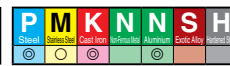
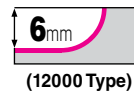
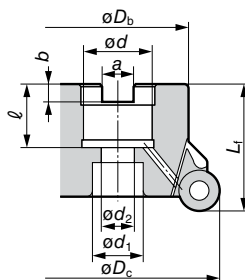


# WRCX(F)12000 Type

Rake Angle	Radial	0°
	Axial	-3°



Milling for Steel, Stainless Steel, Cast Iron and Non-Ferrous Alloys



## Body (WRCX12000)

Metric	Cat. No.	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	
			$\phi D_c$	$\phi D_b$	$L_f$	$\phi d$	$a$	$b$	$\ell$	$\phi d_1$			$\phi d_2$
	<b>WRCX 12040RS</b>	●	40	36	40	16	8.4	5.6	18	13.5	9	4	0.2
	<b>12050RS</b>	●	50	40	40	22	10.4	6.3	20	18	11	4	0.2
	<b>12063RS</b>	●	63	40	40	22	10.4	6.3	20	18	11	5	0.4
	<b>12080RS</b>	●	*80	55	50	27	12.4	7.0	25	20	13.5	6	0.9

Inserts are not included.

## Body (WRCXF12000) Fine Pitch Type

Metric	Cat. No.	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	
			$\phi D_c$	$\phi D_b$	$L_f$	$\phi d$	$a$	$b$	$\ell$	$\phi d_1$			$\phi d_2$
	<b>WRCXF 12050RS</b>	●	50	40	40	22	10.4	6.3	20	18	11	5	0.2
	<b>12063RS</b>	●	63	40	40	22	10.4	6.3	20	18	11	6	0.4

Inserts are not included.



\*Please use JIS B1176 hexagonal bolt for securing cutter to the arbour.

## Inserts

**P** Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade	Coat					Carbide	DLC	Dimensions (mm)				
		ACP100	ACP200	ACP300	ACK200	ACK300			A	$r_\epsilon$	s	Fig	
High Speed/Light General Purpose Roughing		<b>P</b>			<b>K</b>	<b>N</b>							
		<b>M</b>	<b>M</b>	<b>M</b>	<b>K</b>								
		<b>M</b>	<b>M</b>		<b>K</b>								
Usage	Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	H1	DL1000	A	$r_\epsilon$	s	Fig	
General Purpose	<b>QPMT 120440 PPEN</b>	●	●	●	●	●	—	—	12	4.0	4.76	1	
	<b>120440 PPEN-H</b>	●	●	●	●	●	—	—	12	4.0	4.76	1	
Non-Ferrous Metal	<b>QPET 120460 PPF-R-S</b>	—	—	—	—	—	●	●	12	6.0	4.76	2	
Surfing	<b>QPMT 120460 PPER-R</b>	●	●	—	—	—	—	—	12	6.0	4.76	3	

Fig 1

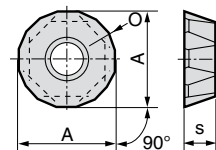


Fig 2

Non-Ferrous Metal

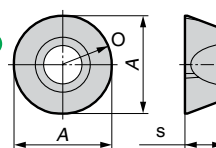
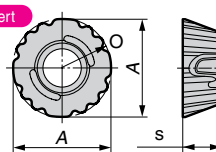


Fig 3

Surfing Insert



\*H: Strong edge.

## Spare Parts

screw	Spanner	Anti-seizure Cream
BFTX0409IP <b>3.0</b> (N·m)	TRDR15IP	SUMI-P

**(N·m)** Recommended Tightening Torque (N·m)

## Recommended Cutting Conditions

External Diameter:  $\phi 40$  to  $\phi 80$ mm

ISO	Work Material	Hardness	Cutting Speed $v_c$ (m/min) Min. - Optimum - Max.	Feed Rate $f_z$ (mm/t) Min. - Optimum - Max.	Grade
<b>P</b>	Carbon Steel	180 to 280HB	100-160-200	0.20-0.40-0.60	ACP200
	Alloy Steel	180 to 280HB	100-140-180	0.20-0.30-0.40	ACP200
<b>M</b>	Stainless Steel	—	80-120-160	0.10-0.20-0.30	ACP300
<b>K</b>	Cast Iron	250HB	80-120-160	0.10-0.20-0.40	ACK200
<b>N</b>	Non-Ferrous Metal	—	200-500-1000	0.10-0.30-0.40	DL1000

**Note** The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.