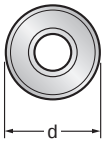
STELLRAM


RDHT20-42-X8


RDHW20-E-X8


RDHW20-S-X8


RDHW20-S-25-X8





Product			Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼					
EDP	Item Description	Grade	Depth of Cut (mm)			d (IC)	l	s	r	h_m min
			a_p max. 10,00	a_p min. - max. 1,00 - 3,00	a_p min. - max. 0,20 - 1,00					
029310	RDHT2006M0E-42-X8	X500	♦■	♦■	-	20,00	-	6,35	10,00	0,08
031533	RDHT2006M0E-42-X8	SP6519	♦●●	♦●●	-	20,00	-	6,35	10,00	0,08
029309	RDHW2006M0E-X8	X500	-	●●●●♦	-	20,00	-	6,35	10,00	0,10
031661	RDHW2006M0S-X8	X500	●●♦	■■■	-	20,00	-	6,35	10,00	0,15
031662	RDHW2006M0S-X8	SP6519	■■■	♦♦♦	-	20,00	-	6,35	10,00	0,15
031660	RDHW2006M0S-25-X8	X500	●●●	-	-	20,00	-	6,35	10,00	0,25
031576	RDHW2006M0S-25-X8	SP6519	♦♦♦	-	-	20,00	-	6,35	10,00	0,25

Machining Choice: ♦ 1st Choice ■ 2nd Choice ● 3rd Choice | Material Guide Key descriptions found on page A5.



INSERT APPLICATION NOTES:

RDHW2006MOE-X8 X500 should be your first choice for medium roughing application when machining Titanium without heavy scale.
RDHW2006M0S-X8 SP6519 should be used when machining Stainless Steel with heavy scale.
RDHW2006M0S-X8 X500 should be used when machining High Temperature Alloys with heavy scale.
RDHT2006M0E-42-X8 should be used when the machine tool has low power available and when the conditions are stable.
RDHW2006M0S-25-X8 should be used for heavy duty applications.

80.0VR00-_R-20 Feeds f_z (mm/tooth)

Geometry	Grade	Operation	Unalloyed Steel	Alloyed Steel	Stainless Steel	Stainless Steel Refractory PH	Gray Iron	Spheroidal-Ducille Iron	Malleable Iron	Aluminium & Alloys <16% Si 116 HBN	Aluminium & Silicon >16% Si 92 HBN	HTA Iron Based Alloys	HTA Cobalt Based Alloys	HTA Nickel Based Alloys	HTA Titanium Based Alloys	Hard Steel >1400 N/mm² >415 HBN	Chilled Cast Iron >1400 N/mm² >400 HBN
			Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.
E-42-X8	X500	Facing	-	-	0,15 - 0,35	0,15 - 0,30	-	-	-	-	-	0,12 - 0,25	0,12 - 0,25	0,12 - 0,25	0,12 - 0,30	-	-
E-42-X8	SP6519	Facing	-	-	0,15 - 0,35	0,15 - 0,28	-	-	-	-	-	0,12 - 0,25	0,12 - 0,25	0,12 - 0,25	0,12 - 0,30	-	-
E-X8	X500	Facing	0,20 - 0,30	0,18 - 0,28	0,20 - 0,40	0,20 - 0,30	0,20 - 0,35	0,20 - 0,35	0,20 - 0,30	-	-	0,20 - 0,28	0,20 - 0,28	0,20 - 0,28	0,20 - 0,32	-	-
S-X8	X500	Facing	0,25 - 0,45	0,25 - 0,35	0,25 - 0,45	0,25 - 0,32	0,25 - 0,45	0,25 - 0,45	0,25 - 0,40	-	-	0,25 - 0,32	0,25 - 0,32	0,25 - 0,32	0,25 - 0,35	-	-
S-X8	SP6519	Facing	0,25 - 0,45	0,25 - 0,35	-	-	0,25 - 0,45	0,25 - 0,45	0,25 - 0,40	-	-	-	-	-	-	-	-
S-25-X8	X500	Facing	0,35 - 0,60	0,35 - 0,50	-	-	0,35 - 0,60	0,35 - 0,55	0,35 - 0,45	-	-	-	-	-	-	-	-
S-25-X8	SP6519	Facing	0,35 - 0,55	0,35 - 0,45	-	-	0,35 - 0,55	0,35 - 0,50	0,35 - 0,40	-	-	-	-	-	-	-	-

Speed recommendations can be found on page A158.