



SOD05



PRAMET

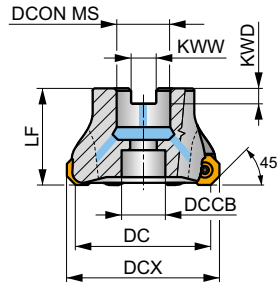
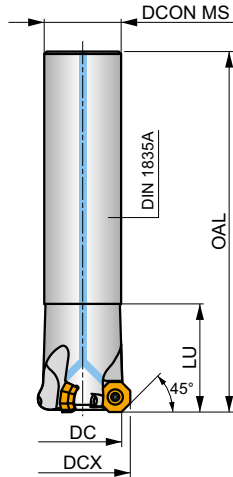
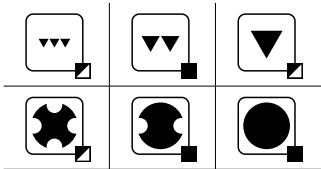
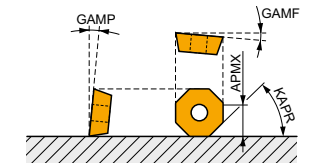
S



Universal Face Mill with Positive Design and Internal Coolant

Highly productive universal face mill utilising single-sided positive inserts with APMX up to 10 mm. Unique insert seat fits OD.. 05, RD.. 12 and SD.. 12 style inserts, suited for wide range of applications. Differential tooth pitch. Arbor and cylindrical style in range from Ø32 up to Ø125 mm. Body treated for longer tool life.

KAPR	45°
APMX	2.7 (10.0) mm



	0.03 - 0.15
	0.03 - 0.12



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	KAPR	KWW	KWD	GAMF	GAMP	max.		kg	Icons				
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[°]	[°]								
32N3R045A25-SOD05-C	32	24.7	130	25	-	45	-	45	-	-	-10	8	3	-	17700	✓	0.41	GI326	FA049	-
40N3R045A32-SOD05-C	40	32.6	150	32	-	45	-	45	-	-	-7	8	3	-	15800	✓	0.86	GI326	FA040	-
40A03R-S45OD05-C	40	32.7	-	16	14	-	40	45	8.4	5.6	-10	8	3	-	15800	✓	0.19	GI326	FA042	-
50A04R-S45OD05-C	50	42.6	-	22	18	-	40	45	10.4	6.3	-7	8	4	-	14100	✓	0.28	GI326	FA043	-
50A05R-S45OD05-C	50	42.6	-	22	18	-	40	45	10.4	6.3	-7	8	5	-	14100	✓	0.28	GI326	FA043	-
63A05R-S45OD05-C	63	55.6	-	22	18	-	40	45	10.4	6.3	-7	8	5	✓	12600	✓	0.39	GI326	FA043	-
63A06R-S45OD05-C	63	55.6	-	22	18	-	40	45	10.4	6.3	-7	8	6	✓	12600	✓	0.40	GI326	FA043	-
80A06R-S45OD05-C	80	72.6	-	27	38	-	50	45	12.4	7	-7	8	6	✓	11100	✓	0.73	GI326	FA041	AC001
80A08R-S45OD05-C	80	72.6	-	27	38	-	50	45	12.4	7	-7	8	8	✓	11100	✓	0.66	GI326	FA041	AC001
100A07R-S45OD05-C	100	92.6	-	32	45	-	50	45	14.4	8	-7	8	7	✓	10000	✓	1.09	GI326	FA041	AC002
125A08R-S45OD05-C	125	117.6	-	40	56	-	63	45	16.4	9	-7	8	8	✓	8900	✓	2.20	GI326	FA041	AC003

GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

FA040	US 45014-T20P	5.0	M 5	13	Flag T20P	-	-
FA041	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	-
FA042	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	HS 90835
FA043	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	HS 1030C
FA049	US 45011-T20P	5.0	M 5	11	Flag T20P	-	-

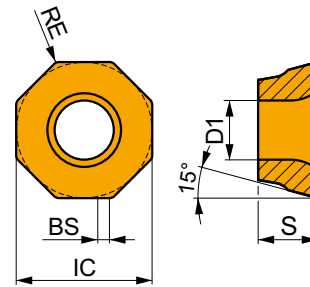


AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ODKT 05IM

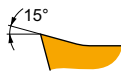


	IC	D1	S	BS
	[mm]	[mm]	[mm]	[mm]
0505	12.700	5.50	5.56	1.00



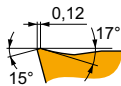
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
	[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]



F geometry, 45° face milling insert, with highly positive design for light machining.

