

Roughing Chipper

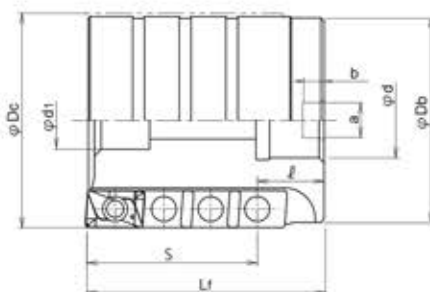
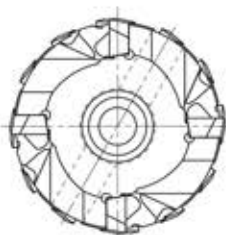
RFC TYPE

G-Body

- 3D insert geometry gives low cutting forces and excellent chip ejection for high productivity at high feed rate
- Adopted ultra rigid G Body



BODY



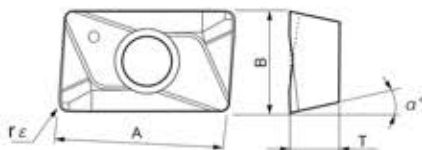
Cat. No.	Stock	No. of Inserts	No. of flutes	No. of Eff. Cutting edge	Dimensions (mm)							Weight (kg)	Set bolt	Parts			
					φDc	φDb	φd1	S	Lf	φd	a			b	ℓ	Clamp screw	Wrench
RFC5050R-22	●	12	3	3	50	45	17	50	90	22	10.4	6.3	20	0.9	★	DSW-4510H	A-20SD
RFC6350R-22	●	16	4	4	63	60	17	50	70	22	10.4	6.3	20	1.1	★	DSW-4510H	A-20SD
RFC8060R-27	□	25	5	5	80	60	20	60	80	27	12.4	7	22	2.2	M10x1.5x55	DSW-4510H	A-20SD

Note) 1. All cutters are supplied without inserts

2. ★ mark shows: these cutter bodies are equipped with these bolt because of the specified bolt size.

Clamp Screw	Recommended torque (N·m)
DSW-4510H	6.0

INSERTS



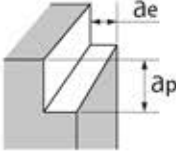
Cat. No.	PVD coated		Dimensions (mm)				
	JC5015	JC5040	A	B	T	α°	rε
ZPMT170508R	●	●	17	11	5.56	11	0.8

10 inserts per case

Roughing Chipper

RFC TYPE

RECOMMENDED CUTTING CONDITIONS

Type of Machining	Shoulder Milling											
												
	Work Materials	Hardness	Insert Grades	Max. D.O.C. (mm)	Tool dia. (mm)							
φ 50					φ 63			φ 80				
				Vc (m/min)	n (min ⁻¹)	Vf (mm/min)	Vc (m/min)	n (min ⁻¹)	Vf (mm/min)	Vc (m/min)	n (min ⁻¹)	Vf (mm/min)
Cast iron (FC)	150HB	JC5015 (JC5040)	$a_e = 0.5D_c(\max)$ $a_p = 1.0D_c(\max)$	140	890	610	140	710	650	140	560	640
			$a_e = 0.1D_c$ $a_p = \text{Below flute length}$	140	890	880	140	710	940	140	560	920
Nodular cast iron (FCD)	Below 220HB	JC5015 (JC5040)	$a_e = 0.5D_c(\max)$ $a_p = 1.0D_c(\max)$	120	760	520	120	610	560	120	480	550
			$a_e = 0.1D_c$ $a_p = \text{Below flute length}$	120	760	750	120	610	810	120	480	790
Carbon steel Alloy steel (S-C, SCM)	Below 250HB	JC5040	$a_e = 0.5D_c(\max)$ $a_p = 1.0D_c(\max)$	110	700	420	110	560	450	110	440	440
			$a_e = 0.1D_c$ $a_p = \text{Below flute length}$	110	700	690	110	560	670	110	440	660
Tool & Die steel SKD	Below 255HB	JC5040	$a_e = 0.5D_c(\max)$ $a_p = 1.0D_c(\max)$	100	640	230	100	510	250	100	400	240
			$a_e = 0.1D_c$ $a_p = \text{Below flute length}$	100	640	350	100	510	370	100	400	360

Vc: Cutting speed, Vf: Feed speed, n: Spindle speed, ap: Depth of cut, ae: Width of cut