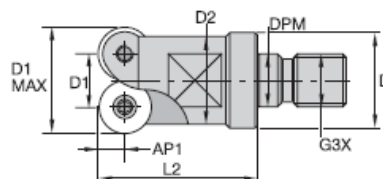


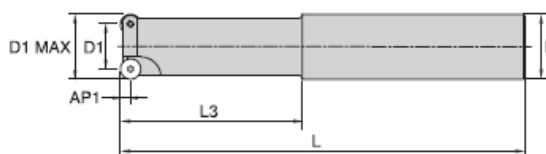
- Diameter range 20 mm to 42 mm
- Stable and positive geometry.
- Ground and sintered-to-size inserts.



■ Screw-On End Mills – RD.X10 Inserts

D1 max	order number	catalog number	Z	D1	D	D2	L2	DPM	G3X	Ap1 max	Max Ramp Angle	kg	insert screw	Torx wrench	Nm
20	1888415	20E02R030M10SRD10	2	10	18	17,5	30	10,5	M10	4,5	15.0°	0,07	193.342	FT15	3,5
25	1888417	25E03R035M12SRD10	3	15	21	20,6	35	12,5	M12	4,5	13.5°	0,11	193.342	FT15	3,5
25	1888416	25E02R035M12SRD10	2	15	21	21,0	35	12,5	M12	4,5	13.5°	0,03	193.342	FT15	3,5
30	1888418	30E04R043M16SRD10	4	20	29	25,0	43	17,0	M16	4,5	9.0°	0,20	193.342	FT15	3,5
35	1888419	35E04R045M16SRD10	4	25	29	32,9	45	17,0	M16	4,5	7.0°	0,03	193.342	FT15	3,5
42	1888420	42E05R045M16SRD10	5	32	29	37,7	45	17,0	M16	4,5	5.0°	0,29	193.342	FT15	3,5

- Stable and positive geometry.
- Ground and sintered-to-size inserts.



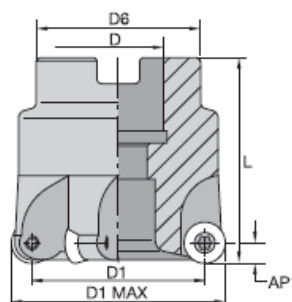
■ End Mills with Cylindrical Shank – RD.X10 Inserts

D1 max	order number	catalog number	Z	D1	D	L3	L	Ap1 max	Max Ramp Angle	kg	insert screw	Torx wrench	Nm
25	1888457	25E02R070A25SRD10	2	15	25	70	180	5	15.0°	0,62	193.342	FT15	3,5
32	1888454	32E03R090A32SRD10	3	22	32	90	200	5	15.0°	0,20	193.342	FT15	3,5

■ End Mills with Weldon Shank – RD.X10 Inserts

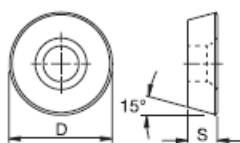
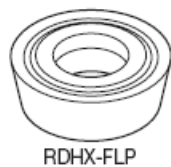
D1 max	order number	catalog number	Z	D1	D	L3	L	Ap1 max	Max Ramp Angle	kg	insert screw	Torx wrench	Nm
20	1888468	20E02R040B20SRD10	2	10	20	40	112	5	15.0°	0,25	193.342	FT15	3,5
20	1888466	20E02R060B20SRD10	2	10	20	60	138	5	15.0°	0,31	193.342	FT15	3,5
20	1888464	20E02R080B20SRD10	2	10	25	60	158	5	15.0°	0,47	193.342	FT15	3,5
20	1888460	20E02R120B20SRD10	2	10	25	60	180	5	15.0°	0,52	193.342	FT15	3,5
20	1888461	20E02R100B20SRD10	2	10	25	60	180	5	15.0°	0,53	193.342	FT15	3,5

- Stable and positive geometry.
- Ground and sintered-to-size inserts.



