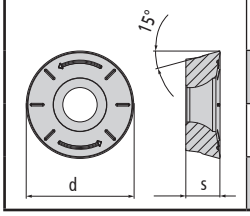
NEW ROUND INSERTS WITH AN OPTIMIZED GEOMETRY FOR SAH MACHINING. NOW ALSO AVAILABLE IN Ø 7 MM AND Ø 16 MM

- Round inserts for SAH machining, now available in 7, 10, 12, 16 mm
- A new design of the cutting edge, an optimized chip-breaker groove for maximum stability and reduced cutting forces
- In tools with a 0° axial angle of rake for chipping martensitic materials, e.g. 1.2316
- In tools with a 7° axial angle of rake for chipping austenitic steels, e.g. 1.4571, as well as high temperature alloys and titanium alloys
- **Machining of stainless materials, preferably dry with high cutting speeds, wet machining max. 140 m/min.**
- When machining titanium alloys or high temperature alloys, emulsion is necessary as a coolant.

Round inserts	Catalogue No.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	02 07 896	RDMT 0702 M0EN	M 40	PVST	7	2.38	3.5	M 3.5
	02 10 896	RDMT 1003 M0EN	M 40	PVST	10	3.18	5	M 3.5
	03 12 896K	RDMT 12T3 M0EN	M 40	PVST	12	3.97	6	M 3.5
	04 16 896	RDMT 1604 M0EN	M 40	PVST	16	4.76	8	M 4.5

Cutting speed (V_c in m/min) | Feed per tooth (f_z in mm/tooth) | d.o.c. (a_p in mm)

Radius (r mm)	Dia-meter (d mm)	Material		Application*	V_c (m/min)		f_z (mm/Zahn)		a_p (mm)	
		Major group	Minor group		min	max	min	max	min	max
3.5	7	Steel	Free machining steel / Mild steel	*roughing*	*100*	*200*	*0.35*	*0.5*	*0.3*	*0.75*
				pre-finishing	*100*	*200*	*0.2*	*0.35*	*0.2*	*0.4*
				finishing	*150*	*250*	*0.1*	*0.25*	*0.1*	*0.25*
			Normal tool steel / Steel castings	*roughing*	*100*	*180*	*0.35*	*0.5*	*0.3*	*0.75*
				pre-finishing	*100*	*200*	*0.2*	*0.35*	*0.2*	*0.4*
				finishing	*130*	*220*	*0.1*	*0.25*	*0.1*	*0.25*
			Tool steel and steel castings. both difficult to machine	*roughing*	*80*	*160*	*0.35*	*0.5*	*0.2*	*0.75*
				pre-finishing	*100*	*180*	*0.2*	*0.35*	*0.15*	*0.3*
				finishing	*110*	*200*	*0.1*	*0.25*	*0.1*	*0.2*
		Stainlees Steel	all kinds	roughing	80	180	0.3	0.5	0.2	0.75
				pre-finishing	100	210	0.15	0.35	0.15	0.4
				finishing	120	250	0.05	0.2	0.05	0.2
		High-tempera-ture Alloys	High-temperature Alloys	roughing	30	80	0.1	0.3	0.2	0.75
				pre-finishing	40	70	0.1	0.22	0.15	0.4
				finishing	60	120	0.05	0.15	0.05	0.15
			Titanium Alloys	roughing	40	90	0.15	0.4	0.2	0.75
				pre-finishing	50	90	0.1	0.25	0.15	0.4
				finishing	60	120	0.05	0.15	0.05	0.15

*** major application** *minor application*

TECHNICAL INFORMATION

Cutting speed (V_c in m/min) | Feed per tooth (f_z in mm/tooth) | d.o.c. (a_p in mm)

