

RRD

FRESAS CON PLACA REDONDA
RENDIMIENTO VERSÁTIL Y PROLONGADA VIDA ÚTIL
DE LA HERRAMIENTA



Mplus...

RRD

CARACTERÍSTICAS DEL PRODUCTO



- Fresa con placa redonda para el mecanizado de moldes y matrices.
- Gama versátil de calidades de placa para el mecanizado de hasta 60 HRC.
- Disponibilidad de un amplio abanico de fresas: tipo husillo, roscado, mango y Weldon.
- Gran variedad de tamaños de placa: R2,5, 3,5, 5,0, 6,0 y 8,0.

RRD

FRESAS CON PLACA REDONDA

FRESAS RRD

Mango recto



Mango con Weldon



Roscado

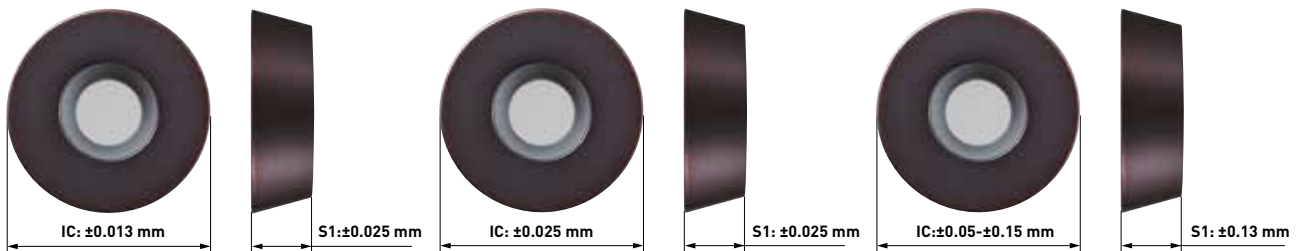


Frontal



CARACTERÍSTICAS

Las placas están disponibles en tres tolerancias distintas para adaptarse a cualquier aplicación.



RDHX

- Rectificado (tolerancia H)
- Alta precisión
- Semiacabado y acabado

RDZX

- Sinterización de precisión (tolerancia E)
- Uso universal
- Placa económica con una prolongada vida útil de la herramienta

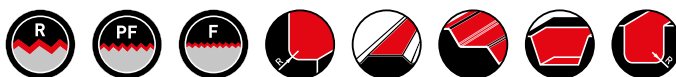
RDMX

- Sinterización (tolerancia M)
- Uso universal
- Desbaste y semiacabado

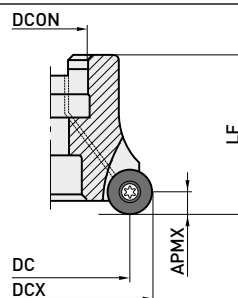
VISTA GENERAL DE LAS CALIDADES

ISO	Metal duro con recubrimiento					Metal duro sin recubrimiento		
P	P01	VP05HT	VP10H	VP15TF	VP20M	F7030	UT120T	Resistencia al desgaste ↑
	P10							
	P20							
	P30							
	P40							
K	K01	VP15TF	UT120T	Resistencia al desgaste ↓				
	K10							
	K20							
	K30							
H	H01	VP05HT	VP10H	VP15TF	Dureza ↓			
	H10							
	H20							
	H30							

RRD N



P K H



Solo portaherramientas a mano derecha

TIPO FRONTAL (neutro)

RE	Referencia	Stock	Dientes	DCX	DC	LF	DCON	APMX	WT *1	Placa
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	RDH/M/Z
	RRD050N-052A07R	●	7	52	42	50	22	5	0.4	1003M0
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	RDH/M/Z 12T3M0
	RRD060N-050A05R	●	5	50	38	50	22	6	0.38	
	RRD060N-052A05R	●	5	52	40	50	22	6	0.4	
	RRD060N-063A06R	●	6	63	51	50	22	6	0.33	
	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	
8	RRD080N-052A04R	●	4	52	36	50	22	8	0.4	RDH/M/Z 1604M0
	RRD080N-052A05R	●	5	52	36	50	22	8	0.4	
	RRD080N-063A05R	●	5	63	47	50	22	8	0.58	
	RRD080N-066A05R	●	5	66	50	50	27	8	0.6	
	RRD080N-080A06R	●	6	80	64	52	27	8	1	
	RRD080N-100A07R*2	●	7	100	84	52	32	8	1.5	
	RRD080N-125B08R*2	□	8	125	109	52	40	8	2.5	
RRD080N-160C09R*2	●	9	160	144	52	40	8	3.5		

