

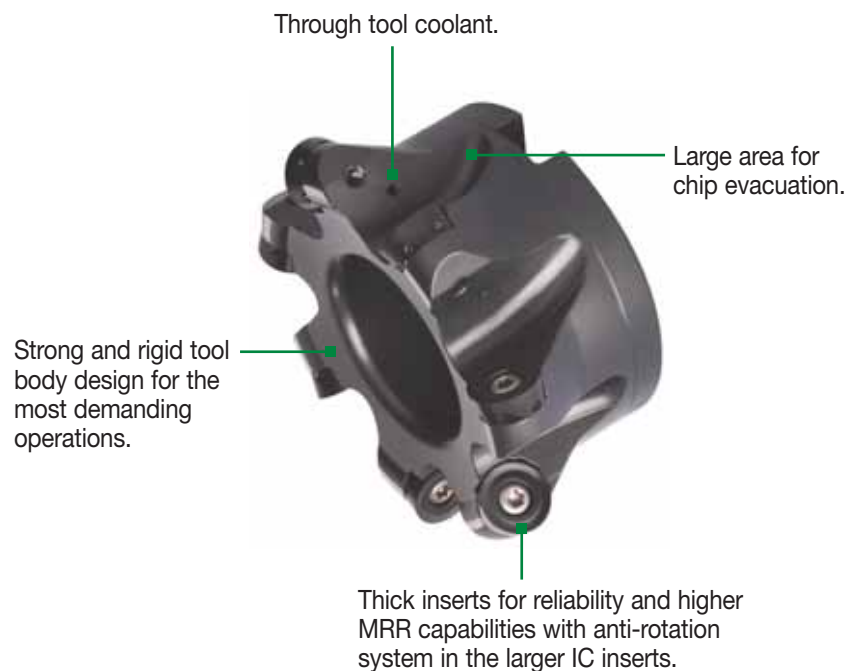
Versatile Platform for All Materials and Applications • **M100 Series** Copy Mills

A trusted multi-purpose solution for profiling and copy applications, the M100 Series ensures a reliable platform for all of your copy milling, face milling, helical interpolation, and roughing needs, even in your most demanding operations.

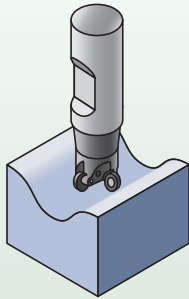


M100

- Thick inserts ensure reliability and consistent results.
- Anti-rotation systems in larger IC inserts provide higher MRR capabilities.
- Increased chip evacuation and through tool coolant for enhanced performance.



Copy Mills



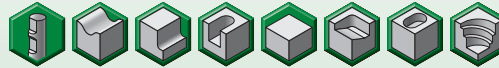
M100 RD0802..

Max depth of cut:
4,0mm

Diameter: 12mm–16mm

Pages: A182–A184

P
M
K
N
S
H



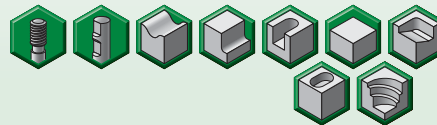
M100 RD1003..

Max depth of cut:
5,0mm

Diameter: 20mm–30mm

Pages: A186–A189

P
M
K
N
S
H



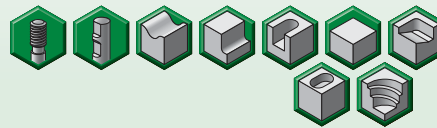
M100 RD1204..

Max depth of cut:
6,0mm

Diameter: 24mm–125mm

Pages: A190–A195

P
M
K
N
S
H



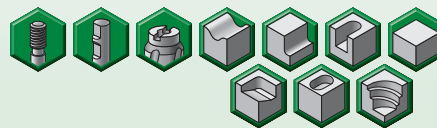
M100 RD1605..

Max depth of cut:
8,0mm

Diameter: 32mm–125mm

Pages: A196–A199

P
M
K
N
S
H



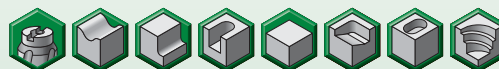
M100 RC1606..

Max depth of cut:
8,0mm

Diameter: 50mm–200mm

Pages: A200–A203

P
M
K
N
S
H



Insert Geometry		Recommended Use
	M0T	Positive geometry for lower cutting forces. First choice for general machining and stainless steel/high-temp alloys.
	ML/M0	First choice for light machining.
	M0T	PSTS insert. First choice for roughing operations.
	MH	Precision insert. Alternate choice for stable milling operations.

Insert Geometry		Recommended Use
	M0TX	Positive geometry for lower cutting forces. First choice for general machining and stainless steel/high-temp alloys.
	ML	First choice for light machining.
	M0TX	PSTS insert. First choice for roughing operations.
	MH	Precision insert. Alternate choice for stable milling operations.

Insert Geometry		Recommended Use
	M0TX	Positive geometry for lower cutting forces. First choice for general machining and stainless steel/high-temp alloys.
	M0TX	PSTS insert. First choice for roughing operations.

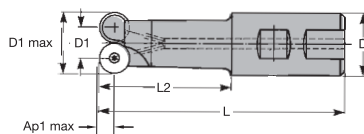
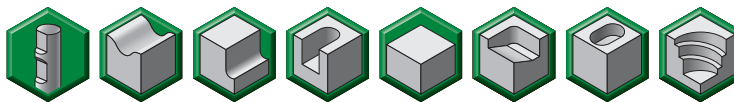
Insert Geometry		Recommended Use
	43	Optimisation geometry providing excellent chip control, even in low depth of cut applications. First choice for steel applications.
	M0TX	First choice for general machining.

Copy Mills • M100 Series

M100 Tool Bodies • RD0802..



- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.

