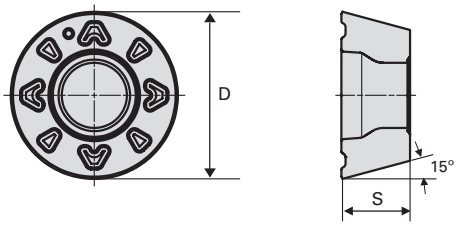
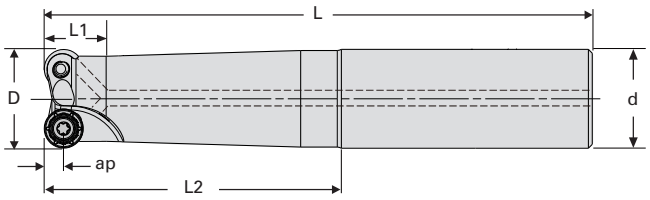
RDKW 0802



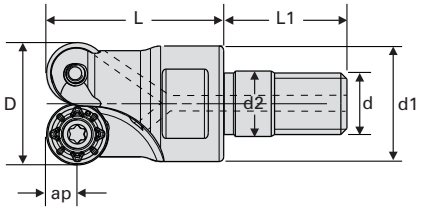
Designation	Grade	Dimensions			
		l	D	S	r
RDKW 0802M0	YG602	-	8.00	2.38	-

RDKW 0802 / Shank



Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-16Z2S16P160-08	16	16	12	60	160	2	4	Plain	Y	RDKT(W) 08	TP082505	TPWFTP08
YGR1-20Z2S20P180-08	20	20	12	80	180	2	4	Plain	Y	RDKT(W) 08		
YGR1-25Z3S20P180-08	25	20	-	40	180	3	4	Plain	Y	RDKT(W) 08		

RDKW 0802 / Modular

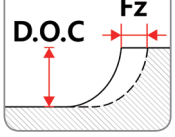


Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-16Z2M08-08	16	M8	13	8.5	23	16	2	4	Y	RDKT(W) 08	TP082505	TPWFTP08
YGR1-20Z2M10-08	20	M10	18	10.5	30	18	2	4	Y	RDKT(W) 08		
YGR1-25Z3M12-08	25	M12	21	12.5	35	20	3	4	Y	RDKT(W) 08		

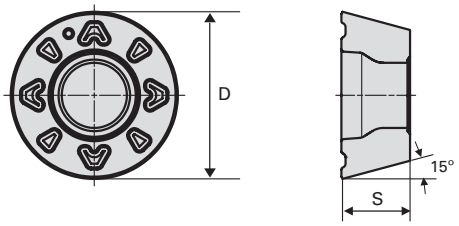
RDKW 0802 Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.41	190	330	260	0.5	2.5	0.8
	Low Alloys	200	0.15	0.50	0.33	150	240	195	0.5	2.5	0.8
	High Alloys	220	0.12	0.44	0.28	90	150	120	0.5	1.8	0.6
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	0.8
H	Hardened Materials	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

* D.O.C: Depth Of Cut

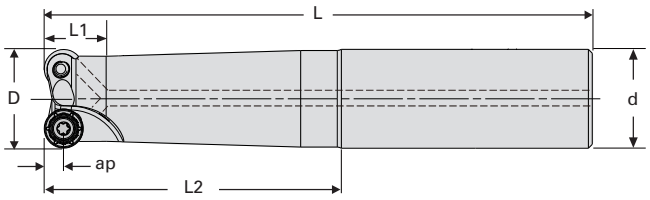


RDKW 10T3



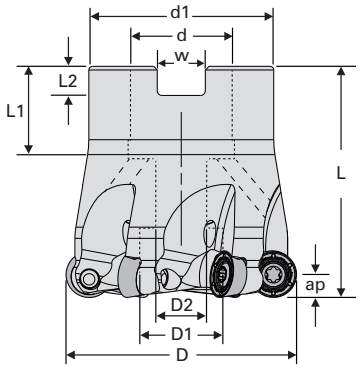
Designation	Grade	Dimensions			
		l	D	S	r
RDKW 10T3M0	YG602	-	10.00	3.97	-

RDKW 10T3 / Shank



Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-20Z2S20P180-10	20	20	15	80	180	2	5	Plain	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z2S25P180-10	25	25	15	80	180	2	5	Plain	Y	RDKT(W) 10		

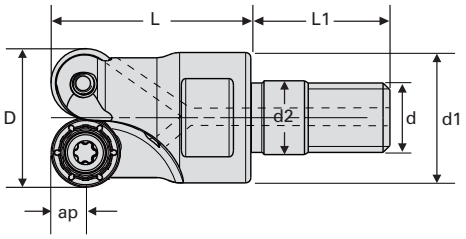
RDKW 10T3 / Cutter



Designation	Dimensions											
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	Coolant
YGR1-40Z5C16-10	40	14	9	16	32	8.4	40	18	5.6	2.5	5	Y
YGR1-50Z6C22-10	50	18	11	22	40	10.4	50	20	6.3	2.5	6	Y