■ Shell Mills – RD.X10 Inserts

D1 max	order number	catalog number	Z	D1	D	D6	L	Ap1 max	Max Ramp Angle	kg	insert screw	Torx wrench	Nm
52	1888180	52A06RSMORD10	6	42	22	42	50	5	15°	0,45	193.342	FT15	3,5



● first choice
○ alternate choice

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

catalog number	D	S	hm	K110M	KC510M	KC522M	KC525M	KC715M	KC725M	KC935M	KT530M
RDHX1003M0FLP	10,00	3,18	0,05	●	●	●			●		
RDHX1003M0SGN	10,00	3,18	0,10		●	●	●		●		
RDHX1003M0TGN	10,00	3,18	0,10								●
RDPX1003M0SHN	10,00	3,18	0,10		●	●	●	●	●		
RDPX1003M0SHP	10,00	3,18	0,10			●			●	●	

Recommended Starting Speeds [m/min]

RD.X10 Inserts

Material Group	K110M			KC510M			KC522M			KC525M			KC715M			KC725M			KC935M			KT530M		
P1										220	200	180	410	360	330	315	275	260	475	420	385	345	305	280
P2										180	160	150	260	225	205	195	175	160	295	260	240	215	195	170
P3										160	150	140	225	205	185	180	160	145	260	240	215	195	170	160
P4							120	110	100	140	130	120	170	160	145	130	120	110	200	180	165	145	130	120
P5							160	145	130	150	140	130	235	205	190	180	160	145	275	240	220	200	180	160
P6							95	85		130	120	110	145	125		110	95		165	145		120	110	
M1							185	160	150	150	140	130				205	180	165	310	270	230	225	200	180
M2							165	150	140	130	120	110				185	170	150	280	255	230	205	185	170
M3							140	110		90	80	70				140	125		210	185		150	135	
K1				350	320	285													310	275	205			
K2				275	250	230													245	220	200			
K3				235	205	190													205	180	165			
N1	180	150	120	425	365	305																		
N2																								
S1							40	35		40	35					45	40							
S2							35	30		35	30					40	40							
S3							45	40		45	40					50	45							
S4							55	50		55	50					60	55							
H1							150	110	80															

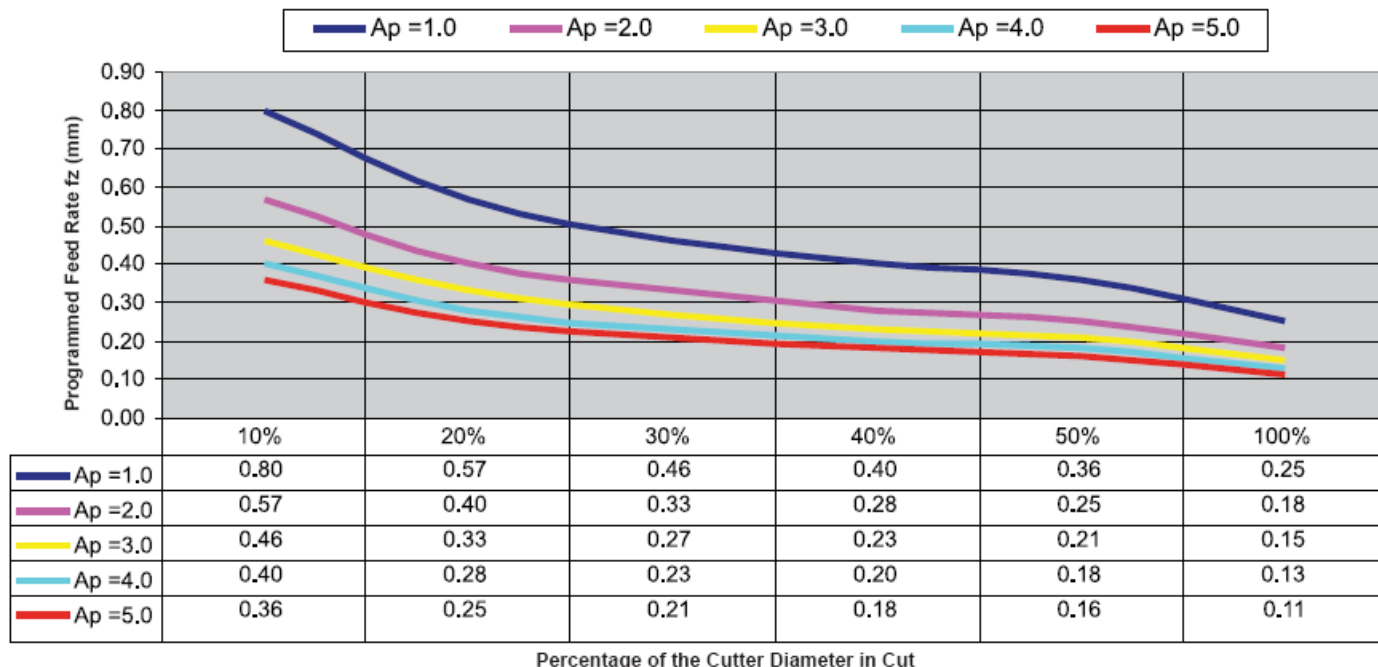
FIRST choice starting speeds are in bold type.