ODKT 0505ADFR-F	M8310	0.8	■ 275	0.15	2.5	■ 140	0.14	2.5	■ -	-	-	■ -	-	-	■ -	-	-	■ -	-	-
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FM geometry, 45° face milling insert, with positive design for light to medium machining.

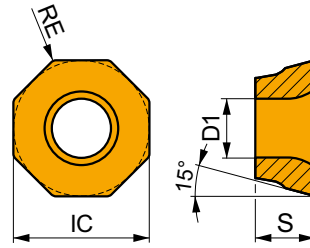
ODKT 0505ADSR-FM	M6330	0.8	■ 190	0.25	2.5	■ 135	0.23	2.5	■ -	-	-	■ -	-	-	■ -	-	-	■ -	-	-
	M8310	0.8	■ 240	0.25	2.5	■ 120	0.23	2.5	■ 225	0.25	2.5	■ -	-	-	■ -	-	-	■ -	-	-
	M8330	0.8	■ 225	0.25	2.5	■ 135	0.23	2.5	■ 210	0.25	2.5	■ -	-	-	■ -	-	-	■ -	-	-
	M8345	0.8	■ 160	0.25	2.5	■ 95	0.23	2.5	■ -	-	-	■ -	-	-	■ -	-	-	■ -	-	-
	M9340	0.8	■ 245	0.25	2.5	■ 145	0.23	2.5	■ -	-	-	■ -	-	-	■ -	-	-	■ -	-	-



ODMT 051M

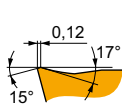
PRAMET

	IC	D1	S
	[mm]	[mm]	[mm]
0505	12.700	5.50	5.56



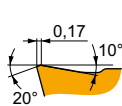
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



FM geometry, 45° face milling insert, with positive design for light to medium machining.

ODMT 0505ADSR-FM	M8340	0.8	200	0.25	2.5	120	0.23	2.5	190	0.25	2.5	-	-	-	-	-	-	-	-
	M9340	0.8	245	0.25	2.5	145	0.23	2.5	-	-	-	-	-	-	-	-	-	-	-



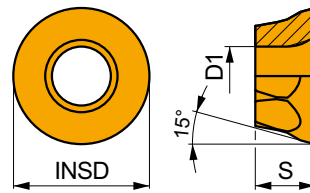
R geometry, 45° face milling insert, with positive design for unstable cutting conditions.

ODMT 050508SN-R	M8330	0.8	190	0.25	2.5	-	-	-	180	0.25	2.5	-	-	-	-	-	-	-	-
	M9340	0.8	210	0.25	2.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-

RDGT 121M

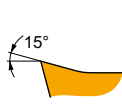
PRAMET

	INSD	D1	S
	[mm]	[mm]	[mm]
1205	12.7	5.50	5.56



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]



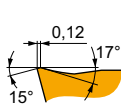
F geometry with highly positive design for light machining.

RDGT 120500FN-F	M8310	-	210	0.20	1.5	105	0.18	1.5	-	-	-	-	-	-	-	-	-	-	-
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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]



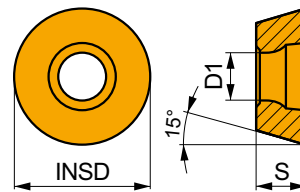
FM geometry with positive design for light to medium machining.

RDGT 120500SN-FM	M8330	-	■	190	0.20	1.5	▣	110	0.18	1.5	▣	180	0.20	1.5	-	-	-	-	-	-
	M8345	-	■	140	0.20	1.5	▣	80	0.18	1.5	■	-	-	-	-	-	-	-	-	-

RDMT 12IM

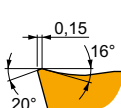


	INSD [mm]	D1 [mm]	S [mm]
1205	12.7	5.50	5.56



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]



R geometry, copy and profile milling insert, with positive design for unstable cutting conditions.

