

◆ Cutting Performance of MEA

[CUTTING CONDITIONS] CUTTING SPEED: $V_c=100\text{m/min}$,
OVERHANG LENGTH: same as l in the dimension table
INSERT: NDKT090304ER-V (PR660),
COOLANT: No

Workpiece Material	Shouldering	Slotting
C50 (S50C) (Overhang Length: 20mm)		
Description		
MEA12-S10 (Overhang Length: 20mm)		
MEA16-S10 (Overhang Length: 23mm)		
MEA20-S16 (Overhang Length: 26mm)		
MEA25-S20 (Overhang Length: 29mm)		
MEA32-S25 (Overhang Length: 32mm)		
MEA20-S20-130 (Overhang Length: 60mm)		
MEA40-S32-200		
	Holder overhang Length: 120mm	* Overhang Length (mm)

◆ Cutting Performance of MEB

[CUTTING CONDITIONS] CUTTING SPEED: $V_c=100\text{m/min}$,
OVERHANG LENGTH: same as l in the dimension table
INSERT: NDKT150408ER-V (PR660),
COOLANT: No

Workpiece Material	Shouldering	Slotting
C50 (S50C) (Overhang Length: 20mm)		
Description		
MEB25-S20 (Overhang Length: 36mm)		
MEB32-S25 (Overhang Length: 40mm)		
MEB40-S32 (Overhang Length: 45mm)		
MEB50-S32 (Overhang Length: 45mm)		Not recommended for Slotting
MEB63-S32 (Overhang Length: 45mm)		Not recommended for Slotting
MEB80-S32 (Overhang Length: 45mm)		Not recommended for Slotting

* In this case only, ap is fixed at 3mm and overhang length is changed.

M



Milling