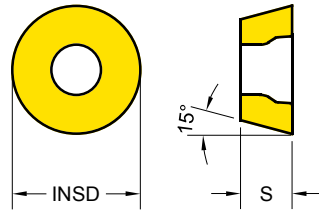


Milling - Profiling - Inserts

RDKT / W-Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDK* 0501	5	1.4	RDK* 10T3	10	4.0
RDK* 0702	7	2.4	RDK* 1204	12	4.8
RDK* 0802	8	2.4			

EDP 1200..

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M35		
K30	K30			S30	H15	
S20						

RDKT RDKW	Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG712	YG603	YG501	YG5020
RDKT General	RDKT 0802M0	0.15 ~ 0.25	● 0035						
	RDKT 10T3M0	0.15 ~ 0.28	● 0041						
	RDKT 1204M0	0.20 ~ 0.30	● 0034			● 0635			
	RDKT 1604M0	0.30~0.60	● 0539						
-ST Stainless Steel Super Alloy	RDKT 0802M0 - ST	0.08 ~ 0.25	● 0292						
	RDKT 10T3M0 - ST	0.08 ~ 0.28	● 0293						
	RDKT 1204M0 - ST	0.10 ~ 0.30	● 0294						
-TR Hardened Steel	RDKT 0802M0 - TR	0.18 ~ 0.35	● 0284	● 0339					
	RDKT 10T3M0 - TR	0.22 ~ 0.40	● 0285	● 0338					
	RDKT 1204M0 - TR	0.22 ~ 0.40	● 0272	● 0340					
RDKW Hard Materials	RDKW 0501M0	0.10 ~ 0.20	● 0207	● 0412					
	RDKW 0702M0	0.12 ~ 0.25	● 0208	● 0439					
	RDKW 0802M0	0.13 ~ 0.25	● 0043	● 0440					
	RDKW 10T3M0	0.16 ~ 0.30	● 0040	● 0441					
	RDKW 1204M0	0.16 ~ 0.35	● 0042	● 0442					

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	150	280	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	130	235	70	210	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	90	130	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	20	40	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	50	100	-	-	50	90	-	-