Profile Milling

MPC100

Arbor

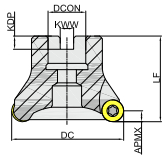


Fig1

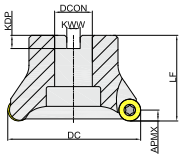


Fig2

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	KWW	KDP					
MPC100050R04A22RC12	50	4	50	22	50	10.4	6.3	6	RC**1204	×	Fig1	●
MPC100050R05A22RC12	50	5	50	22	50	10.4	6.3	6	RC**1204	×	Fig1	●
MPC100063R04A22RC12	63	4	63	22	50	10.4	6.3	6	RC**1204	×	Fig1	●
MPC100063R04A22RC16	63	4	63	22	50	10.4	6.3	8	RC**1606	×	Fig1	●
MPC100063R05A22RC12	63	5	63	22	50	10.4	6.3	6	RC**1204	×	Fig1	●
MPC100063R05A22RC16	63	5	63	22	50	10.4	6.3	8	RC**1606	×	Fig1	●
MPC100063R06A22RC12	63	6	63	22	50	10.4	6.3	6	RC**1204	×	Fig1	●
MPC100080R05A27RC16	80	5	80	27	50	12.4	7	8	RC**1606	×	Fig1	●
MPC100080R06A27RC12	80	6	80	27	50	12.4	7	6	RC**1204	×	Fig1	●
MPC100080R06A27RC16	80	6	80	27	50	12.4	7	8	RC**1606	×	Fig1	●
MPC100100R06B32RC16	100	6	100	32	50	14.4	8	8	RC**1606	×	Fig2	●
MPC100100R06B32RC20	100	6	100	32	50	14.4	8	10	RC**2006	×	Fig2	●
MPC100125R07B40RC20	125	7	125	40	63	16.4	9	10	RC**2006	×	Fig2	●
MPC100160R08B40RC20	160	8	160	40	63	16.4	9	10	RC**2006	×	Fig2	●

● Stock ○ Available Upon Order

MPC100

Cylindrical Straight Type

Fig3

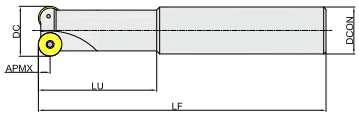
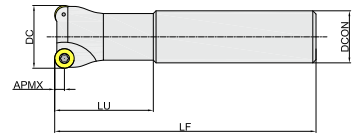


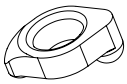
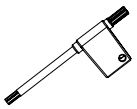
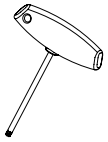
Fig4



Ordering Code	Dia-meter	Teeth	Dimension(mm)				APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	LU					
MPC100020R02P20RC10	20	2	20	20	110	60	5	RC**10T3	×	Fig3	●
MPC100025R02P20RC10	25	2	25	20	160	50	5	RC**10T3	×	Fig4	●
MPC100032R02P25RC12	32	2	32	25	200	50	6	RC**1204	×	Fig4	●
MPC100040R03P32RC12	40	3	40	32	200	50	6	RC**1204	×	Fig4	●

● Stock ○ Available Upon Order

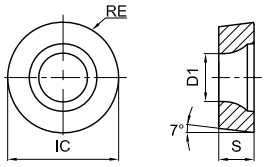
Spare Parts

Part Name		Clamp Screw	Clamp	Inserts Screw	Insert Screw Wrench	
Inserts \ Shape						
RD**05	Specification	--	--	SI60M2X3.7-02806	TT06P	--
	Ordering Code	--	--	SI60M020037-02806S	TT06PQ	--
RD**07	Specification	--	--	SI60M2.5X5-03509	TT07P	--
	Ordering Code	--	--	SI60M025050-03509S	TT07PQ	--
RD**08 RP**08	Specification	--	--	SI60M2.5X6.5-03509	TT07P	--
	Ordering Code	--	--	SI60M025065-03509S	TT07PQ	--
RD**10 RP**10	Specification	SI60M3.5X10-05510	CAX1	SI60M4X8.9-05313	TT15P	--
	Ordering Code	SI60M035100-05510S	CAX01RQ	SI60M040089-05313S	TT15PQ	--
RC**10	Specification	--	--	SI60M4X8.9-05313	TT15P	--
	Ordering Code	--	--	SI60M040089-05313S	TT15PQ	--
RD**12 RP**12	Specification	SI60M3.5X12-05314	CAX2	SI60M4X8.9-05313	TT15P	--
	Ordering Code	SI60M035120-05314S	CAX02RQ	SI60M040089-05313S	TT15PQ	--
RC**12	Specification	--	--	SI60M3.5X8-05314	TT15P	--
	Ordering Code	--	--	SI60M035080-05314S	TT15PQ	--
RD**16 RP**16/RC**16	Specification	--	--	SI60M5X10.8-07209	TT20P	TT20T
	Ordering Code	--	--	SI60M050108-07209S	TT20PQ	TT20TQ
RC**20	Specification	--	--	SI60M6X16-08509	--	TT25T
	Ordering Code	--	--	SI60M060160-08509S	--	TT25TQ

Profile Milling

RC

Profile Milling Inserts (Positive)



