

RICH MILL RM16

RECOMMENDED CUTTING CONDITIONS

CUTTING DATA

If you require cutting data for wiper inserts please contact our tech team

ISO	Grade	ONM(H)X06 -MM		ONM(H)X06 -MF/ML		ONM(H)X06 -MA		ONM(H)X08 -MM		ONM(H)X08 -MF/ML		ONM(H)X08 -MA	
		vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)
P	PC3500	150~300	0.10~0.35	200~300	0.05~0.30	-	-	150~300	0.10~0.40	200~300	0.05~0.35	-	-
	PC5300/PC5400	130~240	0.10~0.35	180~240	0.05~0.30	-	-	130~240	0.10~0.40	180~240	0.05~0.35	-	-
M	PC9530	120~180	0.10~0.35	100~180	0.05~0.30	-	-	120~180	0.10~0.40	100~180	0.05~0.35	-	-
	PC5300/PC5400	80~160	0.10~0.35	80~140	0.05~0.30	-	-	80~160	0.10~0.40	80~140	0.05~0.35	-	-
K	PC6510	150~300	0.10~0.40	150~300	0.08~0.35	-	-	150~300	0.10~0.45	150~300	0.08~0.40	-	-
N	H01	-	-	-	-	320~750	0.1~0.4	-	-	-	-	320~750	0.1~0.4

MAXIMUM CUTTING DEPTH

06 inserts max. ap when using: **1 edge = 4mm** or **2 edges =10mm**. **08 inserts** max. ap when using: **1 edge = 5.5mm** or **2 edges =13mm**

CHIPBREAKER GUIDE

CHIPBREAKER	CUTTING EDGE	APPLICATIONS	BENEFITS
MA			For Aluminium
ML			Hard to Cut Material
MF			Light Cutting
MM			General Cutting
W			Wiper

RECOMMENDED CHIPBREAKERS & GRADES

*First choice grade / chip breaker

P		M		K		N			
Low Carbon & Mild Steel		High Carbon & Alloy Steel		Stainless Steel		Cast Iron		Aluminium Alloy	
Chip Breaker	Grades	Chip Breaker	Grades	Chip Breaker	Grades	Chip Breaker	Grades	Chip Breaker	Grades
MM	PC3500*	MM*	PC3500*	MM	PC5300	MM*	PC6510*	-	-
	PC5300		PC5400		PC5300				
	PC5400		PC9530		PC5400				
MF*	PC3500*	MF	PC3500	MF	PC5300	MF	PC6510	-	-
	PC5300				PC5400		PC5300		
	PC5400				PC9530		PC5400		
-	-	-	-	ML*	PC5300*	-	-	-	-
					PC5400				
-	-	-	-	-	-	-	-	MA*	H01*

WIPER INSERT SETTING

Right Hand					
	✓	✗	✗	✗	✗
Left Hand					
	✓	✗	✗	✗	✗

THROUGH COOLANT DESIGN

Reduces cutting heat for improved chip control and tool life