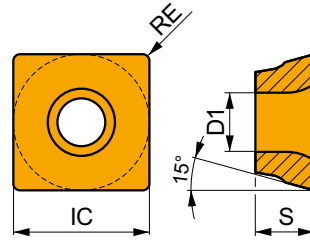
RDMT 120500SN-R	M8330	-	■	175	0.30	1.5	■	-	-	-	■	165	0.30	1.5	-	-	-	-	-	-
	M8340	-	■	160	0.30	1.5	■	-	-	-	▣	150	0.30	1.5	-	-	-	-	-	-
	M9340	-	■	190	0.30	1.5	■	-	-	-	■	-	-	-	-	-	-	-	-	-



SDKT 12IM

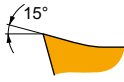
PRAMET

	IC	D1	S
	[mm]	[mm]	[mm]
1205	12.700	5.50	5.56



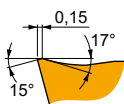
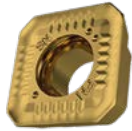
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



F geometry, 90° shoulder milling insert, with highly positive design for light machining.

SDKT 1205PDFR-F	M8215	0.8	■ 285	0.10	4.0	☑ 170	0.09	4.0	—	—	—	☑ 855	0.12	4.0	—	—	—	—	—	—
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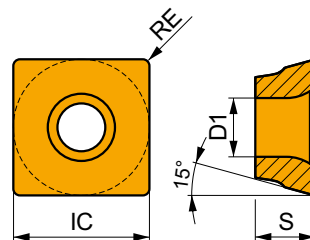
FM geometry, 90° shoulder milling insert, with positive design for light to medium machining.

SDKT 1205AESN-FM	M6330	—	■ 240	0.15	4.0	☑ 170	0.15	4.0	—	—	—	—	—	—	—	—	—	—	—	—
	M8330	—	■ 280	0.15	4.0	☑ 165	0.15	4.0	☑ 265	0.15	4.0	—	—	—	—	—	—	—	—	—
	M8345	—	■ 205	0.15	4.0	☑ 120	0.15	4.0	—	—	—	—	—	—	—	—	—	—	—	—
SDKT 1205PDSR-FM	M8330	0.8	■ 255	0.15	4.0	☑ 150	0.15	4.0	☑ 240	0.15	4.0	—	—	—	—	—	—	—	—	—
	M8345	0.8	■ 185	0.15	4.0	☑ 110	0.15	4.0	—	—	—	—	—	—	—	—	—	—	—	—

SDMT 12IM

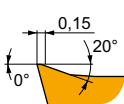
PRAMET

	IC	D1	S
	[mm]	[mm]	[mm]
1205	12.700	5.50	5.56



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]



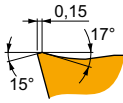
F geometry, 90° shoulder milling insert, with positive design for light to medium machining.

SDMT 120508SN-F	M8310	0.8	■ 265	0.15	4.0	☑ 135	0.15	4.0	—	—	—	—	—	—	—	—	—	—	—	—
	M8330	0.8	■ 245	0.15	4.0	☑ 145	0.15	4.0	—	—	—	☑ 735	0.18	4.0	—	—	—	—	—	—



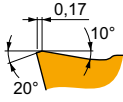
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



FM geometry, 90° shoulder milling insert, with positive design for medium machining.

SDMT 120508SN-FM	M8345	0.8	■	175	0.15	4.0	■	105	0.15	4.0	■	-	-	-	-	-	-	-	-
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R geometry, 90° shoulder milling insert, with positive design for unstable cutting conditions.

SDMT 120508SN-R	M8330	0.8	■	225	0.20	4.0	■	-	-	-	■	210	0.20	4.0	■	-	-	-	-
	M8345	0.8	■	165	0.20	4.0	■	-	-	-	■	-	-	-	■	-	-	-	-
	M9340	0.8	■	250	0.20	4.0	■	-	-	-	■	-	-	-	■	-	-	-	-
SDMT 1205AESN-R	M8330	-	■	265	0.20	4.0	■	-	-	-	■	250	0.20	4.0	■	-	-	-	-
	M8340	-	■	240	0.20	4.0	■	-	-	-	■	225	0.20	4.0	■	-	-	-	-

