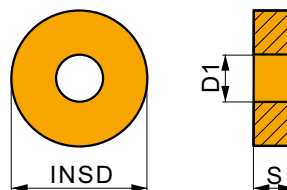




RNMG

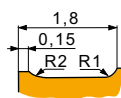


	INSD	D1	S
	[mm]	[mm]	[mm]
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



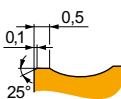
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



Geometry 08 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RNMG 120400E-08	T5305	—	195	0.70	3.0	—	—	—	185	0.70	3.0	—	—	—	—	—	—	35	0.15	1.0
	T9315	—	150	0.70	3.0	—	—	—	140	0.70	3.0	—	—	—	—	—	—	30	0.15	1.0
	T9325	—	135	0.70	3.0	—	—	—	125	0.70	3.0	—	—	—	—	—	—	—	—	—
RNMG 150600E-08	T5305	—	295	0.70	3.0	—	—	—	280	0.70	3.0	—	—	—	—	—	—	55	0.15	1.0
	T9315	—	225	0.70	3.0	—	—	—	210	0.70	3.0	—	—	—	—	—	—	45	0.15	1.0
	T9325	—	205	0.70	3.0	—	—	—	190	0.70	3.0	—	—	—	—	—	—	—	—	—
RNMG 190600E-08	T9315	—	150	0.70	3.0	—	—	—	140	0.70	3.0	—	—	—	—	—	—	30	0.15	1.0
	T9325	—	135	0.70	3.0	—	—	—	125	0.70	3.0	—	—	—	—	—	—	—	—	—



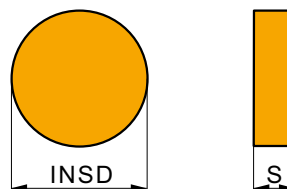
Geometry 081 for rough to heavy-rough machining, and continuous to interrupted cuts.

RNMG 250900E-081	T9315	—	145	0.90	5.0	—	—	—	135	0.90	5.0	—	—	—	—	—	—	25	0.15	1.0
	T9325	—	130	0.90	5.0	—	—	—	120	0.90	5.0	—	—	—	—	—	—	—	—	—

RNGN CER

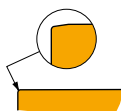
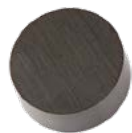


	INSD	S
	[mm]	[mm]
0903	9.525	3.18
1204	12.700	4.76
1207	12.700	7.94



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/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For machining with high speeds and continuous cuts.

RNGN 090300 T01020	TC100	—	—	—	—	—	—	460	0.20	1.2	—	—	—	—	—	—	—	—	—
RNGN 120400 T01020	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—
RNGN 120700 T01020	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—
RNGN 120700 T15015	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—