



# SRD10



PRAMET

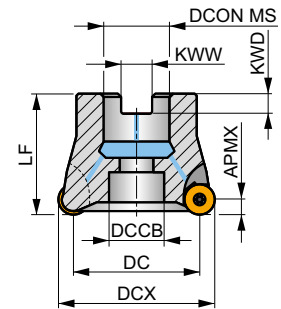
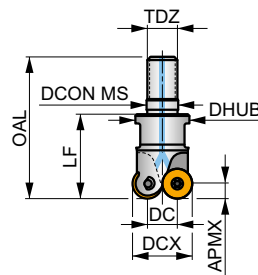
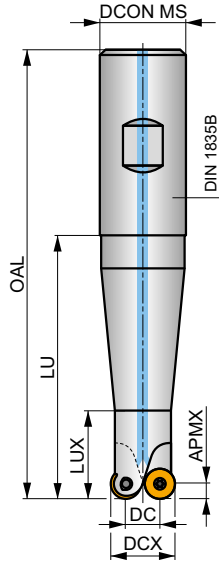
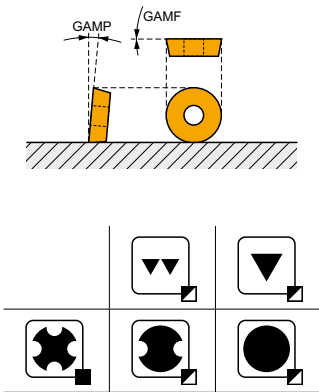
S



## Copy Milling Cutter for Round Inserts RD.. 10 with Internal Coolant

Milling cutter for copy milling utilising positive RD.. 10 inserts with APMX of 2.5 mm. Internal coolant. Suitable for face, helical interpolation, ramping, progressive plunge and copy milling. Available in Weldon, modular and arbor style, in range Ø20 up to Ø52 mm. Body treated for longer tool life.

APMX	2.5 mm
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$h_m$  0.065 - 0.19



Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LU	LUX	LF	TDZ	KWW	KWD	GAMF	GAMP	max.			kg	G119		
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	[°]							
20E2R040B20-SRD10-CF	20	10	90	20	-	-	40	20	-	-	-	-	-2	0	2	-	30800	✓	0.17	G119	C0356
20E2R060B20-SRD10-CF	20	10	110	20	-	-	60	22	-	-	-	-	-2	0	2	-	30800	✓	0.20	G119	C0356
20E2R080B25-SRD10-CF	20	10	136	25	-	-	80	25	-	-	-	-	-2	0	2	-	30800	✓	0.36	G119	C0356
20E2R100B25-SRD10-CF	20	10	156	25	-	-	100	25	-	-	-	-	-2	0	2	-	30800	✓	0.41	G119	C0356
20E2R120B25-SRD10-CF	20	10	176	25	-	-	120	25	-	-	-	-	-2	0	2	-	30800	✓	0.46	G119	C0356
20E2R028M10-SRD10-CF	20	10	47	10.5	18	-	-	28	M10	-	-	-	-2	0	2	-	30800	✓	0.07	G119	C0356
25E2R032M12-SRD10-CF	25	15	54	12.5	21	-	-	32	M12	-	-	-	0.5	0.5	2	-	27500	✓	0.08	G119	C0356
25E3R032M12-SRD10-CF	25	15	54	12.5	21	-	-	32	M12	-	-	-	0.5	0.5	3	-	27500	✓	0.08	G119	C0356
30E4R042M16-SRD10-CF	30	20	65	17	29	-	-	42	M16	-	-	-	0	0	4	-	25100	✓	0.18	G119	C0356
32E4R042M16-SRD10-CF	32	22	65	17	29	-	-	42	M16	-	-	-	0	0	4	-	24300	✓	0.19	G119	C0356
35E5R042M16-SRD10-CF	35	25	65	17	29	-	-	42	M16	-	-	-	0	0	5	-	23200	✓	0.20	G119	C0356
42E4R042M16-SRD10-CF	42	32	65	17	29	-	-	42	M16	-	-	-	0	0	4	-	21200	✓	0.24	G119	C0356
42E5R042M16-SRD10-CF	42	32	65	17	29	-	-	42	M16	-	-	-	0	0	5	-	21200	✓	0.24	G119	C0356
42A05R-SMORD10-CF	42	32	-	16	-	14	-	40	-	8.4	8.4	0	0	5	-	21200	✓	0.20	G119	C0358	
52A07R-SMORD10-CF	52	42	-	22	-	18	-	40	-	10.4	10.4	0	0	7	-	19100	✓	0.28	G119	C0360	

