

MECH Endmill

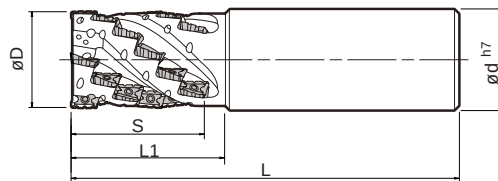


Fig.1

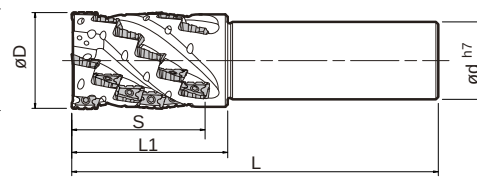


Fig.2

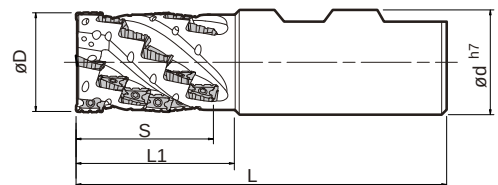


Fig.3

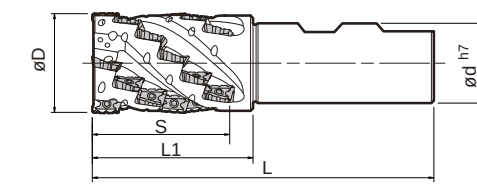


Fig.4

Dimensions

Description		Std.	No. of Flute	No. of Stage	No. of Insert	Dimension (mm)					Rake Angle (°)		Drawing	Spare Parts			Applicable Inserts 
						øD	ød	L	L1	S	A.R. (MAX)	R.R.		Clamp Screw	Wrench	Anti-seize Compound	
																	
Cylindrical	MECH 025-S25-11-4-2T	●	2	4	8	25	25	120	46	37	+21°	-10°	Fig.1	SB-2555TRG	DTM-8	MP-1	BDMT11T308ER-N2 BDMT11T308ER-N3
	032-S32-11-5-2T	●		5	10	32	140	55	46	+23°	-9°						
	032-S32-11-5-4T	●	20														
	040-S32-11-6-4T	●	4	6	24	40	150	64	55			-8°	Fig.2				
	040-S42-11-6-4T	●									160		Fig.1				
	050-S42-11-7-4T	●		7	28	42	170	75	64		-7°		Fig.2				
	050-S42-11-7-6T	●	42														
	MECH 040-S32-17-4-2T	●	2	4	8	40	32	160	73	59		+19°	-7°	Fig.2	SB-4070TRN	DTM-15	MP-1
	040-S42-17-4-2T	●					42	170			Fig.1						
050-S42-17-5-4T	●	4	5	20	50	185	88	74	Fig.2								
Weldon	MECH 025-W25-11-4-2T	●	2	4	8	25	25	104	46	37	+21°	-10°	Fig.3	SB-2555TRG	DTM-8	MP-1	BDMT11T308ER-N2 BDMT11T308ER-N3
	032-W32-11-5-2T	●		5	10	32	117	55	46	+23°	-9°						
	032-W32-11-5-4T	●	20														
	040-W32-11-6-4T	●	4	6	24	40	126	64	55			-8°	Fig.4				
	050-W40-11-7-4T	●									7						
	050-W40-11-7-6T	●	42	-7°													
	MECH 040-W32-17-4-2T	●	2	4	8	40	32	136	73		59	+19°	-7°	Fig.4	SB-4070TRN	DTM-15	MP-1
	050-W40-17-5-4T	●	4	5	20	50	40	161	88	74							



Coat Anti-seize Compound (MP-1) thinly on clamp screw when insert is fixed.

Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc : m/min)	
		PVD Coated Carbide	
		PR830	PR905
Carbon Steel	0.08~0.1~0.15	100~180	-
Alloy Steel	0.08~0.1~0.15	100~180	-
Mold Steel	0.08~0.1~0.15	100~150	-
Gray Cast Iron	0.08~0.1~0.15	-	100~180
Nodular Cast Iron	0.08~0.1~0.15	-	100~150
Titanium Alloy	0.08~0.1~0.15	-	20~50

*Machining with coolant is recommended for Titanium Alloy.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)