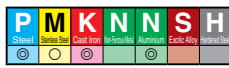
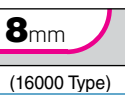


Rake Angle	Radial	0°
	Axial	-3°



SEC-WaveRadius Mill

WRCX(F)16000 Type

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



Fig 1

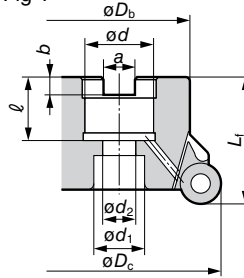
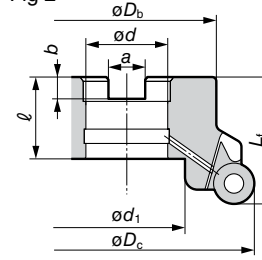


Fig 2



Body (WRCX16000)

	Cat. No.	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig	
			σD_c	σD_b	L_f	σd	a	b	ℓ	σd_1				σd_2
Metric	WRCX 16063RS	●	63	50	40	22	10.4	6.3	20	18	11	3	0.4	1
	16080RS	●	*80	55	50	27	12.4	7.0	25	20	13.5	4	0.8	1
	16100RS	●	100	70	50	32	14.4	8.5	32	46	—	5	1.2	2
Imperial	WRCX 16080R	●	*80	55	50	25.4	9.5	6.0	25	20	13	4	0.8	1
	16100R	●	*100	70	63	31.75	12.7	8.0	32	46	17	5	1.4	1

Inserts are not included.

Body (WRCXF16000) Fine Pitch Type

	Cat. No.	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig	
			σD_c	σD_b	L_f	σd	a	b	ℓ	σd_1				σd_2
Metric	WRCXF 16063RS	●	63	50	40	22	10.4	6.3	20	18	11	4	0.4	1
	16080RS	●	*80	55	50	27	12.4	7.0	25	20	13.5	5	0.7	1
	16100RS	●	100	70	50	32	14.4	8.5	32	46	—	6	1.2	2

Inserts are not included.



*Please use JIS B1176 hexagonal bolt ($\sigma 80$: M12x30 to 35mm, $\sigma 100$: M16x40 to 45mm) for securing $\sigma 80/\sigma 100$ 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	Coated Carbide						Carbide	DLC
		P	M	K	N	S	H		
High Speed/Light		P		K				N	
General Purpose		P	M	K				N	
Roughing		P	M	K					

Usage	Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	H1	DL1000	Dimensions (mm)			Fig
									A	r_ϵ	s	
General Purpose	QPMT 160660 PPEN	●	●	●	●	●	—	—	16	6.0	6.5	1
	160660 PPEN-H	●	●	●	●	●	—	—	16	6.0	6.5	1
Anti-Vibration	QPMT 160608 PPEN	●	●	●	●	●	—	—	16	0.8	6.5	1
	160608 PPEN-CP	●	●	●	●	●	—	—	16	0.8	6.5	2
Non-Ferrous Metal	QPET 160680 PPFR-S	—	—	—	—	—	●	●	16	8.0	6.5	3
Surfing	QPMT 160680 PPER-R	●	●	—	—	—	—	—	16	8.0	6.5	4

Fig 1

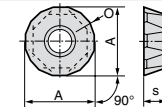


Fig 2 (CP Type)

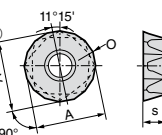


Fig 3

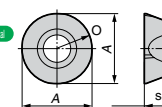
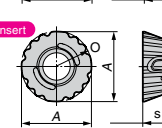


Fig 4



*1 -H: Strong edge. *2: When using anti-vibration inserts, 08 type and 08-CP type inserts must be set in alternating fashion.

Spare Parts

screw	Spanner	Anti-seize Cream
BFTX0511P	5.0 TRDR20IP	SUMI-P

Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

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

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	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
M	Stainless Steel	—	80-120-160	0.10-0.20-0.30	ACP300
K	Cast Iron	250HB	80-120-160	0.10-0.20-0.40	ACK200
N	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.

External Diameter: $\sigma 100$ to $\sigma 160$ mm

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	Carbon Steel	180 to 280HB	150-200-250	0.30-0.40-0.60	ACP200
	Alloy Steel	180 to 280HB	100-160-200	0.10-0.30-0.50	ACP200
M	Stainless Steel	—	160-180-200	0.15-0.20-0.30	ACP300
K	Cast Iron	250HB	100-150-200	0.10-0.15-0.20	ACK200
N	Non-Ferrous Metal	—	200-500-1000	0.20-0.40-0.60	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.

Milling Cutters
 Face Milling
 Radius
 Multi-Purpose
 Shoulder Milling
 R/Copying
 Groove/T-Slot
 Chamfering
 Aluminium/Light Alloys
 High-Speed Cast Iron