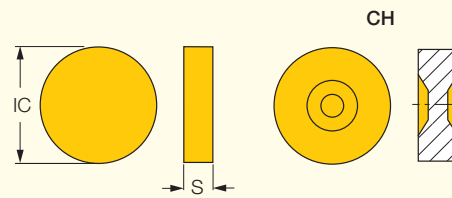


RNGN-Ceramic Round Double-Sided Ceramic Inserts



Designation	Dimensions		Tough ↔ Hard				
	IC	S	IN22	IN23	IS35	IS25	IW7
RNGN 120700E	12.70	7.94			•	•	•
RNGN 120700E-CH ⁽¹⁾	12.70	7.94			•	•	
RNGN 120700T	12.70	7.94	•	•	•	•	•
RNGN 120700T-CH ⁽¹⁾	12.70	7.94			•	•	
RNGN 120700TE	12.70	7.94			•	•	

⁽¹⁾ Insert with a dimple

Recommended ceramic grade and machining data for milling

ISO class DIN/ISO 513	Workpiece material		Grade	Cutting Speed and Feed		
	Description	ISCAR mat group		Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)	Coolant
P	Steel	1-13	IN23	300-600	0.05-0.15	Dry
K	Cast iron	15-18	IN22	700-1200	0.05-0.15	Dry
S	Ni or Co based high temperature alloys	33-35	IS35	400-1000	0.05-0.2	Dry
			IS25	600-1300	0.05-0.2	Dry
			IW7	1000-1500	0.05-0.2	Dry

*According to VDI 3323 standard.
Recommended range of depth of cut is 0.5-3 mm.

The attached table provides recommended machining data. For milling in unstable conditions the limit values in the table data should be reduced by 20-30%.

Edge preparation types

Type	Figure	Cutting Condition	
		Normal	Unfavorable
E		●	○
T		◐	◑
TE		○	●

- - Most recommended
- ◐ - Second choice
- - May be used