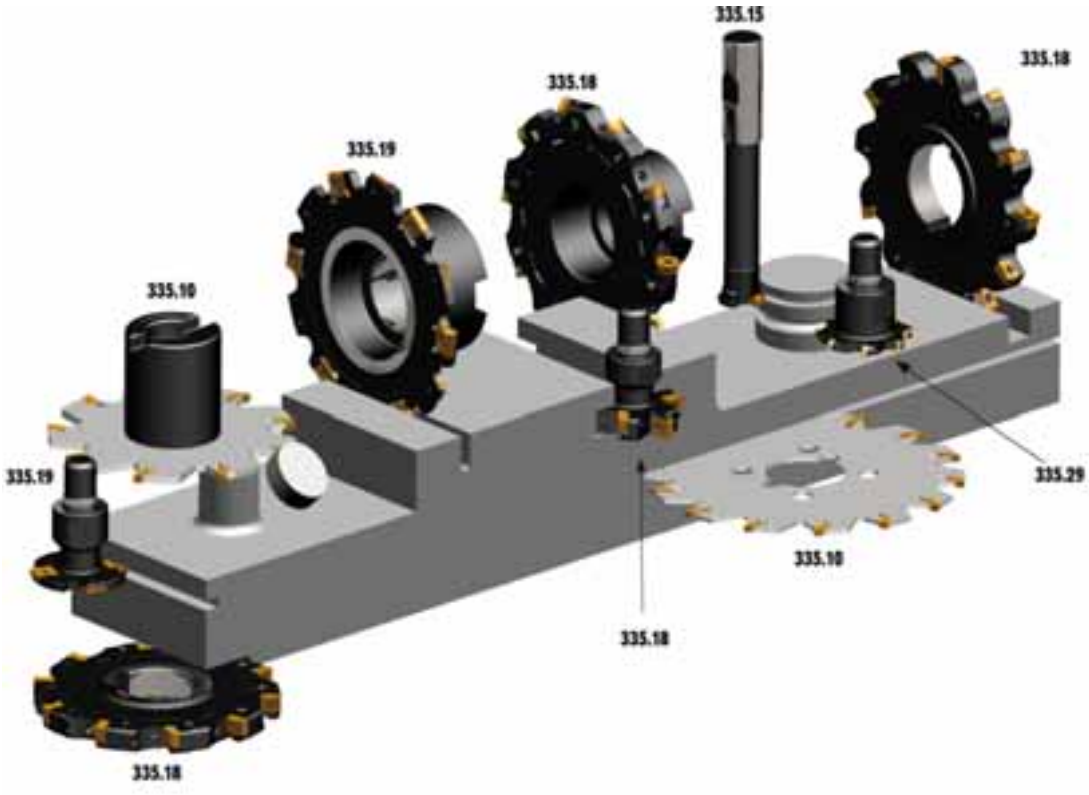
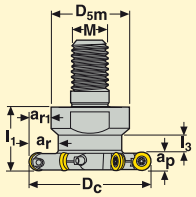
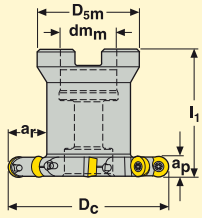
DISC MILLING UPDATES



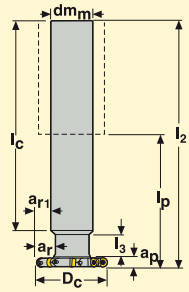
Combimaster (Type RE)



Type B for stub arbor (Type B FP)



Cylindrical

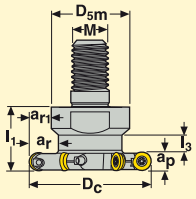


For insert selection and cutting data recommendations, see pages 7-9 .
For complete insert programme, see page 17 .
For spare parts, see page 6 .

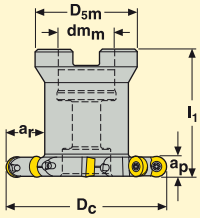
Type	a_p	a_r	a_{r1}	Part No.	Dimension in mm D_c	dm_m M	l_1	l_2	l_3	l_c D_{5m}	l_p		z_c	KG		Insert
Cyl	5	6,9	6,5	R335.29 -1225.0-05.4N-R25A	25	12	–	110	10	94	65	4	4	0,1	44800	RD..0501
Cyl	5	8,4	8	-1632.0-05.5N-R25A	32	16	–	130	10	114	82	5	5	0,2	39600	RD..0501
Cyl	5	10,4	10	-2040.0-05.6N-R25A	40	20	–	140	10	124	90	6	6	0,4	35400	RD..0501
Cyl	5	12,9	12,5	-2550.0-05.8N-R25A	50	25	–	150	10	134	94	8	8	0,6	31700	RD..0501
Cyl	6	6,9	6,5	R335.29 -1225.0-06.4N-R3A	25	12	–	110	10	93	65	4	4	0,1	20600	RD..06T1
Cyl	6	8,4	8	-1632.0-06.5N-R3A	32	16	–	130	10	114	82	5	5	0,2	18700	RD..06T1
RE	6	10	8,5	-1240.RE-06.6N-R3A	40	M12	28	–	10	23	–	6	6	0,1	17600	RD..06T1
Cyl	6	10,4	10	-2040.0-06.6N-R3A	40	20	–	140	10	123	90	6	6	0,4	16300	RD..06T1
RE	6	12,5	10	-1650.RE-06.8N-R3A	50	M16	28	–	9	30	–	8	8	0,2	17300	RD..06T1
Cyl	6	12,9	12,5	-2550.0-06.8N-R3A	50	25	–	150	10	133	94	8	8	0,6	17300	RD..06T1
B	6	15	–	-063.06.22-10N-R3A	63	22	50	–	30,7	40	–	10	10	0,3	13900	RD..06T1
Cyl	7	8,4	8	R335.29 -1632.0-07.5N-R35A	32	16	–	130	10	112	82	5	5	0,2	31600	RD..0702
RE	7	10	8,5	-1240.RE-07.6N-R35A	40	M12	28	–	9	23	–	6	6	0,1	28200	RD..0702
RE	7	12,5	10	-1650.RE-07.7N-R35A	50	M16	28	–	8	30	–	7	7	0,2	25300	RD..0702
B	7	15	–	-063.07.22-10N-R35A	63	22	50	–	29,7	40	–	10	10	0,3	22500	RD..0702

Please check availability in current price and stock-list

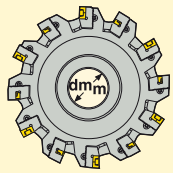
Combimaster (Type RE)

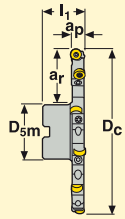


Type B for stub arbor (Type B FP)

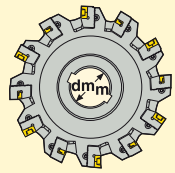


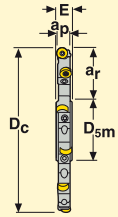
Type B for stub arbor (Type B adj.)





Type A for milling arbor (Type A adj.)



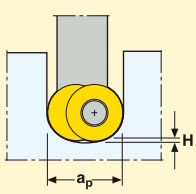


For insert selection and cutting data recommendations, see page 10.
For complete insert programme, see page 17.
For spare parts, see page 6.

