

Wave Radius Mill

WRCX 08000/10000 E Type

Multi Purpose Endmills with Polygon Inserts



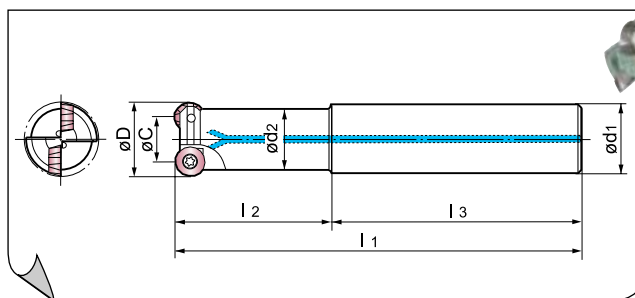
Shank Type with Small Diameter Inserts

E₋ : Cylindrical straight shank type

ES : Short type with straight shank

EM : Middle length type with straight shank

EL : Long type with straight shank



Axial rake angle: -3°
Radial rake angle: 0 ~ 35°

■ BODY

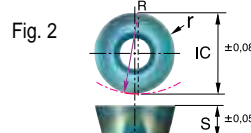
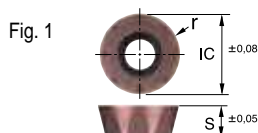
■ Spare Parts

Insert IC (mm)	Cat. No.	Stock	Dimensions (mm)							No. of teeth	Axial Rake	Radial Rake	Helical Boring øB Standard	Plunging α max.		
8	WRCX 08012 ES	●	12	-	12	9,4	110	40	70	1	-3°	-35°	-	0°30'	BFTX 02505 IP	TRDR 08 IP
	WRCX 08012 EM	●	12	-	12	9,4	150	70	80	1	-3°	-10°	24 ⁺⁷ ₋₄	5°30'	BFTX 02506 IP	TRDR 08 IP
	WRCX 08016 ES	●	16	-	16	14	120	50	70	1	-3°	-10°	24 ⁺⁷ ₋₄	5°30'		
	WRCX 08016 EM	●	16	-	16	14	150	70	80	1	-3°	-10°	24 ⁺⁷ ₋₄	5°30'		
	WRCX 08020 ES	●	20	12	20	18	130	50	80	2	-3°	-3°	32 ± 7	13°		
	WRCX 08020 EM	●	20	12	20	18	180	100	80	2	-3°	-3°	32 ± 7	13°		
	WRCX 08020 EL	●	20	12	20	18	250	130	120	2	-3°	-3°	32 ± 7	13°		
	WRCX 08025 ES	●	25	17	25	21	130	50	80	3	-3°	0°	42 ± 7	8°20'		
10	WRCX 08025 EM	●	25	17	25	21	180	100	80	3	-3°	0°	42 ± 7	8°20'	BFTX 03584 IP	TRDR 15 IP
	WRCX 08025 EL	●	25	17	25	21	250	130	120	3	-3°	0°	42 ± 7	8°20'		
	WRCX 10025 ES	●	25	15	25	21	130	50	80	2	-3°	0°	40 ± 8	13°10'		
	WRCX 10025 EM	●	25	15	25	21	180	100	80	2	-3°	0°	40 ± 8	13°10'		
	WRCX 10025 EL	●	25	15	25	21	250	130	120	2	-3°	0°	40 ± 8	13°10'		
	WRCX 10032 ES	●	32	22	32	28	130	50	80	3	-3°	0°	54 ± 8	8°		
	WRCX 10032 EM	●	32	22	32	28	200	120	80	3	-3°	0°	54 ± 8	8°		
	WRCX 10032 EL	●	32	22	32	28	300	180	120	3	-3°	0°	54 ± 8	8°		

■ Insert

- QPMT... : Standard 16 cornered polygon type
- QPMT...-H : Stronger cutting edge type

- QPET...-S : Polished round insert for non-ferrous material



Rake angle: 25°
4 corners use
R : wiper radius

Cat. No.	Coated Carbide					Diamond Coated	Uncoated carbide	IC (mm)	r (mm)	s (mm)	Max. d _{oc}		Fig.	Applicable Endmill
	ACP100	ACP200	ACP300	ACK200	ACK300	DL1000	H1				4 corners application	8 corners application		
QPMT 080330 PPEN	●	●	●	●	●			8	3,0	3,18	3,8	1,0	①	WRCX 08000 E
QPMT 080330 PPEN-H	●	●	●	●	●									
QPMT 10T335 PPEN	●	●	●	●	●			10	3,5	3,97	4,7	1,2	①	WRCX 10000 E
QPMT 10T335 PPEN-H	●	●	●	●	●									
QPET 10T350 PPFR-S						●	●		5,0			-	②	

■ Recommended Cutting Conditions

[v_c = m/min, f_t = mm/tooth] [min. – optimum – max.]

Material	Carbon steel (ex. C40 ~ C50)	Alloy steel (Below HRC40)	Stainless steel (ex. X10CrNiS18-9)	Cast iron (ex. GG20)	Non-ferrous material
Grade	ACP100, ACP200	ACP100, ACP200	ACP200, ACP300	ACK200, ACK300	DL1000, H1
12 ~ 32	v _c 80-120-160	60-100-140	60-100-120	60-80-120	200-500-1000
32	f _t 0,1-0,3-0,4	0,1-0,2-0,3	0,1-0,15-0,2	0,1-0,2-0,3	0,1-0,2-0,3

- = Euro stock
- = Delivery on request