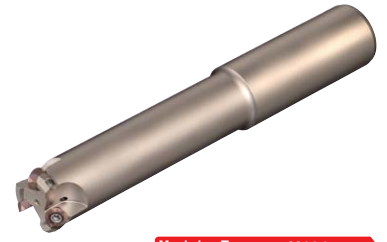
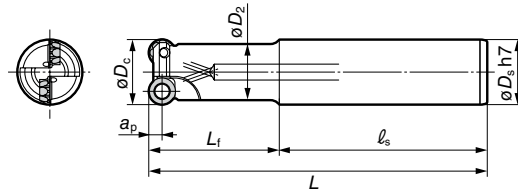


SEC-Wave Radius Mill

WRCX08000E/10000E/16000E Type

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



Modular Type H131

Body (WRCX08000E) Insert: A=8 Type

Cat. No.	Stock	Dimensions(mm)							No. of Teeth	Weight (kg)
		ϕD_c	ϕD_s	ϕD_2	a_p	L_f	l_s	L		
WRCX 08020ES	●	20	20	18	4	50	80	130	2	0.2
08020EM	●	20	20	18	4	100	80	180	2	0.3
08020EL		20	20	18	4	130	120	250	2	0.5
WRCX 08025ES	●	25	25	21	4	50	80	130	3	0.4
08025EM	●	25	25	21	4	100	80	180	3	0.5
08025EL		25	25	21	4	130	120	250	3	0.7

Inserts are not included.

Body (WRCX10000E) Insert: A=10 Type

Cat. No.	Stock	Dimensions (mm)							No. of Teeth	Weight (kg)
		ϕD_c	ϕD_s	ϕD_2	a_p	L_f	l_s	L		
WRCX 10025ES	●	25	25	21	5	50	80	130	2	0.4
10025EM	●	25	25	21	5	100	80	180	2	0.5
10025EL		25	25	21	5	130	120	250	2	0.7
WRCX 10032ES	●	32	32	28	5	50	80	130	3	0.7
10032EM	●	32	32	28	5	120	80	200	3	1.0
10032EL		32	32	28	5	180	120	300	3	1.5

Inserts are not included.

Body (WRCX16000E) Insert: A=16 Type

Cat. No.	Stock	Dimensions (mm)							No. of Teeth	Weight (kg)
		ϕD_c	ϕD_s	ϕD_2	a_p	L_f	l_s	L		
WRCX 16040ES	●	40	32	31.3	8	50	120	170	2	0.9
16040EM	●	40	32	31.3	8	50	200	250	2	1.4
WRCX 16050ES	●	50	32	40.8	8	50	120	170	3	1.0
16050EM	●	50	32	40.8	8	50	200	250	3	1.5

Inserts are not included.

Inserts

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

Usage	Cat. No.	Grade				DL1000	Dimensions (mm)			Fig	Applicable Cutters
		Coated Carbide					A	r_ϵ	s		
		High Speed/Light	General Purpose	Roughing							
General Purpose	QPMT 080330 PPEN	●	●	●	●	8	3.0	3.18	1	WRCX08000E Type	
	080330 PPEN-H	●	●	●	●	8	3.0	3.18	1		
	QPMT 10T335 PPEN	●	●	●	●	10	3.5	3.97	1	WRCX10000E Type	
	10T335 PPEN-H	●	●	●	●	10	3.5	3.97	1		
	QPMT 160660 PPEN	●	●	●	●	16	6.0	6.5	1	WRCX16000E Type	
	160660 PPEN-H	●	●	●	●	16	6.0	6.5	1		
Anti-Vibration	QPMT 160608 PPEN	●	●	●	●	16	0.8	6.5	1	WRCX16000E Type	
	160608 PPEN-CP	●	●	●	●	16	0.8	6.5	2		
Non-Ferrous Metal	QPET 10T350 PPFR-S	—	—	—	●	10	5.0	3.97	3	WRCX10000E Type	
	QPET 160680 PPFR-S	—	—	—	●	16	8.0	6.5	3	WRCX16000E Type	
Surfing	QPMT 160680 PPER-R	●	●	—	—	16	8.0	6.5	4	WRCX16000E Type	

*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

Applicable Cutters	Screw	Spanner
WRCX08000E Type	BFTX02506IP	TRDR08IP
WRCX10000E Type	BFTX03584IP	TRDR15IP
WRCX16000E Type	BFTX0511IP	TRDR20IP

Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

External Diameter: $\phi 20$ to $\phi 32$ 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	80-120-160	0.10-0.30-0.40	ACP200
	Alloy Steel	180 to 280HB	60-100-140	0.10-0.20-0.30	ACP200
M	Stainless Steel	—	60-100-120	0.10-0.15-0.20	ACP300
K	Cast Iron	250HB	60-80-120	0.10-0.20-0.30	ACK200
N	Non-Ferrous Metal	—	200-500-1000	0.10-0.20-0.30	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: $\phi 40$ to $\phi 50$ 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.

Fig 1

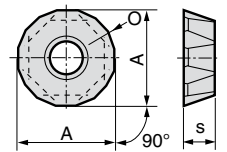


Fig 2 (CP Type)

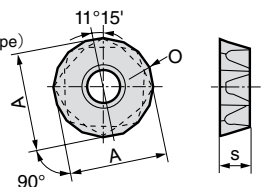


Fig 3

Non-Ferrous Metal

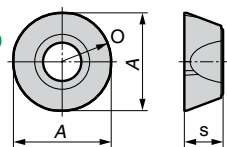
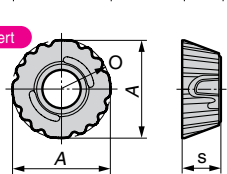


Fig 4

Surfing Insert



Milling Cutters

Face Milling

Radius

Multi-Purpose

Shoulder Milling

R/Copying

Groove/T-Slot

Chamfering

Aluminum/Light Alloys

High-Speed Cast Iron