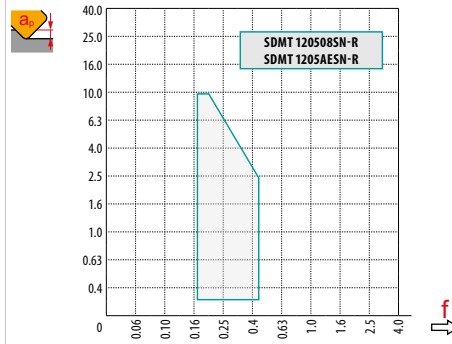
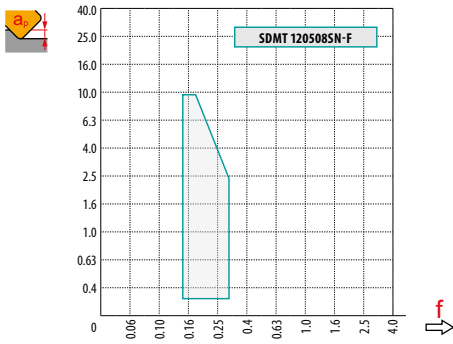
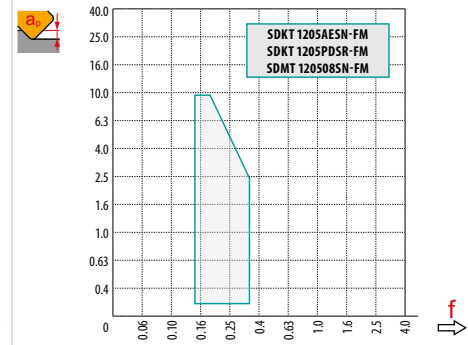
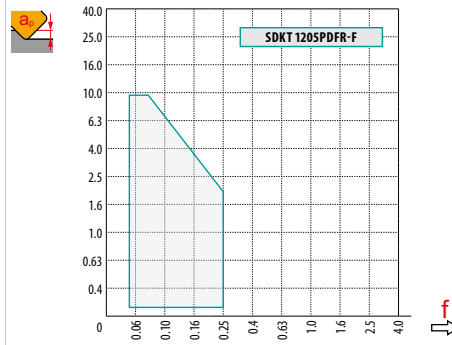
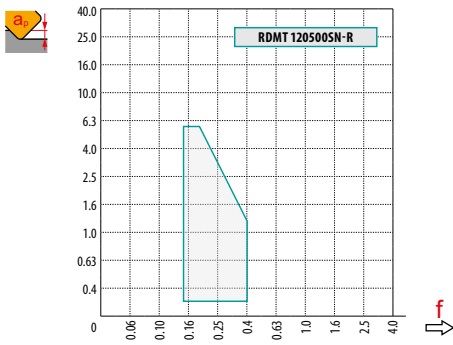
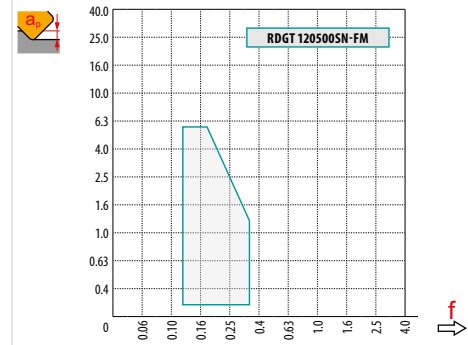
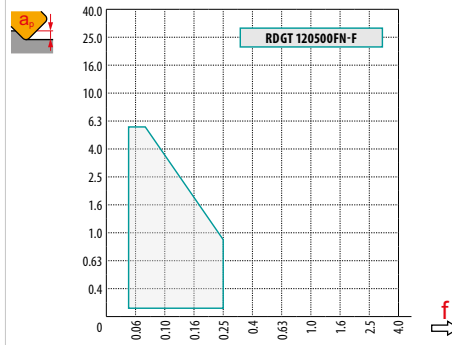
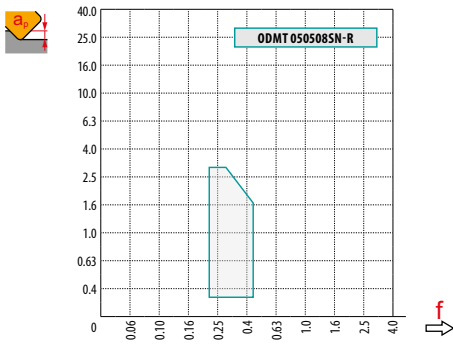
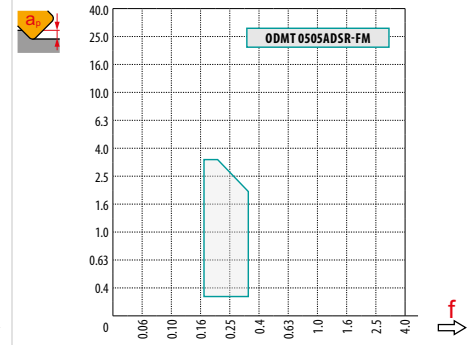
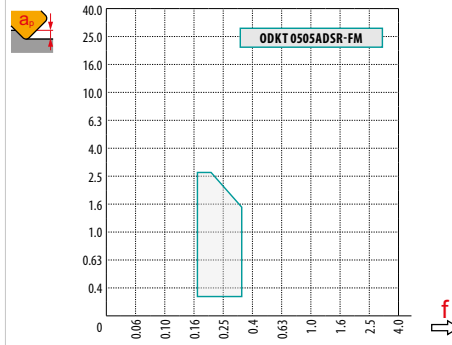
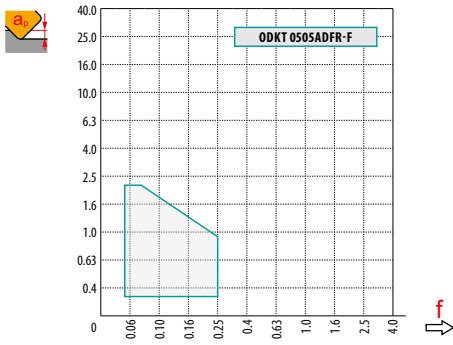


