

● Applicable Inserts

Toolholder	Applicable Inserts ➔ M16			Applicable Inserts ➔ M21
				
MEC.....11...	BDMT 1103 ○○ ER-JT	BDMT 1103 ○○ ER-JS	-	-
MEC.....11T... MEC..R-11...	BDMT 11T3 ○○ ER-JT	BDMT 11T3 ○○ ER-JS	BDGT 11T3 ○○ FR-JA	BDMT 11T3 ○○ FR
MEC.....17... MEC..R-17...	BDMT 1704 ○○ ER-JT	BDMT 1704 ○○ ER-JS	BDGT 1704 ○○ FR-JA	BDMT 1704 ○○ FR

■ Recommended Cutting Conditions (MEC Endmill / Face Mill)

•JT Chipbreaker

Cutting Dia. $\varnothing 10 \sim \varnothing 18$
(MEC10~MEC18)

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		PVD Coated Carbide	
		PR830	PR905
Stainless Steel	0.06~0.08~0.1	100~180	-
Carbon Steel	0.06~0.1~0.15	120~200	-
Alloy Steel	0.06~0.1~0.12	100~180	-
Mold Steel	0.06~0.08~0.1	80~150	-
Gray Cast Iron	0.08~0.1~0.15	-	100~180
Nodular Cast Iron	0.06~0.08~0.1	-	80~120

Cutting Dia. $\varnothing 20 \sim \varnothing 160$

(MEC20~MEC40) (MEC040R~MEC160R)

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		PVD Coated Carbide	
		PR830	PR905
Stainless Steel	0.08~0.12~0.15	100~180	-
Carbon Steel	0.08~0.15~0.25	120~200	-
Alloy Steel	0.08~0.15~0.2	100~180	-
Mold Steel	0.08~0.12~0.2	80~150	-
Gray Cast Iron	0.08~0.18~0.25	-	100~180
Nodular Cast Iron	0.08~0.15~0.2	-	80~120

•JS Chipbreaker

Cutting Dia. $\varnothing 10 \sim \varnothing 18$
(MEC10~MEC18)

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		PVD Coated Carbide	
		PR830	PR1025
Stainless Steel	0.06~0.08~0.1	100~180	100~180
Carbon Steel	0.06~0.1~0.12	120~200	100~150
Alloy Steel	0.06~0.08~0.1	100~180	-
Mold Steel	0.06~0.08~0.1	80~150	-

Cutting Dia. $\varnothing 20 \sim \varnothing 160$

(MEC20~MEC40) (MEC040R~MEC160R)

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		PVD Coated Carbide	
		PR830	PR1025
Stainless Steel	0.08~0.1~0.12	100~180	100~180
Carbon Steel	0.08~0.15~0.18	120~200	100~150
Alloy Steel	0.08~0.12~0.15	100~180	-
Mold Steel	0.08~0.1~0.12	80~150	-

•JA Chipbreaker

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		Carbide	
		GW25	
Aluminum Alloy (Si 13% or below)	0.05~0.3	200~800	
Aluminum Alloy (Si 13% or above)	0.05~0.2	200~300	

•PCD

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed: m/min)	
		PCD	
		KPD230 (KPD001)	
Aluminum Alloy (Si 13% or below)	0.05~0.2	500~1,500	
Aluminum Alloy (Si 13% or above)	0.05~0.15	300~1,000	

M



Milling



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

- When running the endmill and the facemill at revolutions exceeding the maximum revolution limit, the inserts or toolholder may be damaged due to the centrifugal force.
- For actual practical revolution, please set within recommended machining condition.
- When using at a higher revolution (over 10,000min⁻¹), refer to the table to adjust the balance of MEC and suitable arbor.

Max. Revolution (min ⁻¹)	Balance quality grade G ISO 1940-1 / 8821 (JIS B9095)
~20,000	G16
~30,000	G6.3
30,000~	G2.5