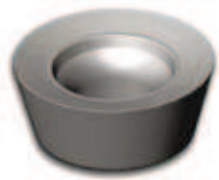


Milling



**R**

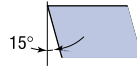
**D**

**M**

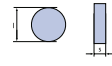
**T**



**Shape**  
Round



**Clearance Angle**  
15°



**Tolerance**  
ll ± 0.05  
s ± 0.13



**Insert Type**  
Screw down clamping  
chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
RDMT 0602 MO	LT 30	6	2,38	3		Neutral	M0000035	175
RDMT 0803 MO	LT 30	8	3,18	4		Neutral	M0000037	176
RDMT 1003 MO	LT 30	10	3,18	5		Neutral	M0001875	177
RDMT 10T3 MO	LT 30	10	3,97	5		Neutral	M0000038	177
RDMT 1204 MO	LT 30	12	4,76	6		Neutral	M0000039	178
RDMT 12T3 MO	LT 30	12	3,97	6		Neutral	M0001876	178

**Surfacing Insert Lead angle 90°**

Application Guide

Surfacing

Copying

Mould-Milling

Multi purpose Round inserts. Suitable for Roughing to Semi-finishing Copying of 3D surfaces and Face milling operations.

Stainless Steel

Vc

Machining Recommendation Guide - Please see Pg. 8



**RDMT 0602 MO**

Cutters Milling

Catalog Nr.	Description	D	H	L	Ap	z
M2000676	LT 060 W-W-D16	16	25	150	3	2
M2000677	LT 060 W-W-D20	20	60	180	3	3
M2000678	LT 060 W-W-D25	25	80	180	3	3

**RDMT 0803 MO**

Catalog Nr.	Description	D	H	L	Ap	z
M2000679	LT 080 W-W-D20	20	42	180	4	2
M2000680	LT 080 W-W-D25	25	60	180	4	3
M2000681	LT 080 W-W-D32	32	80	180	4	3

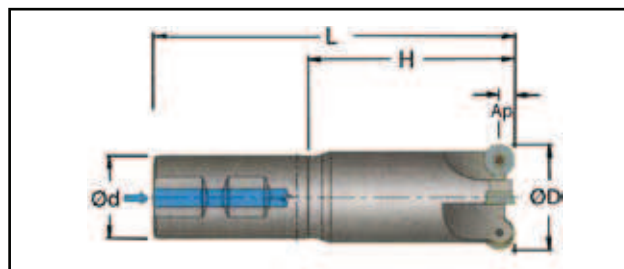
RDMT

**RDMT 1003 MO**

Catalog Nr.	Description	D	H	L	Ap	z
M2002085	LT 105 W-W-D20	20	42	180	4	2
M2002086	LT 105 W-W-D25	25	60	180	4	3
M2002087	LT 105 W-W-D32	32	80	180	4	3

**RDMT 10T3 MO**

Catalog Nr.	Description	D	H	L	Ap	z
M2000683	LT 100 W-W-D20	20	80	180	5	2
M2000684	LT 100 W-W-D25	25	80	180	5	3
M2000685	LT 100 W-W-D32	32	105	212	5	3



Catalog Nr.	Description	D	H	L	Ap	z
M2000687	LT 120 W-W-D40	40	110	170	6	4

Catalog Nr.	Description	D1	D2	d	H	Ap	z
M2000691	LT 120 M-W-D40	40	28	16	40	6	4
M2000689	LT 120 M-W-D63	63	51	27	40	6	5
M2000690	LT 120 M-W-D80	80	68	32	50	6	6
M2000688	LT 120 M-W-D100	100	88	40	50	6	7

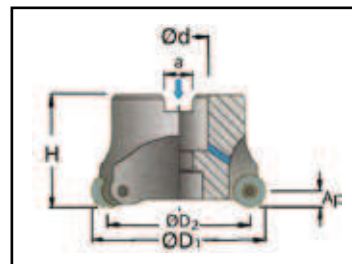
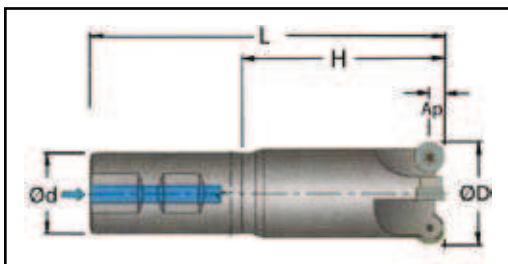
W = With coolant

## RDMT 12T3 M0

Catalog Nr.	Description	D	H	L	Ap	z
M2002088	LT 125 W-W-D40	40	110	170	6	4

Catalog Nr.	Description	D1	D2	d	H	Ap	z
M2002089	LT 125 M-W-D40	40	28	16	40	6	4
M2002090	LT 125 M-W-D63	63	51	27	40	6	5
M2002091	LT 125 M-W-D80	80	68	32	50	6	6
M2002093	LT 125 M-W-D100	100	88	40	50	6	7

