

Advanced
Engineering

Hitachi Tool

HITACHI
Inspire the Next

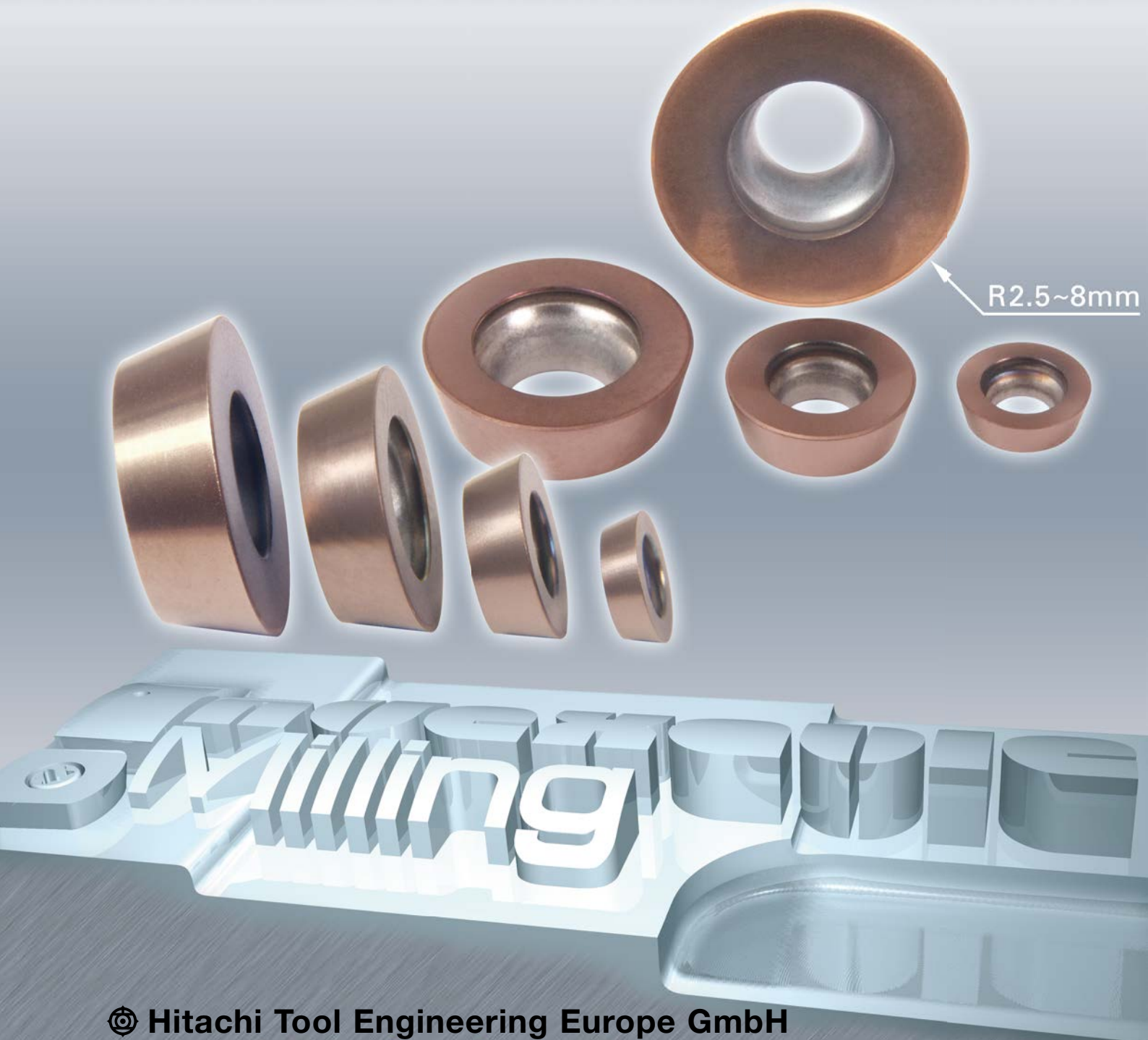
Indexable
Milling
+ Modular Series

No. 331

NEW

HITACHI Round Inserts

Ø 5 ~ 16 · For Multi Usage

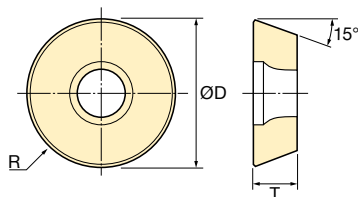
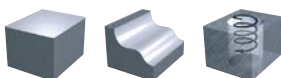
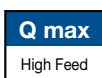


