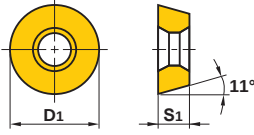
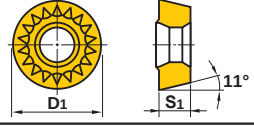


INSERTS

Work Material	P	Steel	●	●	●	●	●	●	Cutting Conditions (Guide):	
	M	Stainless Steel	●	●	●	●	●	●		
Work Material	K	Cast Iron	●	●	●	●	●	●	Honing:	
	S	Heat-resistant Alloy, Titanium Alloy	●	●	●	●	●	●		
Work Material	H	Hardened Materials	●	●	●	●	●	●	E: Round T: Chamfer	
			●	●	●	●	●	●		
Shape	Order Number	Class	Honing	Coated		Cermet	Carbide	Dimensions (mm)		Geometry
				F7010	F7030			D1	S1	
	RPMW08T2M0E	M	E					8	2.78	
	08T2M0T	M	T		●			8	2.78	
	10T3M0E	M	E	●			★	10	3.97	
	10T3M0T	M	T		●			10	3.97	
	1204M0E	M	E	●		●	●	12	4.76	
	1204M0T	M	T		●	●	●	12	4.76	
	1606M0E	M	E	●		●	●	16	6.35	
	1606M0T	M	T		●			16	6.35	
	RPMT08T2M0E-JS	M	E	●	●		●	8	2.78	
	10T3M0E-JS	M	E	●	●		●	10	3.97	
	1204M0E-JS	M	E	●	●	●	●	12	4.76	
	1606M0E-JS	M	E	●	●			16	6.35	

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED (m/min)

Work Material	Hardness	Coated		Carbide
		F7030	VP15TF	UTi20T
P	Mild Steel	250 (200—300)	250 (200—300)	150 (100—200)
	Carbon Steel Alloy Steel	180 (130—220)	180 (130—220)	140 (100—170)
		160 (110—190)	160 (110—190)	100 (70—120)
	Pre-Hardened Steel	120 (80—140)	120 (80—140)	90 (60—100)
	High Alloy Steel	130 (90—160)	130 (90—160)	100 (70—120)
M	Stainless Steel	180 (130—220)	180 (130—220)	140 (100—170)
K	Cast Iron	—	170 (130—220)	140 (100—170)
	Ductile Cast Iron	—	140 (100—180)	120 (80—140)
		—	110 (80—140)	90 (70—110)
H	Hardened Steel	—	60 (50—100)	60 (40—70)

(Note) Cutting speeds shown in bold type are for the recommended first choice grades.

FEED PER TOOTH (mm/tooth)

Type	Depth of Cut (mm)							
	1	2	3	4	5	6	7	8
BRP4	0.40	0.30	0.20	0.10	—	—	—	—
BRP5	0.40	0.35	0.30	0.20	0.10	—	—	—
BRP6	0.50	0.40	0.30	0.25	0.23	0.20	—	—
BRP8	0.60	0.50	0.45	0.40	0.33	0.30	0.25	0.20