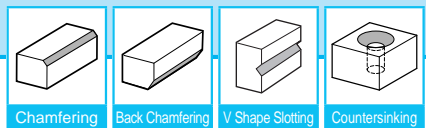
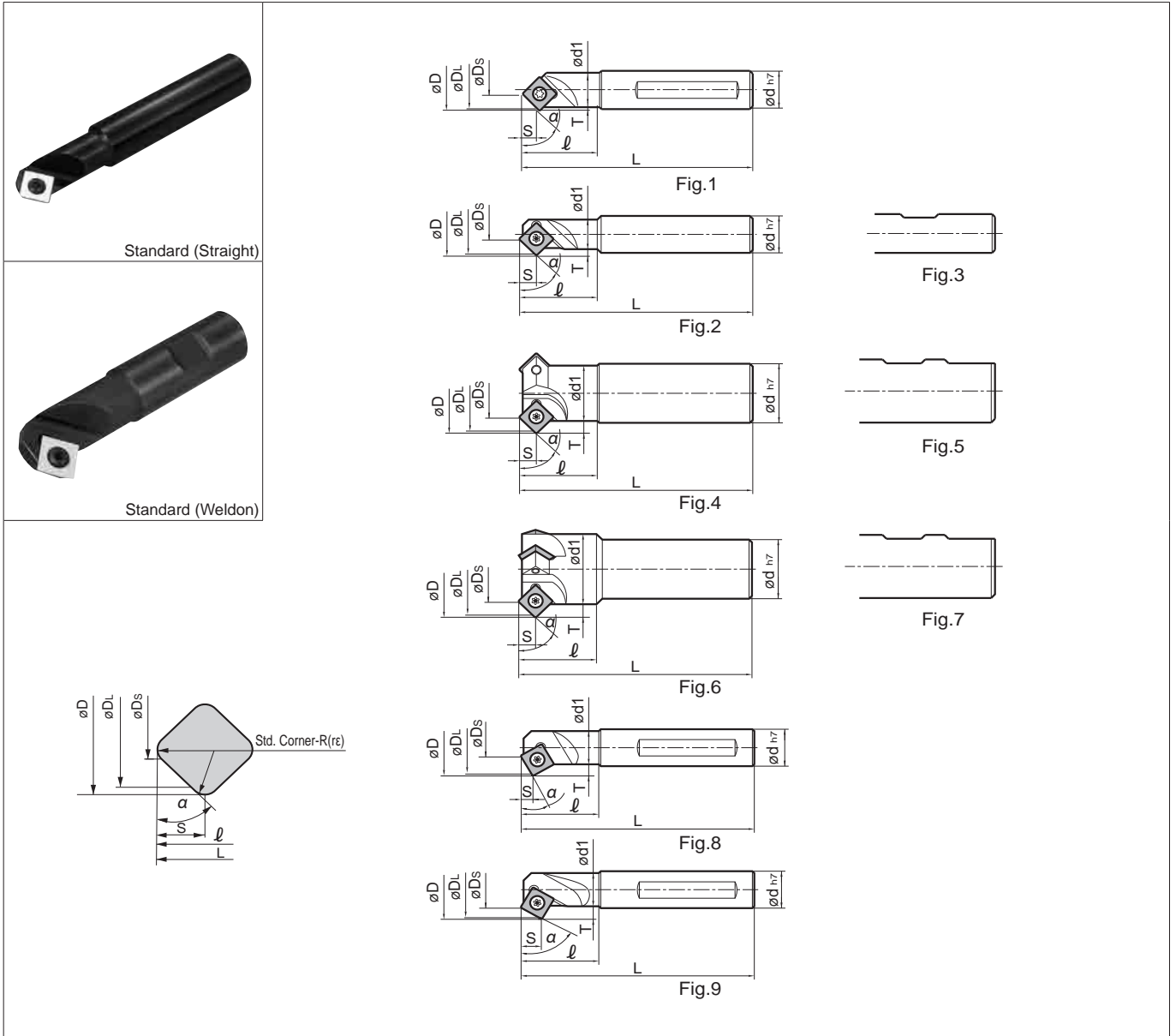