R2.5~8mm

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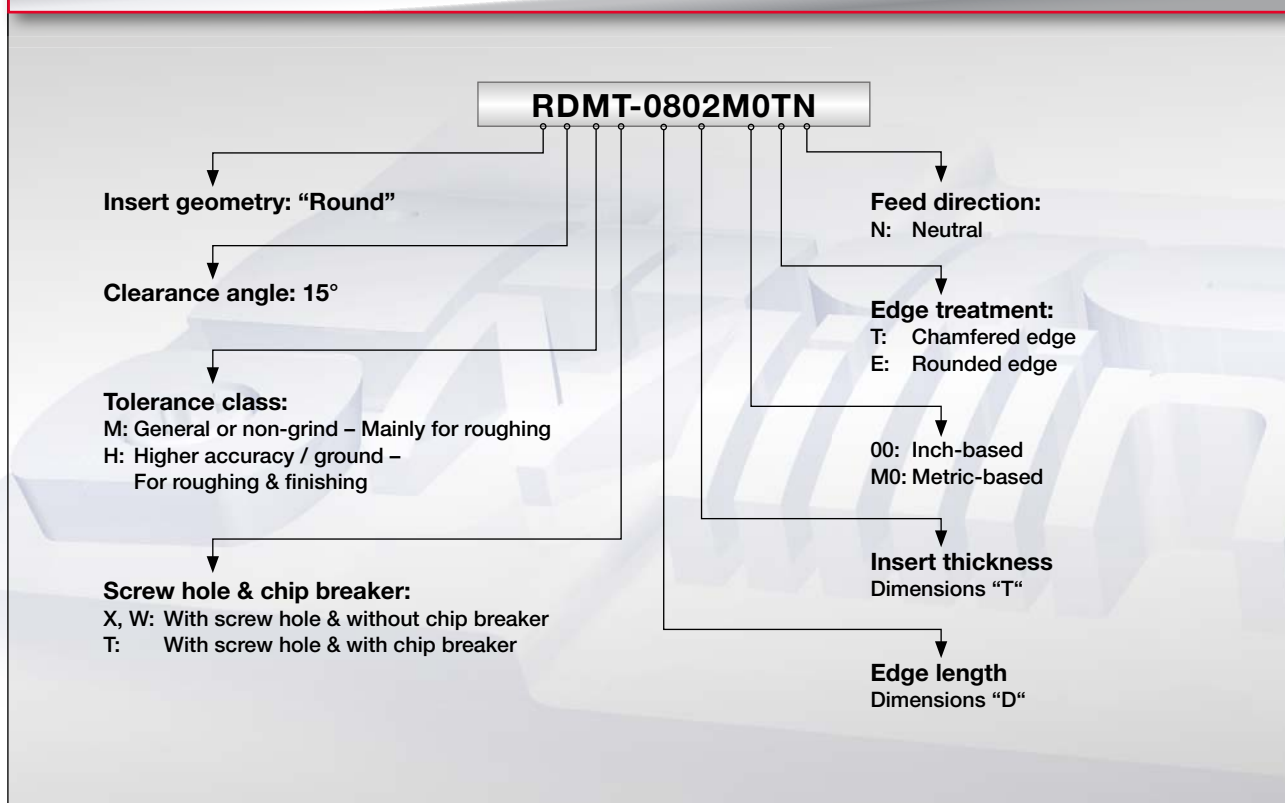
Indexable Milling Inserts

