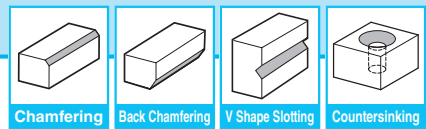
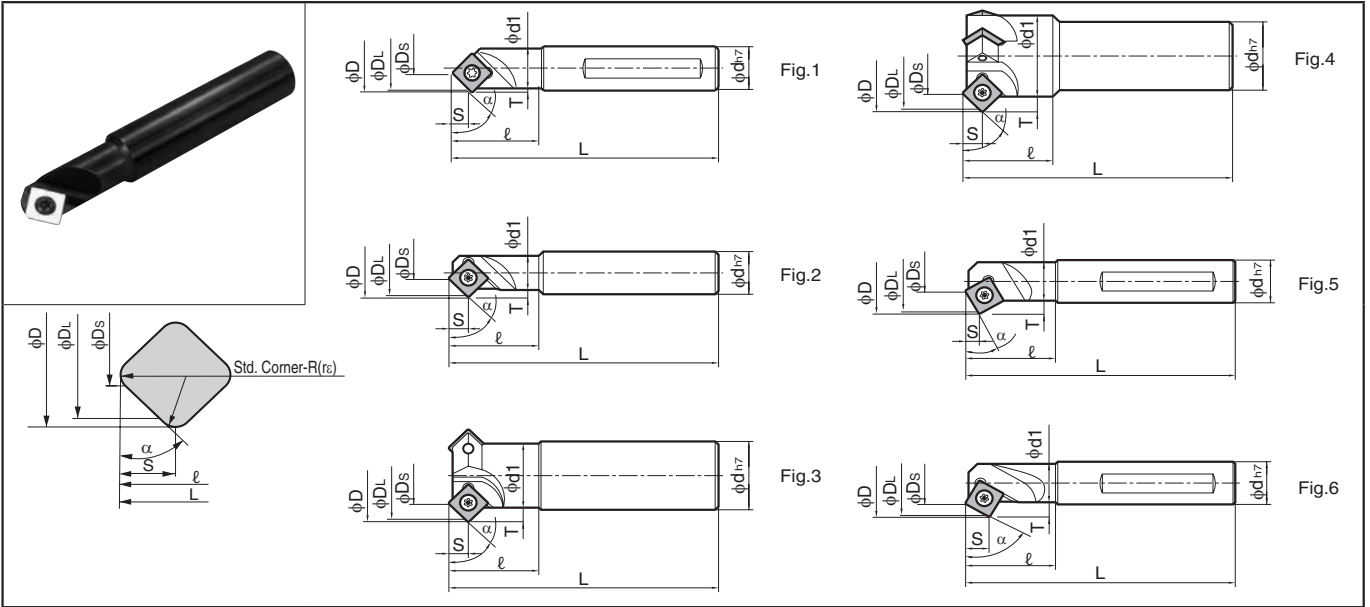


Chamfering End Mill MCSE



MCSE






Toolholder Dimensions

Description	Std.	No. of Inserts	Dimension (mm)								Std. Corner-R (r _c)	Angle α	Rake Angle		Drawing	Spare Parts								
			φD	φDL	φDs	φd	φd1	L	ℓ	S			T	A.R.		R.R.	Clamp Screw	Wrench						
Cylindrical	MCSE	104	●	16	15	4	16	15	85	30	6.5	0.5	0.4	45°	0°	-4.5°	Fig.1	SB-3060TR	DT-10					
		106	●	22	21	6	20	16	120	40	8.6	3.0	Fig.2			SB-5090TR	LTW-20							
		115	●	31	30	15	18	6.5				Fig.3												
		227	●	43	42	27	32	6.5				Fig.4												
		336	●	52	51	36	38	7.0				Fig.4												
Cylindrical	MCSE	104-30D	●	19	18	4	16	15	85	30	4.7	2.0	0.4	30°	0°	-4°	Fig.5	SB-3060TR	DT-10					
		108-30D	●	28	27	8	20	19	110	40	6.3	4.5	-2.5°			SB-5090TR		LTW-20						
		110-30D	●	30	28	10	18	120	6.0	0°														
		MCSE	108-60D	●	19.5	19	8	20	19	110	40	10	0.25						0.8	60°	0°	Fig.6	SB-5070TR	LTW-20
			120-60D	●	31	30	20	18	120	6.5	0°													
Weldon	MCSE	106-W	●	22	21	6	20	16	92	40	8.6	3.0	0.8	45°	0°		SB-5090TR	LTW-20						
		115-W	●	31	30	15	20	18				6.5												
		227-W	●	43	42	27	32	30				120							6.5					
		336-W	●	52	51	36	38	105				45							7.0	+10°				

