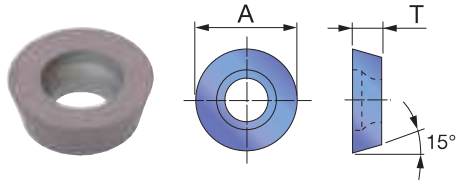


# INSERT

RDMW05/07/10



P	Steel	★
M	Stainless	
K	Cast iron	★
N	Non-ferrous	
S	Superalloys	★
H	Hard materials	

★ : First choice  
☆ : Second choice

Designation	Max. ap	Coating						A	T
		AH120							
RDMW0501M0	2.5	●						5	1.4
RDMW0702M0	3.5	●						7	2.38
RDMW1003M0	5.0	●						10	3.18

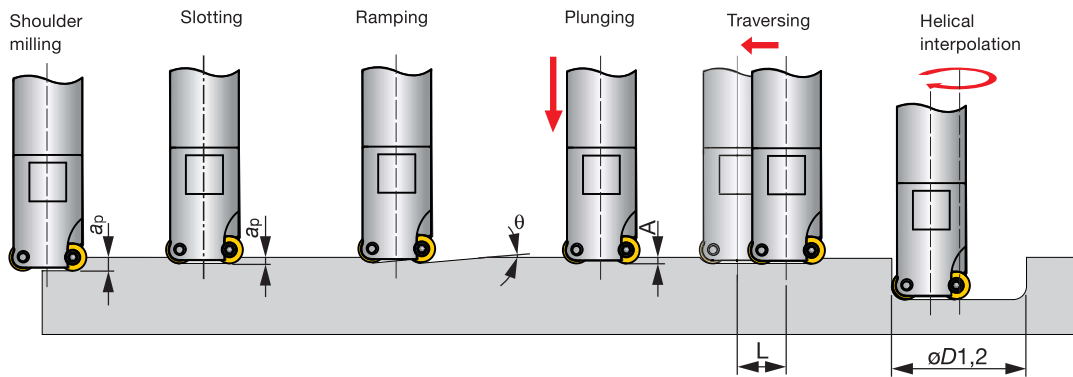
● : Line-up

# STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)		
					Cutter dia. ø10, 12	Cutter dia. ø15, 20	Cutter dia. ø25
P	Carbon steels C45, etc. < 300 HB	AH120	200 ~ 500	0.15 ~ 0.45	~ 0.5	~ 0.7	~ 1
	Alloy steels 42CrMo4 etc. < 300 HB	AH120	120 ~ 350	0.15 ~ 0.35	~ 0.5	~ 0.7	~ 1
	Die steels X40CrMoV5-1 etc. < 300 HB	AH120	100 ~ 300	0.1 ~ 0.3	~ 0.5	~ 0.7	~ 1
K	Cast irons 250, etc.	AH120	200 ~ 500	0.2 ~ 0.5	~ 0.5	~ 0.7	~ 1
H	Hardened steels, Prehardened steels < 40HRC	AH120	70 ~ 200	0.1 ~ 0.25	~ 0.5	~ 0.7	~ 1

Profile Milling

# APPLICATION RANGE



Designation	Tool-ø	Max. depth of cut	Max. ramping	Max. plunging depth	Machining length for removing uncut portion	Max. machining	*Max. machining
	øDc	ap	θ°	A	L	øD1	øD2
HWD07R015MM08-03	15	3.5	25	2	øDc - 6	23	28
HWD07R020MM10-04	20	3.5	11	2	øDc - 6	33	38
HWD07R025MM12-05	25	3.5	7	2	øDc - 6	43	48
HWD07R030MM16-05	30	3.5	5.5	2	øDc - 6	53	58

\*For flat bottom hole