

KERFOLG® MULTIFUNCTIONAL END MILLS ROUND INSERTS

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ITEM: B6F15

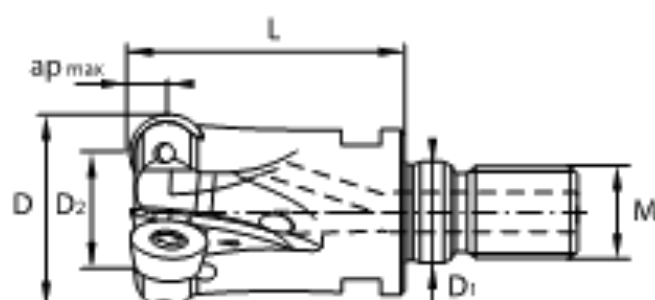
Toroidal end mills with round inserts for face milling and pocketing.

Ø16 ~ 35 mm



Coupling type
Insert type
Application

Screw-On
RD...0702MO - RD...1003MO
For profiling and pocketing.



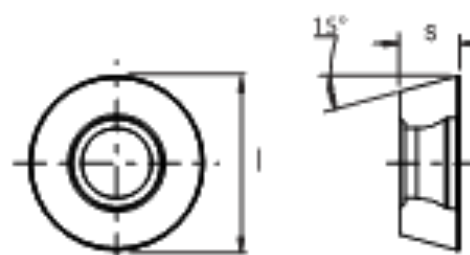
SCREW ON CUTTER

B6F15	Tech. Code		Z	D mm	D2 mm	L mm	D1 mm	Ap max mm	M	Air hole	Insert
Screw-On	B6F151607Z3		3	16	9	23	8.5	3.5	8	With	RDPX0702MO
	B6F152007Z4		4	20	13	30	10.5		10		
	B6F152507Z5		5	25	18	35	12.5		12		
	B6F152010Z2		2	20	10	30	10.5	5	10		RDPX1003MO
	B6F152510Z3		3	25	15	35	12.5		12		
	B6F153010Z4		4	30	20	43	17		16		
	B6F153510Z5		5	35	25	45					

KERFOLG® GEOMETRY AND CUTTING CONDITIONS

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RDPX 0702... l=7mm s=2,38mm
RDPX 1003... l=10mm s=3,18mm
RDPX 12T3... l=12mm s=3,97mm



		Description	Grade	Tech. Code	P			M		K		N	S	H
					<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
Roughing	MR	RDPX 0702MOSN MR	PH20	B6A2207RDMR01	○	●	●			●	○			●
		RDPX 1003MOSN MR		B6A2210RDMR02	○	●	●			●	○			●
		RDPX 12T3MOSN MR		B6A2212RDMR03	○	●	●			●	○			●
		RDPX 0702MOSN MR	PT20	B6A2207RDMR04		●	●	○		○				
		RDPX 1003MOSN MR		B6A2210RDMR05		●	●	○		○				
		RDPX 12T3MOSN MR		B6A2212RDMR06		●	●	○		○				

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Priority	Recommended grades	Geometry	Cutting speed Vc (m/min.)	Insert r = 3.5 mm P.D.T. - fz	Insert r = 5 mm P.D.T. - fz	Insert r = 6 mm P.D.T. - fz
Alloyed steel (42CRMo4, 17Cr3 etc.)	~ 300HB	Roughing	PT20	MR	215 - 250	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
Hardened and tempered steels (NAK80, PX5 etc.)	30 ~ 40HRC	Roughing	PT20	MR	185 - 215	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
Hardened steels	40 ~ 50HRC	Roughing	PH20	MR	140 - 175	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
	50 ~ 56HRC	Roughing	PH20	MR	115 - 140	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA192	RDPX 0702MOSN...	Clamping insert screw	BRICA192
BRICA193	RDPX 1003MOSN... - RDPX 12T3MOSN...		BRICA193
BRICA195	RDPX 12T3MOSN...	Clamping screw	BRICA195