For cylindrical type, see previous page

Type	a_p	a_r	a_{r1}	Part No.	Dimension in mm D_c	dm_m M	l_1 E	l_2	l_3	l_c D_{5m}	l_p		z_c	KG		Insert
Cyl	8	8,4	8	**R335.29 -1632.0-08.4N-R4A**	32	16	–	130	10	111	82	4	4	0,2	23300	RD..08..
RE	8	10	8,5	**-1240.RE-08.5N-R4A**	40	M12	28	–	8	23	–	5	5	0,1	18800	RD..08..
Cyl	8	10,4	10	**-2040.0-08.5N-R4A**	40	20	–	140	10	121	90	5	5	0,4	18800	RD..08..
RE	8	30	10	**-1650.RE-08.6N-R4A**	50	M16	28	–	7	30	–	6	6	0,2	17300	RD..08..
Cyl	8	12,9	12,5	**-2550.0-08.6N-R4A**	50	25	–	150	10	131	94	6	6	0,6	17300	RD..08..
B	8	15	–	**-063.08.22-8N-R4A**	63	22	50	–	28,7	40	–	8	8	0,4	15600	RD..08..
B	8	20		**-080.08.27-10N-R4A**	80	27	50	–	26,8	48	–	10	10	0,5	13700	RD..08..
A adj	8-10	27,5	–	**335.18 -100.0810.27-8N-R4**	102	27	15	–	–	41	–	8	8	0,2	9400	RD..08..
B adj	8-10	26,0	–	**R335.18 -100.0810.27-8N-R4**	102	27	48	–	–	41	–	8	8	0,5	9400	RD..08..
A adj	8-10	33,0	–	**335.18 -125.0810.40-10N-R4**	127	40	15	–	–	55	–	10	10	0,8	8400	RD..08..
B adj	8-10	33,5	–	**R335.18 -125.0810.32-10N-R4**	127	32	58	–	–	55	–	10	10	1,0	8400	RD..08..
A adj	8-10	50,5	–	**335.18 -160.0810.40-12N-R4**	162	40	15	–	–	55	–	12	12	1,0	7500	RD..08..
B adj	8-10	45,0	–	**R335.18 -160.0810.40-12N-R4**	162	40	70	–	–	55	–	12	12	1,2	7500	RD..08..
A adj	8-10	63,5	–	**335.18 -200.0810.50-16N-R4**	202	50	70	–	–	69	–	16	16	1,7	6700	RD..08..
B adj	8-10	55,0	–	**R335.18 -200.0810.40-16N-R4**	202	40	90	–	–	69	–	16	16	2,0	6700	RD..08..
A adj	8-10	88,5	–	**335.18 -250.0810.50-18N-R4**	252	50	15	–	–	69	–	18	18	3,0	6000	RD..08..

Profile machined round inserts



a_p min

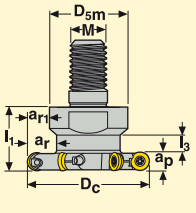
a_p max

Round 8	
a_p mm	Profile height H mm
8,03	0
8,50	0
9,00	0,03
9,50	0,07
10,00	0,13
Recom. min setting width is 8,03 mm	

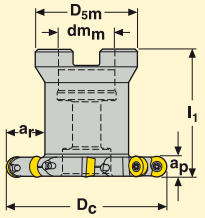
Please check availability in current price and stock-list

Cutters 335.29 and 335.18 with round inserts 10

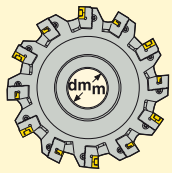
Combimaster (Type RE)

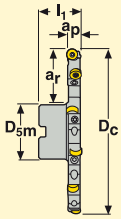


Type B for stub arbor (Type B FP)

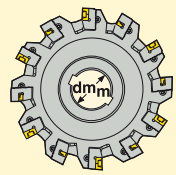


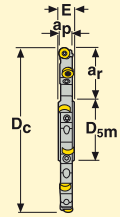
Type B for stub arbor (Type B adj.)





Type A for milling arbor (Type A adj.)

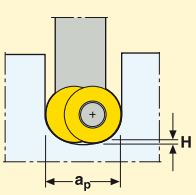




For insert selection and cutting data recommendations, see pages 11-12 .
For complete insert programme, see the Milling catalogue 17.
For spare parts, see page 6.

Type	a_p	a_r	a_{r1}	Part No.	Dimension in mm D_c	dm_m M / l_1 E	l_3	D_{5m}		z_c	KG		Insert
RE	10	12,5	10	**R335.29 -1650.RE-10.6N-R5A**	50	M16 / 28	4,4	30	6	6	0,2	15800	RD..10T3
B	10	15	–	**-063.10.22-6N-R5A**	63	22 / 50	26,7	40	6	6	0,4	13500	RD..10T3
B	10	20	–	**-080.10.27-8N-R5A**	80	27 / 50	24,8	48	8	8	0,5	12000	RD..10T3
B adj	10-12	17,0	–	**R335.18 -080.1012.27-3N-R5**	82	27 / 50	–	48	6	3	0,6	10500	RD..10T3
B adj	10-12	27,0	–	**-100.1012.27-4N-R5**	102	27 / 50	–	48	8	4	0,8	9400	RD..10T3
A adj	10-12	28,5	–	**335.18 -100.1012.27-4N-R5**	102	27 / 15	–	41	8	4	0,4	9400	RD..10T3
B adj	10-12	34,5	–	**R335.18 -125.1012.32-5N-R5**	127	32 / 50	–	58	10	5	1,1	8400	RD..10T3
A adj	10-12	34,0	–	**335.18 -125.1012.40-5N-R5**	127	40 / 15	–	55	10	5	0,6	8400	RD..10T3
B adj	10-12	46,0	–	**R335.18 -160.1012.40-6N-R5**	162	40 / 50	–	70	12	6	1,7	7500	RD..10T3
A adj	10-12	51,5	–	**335.18 -160.1012.40-6N-R5**	162	40 / 15	–	55	12	6	1,1	7500	RD..10T3
B adj	10-12	56,0	–	**R335.18 -200.1012.40-8N-R5**	202	40 / 50	–	90	16	8	3,1	6700	RD..10T3
A adj	10-12	64,5	–	**335.18 -200.1012.50-8N-R5**	202	50 / 15	–	69	16	8	1,8	6700	RD..10T3
A adj	10-12	89,5	–	**-250.1012.50-9N-R5**	252	50 / 15	–	69	18	9	2,9	6000	RD..10T3

Profile machined with round inserts



a_p min

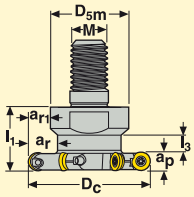
a_p max

Round 10	
a_p mm	Profile height H mm
10,03	0
10,50	0
11,00	0,025
11,50	0,060
12,00	0,100
Recom. min setting width is 10,03 mm	

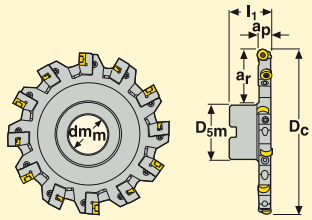
Please check availability in current price and stock-list

Cutter 335.29 and 335.18 with round inserts 12/16

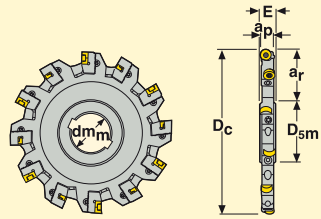
Combimaster



Type B for stub arbor (Type B adj.)



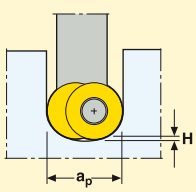
Type A for milling arbor (Type A adj.)



For insert selection and cutting data recommendations, see pages 13-16 .
For complete insert programme, see pages 18-19 .
For spare parts, see page 6.

