

3RDSL, 4RDSL, 5RDSL

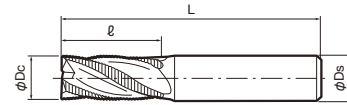
Number of Flutes: 3, 4, 5

General use / Roughing (Long)



Recommended Material

★ 1st Recommendation



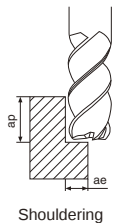
Lineup

(Unit: mm)

Description	Std.	Outside Dia.	Outside Dia. tolerance	Edge Length	Shank Dia.	Total length	Number of Flutes
		øDc		l	øDs	L	Z
3RDSL060-240-06	●	6	-0.030 -0.105	24	6	76	3
3RDSL080-280-08	●	8	-0.040 -0.130	28	8	76	3
4RDSL100-340-10	●	10	-0.040 -0.130	34	10	89	4
4RDSL120-450-12	●	12	-0.050 -0.160	45	12	100	4
4RDSL160-560-16	●	16	-0.050 -0.160	56	16	125	4
4RDSL200-600-20	●	20	-0.065 -0.195	60	20	125	4
5RDSL250-800-25	●	25	-0.065 -0.195	80	25	150	5

Recommended Cutting Conditions

Shouldering



Workpiece Materials		Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
Steel	< 22HRC	2.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	7,800	5,900	4,700	3,900	2,900	2,300	1,900
			Feed Rate (mm/min)	700	700	770	780	840	840	940
	22~32HRC	2.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	6,700	5,000	4,000	3,400	2,500	2,000	1,600
			Feed Rate (mm/min)	500	500	600	600	600	640	720
	32~40HRC	2.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	4,500	3,400	2,700	2,200	1,700	1,300	1,100
			Feed Rate (mm/min)	220	220	290	290	280	280	280
	40~45HRC	2.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	3,400	2,500	2,000	1,700	1,300	1,000	800
			Feed Rate (mm/min)	150	150	180	180	180	180	180
	45~50HRC	2.5Dc×0.3Dc	Spindle Revolution (min ⁻¹)	2,900	2,200	1,800	1,500	1,100	900	700
			Feed Rate (mm/min)	110	110	130	130	120	120	120
Cast Iron		2.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	6,700	5,000	4,000	3,400	2,500	2,000	1,600
			Feed Rate (mm/min)	600	600	720	720	720	770	970

Not Recommended for Slotting.

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