
	T8430	—	165	0.50	1.4	90	0.45	1.4	135	0.50	1.4	—	—	—	—	—	—	—	—	—
	T9315	—	215	0.50	1.4	—	—	—	200	0.50	1.4	—	—	—	—	—	—	—	—	—
	T9325	—	190	0.50	1.4	110	0.45	1.4	180	0.50	1.4	—	—	—	—	—	—	—	—	—
RCMT 1204MOE-UR	T6310	—	150	0.55	1.8	105	0.50	1.8	120	0.55	1.8	—	—	—	—	—	—	—	—	—
	T7325	—	165	0.55	1.8	125	0.50	1.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	—	150	0.55	1.8	90	0.50	1.8	140	0.55	1.8	—	—	—	—	—	—	—	—	—
	T8430	—	145	0.55	1.8	80	0.50	1.8	120	0.55	1.8	—	—	—	—	—	—	—	—	—
	T9315	—	200	0.55	1.8	—	—	—	190	0.55	1.8	—	—	—	—	—	—	—	—	—
	T9325	—	180	0.55	1.8	105	0.50	1.8	170	0.55	1.8	—	—	—	—	—	—	—	—	—

RCMW

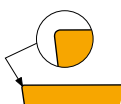


	INS D (mm)	D1 (mm)	S (mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

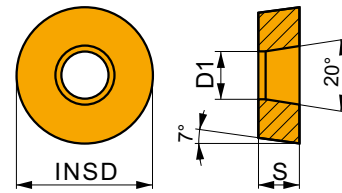
RCMW 0602M0	T5305	—	—	—	—	—	—	—	280	0.25	0.6	—	—	—	—	—	—	55	0.15	1.0
	T5315	—	—	—	—	—	—	—	250	0.25	0.6	—	—	—	—	—	—	50	0.15	1.0
RCMW 0803M0	T5305	—	—	—	—	—	—	—	255	0.30	0.8	—	—	—	—	—	—	50	0.15	1.0
	T5315	—	—	—	—	—	—	—	230	0.30	0.8	—	—	—	—	—	—	45	0.15	1.0
RCMW 10T3M0	T5305	—	—	—	—	—	—	—	225	0.40	1.0	—	—	—	—	—	—	45	0.15	1.0
	T5315	—	—	—	—	—	—	—	200	0.40	1.0	—	—	—	—	—	—	40	0.15	1.0
RCMW 1204M0	T5305	—	—	—	—	—	—	—	205	0.45	1.2	—	—	—	—	—	—	40	0.15	1.0
	T5315	—	—	—	—	—	—	—	190	0.45	1.2	—	—	—	—	—	—	40	0.15	1.0



RCMX

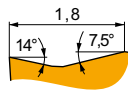


	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.60	3.18
1204	12.0	4.20	4.76
1606	16.0	5.20	6.35
2006	20.0	6.50	6.35
2507	25.0	7.20	7.94
3209	32.0	9.50	9.53



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

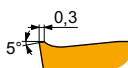
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



Geometry 31 for finish to semi-rough machining, and continuous to interrupted cuts.

RCMX 1003M05-31

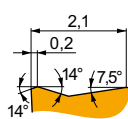
T9325	—	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	—	—	—	—	—	—	—	—	—
T9335	—	140	0.50	2.0	80	0.45	2.0	—	—	—	—	—	—	—	—	—	—	—	—



Geometry 37 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMX 1606M05-37

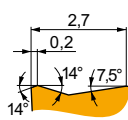
T9315	—	165	0.60	3.0	—	—	—	155	0.60	3.0	—	—	—	—	—	—	—	—	—
T9325	—	145	0.60	3.0	—	—	—	135	0.60	3.0	—	—	—	—	—	—	—	—	—



Geometry 321 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMX 1204M05-321

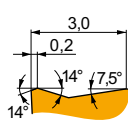
T9315	—	130	1.00	3.0	—	—	—	120	1.00	3.0	—	—	—	—	—	—	—	—	—
T9325	—	120	1.00	3.0	—	—	—	110	1.00	3.0	—	—	—	—	—	—	—	—	—
T9335	—	105	1.00	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



Geometry 331 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMX 1606M05-331

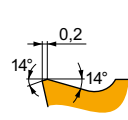
T9315	—	120	1.20	3.5	—	—	—	110	1.20	3.5	—	—	—	—	—	—	—	—	—
T9325	—	105	1.20	3.5	—	—	—	95	1.20	3.5	—	—	—	—	—	—	—	—	—
T9335	—	110	0.80	3.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



Geometry 341 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMX 2006M05-341

6640	—	90	1.00	3.5	—	—	—	85	1.00	3.5	—	—	—	—	—	—	—	—	—
------	---	----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---	---	---



Geometry 351 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMX 2507M05-351

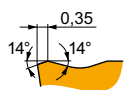
6640	—	60	1.00	3.5	—	—	—	55	1.00	3.5	—	—	—	—	—	—	—	—	—
------	---	----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---	---	---

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



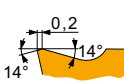
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



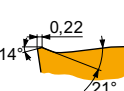
Geometry 361 for rough to heavy-rough machining and continuous to heavy interrupted cuts.

