



# SRD12



PRAMET

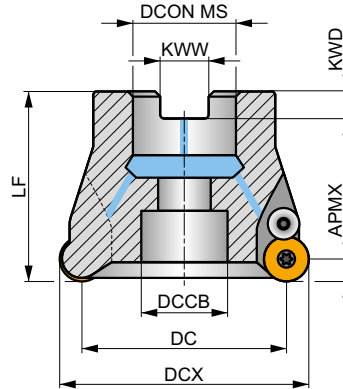
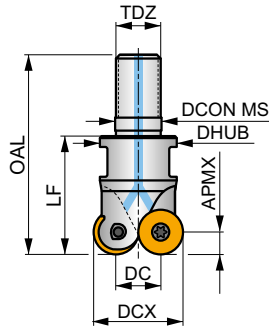
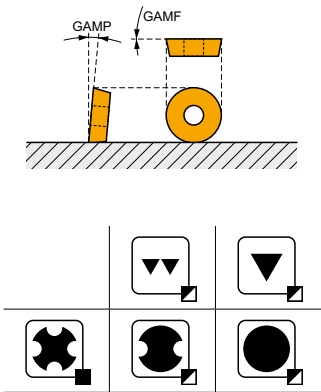
S(C)



## Copy Milling Cutter for Round Inserts RD.. 12 with Internal Coolant

Milling cutter for copy milling utilising positive RD.. 12 inserts with APMX of 3 mm. Internal coolant. Suitable for face, helical interpolation, ramping, progressive plunge and copy milling. Available in modular and arbor style, in range Ø24 up to Ø80 mm. Body treated for longer tool life.

APMX	3.0 mm
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Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LF	TDZ	KWW	KWD	GAMF	GAMP	Rotation			kg	Material	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]	max.	kg	GI120	C0362		
<b>24E2R032M12-SRD12-CF</b>	24	12	54	12.5	21	-	32	M12	-	-	-3	0	2	-	21900	✓	0.07	GI120 C0362
<b>35E3R042M16-SCRD12-CF</b>	35	23	65	17	29	-	42	M16	-	-	0	0	3	-	18100	✓	0.19	GI120 C0364
<b>35E4R042M16-SRD12-CF</b>	35	23	65	17	29	-	42	M16	-	-	0	0	4	-	18100	✓	0.20	GI120 C0362
<b>42E4R042M16-SCRD12-CF</b>	42	30	65	17	29	-	42	M16	-	-	0	0	4	-	16600	✓	0.21	GI120 C0364
<b>42E5R042M16-SRD12-CF</b>	42	30	65	17	29	-	42	M16	-	-	0	0	5	-	16600	✓	0.22	GI120 C0366
<b>50A05R-SCMORD12-CF</b>	50	38	-	22	-	18	50	-	10.4	10.4	2	7	5	-	15200	✓	0.29	GI120 C0366
<b>52A05R-SCMORD12-CF</b>	52	40	-	22	-	18	50	-	10.4	10.4	2	7	5	-	14900	✓	0.32	GI120 C0366
<b>66A06R-SCMORD12-CF</b>	66	54	-	27	-	22	50	-	12.4	12.4	2	7	6	-	13200	✓	0.54	GI120 C0370
<b>80A07R-SCMORD12-CF</b>	80	68	-	27	-	38	52	-	12.4	12.4	2	7	7	-	12000	✓	0.89	GI120 C0372

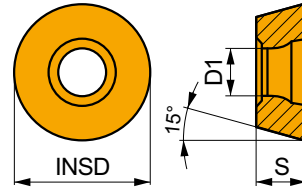
GI120	RD.. 12T3MOT	RDHT 12T3M0-FA
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Product	US	Nm	M	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
C0362	US 3508-T15P	3.5	M 3.5	8	-	-	-	-	-	-	Flag T15P	-	-	-	-	-
C0364	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	-	-	-	HS 1230C	-	-	-	-	-
C0366	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	-	-	-	-	CS12P	HS 1030C	-	-	-
C0370	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	-	-	-	-	CS12P	HS 1230C	-	-	-
C0372	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	-	-	-	-	CS12P	-	-	-	-



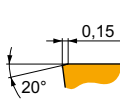
# RDHX 12

	INSD	D1	S
	[mm]	[mm]	[mm]
12T3	12.0	3.90	3.97



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]

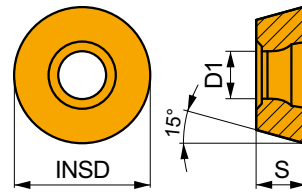


Zero rake angle design for finish machining.

<b>RDHX 12T3MOT</b>	<b>M4303</b>	–	☑	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.15	1.0
	<b>M8310</b>	–	☑	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.15	1.0
	<b>M8325</b>	–	☑	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	–	☑	270	0.20	1.5	–	–	–	■	255	0.20	1.5	–	–	–	–	–	–	☑	50	0.15	1.0
	<b>M8345</b>	–	☑	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

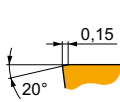
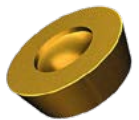
# RDMX 12

	INSD	D1	S
	[mm]	[mm]	[mm]
12T3	12.0	3.90	3.97



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.