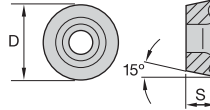


■ M100

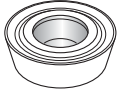
order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021331	12391010000	12	4	16	90	42	4,0	1	2.0°	33000	Yes	0,1
2021332	12391010400	12	4	16	130	82	4,0	1	2.0°	33000	Yes	0,1
2021333	12391010600	16	8	16	90	42	4,0	2	7.5°	28000	Yes	0,1
2021334	12391011000	16	8	20	132	82	4,0	2	7.5°	28000	Yes	0,2
2021335	12391011400	16	8	25	183	127	4,0	2	7.5°	28000	Yes	0,4

■ M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
12	12148001300	3,0	12148086600
16	12148001300	3,0	12148086600



RDMT-M0T

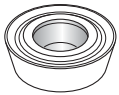


- first choice
- alternate choice

P	●	●
M	○	○
K	○	○
N	○	○
S	○	○
H	○	○

catalogue number	D	S	hm	TN7525	TN7535
RDMT0802M0T	8,00	2,38	0,09	●	●

RDHT-M0T

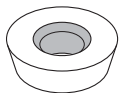


- first choice
- alternate choice

P	●	●
M	○	○
K	○	○
N	○	○
S	○	○
H	○	○

catalogue number	D	S	hm	TN7525
RDHT0802M0T	8,00	2,38	0,09	●

RDHW-ML

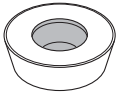


- first choice
- alternate choice

P	●	○
M	○	○
K	○	○
N	○	○
S	○	○
H	○	○

catalogue number	D	S	hm	TN2510
RDHW0802M0ML	8,00	2,38	0,08	●

RDMW-M0/-M0T

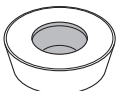


- first choice
- alternate choice

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

catalogue number	D	S	hm	TN2510	TN6540	TN7535	THM
RDMW0802M0	8,00	2,38	0,09	●	○	○	○
RDMW0802M0T	8,00	2,38	0,09	○	●	●	●

RDHW-MH



- first choice
- alternate choice

P	○	○
M	○	○
K	○	○
N	○	○
S	○	○
H	○	○

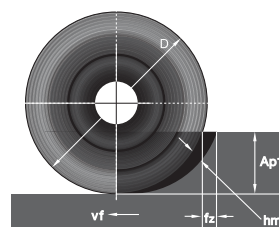
catalogue number	D	S	hm	TN2510
RDHW0802M0MH	8,00	2,38	0,09	●

Copy Mills • M100 Series

M100 Cutting Data • RD0802..



		TN2510			TN6540			TN7525			TN7535			THM		
Edge Geometry		feed per tooth fz (mm)														
..ML/MO		0,06	0,10	0,12												
..MOT		0,06	0,12	0,16	0,09	0,17	0,22	0,06	0,12	0,16	0,08	0,15	0,20	0,08	0,15	0,20
..MH		0,06	0,12	0,16												
Material Group		vc (m/min)														
P	1	390	290	250	290	220	190	410	320	280	360	280	240			
	2	260	200	180	200	150	130	290	220	190	250	190	165			
	3	220	180	140	170	130	110	240	180	160	210	160	140			
	4	220	180	140	170	130	110	250	190	160	215	165	140			
	5	190	130	120	140	100	90	210	150	130	180	130	110			
	6	250	190	150	190	140	120	280	210	170	240	180	150			
	7	190	140	130	140	110	100	210	160	140	180	140	120			
	8	180	130	110	130	100	80	180	140	120	160	120	100			
	9	140	110	80	110	80	60	160	120	90	140	100	80			
	10	190	150	130	140	120	100	210	170	150	180	145	130			
	11	130	90	80	100	70	60	140	100	80	120	90	70			
	12	240	220	150	180	140	120	260	200	170	230	175	150			
	13.1	210	150	130	160	120	100	230	170	140	200	145	120			
13.2	110	80	70	80	60	50	120	90	70	100	75	60				
M	14.1				190	160	110	280	230	160	240	200	140			
	14.2				150	150	100	220	210	140	190	185	125			
	14.3				110	110	80	160	160	110	140	135	95			
	14.4				100	80	60	140	120	80	120	100	70			
K	15	460	340	280	—	—	—				—	—	—	160	120	100
	16	350	260	220	—	—	—				—	—	—	120	90	80
	17	390	280	230	200	150	130				240	180	160	140	105	90
	18	280	170	140	170	130	110				200	160	130	100	70	50
	19	390	230	190	—	—	—				—	—	—	140	90	70
	20	310	190	160	—	—	—				—	—	—	110	70	50
N	21													900	600	500
	22													450	300	250
	23													900	600	500
	24													700	500	400
	25													450	280	200
	26													400	250	200
	27													340	210	160
	28													250	160	120
	29													500	350	200
	30													500	350	200
S	31				60	50	45							38	25	—
	32				50	40	35							30	20	—
	33				35	25	20							24	16	—
	34				30	20	15							20	13	—
	35				30	20	15							20	13	—
	36				80	50	40							80	40	—
	37				70	45	35							70	35	—
H	38.1															
	38.2															
	38.1															
	38.2															



First choice starting feed (fz) is in **bold** type. Use corresponding speed (vc).

Given fz is valid for face milling with width of cut (ae) ≥ 0,4 D1 and Ap1 max.

For smaller ae and ap, use the given correction factors (D = diameter of insert, D1 = cutter diameter).

		ae/D1			
Ap1/D		0,05	0,1	0,2	0,4
0,05		9	6,3	4,3	3,2
0,1		6,3	4,3	3,2	2,2
0,2		4,3	3,2	2,2	1,6
0,4		3,2	2,2	1,6	1,1

vc-factor at fz-factor							
Factor fz	9	6,3	4,3	3,2	2,2	1,6	1,1
Factor vc	1,6	1,5	1,4	1,3	1,2	1,1	1
Example: ae/D1 = 0,1; Ap1/D = 0,2							
fz nom = 0,22 fz eff = 0,22 x 3,2 = 0,7mm							
vc nom = 160 vc eff = 160 x 1,3 = 208 m/min							

WIN WITH WIDIA™

WIDIA 



WIDIA M100 Copy Mill Series

M100 RD0802.. | M100 RD1003.. | M100 RD1204..

M100 RD1605.. | M100 RC1606..

The strong and rigid tool body design of the M100 Series Copy Mills ensures superior performance in even the most demanding copy milling, face milling, helical interpolation, and roughing operations.

- Thick inserts for reliable and consistent results.
- Improved MRR capabilities and increased chip evacuation.
- Reliable and stable platform across many applications.

To learn more about our innovations, contact your local Authorised Distributor or visit www.widia.com.

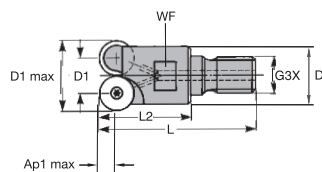
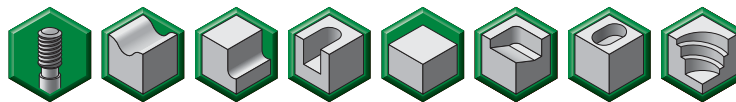
WIDIA 

Copy Mills • M100 Series

M100 Tool Bodies • RD1003..



- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.

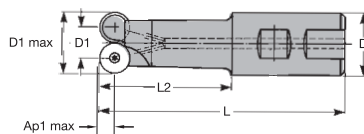
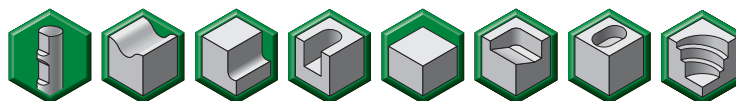


■ M100

order number	catalogue number	D1 max	D1	D	G3X	L	L2	WF	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021375	12391050400	25	15	22	M12	52	30	19	5,0	2	15.8°	22000	Yes	0,1
2021376	12391050600	30	20	28	M16	63	40	22	5,0	3	10.3°	20000	Yes	0,2

■ M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
25	12148036700	3,0	12148000600
30	12148036700	3,0	12148000600



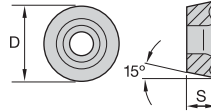
■ M100

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021336	12391011600	20	10	20	92	42	5,0	2	7.8°	25000	Yes	0,2
2021337	12391012000	20	10	25	138	82	5,0	2	8.8°	25000	Yes	0,4
2021338	12391012400	20	10	25	183	127	5,0	2	7.5°	25000	Yes	0,5
2021339	12391012800	26	16	32	142	82	5,0	2	13.5°	22000	Yes	0,6
2021340	12391013200	26	16	32	187	127	5,0	2	14.3°	22000	Yes	0,9

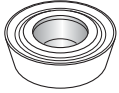
■ M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
20	12148036700	3,0	12148000600
26	12148036700	3,0	12148000600





■ RDMT-M0T

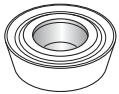


- first choice
- alternate choice

P	●	●	●	●	●
M	○	○	○	○	○
K	○	○	○	○	○
N	○	○	○	○	○
S	○	○	○	○	○
H	○	○	○	○	○
	TN6525	TN6540	TN7525	TN7535	TTM
	●	●	●	●	●

catalogue number	D	S	hm	
RDMT1003M0T	10,00	3,18	0,14	●

■ RDHT-M0T

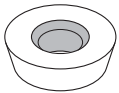


- first choice
- alternate choice

P	●	●	○
M	○	○	○
K	○	○	○
N	○	○	○
S	○	○	○
H	○	○	○
	TN7525	TTM	
	●	●	

catalogue number	D	S	hm	
RDHT1003M0T	10,00	3,18	0,14	●

■ RDHW-ML

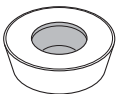


- first choice
- alternate choice

P	○	○	○
M	○	○	○
K	○	○	○
N	○	○	○
S	○	○	○
H	○	○	○
	TN2510		
	●		

catalogue number	D	S	hm	
RDHW1003M0ML	10,00	3,18	0,08	●

■ RDMW-M0/-M0T

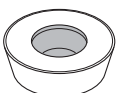


- first choice
- alternate choice

P	○	○	○	○	○
M	○	○	○	○	○
K	○	○	○	○	○
N	○	○	○	○	○
S	○	○	○	○	○
H	○	○	○	○	○
	TN2510	TN5515	TN6540	TN7525	TN7535
	●	●	●	●	●
				TT125	TTM

catalogue number	D	S	hm	
RDMW1003M0	10,00	3,18	0,09	●
RDMW1003M0T	10,00	3,18	0,14	●

■ RDHW-MH



- first choice
- alternate choice

P	○	○	○
M	○	○	○
K	○	○	○
N	○	○	○
S	○	○	○
H	○	○	○
	TN2510		
	●		

catalogue number	D	S	hm	
RDHW1003M0MH	10,00	3,18	0,14	●

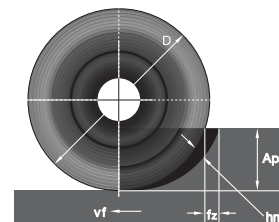
Copy Mills • M100 Series

M100 Cutting Data • RD1003..



		TN2510			TN5515			TN6525			TN6540			TN7525		
Edge Geometry		feed per tooth fz (mm)														
..ML		0,06	0,10	0,12												
..MO		0,06	0,10	0,12	0,06	0,12	0,16									
..MOT		0,06	0,12	0,16	0,08	0,15	0,20	0,07	0,12	0,17	0,09	0,17	0,22	0,06	0,12	0,16
..MH		0,06	0,12	0,16												
Material Group		vc (m/min)														
P	1	390	290	250				350	260	230	290	220	190	410	320	280
	2	260	200	180				240	180	160	200	150	130	290	220	190
	3	220	180	140				200	160	130	170	130	110	240	180	160
	4	220	180	140				200	160	130	170	130	110	250	190	160
	5	190	130	120				170	120	110	140	100	90	210	150	130
	6	250	190	150				230	170	140	190	140	120	280	210	170
	7	190	140	130				170	130	120	140	110	100	210	160	140
	8	180	130	110				160	120	100	130	100	80	180	140	120
	9	140	110	80				130	100	70	110	80	60	160	120	90
	10	190	150	130				170	140	120	140	120	100	210	170	150
	11	130	90	80				120	80	70	100	70	60	140	100	80
	12	240	220	150				220	170	140	180	140	120	260	200	170
	13.1	210	150	130				190	140	120	160	120	100	230	170	140
	13.2	110	80	70				100	70	60	80	60	50	120	90	70
M	14.1							230	190	130	190	160	110	280	230	160
	14.2							180	180	120	150	150	100	220	210	140
	14.3							130	130	100	110	110	80	160	160	110
	14.4							120	100	70	100	80	60	140	120	80
K	15	460	340	280	380	280	235	—	—	—	—	—	—			
	16	350	260	220	290	215	185	—	—	—	—	—	—			
	17	390	280	230	325	235	195	240	180	160	200	150	130			
	18	280	170	140	235	145	120	200	160	130	170	130	110			
	19	390	230	190	325	195	160	—	—	—	—	—	—			
	20	310	190	160	260	160	130	—	—	—	—	—	—			
N	21															
	22															
	23															
	24															
	25															
	26															
	27															
	28															
	29															
	30															
S	31										60	50	45			
	32										50	40	35			
	33										35	25	20			
	34										30	20	15			
	35										30	20	15			
	36										80	50	40			
	37										70	45	35			
H	38.1	290	240	200												
	38.2	240	200	160												
	39.1	180	150	120												
	39.2	120	100	70												

First choice starting feed (fz) is in **bold** type. Use corresponding speed (vc). **Given fz is valid for face milling with width of cut (ae) ≥ 0,4 D1 and Ap1 max.** For smaller ae and ap, use the given correction factors (D = diameter of insert, D1 = cutter diameter).



