



The Innovative Milling Cutter

New

Rich Mill Series #1 - RM8



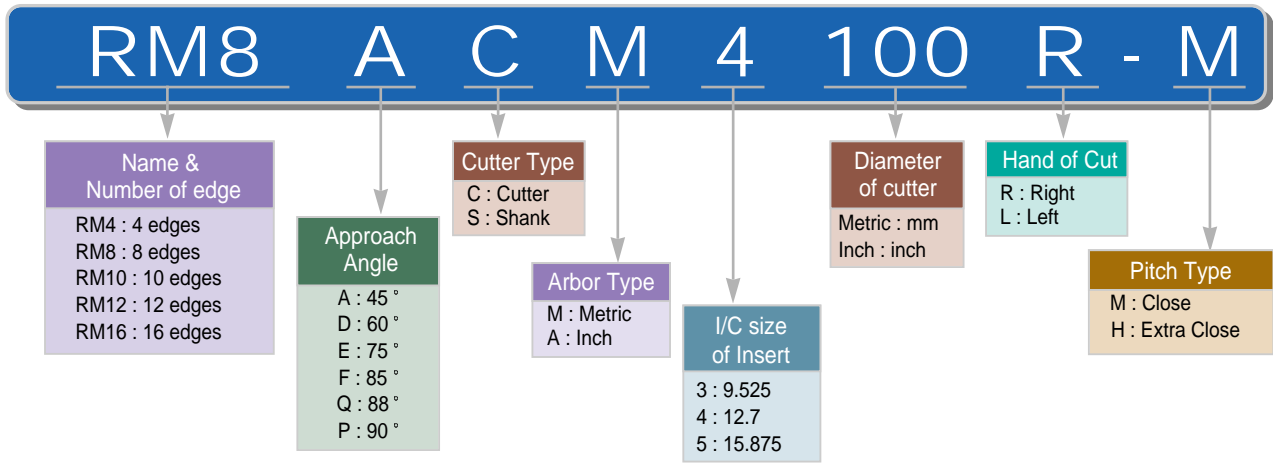
Rich Mill Series #1 - RM8

- Innovative double-sided high rake angle insert makes it possible to use 8 cutting edges per a milling insert.
- Smooth cutting with low cutting load that has been acquired from the unique geometry & high rake angle of cutting edge guarantees excellent surface finish.
- In combination with the innovative geometries & the variety of grades provide wide coverage for milling application.
- Applicable for various workpiece not only Steel, Cast iron but Stainless Steel.

Rich Mill Series #1 - RM8

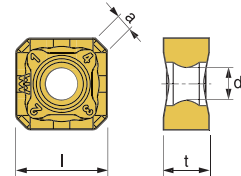
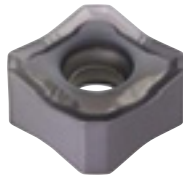


RM8 Code System



► Rich Mill Series : KORLOY's new generation milling tool for productive machining.



RM8 Insert



Designation	Grade							Dimensions (metric)			
	NCM325	PC3525	PC3535	PC9530	NCM310K	PC6510	H01	l	t	a	d ₁
SNMX1206ANN-MM	●	●	●	●	●	●	●	12.7	6.35	2.36	4.5
SNEX1206ANN-MM	●	●	●	●	●	●	●	12.7	6.35	2.36	4.5
SNMX1206ANN-MF	●	●	●	●	●	●	●	12.7	6.35	2.36	4.5
SNEX1206ANN-MF	●	●	●	●	●	●	●	12.7	6.35	2.36	4.5
SNEX1206ANN-MA							●	12.7	6.35	2.36	4.5

P M K N

Parts

Screw	 FTKA0410	Wrench	 TW15S
-------	--	--------	---

Clamping bolt for cutter

- Ø50~Ø125 → Hexagonal socket bolt
- Ø160~Ø250 → Mounting bolt for general face mill

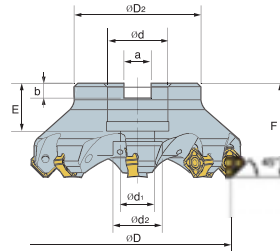
Through coolant system Ø50~Ø125

- Exclusive coolant bolt is adapted to get better chip evacuation and more powerful cooling
- To get optimal chip evacuation, the direction of coolant injection has designed to reach to each cutting edge directly. But, through coolant arbor is necessary
- * Exclusive coolant bolt is sold separately

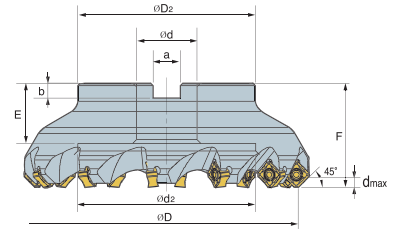
Rich Mill Series #1 - RM8



RM8 Cutter



ø50 mm ~ ø125 mm (with coolant)
ø2 inch ~ ø5 inch (with coolant)