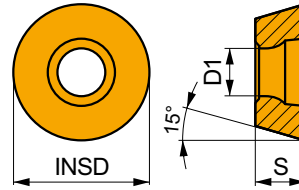
<b>RDMX 12T3MOT</b>	<b>M8310</b>	–	☑	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.15	1.0
	<b>M8325</b>	–	☑	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	<b>M8345</b>	–	☑	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



## RDGT 12

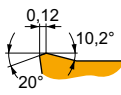
PRAMET

	INSD	D1	S
	[mm]	[mm]	[mm]
12T3	12.0	3.90	3.97



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]



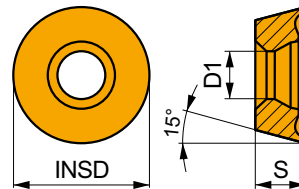
Positive design for finish machining.

RDGT 12T3MOT	M6330	-	260	0.20	1.5	185	0.18	1.5	-	-	-	-	-	-	75	0.14	1.2	-	-	-
	M8310	-	330	0.20	1.5	165	0.18	1.5	310	0.20	1.5	-	-	-	-	-	-	-	-	-
	M8325	-	250	0.20	1.5	120	0.18	1.5	-	-	-	-	-	-	-	-	-	-	-	-
	M8345	-	225	0.20	1.5	135	0.18	1.5	-	-	-	-	-	-	55	0.14	1.2	-	-	-
	M9340	-	340	0.20	1.5	200	0.18	1.5	-	-	-	-	-	-	85	0.14	1.2	-	-	-

## RDHT 12-FA

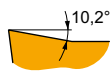
PRAMET

	INSD	D1	S
	[mm]	[mm]	[mm]
12T3	12.0	3.90	3.97



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]



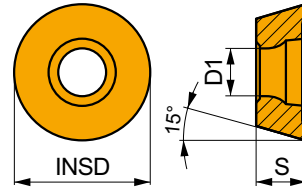
FA geometry with highly positive design for fine-finish to medium machining.

RDHT 12T3M0-FA	HF7	-	-	-	-	-	-	-	360	0.24	1.5	-	-	-	-	-	-	-	-	-
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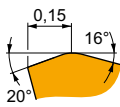
# RDMT 12

	INSD	D1	S
	[mm]	[mm]	[mm]
12T3	12.0	3.90	3.97



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 [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



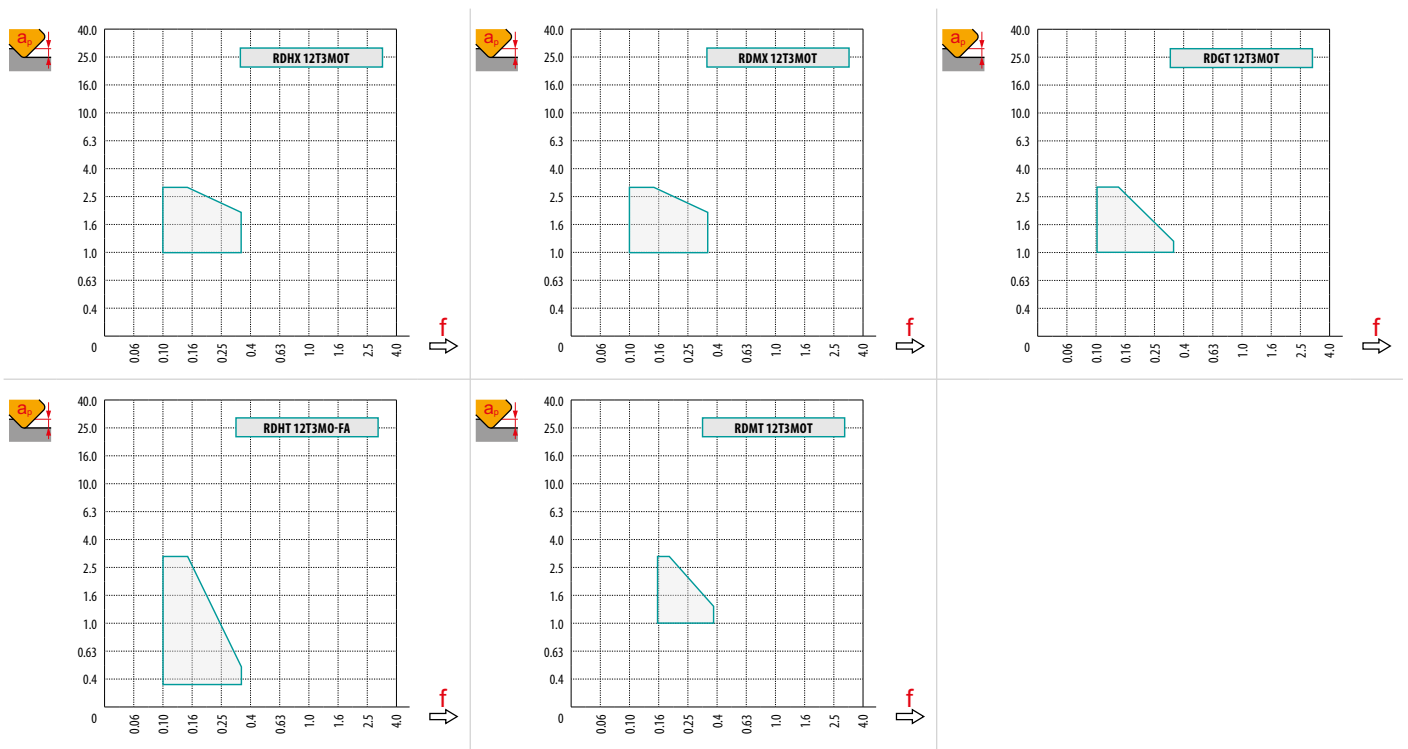
Positive design for finish machining.