Type	a_p	a_r	a_{r1}	Part No.	Dimension in mm D_c	dm_m M	E	l_1	l_3	D_{5m}		z_c	KG		Insert
RE	12	12,5	10	**R335.29 -1650.RE-12.4N-R6A**	50	M16	–	28	4,4	30	4	4	0,2	11200	RP..1204
B	12	15	–	**-063.12.22-6N-R6A**	63	22	–	50	24,7	40	6	6	0,4	10200	RP..1204
B	12	20	–	**-080.12.27-8N-R6A**	80	27	–	50	22,8	48	8	8	0,5	10000	RP..1204
B adj.	12-15	17,0	–	**R335.18 -080.1215.27-3N-R6**	82	27	–	50	–	48	6	3	0,7	10000	RP..1204
B adj	12-15	27,0	–	**-100.1215.27-4N-R6**	102	27	–	50	–	48	8	4	0,9	9400	RP..1204
A adj	12-15	28,5	–	**335.18 -100.1215.27-4N-R6**	102	27	15	–	–	41	8	4	0,5	9400	RP..1204
B adj	12-15	34,5	–	**R335.18 -125.1215.32-5N-R6**	127	32	–	50	–	58	10	5	1,1	8400	RP..1204
A adj	12-15	34,0	–	**335.18 -125.1215.40-5N-R6**	127	40	15	–	–	55	10	5	0,8	8400	RP..1204
B adj	12-15	46,0	–	**R335.18 -160.1215.40-6N-R6**	162	40	–	50	–	70	12	6	1,9	7500	RP..1204
A adj	12-15	51,5	–	**335.18 -160.1215.40-6N-R6**	162	40	15	–	–	55	12	6	1,8	7500	RP..1204
B adj	12-15	56,0	–	**R335.18 -200.1215.40-8N-R6**	202	40	–	50	–	90	16	8	3,3	6700	RP..1204
A adj	12-15	64,5	–	**335.18 -200.1215.50-8N-R6**	202	50	15	–	–	69	16	8	2,2	6700	RP..1204
B adj	12-15	89,5	–	**-250.1215.50-9N-R6**	252	50	15	–	–	69	18	9	3,6	6000	RP..1204
B adj	16-18	25,0	–	**R335.18 -125.1418.40-4N-R8**	130	40	–	50	–	70	8	4	1,7	7800	RP..1605
A adj	16-18	34,0	–	**335.18- 125.1418.40-4N-R8**	130	40	18	–	–	56	8	4	1,0	7800	RP..1605
B adj	16-18	44,0	–	**R335.18 -160.1418.40-6N-R8**	165	40	–	50	–	70	12	6	2,7	6900	RP..1605
A adj	16-18	50,0	–	**335.18 -160.1418.40-6N-R8**	165	40	18	–	–	56	12	6	1,5	6900	RP..1605
B adj	16-18	52,0	–	**R335.18 -200.1418.40-7N-R8**	205	40	–	50	–	90	14	7	4,1	6100	RP..1605
A adj	16-18	60,0	–	**335.18 -200.1418.50-7N-R8**	205	50	18	–	–	71	14	7	2,0	6100	RP..1605
B adj	16-18	58,0	–	**R335.18 -250.1418.60-9N-R8**	255	60	–	50	–	130	18	9	7,5	5500	RP..1605
A adj	16-18	85,0	–	**335.18 -250.1418.50-9N-R8**	255	50	18	–	–	71	18	9	3,0	5500	RP..1605
B adj	16-18	90,0	–	**R335.18 -315.1418.60-12N-R8**	320	60	–	50	–	130	24	12	9,5	4900	RP..1605
A adj	16-18	110,0	–	**335.18- 315.1418.50-12N-R8**	320	50	18	–	–	71	24	12	4,0	4900	RP..1605

Profile machined with round inserts



a_p min

a_p max

Round 12	
a_p mm	Profile height H mm
12,03	0
12,50	0,01
13,00	0,02
14,00	0,08
15,00	0,19
Recom. min setting width is 12,03 mm	

Round 16	
a_p mm	Profile height H mm
16,03	0
16,50	0
17,00	0,02
18,00	0,06
18,50	0,10
Recom. min setting width is 16,03 mm	

Spare parts for (R) 335.18 – For fixed and adjustable cutters

For cutter R335.18	Insert type	Locking screw/Nm	Key	Wedge	Wedge screw	Key	Adjusting screw*	Cassettes	
								Right	Left
								R335.18-..	L335.18-..
0810	**LNK.05..**	C02508-T08P/ 1,2Nm	T08P-3	335.18-607	LD5018F-T15P	T15P-3	SH6004-T08P	0810-05	0810-05
–	**RD..05..**	C02035-T06P/ 0,5Nm	T06P-3	–	–	–	–	–	–
–	**RD..06..**	C02205-T07P/ 0,9Nm	T07P-3	–	–	–	–	–	–
–	**RD..07..**	C02245-T07P/ 0,9Nm	T07P-3	–	–	–	–	–	–
0810	**RD..08..**	C02506-T08P/ 1,2Nm	T08P-3	335.18-607	LD5018F-T15P	T15P-3	SH6004-T08P	N335.18-08-R4	
1012	**LNK.06..**	C73007-T09P/ 2,0Nm	T09P-3	335.18-609	LD6018F-T20P	T20P-4	SH6005-T09P	1012-06	1012-06
1012	**RD..10T3**	C03007-T09P/ 2,0Nm	T09P-3	335.18-609	LD6018F-T20P	T20P-4	SH6005-T09P	10-R5	10-R5
1215	**LNK.08..**	C73007-T09P/ 2,0Nm	T09P-3	335.18-611	LD6018F-T20P	T20P-4	SH6005-T09P	1215-08	1215-08
1215	**RP..12..**	C03508-T15P/ 3,0Nm	T15P-3	335.18-611	LD6018F-T20P	T20P-4	SH6005-T09P	12-R6	12-R6
1418	**RP..16..**	C05010-T20P/ 5,0Nm	T20P-4	335.18-613F	LD6018F-T20P	T20P-4	SH6005-T09P	16-R8-D5	16-R8-D5

*Adjusting screw key T08P-3 alt. T09P-3. Dynamomentic keys, see page 550 in Milling Catalogue 2009.
Arbor screw for type B – Cutter (R) 335.18 dia 63 mm, use arbor screw **MC6S 10x40** for dia 80 and 100 mm, use arbor screw **MC6S 12x40.**

Insert selection – 335.29-R25

Universal insert: RDHW0501M0-MD01 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,07–0,15	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
2	0,07–0,15	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
3	0,07–0,15	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
4	0,05–0,13	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F40M	
5	0,05–0,13	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
6	0,05–0,13	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
7	–	-	-	
8	0,03–0,12	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F40M	
9	0,03–0,12	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F40M	
10	0,02–0,09	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 MP3000	
11	0,02–0,09	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 MP3000	
12	0,09–0,16	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
13	0,09–0,16	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
14	0,09–0,16	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
15	0,09–0,16	RDHW 0501M0-MD01 MP3000	RDHW 0501M0-MD01 F15M	
16	0,07–0,19	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
17	0,07–0,19	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
20	0,05–0,13	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
21	0,02–0,09	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	
22	0,05–0,13	RDHW 0501M0-MD01 F40M	RDHW 0501M0-MD01 F40M	

Cutting data – 10% engagement width (a_e/D_c = 10%)