*1 WT: peso de la herramienta en kg

*2 Sin refrigeración interna

REPUESTOS

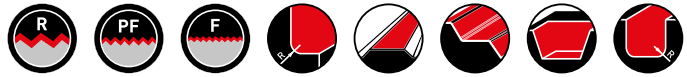
RE	Referencia	Arandela	Tornillo de arandela	Tornillo de placa	Tornillo de sujeción	Llave
5	RRD050N-042A06R					
	052A07R					
6	RRD060N-042A05R			B-TS35		TKY15F
	050A05R				TS1001	
	052A05R					
	063A06R					
	050A04R					
8	RRD080N-052A04R					TKY20F
	052A05R					
	063A05R					
	066A05R	KS-12	B-TS45	214		
	080A06R					
	100A07R					
125B08R						
160C09R						

● Desbaste

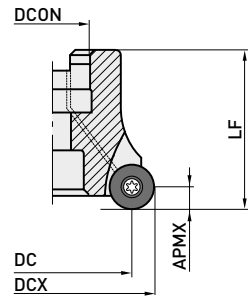
● Semicabado

● Acabado

RRD P



P K H



Solo portaherramientas a mano derecha

TIPO FRONTAL (positivo)

RE	Referencia	Stock	Dientes	DCX	DC	LF	DCON	APMX	WT *1	Placa
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	RDH/M/Z 12T3M0E
	RRD060P-052A05R	●	5	52	40	50	22	6	0.35	
	RRD060P-063A06R	●	6	63	51	50	22	6	0.58	
	RRD060P-066A06R	●	6	66	54	52	27	6	0.6	
	RRD060P-080A07R	●	7	80	68	50	27	6	1	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	RDH/M/Z 1604M0
	RRD080P-063A05R	●	5	63	47	50	22	8	0.53	
	RRD080P-066A05R	●	5	66	50	50	27	8	0.55	
	RRD080P-080A06R	●	6	80	64	52	27	8	1	
	RRD080P-100A07R *2	●	7	100	84	52	32	8	1.5	
	RRD080P-125B08R *2	●	8	125	109	52	40	8	2.6	
RRD080P-160C09R *2	●	9	160	144	52	40	8	3.5		

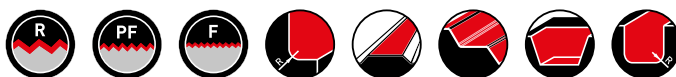
*1 WT: peso de la herramienta en kg

*2 Sin refrigeración interna

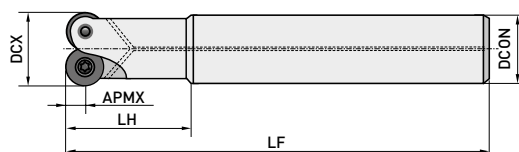
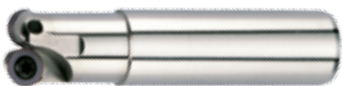
REPUESTOS

RE	Referencia	Arandela	Tornillo de arandela	Tornillo de placa	Tornillo de sujeción	Llave
6	050A05R	—	—	B-TS35	TS1001	TKY15F
	052A05R					
	063A06R					
	066A06R					
	080A07R					
8	050A04R	KS-12	B-TS45	214	—	TKY20F
	063A05R					
	066A05R					
	080A06R					
	100A07R					
	125B08R					
160C09R						

RRD



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TIPO MANGO RECTO

Solo portaherramientas a mano derecha

RE	Referencia	Stock	Dientes	DCX	DCON	LF	LH	APMX	Placa
2.5	RRD025R102S10Z	●	2	10	10	75	23	2.5	RDH/Z 0501M0
	RRD025R123S12Z	●	3	12	12	75	23	2.5	
	RRD025R154S16Z	●	4	15	16	80	23	2.5	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	RDH/M/Z 07T1M0
	RRD035R122S12Z	●	2	12	12	75	23	3.5	
	RRD035R122S16Z	□	2	12	16	88	15	3.5	
	RRD035R122S16ZL	●	2	12	16	128	15	3.5	
	RRD035R122S16ZM	●	2	12	16	108	15	3.5	
	RRD035R152S16Z	□	2	15	16	88	18	3.5	
3.5	RRD035R152S16ZM	□	2	15	16	108	18	3.5	RDH/M/Z 0702M0
	RRD035R152S20Z	●	2	15	20	130	20	3.5	
	RRD035R152S20ZM	●	2	15	20	150	20	3.5	
	RRD035R152S25Z	□	2	15	25	176	20	3.5	
3.5	RRD035R153S12Z	□	3	15	12	75	17	3.5	RDH/M/Z 07T1M0
	RRD035R153S16Z	□	3	15	16	78	30	3.5	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	RDH/M/Z 1003M0
	RRD050R202S20ZM	●	2	20	20	110	51	5.0	
	RRD050R202S25Z	●	2	20	25	136	72	5.0	
	RRD050R202S25ZL	●	2	20	25	176	112	5.0	
	RRD050R202S25ZM	●	2	20	25	156	92	5.0	

