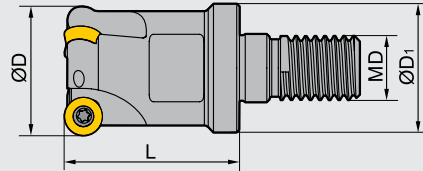
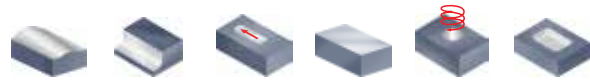


### QCH - RD



Type Typ	Stock Lager	Dimensions (mm) Abmessungen				Insert WSP	No. of teeth Zähne (Z)	Weight Gewicht (kg)	Coolant Kühlung	
		ØD	ØD <sub>1</sub>	L	MD					
<b>QCH</b>	-16-RDKW0702-M8-02	●	16	15	25	8	RDKW0702MO	2	0.027	-
	-16-RDKW0702-M8-03	●	16	15	25	8		3	0.030	
	-20-RDKW0702-M10-03	●	20	19	30	10		3	0.058	
	-25-RDKW0702-M12-03	●	25	24	35	12		3	0.093	
	-20-RDKW10T3-M10-02	●	20	19	30	10	RDKW10T3MO	2	0.054	
	-25-RDKW10T3-M12-02	●	25	24	35	12		2	0.097	
	-32-RDKW10T3-M16-03	●	32	30	45	16		3	0.183	
	-32-RDKW1605-M16-02	●	32	30	45	16		RDKW1605MO	2	
-15-RDKW0702-M8-02	○	15	12.5	23	8	RDKW0702MO	2	-	Internal cooling Innen Kühlung	
-15-RDKW0702-M8-03	○	15	12.5	23	8		3	-		
-20-RDKW0702-M10-04	○	20	18	30	10		4	-		
-25-RDKW0702-M12-05	○	25	21	35	12		5	-		
-20-RDKW1003-M10-02	○	20	18	30	10	RDKW1003MO	2	-		
-25-RDKW1003-M12-02	○	25	21	35	12		2	-		
-25-RDKW1003-M12-03	○	25	21	35	12		3	-		
-30-RDKW1003-M16-04	○	30	29	43	16		4	-		
-35-RDKW1003-M16-04	○	35	29	43	16	4	-			
-42-RDKW1003-M16-05	○	42	29	43	16	5	-			
-24-RDKW12T3-M12-02	○	24	21	35	12	RDKW12T3MO	2	-		
-35-RDKW12T3-M16-03	○	35	29	43	16		3	-		
-42-RDKW12T3-M16-04	○	42	29	43	16		4	-		
-32-RDKW1604-M16-02	○	32	29	43	16		RDKW1604MO	2		-

### ■ Spare parts · Ersatzteile

Insert Durchmesser Ø D	Insert Screw Schraube	Wrench Schlüssel	
RDKW0702MO	I60M2.5×5	WT07IP	--
RDKW10T3MO	I60M4×8	WT15IP	--
RDKW1003MO	I60M3.5×7.7	WT15	--
RDKW12T3MO	I60M3.5×7.7	WT15	--
RDKW1604MO	I60M4.5×10	WT20	--
RDKW1605MO	I60M5×13	--	WT20IT



Applicable tool  
Werkzeug **B11-B18**

Tools code key  
Werkzeug ISO **B26-B27**

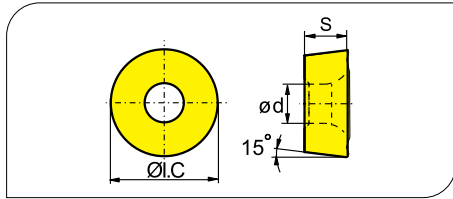
Grade selection guide  
Sortenauswahl **B19-B23**

Technical data  
Technische Daten **B215-B220**

# Milling · Fräsen

## Indexable Milling Tools · Wendepplattenfräser

### Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoff	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert shape / Plattenform	Type / Typ	Dimension (mm) / Abmessung			CVD Coating / CVD Beschicht.				PVD Coating / PVD Beschicht.				Cermet / Cermet	Carbide uncoat. / unbe. Hartmetall											
		I.C.	S	d	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252		YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201	
	RDKW0702MO	7.0	2.38	2.7						●			●	●											
	RDKW0803MO	8.0	3.18	3.4						●				●											
	RDKW1003MO	10.0	3.18	3.9				●		●				●	●										
	RDKW10T3MO	10.0	3.97	4.4	○	●				●				●	●										
	RDKW1204MO	12.0	4.76	4.4	○	●		●		●				●	●	●	○								
	RDKW12T3MO	12.0	3.97	3.9			○	●		●				●	●									○	
	RDKW1604MO	16.0	4.76	5.2						●				●	●										
	RDKW1605MO	16.0	5.56	5.5						●				●	●	●									
RDKW2006MO	20.0	6.35	6.5	●					●			○													