Seco Material Group No.	Grades												
	MP3000			F40M			F15M						
	Feed, f_z (mm/tooth)												
	0,03	0,09	0,16	0,03	0,09	0,16	0,03	0,09	0,16				
	Cutting speed, v_c (m/min)												
1	–	–	–	365	310	275	–	–	–				
2	–	–	–	315	270	240	–	–	–				
3	–	–	–	265	225	200	–	–	–				
4	300	260	–	240	205	185	290	250	–				
5	245	210	–	–	–	–	235	200	–				
6	180	155	–	–	–	–	170	145	–				
7	–	–	–	–	–	–	–	–	–				
8	270	230	–	235	200	–	280	240	–				
9	235	200	–	205	175	–	245	210	–				
10	200	170	–	175	150	–	210	180	–				
11	160	135	–	135	115	–	165	140	–				
12	265	225	200	210	180	160	255	215	190				
13	235	200	180	190	160	145	225	195	170				
14	215	185	165	175	150	130	210	180	160				
15	175	150	135	140	120	105	170	145	125				
16	–	–	–	980	840	740	–	–	–				
17	–	–	–	795	680	600	–	–	–				
20	–	–	–	60	50	–	–	–	–				
21	–	–	–	40	30	–	–	–	–				
22	–	–	–	60	50	–	–	–	–				

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,01	0,04	0,08	0,65
Side milling	2%	0,07	0,20	0,35	1,20
	5%	0,04	0,13	0,22	1,10
	10%	0,03	0,09	0,16	1,00
	20%	0,02	0,06	0,12	0,90
	30%	0,02	0,05	0,10	0,85
Average chip thickness h_m		0,009	0,03	0,05	–

Type of insert

Insert size	Width of slot mm
05	5

Insert selection – (R)335.29-R03

Universal insert: RDHT 06T1M0-E02 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,08–0,16	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	
2	0,08–0,16	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	
3	0,08–0,16	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	
4	0,06–0,14	RDHW 06T1M0-MD02 MP3000	RDHT 06T1M0-E02 F40M	
5	0,06–0,14	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
6	0,06–0,14	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
7	–	–	–	
8	0,04–0,13	RDHW 06T1M0-MD02 MP3000	RDHT 06T1M0-E02 F40M	
9	0,04–0,13	RDHW 06T1M0-MD02 MP3000	RDHT 06T1M0-E02 F40M	
10	0,03–0,10	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 MP3000	
11	0,03–0,10	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 MP3000	
12	0,10–0,17	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
13	0,10–0,17	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
14	0,10–0,17	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
15	0,10–0,17	RDHW 06T1M0-MD02 MP3000	RDHW 06T1M0-MD02 F15M	
16	0,08–0,20	RDHT 06T1M0-E02 H25	RDHT 06T1M0-E02 F40M	
17	0,08–0,20	RDHT 06T1M0-E02 H25	RDHT 06T1M0-E02 F40M	
20	0,06–0,14	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	
21	0,03–0,10	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	
22	0,06–0,14	RDHT 06T1M0-E02 F40M	RDHT 06T1M0-E02 F40M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades																
	MP3000			F40M			F25M			F15M			H25				
	Feed, f_z (mm/tooth)																
	0,04	0,10	0,17	0,04	0,10	0,17	0,04	0,10	0,17	0,04	0,10	0,17	0,04	0,10	0,17		
	Cutting speed, v_c (m/min)																
1	–	–	–	335	290	260	–	–	–	–	–	–	–	–	–		
2	–	–	–	295	255	225	–	–	–	–	–	–	–	–	–		
3	–	–	–	245	210	190	–	–	–	–	–	–	–	–	–		
4	280	245	–	225	195	175	245	215	–	270	235	–	–	–	–		
5	230	195	–	–	–	–	200	175	–	220	190	–	–	–	–		
6	165	145	–	–	–	–	145	125	–	160	140	–	–	–	–		
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–		
8	250	220	–	215	190	–	240	205	–	–	–	–	–	–	–		
9	220	190	–	190	165	–	210	180	–	–	–	–	–	–	–		
10	185	160	–	160	140	–	175	155	–	–	–	–	–	–	–		
11	145	125	–	125	110	–	140	120	–	–	–	–	–	–	–		
12	245	210	190	195	170	150	215	185	165	235	205	180	185	160	145		
13	220	190	170	175	150	135	195	165	150	210	180	160	165	145	130		
14	200	175	155	160	140	125	175	155	135	195	165	150	155	135	120		
15	165	140	125	130	115	100	145	125	110	155	135	120	–	–	–		
16	–	–	–	910	790	700	–	–	–	1095	945	840	865	750	665		
17	–	–	–	735	635	565	–	–	–	885	765	680	700	605	540		
20	–	–	–	55	50	–	–	–	–	–	–	–	–	–	–		
21	–	–	–	35	30	–	–	–	–	–	–	–	–	–	–		
22	–	–	–	55	50	–	–	–	–	–	–	–	–	–	–		

Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,02	0,05	0,08	0,65
Side milling	2%	0,09	0,22	0,37	1,20
	5%	0,06	0,14	0,24	1,10
	10%	0,04	0,10	0,17	1,00
	20%	0,03	0,07	0,12	0,90
	30%	0,02	0,06	0,10	0,85
Average chip thickness h_m		0,01	0,03	0,05	–

Type of insert

Insert size	Width of slot mm
06	6

Insert selection – 335.29-R35

Universal insert: RDHT0702M0-E03 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,09–0,17	RDHT 0702M0-E03 F40M	RDHW 0702M0-MD03 F40M	
2	0,09–0,17	RDHT 0702M0-E03 F40M	RDHW 0702M0-MD03 F40M	
3	0,09–0,17	RDHT 0702M0-E03 F40M	RDHW 0702M0-MD03 F40M	
4	0,08–0,15	RDHW 0702M0-MD03 F40M	RDHT 0702M0-E03 F40M	
5	0,08–0,15	RDHW 0702M0T-MD04 MK2000	RDHW 0702M0T-MD04 F40M	
6	0,08–0,15	RDHW 0702M0T-MD04 MK2000	RDHW 0702M0T-MD04 F40M	
7	–	-	-	
8	0,06–0,15	RDHT 0702M0-E03 F40M	RDHW 0702M0-MD03 F40M	
9	0,06–0,15	RDHT 0702M0-E03 F40M	RDHW 0702M0-MD03 F40M	
10	0,04–0,12	RDHW 0702M0-MD03 F40M	RDHW 0702M0-MD03 MP3000	
11	0,04–0,12	RDHW 0702M0-MD03 F40M	RDHW 0702M0-MD03 MP3000	
12	0,11–0,19	RDHW 0702M0-MD03 MP3000	RDHW 0702M0T-MD04 MK2000	
13	0,11–0,19	RDHW 0702M0-MD03 MP3000	RDHW 0702M0T-MD04 MK2000	
14	0,11–0,19	RDHW 0702M0-MD03 MP3000	RDHW 0702M0T-MD04 MK2000	
15	0,11–0,19	RDHW 0702M0-MD03 MP3000	RDHW 0702M0T-MD04 MK2000	
16	0,09–0,20	RDHT 0702M0-E03 H25	RDHT 0702M0-E03 F40M	
17	0,09–0,20	RDHT 0702M0-E03 H25	RDHT 0702M0-E03 F40M	
20	0,08–0,15	RDHT 0702M0-E03 F40M	RDHT 0702M0-E03 F40M	
21	0,04–0,12	RDHT 0702M0-E03 F40M	RDHT 0702M0-E03 F40M	
22	0,08–0,15	RDHT 0702M0-E03 F40M	RDHT 0702M0-E03 F40M	

Cutting data – 10% engagement width (a_e/D_c = 10%)