RDXX | Round Inserts for Indexable Milling Tools



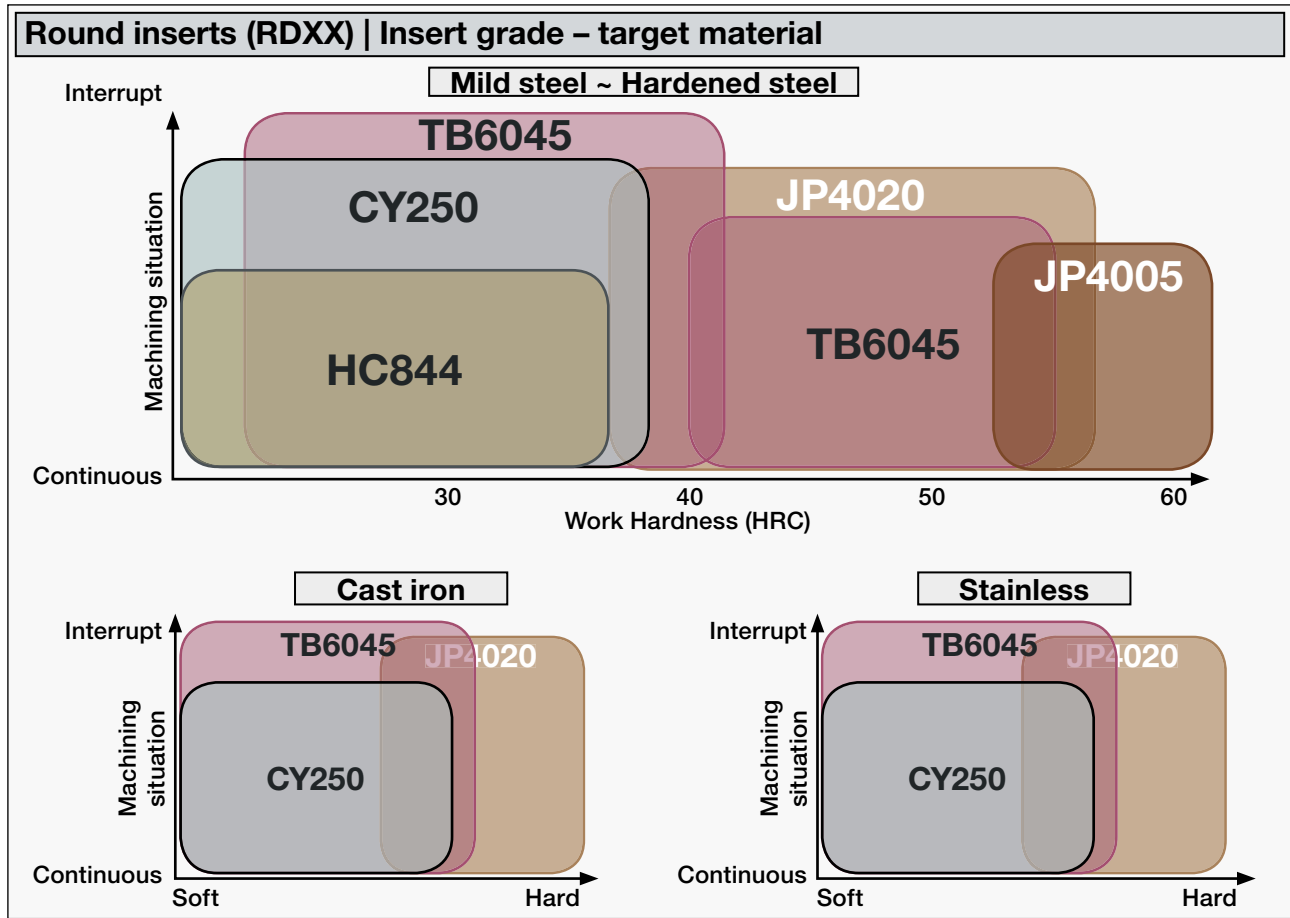
Tolerance Class	Chip breaker	Inserts	Dimensions				ATH Coat	JP Coat	TB Coat		PCA Coat	G Coat
			D	R	T	Clamp Screw	JP4005	JP4020	TB6020	TB6045	CY250	HC844
NEW H-class (with peripheral grind)	-	RDHX-0501M0EN	5	2.5	1.50	M2	WF222	WF221	ID Code			
		RDHX-07T1M0TN	7	3.5	1.99	M2.5	WF224	WF223				
		RDHX-0702M0TN	7	3.5	2.38	M2.5	WF226	WF225				
		RDHX-1003M0TN	10	5	3.18	M3.5	WF228	WF227				
		RDHX-12T3M0TN	12	6	3.97	M3.5	WF230	WF229				
M-class (No peripheral grind)	•	RDMT-0802M0TN	8	4	2.38	M3					WF477	
		RDMW-1003M0TN	10	5	3.18	M3.5			WF158	WF159	WF581	
		RDMT-10T3M0TN	10	5	3.97	M4					WF480	
		RDMW-12T3M0TN	12	6	3.97	M3.5			WF160	WF161	WF545	WF546
		RDMT-12T3M0TN	12	6	3.97	M3.5					WF509	
		RDMT-1204M0TN	12	6	4.76	M4		WF213				
		RDMT-1604M0TN	16	8	4.76	M5		WF214				
		RDMW-1604M0TN	16	8	4.76	M5			WF162	WF163	WF543	WF544

