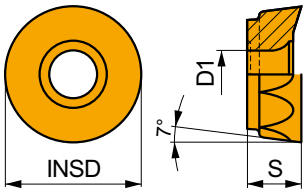
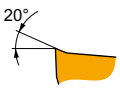
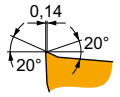
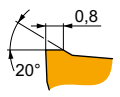
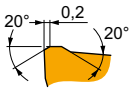
RCMT 12

	INSD	D1	S
	[mm]	[mm]	[mm]
1204	12.0	4.40	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]
			HFC E																	
			F geometry with highly positive design for light machining.																	
RCMT 1204MOEN-F	**8215**	–	■ 390	0.10	1.5	◪ 230	0.09	1.5	–	–	–	–	–	–	◪ 95	0.07	1.2	–	–	–
	M8310	–	■ 420	0.10	1.5	◪ 210	0.09	1.5	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	–	■ 380	0.10	1.5	■ 225	0.09	1.5	–	–	–	–	–	–	◪ 95	0.07	1.2	–	–	–
			U HFC S																	
			M geometry with highly positive design for medium machining.																	
RCMT 1204MOSN-M	**M6330**	–	■ 265	0.20	1.5	◪ 185	0.18	1.5	–	–	–	–	–	–	■ 75	0.16	1.2	–	–	–
	M8310	–	■ 335	0.20	1.5	◪ 170	0.18	1.5	■ 315	0.20	1.5	–	–	–	–	–	–	–	–	–
	M8330	–	■ 305	0.20	1.5	◪ 180	0.18	1.5	■ 285	0.20	1.5	–	–	–	◪ 75	0.16	1.2	–	–	–
	M8345	–	■ 225	0.20	1.5	◪ 135	0.18	1.5	–	–	–	–	–	–	■ 55	0.16	1.2	–	–	–
	M9325	–	■ 380	0.20	1.5	–	–	–	■ 360	0.20	1.5	–	–	–	–	–	–	–	–	–
	M9340	–	■ 345	0.20	1.5	◪ 205	0.18	1.5	–	–	–	–	–	–	■ 85	0.16	1.2	–	–	–
			HFC S																	
			EN-R geometry with positive design for rough copy machining.																	
RCMT 1204MOEN-R	**M8310**	–	■ 280	0.30	1.5	◪ 140	0.27	1.5	■ 265	0.30	1.5	–	–	–	–	–	–	■ 55	0.15	1.0
	M8330	–	■ 260	0.30	1.5	◪ 155	0.27	1.5	■ 245	0.30	1.5	–	–	–	◪ 65	0.24	1.2	◪ 50	0.15	1.0
			HFC P																	
			SN-R geometry with positive design for rough copy machining.																	
RCMT 1204MOSN-R	**M8345**	–	■ 190	0.35	1.5	–	–	–	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
	M9315	–	■ 315	0.35	1.5	–	–	–	■ 295	0.35	1.5	–	–	–	–	–	–	◪ 60	0.15	1.0