Seco Material Group No.	Grades																	
	MP3000			F40M			F15M			MS2500			MK2000			H25		
	Feed, f_z (mm/tooth)																	
	0,04	0,11	0,19	0,04	0,11	0,19	0,04	0,11	0,19	0,04	0,11	0,19	0,04	0,11	0,19	0,04	0,11	0,19
	Cutting speed, v_c (m/min)																	
1	420	355	315	335	285	250	405	345	300	485	410	365	440	370	325	–	–	–
2	370	310	275	295	250	220	355	300	265	425	360	315	385	325	285	–	–	–
3	305	260	230	245	210	185	295	250	220	355	300	265	320	270	240	–	–	–
4	280	240	210	225	190	170	270	230	200	325	275	240	290	245	220	–	–	–
5	230	195	170	180	155	135	220	185	165	265	225	195	235	200	175	–	–	–
6	165	140	125	135	115	100	160	135	120	190	165	145	175	145	130	–	–	–
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
8	250	215	190	215	185	165	–	–	–	280	235	210	285	240	210	–	–	–
9	220	185	165	190	160	140	–	–	–	240	205	180	245	210	185	–	–	–
10	185	160	–	160	135	–	–	–	–	205	175	–	210	180	–	–	–	–
11	145	125	–	125	105	–	–	–	–	160	135	–	165	140	–	–	–	–
12	245	210	185	195	165	145	235	200	175	285	240	210	255	215	190	210	180	160
13	220	185	165	175	150	130	210	180	155	255	215	190	230	195	170	190	160	140
14	200	170	150	160	135	120	195	165	145	230	195	175	210	180	155	175	150	130
15	165	140	120	130	110	100	155	135	115	190	160	140	170	145	125	140	120	105
16	1140	965	850	910	775	680	1095	930	820	–	–	–	–	–	–	985	835	735
17	920	780	690	735	625	550	885	750	660	–	–	–	–	–	–	795	675	595
20	65	55	50	55	50	40	–	–	–	75	65	55	75	60	55	35	30	–
21	40	35	–	35	30	–	–	–	–	45	40	–	45	40	–	20	20	–
22	65	55	50	55	50	40	–	–	–	75	65	55	75	60	55	35	30	–

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,02	0,05	0,09	0,65
Side milling	2%	0,09	0,24	0,42	1,20
	5%	0,06	0,15	0,27	1,10
	10%	0,04	0,11	0,19	1,00
	20%	0,03	0,08	0,14	0,90
	30%	0,02	0,07	0,11	0,85
Average chip thickness h_m		0,012	0,03	0,06	–

Type of insert

Insert size	Width of slot mm
07	7

Insert selection – (R)335.29-R04

Universal insert: RDHT 0803M0-E03 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,10–0,18	RDHT 0803M0-E03 F40M	RDHT 0803M0-E03 T350M	
2	0,10–0,18	RDHT 0803M0-E03 F40M	RDHT 0803M0-E03 T350M	
3	0,10–0,18	RDHT 0803M0-E03 F40M	RDHT 0803M0-E03 T350M	
4	0,10–0,16	RDHW 0803M0-MD03 F40M	RDKW 0803M0T-MD05 F40M	
5	0,10–0,16	RDKW 0803M0T-MD05 F40M	RDKW 0803M0T-MD05 F25M	
6	0,10–0,16	RDKW 0803M0T-MD05 F40M	RDKW 0803M0T-MD05 F15M	
7	–	–	–	
8	0,08–0,16	RDHT 0803M0-E03 F40M	RDHW 0803M0-MD03 F40M	
9	0,08–0,16	RDHT 0803M0-E03 F40M	RDHW 0803M0-MD03 F40M	
10	0,06–0,14	RDHW 0803M0-MD03 F40M	RDKW 0803M0T-MD05 F40M	
11	0,06–0,14	RDHW 0803M0-MD03 F40M	RDKW 0803M0T-MD05 F40M	
12	0,12–0,20	RDKW 0803M0T-MD05 F25M	RDKW 0803M0T-MD05 F15M	
13	0,12–0,20	RDKW 0803M0T-MD05 F25M	RDKW 0803M0T-MD05 F15M	
14	0,12–0,20	RDKW 0803M0T-MD05 F25M	RDKW 0803M0T-MD05 F15M	
15	0,12–0,20	RDKW 0803M0T-MD05 F25M	RDKW 0803M0T-MD05 F15M	
16	0,10–0,20	RDHT 0803M0-E03 H25	RDHT 0803M0-E03 F40M	
17	0,10–0,20	RDHT 0803M0-E03 H25	RDHT 0803M0-E03 F40M	
20	0,10–0,16	RDHT 0803M0-E03 F40M	RDHW 0803M0-MD03 F40M	
21	0,06–0,14	RDHT 0803M0-E03 F40M	RDHW 0803M0-MD03 F40M	
22	0,10–0,16	RDHT 0803M0-E03 F40M	RDHW 0803M0-MD03 F40M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades																					
	MP3000			T350M			F40M			F15M			F25M			MS2500			H25		
	Feed, f_z (mm/tooth)																					
	0,06	0,12	0,20	0,06	0,12	0,20	0,06	0,12	0,20	0,06	0,12	0,20	0,06	0,12	0,20	0,06	0,12	0,20	0,06	0,12	0,20
	Cutting speed, v_c (m/min)																					
1	400	350	310	365	320	285	320	280	250	380	335	300	335	295	265	335	295	265	–	–	–
2	350	305	270	320	280	250	280	245	215	335	295	260	295	260	230	295	260	230	–	–	–
3	290	255	225	265	235	210	230	205	180	280	245	215	245	215	190	245	215	190	–	–	–
4	265	235	205	245	215	190	210	185	165	255	225	200	225	200	175	225	200	175	–	–	–
5	215	190	170	200	175	155	175	150	135	205	180	160	185	160	140	185	160	140	–	–	–
6	160	140	125	–	–	–	125	110	100	150	135	120	135	115	105	135	115	105	–	–	–
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
8	240	210	185	225	200	175	205	180	160	–	–	–	220	190	170	220	190	170	–	–	–
9	210	185	160	195	175	155	180	160	140	–	–	–	190	165	150	190	165	150	–	–	–
10	175	155	–	170	150	–	155	135	–	–	–	–	160	140	–	160	140	–	–	–	–
11	140	120	–	130	115	–	120	105	–	–	–	–	125	110	–	125	110	–	–	–	–
12	230	205	180	215	190	165	185	165	145	225	195	175	195	175	155	195	175	155	270	235	210
13	205	185	160	190	170	150	165	145	130	200	175	155	175	155	135	175	155	135	240	210	185
14	190	170	150	175	155	135	155	135	120	185	160	145	160	140	125	160	140	125	220	195	170
15	155	135	120	140	125	110	125	110	95	150	130	115	130	115	100	130	115	100	180	155	140
16	1080	950	840	–	–	–	865	760	675	1035	910	810	–	–	–	–	–	–	1240	1095	970
17	870	765	680	–	–	–	695	615	545	835	735	650	–	–	–	–	–	–	1005	885	785
20	60	55	50	60	50	45	55	45	40	–	–	–	55	50	45	55	50	45	70	65	–
21	40	35	–	35	30	–	35	30	–	–	–	–	35	30	–	35	30	–	45	40	–
22	60	55	50	60	50	45	55	45	40	–	–	–	55	50	45	55	50	45	70	65	–

Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,03	0,06	0,10	0,65
Side milling	2%	0,13	0,26	0,44	1,20
	5%	0,08	0,17	0,28	1,10
	10%	0,06	0,12	0,20	1,00
	20%	0,04	0,09	0,14	0,90
	30%	0,04	0,07	0,12	0,85
Average chip thickness h_m		0,02	0,04	0,06	–

Type of insert

Insert size	Width of slot mm
08	8

Insert selection – (R)335.18/29-R05

Universal insert: RDHT10T3M0T-M05 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,12–0,20	RDHT 10T3M0-E04 F40M	RDHT 10T3M0T-M05 F40M	
2	0,12–0,20	RDHT 10T3M0-E04 F40M	RDHT 10T3M0T-M05 F40M	
3	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
4	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
5	0,15–0,20	RDKW 10T3M0T-MD06 F40M	RDKW 10T3M0T-MD06 MP1500	
6	0,15–0,20	RDKW 10T3M0T-MD06 F40M	RDKW 10T3M0T-MD06 MP1500	
7	–	–	–	
8	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
9	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
10	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
11	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
12	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
13	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
14	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
15	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
16	0,12–0,25	RDHT 10T3M0-E04 H25	RDHT 10T3M0-E04 F40M	
17	0,12–0,25	RDHT 10T3M0-E04 H25	RDHT 10T3M0-E04 F40M	
20	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
21	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
22	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0-E04 F40M	