TN7535			TT125			THM			TTM			Edge Geometry	
feed per tooth fz (mm)													
												..ML	
												..MO	
0,08	0,15	0,20	0,08	0,13	0,16	0,08	0,15	0,20	0,08	0,15	0,20	..MOT	
												..MH	
vc (m/min)												Material Group	
360	280	240	450	345	300				320	195	180	1	P
250	190	165	380	280	240				160	130	120	2	
210	160	140	310	235	200				130	100	90	3	
215	165	140	350	260	220				140	110	100	4	
180	130	110	—	—	—				110	90	70	5	
240	180	150	380	280	240				160	130	120	6	
180	140	120	310	220	190				120	100	90	7	
160	120	100	250	175	150				100	80	65	8	
140	100	80	—	—	—				90	60	45	9	
180	145	130	360	265	220				140	110	100	10	
120	90	70	—	—	—				90	60	45	11	
230	175	150	350	260	220				150	120	110	12	
200	145	120	300	230	200				130	100	90	13.1	
100	75	60	150	115	100				65	50	45	13.2	
240	200	140	350	300	230				120	100	80	14.1	M
190	185	125	270	240	190				100	90	60	14.2	
140	135	95	220	180	140				85	70	50	14.3	
120	100	70	180	150	115				60	50	40	14.4	
—	—	—				160	120	100	—	—	—	15	K
—	—	—				120	90	80	—	—	—	16	
240	180	160				140	105	90	160	120	100	17	
200	160	130				100	70	50	140	100	90	18	
—	—	—				140	90	70	—	—	—	19	
—	—	—				110	70	50	—	—	—	20	
						900	600	500				21	N
						450	300	250				22	
						900	600	500				23	
						700	500	400				24	
						450	280	200				25	
						400	250	200				26	
						340	210	160				27	
						250	160	120				28	
						500	350	200				29	
						500	350	200				30	
						38	25	—				31	S
						30	20	—				32	
						24	16	—				33	
						20	13	—				34	
						20	13	—				35	
						80	40	—				36	
						70	35	—				37	
												38.1	H
												38.2	
												39.1	
												39.2	

Ap1/D	ae/D1			
	0,05	0,1	0,2	0,4
0,05	9	6,3	4,3	3,2
0,1	6,3	4,3	3,2	2,2
0,2	4,3	3,2	2,2	1,6
0,4	3,2	2,2	1,6	1,1

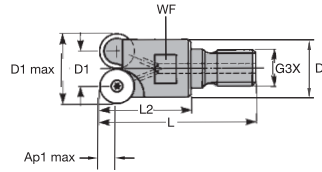
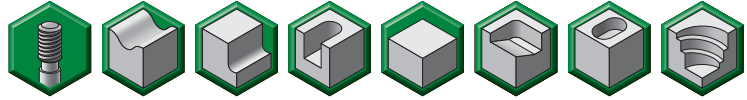
vc-factor at fz-factor							
Factor fz	9	6,3	4,3	3,2	2,2	1,6	1,1
Factor vc	1,6	1,5	1,4	1,3	1,2	1,1	1
Example: ae/D1 = 0,1; Ap1/D = 0,2							
fz nom = 0,22 fz eff = 0,22 x 3,2 = 0,7mm							
vc nom = 160 vc eff = 160 x 1,3 = 208 m/min							

Copy Mills • M100 Series

M100 Tool Bodies • RD1204..



- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.
- Anti-rotation feature for top security.



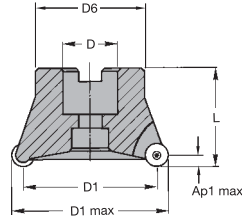
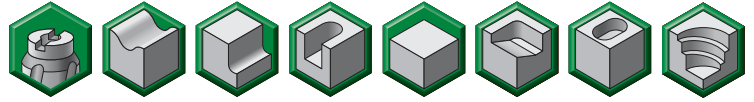
■ M100

order number	catalogue number	D1 max	D1	D	G3X	L	L2	WF	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021374	12391050200	24	12	22	M12	52	30	19	6,0	2	10.0°	23000	Yes	0,1
2021378	12391051000	35	23	28	M16	63	40	22	6,0	3	10.8°	19000	Yes	0,2
2021379	12391051200	40	28	28	M16	63	40	22	6,0	4	8.3°	17000	Yes	0,3

■ M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
24	12148038800	3,0	12148000600
35	12148038800	3,0	12148000600
40	12148038800	3,0	12148000600

- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.
- Anti-rotation feature for top security.

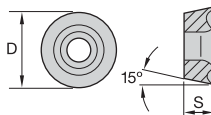


M100

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021342	12391020000	50	38	22	40	40	6,0	4	6.8°	15000	Yes	0,2
2021361	12391024000	52	40	22	40	40	6,0	4	6.5°	15000	No	0,2
2021343	12391020200	63	51	27	48	40	6,0	5	4.5°	14000	Yes	0,3
2021344	12391020400	80	68	27	60	50	6,0	6	3.5°	12000	Yes	0,9
2021345	12391020600	100	88	32	78	50	6,0	6	2.5°	11000	No	1,2
2021346	12391020800	125	113	40	89	50	6,0	7	2.0°	10000	No	1,7

M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
50	12148038800	3,0	12148000600
52	12148038800	3,0	12148000600
63	12148038800	3,0	12148000600
80	12148038800	3,0	12148000600
100	12148038800	3,0	12148000600
125	12148038800	3,0	12148000600