RCMX 3209M0S-361	6640	—	50	1.40	4.5	—	—	—	45	1.40	4.5	—	—	—	—	—	—	—	—	—
------------------	------	---	----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---	---	---



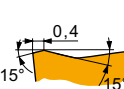
RF1 geometry for finish to semi-rough machining, and continuous to interrupted cuts.

RCMX 2006M0-RF1	T5305	—	105	0.80	3.5	—	—	—	95	0.80	3.5	—	—	—	—	—	—	—	—	—
	T9310	—	105	0.80	3.5	—	—	—	95	0.80	3.5	—	—	—	—	—	—	—	—	—
	T9315	—	100	0.80	3.5	—	—	—	95	0.80	3.5	—	—	—	—	—	—	—	—	—
	T9325	—	90	0.80	3.5	—	—	—	85	0.80	3.5	—	—	—	—	—	—	—	—	—
	T9335	—	110	0.80	3.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
RCMX 2507M0-RF1	T8345	—	45	1.00	3.5	—	—	—	40	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9310	—	95	1.00	3.5	—	—	—	90	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9315	—	90	1.00	3.5	—	—	—	85	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9325	—	80	1.00	3.5	—	—	—	75	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9335	—	65	1.00	3.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



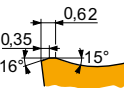
RM1 geometry for finish to rough machining, and continuous to interrupted cuts.

RCMX 2006M0-RM1	T9310	—	95	1.00	3.5	—	—	—	90	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9315	—	90	1.00	3.5	—	—	—	85	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9325	—	80	1.00	3.5	—	—	—	75	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9335	—	125	0.60	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
RCMX 2507M0-RM1	T9310	—	95	1.00	3.5	—	—	—	90	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9315	—	90	1.00	3.5	—	—	—	85	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9325	—	80	1.00	3.5	—	—	—	75	1.00	3.5	—	—	—	—	—	—	—	—	—
	T9335	—	80	0.60	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



RM2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

RCMX 2507M0-RM2	T9310	—	90	1.10	3.5	—	—	—	85	1.10	3.5	—	—	—	—	—	—	—	—	—
	T9315	—	85	1.10	3.5	—	—	—	80	1.10	3.5	—	—	—	—	—	—	—	—	—
	T9325	—	75	1.10	3.5	—	—	—	70	1.10	3.5	—	—	—	—	—	—	—	—	—
RCMX 3209M0-RM2	T5315	—	95	1.00	4.5	—	—	—	90	1.00	4.5	—	—	—	—	—	—	—	—	—
	T9310	—	90	1.00	4.5	—	—	—	85	1.00	4.5	—	—	—	—	—	—	—	—	—
	T9315	—	85	1.00	4.5	—	—	—	80	1.00	4.5	—	—	—	—	—	—	—	—	—
	T9325	—	75	1.00	4.5	—	—	—	70	1.00	4.5	—	—	—	—	—	—	—	—	—
	T9335	—	55	1.40	4.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



RR2 geometry for heavy rough machining, and continuous to interrupted cuts.

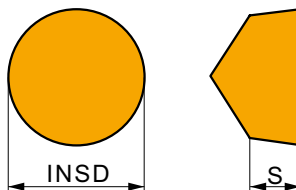
RCMX 3209M0-RR2	T9315	—	60	1.40	4.5	—	—	—	55	1.40	4.5	—	—	—	—	—	—	10	0.15	1.0
	T9316	—	60	1.40	4.5	—	—	—	55	1.40	4.5	—	—	—	—	—	—	—	—	—



RCGX CER

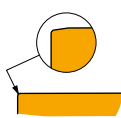


	INSD	S
	(mm)	(mm)
0606	6.350	6.35
0907	9.525	7.94
1207	12.700	7.94



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For machining with high speeds and continuous cuts.

RCGX 060600 K15015	TC100	—	—	—	—	—	—	—	365	0.30	0.8	—	—	—	—	—	—	—	—	—
RCGX 090700 K15015	TC100	—	—	—	—	—	—	—	410	0.20	1.2	—	—	—	—	—	—	—	—	—
RCGX 120700 K15015	TC100	—	—	—	—	—	—	—	405	0.20	1.5	—	—	—	—	—	—	—	—	—