Cutting data – 10% engagement width (a_e/D_c = 10%)

Seco Material Group No.	Grades																				
	MP1500			MP3000			T350M			F40M			F25M			F15M			MS2500		
	Feed, f_z (mm/tooth)																				
	0,10	0,18	0,25	0,10	0,18	0,25	0,10	0,18	0,25	0,10	0,18	0,25	0,10	0,18	0,25	0,10	0,18	0,25	0,10	0,18	0,25
	Cutting speed, v_c (m/min)																				
1	–	–	–	390	345	315	360	315	290	315	275	250	330	290	265	–	–	–	435	380	350
2	–	–	–	345	300	275	315	275	255	275	240	220	290	255	235	–	–	–	380	335	305
3	–	–	–	285	250	230	265	230	210	230	200	185	240	210	195	–	–	–	315	280	255
4	300	265	240	260	230	210	240	210	195	210	185	170	220	195	180	–	–	–	290	255	235
5	245	215	195	210	185	170	195	170	155	170	150	135	180	160	145	–	–	–	235	205	190
6	180	155	145	155	135	125	145	125	115	125	110	100	130	115	105	–	–	–	170	150	140
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
8	–	–	–	235	205	–	225	195	–	200	175	–	215	190	–	–	–	–	250	220	–
9	–	–	–	205	180	–	195	170	–	175	155	–	185	165	–	–	–	–	215	190	–
10	–	–	–	175	155	–	165	145	–	150	130	–	160	140	–	–	–	–	185	160	–
11	–	–	–	135	120	–	130	115	–	120	105	–	125	110	–	–	–	–	145	125	–
12	260	230	210	230	200	185	210	185	170	185	160	145	195	170	155	220	190	175	255	220	205
13	235	205	190	205	180	165	190	165	150	165	145	130	175	150	140	195	170	160	225	200	180
14	215	190	175	190	165	150	175	150	140	150	130	120	160	140	130	180	160	145	210	180	165
15	175	155	140	150	135	120	140	120	110	120	105	100	130	115	105	145	130	115	170	145	135
16	–	–	–	1060	930	855	975	855	785	850	745	685	900	790	720	1020	895	820	1175	1030	945
17	–	–	–	855	750	690	790	690	635	685	600	550	725	635	585	825	720	660	950	835	765
20	–	–	–	60	55	–	55	50	–	50	45	–	55	50	–	–	–	–	65	60	–
21	–	–	–	40	35	–	35	30	–	35	30	–	35	30	–	–	–	–	40	35	–
22	–	–	–	60	55	–	55	50	–	50	45	–	55	50	–	–	–	–	65	60	–

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,05	0,09	0,12	0,65
Side milling	2%	0,22	0,40	0,55	1,20
	5%	0,14	0,25	0,35	1,10
	10%	0,10	0,18	0,25	1,00
	20%	0,07	0,13	0,18	0,90
	30%	0,06	0,11	0,15	0,85
Average chip thickness h_m		0,03	0,06	0,08	–

Type of insert

Insert size	Width of slot mm
10	10–12

Insert selection – (R)335.18/29-R05

Universal insert: RDHT10T3M0T-M05 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,12–0,20	RDHT 10T3M0-E04 F40M	RDHT 10T3M0T-M05 F40M	
2	0,12–0,20	RDHT 10T3M0-E04 F40M	RDHT 10T3M0T-M05 F40M	
3	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
4	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
5	0,15–0,20	RDKW 10T3M0T-MD06 F40M	RDKW 10T3M0T-MD06 MP1500	
6	0,15–0,20	RDKW 10T3M0T-MD06 F40M	RDKW 10T3M0T-MD06 MP1500	
7	–	–	–	
8	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
9	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
10	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
11	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
12	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
13	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
14	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
15	0,15–0,25	RDKW 10T3M0T-MD06 MP1500	RDKW 10T3M0T-MD06 F15M	
16	0,12–0,25	RDHT 10T3M0-E04 H25	RDHT 10T3M0-E04 F40M	
17	0,12–0,25	RDHT 10T3M0-E04 H25	RDHT 10T3M0-E04 F40M	
20	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
21	0,10–0,18	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0T-M05 T350M	
22	0,12–0,20	RDHT 10T3M0T-M05 F40M	RDHT 10T3M0-E04 F40M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades							
	H25							
	Feed, f_z (mm/tooth)							
	0,10	0,18	0,25					
	Cutting speed, v_c (m/min)							
1	–	–	–					
2	–	–	–					
3	–	–	–					
4	–	–	–					
5	–	–	–					
6	–	–	–					
7	–	–	–					
8	–	–	–					
9	–	–	–					
10	–	–	–					
11	–	–	–					
12	195	170	155					
13	175	150	140					
14	160	140	130					
15	130	115	105					
16	900	790	725					
17	725	635	585					
20	–	–	–					
21	–	–	–					
22	–	–	–					

Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,05	0,09	0,12	0,65
Side milling	2%	0,22	0,40	0,55	1,20
	5%	0,14	0,25	0,35	1,10
	10%	0,10	0,18	0,25	1,00
	20%	0,07	0,13	0,18	0,90
	30%	0,06	0,11	0,15	0,85
Average chip thickness h_m		0,03	0,06	0,08	–

Type of insert

Insert size	Width of slot mm
10	10–12

Insert selection – (R)335.18-R06

Universal insert: RPHT 1204M0T-M08 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,20–0,32	RPHT 1204M0-E05 F40M	RPHT 1204M0T-ME07 F40M	
2	0,20–0,32	RPHT 1204M0-E05 F40M	RPHT 1204M0T-ME07 F40M	
3	0,20–0,32	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-M08 F40M	
4	0,20–0,32	RPHT 1204M0T-M08 F40M	RPHT 1204M0T-M08 T350M	
5	0,15–0,25	RPHT 1204M0T-M10 F40M	RPHT 1204M0T-M08 T350M	
6	0,15–0,20	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
7	–	–	–	
8	0,12–0,25	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-ME07 T350M	
9	0,12–0,25	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-ME07 T350M	
10	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 MP3000	
11	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 MP3000	
12	0,20–0,32	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
13	0,20–0,32	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
14	0,15–0,25	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
15	0,15–0,25	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
16	0,15–0,32	RPHT 1204M0-E05 H25	RPHT 1204M0-E05 F40M	
17	0,15–0,32	RPHT 1204M0-E05 H25	RPHT 1204M0-E05 F40M	
20	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 F40M	
21	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 F40M	
22	0,12–0,20	RPHT 1204M0T-ME07 F40M	RPHT 1204M0-E05 F40M	

Cutting data – 10% engagement width (a_e/D_c = 10%)