Radius (r mm)	Dia-meter (d mm)	Material		Application*	V_c (m/min)		f_z (mm/tooth)		a_p (mm)	
		Major group	Minor group		min	max	min	max	min	max
5	10	Steel	Free machining steel / Mild steel	*roughing*	*100*	*200*	*0.3*	*0.75*	*0.4*	*1*
				pre-finishing	*100*	*200*	*0.2*	*0.4*	*0.3*	*0.5*
				finishing	*150*	*250*	*0.1*	*0.25*	*0.1*	*0.4*
			Normal tool steel / Steel castings	*roughing*	*100*	*180*	*0.35*	*0.75*	*0.4*	*1*
				pre-finishing	*100*	*200*	*0.2*	*0.4*	*0.3*	*0.5*
				finishing	*130*	*220*	*0.1*	*0.25*	*0.1*	*0.4*
			Tool steel and steel castings, both difficult to machine	*roughing*	*80*	*160*	*0.3*	*0.6*	*0.4*	*1*
				pre-finishing	*100*	*180*	*0.2*	*0.35*	*0.25*	*0.5*
				finishing	*110*	*200*	*0.1*	*0.25*	*0.1*	*0.35*
		Stainlees Steel	all kinds	**roughing**	**80**	**180**	**0.3**	**0.6**	**0.4**	**2**
				pre-finishing	**100**	**210**	**0.15**	**0.4**	**0.2**	**1**
				finishing	**120**	**250**	**0.05**	**0.25**	**0.2**	**0.5**
		High-temperature Alloys	High-temperature Alloys	**roughing**	**30**	**80**	**0.15**	**0.4**	**0.5**	**2**
				pre-finishing	**40**	**70**	**0.1**	**0.3**	**0.3**	**0.9**
				finishing	**60**	**120**	**0.05**	**0.2**	**0.1**	**0.2**
			Titanium Alloys	**roughing**	**40**	**90**	**0.15**	**0.4**	**0.5**	**2**
				pre-finishing	**50**	**90**	**0.1**	**0.3**	**0.3**	**1.2**
				finishing	**60**	**120**	**0.05**	**0.2**	**0.1**	**0.5**
6	12	Steel	Free machining steel / Mild steel	*roughing*	*100*	*200*	*0.4*	*0.8*	*0.75*	*2*
				pre-finishing	*100*	*200*	*0.2*	*0.45*	*0.5*	*1.2*
				finishing	*150*	*250*	*0.1*	*0.25*	*0.1*	*0.6*
			Normal tool steel / Steel castings	*roughing*	*100*	*180*	*0.4*	*0.8*	*0.75*	*2*
				pre-finishing	*100*	*200*	*0.2*	*0.45*	*0.5*	*1.2*
				finishing	*130*	*220*	*0.1*	*0.25*	*0.1*	*0.6*
			Tool steel and steel castings, both difficult to machine	*roughing*	*80*	*160*	*0.35*	*0.65*	*0.6*	*2*
				pre-finishing	*100*	*180*	*0.2*	*0.4*	*0.4*	*1*
				finishing	*110*	*200*	*0.1*	*0.25*	*0.1*	*0.5*
		Stainlees Steel	all kinds	**roughing**	**80**	**180**	**0.2**	**0.7**	**0.6**	**2.5**
				pre-finishing	**100**	**210**	**0.15**	**0.4**	**0.3**	**1.5**
				finishing	**120**	**250**	**0.08**	**0.3**	**0.1**	**0.5**
		High-temperature Alloys	High-temperature Alloys	**roughing**	**30**	**80**	**0.15**	**0.4**	**0.5**	**2.2**
				pre-finishing	**40**	**70**	**0.1**	**0.3**	**0.3**	**1.3**
				finishing	**60**	**120**	**0.08**	**0.2**	**0.1**	**0.35**
			Titanium Alloys	**roughing**	**40**	**90**	**0.2**	**0.5**	**0.5**	**2.2**
				pre-finishing	**50**	**90**	**0.15**	**0.4**	**0.3**	**1.3**
				finishing	**60**	**120**	**0.08**	**0.25**	**0.1**	**0.6**
8	16	Steel	Free machining steel / Mild steel	*roughing*	*100*	*200*	*0.3*	*1.2*	*0.8*	*3.0*
				pre-finishing	*100*	*200*	*0.2*	*0.8*	*0.8*	*2.5*
				finishing	*150*	*250*	*0.08*	*0.3*	*0.1*	*1.0*
			Normal tool steel / Steel castings	*roughing*	*100*	*180*	*0.3*	*1.0*	*0.8*	*3.0*
				pre-finishing	*100*	*200*	*0.2*	*0.6*	*0.5*	*2.5*
				finishing	*130*	*220*	*0.08*	*0.3*	*0.1*	*1.0*
			Tool steel and steel castings, both difficult to machine	*roughing*	*80*	*160*	*0.3*	*0.8*	*0.7*	*3.0*
				pre-finishing	*100*	*180*	*0.2*	*0.5*	*0.4*	*2.5*
				finishing	*110*	*200*	*0.08*	*0.3*	*0.1*	*1.0*
		Stainlees Steel	all kinds	**roughing**	**80**	**180**	**0.2**	**0.7**	**0.8**	**3.0**
				pre-finishing	**100**	**210**	**0.15**	**0.4**	**0.5**	**2.2**
				finishing	**120**	**250**	**0.08**	**0.3**	**0.1**	**1.0**
		High-temperature Alloys	High-temperature Alloys	**roughing**	**30**	**80**	**0.15**	**0.4**	**0.7**	**2.0**
				pre-finishing	**40**	**70**	**0.1**	**0.3**	**0.4**	**1.5**
				finishing	**60**	**120**	**0.08**	**0.2**	**0.1**	**0.5**
			Titanium Alloys	**roughing**	**40**	**90**	**0.2**	**0.5**	**0.7**	**2.0**
				pre-finishing	**50**	**90**	**0.15**	**0.4**	**0.4**	**1.5**
				finishing	**60**	**120**	**0.08**	**0.25**	**0.1**	**0.7**

*** major application** *minor application*

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