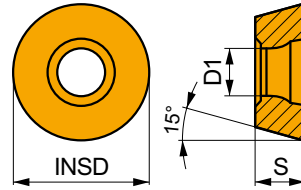
G119	RD.. 1003MOT	RDHT 1003MO-FA

C0356	US 63507-T15P	3.0	M 3.5	7	Flag T15P	-
C0358	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15 HS 0830C
C0360	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15 HS 1030C



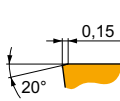
## RDHX 10

	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.90	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]

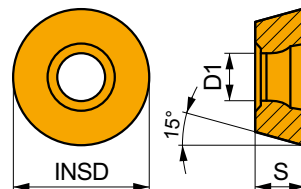


Zero rake angle design for finish machining.

<b>RDHX 1003MOT</b>	<b>M4303</b>	–	☑	340	0.15	1.0	–	–	–	■	320	0.15	1.0	–	–	–	–	–	–	■	65	0.15	1.0
	<b>M8310</b>	–	☑	335	0.15	1.0	–	–	–	■	315	0.15	1.0	–	–	–	–	–	–	■	65	0.15	1.0
	<b>M8325</b>	–	☑	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	–	☑	305	0.15	1.0	–	–	–	■	285	0.15	1.0	–	–	–	–	–	–	☑	60	0.15	1.0
	<b>M8345</b>	–	☑	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

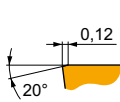
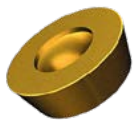
## RDMX 10

	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.90	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



Zero rake angle design for finish machining.

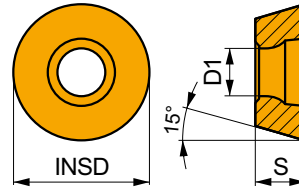
<b>RDMX 1003MOT</b>	<b>M8310</b>	–	☑	335	0.15	1.0	–	–	–	■	315	0.15	1.0	–	–	–	–	–	–	■	65	0.15	1.0
	<b>M8325</b>	–	☑	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
	<b>M8345</b>	–	☑	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	



## RDGT 10

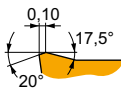


	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.90	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



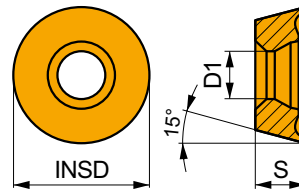
Positive design for finish machining.

RDGT 1003MOT	M6330	-	290	0.15	1.0	205	0.14	1.0	-	-	-	-	-	-	85	0.12	0.8	-	-	-
	M8310	-	375	0.15	1.0	190	0.14	1.0	355	0.15	1.0	-	-	-	-	-	-	-	-	-
	M8325	-	280	0.15	1.0	130	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-
	M8345	-	250	0.15	1.0	150	0.14	1.0	-	-	-	-	-	-	60	0.12	0.8	-	-	-
	M9340	-	395	0.15	1.0	235	0.14	1.0	-	-	-	-	-	-	95	0.12	0.8	-	-	-

## RDHT 10-FA

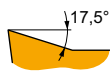


	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.90	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



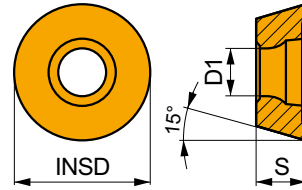
FA geometry with highly positive design for fine-finish to medium machining.