Seco Material Group No.	Grades																				
	MP1500			MP3000			T350M			F40M			F15M			F25M			MS2500		
	Feed, f_z (mm/tooth)																				
	0,10	0,20	0,32	0,10	0,20	0,32	0,10	0,20	0,32	0,10	0,20	0,32	0,10	0,20	0,32	0,10	0,20	0,32	0,10	0,20	0,32
	Cutting speed, v_c (m/min)																				
1	–	–	–	390	335	295	360	310	270	300	255	225	–	–	–	330	285	250	450	385	340
2	–	–	–	345	295	255	315	270	235	265	225	195	–	–	–	290	250	215	395	335	295
3	–	–	–	285	245	215	265	225	195	220	190	165	–	–	–	240	205	180	330	280	245
4	300	255	225	260	225	195	240	205	180	200	170	150	–	–	–	220	190	165	300	255	225
5	245	210	180	210	180	160	195	165	145	165	140	120	–	–	–	180	155	135	245	210	185
6	180	150	–	155	130	–	145	120	–	120	100	–	–	–	–	130	110	–	180	155	–
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
8	–	–	–	235	200	–	225	190	–	195	165	–	–	–	–	215	185	–	260	220	–
9	–	–	–	205	175	–	195	165	–	170	145	–	–	–	–	185	160	–	225	195	–
10	–	–	–	175	150	–	165	140	–	145	125	–	–	–	–	160	135	–	190	165	–
11	–	–	–	135	115	–	130	110	–	115	95	–	–	–	–	125	105	–	150	130	–
12	260	225	195	230	195	170	210	180	155	175	150	130	245	210	185	195	165	145	265	225	195
13	235	200	175	205	175	155	190	160	140	155	135	120	220	185	165	175	145	130	235	200	175
14	215	185	160	190	160	140	175	145	130	145	125	110	200	170	150	160	135	120	215	185	160
15	175	150	130	150	130	115	140	120	105	115	100	85	160	140	120	130	110	95	175	150	130
16	–	–	–	1060	905	795	975	835	730	815	695	610	1135	970	850	900	765	670	1225	1045	915
17	–	–	–	855	730	640	790	675	590	660	565	495	915	785	685	725	620	545	990	845	740
20	–	–	–	60	50	–	55	50	–	50	45	–	–	–	–	55	45	–	70	60	–
21	–	–	–	40	30	–	35	30	–	30	25	–	–	–	–	35	30	–	45	35	–
22	–	–	–	60	50	–	55	50	–	50	45	–	–	–	–	55	45	–	70	60	–

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,05	0,10	0,16	0,65
Side milling	2%	0,22	0,44	0,71	1,20
	5%	0,14	0,28	0,45	1,10
	10%	0,10	0,20	0,32	1,00
	20%	0,07	0,14	0,23	0,90
	30%	0,06	0,12	0,19	0,85
Average chip thickness h_m		0,03	0,06	0,10	–

Type of insert

Insert size	Width of slot mm
12	12–15

Insert selection – (R)335.18-R06

Universal insert: RPHT 1204M0T-M08 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,20–0,32	RPHT 1204M0-E05 F40M	RPHT 1204M0T-ME07 F40M	
2	0,20–0,32	RPHT 1204M0-E05 F40M	RPHT 1204M0T-ME07 F40M	
3	0,20–0,32	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-M08 F40M	
4	0,20–0,32	RPHT 1204M0T-M08 F40M	RPHT 1204M0T-M08 T350M	
5	0,15–0,25	RPHT 1204M0T-M10 F40M	RPHT 1204M0T-M08 T350M	
6	0,15–0,20	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
7	–	–	–	
8	0,12–0,25	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-ME07 T350M	
9	0,12–0,25	RPHT 1204M0T-ME07 F40M	RPHT 1204M0T-ME07 T350M	
10	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 MP3000	
11	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 MP3000	
12	0,20–0,32	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
13	0,20–0,32	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
14	0,15–0,25	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
15	0,15–0,25	RPKW 1204M0T-MD10 MP1500	RPKW 1204M0T-MD10 F15M	
16	0,15–0,32	RPHT 1204M0-E05 H25	RPHT 1204M0-E05 F40M	
17	0,15–0,32	RPHT 1204M0-E05 H25	RPHT 1204M0-E05 F40M	
20	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 F40M	
21	0,12–0,20	RPHT 1204M0T-M08 F40M	RPHW 1204M0-MD05 F40M	
22	0,12–0,20	RPHT 1204M0T-ME07 F40M	RPHT 1204M0-E05 F40M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades							
	H25							
	Feed, f_z (mm/tooth)							
	0,10	0,20	0,32					
	Cutting speed, v_c (m/min)							
1	–	–	–					
2	–	–	–					
3	–	–	–					
4	–	–	–					
5	–	–	–					
6	–	–	–					
7	–	–	–					
8	–	–	–					
9	–	–	–					
10	–	–	–					
11	–	–	–					
12	175	150	130					
13	155	130	115					
14	145	120	105					
15	115	100	85					
16	805	690	605					
17	650	555	490					
20	–	–	–					
21	–	–	–					
22	–	–	–					

Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,05	0,10	0,16	0,65
Side milling	2%	0,22	0,44	0,71	1,20
	5%	0,14	0,28	0,45	1,10
	10%	0,10	0,20	0,32	1,00
	20%	0,07	0,14	0,23	0,90
	30%	0,06	0,12	0,19	0,85
Average chip thickness h_m		0,03	0,06	0,10	–

Type of insert

Insert size	Width of slot mm
12	12–15

Insert selection – (R)335.18-R08

Universal insert: RPKT 1605M0T-ME11 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
2	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
3	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
4	0,20–0,32	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
5	0,20–0,28	RPHT 1605M0T-M12 F40M	RPHT 1605M0T-M12 T350M	
6	0,16–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 MP1500	
7	–	–	–	
8	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
9	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
10	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
11	0,20–0,28	RPHT 1605M0T-M12 F40M	RPHT 1605M0T-M12 T350M	
12	0,25–0,38	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
13	0,25–0,38	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
14	0,20–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
15	0,20–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
16	0,20–0,38	RPHT 1605M0-E08 H25	RPHT 1605M0-E08 H25	
17	0,20–0,38	RPHT 1605M0-E08 H25	RPHT 1605M0-E08 H25	
20	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHW 1605M0T-MD08 F40M	
21	0,16–0,25	RPHT 1605M0T-ME11 F40M	RPHW 1605M0T-MD08 F40M	
22	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades																				
	MP1500			MP3000			T350M			F40M			F25M			F15M			MS2500		
	Feed, f_z (mm/tooth)																				
	0,16	0,25	0,38	0,16	0,25	0,38	0,16	0,25	0,38	0,16	0,25	0,38	0,16	0,25	0,38	0,16	0,25	0,38	0,16	0,25	0,38
	Cutting speed, v_c (m/min)																				
1	–	–	–	345	310	270	320	285	250	275	245	220	295	260	230	–	–	–	400	355	315
2	–	–	–	305	270	240	280	250	220	240	215	190	255	230	200	–	–	–	350	310	275
3	–	–	–	250	225	200	230	205	185	200	180	160	215	190	170	–	–	–	290	260	230
4	265	235	210	230	205	180	210	190	165	185	165	145	195	175	155	–	–	–	265	235	210
5	215	190	170	185	165	145	170	155	135	150	135	120	160	140	125	–	–	–	215	190	170
6	155	140	–	135	120	–	125	110	–	110	100	–	115	105	–	–	–	–	160	140	–
7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
8	–	–	–	205	185	165	195	175	155	180	160	140	190	170	150	–	–	–	230	205	180
9	–	–	–	180	160	140	170	155	135	155	140	125	165	145	130	–	–	–	200	180	155
10	–	–	–	155	135	–	145	130	–	135	120	–	140	125	–	–	–	–	170	150	–
11	–	–	–	120	105	–	115	100	–	105	90	–	110	100	–	–	–	–	135	120	–
12	230	205	180	200	180	160	185	165	145	160	145	125	170	150	135	215	190	170	230	205	185
13	205	185	165	180	160	140	165	150	130	145	130	115	155	135	120	195	170	150	210	185	165
14	190	170	–	165	150	–	155	135	–	135	120	–	140	125	–	175	160	–	190	170	–
15	155	135	–	135	120	–	125	110	–	105	95	–	115	100	–	145	130	–	155	140	–
16	–	–	–	935	835	735	860	770	680	750	670	590	795	705	625	1005	895	790	1080	960	850
17	–	–	–	755	675	595	695	620	550	605	540	475	640	570	505	810	720	635	870	775	685
20	–	–	–	55	50	–	50	45	–	45	40	–	50	45	–	–	–	–	60	55	–
21	–	–	–	35	30	–	30	30	–	30	25	–	30	25	–	–	–	–	40	35	–
22	–	–	–	55	50	–	50	45	–	45	40	–	50	45	–	–	–	–	60	55	–

Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,08	0,12	0,19	0,65
Side milling	2%	0,35	0,55	0,84	1,20
	5%	0,22	0,35	0,53	1,10
	10%	0,16	0,25	0,38	1,00
	20%	0,12	0,18	0,27	0,90
	30%	0,10	0,15	0,23	0,85
Average chip thickness h_m		0,05	0,08	0,12	–

Type of insert

Insert size	Width of slot mm
16	16–18,5

Insert selection – (R)335.18-R08

Universal insert: RPKT 1605M0T-ME11 F40M

Seco Mat. group No.	Recom. feed f_z mm/tooth a_e/D_c = 10%	First choice	Alternative	
1	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
2	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
3	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
4	0,20–0,32	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
5	0,20–0,28	RPHT 1605M0T-M12 F40M	RPHT 1605M0T-M12 T350M	
6	0,16–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 MP1500	
7	–	–	–	
8	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
9	0,25–0,38	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
10	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	
11	0,20–0,28	RPHT 1605M0T-M12 F40M	RPHT 1605M0T-M12 T350M	
12	0,25–0,38	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
13	0,25–0,38	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
14	0,20–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
15	0,20–0,28	RPKW 1605M0T-MD20 MP1500	RPKW 1605M0T-MD20 F15M	
16	0,20–0,38	RPHT 1605M0-E08 H25	RPHT 1605M0-E08 H25	
17	0,20–0,38	RPHT 1605M0-E08 H25	RPHT 1605M0-E08 H25	
20	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHW 1605M0T-MD08 F40M	
21	0,16–0,25	RPHT 1605M0T-ME11 F40M	RPHW 1605M0T-MD08 F40M	
22	0,20–0,28	RPHT 1605M0T-ME11 F40M	RPHT 1605M0T-ME11 T350M	

Cutting data – 10% engagement width (a_e /D_c = 10%)

Seco Material Group No.	Grades							
	H25							
	Feed, f_z (mm/tooth)							
	0,16	0,25	0,38					
	Cutting speed, v_c (m/min)							
1	–	–	–					
2	–	–	–					
3	–	–	–					
4	–	–	–					
5	–	–	–					
6	–	–	–					
7	–	–	–					
8	–	–	–					
9	–	–	–					
10	–	–	–					
11	–	–	–					
12	155	135	120					
13	135	120	110					
14	125	110	–					
15	100	90	–					
16	710	635	560					
17	575	510	455					
20	–	–	–					
21	–	–	–					
22	–	–	–					

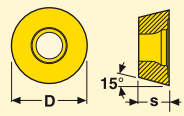
Cutting data – Side milling

Operations	a_e /D_c	Recom. feed f_z mm/tooth			Speed factor
Radial infeed	–	0,08	0,12	0,19	0,65
Side milling	2%	0,35	0,55	0,84	1,20
	5%	0,22	0,35	0,53	1,10
	10%	0,16	0,25	0,38	1,00
	20%	0,12	0,18	0,27	0,90
	30%	0,10	0,15	0,23	0,85
Average chip thickness h_m		0,05	0,08	0,12	–

Type of insert

Insert size	Width of slot mm
16	16–18,5

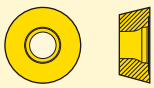
RD..05/06/07/08/10



Tolerances (± mm)

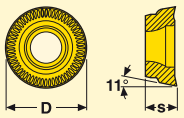
	D	s
RDHT	0,013	0,025
RDHW	0,013	0,025
RDKW	0,05	0,025

Size	Dimensions in mm D	s
0501	5,0	1,51
06T1	6,0	2,18
0702	7,0	2,38
0803	8,0	3,18
10T3	10,0	3,97

Inserts	Part No.	Cutting rake	Grades: Coated MK1500	MK2000	MK3000	MP1500	MP2500	MP3000	MH1000	MS2500	T25M	T350M	F15M	F20M	F25M	F40M	Uncoated S60M	HX	H15	H25
E02/E03/E04																				
	RDHT 06T1M0-E02	18°														■				■
	0702M0-E03	18°														■				■
	0803M0-E03	20°										■				■				■
	10T3M0-E04	20°										■				■				■
M05/M07	10T3M0T-M05	16°			■		■			■		■				■				
	10T3M0T-M07	11°					■			■		■				■				
	RDHW 0501M0-MD01	0°						■					■			■				
	06T1M0-MD02	0°		■				■					■		■	■				
MD01/MD02/MD03/	0702M0-MD03	0°						■								■				
MD04/MD05/MD06	0702M0-MD04	0°		■						■			■			■				
	0803M0-MD03	0°						■								■				
	10T3M0-MD04	0°						■								■				
	10T3M0T-MD06	0°							■						■	■				
	RDKW 0803M0T-MD05	0°		■			■			■			■		■	■				
	10T3M0T-MD06	0°		■		■	■			■			■		■	■				

■Stock standard
Subject to change refer to current price and stock-list

RP..12



Tolerances (± mm)

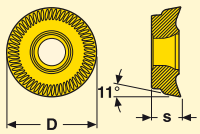
	D	s
RPH.	0,013	0,025
RPKW	0,08	0,025

Size	Dimensions in mm D	s
1204	12,0	4,76

Inserts	Part No.	Cutting rake	Grades: Coated MK1500	MK2000	MK3000	MP1500	MP2500	MP3000	MH1000	MS2500	T25M	T350M	F15M	F20M	F25M	F40M	Uncoated S60M	HX	H15	H25
ME07																				
	RPHT 1204M0T-M08	16°					■			■	■	■				■				
	1204M0-E05	20°								■		■	■			■				■
	1204M0T-ME07	20°								■		■				■				
	1204M0T-M15	15°			■	■	■			■		■			■	■				
E05/MD05	1204M0T-M10	11°					■			■		■				■				
																				
	RPHW 1204M0-MD05	0°						■								■				
	1204M0T-MD10	0°							■											
M08/M15/MD10																				
	RPKW 1204M0T-MD10	0°		■		■				■			■		■					
M10																				
																				

■Stock standard
Subject to change refer to current price and stock-list

RP..16



Tolerances (± mm)

	D	s
RPHT	0,013	0,025
RPKW	0,10	0,025
RPHW	0,013	0,025

Size	Dimensions in mm D	s
1605	16,0	5,56

Inserts	Part No.	Cutting rake	Grades: Coated MK1500	MK2000	MK3000	MP1500	MP2500	MP3000	MH1000	MS2500	T25M	T350M	F15M	F20M	F25M	F40M	Uncoated S60M	HX	H15	H25
ME11																				
	RPHT 1605M0T-ME11	21°					■			■		■				■				
	1605M0-E08	21°																		■
	1605M0T-M12	15°					■			■		■				■				
	1605M0T-M18	15°			■	■	■			■		■			■	■				
M12/MD20/MD08																				
	RPKW 1605M0T-MD20	0°		■		■				■		■	■		■					
	RPHW 1605M0T-MD08	0°						■								■				
E08																				

■Stock standard
Subject to change refer to current price and stock-list