■ RDMT-M0TX



- first choice
- alternate choice

P	●	○	●	●	●	●	●	●
M	●	○	●	○	○	○	○	○
K	●	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○
H	●	○	○	○	○	○	○	○
TN2510	●	○	○	○	○	○	○	○
TN6525	●	○	○	○	○	○	○	○
TN6540	●	○	○	○	○	○	○	○
TN7525	●	○	○	○	○	○	○	○
TN7535	●	○	○	○	○	○	○	○
THM	●	○	○	○	○	○	○	○
TTM	●	○	○	○	○	○	○	○

catalogue number	D	S	hm	
RDMT1204M0TX	12,00	4,76	0,15	●

■ RDHT-M0TX

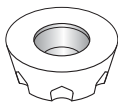


- first choice
- alternate choice

P	●	○	●	●	●	●	●	●
M	●	○	○	○	○	○	○	○
K	●	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○
H	●	○	○	○	○	○	○	○
TN5515	●	○	○	○	○	○	○	○
TN7525	●	○	○	○	○	○	○	○
TTI25	●	○	○	○	○	○	○	○

catalogue number	D	S	hm	
RDHT1204M0TX	12,00	4,76	0,12	●

■ RDHW-ML

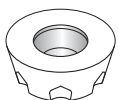


- first choice
- alternate choice

P	●	○	●	●	●	●	●	●
M	●	○	○	○	○	○	○	○
K	●	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○
H	●	○	○	○	○	○	○	○
TN2510	●	○	○	○	○	○	○	○

catalogue number	D	S	hm	
RDHW1204M0ML	12,00	4,76	0,10	●

■ RDMW-M0TX

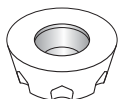


- first choice
- alternate choice

P	●	○	●	●	●	●	●	●
M	●	○	○	○	○	○	○	○
K	●	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○
H	●	○	○	○	○	○	○	○
TN2510	●	○	○	○	○	○	○	○
TN5515	●	○	○	○	○	○	○	○
TN6540	●	○	○	○	○	○	○	○
TN7525	●	○	○	○	○	○	○	○
TN7535	●	○	○	○	○	○	○	○
TTM	●	○	○	○	○	○	○	○

catalogue number	D	S	hm	
RDMW1204M0TX	12,00	4,76	0,15	●

■ RDHW-MH



- first choice
- alternate choice

P	●	○	●	●	●	●	●	●
M	●	○	○	○	○	○	○	○
K	●	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○
H	●	○	○	○	○	○	○	○
TN2510	●	○	○	○	○	○	○	○

catalogue number	D	S	hm	
RDHW1204M0MH	12,00	4,76	0,14	●

Sustainable Engineering

Environmental Responsibility

We are deeply committed to designing and manufacturing environmentally responsible products that deliver high performance and proven value. With decades of experience in tooling and manufacturing, and the synergies of superior engineering, leading technology, and customised solutions, we offer some of the most effective opportunities for sustainable manufacturing in the industry. Our comprehensive range of products and excellent customer service make us your complete supplier of sustainable tooling solutions.

Sustainable Engineering

Leading the way with innovation, engineering, and service in standard and custom tooling — a proven methodology and partnership.

Successful project engineering requires planning, teamwork, and disciplined execution. Through our extensive experience in developing and implementing new project engineering strategies, we have pioneered a proven methodology to help you manufacture new products and bring them to market quickly. Service deliverables are carefully outlined and jointly agreed to before the project begins. We formally evaluate progress and results with you throughout the project through our stage-gate management systems.

We can provide your engineering teams and machine tool builders with process engineering support, advanced metalcutting technologies, and project management expertise to help you achieve your sustainability goals. With our best-in-class process, you will experience accelerated time-to-market, lower overall costs, and reduced risks to implement new technologies.



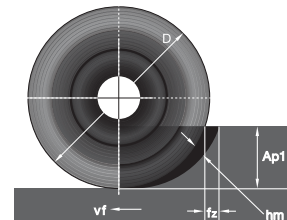
Copy Mills • M100 Series

M100 Cutting Data • RD1204..



		TN2510			TN5515			TN6525			TN6540			TN7525		
Edge Geometry		feed per tooth fz (mm)														
..ML		0,08	0,14	0,16												
..MOTX		0,08	0,18	0,24	0,10	0,22	0,30	0,08	0,18	0,25	0,11	0,24	0,33	0,08	0,18	0,24
..MH		0,08	0,18	0,24												
Material Group		vc (m/min)														
P	1	390	290	250				350	260	230	290	220	190	410	320	280
	2	260	200	180				240	180	160	200	150	130	290	220	190
	3	220	180	140				200	160	130	170	130	110	240	180	160
	4	220	180	140				200	160	130	170	130	110	250	190	160
	5	190	130	120				170	120	110	140	100	90	210	150	130
	6	250	190	150				230	170	140	190	140	120	280	210	170
	7	190	140	130				170	130	120	140	110	100	210	160	140
	8	180	130	110				160	120	100	130	100	80	180	140	120
	9	140	110	80				130	100	70	110	80	60	160	120	90
	10	190	150	130				170	140	120	140	120	100	210	170	150
	11	130	90	80				120	80	70	100	70	60	140	100	80
	12	240	220	150				220	170	140	180	140	120	260	200	170
	13.1	210	150	130				190	140	120	160	120	100	230	170	140
13.2	110	80	70				100	70	60	80	60	50	120	90	70	
M	14.1							230	190	130	190	160	110	280	230	160
	14.2							180	180	120	150	150	100	220	210	140
	14.3							130	130	100	110	110	80	160	160	110
	14.4							120	100	70	100	80	60	140	120	80
K	15	460	340	280	380	280	235	—	—	—	—	—	—			
	16	350	260	220	290	215	185	—	—	—	—	—	—			
	17	390	280	230	325	235	195	240	180	160	200	150	130			
	18	280	170	140	235	145	120	200	160	130	170	130	110			
	19	390	230	190	325	195	160	—	—	—	—	—	—			
	20	310	190	160	260	160	130	—	—	—	—	—	—			
N	21															
	22															
	23															
	24															
	25															
	26															
	27															
	28															
	29															
	30															
S	31										60	50	45			
	32										50	40	35			
	33										35	25	20			
	34										30	20	15			
	35										30	20	15			
	36										80	50	40			
	37										70	45	35			
H	38.1	290	240	200												
	38.2	240	200	160												
	39.1	180	150	120												
	39.2	120	100	70												

First choice starting feed (fz) is in **bold** type. Use corresponding speed (vc). **Given fz is valid for face milling with width of cut (ae) ≥ 0,4 D1 and Ap1 max.** For smaller ae and ap, use the given correction factors (D = diameter of insert, D1 = cutter diameter).