Over ø160 mm
Over ø6 inch

RM8ACM4000

Designation	Stock		øD	øD ₂	ød	ød ₁	ød ₂	a	b	E	F	d _{max}	No. of tooth	Available arbor	
	R	L												RM8ACM	RM8AC
RM8ACM (RM8AC)	4050R-M	●	50	42	22	11	18	10.4	6.3	20	40	6.0	4	BT30/BT40/ BT50	BT30/BT40/ BT50
	4050R-H	●	50	42	22	11	18	10.4	6.3	20	40		6	FMC22	FMC22
	4063R-M	●	63	49	22	11	18	10.4	6.3	20	40		6		
	4063R-H	●	63	49	22	11	18	10.4	6.3	20	40		8		
4080R-M	●		80	57	27(25.4)	14	20	12.4(9.75)	7(6.0)	23(25)	50	7	BT40/BT50	BT30/BT40/BT50	
4080R-H	●		80	57	27(25.4)	14	20	12.4(9.75)	7(6.0)	23(25)	50	10	FMB/FMC27	FMA/FMB25.4	
4100R-M	●		100	67	32(31.75)	18	26	14.4(12.95)	8.0	25.5(33)	50(63)	8	BT40/BT50	BT40/BT50	
4100R-H	●		100	67	32(31.75)	18	26	14.4(12.95)	8.0	25.5(33)	50(63)	12	FMC32	FMA31.75	
4125R-M	●		125	87	40(38.1)	22	32	16.4(16.15)	9(10.0)	30(36)	63	10	BT40/BT50	BT40/BT50	
4125R-H	●		125	87	40(38.1)	22	32	16.4(16.15)	9(10.0)	30(36)	63	16		FMA/FMB38.1	
4160R-M	●		160	107	40(50.8)	-	107	16.4(19.25)	9(11.0)	32(38)	63	12	FMB/FMC40	BT50	
4160R-H	●		160	107	40(50.8)	-	107	16.4(19.25)	9(11.0)	32(38)	63	20		FMA50.8	
4200R-M	●		200	130	60(47.625)	-	135	25.7	14.0	32(38)	63	14	BT50	BT50	
4200R-H	●		200	130	60(47.625)	-	135	25.7	14.0	32(38)	63	24			FMA47.625
4250R-M	●		250	180	60(47.625)	-	180	25.7	14.0	32(38)	63	16	FMB60	BT50	
4250R-H	●		250	180	60(47.625)	-	180	25.7	14.0	32(38)	63	30			FMA47.625

* Data written inside of () is for RM8AC

RM8ACA4000

Designation	Stock		øD	øD ₂	ød	ød ₁	ød ₂	a	b	E	F	d _{max}	No. of tooth	Available arbor
	R	L												
RM8ACA	4200R-M		2.0(50.8)	1.772	0.75	0.413	0.63	0.313	0.22	0.787	1.75	0.236	4	CT40 531-192~194
	4200R-H		2.0(50.8)	1.772	0.75	0.413	0.63	0.313	0.22	0.787	1.75		6	CT50 531-208~214
	4250R-M		2.5(63.5)	2.205	1.00	0.551	0.827	0.375	0.248	0.866	1.75	0.236	6	CT40 531-196~198
	4250R-H		2.5(63.5)	2.205	1.00	0.551	0.827	0.375	0.248	0.866	1.75		8	
	4300R-M		3.0(76.2)	2.205	1.00	0.551	0.827	0.375	0.248	0.866	2.0	0.236	7	CT50 531-216~222
	4300R-H		3.0(76.2)	2.205	1.00	0.551	0.827	0.375	0.248	0.866	2.0		10	
	4400R-M		4.0(101.6)	2.874	1.25	0.709	1.024	0.5	0.319	0.866	2.0	0.236	8	CT40 531-200~202
	4400R-H		4.0(101.6)	2.874	1.25	0.709	1.024	0.5	0.319	0.866	2.0		12	
	4500R-M		5.0(127)	3.386	1.50	0.827	1.220	0.625	0.394	1.181	2.5	0.236	10	CT40 531-204~206
	4500R-H		5.0(127)	3.386	1.50	0.827	1.220	0.625	0.394	1.181	2.5		16	
	4600R-M		6.0(152.4)	4.882	2.00	-	4.213	0.75	0.433	1.181	2.5	0.236	12	CT50 531-240~244
	4600R-H		6.0(152.4)	4.882	2.00	-	4.213	0.75	0.433	1.181	2.5		20	
	4800R-M		8.0(203.2)	5.118	2.50	-	5.315	1.0	0.551	1.496	2.5	0.236	14	NMTB50 534-152
	4800R-H		8.0(203.2)	5.118	2.50	-	5.315	1.0	0.551	1.496	2.5		24	
	41000R-M		10.0(254.0)	7.087	2.50	-	7.087	1.0	0.551	1.496	2.5	0.236	16	
	41000R-H		10.0(254.0)	7.087	2.50	-	7.087	1.0	0.551	1.496	2.5		30	

