

RDMX 1204 M0EN LT 30

Cat. Nr. M0001553

RDMX 1204 M0EN LT 30

Lamina Technologies Marketing team is delighted to offer a new addition to our Milling Line – RDMX 1204 M0EN LT 30.



Description

- Positive cutting edge for an extreme performance in materials with long 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 positive design reduces the formation of built-up-edge, increases consistency and reduces notch wear.

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


- Pocket milling, shoulder milling, facing, plunging, and ramping down
- Dry & wet machining (according to each material's recommendation)

Main Advantages

- Fits standard cutters available in the market
- Low cost per edge, with unlimited indexes
- Excellent toughness & wear resistance
- Follows the "Multi-Mat™" Concept

Main Competitors

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

Material Group	Gr. N°	VDI Group	Material Examples*	Coolant	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	C35, Ck45, 1020, 1045, 1060, 28Mn6		125 HB	0.3	4.0	0.27	0.70	190	350	1.5	0.60	300
		190 HB			0.3	4.0	0.27	0.65	190	300	1.5	0.60	250	
		250 HB			0.3	3.0	0.27	0.50	190	260	1.5	0.50	220	
	Low alloyed	2	42CrMo4, St50-2, Ck60, 4140, 4340, 100Cr6		180 HB	0.3	4.0	0.25	0.65	150	240	1.5	0.60	210
		230 HB			0.3	3.0	0.25	0.57	150	210	1.5	0.55	190	
		280 HB			0.3	2.0	0.23	0.52	130	190	1.5	0.50	150	
		350 HB			0.3	1.5	0.23	0.50	130	170	1.0	0.50	130	
	High alloyed	3	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
		280 HB			0.3	2.0	0.20	0.52	90	130	1.0	0.50	120	
		320 HB			0.3	1.5	0.20	0.50	60	110	1.0	0.50	100	
		350 HB			0.3	1.5	0.20	0.47	60	90	1.0	0.45	90	
Stainless Steel	Austenitic	4	304, 316, 316L, X5CrNi18-9	180 HB	0.3	3.0	0.20	0.45	190	250	2.5	0.30	200	
		240 HB		0.3	3.0	0.20	0.45	190	250	2.5	0.30	170		
	Duplex	5	X2CrNi23-4, S31500	-	0.3	3.0	0.15	0.40	70	150	2.5	0.25	90	
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	-	0.3	3.0	0.15	0.40	70	150	2.5	0.25	90		
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	3.0	0.20	0.80	170	300	2.0	0.80	200	
		200 HB		0.3	3.0	0.20	0.80	170	250	2.0	0.70	170		
		250 HB		0.3	3.0	0.20	0.80	150	210	2.0	0.60	150		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.3	2.5	0.20	0.60	120	210	1.5	0.50	210	
		200 HB		0.3	2.5	0.20	0.60	120	170	1.5	0.55	170		
		250 HB		0.3	2.5	0.20	0.60	120	150	1.5	0.60	150		
		250 HB		0.3	4.0	0.17	0.35	25	35	3.0	0.25	30		
High Temp. Alloys	Ni, Fe & Co based	9	Inconel 718, Monel 400, Hastelloy C	350 HB	0.3	4.0	0.17	0.35	28	45	3.0	0.25	40	
		240 HB		0.3	4.0	0.17	0.35	40	60	3.0	0.25	55		
		-		0.3	4.0	0.20	0.38	35	60	2.0	0.30	50		
Ti based	10	TiAl6V4, R54520	-	0.3	4.0	0.20	0.30	28	40	2.0	0.30	35		
Hardened Mat.	Steel	11	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	
				50 HRc	0.3	0.8	0.18	0.34	40	70	0.5	0.34	50	
				55 HRc	0.3	0.5	0.18	0.30	40	60	0.5	0.30	40	
				400 HB	0.3	1.0	0.18	0.38	40	60	0.5	0.38	50	
	Chilled Cast Iron White Cast Iron	41	G-X260Cr27	55 HRc	0.3	0.5	0.18	0.34	30	60	0.5	0.34	30	
NF	Al (>8%Si)	12	AlSi12	130 HB	0.3	4.0	0.30	0.80	200	400	2.0	0.40	350	

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

New Product Release