* Dimension T indicates available back chamfering dimension.

Applicable Inserts

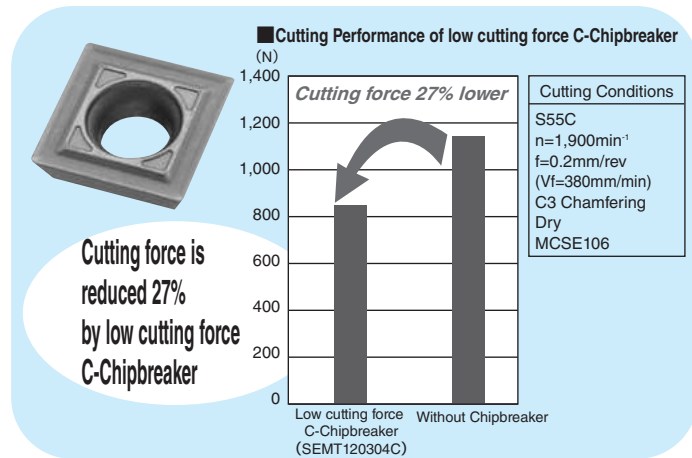
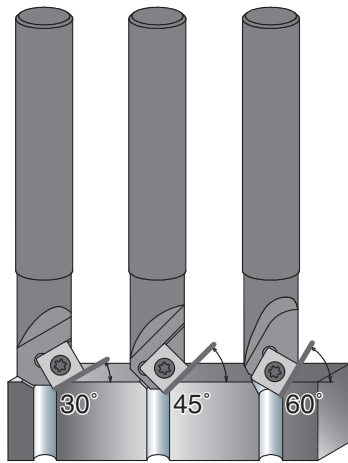
Description	Applicable Inserts M22		
			
MCSE 104 104-30D	SDKW09T204TN	SDKW09T204FN	SDMT09T204C
MCSE 106 115 227 336	SEKW120304TN 120308TN	SEKW120304FN 120308FN	SEMT120304C
MCSE 108-30D 110-30D			
MCSE 108-60D 120-60D			

● : Std. Item

◆ Recommended Cutting Conditions

Workpiece Material	fz (mm/t)		Recommended Insert Grades (Cutting Speed Vc: m/min)		
			Cermet	MEGACOAT	Carbide
	ϕ Ds ($\phi 4 \sim \phi 20$)	ϕ Ds ($\phi 27 \sim \phi 36$)	TN100M	PR1225	KW10
Carbon Steel	0.05~0.25	0.2~0.4	★ 100~180	★ 120~250	-
Alloy Steel	0.05~0.25	0.2~0.4	★ 100~180	★ 100~220	-
Mold Steel	0.05~0.25	0.2~0.4	★ 100~150	★ 80~180	-
Stainless Steel	0.05~0.2	0.1~0.3	☆ 100~180	★ 120~220	-
Cast Iron	0.1~0.3	0.3~0.5	-	-	☆ 80~150
Non-ferrous Metals	0.1~0.3	0.3~0.5	-	-	★ 100~300

★ : 1st Recommendation ☆ : 2nd Recommendation



M



Milling