

Profile Milling

# MPB100

Arbor

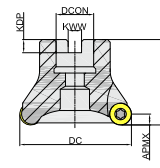


Fig1

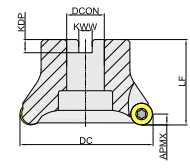


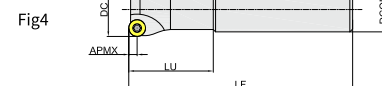
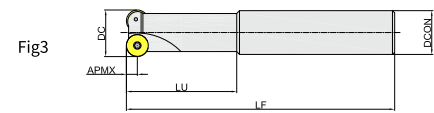
Fig2

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Clamp	Shape	Stock
			DC	DCON	LF	KWW	KDP						
MPB100040R04A16RP10	40	4	40	16	40	8.4	6.3	5	RP**1003	×	✓	Fig1	●
MPB100040R05A16RP08	40	5	40	16	40	8.4	6.3	4	RP**08T2	×	×	Fig1	●
MPB100050R04A22RP10	50	4	50	22	50	10.4	6.3	5	RP**1003	×	✓	Fig1	●
MPB100050R04A22RP12	50	4	50	22	50	10.4	6.3	6	RP**1204	×	✓	Fig1	●
MPB100063R04A22RP16	63	4	63	22	40	10.4	6.3	8	RP**1606	×	×	Fig1	●
MPB100063R05A22RP12	63	5	63	22	50	10.4	6.3	6	RP**1204	×	✓	Fig1	●
MPB100063R06A22RP12	63	6	63	22	50	10.4	6.3	6	RP**1204	×	✓	Fig1	●
MPB100080R06A27RP16	80	6	80	27	50	12.4	7	8	RP**1606	×	×	Fig1	●
MPB100100R07B32RP16	100	7	100	32	50	14.4	8	8	RP**1606	×	×	Fig2	●
MPB100125R08B40RP16	125	8	125	40	63	16.4	9	8	RP**1606	×	×	Fig2	●

● Stock ○ Available Upon Order

# MPB100

Cylindrical Straight Type



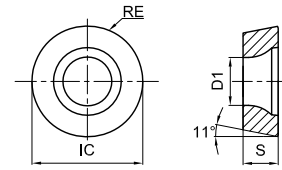
Ordering Code	Dia-meter	Teeth	Dimension(mm)				APMX	Suitable for	Coolant	Clamp	Shape	Stock
			DC	DCON	LF	LU						
MPB100016R02P16RP08S	16	2	16	16	120	40	4	RP**08T2	×	×	Fig3	●
MPB100016R02P16RP08	16	2	16	16	160	50	4	RP**08T2	×	×	Fig3	●
MPB100020R02P20RP08	20	2	20	20	160	50	4	RP**08T2	×	×	Fig3	●
MPB100020R02P20RP10	20	2	20	20	160	50	5	RP**1003	×	✓	Fig3	●
MPB100025R02P20RP10	25	2	25	20	160	50	5	RP**1003	×	✓	Fig4	●
MPB100025R02P20RP10L	25	2	25	20	200	50	5	RP**1003	×	✓	Fig4	●
MPB100025R02P25RP12	25	2	25	25	160	50	6	RP**1204	×	✓	Fig3	●
MPB100025R03P25RP08	25	3	25	25	160	50	4	RP**08T2	×	×	Fig3	●
MPB100032R02P25RP12	32	2	32	25	160	50	6	RP**1204	×	✓	Fig4	●
MPB100032R02P25RP12L	32	2	32	25	200	60	6	RP**1204	×	✓	Fig4	●
MPB100032R03P25RP12	32	3	32	25	160	50	6	RP**1204	×	✓	Fig4	●
MPB100040R02P32RP16	40	2	40	32	200	65	8	RP**1606	×	×	Fig4	●






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Profile Milling

# RP

Profile Milling Inserts (Positive)



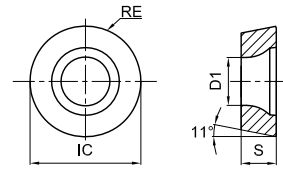
Ordering Code	Dimension(mm)				Coating Grade										Uncoated	Cermat					
	IC	S	RE	D1	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115			GS4130	GH4115	GN9125	GP01TM	
	RPET1003M0-GL	10	3.18	5	4.4	○	○	○													
	RPET1204M0-GL	12	4.76	6	4.4	○	○	○													
	RPET08T2M0-GM	8	2.78	4	2.9	●	●	●	○	●											
	RPET1003M0T-GM	10	3.18	5	4.4	○	○	○													
	RPET1204M0-GM	12	4.76	6	4.4	●	○	●	○												
	RPET1204M0T-GM	12	4.76	6	4.4	●	●	○	●												
	RPET1606M0T-GM	16	6.35	8	5.5	○	○	○	○												
	RPET1606M0T-GH	16	6.35	8	5.5	○	○	○	○												
	RPET1606M0-SM	16	6.35	8	5.5					○		●				●					
	RPEW08T2M0	8	2.78	4	2.9	○		○	○												
	RPEW1003M0	10	3.18	5	4.4	○	○	○	○												
	RPEW10T3M0	10	3.97	5	4.4	○	○	○	○												
	RPEW1003M0T	10	3.18	5	4.4	●	●	●	●												
	RPEW1204M0T	12	4.76	6	4.4		○	○	○												