Round Inserts: General Information about Item Codes



Indexable Milling Inserts

RDXX | Round Inserts for Indexable Milling Tools



RDXX | Round Inserts | Recommended Cutting Conditions

Work piece material	Recommend grade & Target hardness (HRC)			Emulsion	Mist	Air	Parameter	R2.5/Ø5		RR3.5/Ø7		R4/Ø8		R5/Ø10		R6/Ø12		R8/Ø16			
	30	40	50					General	High Feed	General	High Feed	General	High Feed	General	High Feed	General	High Feed	General	High Feed	General	High Feed
								V_c	f_z	a_p	V_c	f_z	a_p	V_c	f_z	a_p	V_c	f_z	a_p	V_c	f_z
I Carbon-Steel <30HRC	CY250						V_c (m/min)	250	250	250	250	250	250	250	250	250	250	250	250	250	250
	HC844						f_z feed/tooth	0.2	0.3	0.4	0.5	0.4	0.6	0.5	0.8	0.5	0.8	0.6	1		
	TB6045						a_p (mm)	0.8	0.4	1	0.5	1.2	0.6	1.6	0.8	2	1.2	3	1.5		
III Alloy-Steel 30~40HRC	CY250						V_c (m/min)	200	200	200	200	200	200	200	200	200	200	200	200	200	200
	HC844						f_z feed/tooth	0.2	0.4	0.4	0.5	0.4	0.6	0.5	0.8	0.5	0.8	0.6	1		
	TB6045						a_p (mm)	0.6	0.3	0.8	0.4	1	0.6	1.2	0.6	1.8	0.9	2.5	1.2		
IV Pre-Hardened steel 40~50HRC			TB6020				V_c (m/min)	160	160	160	160	160	160	160	160	160	160	160	160	160	160
			JP4020				f_z feed/tooth	0.15	0.25	0.25	0.4	0.25	0.4	0.35	0.5	0.35	0.5	0.4	0.6		
			TB6045				a_p (mm)	0.4	0.25	0.5	0.25	0.7	0.35	0.8	0.4	1	0.5	1.4	0.7		
V Hardened steel 50~55HRC			JP4005				V_c (m/min)	120	120	120	120	120	120	120	120	120	120	120	120	120	120
			TB6020				f_z feed/tooth	0.15	0.25	0.25	0.4	0.25	0.4	0.35	0.5	0.35	0.5	0.4	0.6		
			JP4020				a_p (mm)	0.3	0.15	0.4	0.2	0.5	0.25	0.6	0.3	0.8	0.4	1	0.5		
V Hardened steel > 55HRC			JP4005				V_c (m/min)	80	80	80	80	80	80	80	80	80	80	80	80	80	80
			JP4020				f_z feed/tooth	0.1	0.15	0.15	0.2	0.15	0.2	0.2	0.25	0.2	0.3	0.25	0.4		
							a_p (mm)	0.2	0.1	0.3	0.15	0.4	0.2	0.5	0.25	0.6	0.3	0.8	0.4		
VI Cast-Iron GG EN-JL10**			JP4020				V_c (m/min)	200	200	200	200	200	200	200	200	200	200	200	200	200	200
			TB6045				f_z feed/tooth	0.2	0.4	0.4	0.5	0.4	0.6	0.5	0.8	0.5	0.8	0.6	1		
			CY250				a_p (mm)	0.5	0.3	1	0.5	1.2	0.6	1.6	0.8	2	1.2	3	1.5		
VI Cast-Iron GGG EN-JS10**			JP4020				V_c (m/min)	150	150	150	150	150	150	150	150	150	150	150	150	150	150
			TB6045				f_z feed/tooth	0.2	0.4	0.4	0.5	0.4	0.6	0.5	0.8	0.5	0.8	0.6	1		
			CY250				a_p (mm)	0.5	0.3	1	0.5	1.2	0.6	1.6	0.8	2	1.2	3	1.5		
VII Stainless Steels			JP4020				V_c (m/min)	200	200	200	200	200	200	200	200	200	200	200	200	200	200
			TB6045				f_z feed/tooth	0.2	0.4	0.4	0.5	0.4	0.6	0.5	0.8	0.5	0.8	0.6	1		
			CY250				a_p (mm)	0.5	0.3	1	0.5	1.2	0.6	1.6	0.8	2	1.2	3	1.5		

Product Range

Solid Carbide End Mills

micro**EndMill**

CBN
Cubic Boron Nitride

HD
COATING

Epoch21

MINIATURE

3D-Cut

Indexable Milling Tools

Indexable
Milling

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Milling Chucks

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