MCSE Chamfering Endmill



MCSE



M



Milling



● Toolholder Dimensions

| Toolholder Dimensions | | Std. | No. of Inserts | Dimension (mm) | | | | | | | | | Std. Corner-R(r _c) | Angle (°) | Rake Angle (°) | | Drawing | Spare Parts | | |
|-----------------------|--------------|------|----------------|----------------|-----|-----|------|-------|-----|-----|------|-------|--------------------------------|-----------|----------------|-------|-----------|-------------|-------------|--------|
| | | | | øD | øDL | øDS | ød | ød1 | L | l | S | T | | | α | A.R. | | R.R. | Clamp Screw | Wrench |
| Cylindrical | MCSE 104 | ● | 1 | 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 | -1° | | | Fig.2 | | | | |
| | 115 | ● | | 31 | 30 | 15 | 18 | 6.5 | | | | | +5° | | | Fig.4 | | | | |
| | 227 | ● | | 43 | 42 | 27 | 30 | 6.5 | | | | | +8° | | | Fig.4 | | | | |
| | 336 | ● | | 52 | 51 | 36 | 32 | 7.0 | | | | | +10° | | | Fig.6 | | | | |
| Weldon | MCSE 106-W | ● | 1 | 22 | 21 | 6 | 20 | 16 | | | | | 92 | 40 | 3.0 | 0.8 | 45° | 0° | -1° | Fig.3 |
| 115-W | ● | 31 | 30 | 15 | 18 | 6.5 | +5° | Fig.5 | | | | | | | | | | | | |
| 227-W | ● | 43 | 42 | 27 | 30 | 6.5 | +8° | Fig.5 | | | | | | | | | | | | |
| 336-W | ● | 52 | 51 | 36 | 32 | 7.0 | +10° | Fig.7 | | | | | | | | | | | | |
| Cylindrical | MCSE 104-30D | ● | 1 | 19 | 18 | 4 | 16 | 15 | 85 | 30 | 4.7 | 2.0 | 0.8 | 30° | 0° | | | | -2.5° | Fig.8 |
| 108-30D | ● | 28 | | 27 | 8 | 20 | 19 | 110 | 40 | 6.3 | 4.5 | 0° | | | | Fig.8 | | | | |
| 110-30D | ● | 30 | | 28 | 10 | 20 | 18 | 120 | 40 | 6.0 | 6.0 | 0° | | | | Fig.8 | | | | |
| MCSE 108-60D | ● | 19.5 | | 19 | 8 | 20 | 19 | 110 | 40 | 10 | 0.25 | -3.5° | | | | Fig.9 | SB-5070TR | LTW-20 | | |
| 120-60D | ● | 31 | | 30 | 20 | 20 | 18 | 120 | 40 | 10 | 6.5 | 0° | | | | Fig.9 | | | SB-5090TR | |

• Dimension T indicates available back chamfering dimension.

● : Std. Item □ : Check Availability

● Applicable Inserts

| Description | Applicable Inserts M13,M14 | | |
|---|---|--|--------------|
| |  |  | |
| MCSE 104 104-30D | SDKW 09T204TN | SDKW 09T204FN | SDMT 09T204C |
| MCSE 106 (-W) 115 (-W) 227 (-W) 336 (-W) | SEKW 120304TN 120308TN | SEKW 120304FN 120308FN | SEMT 120304C |
| MCSE 108-30D 110-30D | | | |
| MCSE 108-60D 120-60D | | | |

◆ Recommended Cutting Conditions

| Workpiece Material | fz (mm/t) | | Insert Grade (Cutting Speed Vc: m/min) | | | | | | | | | | | |
|--------------------|--------------|---------------|--|--------------|-------------|--------------|--------------|--------------------|--------------|-------|-------|---------|------|--------------|
| | | | Cermet | | | MEGACOAT | | PVD Coated Carbide | | | | Carbide | | |
| | ∅Ds (∅4~∅20) | ∅Ds (∅27~∅36) | TN60 | TN100M | TC60 | PR1225 | PR1210 | PR630 | PR730 | PR830 | PR660 | PR905 | PW30 | KW10 |
| Stainless Steel | 0.05~0.2 | 0.1~0.3 | | ☆ 100~180 | ☆ 80~160 | ★ 120~220 | - | ☆ 100~180 | ☆ 100~180 | | | | | - |
| Carbon Steel | 0.05~0.25 | 0.2~0.4 | | ★ 100~180 | ☆ 80~160 | ★ 120~250 | - | ☆ 100~180 | ☆ 100~180 | | | | | - |
| Alloy Steel | 0.05~0.25 | 0.2~0.4 | | ★ 100~180 | ☆ 80~160 | ★ 100~220 | - | ☆ 80~150 | ☆ 80~150 | | | | | - |
| Mold Steel | 0.05~0.25 | 0.2~0.4 | | ★ 100~150 | ☆ 80~130 | ★ 80~180 | - | ☆ 60~130 | ☆ 60~130 | | | | | - |
| Cast Iron | 0.1~0.3 | 0.3~0.5 | | - | - | - | ★ 100~220 | - | - | | | | | ★ 80~150 |
| Non-ferrous Metals | 0.1~0.3 | 0.3~0.5 | | - | - | - | - | - | - | | | | | ★ 100~300 |

★ : 1st Recommendation ☆ : 2nd Recommendation