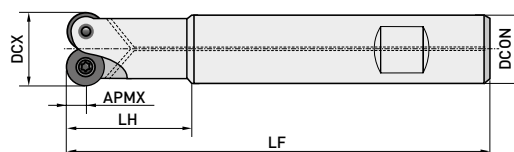
REPUESTOS

RE	Referencia	Arandela	Tornillo de arandela	Tornillo de placa	Tornillo de sujeción	Llave
2.5	RRD025R 102S10Z	—	—	B-TS20	—	TKY06F
	123S12Z					
	154S16Z					
3.5	RRD035R 122S10Z	—	—	B-TS253	—	TKY07F
	122S12Z					
	122S16Z					
	122S16ZL					
	122S16ZM					
	152S16Z					
3.5	RRD035R 152S16ZM	—	—	TS25	—	TKY08F
	152S20Z					
	152S20ZM					
	152S25Z					
	153S12Z					
5	RRD050R 153S16Z	—	—	B-TS35	—	TKY15F
	202S20Z					
	202S20ZM					
	202S25Z					
	202S25ZL					
202S25ZM						

RRD



P K H



TIPO MANGO CON WELDON

Solo portaherramientas a mano derecha

RE	Referencia	Stock	Dientes	DCX	DCON	LF	LH	APMX	Placa
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	RDH/M/Z 07T1M0
	RRD035R122S16WL	□	2	12	16	128	15	3.5	
	RRD035R122S16WM	□	2	12	16	108	15	3.5	
3.5	RRD035R152S16W	□	2	15	16	88	18	3.5	RDH/M/Z 0702M0
	RRD035R152S16WM	□	2	15	16	108	18	3.5	
	RRD035R152S20W	□	2	15	20	130	20	3.5	
	RRD035R152S20WM	□	2	15	20	150	20	3.5	
3.5	RRD035R152S25W	□	2	15	25	176	20	3.5	
5	RRD035R153S16W	●	3	15	16	78	30	3.5	RDH/M/Z 07T1M0
	RRD050R202S20W	●	2	20	20	90	31	5.0	RDH/M/Z 1003M0
5	RRD050R202S20WM	●	2	20	20	110	51	5.0	
	RRD050R202S25W	●	2	20	25	135	72	5.0	
	RRD050R202S25WL	●	2	20	25	176	112	5.0	
	RRD050R202S25WM	●	2	20	25	156	92	5.0	

REPUESTOS

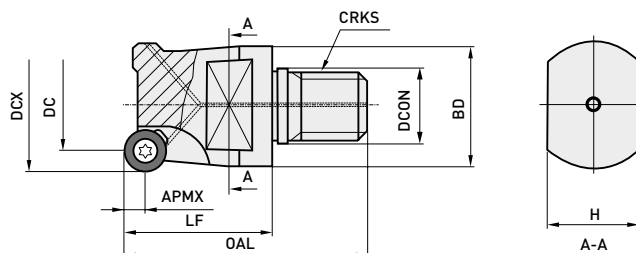
RE	Referencia	Arandela	Tornillo de arandela	Tornillo de placa	Tornillo de sujeción	Llave
3.5	RRD035R					
	122S16W					
	122S16WL	—	—	B-TS253	—	TKY07F
	122S16WM					
	152S16W					
	152S16WM					
	152S20W	—	—	TS25	—	TKY08F
152S20WM						
152S25W						
153S16W				TS253		
5	RRD050R					
	202S20W					
	202S20WM					
	202S25W	—	—	B-TS35	—	TKY15F
202S25WL						
202S25WM						

Desbaste
 Semiacabado
 Acabado
 ● : Stock en Europa. ★ : Stock en Japón. □ : A fabricar según demanda.