W = With coolant



Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	2.0	0.18	0.40	190	350
			180		2.0		0.35		300
			210		1.5		0.32		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	2.0	0.15	0.40	150	240
			230		2.0		0.32		210
			280	0.5	2.0	0.13	0.30	130	190
			320		1.5		0.25		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	2.0	0.13	0.32	90	150
			280		2.0		0.30		130
			320	0.5	1.5	0.13	0.27	60	110
			350		1.5		0.25		90
			400	0.2	0.8	0.12	0.22	40	80
			480		0.5		0.20		70
			550		0.5		0.18		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	2.0	0.14	0.28	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	2.0	0.13	0.25	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	1.5	0.13	0.22	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	2.0	0.15	0.25	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	2.0	0.15	0.25	150	230
			Treated	0.5	2.0	0.15	0.25	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	2.0	0.11	0.45	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	2.0	0.11	0.35	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.2	0.5	0.11	0.20	30	60
Nickel Based Alloys	11	Inconel 625	-----	0.5	1.5	0.13	0.23	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	1.5	0.13	0.25	35	60
		T40					0.18	28	40

RDMT

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	3.0	0.20	0.50	190	350
			180		2.5		0.47		300
			210		1.5		0.43		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	3.0	0.18	0.45	150	240
			230		2.5		0.40		210
			280	0.5	2.0	0.15	0.37	130	190
			320		1.5		0.35		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	2.0	0.13	0.40	90	150
			280		2.0		0.37		130
			320	0.5	1.5	0.13	0.35	60	110
			350		1.5		0.32		90
			400	0.2	1.0	0.12	0.28	40	80
			480		0.5		0.25		70
			550		0.5		0.22		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	3.0	0.14	0.35	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	2.5	0.13	0.32	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	2.0	0.13	0.30	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	2.5	0.15	0.30	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	2.5	0.15	0.30	150	230
			Treated	0.5	2.5	0.15	0.30	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	3.0	0.11	0.50	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	2.5	0.11	0.45	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.2	0.5	0.12	0.25	30	60
Nickel Based Alloys	11	Inconel 625	-----	0.5	2.0	0.13	0.27	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	2.0	0.13	0.32	35	60
		T40					0.25	28	40

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	3.0	0.23	0.58	190	350
			180		2.5		0.52		300
			210		1.5		0.45		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	3.0	0.21	0.52	150	240
			230		2.5		0.47		210
			280	0.5	2.0	0.20	0.43	130	190
			320		1.5		0.40		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	2.0	0.17	0.47	90	150
			280		2.0		0.43		130
			320	0.5	1.5	0.17	0.40	60	110
			350		1.5		0.38		90
			400	0.2	1.0	0.12	0.32	40	80
			480		0.5		0.28		70
550	0.5	0.25	60						
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	3.0	0.17	0.38	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	2.5	0.15	0.35	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	2.0	0.13	0.32	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	2.5	0.15	0.35	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	2.5	0.15	0.35	150	230
			Treated	0.5	2.5	0.15	0.35	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	3.0	0.18	0.60	170	300
GG 25		250							
GG 30		210							
Nodular Cast Iron	10	GGG 40	210	0.5	2.5	0.18	0.50	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.2	0.5	0.12	0.32	30	60
Nickel Based Alloys	11	Inconel 625	-----	0.5	2.0	0.15	0.32	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	2.0	0.17	0.35	35	60
		T40					0.27	28	40

**RDMT**



Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	3.0	0.27	0.70	190	350
			180		2.5		0.65		300
			210		1.5		0.50		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	3.0	0.25	0.65	150	240
			230		2.5		0.57		210
			280	0.5	2.0	0.23	0.52	130	190
			320		1.5		0.50		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	2.0	0.20	0.57	90	150
			280		2.0		0.52		130
			320	0.5	1.5	0.20	0.50	60	110
			350		1.5		0.47		90
			400	0.5	1.5	0.18	0.38	40	80
			480		1.0		0.34		70
			550		0.5		0.30		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	3.0	0.20	0.45	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	2.5	0.17	0.40	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	2.0	0.15	0.37	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	2.5	0.17	0.40	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	2.5	0.17	0.40	150	230
			Treated	0.5	2.5	0.17	0.40	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	3.0	0.20	0.80	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	2.5	0.20	0.60	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.3	1.0	0.16	0.30	30	60
Nickel Based Alloys	11	Inconel 625	-----	0.5	2.0	0.17	0.35	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	2.0	0.20	0.38	35	60
		T40					0.30	28	40