

ECO+PLUS

MCX Series Chamfering Endmill



General Engineering



Mold&Die



Automotive



Finish



Rough



Available from stock in all sizes **% 100**



Stock	Code	d1	d2h6	l1	α (°)	Z
*	MCX404051	4	6	51	90°	4
*	MCX406058	6	6	58	90°	4
*	MCX508064	8	8	64	90°	5
*	MCX610073	10	10	73	90°	6
*	MCX612082	12	12	82	90°	6

Cutting Parameters

Material	Pah Karma Freze
	Vc (m/min)



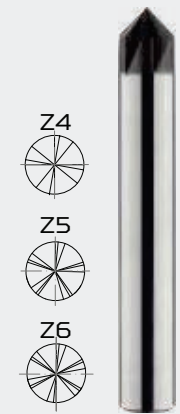
Material	Vc (m/min)	
Steel	Unalloyed Steel 280-320	
	Steel 220-250	
	Tempered Steel 190-220	
	Cold Work Tool Steel 100-130	
Stainless Steel	Hot Work Tool Steel 100-130	
	AISI 304 - 416 - 420 80-110	
	AISI 316 - 440 80-110	
	17-4 PH 15-5 PH 60-90	
	Chrome-Cobalt Alloy 60-90	
	Duplex F51 50-70	
	Super Duplex F55 50-70	
	Cast Iron	Gray Cast Iron 200-240
		Alloyed Cast Iron 200-240
		Precision Cast Iron 180-215
Aluminum Alloys 230-370		
Titanium	Copper Alloys 650-680	
	Iron-Based Super Alloys 40-50	
	Nickel-Based Super Alloys 40-50	
	Titanium-Based Super Alloys 70-90	

Feed Per Tooth (mm/tooth)

d	ae=0.1xØ ap=0.1xØ
0	
4	0.05-0.11
6	0.06-0.15
8	0.08-0.2
10	0.1-0.26
12	0.1-0.26
14	0.1-0.26
16	0.12-0.26
20	0.16-0.44

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MCX Chamfering Endmill



MCX Eco-Plus

≤48 HRC +TiAlN



α 90°

Steel	●
Stainless Steel	○
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	●
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended

* Marked products can be delivered quickly from stock.