RRD



P K H



TIPO ROSCADO

Solo portaherramientas a mano derecha



RE	Referencia	Stock	Dientes	DCX	DC	OAL	LF	DCON	BD	CRKS	APMX	H	Placa
2.5	RRD025R102M5	●	2	10	5	35	20	5.5	9.9	M5	2.5	6	RDH/Z 0501M0
	RRD025R123M8	●	3	12	7	38	20	8.5	13.5	M8	2.5	9	
	RRD025R154M8	●	4	15	10	38	20	8.5	13.5	M8	2.5	10	
	RRD025R205M10	●	5	20	15	44	25	10.5	18	M10	2.5	15	
3.5	RRD035R122M8	●	2	12	5	46	28	8.5	13.5	M8	3.5	9	RDH/M/Z 07T1M0
	RRD035R153M8	●	3	15	8	46	28	8.5	13.5	M8	3.5	10	
	RRD035R204M10	●	4	20	13	47	28	10.5	18	M10	3.5	15	
	RRD035R255M12	●	5	25	18	50	28	12.5	21	M12	3.5	17	
	RRD035R306M16	●	6	30	23	51	28	17	29	M16	3.5	22	
3.5	RRD035R357M16	●	7	35	28	51	28	17	29	M16	3.5	22	RDH/M/Z 0702M0
	RRD035R152M8	●	2	15	8	46	28	8.5	13.5	M8	3.5	10	
5	RRD035R153M8X	●	3	15	8	43	28	8.5	13.5	M8	3.5	10	RDH/M/Z 1003M0
	RRD050R202M10	●	2	20	10	47	28	10.5	18	M10	5.0	15	
	RRD050R252M12	●	2	25	15	54	32	12.5	21	M12	5.0	17	
	RRD050R253M12	●	3	25	15	54	32	12.5	21	M12	5.0	17	
	RRD050R304M12	●	4	30	20	54	32	12.5	21	M12	5.0	17	
	RRD050R304M16	●	4	30	20	55	32	17	29	M16	5.0	22	
	RRD050R355M16	●	5	35	25	65	42	17	29	M16	5.0	22	
6	RRD050R426M16	●	6	42	32	65	42	17	29	M16	5.0	22	RDH/M/Z 12T3M0
	RRD060R242M12	●	2	24	12	54	32	12.5	21	M12	6.0	17	
	RRD060R353M16	●	3	35	23	65	42	17	29	M16	6.0	22	
	RRD060R354M16	●	4	35	23	65	42	17	29	M16	6.0	22	
	RRD060R424M16	●	4	42	30	55	32	17	29	M16	6.0	24	
8	RRD060R425M16	●	5	42	30	65	42	17	29	M16	6.0	22	RDH/M/Z 1604M0
	RRD080R322M16	●	2	32	16	65	42	17	29	M16	8.0	22	






● Desbaste

● Semiacabado

● Acabado

● : Stock en Europa. ★ : Stock en Japón. □ : A fabricar según demanda.

REPUESTOS

RE	Referencia						
		Arandela	Tornillo de arandela	Tornillo de placa	Tornillo de sujeción	Llave	
2.5	RRD025R	102M5					
		123M8					
		154M8	—	—	B-TS20	—	TKY06F
		205M10					
3.5	RRD035R	122M8			B-TS253	—	TKY07F
		153M8					
		204M10					
		255M12	—	—	TS253	—	TKY08F
		306M16					
		357M16					
		152M8			TS25	—	TKY08F
5	RRD050R	153M8X					
		202M10					
		252M12					
		253M12					
		304M12	—	—	B-TS35	—	TKY15F
		304M16					
6	RRD060R	355M16					
		426M16					
		242M12				—	
		353M16					
8	RRD080R	354M16	—	—	B-TS35	TS1001	TKY15F
		424M16					
		425M16					
8	RRD080R	322M16			214	—	TKY20F

PLACAS

P	Acero	● ● ● ● ● ●
K	Fundición	✱ ✱ ✱ ✱ ✱
H	Materiales endurecidos	● ● ●

Condiciones de corte (guía):

