



**Vielseitige Performance
und lange Standzeit**



Für Fräser mit runden WSP

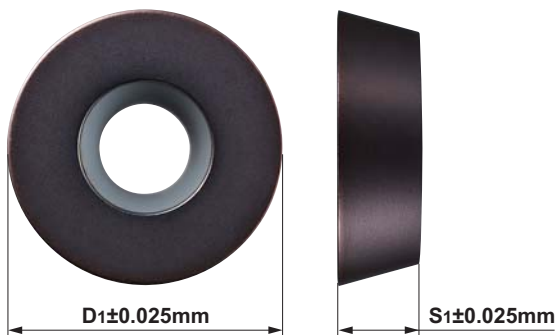
RDH/M/ZX WSP

Eigenschaften

RDZX WSP

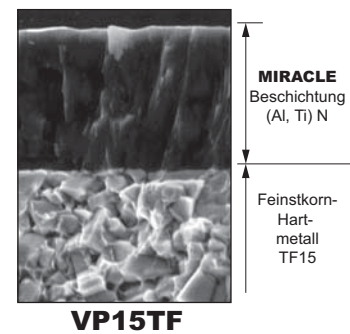
Hohe Präzision

RDZX-Wendeschneidplatten zeichnen sich durch höchste Genauigkeit der E-Toleranz aus, die ohne Umfangsschleifen erreicht wird.



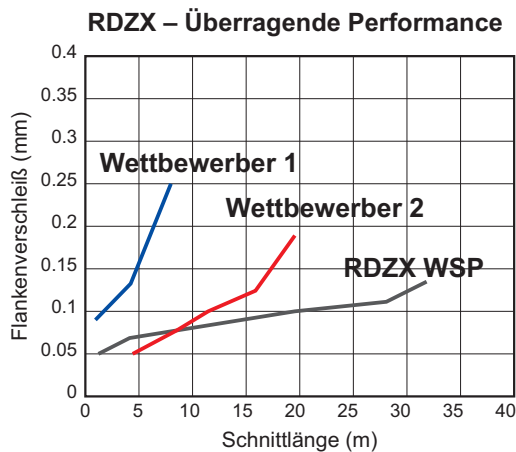
WSP mit extralanger Standzeit

WSP mit **VP15TF MIRACLE**-Beschichtung für stabile Bearbeitung.



Schnittleistung

Längere Standzeiten dank der Miracle-beschichteten Sorte VP15TF.



<Schnittdaten>

Werkstoff : DIN X40CrMoV51
Fräser : RRD050R202S20ZM
WSP : RDZX1003M0E
Typ : VP15TF
Schnittgeschw. : 200m/min.
Vorschub : 0.15mm/tooth