### Recommended cutting data · Empfohlene Schnittdaten

Workpiece material / Werkstück Material	Hardness HB / Härte	Grade / Sorte	V(m/min)	f(mm/z)	a <sub>max</sub> (mm)							
					RDKW07**		RDKW10**		RDKW12**		RDKW16**	
					a <sub>z</sub>	a <sub>p</sub>	a <sub>z</sub>	a <sub>p</sub>	a <sub>z</sub>	a <sub>p</sub>	a <sub>z</sub>	a <sub>p</sub>
P Low-carbon steel / Soft steel / Niedrig legierter Kohlenstoffstahl / Baustahl	≤180	YBM351	220 (180-300)	0.25 (0.15-0.3)	1.6	3.5	2.3	5	3.3	6	3.9	8
		YBG302										
	180-280	YBM351	200 (160-280)	0.25 (0.15-0.3)	1.6	3.5	2.3	5	3.3	6	3.9	8
		YBG202										
280-350	YBM351	180 (150-250)	0.25 (0.15-0.3)	1.6	3.5	2.3	5	3.3	6	3.9	8	
	YBG202											
M Stainless steel / Rostfreier Stahl	≤270	YBM351	150 (100-220)	0.25 (0.1~0.3)	1.6	3.5	2.3	5	3.3	6	3.9	8
		YBG302										
K Cast iron / Gusseisen	180-250	YBM351	210 (120-300)	0.2 (0.1-0.3)	1.6	3.5	2.3	5	3.3	6	3.9	8
		YBG202										

● Ex Stock / ab Lager ○ On demand / auf Anfrage

### Hard alloy toolholder · Hartmetal Verlängerung

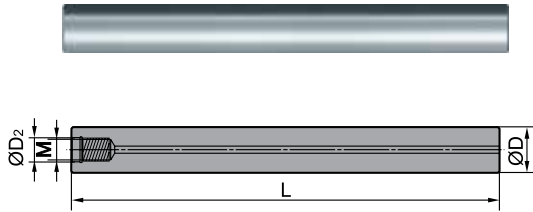


Fig 1

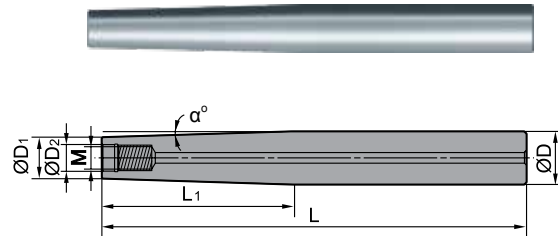


Fig 2

Type Typ	Stock Large	Flg	Dimensions (mm) Abmessungen								
			L	M	ØD <sub>2</sub>	ØD	ØD <sub>1</sub>	L <sub>1</sub>	α°		
G16-QCH-M8-100C	○	1	100	M8	8.5	16	--	--	--		
G16-QCH-M8-150C	○		150			16	--	--	--		
G20-QCH-M8-200C-ZJ90	○	2	200			20	15.5	90	1.3°		
G20-QCH-M8-250C-ZJ115	○		250			20	15.5	115	1°		
G20-QCH-M8-300C-ZJ135	○		300			20	15.5	135	0.85°		
G20-QCH-M10-100C	○	1	100			M10	10.5	20	--	--	--
G20-QCH-M10-150C	○		150					20	--	--	--
G20-QCH-M10-200C	○	200	20					20	--	--	
G25-QCH-M10-200C-ZJ90	○	2	200					25	19.8	90	1.6°
G25-QCH-M10-250C-ZJ115	○		250					25	19.8	115	1.25°
G25-QCH-M10-300C-ZJ135	○		300	25	19.8			135	1.1°		
G25-QCH-M12-100C	○	1	100	M12	12.5			25	--	--	--
G25-QCH-M12-150C	○		150					25	--	--	--
G25-QCH-M12-200C	○	200	25					--	--	--	
G25-QCH-M12-200C-ZJ90	○	2	200					32	24.5	90	2.3°
G25-QCH-M12-250C-ZJ115	○		250			32	24.5	115	1.75°		
G25-QCH-M12-300C-ZJ135	○		300			32	24.5	135	1.5°		
G32-QCH-M16-150C	○	1	150			M16	17	32	--	--	--
G32-QCH-M16-200C	○		200					32	--	--	--
G32-QCH-M16-250C	○	250	32					--	--	--	
G32-QCH-M16-300C	○	300	32					--	--	--	
G32-QCH-M16-200C-ZJ90	○	2	200	32	30			90	0.64°		
G32-QCH-M16-250C-ZJ115	○		250	32	30			115	0.5°		
G32-QCH-M16-300C-ZJ135	○		300	32	30			135	0.4°		

Applicable tool B11-B18  
Werkzeug

Tools code key B26-B27  
Werkzeug ISO

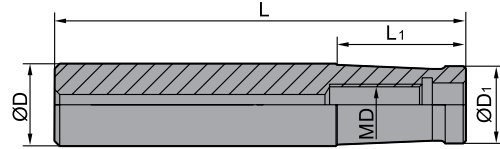
Grade selection guide B19-B23  
Sortenauswahl

Technical data B215-B220  
Technische Daten

# Milling · Fräsen

Indexable Milling Tools · Wendeplattenfräser

## Steel toolholder · Stahl Verlängerung



Type Typ	Stock Large	Dimensions (mm) Abmessungen				
		ØD	L	L <sub>1</sub>	ØD <sub>1</sub>	MD
<b>G16-QCH-M8-80</b>	○	16	80	25	15	M8
<b>G16-QCH-M8-100</b>	○	16	100	45	15	M8
<b>G20-QCH-M10-90</b>	○	20	90	35	18.5	M10
<b>G20-QCH-M10-105</b>	○	20	105	50	18.5	M10
<b>G25-QCH-M12-90</b>	○	25	90	30	24	M12
<b>G25-QCH-M12-110</b>	○	25	110	50	24	M12
<b>G32-QCH-M16-100</b>	○	32	100	35	28.5	M16
<b>G32-QCH-M16-120</b>	○	32	120	55	28.5	M16
<b>G32-QCH-M16-115</b>	○	32	115	40	30	M16
<b>G32-QCH-M16-135</b>	○	32	135	60	30	M16



● Ex Stock / ab Lager ○ On demand / auf Anfrage