TN7535			TTI25			THM			TTM			Edge Geometry	
feed per tooth fz (mm)													
												..ML	
0,10	0,22	0,30	0,10	0,19	0,24	0,10	0,22	0,30	0,10	0,22	0,30	..MOTX	
												..MH	
vc (m/min)												Material Group	
360	280	240	450	345	300				320	195	180	1	P
250	190	165	380	280	240				160	130	120	2	
210	160	140	310	235	200				130	100	90	3	
215	165	140	350	260	220				140	110	100	4	
180	130	110	—	—	—				110	90	70	5	
240	180	150	380	280	240				160	130	120	6	
180	140	120	310	220	190				120	100	90	7	
160	120	100	250	175	150				100	80	65	8	
140	100	80	—	—	—				90	60	45	9	
180	145	130	360	265	220				140	110	100	10	
120	90	70	—	—	—				90	60	45	11	
230	175	150	350	260	220				150	120	110	12	
200	145	120	300	230	200				130	100	90	13.1	
100	75	60	150	115	100				65	50	45	13.2	
240	200	140	350	300	230				120	100	80	14.1	M
190	185	125	270	240	190				100	90	60	14.2	
140	135	95	220	180	140				85	70	50	14.3	
120	100	70	180	150	115				60	50	40	14.4	
—	—	—				160	120	100	—	—	—	15	K
—	—	—				120	90	80	—	—	—	16	
240	180	160				140	105	90	160	120	100	17	
200	160	130				100	70	50	140	100	90	18	
—	—	—				140	90	70	—	—	—	19	
—	—	—				110	70	50	—	—	—	20	
						900	600	500				21	N
						450	300	250				22	
						900	600	500				23	
						700	500	400				24	
						450	280	200				25	
						400	250	200				26	
						340	210	160				27	
						250	160	120				28	
						500	350	200				29	
						500	350	200				30	
						38	25	—				31	S
						30	20	—				32	
						24	16	—				33	
						20	13	—				34	
						20	13	—				35	
						80	40	—				36	
						70	35	—				37	
												38.1	H
												38.2	
												39.1	
												39.2	

Ap1/D	ae/D1			
	0,05	0,1	0,2	0,4
0,05	9	6,3	4,3	3,2
0,1	6,3	4,3	3,2	2,2
0,2	4,3	3,2	2,2	1,6
0,4	3,2	2,2	1,6	1,1

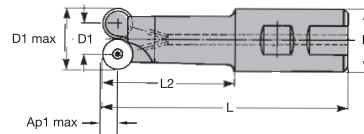
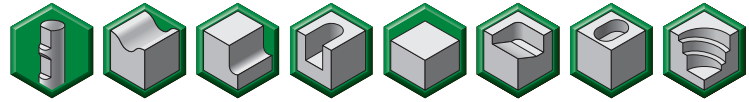
vc-factor at fz-factor							
Factor fz	9	6,3	4,3	3,2	2,2	1,6	1,1
Factor vc	1,6	1,5	1,4	1,3	1,2	1,1	1
Example: ae/D1 = 0,1; Ap1/D = 0,2							
fz nom = 0,22	fz eff = 0,22 x 3,2 = 0,7mm						
vc nom = 160	vc eff = 160 x 1,3 = 208 m/min						

Copy Mills • M100 Series

M100 Tool Bodies • RD1605..



- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.
- Anti-rotation feature for top security.

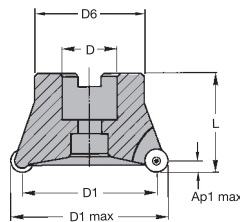
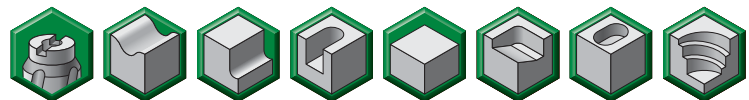


M100

order number	catalogue number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021341	12391013800	32	16	32	142	82	8,0	2	7.8°	19000	Yes	1,1

M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
32	12148007200	4,0	12148007500



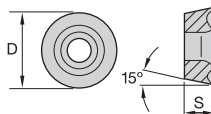
M100

order number	catalogue number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021347	12391021000	50	34	22	40	40	8,0	4	10.3°	13000	Yes	0,2
2021348	12391021200	63	47	27	48	40	8,0	4	7.0°	12000	Yes	0,3
2021349	12391021400	80	64	27	60	50	8,0	5	4.8°	10000	Yes	0,9
2021350	12391021600	100	84	32	78	50	8,0	6	3.8°	9000	No	1,2
2021351	12391021800	125	109	40	89	50	8,0	7	2.8°	8000	No	1,7

M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
50	12148007200	4,0	12148007500
63	12148007200	4,0	12148007500
80	12148007200	4,0	12148007500
100	12148007200	4,0	12148007500
125	12148007200	4,0	12148007500





■ **RDMT-M0TX**



- first choice
- alternate choice

P	●	○	●	●	●	●	●
M	●	○	●	○	○	○	○
K	●	○	○	○	○	○	○
N	○	○	○	○	○	○	○
S	○	○	○	○	○	○	○
H	○	○	○	○	○	○	○
	TN2510	TN6525	TN6540	TN7525	TN7535	THM	TTM

catalogue number	D	S	hm	
RDMT1605M0TX	16,00	5,56	0,18	●

■ **RDHT-M0TX**



- first choice
- alternate choice

P	●	○	○	○
M	○	○	○	○
K	○	○	○	○
N	○	○	○	○
S	○	○	○	○
H	○	○	○	○
	TT125			

catalogue number	D	S	hm	
RDHT1605M0TX	16,00	5,56	0,12	●

■ **RDMW-M0TX**



- first choice
- alternate choice

P	●	○	●	●	●	●	●
M	●	○	●	○	○	○	○
K	●	○	○	○	○	○	○
N	○	○	○	○	○	○	○
S	○	○	○	○	○	○	○
H	○	○	○	○	○	○	○
	TN2510	TN5515	TN6540	TN7525	TN7535	TTM	

catalogue number	D	S	hm	
RDMW1605M0TX	16,00	5,56	0,15	●

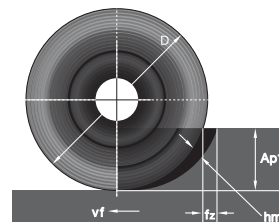
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M100 Cutting Data • RD1605..



