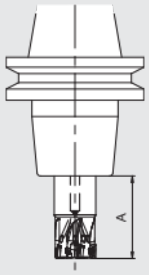
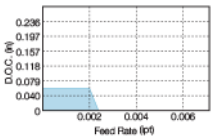
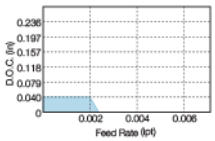
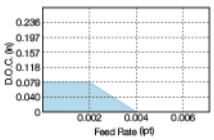
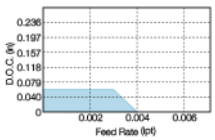
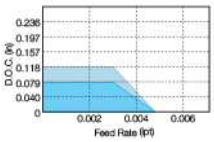
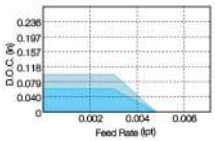
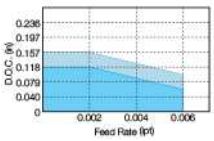
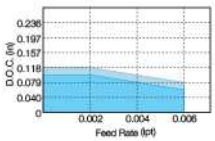
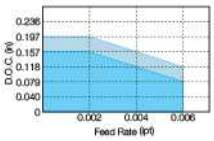
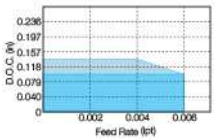
Cutting Performance of MECX End Mill

Cutting Dia.	Part Number (mm / inch)	Overhang Length A (in) (Colors Refer to charts on right)	
Ø8mm	**MECX08-S10-07-1T**	0.630	-
Ø0.375in Ø10mm	**MECX0375-S375-07-1T MECX10-S10-07-1T**	0.670	-
Ø0.500in Ø12mm	**MECX0500-S500-07-2T MECX12-S12-07-2T**	0.709	1.18
Ø0.625in Ø16mm	**MECX0625-S625-07-4T MECX16-S16-07-3T**	0.787	1.57
Ø0.750in Ø20mm	**MECX0750-S750-07-4T MECX20-S20-07-4T**	0.787	1.57



(JT chipbreaker Vc=400 SFM Workpiece :1049)

Part Number	■ Shouldering (Cutting width ae = ØD/2)	■ Slotting ■ Ramping and Helical Milling
MECX08-S10-07-1T		
MECX0375-S375-07-1T MECX10-S10-07-1T		
MECX0500-S500-07-2T MECX12-S12-07-2T		
MECX0625-S625-07-4T MECX16-S16-07-3T		
MECX0750-S750-07-4T MECX20-S20-07-4T		

- Machining with extended overhang length is not recommended for Ø0.315" and Ø0.394".
- The cutting performance chart shows the applicable range of JT Chipbreaker (PR830) with standard flute-number type.
  For Multi-Edge type, use with 70% or less of ap.

Cutting conditions of JS Chipbreaker

① For MECX0375~MECX0500 / MECX08~MECX12
Decrease the feed rate by 25% according to cutting capability list.

② For MECX 0625 / MECX16 and over
Decrease the feed rate and ap by 30% according to cutting application chart

Warning Please observe below precautions fully. Failure to observe the precautions may cause serious damage to human body.

Warning about Max. Revolution indicated on main body

1. When running the end mill and the face mill at revolutions exceeding the maximum revolution limit, the inserts or toolholder may be damaged due to the centrifugal force.
2. For actual practical revolution, please set within recommended cutting condition.
3. When using at a higher revolution (over 10,000RPM), refer to the table to adjust the balance of MECX and suitable arbor.

Max. Revolution (RPM)	Balance quality grade G ISO 1940-1 / 8821 (JIS B0905)
~20,000	G16.0
~30,000	G6.3
30,000~	G2.5