Insert	Spare parts	
	Screw	Wrench
RDKT(W) 10	TP154808	TPWFTP15

RDKW 10T3 / Modular

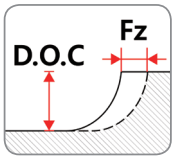


Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-20Z2M10-10	20	M10	18	10.5	30	18	2	5	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z3M12-10	25	M12	21	12.5	35	20	3	5	Y	RDKT(W) 10		

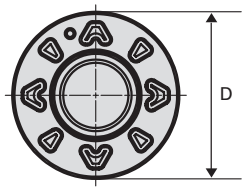
RDKW 10T3 Recommended Cutting Condition

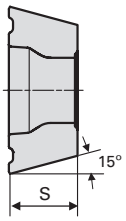
Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
H	Hardened Materials	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

* D.O.C: Depth Of Cut



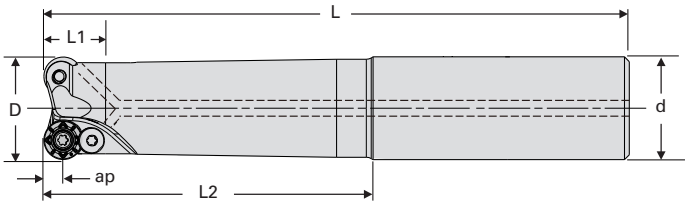
RDKW 1204





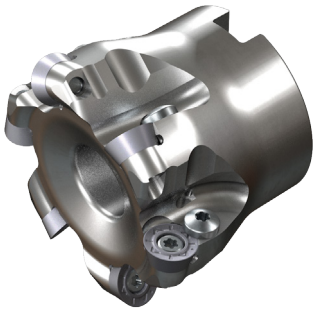
Designation	Grade	Dimensions			
		l	D	S	r
RDKW 1204M0	YG602	-	12.00	4.76	-

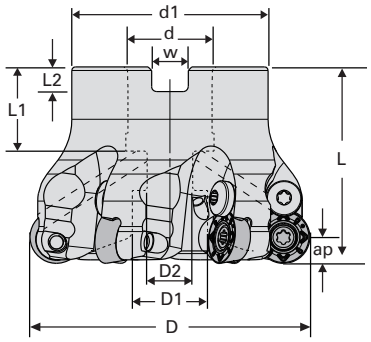
RDKW 1204 / Shank



Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-25Z2S25P180-12	25	25	18	80	180	2	6	Plain	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z2S32P200-12	32	32	18	100	200	2	6	Plain	Y	RDKT(W) 12		
YGR1-32Z3S32P160-12	32	32	18	60	160	3	6	Plain	Y	RDKT(W) 12		

RDKW 1204 / Cutter

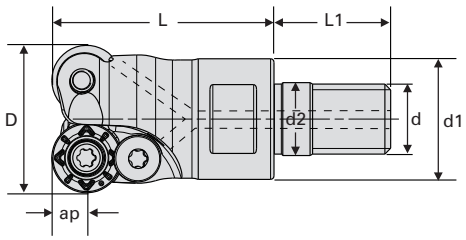




Designation	Dimensions											
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	Coolant
YGR1-40Z4C16-12	40	13.8	9	16	32	8.4	40	18	5.6	4	4	Y
YGR1-50Z5C22-12	50	18	11	22	40	10.4	50	20	6.3	4	5	Y
YGR1-63Z6C22-12	63	18	11	22	48	10.4	50	20	6.3	4	6	Y

Insert	Spare parts	
	Screw	Wrench
RDKT(W) 12	TP154009 + TP153507	TPWFTP15

RDKW 1204 / Modular

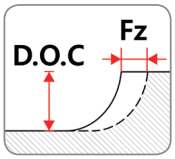


Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-25Z2M12-12	25	M12	21	12.5	35	20	2	6	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z3M16-12	32	M16	29	17	42	22	3	6	Y	RDKT(W) 12		

RDKW 1204 Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
H	Hardened Materials	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7

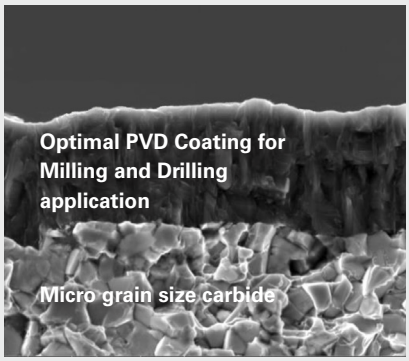
* D.O.C: Depth Of Cut



Features of Grades :

YG-1 Universal grades, designs for multi-purpose application and extremely efficient in covering materials including Steels, Stainless Steels and Cast Iron.