As the average chip thickness goes higher the speed should be decreased.

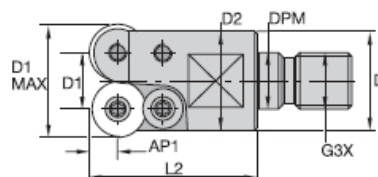
Recommended Starting Feeds

RD.X10 Insert

Feed Rate Compensation For 10 mm Round Insert



- Diameter range from 24 mm to 42 mm.
- Stable and positive geometry.
- Ground and sintered-to-size inserts.



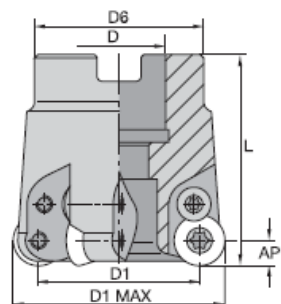
■ Screw-On End Mills — RD.X12 Inserts

D1 max	order number	catalog number	Z	D1	D	D2	L2	DPM	G3X	Ap1 max	Max Ramp Angle	kgs
24	1888421	24E02R035M12SRD12	2	12	21	21,0	35	12,5	M12	6	15.0°	0,09
35	1888422	35E03R043M16SRD12	3	23	29	32,6	43	17,0	M16	6	9.5°	0,23
42	1888423	42E04R043M16SRD12	4	30	29	38,0	43	17,0	M16	6	5.5°	0,30

■ Spare Parts

D1 max	insert screw	Torx wrench	torque (Nm)	clamp screw
24	193.342	FT15	3,5	193.338
35	193.342	FT15	3,5	193.338
42	193.342	FT15	3,5	193.338

- Diameter range from 52 mm to 80 mm.
- Stable and positive geometry.
- Ground and sintered-to-size inserts.



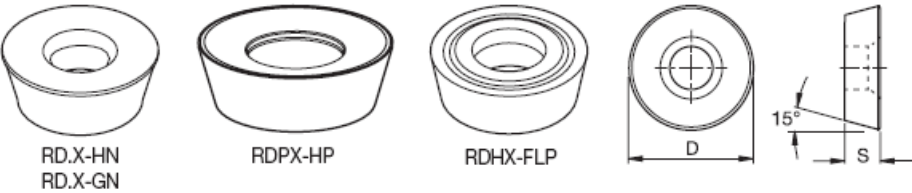
■ Shell Mills — RD.X12 Inserts

D1 max	order number	catalog number	Z	D1	D	D6	L	Ap1 max	Max Ramp Angle	kgs
52	1888182	52A05RSMORD12	5	40	22	42	50	6	4.5°	0,45
66	1888205	66A06RSMORD12	6	54	27	50	50	6	3.5°	0,75
80	1888200	80A07RSMORD12	7	68	27	50	50	6	2.5°	1,00

■ Spare Parts

D1 max	insert screw	Torx wrench	torque (Nm)	clamp screw
52	193.342	FT15	3,5	193.338
66	193.342	FT15	3,5	193.338
80	193.342	FT15	3,5	193.338

Indexable Inserts for KDM RD.X12...



● first choice
○ alternate choice

H			●					
S		●		○			●	
N		○						
K	●							○
M			●	○			●	○
P			○	●	●	●	●	●
	KC510M	KC522M	KC525M	KC715M	KC725M	KC985M	KT530M	
catalog number								
RDHX12T3M0FGN	●							
RDHX12T3M0FLP	●	●						
RDHX12T3M0SGN	●	●						
RDHX12T3M0TGN			●	●	●			
RDHX12T3M0TGN							●	
RDPX12T3M0SHN	●	●		●	●			
RDPX12T3M0SHP		●			●	●		

catalog number	D	S	hm
RDHX12T3M0FGN	12,00	3,97	0,08
RDHX12T3M0FLP	12,00	3,97	0,08
RDHX12T3M0SGN	12,00	3,97	0,12
RDHX12T3M0TGN	12,00	3,97	0,12
RDPX12T3M0SHN	12,00	3,97	0,12
RDPX12T3M0SHP	12,00	3,97	0,12

Recommended Starting Speeds [m/min]

