

MCSE CHAMFERING END MILL

◆ Recommended Cutting Conditions

| Workpiece Material | Feed Rate fz (ipt) | | Recommended Insert Grades (Cutting Speed Vc: sfm) | | |
|--------------------|-----------------------|----------------------|---|---------------|--------------|
| | | | Cermet | MEGACOAT | Carbide |
| | ØDs (Ø4mm~Ø20mm) | ØDs (Ø27mm~Ø36mm) | TN100M | PR1225 | KW10 |
| Carbon Steel | 0.002~0.010 | 0.008~0.016 | ★ 330~590 | ★ 390~820 | - |
| Alloy Steel | 0.002~0.010 | 0.008~0.016 | ★ 330~590 | ★ 330~720 | - |
| Mold Steel | 0.002~0.010 | 0.008~0.016 | ★ 330~490 | ★ 260~590 | - |
| Stainless Steel | 0.002~0.008 | 0.004~0.012 | ☆ 330~590 | ★ 390~720 | - |
| Cast Iron | 0.004~0.012 | 0.012~0.020 | - | - | ☆ 260~490 |
| Non-ferrous Metals | 0.004~0.012 | 0.012~0.020 | - | - | ★ 330~980 |

• Use down-cut machining.

★: 1st Recommendation ☆: 2nd Recommendation

| | |
|--------------------|----------|
| GRADES | A |
| LINEUP / INSERTS | B |
| 45° / 70° LEAD | C |
| 75° LEAD | D |
| 90° LEAD | E |
| HIGH FEED | F |
| MULTI-FUNCTION | G |
| SLOT MILLS | H |
| RADIUS / BALL-NOSE | J |
| OTHER APPLICATIONS | K |
| TOOL HOLDING | O |
| SPARE PARTS | P |
| TECHNICAL | R |
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