RM Type

Rake Angle		
	Radial	−6° 45′
	Axial	−5° 45′

3mm / 75°

P Steel	M Stainless Steel	K Cast Iron	N Non-Ferrous Metal	N Aluminum	S Exotic Alloy	H Hardened Steel
×	×	◎	×	×	×	×

High Speed and High Efficiency Milling for Cast Iron

- **High Speed, High Efficiency Milling of Gray Cast Iron**
  - Utilising solid SUMIBORON BNS800 for high speed cutting of v_c = 1,500m/min.
  - High speed roughing of up to d=3.0mm.
  - Wiper insert for high speed finishing.
- **Low Cost**
  - Cost effective 8 cornered inserts.
  - Insert regrinding possible.
- **Simple Design for Insert Run-out**
  - Direct insert mounting design.
  - Insert run-out can be easily adjusted.

Fig 1

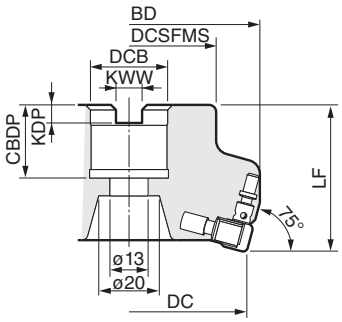
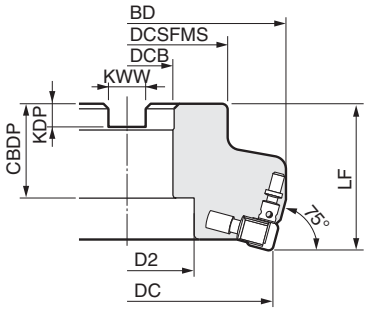


Fig 2



Body

Inch

Dimensions (mm)

Cat. No.	Stock	Diameter DC	External Diameter BD	Boss DCSFMS	Bolt D1	Height LF	Hole Size DCB	Grooving Width KWW	Grooving Depth KDP	Mounting Depth CBDP	No. of Teeth	Max. Rotation (min⁻¹)	Weight (kg)	Fig
RM 3080R		**80**	90	60	—	50	**25.40**	9.5	6	25	6	9,000	1.6	1
RM 3100R		**100**	110	70	46	50	**31.75**	12.7	8	32	8	8,000	2.1	2
3125R		**125**	135	80	59	63	**38.10**	15.9	10	38	10	7,000	3.9	2
3160R		**160**	170	100	80	63	**50.80**	19.1	11	38	12	6,000	5.9	2

Inserts are not included.

Inserts

Fig 3

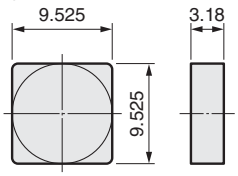
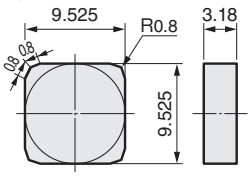
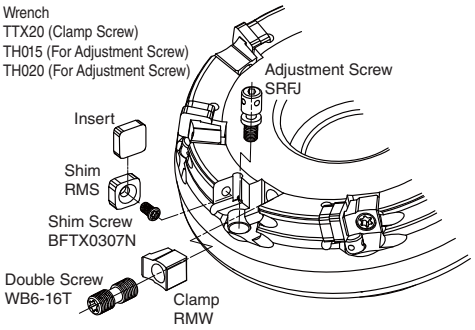


Fig 4 Wiper Insert



	Grade	CBN	
Application	High Speed/Light	K	
	General Purpose	K	
	Roughing	K	
Cat. No.		BNS800	Fig
SNGN 090308		●	3
090312		●	3
SNEN 090308W		●	4



Parts

Clamp	Double Screw	Shim	Shim Screw
RMW	WB6-16T	RMS	BFTX0307N (N·m) 2.0
Adjustment Screw	Wrench (For Clamp)	Wrench (For Adjustment Screw)	Wrench (For Adjustment Screw)
SRF J	TTX20	TH015	TH020

(N·m) Recommended Tightening Torque (N·m)

CAUTION

- Do not mix standard and wiper inserts on same cutter.
- Do not mix new and reground inserts on same cutter.
- Inserts can only be reground once (inscribed circle dimension must be at least 9.125mm)

For hardened steel machining use the SEC ACE Mill DNF Type.

Milling Cutter Body…☞ Page H54 Insert…☞ Page L96

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - **Optimum** - Max.	Feed Rate f_z(mm/t) Min. - **Optimum** - Max.	Grade
K	Gray Cast Iron	250HB	800- **1150** -1500	0.05- **0.13** -0.20	BNS800 (Dry)

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.