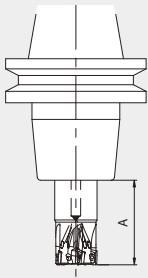


Cutting Performance of MECX Endmill

[Vc=150m/min Workpiece Material: C50 (S50C)]

Cutting Dia.	Description	Overhang Length A (mm)	
ø8	MECX08-S10-07-1T	16	-
ø10	MECX10-S10-07-1T	17	-
ø12	MECX12-S12-07-2T	18	30
ø16	MECX16-S16-07-3T	20	40
ø20	MECX20-S20-07-4T	20	40
ø25	MECX25-S25-07-5T	25	50
ø32	MECX32-S32-07-6T	30	50

Shape



*Machining with extended overhang length is not recommended for ø8 and ø10.

*The cutting performance list shows 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 MECX08-MECX12

Decrease the feed rate by 25% according to cutting capability list.

② For MECX16 and over

Decrease the feed rate and ap by 30% according to cutting capability list.

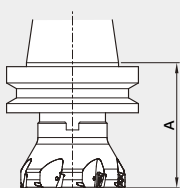
Description	Cutting width ae = øD/2	
	Shouldering	Slotting Ramping and Helical Milling
MECX08-S10-07-1T		
MECX10-S10-07-1T		
MECX12-S12-07-2T		
MECX16-S16-07-3T		
MECX20-S20-07-4T		
MECX25-S25-07-5T		
MECX32-S32-07-6T		

Cutting Performance of MECX Milling Cutter

[Vc=150m/min Workpiece Material: C50 (S50C)]

Cutting Dia.	Description	Overhang Length A (mm)	
ø32	MECX032R-07-8T-M	100	
ø40	MECX040R-07-10T-M		
ø50	MECX050R-07-12T-M		
ø63	MECX063R-07-14T-M		

Shape



Description	Cutting width ae = øD/2	
	Shouldering	Slotting Ramping and Helical Milling
MECX032R-07-8T-M MECX040R-07-10T-M		
MECX050R-07-12T-M MECX063R-07-14T-M		

*Use JT Chipbreaker.

*Not Recommended for Slotting.

M



Milling