RD.X12 Inserts

Material Group	KC510M			KC522M			KC525M			KC715M			KC725M			KC935M			KT530M		
P1										410	360	330	310	270	250	470	410	380	350	300	280
P2										250	220	200	190	180	160	290	260	240	210	190	170
P3										220	200	180	180	160	140	260	240	220	190	170	160
P4				120	110	100				170	160	140	130	120	110	200	180	160	150	130	120
P5				155	150	135				230	205	180	180	160	150	265	240	215	200	175	160
P6				100	80					140	120		110	90		160	140		120	110	
M1				180	160	150	150	140	130	270	230	220	200	180	160	310	270	250	220	200	180
M2				170	150	140	130	120	110				180	170	150	280	250	230	200	180	170
M3				120	110		90	80	70				140	120		210	180		150	130	
K1	350	320	280										200	180	160	310	280	250			
K2	280	250	230	240	220	200							160	140	130	240	220	200			
K3	230	210	190	200	180	170							130	120	110	200	180	170			
N1	760	680	620																		
N2																					
S1				40	30		40	30					40	40							
S2				30	30		30	30					40	40							
S3				40	40		40	40					50	50							
S4				50	50		50	50					60	50							
H1				150	110	80															

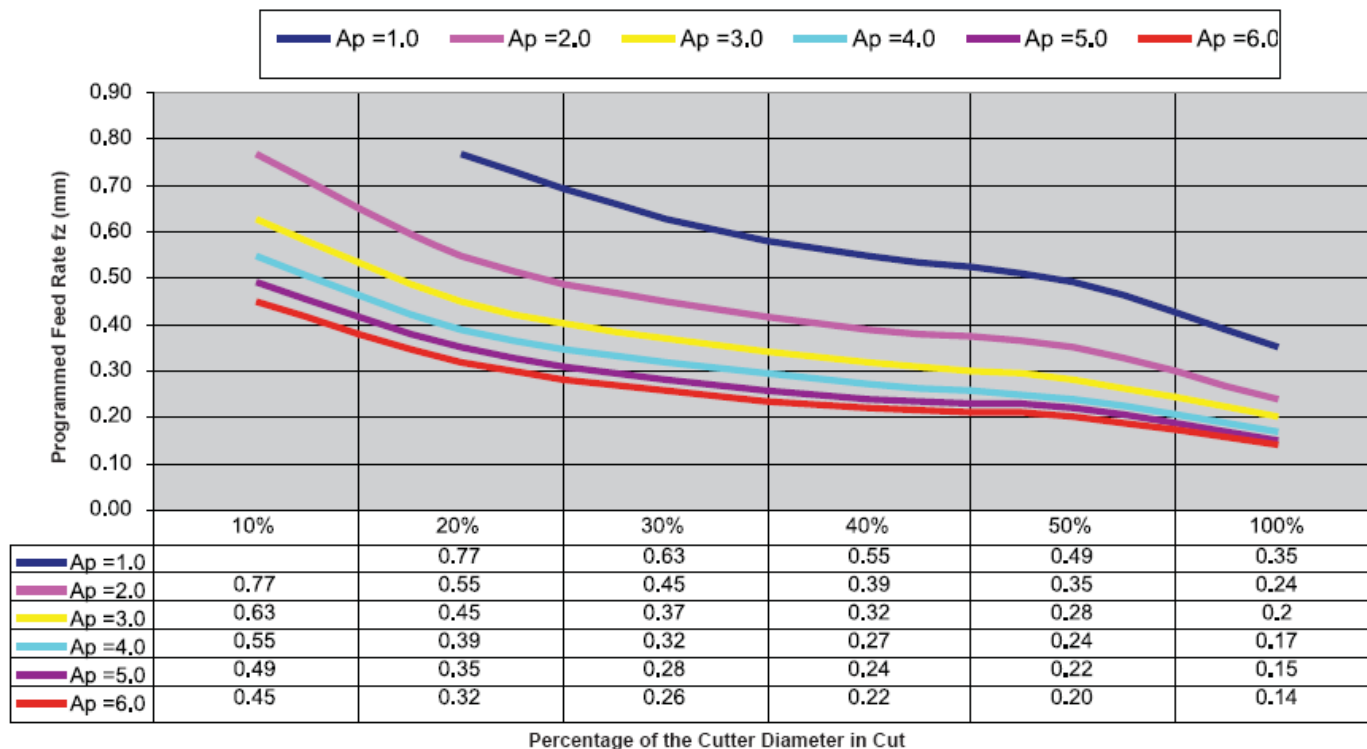
FIRST choice starting speeds are in bold type.

As the average chip thickness goes higher the speed should be decreased.