●: Corte estable ●: Corte general ✱: Corte inestable

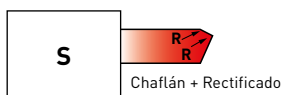
Referencia	Clase	Rectificado	Rectificado						IC	S	Geometría
			F7030	VP15TF	VP20M	VP10H	VP05HT	UT120T			
RDHX0501M0E	H	E	●	●		●	●	5	1.5		
RDHX0501M0S	H	S	●	●		●		5	1.5		
RDHX07T1M0E	H	E	●	●		●	●	7	1.98		
RDHX07T1M0S	H	S	●	●		●	●	7	1.98		
RDHX0702M0E	H	E	●	●		●	●	7	2.38		
RDHX0702M0S	H	S	●	●		●		7	2.38		
RDHX1003M0E	H	E	●	●		●	●	10	3.18		
RDHX1003M0S	H	S	●	●		●	●	10	3.18		
RDHX12T3M0E	H	E	●	●		●	●	12	3.97		
RDHX12T3M0S	H	S	●	●		●		12	3.97		
RDHX1604M0E	H	E	●	●		●	●	16	4.76		
RDHX1604M0S	H	S	●	●		●		16	4.76		
RDMX07T1M0E	M	E					●	7	1.98		
RDMX07T1M0T	M	T	●		●	●		7	1.98		
RDMX0702M0E	M	E					●	7	2.38		
RDMX0702M0T	M	T	●		●	●	□	7	2.38		
RDMX1003M0E	M	E					●	10	3.18		
RDMX1003M0S	M	S		●		●		10	3.18		
RDMX1003M0T	M	T	●		●	●	●	10	3.18		
RDMX12T3M0E	M	E					●	12	3.97		
RDMX12T3M0S	M	S		●		●		12	3.97		
RDMX12T3M0T	M	T	●		●	●	●	12	3.97		
RDMX1604M0E	M	E					●	16	4.76		
RDMX1604M0S	M	S		●		●		16	4.76		
RDMX1604M0T	M	T	●		●	●	●	16	4.76		
RDZX0501M0E	Z	E		●				5	1.50		
RDZX07T1M0E	Z	E		●				7	1.98		
RDZX0702M0E	Z	E		●				7	2.38		
RDZX1003M0E	Z	E		●				10	3.18		
RDZX1003M0S	Z	S	●	●				10	3.18		
RDZX12T3M0E	Z	E		●				12	3.97		
RDZX12T3M0S	Z	S	●	●				12	3.97		
RDZX1604M0E	Z	E		●				16	4.76		
RDZX1604M0S	Z	S	●	●				16	4.76		

IC: ±0.013 mm S: ±0.025 mm

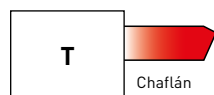
IC: ±0.05-±0.15 mm S: ±0.15 mm

IC: ±0.025 mm S: ±0.025 mm

Preparación del filo de corte



● Para desbaste



● Para desbaste y acabado



● Para acabado

CONDICIONES DE CORTE RECOMENDADAS

CONDICIONES DE CORTE PARA DESBASTE (ae = 50 % de Ø)

Material de trabajo	Dureza	Calidad	Vc (m/min)	Ø 10-15 mm		Ø 20 mm		Ø 24-25 mm		Ø 30-42 mm		Ø 50-80 mm		Ø 100-160 mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acero dulce	<180HB	F7030 VP15TF	(250-320)	-0.2	0.25	-0.5	0.45	-1.0	0.35	-1.0	0.40	-1.0	0.50	-1.5	0.60
			(240-300)	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
			(200-280)	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
			(220-300)	-0.2	0.20	-0.5	0.40	-1.0	0.30	-1.0	0.40	-1.0	0.50	-1.5	0.55
			(200-290)	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
			(160-250)	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
K Fundición	Resistencia a la tracción <450 MPa	VP15TF VP20M VP10H	(200-250)	-0.1	0.15	-0.5	0.18	-1.0	0.20	-1.0	0.25	-1.0	0.30	-1.5	0.35
			(180-230)	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
			(160-200)	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
			(140-200)	-0.1	0.12	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(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
			(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
H Acero endurecido	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(140-200)	-0.1	0.12	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(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
			(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. Al utilizar una anchura de corte máxima, las condiciones de corte deben reducirse en un 20 %.
2. Al utilizar un mango largo, la velocidad de avance debe reducirse en un 20 %.

CONDICIONES DE CORTE PARA ACABADO (ae = 20 % de Ø)

Material de trabajo	Dureza	Calidad	Vc (m/min)	Ø 10-15 mm		Ø 20 mm		Ø 24-25 mm		Ø 30-42 mm		Ø 50-80 mm		Ø 100-160 mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acero dulce	<180HB	F7030 VP15TF	(260-360)	-0.1	0.15	-0.15	0.20	-0.15	0.25	-0.15	0.30	-0.15	0.32	-0.3	0.35
			(240-320)	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
			(220-280)	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
			(250-350)	-0.1	0.12	-0.1	0.15	-0.1	0.18	-0.1	0.25	-0.1	0.28	-0.15	0.30
			(230-310)	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
			(210-270)	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
K Fundición	Resistencia a la tracción <450 MPa	VP15TF VP20M VP10H	(200-300)	-0.1	0.15	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(200-280)	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
			(180-240)	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
			(150-200)	-0.1	0.15	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(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
			(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
H Acero endurecido	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(150-200)	-0.1	0.15	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(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
			(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. Al utilizar una anchura de corte máxima, las condiciones de corte deben reducirse en un 20 %.
2. Al utilizar un mango largo, la velocidad de avance debe reducirse en un 20 %.



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