

Eco line

Round

RPMT

Milling Inserts

		MT-CVD			PVD		
-	-				-	+	+
					KM 2405	KM 2415	KM 1530

RE

Grade

Ap (mm)

Size	d	S	d ₁
08T2	8.0	2.78	3.50
10T3	10.0	3.97	4.50
1204	12.0	4.76	4.50

Medium

RPMT 08T2 MOF
10T3 MOF
1204 MOF

Eco line

Round

RDMW

Milling Inserts

		PVD				
-	-			-	+	+
				KM 2405	KM 2415	KM 1530

RE

Grade

Ap (mm)

Size	d	S	d ₁
10T3	10.0	3.97	4.50
1204	12.0	4.76	4.50
1605	16.0	5.56	5.50

Medium

RDMW 10T3 MOF
1204 MOF
1605 MOF

■ Feed rate per tooth fz (mm / tooth)

Grade	Condition	P	M	K	N	S	H
All	Stable ●	0.10 - 0.30	0.10 - 0.30	0.10 - 0.30		0.10 - 0.30	0.10 - 0.30
	Unstable ☹	0.10 - 0.25	0.10 - 0.25	0.10 - 0.25		0.10 - 0.25	0.10 - 0.25
	Very unstable ☹☹	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15		0.10 - 0.15	0.10 - 0.12

■ Cutting speed Vc (m / min)

Grade	Working conditions	P			M			K			N			S			H		
		P1	P2	P3	M1	M2	M3	K1	K2	K3	N1	N2	N3	S1	S2	S3	H1	H2	H3
KM 2405	Stable ●	215	175	120	165	135	110	215	180	160				60	55	40	100	90	80
	Unstable ☹	185	155	105	155	115	100	190	165	140				55	50	36	85	75	65
	Very unstable ☹☹	165	140	95	145	105	90	165	145	125				50	47	28	75	65	55
KM 2415	Stable ●	260	200	135	150	120	95	240	200	175									
	Unstable ☹	225	170	120	140	105	80	215	185	155									
	Very unstable ☹☹	195	145	95	130	95	70	185	160	135									
KM 1530	Stable ●	195	160	110	150	120	100	190	165	125				55	50	36	100	90	80
	Unstable ☹	165	145	100	140	105	90	165	145	110				50	45	32	85	75	65
	Very unstable ☹☹	150	130	90	130	95	80	150	135	100				45	40	28	75	65	55