



- Precision pressed insert.
- First choice for roughing operations, especially for steel and cast iron.

- first choice
- alternate choice

P	●	○	○	○
M	●	○	○	○
K	●	○	○	○
N	○	○	○	○
S	○	○	○	○
H	○	○	○	○

■ RDMW/-T

catalogue number	D	S	hm	TN2510	TN6540	TN7525	TN7535
RDMW0802M0	8,00	2,38	0,09	2012564	-	-	-
RDMW0802M0T	8,00	2,38	0,09	-	3353278	-	2020727

Copy Mills

Recommended Starting Speeds

■ Recommended Starting Speeds [m/min]

Material Group		TN2510			TN6540			TN7525			TN7535		
P	1	660	<b>580</b>	540	360	<b>280</b>	240	410	<b>310</b>	280	545	<b>475</b>	445
	2	410	<b>370</b>	330	250	<b>190</b>	170	310	<b>250</b>	215	335	<b>305</b>	275
	3	370	<b>330</b>	305	215	<b>170</b>	140	280	<b>215</b>	185	305	<b>275</b>	245
	4	275	<b>260</b>	230	180	<b>130</b>	110	235	<b>170</b>	145	230	<b>210</b>	190
	5	330	<b>300</b>	275	240	<b>180</b>	150	310	<b>235</b>	200	310	<b>275</b>	250
	6	230	<b>205</b>	175	160	<b>120</b>	100	205	<b>160</b>	130	190	<b>160</b>	130
M	1	270	<b>240</b>	210	130	<b>80</b>	60	245	<b>220</b>	185	245	<b>220</b>	185
	2	245	<b>210</b>	190	80	<b>50</b>	40	220	<b>190</b>	170	220	<b>190</b>	170
	3	190	<b>175</b>	150	85	<b>50</b>	40	175	<b>155</b>	140	175	<b>155</b>	140
K	1	420	<b>360</b>	300	220	<b>205</b>	180	380	<b>280</b>	240	355	<b>320</b>	290
	2	360	<b>300</b>	250	175	<b>155</b>	140	325	<b>240</b>	200	280	<b>250</b>	230
	3	300	<b>250</b>	200	155	<b>145</b>	125	240	<b>200</b>	170	235	<b>210</b>	190
N	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	50	<b>35</b>	30	-	-	-	-	-	-
	2	-	-	-	25	<b>20</b>	10	-	-	-	-	-	-
	3	-	-	-	70	<b>40</b>	30	-	-	-	-	-	-
	4	-	-	-	60	<b>30</b>	25	-	-	-	-	-	-
H	1	145	<b>110</b>	70	-	-	-	-	-	-	-	-	-
	2	145	<b>110</b>	70	-	-	-	-	-	-	-	-	-
	3	115	<b>80</b>	45	-	-	-	-	-	-	-	-	-

NOTE: FIRST choice starting speeds are in **bold** type.  
As the average chip thickness increases, the speed should be decreased.