Zustellung : 5mm
Schnitttiefe : 0.5mm
Luftgebläse

Geeignet für RRD Fräser

Zylinderschaft



Weldonschaft



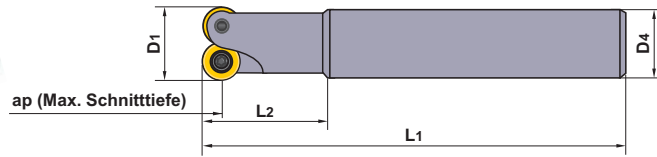
Einschraubfräser



Aufsteckfräser



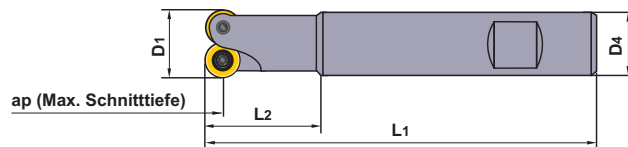
Zylinderschaft



Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager		Abmessungen (mm)					Spanschraube	Schlüssel	WSP
		R	Anz. Zähne	D1	D4	L1	L2	ap			
2.5	RRD025R102S10Z-B20	●	2	10	10	75	23	2.5	B-TS20	TKY06F	RDH/Z 0501M0
	123S12Z-B20	●	3	12	12	75	23	2.5	B-TS20	TKY06F	
	154S16Z-B20	●	4	15	16	80	23	2.5	B-TS20	TKY06F	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	122S12Z	●	2	12	12	75	23	3.5	TS253	TKY08F	
	122S16Z	●	2	12	16	88	15	3.5	TS253	TKY08F	
	122S16ZL	●	2	12	16	128	15	3.5	TS253	TKY08F	
	122S16ZM	●	2	12	16	108	15	3.5	TS253	TKY08F	
3.5	RRD035R152S16Z	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	152S16ZM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	152S20Z	●	2	15	20	130	20	3.5	TS25	TKY08F	
	152S20ZM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	152S25Z	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S12Z	●	3	15	12	75	17	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	153S16Z	●	3	15	16	78	30	3.5	TS253	TKY08F	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	202S20ZM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	202S25Z	●	2	20	25	136	72	5.0	B-TS35	TKY15F	
	202S25ZL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	202S25ZM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	

Weldonschaft

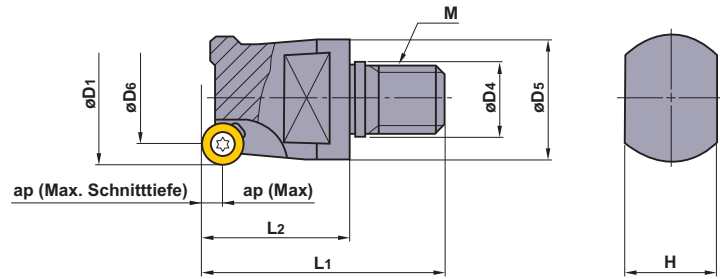


Nur Rechtsausführung.





R (mm)	Bestellbezeichnung	Lager		Abmessungen (mm)					Spanschraube	Schlüssel	WSP
		R	Anz. Zähne	D1	D4	L1	L2	ap			
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	122S16WL	●	2	12	16	128	15	3.5	TS253	TKY08F	
	122S16WM	●	2	12	16	108	15	3.5	TS253	TKY08F	
3.5	RRD035R152S16W	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	152S16WM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	152S20W	●	2	15	20	130	20	3.5	TS25	TKY08F	
	152S20WM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	152S25W	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S16W	●	3	15	16	78	30	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
5	RRD050R202S20W	●	2	20	20	90	19	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	202S20WM	●	2	20	20	110	20	5.0	B-TS35	TKY15F	
	202S25W	●	2	20	25	135	23	5.0	B-TS35	TKY15F	
	202S25WL	●	2	20	25	176	23	5.0	B-TS35	TKY15F	
	202S25WM	●	2	20	25	156	23	5.0	B-TS35	TKY15F	

● : Lagerstandard.