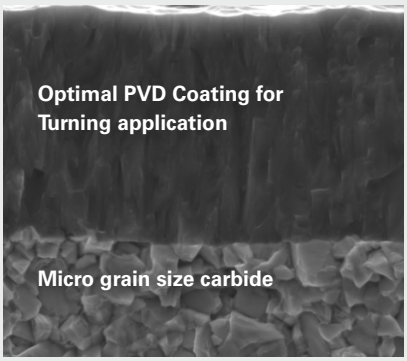
YG602



Exclusive PVD coating / Unique Substrate for MILLING and DRILLING Application

- Ultra dense PVD coating with optimal thermal resistance & added strength
- Sub-micron substrate designed for demanding application

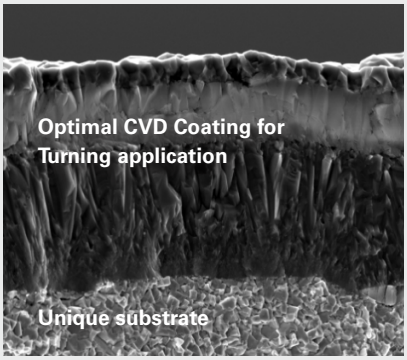
YG801



Exclusive PVD coating / Unique Substrate for TURNING Application

- Unique PVD coating and substrate designed to balance edge strength & wear resistance for continuous machining.
- Excellent cutting performance under harsh machining condition.

YG1001



Unique Substrate / CVD coating for TURNING Application

- Thick coating optimized for Cast iron applications and harsh machining condition.
- Advanced CVD coating with optimal thermal & wear resistance for turning applications.
- Exceptional cutting performance attributed to combination of carbide substrate and coating.

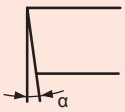
Grade	P	M	K	S
YG602	P30-40	M20-30	K20-30	S10-20
YG801	P20-40	M20-40	K10-25	S05-25
YG1001	-	-	K10-25	-

S	P	K	N
1	2	3	4

1 Insert Shape

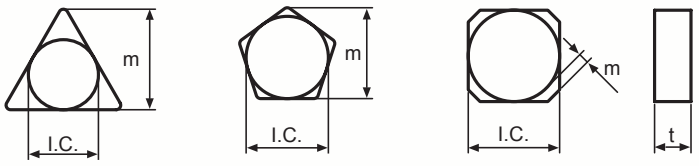
							
A	B	C	D	E	H	K	L
						Special	
O	P	R	S	T	W	X	

2 Clearance Angle

	5°	7°	15°	20°	25°	30°	0°	11°
	B	C	D	E	F	G	N	P

3 Tolerance

	Tolerance			I.C. Size					
	m	t	I.C.	6.35	9.525	12.7	15.875	19.05	25.4
A	± 0.005	± 0.025	± 0.025	●	●	●	●	●	●
C	± 0.013	± 0.025	± 0.025	●	●	●	●	●	●
E	± 0.025	± 0.025	± 0.025	●	●	●	●	●	●
F	± 0.005	± 0.025	± 0.013	●	●	●	●	●	●
G	± 0.025	± 0.13	± 0.025	●	●	●	●	●	●
H	± 0.013	± 0.025	± 0.013	●	●	●	●	●	●
K	± 0.013	± 0.025	± 0.05	●	●				
			± 0.08			●			
			± 0.10				●	●	
			± 0.13						●
M	± 0.08	± 0.13	± 0.05	●	●				
	± 0.13		± 0.08			●			
	± 0.15		± 0.10				●	●	
	± 0.18		± 0.13						●

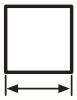


4 Cross Section Shape

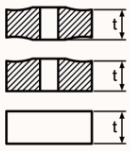
								Special
						C'Sink40°~ 60°	C'Sink40°~ 60°	
A	F	G	M	N	R	T	W	X

12	03	ED	T	R	CHIP BREAKER
5	6	7	8	9	10

5 Cutting Edge Length

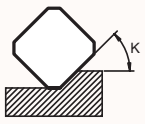
I.C. Size	C	S	R	T	H	O
						
Metric						
5.56	05	05	05	09		
6.35	06	06	06	11		
7.94	08	07	07	13		
9.525	09	09	09	16		
12.7	12	12	12	22	05	05
15.875	16	15	15	27	09	06
19.05	19	19	19	33	10	
25.4	25	25	25	44		

6 Thickness

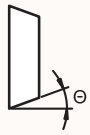


Symbol(t)	mm
02	2.38
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

7 Lead Angle & Relief Angle of Minor Cutting Edge



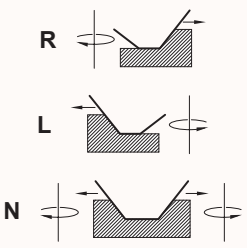
Lead Angle	
A	45°
D	60°
E	75°
F	85°
P	90°
Z	Special



Relief Angle of minor cutting edge	
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z	Special

8 Edge Preparation

9 Cutting Direction



10 Chip Breaker

For Application