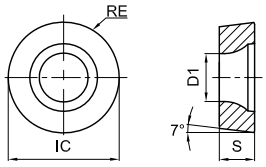
Ordering Code		Dimension(mm)				Coating Grade												Uncoated	Cermet
		IC	S	RE	D1	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115	GS4130	GH4115	GN9125	GP01TM
	RCET10T3M0-EM	10	3.97	5	4.4	●	○	●	○										○
	RCET1204M0-EM	12	4.76	6	4	●	●	○	●				●		●				
	RCET1606M0-EM	16	6.35	8	5.5	○	●	○	○			○	○		○				
	RCET2006M0-EM	20	6.35	10	6.5		●	●	●					○					
	RCET1204M0T-EH	12	4.76	6	4.4		○	○	○										
	RCET1606M0T-EH	16	6.35	8	5.5		●	○	●				○	●					
	RCET2006M0T-EH	20	6.35	10	6.5		●	○	●										
	RCET1204M0-MM	12	4.76	6	4	●	●	●	●				○						○
	RCET1204M0-KM	12	4.76	6	4			○	○										
	RCET1606M0T-KH	16	6.35	8	5.5	○	○	○	○										

●Stock ○Available Upon Order

Profile Milling

RC

Profile Milling Inserts (Positive)



Ordering Code		Dimension(mm)				Coating Grade												Uncoated	Cermet
		IC	S	RE	D1	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115	GS4130	GH4115	GN9125	GP01TM
	RCMT1606M0T-KM	16	6.35	8	5.5				○			●							

●Stock ○Available Upon Order

RC Series Geometry

Medium Cutting for General Material	Medium Cutting of Stainless Steel	Heavy Cutting of General Material	Heavy Cutting for General Material	
				
EM	MM	KM	EH	KH
				
In general circumstances, high stability machining is realized.	Double rake angle design, has good strength and sharpness.	Double rake angle design, has vibration resistance in general machining condition.	Small rake angle and chamfer design, higher edge strength.	

RD/RP/RC Recommend Cutting Feed and Cutting Depth

Specification	Working Conditions	Ap(mm)								
		0.1	0.5	1	1.5	2	2.5	3	4	5
05	Medium Maching (M)	0.35 (0.22-0.63)	0.17 (0.08-0.26)	0.12 (0.06-0.21)	0.1 (0.05-0.17)	-	-	-	-	-
	Heavy Maching (H)	0.45 (0.29-0.95)	0.2 (0.12-0.38)	0.16 (0.09-0.28)	0.14 (0.07-0.25)	-	-	-	-	-
07 08	Medium Maching (M)	0.59 (0.23-0.9)	0.27 (0.1-0.41)	0.2 (0.08-0.3)	0.17 (0.06-0.26)	0.15 (0.03-0.23)	-	-	-	-
	Heavy Maching (H)	0.68 (0.32-1.13)	0.31 (0.14-0.52)	0.23 (0.11-0.38)	0.19 (0.09-0.32)	0.17 (0.08-0.29)	-	-	-	-
10	Light Maching (L)	0.75 (0.25-0.9)	0.34 (0.11-0.41)	0.25 (0.08-0.3)	0.21 (0.07-0.25)	0.19 (0.06-0.23)	0.17 (0.05-0.21)	-	-	-
	Medium Maching (M)	0.9 (0.25-1.26)	0.41 (0.11-0.57)	0.30 (0.08-0.42)	0.25 (0.07-0.35)	0.23 (0.06-0.31)	0.21 (0.05-0.28)	-	-	-
	Heavy Maching (H)	1.01 (0.35-1.51)	0.46 (0.16-0.69)	0.33 (0.12-0.5)	0.28 (0.1-0.42)	0.25 (0.09-0.38)	0.23 (0.08-0.35)	-	-	-
12	Light Maching (L)	0.83 (0.28-1.1)	0.38 (0.13-0.5)	0.27 (0.09-0.36)	0.23 (0.08-0.3)	0.2 (0.07-0.27)	0.18 (0.06-0.25)	0.17 (0.06-0.23)	-	-
	Medium Maching (M)	0.99 (0.28-1.38)	0.45 (0.13-0.63)	0.33 (0.09-0.45)	0.27 (0.08-0.38)	0.24 (0.07-0.34)	0.22 (0.06-0.31)	0.21 (0.06-0.29)	-	-
	Heavy Maching (H)	1.1 (0.39-1.65)	0.5 (0.18-0.75)	0.36 (0.13-0.54)	0.3 (0.11-0.45)	0.27 (0.09-0.4)	0.25 (0.08-0.37)	0.23 (0.08-0.35)	-	-
16	Light Maching (L)	1.14 (0.32-1.59)	0.52 (0.14-0.72)	0.37 (0.1-0.52)	0.31 (0.09-0.43)	0.27 (0.08-0.38)	0.25 (0.07-0.35)	0.23 (0.06-0.32)	0.21 (0.06-0.29)	-
	Medium Maching (M)	1.27 (0.32-1.9)	0.57 (0.14-0.86)	0.41 (0.1-0.62)	0.34 (0.09-0.51)	0.30 (0.08-0.45)	0.28 (0.07-0.41)	0.26 (0.06-0.38)	0.23 (0.06-0.35)	-
	Heavy Maching (H)	1.59 (0.44-2.54)	0.72 (0.20-1.15)	0.52 (0.14-0.83)	0.43 (0.12-0.69)	0.38 (0.11-0.6)	0.35 (0.1-0.54)	0.32 (0.09-0.51)	0.29 (0.08-0.46)	-
20	Heavy Maching (H)	2.14 (0.59-3.49)	0.97 (0.25-1.60)	0.71 (0.18-1.17)	0.58 (0.15-0.96)	0.5 (0.14-0.81)	0.46 (0.13-0.73)	0.42 (0.12-0.68)	0.38 (0.11-0.61)	0.34 (0.1-0.55)

Note: Remark: During round Insert application, in general, the ap should less than 25%IC. Otherwise, we suggest to us Kr=45 SNUE/SEET series insert.