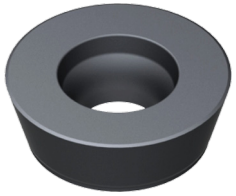
Yverdon-les-Bains, 16th July 2012
NPRM12003

RDMW 1204 M0SN LT 30

Cat. Nr. M0001551

New Product Release

Lamina Technologies Marketing team is delighted to offer a new addition to our Milling Line – RDMW 1204 M0SN LT 30.



Description

- Flat and chamfered cutting edge for an extreme performance in materials with short chips
- ISO round insert for roughing and semi-finishing Milling

Application Area

This new developed insert is completing the Lamina Milling line with the latest and most modern technics in Milling. The robust design increases the ability to machine hardened steel and cast iron on high feed rates.

The insert can be mounted on any type of end mills or shell mills, and is suitable for roughing applications including:

- Pocket milling, shoulder milling, facing, plunging, and ramping down
- Mostly dry machining

Main Advantages

- Fits standard cutters available the market
- Low cost per edge, with unlimited indexes
- Excellent toughness & wear resistance
- Follows the "Multi-Mat™ " Concept but focused on extreme roughing and short chips

Main Competitors

- ISO types of RDHX 1204, RDMT 1204 and RPMT 1204

RDMW 1204 M0SN LT 30

Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		V_c [m/min]		Optimal cutting conditions		
						min	max	min	max	min	max	D.O.C.	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.3	4.0	0.27	0.70	190	350	1.5	0.60	300
			2		190 HB	0.3	4.0	0.27	0.65	190	300	1.5	0.60	250
			3		250 HB	0.3	3.0	0.27	0.50	190	260	1.5	0.50	220
	Low alloyed	2	6	42CrMo4, St50-2, Ck60, 4140, 4340, 100Cr6	180 HB	0.3	4.0	0.25	0.65	150	240	1.5	0.60	210
			4,6		230 HB	0.3	3.0	0.25	0.57	150	210	1.5	0.55	190
			5,7		280 HB	0.3	2.0	0.23	0.52	130	190	1.5	0.50	150
			8		350 HB	0.3	1.5	0.23	0.50	130	170	1.0	0.50	130
	High alloyed	3	10	X40CrMoV5-1, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	2.0	0.20	0.57	90	150	1.0	0.55	130
			10		280 HB	0.3	2.0	0.20	0.52	90	130	1.0	0.50	120
			11		320 HB	0.3	1.5	0.20	0.50	60	110	1.0	0.50	100
			11		350 HB	0.3	1.5	0.20	0.47	60	90	1.0	0.45	90
Stainless Steel	Austenitic	4	14	304, 316, 316L, X5CrNi18-9	180 HB	RDMW inserts are not recommended for Austenitic and Duplex Stainless Steel								
			14		240 HB									
	Duplex	5	14	X2CrNiN23-4, S31500	-									
			14		-									
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	2.0	0.17	0.40	150	210	1.0	0.55	150
			13		42 HRc	0.3	1.5	0.17	0.40	70	150	1.0	0.45	80
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	3.0	0.20	0.80	170	300	2.0	0.80	200
			15		200 HB	0.3	3.0	0.20	0.80	170	250	2.0	0.70	170
			16		250 HB	0.3	3.0	0.20	0.80	150	210	2.0	0.60	150
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.3	2.5	0.20	0.60	120	210	1.5	0.50	210
			17,19		200 HB	0.3	2.5	0.20	0.60	120	170	1.5	0.55	170
			18,20		250 HB	0.3	2.5	0.20	0.60	120	150	1.5	0.60	150
High Temp.Alloys	Ni, Fe & Co based	9	33	Inconel 718, Monel 400, Hastelloy C	250 HB	RDMW inserts are not recommended for High Temperature Alloys								
			34		350 HB									
			31,32		240 HB									
	Ti based	10	36	TiAl6V4, R54520	-									
			37		-									
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42, Ni-Hard 2, G-X260Cr27	45 HRc	0.3	1.0	0.18	0.38	40	80	0.5	0.38	60
			38		50 HRc	0.3	0.8	0.18	0.34	40	70	0.5	0.34	50
			38		55 HRc	0.3	0.5	0.18	0.30	40	60	0.5	0.30	40
	Chilled Cast Iron		40		400 HB	0.3	1.0	0.18	0.38	40	60	0.5	0.38	50
	White Cast Iron		41		55 HRc	0.3	0.5	0.18	0.34	30	60	0.5	0.34	30
NF	Al (>8%Si)	12	25	AlSi12	130 HB	RDMW inserts are not recommended for Non Ferrous Alloys								

This cutting conditions table is showing initial recommendations but, the insert can perform in a wider range.

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