		TN2510			TN5515			TN6525			TN6540			TN7525		
Edge Geometry		feed per tooth fz (mm)														
..ML		0,10	0,16	0,20												
..MOTX		0,10	0,21	0,29	0,12	0,26	0,36	0,10	0,21	0,30	0,13	0,29	0,40	0,10	0,21	0,29
..MH		0,10	0,21	0,29												
Material Group		vc (m/min)														
P	1	390	290	250				350	260	230	290	220	190	410	320	280
	2	260	200	180				240	180	160	200	150	130	290	220	190
	3	220	180	140				200	160	130	170	130	110	240	180	160
	4	220	180	140				200	160	130	170	130	110	250	190	160
	5	190	130	120				170	120	110	140	100	90	210	150	130
	6	250	190	150				230	170	140	190	140	120	280	210	170
	7	190	140	130				170	130	120	140	110	100	210	160	140
	8	180	130	110				160	120	100	130	100	80	180	140	120
	9	140	110	80				130	100	70	110	80	60	160	120	90
	10	190	150	130				170	140	120	140	120	100	210	170	150
	11	130	90	80				120	80	70	100	70	60	140	100	80
	12	240	220	150				220	170	140	180	140	120	260	200	170
	13.1	210	150	130				190	140	120	160	120	100	230	170	140
	13.2	110	80	70				100	70	60	80	60	50	120	90	70
M	14.1							230	190	130	190	160	110	280	230	160
	14.2							180	180	120	150	150	100	220	210	140
	14.3							130	130	100	110	110	80	160	160	110
	14.4							120	100	70	100	80	60	140	120	80
K	15	460	340	280	380	280	235	—	—	—	—	—	—			
	16	350	260	220	290	215	185	—	—	—	—	—	—			
	17	390	280	230	325	235	195	240	180	160	200	150	130			
	18	280	170	140	235	145	120	200	160	130	170	130	110			
	19	390	230	190	325	195	160	—	—	—	—	—	—			
	20	310	190	160	260	160	130	—	—	—	—	—	—			
N	21															
	22															
	23															
	24															
	25															
	26															
	27															
	28															
	29															
	30															
S	31										60	50	45			
	32										50	40	35			
	33										35	25	20			
	34										30	20	15			
	35										30	20	15			
	36										80	50	40			
	37										70	45	35			
H	38.1	290	240	200												
	38.2	240	200	160												
	39.1	180	150	120												
	39.2	120	100	70												

First choice starting feed (fz) is in **bold** type. Use corresponding speed (vc). **Given fz is valid for face milling with width of cut (ae) ≥ 0,4 D1 and Ap1 max.** For smaller ae and ap, use the given correction factors (D = diameter of insert, D1 = cutter diameter).



TN7535			Ti25			THM			TTM				
feed per tooth fz (mm)											Edge Geometry		
												..ML	
0,12	0,26	0,36	0,12	0,22	0,28	0,12	0,26	0,36	0,12	0,26	0,36	..MOTX	
												..MH	
vc (m/min)											Material Group		
360	280	240	450	345	300				320	195	180	1	P
250	190	165	380	280	240				160	130	120	2	
210	160	140	310	235	200				130	100	90	3	
215	165	140	350	260	220				140	110	100	4	
180	130	110	—	—	—				110	90	70	5	
240	180	150	380	280	240				160	130	120	6	
180	140	120	310	220	190				120	100	90	7	
160	120	100	250	175	150				100	80	65	8	
140	100	80	—	—	—				90	60	45	9	
180	145	130	360	265	220				140	110	100	10	
120	90	70	—	—	—				90	60	45	11	
230	175	150	350	260	220				150	120	110	12	
200	145	120	300	230	200				130	100	90	13.1	
100	75	60	150	115	100				65	50	45	13.2	
240	200	140	350	300	230				120	100	80	14.1	M
190	185	125	270	240	190				100	90	60	14.2	
140	135	95	220	180	140				85	70	50	14.3	
120	100	70	180	150	115				60	50	40	14.4	
—	—	—				160	120	100	—	—	—	15	K
—	—	—				120	90	80	—	—	—	16	
240	180	160				140	105	90	160	120	100	17	
200	160	130				100	70	50	140	100	90	18	
—	—	—				140	90	70	—	—	—	19	
—	—	—				110	70	50	—	—	—	20	
						900	600	500				21	N
						450	300	250				22	
						900	600	500				23	
						700	500	400				24	
						450	280	200				25	
						400	250	200				26	
						340	210	160				27	
						250	160	120				28	
						500	350	200				29	
						500	350	200				30	
						38	25	—				31	S
						30	20	—				32	
						24	16	—				33	
						20	13	—				34	
						20	13	—				35	
						80	40	—				36	
						70	35	—				37	
												38.1	H
												38.2	
												39.1	
												39.2	

Ap1/D	ae/D1			
	0,05	0,1	0,2	0,4
0,05	9	6,3	4,3	3,2
0,1	6,3	4,3	3,2	2,2
0,2	4,3	3,2	2,2	1,6
0,4	3,2	2,2	1,6	1,1

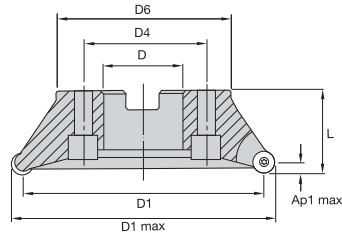
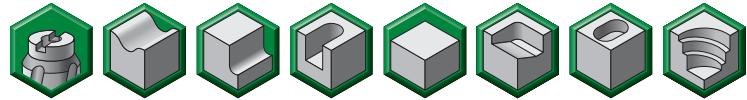
vc-factor at fz-factor							
Factor fz	9	6,3	4,3	3,2	2,2	1,6	1,1
Factor vc	1,6	1,5	1,4	1,3	1,2	1,1	1
Example: ae/D1 = 0,1; Ap1/D = 0,2							
fz nom = 0,22 fz eff = 0,22 x 3,2 = 0,7mm							
vc nom = 160 vc eff = 160 x 1,3 = 208 m/min							

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M100 Tool Bodies • RC1606..



- General-purpose face and copy milling.
- Excellent variety of grades and geometries available.
- Anti-rotation feature for top security.