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Profile Milling

# RP













Profile Milling Inserts (Positive)



Ordering Code	Dimension(mm)				Coating Grade										Uncoated	Cermet				
	IC	S	RE	D1	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115			GS4130	GH4115	GN9125	GP01TM
 RPMT10T3M0-GM	10	3.97	5	4.4	●	●	●	●	●										○	
 RPMT1003M0T-GM	10	3.18	5	4.4	●	●	●	●	○			●	○							
 RPMT1204M0-GM	12	4.76	6	4.4	●	●	●	●	●			○	●							
 RPMT1204M0T-KM	12	4.76	6	4.4	○	○	○	○			●									
 RPMW1003M0T	10	3.18	5	4.4	●	●	●	●	●				●	●						●
 RPMW1204M0T	12	4.76	6	4.4	●	●	●	●	●		●		●							

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## RP Series Geometry

Light Cutting for General Material	Medium Cutting for General Material	Medium Machining of General Cast Iron	Medium Machining of Nonferrous Metal	Heavy Cutting for General Material	
					
GL	GM	KM	SM	GH	None
					
Big rake angle, sharper edge.	Suitable edge width and rake design, has good strength and sharpness.	Suitable edge width and rake design, has good strength and sharpness.	Suitable edge width and rake design, has good strength and sharpness.	Small rake angle, flat design, high edge strength.	

## RD/RP/RC Recommend Cutting Feed and Cutting Depth

Specification	Working Conditions	Ap(mm)								
		0.1	0.5	1	1.5	2	2.5	3	4	5
05	Medium Maching (M)	0.35 (0.22-0.63)	0.17 (0.08-0.26)	0.12 (0.06-0.21)	0.1 (0.05-0.17)	-	-	-	-	-
	Heavy Maching (H)	0.45 (0.29-0.95)	0.2 (0.12-0.38)	0.16 (0.09-0.28)	0.14 (0.07-0.25)	-	-	-	-	-
07 08	Medium Maching (M)	0.59 (0.23-0.9)	0.27 (0.1-0.41)	0.2 (0.08-0.3)	0.17 (0.06-0.26)	0.15 (0.03-0.23)	-	-	-	-
	Heavy Maching (H)	0.68 (0.32-1.13)	0.31 (0.14-0.52)	0.23 (0.11-0.38)	0.19 (0.09-0.32)	0.17 (0.08-0.29)	-	-	-	-
10	Light Maching (L)	0.75 (0.25-0.9)	0.34 (0.11-0.41)	0.25 (0.08-0.3)	0.21 (0.07-0.25)	0.19 (0.06-0.23)	0.17 (0.05-0.21)	-	-	-
	Medium Maching (M)	0.9 (0.25-1.26)	0.41 (0.11-0.57)	0.30 (0.08-0.42)	0.25 (0.07-0.35)	0.23 (0.06-0.31)	0.21 (0.05-0.28)	-	-	-
	Heavy Maching (H)	1.01 (0.35-1.51)	0.46 (0.16-0.69)	0.33 (0.12-0.5)	0.28 (0.1-0.42)	0.25 (0.09-0.38)	0.23 (0.08-0.35)	-	-	-
12	Light Maching (L)	0.83 (0.28-1.1)	0.38 (0.13-0.5)	0.27 (0.09-0.36)	0.23 (0.08-0.3)	0.2 (0.07-0.27)	0.18 (0.06-0.25)	0.17 (0.06-0.23)	-	-
	Medium Maching (M)	0.99 (0.28-1.38)	0.45 (0.13-0.63)	0.33 (0.09-0.45)	0.27 (0.08-0.38)	0.24 (0.07-0.34)	0.22 (0.06-0.31)	0.21 (0.06-0.29)	-	-
	Heavy Maching (H)	1.1 (0.39-1.65)	0.5 (0.18-0.75)	0.36 (0.13-0.54)	0.3 (0.11-0.45)	0.27 (0.09-0.4)	0.25 (0.08-0.37)	0.23 (0.08-0.35)	-	-
16	Light Maching (L)	1.14 (0.32-1.59)	0.52 (0.14-0.72)	0.37 (0.1-0.52)	0.31 (0.09-0.43)	0.27 (0.08-0.38)	0.25 (0.07-0.35)	0.23 (0.06-0.32)	0.21 (0.06-0.29)	-
	Medium Maching (M)	1.27 (0.32-1.9)	0.57 (0.14-0.86)	0.41 (0.1-0.62)	0.34 (0.09-0.51)	0.30 (0.08-0.45)	0.28 (0.07-0.41)	0.26 (0.06-0.38)	0.23 (0.06-0.35)	-
	Heavy Maching (H)	1.59 (0.44-2.54)	0.72 (0.20-1.15)	0.52 (0.14-0.83)	0.43 (0.12-0.69)	0.38 (0.11-0.6)	0.35 (0.1-0.54)	0.32 (0.09-0.51)	0.29 (0.08-0.46)	-
20	Heavy Maching (H)	2.14 (0.59-3.49)	0.97 (0.25-1.60)	0.71 (0.18-1.17)	0.58 (0.15-0.96)	0.5 (0.14-0.81)	0.46 (0.13-0.73)	0.42 (0.12-0.68)	0.38 (0.11-0.61)	0.34 (0.1-0.55)

Note: Remark: During round Insert application, in general, the ap should less than 25%IC. Otherwise, we suggest to us Kr=45 SNUE/SEET series insert.