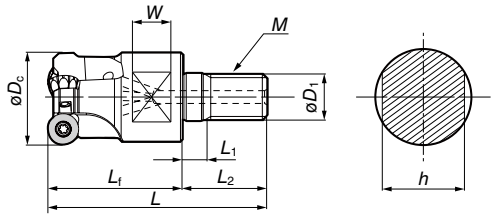
Rake Angle			Max. Depth of Cut	Max. Depth of Cut	Max. Depth of Cut
	Radial	0°	4mm	5mm	6mm
	Axial	−3°	(08000M Type)	(10000M Type)	(12000M Type)

P Steel ◎ | M Stainless Steel ○ | K Cast Iron ◎ | N Non-Ferrous Metal | N Aluminum ◎ | S Exotic Alloy | H Hardened Steel

WRCX08000M Type

WRCX10000M Type

WRCX12000M Type



Head (WRCX 08000M)

Applicable Insert A = 8 mm Type

Cat. No.	Stock	Dimensions (mm)									No. of Teeth
		øDc	øD1	M	L	Lf	L1	L2	W	h	
WRCX 08020M10Z2	●	**20**	10.5	M10	49	30	5	19	8	15	2
08025M12Z3	●	**25**	12.5	M12	56	35	5	21	10	19	3

Inserts are not included.

Head (WRCX 10000M)

Applicable Insert A = 8 mm Type

Cat. No.	Stock	Dimensions (mm)									No. of Teeth
		øDc	øD1	M	L	Lf	L1	L2	W	h	
WRCX 10025M12Z2	●	**25**	12.5	M12	56	35	5	21	10	19	2
10028M12Z2	●	**28**	12.5	M12	56	35	5	21	10	19	2
WRCX 10030M16Z3	●	**30**	17.0	M16	63	40	5	23	10	24	3
10032M16Z3	●	**32**	17.0	M16	63	40	5	23	10	24	3

Inserts are not included.

Head (WRCX 12000M)

Applicable Insert A = 8 mm Type

Cat. No.	Stock	Dimensions (mm)									No. of Teeth
		øDc	øD1	M	L	Lf	L1	L2	W	h	
WRCX 12040M16Z4	●	**40**	17.0	M16	63	40	5	23	10	24	4

Inserts are not included.

Spare Parts

Spanner		Screw	Applicable Head
	N·m		
BFTX02506IP	1.5	TRDR08IP	WRCX08000M
BFTX03584IP	3.0	TRDR15IP	WRCX10000M
BFTX0409IP	3.0		WRCX12000M

N·m Recommended Tightening Torque (N · m)

Anti-seizure cream SUMI-P included in the package.

Identification Details

WRCX 08 020 M10 Z2

(1) Cutter Series | (2) Insert size | (3) Diameter | (4) Mounting Screw | (5) No. of Flutes

Inserts

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

Grade		Coated Carbide				Carbide		DLC							
Application	High Speed/Light	P			K			N							
	General Purpose		PM	PM	K			N							
	Roughing		PM	PM		K									
Usage	Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	H1	DL1000		Dimensions (mm) A	rε	s	Fig	Applicable Cutters
General Purpose *1	**QPMT 080330 PPEN**		●	●	●	●	—	—		8	3.0	3.18	1	WRCX08000M Type
	080330 PPEN-H		●	●	●	●	—	—		8	3.0	3.18	1	
	QPMT 10T335 PPEN		●	●	●	●	—	—		10	3.5	3.97	1	WRCX10000M Type
	10T335 PPEN-H		●	●	●	●	—	—		10	3.5	3.97	1	
	QPMT 120440 PPEN		●	●	●	●	—	—		12	4.0	4.76	1	WRCX12000M Type
	120440 PPEN-H		●	●	●	●	—	—		12	4.0	4.76	1	
Non-Ferrous Metal	**QPET 10T350 PPFR-S**	—	—	—	—	—	●		●	10	5.0	3.97	2	WRCX10000M Type
	QPET 120460 PPFR-S	—	—	—	—	—	●		●	12	6.0	4.76	2	WRCX12000M Type
Surfing	**QPMT 120460 PPER-R**		●	●			—		—	12	6.0	4.76	3	WRCX12000M Type

Fig 1

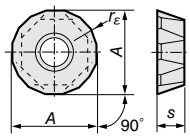


Fig 2

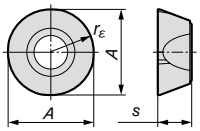
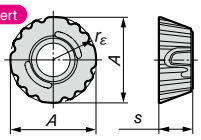


Fig 3 Surfing Insert



*1-H: Strong edge.

Recommended Cutting Conditions

External Diameter: ø20 to ø32mm

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
P	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: ø40mm

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
P	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.