RDHT 1003MO-FA	HF7	-	-	-	-	-	-	-	390	0.18	1.0	-	-	-	-	-	-	-	-	-
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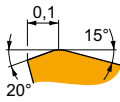
# RDMT 10

	INSD	D1	S
	[mm]	[mm]	[mm]
1003	10.0	3.90	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



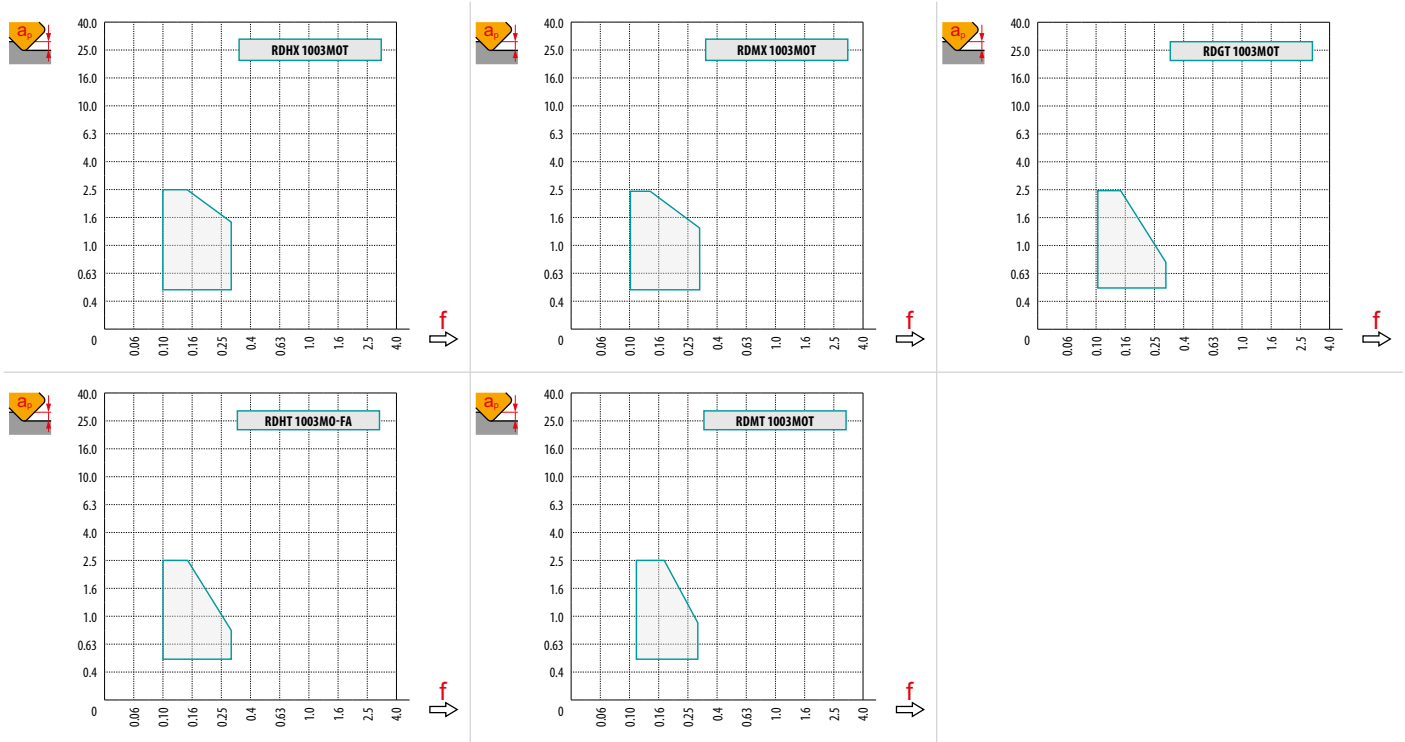
Positive design for finish machining.

