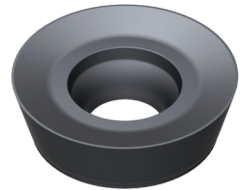


RDMT 1604 MOSN LT 30

Cat. Nr. M0001881

RDMT 1604 MOSN LT 30

Lamina Technologies Marketing team is delighted to offer a new addition to our Milling Line – RDMT 1604 MOSN LT 30.



Description

- Reinforced positive cutting edge for universal applications
- ISO round insert for Roughing Milling

Application Area

This new developed insert is completing the Lamina Milling line with the latest and most modern technics in Milling. The positive rake angle preceded by a chamfer maintains a stable machining, even for machines without ball screws or not powerful electric motors.

The insert can be mounted on any type of end mills or shell mills and is suitable for universal applications including:







- Pocket milling, shoulder milling, facing, plunging, and ramping down
- Dry & wet machining (according to each material's recommendation)

Main Advantages

- Fits standard cutters available in the market
- Low cost per edge, with unlimited indexes
- Excellent toughness & wear resistance
- Follows the "Multi-Mat™" Concept

Main Competitors

- ISO types of RDHX 1604, RDMT 1604 and RPMT 1604

Material Group	Gr. N°	VDI Group	Material Examples*	Coolant	Hardness	d.o.c [mm]		Feed [mm/rev]		V _c [m/min]		Optimal cutting conditions		
						min	max	min	max	min	max	d.o.c.	feed	Vc
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6		125 HB	0.4	5.3	0.40	0.90	190	350	1.9	0.80	300
		190 HB			0.4	5.3	0.40	0.90	190	300	1.9	0.80	250	
		250 HB			0.4	4.0	0.40	0.70	190	260	1.9	0.70	220	
	Low alloyed	2	42CrMo4, St50-2, Ck60, 4140, 4340, 100Cr6		180 HB	0.4	5.3	0.30	0.90	150	240	1.9	0.80	210
		230 HB			0.4	4.0	0.30	0.80	150	210	1.9	0.70	190	
		280 HB			0.4	2.7	0.30	0.70	130	190	1.9	0.70	150	
		350 HB			0.4	1.9	0.30	0.70	130	170	1.3	0.70	130	
		220 HB			0.4	2.7	0.30	0.80	90	150	1.3	0.70	130	
	High alloyed	3	X40CrMoV5-1, H13, M42, D3, S6-5-2, 12Ni19		280 HB	0.4	2.7	0.30	0.70	90	130	1.3	0.70	120
		320 HB			0.4	1.9	0.30	0.70	60	110	1.3	0.70	100	
		350 HB			0.4	1.9	0.30	0.60	60	90	1.3	0.60	90	
		180 HB			0.4	4.0	0.30	0.60	190	250	3.4	0.40	200	
Stainless Steel	Austenitic	4	304, 316, 316L, X5CrNi18-9		-	0.4	4.0	0.20	0.50	70	150	3.4	0.30	90
		-			0.4	4.0	0.20	0.50	70	150	3.4	0.30	90	
	Duplex	5	X2CrNiN23-4, S31500		200 HB	0.4	2.7	0.20	0.50	150	210	1.3	0.70	150
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	42 HRc	0.4	1.9	0.20	0.50	70	150	1.3	0.60	80		
			150 HB	0.4	4.0	0.30	1.10	170	300	2.7	1.10	200		
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B		200 HB	0.4	4.0	0.30	1.10	170	250	2.7	0.90	170
					250 HB	0.4	4.0	0.30	1.10	150	210	2.7	0.80	150
					150 HB	0.4	3.4	0.30	0.80	120	210	1.9	0.70	210
	Malleable & Nodular	8	GGG40, GGG70, S0005		200 HB	0.4	3.4	0.30	0.80	120	170	1.9	0.70	170
					250 HB	0.4	3.4	0.30	0.80	120	150	1.9	0.80	150
High Temp. Alloys	Ni, Fe & Co based	9	Inconel 718, Monel 400, Hastelloy C		250 HB	0.4	5.3	0.20	0.50	25	35	4.0	0.30	30
					350 HB	0.4	5.3	0.20	0.50	28	45	4.0	0.30	40
					240 HB	0.4	5.3	0.20	0.50	40	60	4.0	0.30	55
	Ti based	10	TiAl6V4, R54520		-	0.4	5.3	0.30	0.50	35	60	2.7	0.40	50
					-	0.4	5.3	0.30	0.40	28	40	2.7	0.40	35
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42, Ni-Hard 2, G-X260Cr27		45 HRc	0.4	1.3	0.20	0.50	40	80	0.6	0.50	60
					50 HRc	0.4	1.0	0.20	0.50	40	70	0.6	0.50	50
					55 HRc	0.4	0.6	0.20	0.40	40	60	0.6	0.40	40
	Chilled Cast Iron	40	G-X260Cr27		400 HB	0.4	1.3	0.20	0.50	40	60	0.6	0.50	50
					55 HRc	0.4	0.6	0.20	0.50	30	60	0.6	0.50	30
NF	Al (>8%Si)	12	AlSi12		130 HB	0.4	5.3	0.40	1.10	200	400	2.7	0.50	350

This cutting conditions table is showing initial recommendations but, the insert can perform in a wider range.