a_e DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
	0.4	0.8	0.8	0.8
	1.00	1.00	–	–

	RDGT 12-F	RDGT 12-FM	RDGT 12-R
	6.35	6.35	6.35
	–	–	–

	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
	0.8	0.8	0.8	0.8
	2.30	2.30	–	–



		R												
		0.25	0.50	0.60	0.70	0.80	1.00	1.25	1.50	2.00	3.00	4.00	5.00	6.00
32		23.43	24.80	25.23	25.62	25.99	26.63	27.33	27.94	28.94	30.39	31.31	31.83	32.00
40		31.43	32.80	33.23	33.62	33.99	34.63	35.33	35.94	36.94	38.39	39.31	39.83	40.00
50		41.43	42.80	43.23	43.62	43.99	44.63	45.33	45.94	46.94	48.39	49.31	49.83	50.00
63		54.43	55.80	56.23	56.62	56.99	57.63	58.33	58.94	59.94	61.39	62.31	62.83	63.00
80		71.43	72.80	73.23	73.62	73.99	74.63	75.33	75.94	76.94	78.39	79.31	79.83	80.00
100		91.43	92.80	93.23	93.62	93.99	94.63	95.33	95.94	96.94	98.39	99.31	99.83	100.00
125		116.43	117.80	118.23	118.62	118.99	119.63	120.33	120.94	121.94	123.39	124.31	124.83	125.00



		f_{max}
32	1.36	0.28
40	1.40	0.31
50	1.43	0.33
63	1.47	0.37
80	1.52	0.42
100	1.57	0.47
125	1.62	0.52



S



10.0



S

	1.0	5.0	10.0
	0.35	0.21	0.15



O

	RPMX	APMX/I
50	4.1	7.05/100
63	2.7	4.6/100
80	1.8	3/100
100	1.7	2.85/100
125	0.7	1.1/100



R

	RPMX	APMX/I
50	3.8	6.2/95
63	2.5	4.25/100
80	1.7	2.85/100
100	1.6	2.65/100
125	0.3	0.4/100



O

	DMIN	DMAX		
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	229.0	250.0	4.0	4.5



R

	DMIN	DMAX		
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	230.0	250.0	4.0	4.5



O **R**



2.4 2.3



R

	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125	1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071	

RE

μm

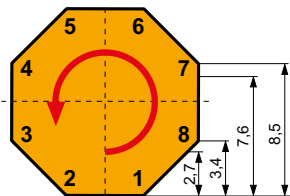
3 5 10 15 20 30 40 50 60 80 100

6.0		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
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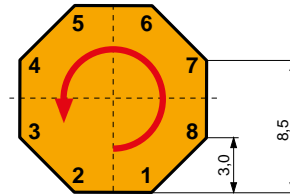
i

ODKT 05

ODMT 05



→ 2.7	8
→ 3.4	7
→ 7.6	4
→ 8.5	2



→ 3.0	8
→ 8.5	4