Rich Mill Series #1 - RM8



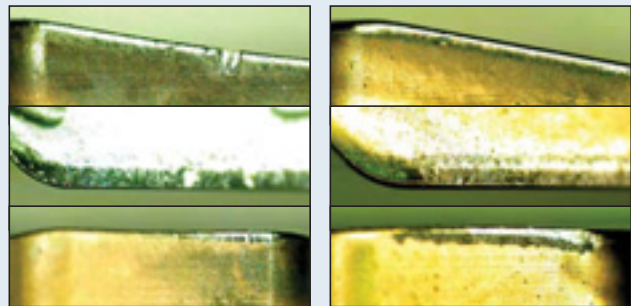
Recommended cutting condition

ISO	Grade	SNM(E)X1206ANN-MM				SNM(E)X1206ANN-MF			
		V(m/min)	V(sfm)	fz(mm/tooth)	fz(ipf)	V(m/min)	V(sfm)	fz(mm/tooth)	fz(ipf)
P	NCM325	150~300	500~990	0.10~0.35	0.004~0.014	200~300	660~990	0.05~0.30	0.002~0.012
	PC3525	150~300	500~990	0.10~0.35	0.004~0.014	200~300	660~990	0.05~0.30	0.002~0.012
	PC3535	120~250	400~830	0.10~0.35	0.004~0.014	150~250	500~830	0.05~0.30	0.002~0.012
M	PC9530	120~180	400~590	0.10~0.35	0.004~0.014	100~180	330~590	0.05~0.30	0.002~0.012
K	NCM310K	180~300	590~990	0.10~0.40	0.004~0.016	180~300	590~990	0.08~0.35	0.003~0.014
	PC6510	150~300	500~990	0.10~0.40	0.004~0.016	150~300	500~990	0.08~0.35	0.003~0.014

Application example

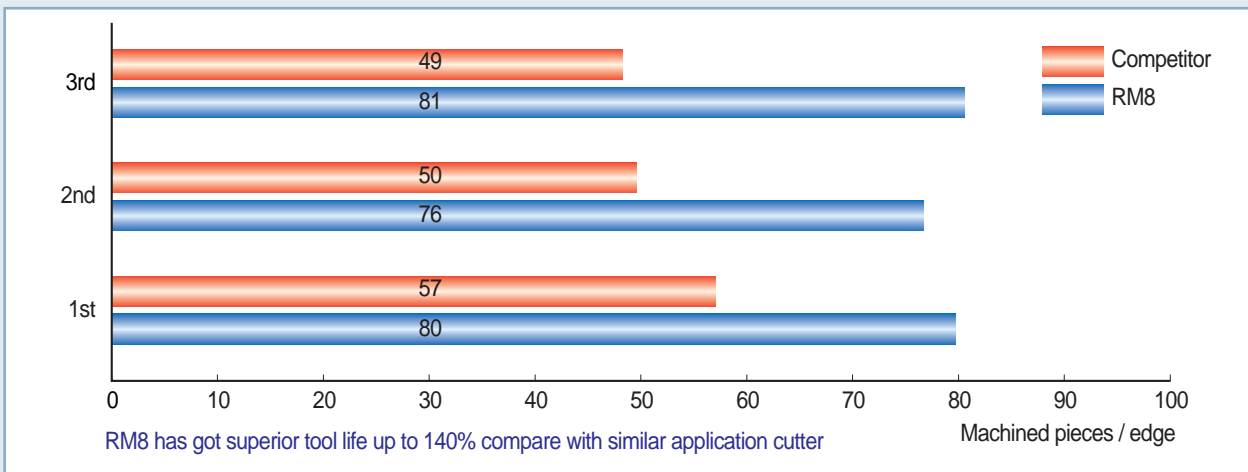
● Cutting Condition

- Cutter : RM8ACM4160R-H
- Insert : SNMX1206ANN-MM(PC6510)
- Workpiece : Diesel engine part (Ductile cast iron)
- Cutting speed : 196 m/min (640 sfm)
- Feed rate : 0.21 mm/tooth (0.008 ipf)
- Depth of cut : 3.0 mm (0.12 inch)
- Machine : MCT



Competitor

Korloy



■ Safety note

- Please wear safety gloves and shoes because the end of edge is shape.
- Please use safety glasses, face cover and other protection equipment as breakage of tool and danger of scattering in case of wrong use condition.
- Please make suitable tool replacement because tool is damaged by serious load and wear.
- When you handle hot and acute chips, please wear safety gloves after stop the engine.
- Please make fire prevention countermeasure because fire can break out when use straight cutting oils.
- Please fix tightly so that workpiece not move.
- Please follow recommended cutting condition considering that insert fall off when high speed cutting.
- Please consult with our specialists if there is inquiry item for product.