

3RDSM, 4RDSM, 5RDSM

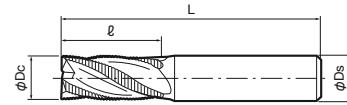
Number of Flutes: 3, 4, 5

General use / Roughing (Medium)



Recommended Material

★ 1st Recommendation



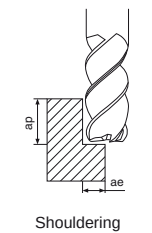
Lineup

(Unit: mm)

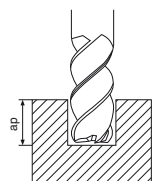
Description	Std.	Outside Dia.	Outside Dia. tolerance	Edge Length	Shank Dia.	Total length	Number of Flutes
		øDc		l	øDs	L	Z
3RDSM040-110-06	●	4	-0.030 -0.105	11	6	55	3
3RDSM050-130-06	●	5	-0.030 -0.105	13	6	57	3
3RDSM060-130-06	●	6	-0.030 -0.105	13	6	57	3
3RDSM080-160-08	●	8	-0.040 -0.130	16	8	63	3
4RDSM100-220-10	●	10	-0.040 -0.130	22	10	72	4
4RDSM120-260-12	●	12	-0.050 -0.160	26	12	83	4
4RDSM160-320-16	●	16	-0.050 -0.160	32	16	92	4
4RDSM200-380-20	●	20	-0.065 -0.195	38	20	104	4
5RDSM250-450-25	●	25	-0.065 -0.195	45	25	121	5

- Three, four and five flutes types are available for roughing. The sine curve shaped cutting edge reduces cutting resistance.

Recommended Cutting Conditions



Shouldering



Slotting

Shouldering

Workpiece Materials		Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
Steel	< 22HRC	1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	11,100	8,400	6,700	5,600	4,200	3,300	2,700
			Feed Rate (mm/min)	1,000	1,000	1,100	1,120	1,200	1,200	1,340
	22~32HRC	1.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	9,600	7,200	5,700	4,800	3,600	2,900	2,300
			Feed Rate (mm/min)	720	720	860	860	860	920	1,030
	32~40HRC	1.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,500
			Feed Rate (mm/min)	320	320	410	410	400	400	400
	40~45HRC	1Dc×0.4Dc	Spindle Revolution (min ⁻¹)	4,800	3,600	2,900	2,400	1,800	1,400	1,100
			Feed Rate (mm/min)	220	220	260	260	250	250	250
	45~50HRC	1Dc×0.3Dc	Spindle Revolution (min ⁻¹)	4,200	3,200	2,500	2,100	1,600	1,300	1,000
			Feed Rate (mm/min)	150	150	180	180	170	170	170
Cast Iron		1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	9,600	7,200	5,700	4,800	3,600	2,900	2,300
			Feed Rate (mm/min)	850	850	1,030	1,030	1,030	1,100	1,380

For Slotting, see page L45

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)