

RICH MILL RM3

RECOMMENDED CUTTING CONDITIONS

CUTTING DATA

RM3 END MILL

WORKPIECE	Grade	XNKT060405 PNSR - MM			XNKT060405 PNER-ML		
		vc (m/min)	fz (mm/t)	max ap (mm)	vc (m/min)	fz (mm/t)	max ap (mm)
P STEEL	PC3600	160-270	0.05-0.25	5.5	160-270	0.05-0.2	5.5
	PC5300	150-240	0.05-0.25	5.5	150-240	0.05-0.25	5.5
	PC5400	130-210	0.05-0.25	5.5	130-210	0.05-0.25	5.5
M STAINLESS STEEL	PC5300	90-150	0.05-0.2	5.5	90-150	0.05-0.1	5.5
	PC5400	70-120	0.05-0.2	5.5	70-120	0.05-0.1	5.5
S HRSA	PC5300	40-70	0.05-0.15	5.5	40-70	0.05-0.15	5.5
	PC5400	30-50	0.05-0.15	5.5	30-50	0.05-0.15	5.5
K CAST IRON	PC6510	140-230	0.08-0.3	5.5	140-230	0.08-0.25	5.5
	PC5300	120-200	0.08-0.3	5.5	120-200	0.08-0.25	5.5

Maximum cutting condition: vc = 350m/min, fz = 0.5 mm/t according to cutting environment

RM3 FACE MILL

WORKPIECE	Grade	XNKT080508 PNSR - MM			XNKT080508 PNER-ML		
		vc (m/min)	fz (mm/t)	max ap (mm)	vc (m/min)	fz (mm/t)	max ap (mm)
P STEEL	PC3600	160-270	0.05-0.3	8	160-270	0.05-0.25	8
	PC5300	150-240	0.05-0.3	8	150-240	0.05-0.25	8
	PC5400	130-210	0.05-0.3	8	130-210	0.05-0.25	8
M STAINLESS STEEL	PC5300	90-150	0.05-0.25	8	90-150	0.05-0.2	8
	PC5400	70-120	0.05-0.25	8	70-120	0.05-0.2	8
S HRSA	PC5300	40-70	0.05-0.2	8	40-70	0.05-0.2	8
	PC5400	30-50	0.05-0.2	8	30-50	0.05-0.2	8
K CAST IRON	PC6510	140-230	0.08-0.35	8	140-230	0.08-0.3	8
	PC5300	120-200	0.08-0.35	8	120-200	0.08-0.3	8
N ALUMINIUM	H01	XNCT080508PNFR-MA			400-1200	0.1-0.4	8

Maximum cutting condition: vc = 350m/min, fz = 0.7 mm/t according to cutting environment

INDEXABLE MILLING

EDGE PREPARATION

HOLE MAKING

TAPS & DIES

THREAD & GROOVE MILLING

TOOL HOLDING

ANTI-VIBRATION FACE MILL ARBORS

REDUCED VIBRATION IN LONG REACH INDEXABLE MILLING

- ▶ Taper or straight neck profile
- ▶ Damped design reduces vibration in long reach applications
- ▶ Increased cut depths and feed rates
- ▶ Improved surface finish
- ▶ Increased tool life

**Vibration reduced up to 60% compared to
any other conventional shell mill adaptor**

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