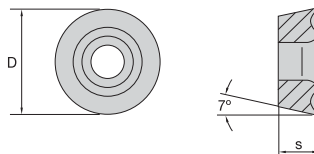


■ M100

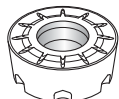
order number	catalogue number	D1 max	D1	D	D4	D6	L	Ap1 max	Z	max ramp angle	max RPM	coolant supply	kg
2021358	12391023400	50	34	22	—	40	40	8,0	4	6.0°	13000	Yes	0,2
2021359	12391023600	52	36	22	—	40	40	8,0	4	5.8°	13000	Yes	0,3
2021357	12391023200	63	47	27	—	48	40	8,0	5	4.0°	12000	Yes	0,2
2021360	12391023800	66	50	27	—	48	40	8,0	5	3.8°	12000	Yes	0,3
2021352	12391022000	80	64	27	—	60	50	8,0	6	2.8°	10000	Yes	0,9
2021353	12391022200	100	84	32	—	78	50	8,0	7	2.3°	9000	No	1,2
2021354	12391022400	125	109	40	—	89	50	8,0	8	1.8°	8000	No	1,8
2021355	12391022600	160	144	40	66,7	90	63	8,0	9	1.3°	7000	No	2,9
2021356	12391022800	200	184	60	101,6	130	63	8,0	11	.8°	6000	No	0,3

■ M100 • Spare Parts

D1 max	insert screw	Nm	Torx driver
50	12148007200	4,0	12148007500
52	12148007200	4,0	12148007500
63	12148007200	4,0	12148007500
66	12148007200	4,0	12148007500
80	12148007200	4,0	12148007500
100	12148007200	4,0	12148007500
125	12148007200	4,0	12148007500
160	12148007200	4,0	12148007500
200	12148007200	4,0	12148007500



■ **RCMT-43**

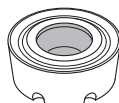


- first choice
- alternate choice

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

catalogue number	D	S	hm	TN515	TN6525	TN6540	TN7525	TN7535	THM
RCMT1606M043	16,00	6,35	0,20	●					●
RCMT1606M043M	16,00	6,35	0,20		●	●	●	●	

■ **RCMT-M0TX**



- first choice
- alternate choice

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

catalogue number	D	S	hm	TN2510	TN515	TN6525	TN6540	TN7525	TN7535
RCMT1606M0TX	16,00	6,35	0,24	●	●	●	●	●	●

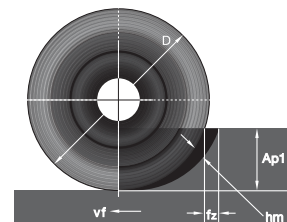
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M100 Cutting Data • RC1606..



		TN2510			TN5515			TN6525			TN6540		
Edge Geometry		feed per tooth fz (mm)											
..43		0,10	0,21	0,29	0,12	0,26	0,36	0,10	0,21	0,30	0,13	0,29	0,40
..MOTX		0,10	0,21	0,29	0,12	0,26	0,36						
Material Group		vc (m/min)											
P	1	390	290	250				350	260	230	290	220	190
	2	260	200	180				240	180	160	200	150	130
	3	220	180	140				200	160	130	170	130	110
	4	220	180	140				200	160	130	170	130	110
	5	190	130	120				170	120	110	140	100	90
	6	250	190	150				230	170	140	190	140	120
	7	190	140	130				170	130	120	140	110	100
	8	180	130	110				160	120	100	130	100	80
	9	140	110	80				130	100	70	110	80	60
	10	190	150	130				170	140	120	140	120	100
	11	130	90	80				120	80	70	100	70	60
	12	240	220	150				220	170	140	180	140	120
	13.1	210	150	130				190	140	120	160	120	100
	13.2	110	80	70				100	70	60	80	60	50
M	14.1							230	190	130	190	160	110
	14.2							180	180	120	150	150	100
	14.3							130	130	100	110	110	80
	14.4							120	100	70	100	80	60
K	15	460	340	280	380	280	235	—	—	—	—	—	—
	16	350	260	220	290	215	185	—	—	—	—	—	—
	17	390	280	230	325	235	195	240	180	160	200	150	130
	18	280	170	140	235	145	120	200	160	130	170	130	110
	19	390	230	190	325	195	160	—	—	—	—	—	—
	20	310	190	160	260	160	130	—	—	—	—	—	—
N	21												
	22												
	23												
	24												
	25												
	26												
	27												
	28												
	29												
	30												
S	31										60	50	45
	32										50	40	35
	33										35	25	20
	34										30	20	15
	35										30	20	15
	36										80	50	40
	37										70	45	35
H	38.1	290	240	200									
	38.2	240	200	160									
	39.1	180	150	120									
	39.2	120	100	70									

First choice starting feed (fz) is in **bold** type. Use corresponding speed (vc). **Given fz is valid for face milling with width of cut (ae) ≥ 0,4 D1 and Ap1 max.** For smaller ae and ap, use the given correction factors (D = diameter of insert, D1 = cutter diameter).



TN7525			TN7535			THM			Edge Geometry	
			feed per tooth fz (mm)						..43	
0,10	0,21	0,29	0,12	0,26	0,36				..MOTX	
0,10	0,21	0,29	0,12	0,26	0,36	0,12	0,26	0,36		
vc (m/min)									Material Group	
410	320	280	360	280	240				1	P
290	220	190	250	190	165				2	
240	180	160	210	160	140				3	
250	190	160	215	165	140				4	
210	150	130	180	130	110				5	
280	210	170	240	180	150				6	
210	160	140	180	140	120				7	
180	140	120	160	120	100				8	
160	120	90	140	100	80				9	
210	170	150	180	145	130				10	
140	100	80	120	90	70				11	
260	200	170	230	175	150				12	
230	170	140	200	145	120				13.1	
120	90	70	100	75	60				13.2	
280	230	160	240	200	140				14.1	M
220	210	140	190	185	125				14.2	
160	160	110	140	135	95				14.3	
140	120	80	120	100	70				14.4	
			—	—	—	160	120	100	15	K
			—	—	—	120	90	80	16	
			240	180	160	140	105	90	17	
			200	160	130	100	70	50	18	
			—	—	—	140	90	70	19	
			—	—	—	110	70	50	20	
						900	600	500	21	N
						450	300	250	22	
						900	600	500	23	
						700	500	400	24	
						450	280	200	25	
						400	250	200	26	
						340	210	160	27	
						250	160	120	28	
						500	350	200	29	
						500	350	200	30	
						38	25	—	31	S
						30	20	—	32	
						24	16	—	33	
						20	13	—	34	
						20	13	—	35	
						80	40	—	36	
						70	35	—	37	
									38.1	H
									38.2	
									39.1	
									39.2	

	ae/D1			
Ap1/D	0,05	0,1	0,2	0,4
0,05	9	6,3	4,3	3,2
0,1	6,3	4,3	3,2	2,2
0,2	4,3	3,2	2,2	1,6
0,4	3,2	2,2	1,6	1,1

vc-factor at fz-factor							
Factor fz	9	6,3	4,3	3,2	2,2	1,6	1,1
Factor vc	1,6	1,5	1,4	1,3	1,2	1,1	1
Example: ae/D1 = 0,1; Ap1/D = 0,2							
fz nom = 0,22 fz eff = 0,22 x 3,2 = 0,7mm							
vc nom = 160 vc eff = 160 x 1,3 = 208 m/min							