Einschraubfräser

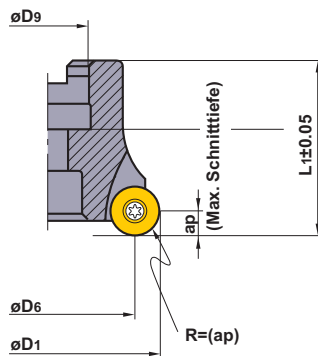


Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager R	Anz. Zähne	Abmessungen (mm)								   				
				D1	D6	L1	L2	D4	D5	M	ap	H	Spannschraube	Spannschraube	Schlüssel	WSP
2.5	RRD025R102M5-B20	●	2	10	5	35	20	5.5	9.9	M5	2.5	6	B-TS20	—	TKY06F	RDH/Z 0501M0
	123M8-B20	●	3	12	7	38	20	8.5	13.5	M8	2.5	9	B-TS20	—	TKY06F	
	154M8-B20	●	4	15	10	38	20	8.5	13.5	M8	2.5	10	B-TS20	—	TKY06F	
	205M10-B20	●	5	20	15	44	25	10.5	18	M10	2.5	15	B-TS20	—	TKY06F	
3.5	RRD035R122M8	●	2	12	5	46	28	8.5	13.5	M8	3.5	9	TS253	—	TKY08F	RDH/M/Z 07T1M0
	153M8	●	3	15	8	46	28	8.5	13.5	M8	3.5	10	TS253	—	TKY08F	
	204M10	●	4	20	13	47	28	10.5	18	M10	3.5	15	TS253	—	TKY08F	
	255M12	●	5	25	18	50	28	12.5	21	M12	3.5	17	TS253	—	TKY08F	
	306M16	●	6	30	23	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
3.5	RRD035R152M8	●	2	15	8	46	28	8.5	13.5	M8	3.5	10	TS25	—	TYK08F	RDH/M/Z 0702M0
	153M8X	●	3	15	8	43	28	8.5	13.5	M8	3.5	10	TS25	—	TYK08F	
5	RRD050R202M10	●	2	20	10	47	28	10.5	18	M10	5.0	15	B-TS35	—	TYK15F	RDH/M/Z 1003M0
	252M12	●	2	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TYK15F	
	253M12	●	3	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TYK15F	
	304M12	●	4	30	20	54	32	12.5	21	M12	5.0	17	B-TS35	—	TYK15F	
	304M16	●	4	30	20	55	32	17	29	M16	5.0	22	B-TS35	—	TYK15F	
	355M16	●	5	35	25	65	42	17	29	M16	5.0	22	B-TS35	—	TYK15F	
6	RRD060R242M12	●	2	24	12	54	32	12.5	21	M12	6.0	17	B-TS35	—	TYK15F	RDH/M/Z 12T3M0
	353M16	●	3	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TYK15F	
	354M16	●	4	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TYK15F	
	424M16	●	4	42	30	55	32	17	29	M16	6.0	24	B-TS35	TS1001	TYK15F	
	425M16	●	5	42	30	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TYK15F	
8	RRD080R322M16	●	2	32	16	65	42	17	29	M16	8.0	22	214	—	TYK20F	RDH/M/Z 1604M0

RRD N

Aufsteckfräser (Neutral)

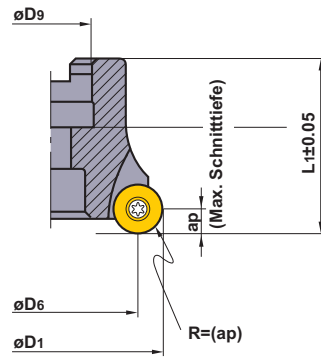


Nur Rechtsausführung.







R (mm)	Bestellbezeichnung	Lager	Anz. Zähne	Abmessungen (mm)					Gewicht (kg)	Zubehör					
				D1	D6	L1	D9	ap		Unterlegscheibe	Unterlegschraube	Spannschraube	Spannschraube	Schlüssel	WSP
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	—	—	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	-052A07R	●	7	52	42	50	22	5	0.4	—	—	B-TS35	—	TKY15F	
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0
	-050A05R	●	5	50	38	50	22	6	0.38	—	—	B-TS35	TS1001	TKY15F	
	-052A05R	●	5	52	40	50	22	6	0.4	—	—	B-TS35	TS1001	TKY15F	
	-063A06R	●	6	63	51	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	
8	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	KS12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	-052A04R	●	4	52	36	50	22	8	0.4	KS12	B-TS45	214	—	TKY20F	
	-052A05R	●	5	52	36	50	22	8	0.4	KS12	B-TS45	214	—	TKY20F	
	-063A05R	●	5	63	47	50	22	8	0.58	KS12	B-TS45	214	—	TKY20F	
	-066A05R	●	5	66	50	50	27	8	0.6	KS12	B-TS45	214	—	TKY20F	
	-080A06R	●	6	80	64	52	27	8	1	KS12	B-TS45	214	—	TKY20F	
	-100A07R	●	7	100	84	52	32	8	1.5	KS12	B-TS45	214	—	TKY20F	
	-125B08R	●	8	125	109	52	40	8	2.5	KS12	B-TS45	214	—	TKY20F	
-160C09R	●	9	160	144	52	40	8	3.5	KS12	B-TS45	214	—	TKY20F		

RRD P

Aufsteckfräser (Positiv)



Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager R	Anz. Zähne	Abmessungen (mm)					Gewicht (kg)						
				D1	D6	L1	D9	ap		Unterlegscheibe	Unterlegschraube	Spannschraube	Spannschraube	Schlüssel	WSP
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0E
	-052A05R	●	5	52	40	50	22	6	0.35	—	—	B-TS35	TS1001	TKY15F	
	-063A06R	●	6	63	51	50	22	6	0.58	—	—	B-TS35	TS1001	TKY15F	
	-066A06R	●	6	66	54	52	27	6	0.6	—	—	B-TS35	TS1001	TKY15F	
	-080A07R	●	7	80	68	50	27	6	1.0	—	—	B-TS35	TS1001	TKY15F	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	KS12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0E
	-063A05R	●	5	63	47	50	22	8	0.53	KS12	B-TS45	214	—	TKY20F	
	-066A05R	●	5	66	50	50	27	8	0.55	KS12	B-TS45	214	—	TKY20F	
	-080A06R	●	6	80	64	52	27	8	1.0	KS12	B-TS45	214	—	TKY20F	
	-100A07R	●	7	100	84	52	32	8	1.5	KS12	B-TS45	214	—	TKY20F	
	-125B08R	●	8	125	109	52	40	8	2.6	KS12	B-TS45	214	—	TKY20F	
	-160C09R	●	9	160	144	52	40	8	3.5	KS12	B-TS45	214	—	TKY20F	

SCHNITTDATEN FÜR DAS SCHRUPPEN (ae = 50 % des Ø)

Werkstoff	Härte	Typ	Schnittgeschw. (m/min)	Ø 10–15mm		Ø 20mm		Ø 24–25mm		Ø 30–42mm		Ø 50–80mm		Ø 100–160mm	
				ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)
P Allg. Baustahl	≤180HB	NX4545	(260–360)	–0.2	0.25	–0.5	0.45	–1.0	0.35	–1.0	0.40	–1.0	0.50	–1.5	0.60
		F7030	(240–320)	0.2–0.3	0.20	0.5–1.0	0.25	1.0–2.0	0.30	1.5–2.0	0.32	1.0–1.5	0.40	1.5–2.5	0.45
		VP15TF	(220–280)	0.3–0.5	0.12	1.0–1.5	0.15	2.0–2.5	0.20	2.0–3.0	0.25	1.5–3.0	0.35	2.5–5.0	0.35
C-Stahl Leg. Stahl	180–350HB	NX4545	(250–350)	–0.2	0.20	–0.5	0.40	–1.0	0.30	–1.0	0.40	–1.0	0.50	–1.5	0.55
		F7030	(230–310)	0.2–0.3	0.15	0.5–1.0	0.20	1.0–1.5	0.25	1.5–2.0	0.30	1.0–1.5	0.38	1.5–2.5	0.40
		VP15TF	(210–270)	0.3–0.5	0.10	1.0–1.5	0.10	1.5–2.0	0.22	2.0–3.0	0.22	1.5–3.0	0.30	2.5–4.5	0.32
M Rostfreier Stahl	≤270HB	F7030 VP20M	(180–240)	–0.1	0.15	–0.5	0.20	–1.0	0.20	–1.0	0.25	–1.0	0.25	–1.5	0.30
			(160–200)	0.1–0.2	0.15	0.5–1.0	0.15	1.0–2.0	0.18	1.5–2.0	0.20	1.0–1.5	0.22	1.5–2.5	0.25
			(140–180)	0.2–0.25	0.10	1.0–1.5	0.12	2.0–2.5	0.14	2.0–3.0	0.15	1.5–3.0	0.18	2.5–5.0	0.20
K Guss	Zug- festigkeit ≤450N/mm ²	VP15TF	(200–300)	–0.1	0.15	–0.5	0.18	–1.0	0.20	–1.0	0.25	–1.0	0.30	–1.5	0.35
		VP20M	(200–280)	0.1–0.2	0.10	0.5–1.0	0.10	1.0–1.5	0.15	1.5–2.0	0.18	1.0–1.5	0.25	1.5–2.5	0.22
		VP10H	(180–240)	0.2–0.25	0.10	1.0–1.5	0.10	1.5–2.0	0.12	2.0–3.0	0.15	1.5–3.0	0.18	2.5–4.5	0.20
H Gehärteter Stahl	–52HRC –58HRC –60HRC	VP15TF	(150–200)	–0.1	0.12	–0.1	0.14	–0.1	0.15	–0.1	0.18	–0.1	0.18	–0.1	0.20
		VP10H	(120–180)	0.1–0.15	0.10	0.1–0.20	0.12	0.1–0.30	0.12	0.1–0.30	0.14	0.1–0.30	0.14	0.1–0.30	0.15
		VP05HT	(100–180)	0.1–0.15	0.10	0.1–0.20	0.10	0.1–0.30	0.10	0.1–0.30	0.12	0.1–0.30	0.12	0.1–0.30	0.12

*1 Bei Verwendung der vollen Zustellung müssen die Schnittdaten um 20 % verringert werden.