<b>RDMT 1003MOT</b>	<b>M8325</b>	—	■	280	0.15	1.0	▣	130	0.14	1.0	■	—	—	—	■	—	—	—	■	—	—	—
	<b>M8345</b>	—	■	250	0.15	1.0	▣	150	0.14	1.0	■	—	—	—	■	—	—	—	■	—	—	—

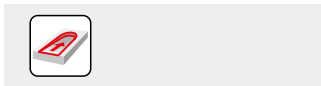


$a_e$ DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

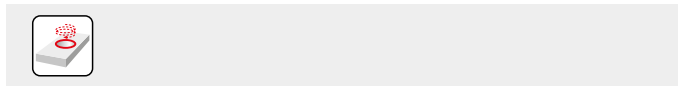
	RDHX 10	RDMX 10	RDGT 10	RDHT 10-FA
	5.0	5.0	5.0	5.0
	-	-	-	-



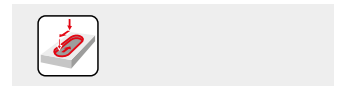
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
20		10.0	14.4	15.3	16.0	16.6	17.1	18.0	18.7	19.2	19.5	19.8	20.0
25		15.0	19.4	20.3	21.0	21.6	22.1	23.0	23.7	24.2	24.5	24.8	25.0
30		20.0	24.4	25.3	26.0	26.6	27.1	28.0	28.7	29.2	29.5	29.8	30.0
32		22.0	26.4	27.3	28.0	28.6	29.1	30.0	30.7	31.2	31.5	31.8	32.0
35		25.0	29.4	30.3	31.0	31.6	32.1	33.0	33.7	34.2	34.5	34.8	35.0
42		32.0	36.4	37.3	38.0	38.6	39.1	40.0	40.7	41.2	41.5	41.8	42.0
52		42.0	46.4	47.3	48.0	48.6	49.1	50.0	50.7	51.2	51.5	51.8	52.0
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
		-	0.54	0.44	0.39	0.35	0.32	0.28	0.25	0.23	0.22	0.21	0.19



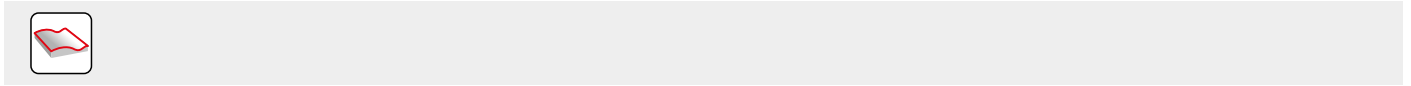
<b>20</b>	20	2.5/15
<b>25</b>	12	2.5/25
<b>30</b>	8	2.5/37
<b>32</b>	7.5	2.5/20
<b>35</b>	7	2.5/42
<b>42</b>	4	2.5/37
<b>52</b>	3	2.5/49



	<b>DMIN</b>	<b>DMAX</b>		
<b>20</b>	22.0	40.0	2.5	2.5
<b>25</b>	32.0	50.0	2.5	2.5
<b>30</b>	42.0	60.0	2.5	2.5
<b>32</b>	46.0	64.0	2.5	2.5
<b>35</b>	52.0	70.0	2.5	2.5
<b>42</b>	66.0	84.0	2.5	2.5
<b>52</b>	86.0	104.0	2.5	2.5



	2.5
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		<b>3</b>	<b>5</b>	<b>10</b>	<b>15</b>	<b>20</b>	<b>30</b>	<b>40</b>	<b>50</b>	<b>60</b>	<b>80</b>	<b>100</b>
<b>20</b>		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
<b>25</b>		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
<b>30</b>		0.600	0.775	1.095	1.342	1.549	1.897	2.191	2.449	2.683	3.098	3.464
<b>32</b>		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
<b>35</b>		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
<b>42</b>		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
<b>52</b>		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
		<b>3</b>	<b>5</b>	<b>10</b>	<b>15</b>	<b>20</b>	<b>30</b>	<b>40</b>	<b>50</b>	<b>60</b>	<b>80</b>	<b>100</b>
<b>5.0</b>		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000