<b>RDMT 12T3MOT</b>	<b>M8325</b>	—	■	250	0.20	1.5	▣	120	0.18	1.5	■	—	—	—	■	—	—	—	■	—	—	—
	<b>M8345</b>	—	■	225	0.20	1.5	▣	135	0.18	1.5	■	—	—	—	■	—	—	—	■	—	—	—

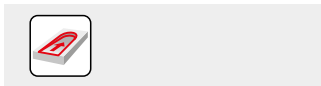


$a_e$ / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

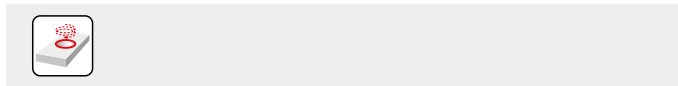
	RDHX 12	RDMX 12	RDGT 12	RDHT 12-FA
	6.0	6.0	6.0	6.0
	-	-	-	-



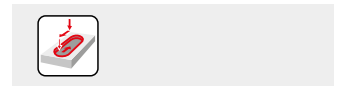
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
<b>24</b>		12.0	16.8	17.8	18.6	19.3	19.9	20.9	21.7	22.4	22.9	23.3	23.8	24.0
<b>35</b>		23.0	27.8	28.8	29.6	30.3	30.9	31.9	32.7	33.4	33.9	34.3	34.8	35.0
<b>42</b>		30.0	34.8	35.8	36.6	37.3	37.9	38.9	39.7	40.4	40.9	41.3	41.8	42.0
<b>50</b>		38.0	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	48.9	49.3	49.8	50.0
<b>52</b>		40.0	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	50.9	51.3	51.8	52.0
<b>66</b>		54.0	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	64.9	65.3	65.8	66.0
<b>80</b>	68.0	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	78.9	79.3	79.8	80.0	
		<b>0.00</b>	<b>0.50</b>	<b>0.75</b>	<b>1.00</b>	<b>1.25</b>	<b>1.50</b>	<b>2.00</b>	<b>2.50</b>	<b>3.00</b>	<b>3.50</b>	<b>4.00</b>	<b>5.00</b>	<b>6.00</b>
		-	0.49	0.40	0.35	0.32	0.29	0.25	0.23	0.21	0.20	0.18	0.17	0.16



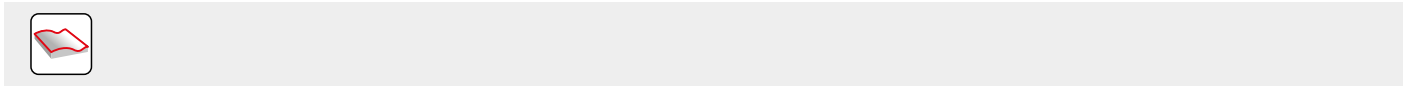
<b>24</b>	25.0	3.0/14
<b>35</b>	9.0	3.0/39
<b>42</b>	8.0	3.0/44
<b>50</b>	4.0	3.0/87
<b>52</b>	4.0	3.0/87
<b>66</b>	3.0	3.0/100
<b>80</b>	2.2	3.0/100



	<b>DMIN</b>	<b>DMAX</b>		
<b>24</b>	26.0	48.0	3.0	3.0
<b>35</b>	46.0	70.0	3.0	3.0
<b>42</b>	62.0	84.0	3.0	3.0
<b>50</b>	78.0	100.0	2.8	2.8
<b>52</b>	82.0	104.0	2.8	2.8
<b>66</b>	110.0	132.0	2.8	2.8
<b>80</b>	136.0	160.0	2.8	2.8



	2.8
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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>24</b>		0.537	0.693	0.980	1.200	1.386	1.697	1.960	2.191	2.400	2.771	3.098
<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>50</b>		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
<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>66</b>		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
<b>80</b>		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
		<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>6.0</b>		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191