*2 Bei langer Auskrägung muss der Vorschub um 20 % reduziert werden.

SCHNITTDATEN FÜR DAS SCHLICHTEN (ae = 20 % des Ø)

Werkstoff	Härte	Typ	Schnittgeschw. (m/min)	Ø 10–15mm		Ø 20mm		Ø 24–25mm		Ø 30–42mm		Ø 50–80mm		Ø 100–160mm	
				ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)	ap (mm)	fz (mm/U)
P Allg. Baustahl	≤180HB	NX4545	(250–320)	–0.1	0.15	–0.15	0.20	–0.15	0.25	–0.15	0.30	–0.15	0.32	–0.3	0.35
		F7030	(240–300)	0.1–0.2	0.15	0.1–0.2	0.15	0.1–0.2	0.18	0.1–0.3	0.20	0.1–0.3	0.22	0.2–0.3	0.25
		VP15TF	(200–280)	0.2–0.24	0.10	0.1–0.30	0.15	0.1–0.30	0.18	0.1–0.30	0.20	0.2–0.30	0.20	0.3–0.40	0.20
C-Stahl Leg. Stahl	180–350HB	NX4545	(220–300)	–0.1	0.12	–0.1	0.15	–0.1	0.18	–0.1	0.25	–0.1	0.28	–0.15	0.30
		F7030	(200–290)	0.1–0.15	0.12	0.1–0.30	0.15	0.1–0.30	0.15	0.1–0.30	0.20	0.1–0.3	0.22	0.15–0.3	0.25
		VP15TF	(160–250)	0.15–0.2	0.10	0.15–0.30	0.12	0.15–0.30	0.15	0.15–0.30	0.15	0.2–0.3	0.18	0.2–0.3	0.18
M Rostfreier Stahl	≤270HB	F7030 VP20M	(180–240)	–0.1	0.12	–0.1	0.18	–0.1	0.20	–0.1	0.22	–0.1	0.25	–0.15	0.30
			(160–200)	0.1–0.2	0.10	0.1–0.30	0.12	0.1–0.3	0.15	0.1–0.3	0.18	0.1–0.3	0.20	0.15–0.3	0.22
			(140–180)	0.2–0.25	0.10	0.2–0.30	0.10	0.2–0.3	0.12	0.2–0.3	0.12	0.2–0.3	0.15	0.2–0.3	0.18
K Guss	Zug- festigkeit ≤450N/mm ²	VP15TF	(200–250)	–0.1	0.15	–0.1	0.18	–0.1	0.20	–0.1	0.22	–0.1	0.25	–0.15	0.30
		VP20M	(180–230)	0.1–0.2	0.10	0.1–0.30	0.10	0.1–0.3	0.15	0.1–0.3	0.15	0.1–0.3	0.20	0.15–0.3	0.22
		VP10H	(160–200)	0.2–0.25	0.10	0.2–0.40	0.10	0.2–0.4	0.12	0.2–0.4	0.12	0.2–0.4	0.15	0.2–0.4	0.18
H Gehärteter Stahl	–52HRC –58HRC –60HRC	VP15TF	(140–200)	–0.1	0.15	–0.1	0.14	–0.1	0.15	–0.1	0.18	–0.1	0.18	–0.1	0.20
		VP10H	(110–180)	0.1–0.15	0.10	0.1–0.20	0.12	0.1–0.30	0.12	0.1–0.30	0.14	0.1–0.30	0.14	0.1–0.30	0.15
		VP05HT	(100–170)	0.1–0.15	0.10	0.1–0.20	0.10	0.1–0.30	0.10	0.1–0.30	0.12	0.1–0.30	0.12	0.1–0.30	0.12

*1 Bei Verwendung der vollen Zustellung müssen die Schnittdaten um 20 % verringert werden.

*2 Bei langer Auskrägung muss der Vorschub um 20 % reduziert werden.



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