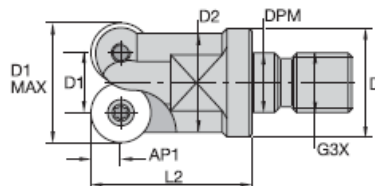
Recommended Starting Feeds

RD.X12 Insert

Feed Rate Compensation For 12 mm Round Insert



- Stable and positive geometry.
- Ground and sintered-to-size inserts.



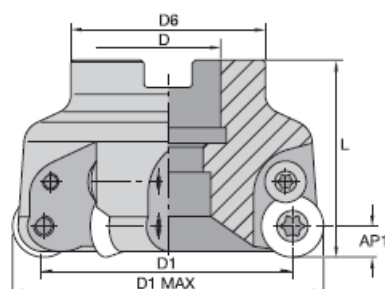
■ Screw-On End Mills — RD.X16 Inserts

D1 max	order number	catalog number	Z	D1	D	D2	L2	DPM	G3X	Ap1 max	Max Ramp Angle	kgs
32	1888424	32E02R043M16SRD16	2	16	29	26,5	43	17	M16	7,5	15.0°	0,2

■ Spare Parts

D1 max	insert screw	Torx wrench	torque (Nm)
32	193.343	FT20	6

- Diameter range of 52 mm to 100 mm.
- Stable and positive geometry.
- Ground and pressed-to-size inserts.



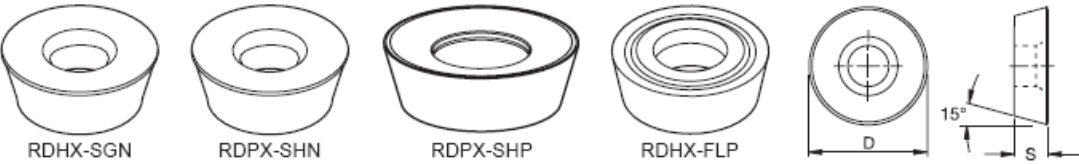
■ Shell Mills — RD.X16 Inserts

D1 max	order number	catalog number	Z	D1	D	D6	L	Ap1 max	Max Ramp Angle	kgs
52	1888196	52A04RSMORD16	4	36	22	40	50	8	5.5°	0,38
66	1888209	66A05RSMORD16	5	50	27	50	50	8	3.5°	0,60
80	1888204	80A06RSMORD16	6	64	27	50	50	8	2.5°	0,80
100	1888197	100B07RSMORD16	7	84	32	60	55	8	2.0°	1,37

■ Spare Parts

D1 max	insert screw	Torx wrench	torque (Nm)	clamp screw
52	193.343	FT20	6	193.383
66	193.343	FT20	6	193.383
80	193.343	FT20	6	193.383
100	193.343	FT20	6	193.383

Indexable Inserts for KDM RD.X16...



● first choice
○ alternate choice

catalog number	D	S	hm		KC510M	KC522M	KC525M	KC715M	KC725M	KC735M	KC935M
RDHX1604M0FLP	16,00	4,76	0,08		●	●			●		
RDHX1604M0SGN	16,00	4,76	0,15		●	●	●		●		
RDPX1604M0SHN	16,00	4,76	0,15		●		●	●	●		
RDPX1604M0SHP	16,00	4,76	0,15			●	●		●		●

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

Recommended Starting Speeds [m/min]

RD.X16.. Inserts

Material Group	KC510M			KC522M			KC525M			KC715M			KC725M			KC735M			KC935M		
P1										410	360	330	310	270	250				470	410	380
P2										250	220	200	190	180	160				290	260	240
P3										220	200	180	180	160	140				260	240	220
P4				120	110	100				170	160	140	130	120	110				200	180	160
P5				155	150	135				230	205	180	180	160	150				265	240	215
P6				100	80					140	120		110	90					160	140	
M1				180	160	150	150	140	130	270	230	220	200	180	160	120	110	100	310	270	250
M2				170	150	140	130	120	110				180	170	150	110	100	90	280	250	230
M3				120	110		90	80	70				140	120		80	70		210	180	
K1	350	320	280										200	180	160				310	280	250
K2	280	250	230	240	220	200							160	140	130				240	220	200
K3	230	210	190	200	180	170							130	120	110				200	180	170
N1	760	680	620																		
N2																					
S1				40	30		40	30					40	40							
S2				30	30		30	30					40	40							
S3				40	40		40	40					50	50							
S4				50	50		50	50					60	50							
H1				150	110	80															

FIRST choice starting speeds are in bold type.

As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

RD.X16 Insert

Feed Rate Compensation For 16 mm Round Insert

