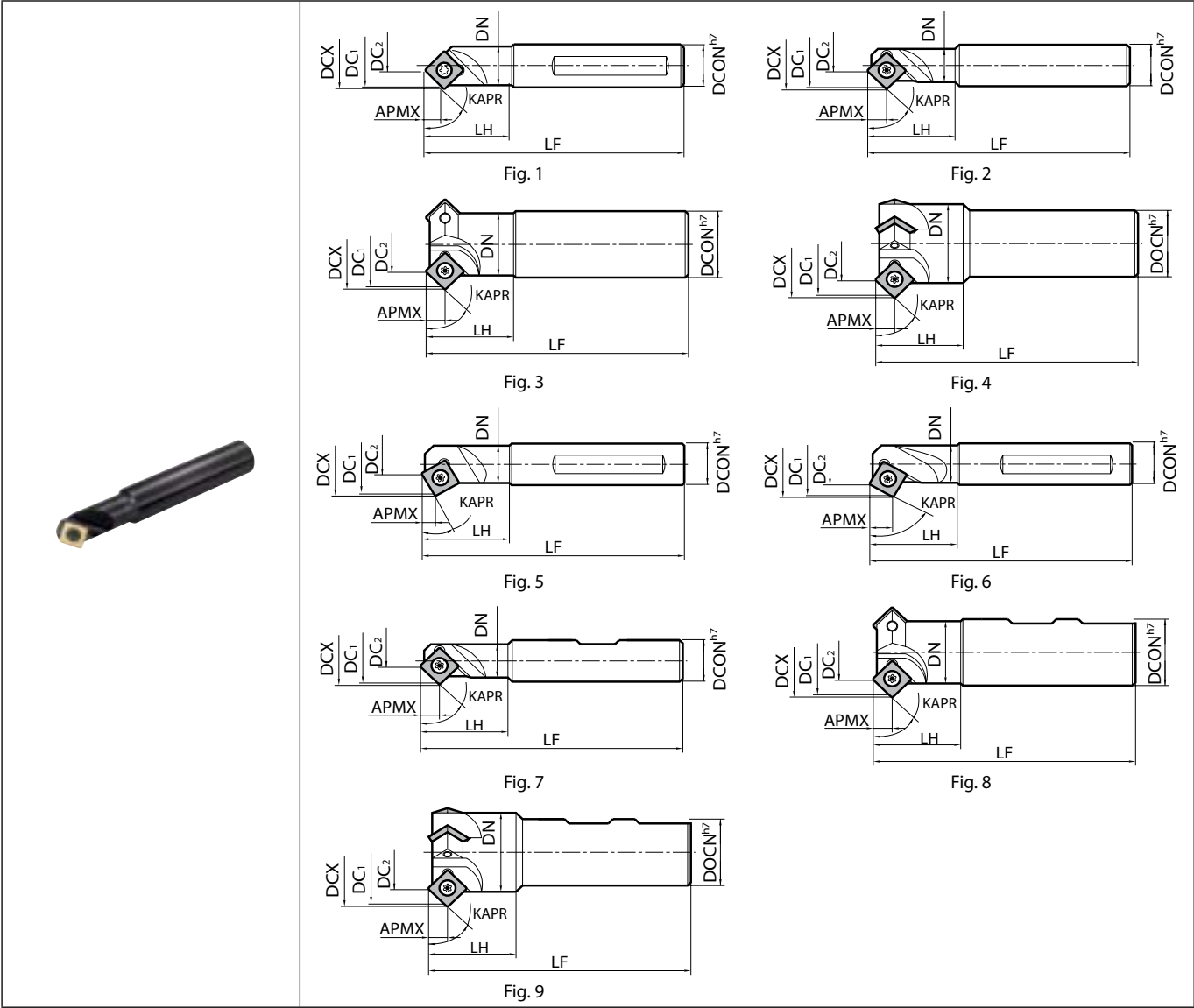


MCSE



M



Milling

Cutting edge angle
45°~70°

Cutting edge angle
75°

Cutting edge angle
88°/90°

Cutter for
Finishing

High Feed
Cutter

Multi-
Function

Slot Mill

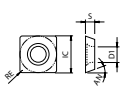
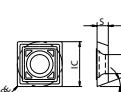
Ball-nose
Radius

Others

Toolholder dimensions

Description		Availability	Inserts	Dimension (mm)								Standard corner-R(RE)	KAPR (°)	A.R. (°)	R.R. (°)	Coolant hole	Fig.	Spare parts			Applicable inserts  M281	
				DCX	DC1	DC2	DCON	LF	LH	APMX	DN							Screw 	Wrench 	Wrench 		
MCSE 104	●	1	16	15	4	16	85	31	6.5	15	0.4	45	0	-4.5	No	1	SB-3060TR	DT-10	-	SDKW09T2... SDMT09T204C		
	●		22	21	6	20	121	41	8.6	16	0.8					2	SB-5090TR	-	LTW-20	SEKW1203... SEMT120304C		
	●		31	30	15					18												
	●		2	43	42					27						30					+5	2
	●		3	52	51					36						32					38	+8
MCSE 106-W 115-W	□	1	22	21	6	20	92	40	8.6	16	0.8	45	0	-1	No	7	SB-5090TR	-	LTW-20	SEKW1203... SEMT120304C		
	□		31	30	15					18						+5					7	
MCSE 104-30D 108-30D 110-30D	●	1	19	18	4	16	85	31	4.7	15	0.4	30	0	-4	No	5	SB-3060TR	DT-10	-	SDKW09T2... SDMT09T204C		
	●		28	27	8	20	110	41	6.3	19	0.8					5	SB-5090TR	-	LTW-20	SEKW1203... SEMT120304C		
	●		30	28	10					18											0	5
MCSE 108-60D 120-60D	●	1	19.5	19	8	20	110	41	10	19	0.8	60	0	-3.5	No	6	SB-5070TR	-	LTW-20	SEKW1203... SEMT120304C		
	●		31	30	20					18						6						

SDKW/SDMT/SEKW/SEMT

Classification of usage ★ : Roughing / 1st Choice ☆ : Roughing / 2nd Choice ■ : Finishing / 1st Choice □ : Finishing / 2nd Choice (In case hardness is 45HRC or under)			Carbon steel / Alloy steel					★	■	P	
			Mold and die steel					★	■		
			Austenitic stainless steel					★		M	
			Martensitic stainless steel								
			Precipitation hardening stainless steel								
			Gray cast iron						☆	K	
			Nodular cast iron								
			Non-ferrous metals						★	N	
			Heat-resistant alloy							S	
			Titanium alloy						☆		
Hard materials								H			
Insert		Description	Dimension (mm)				Angle (°)	Carbide	Cermets	Applicable toolholder ➡ M281	
			IC	S	D1	RE	AN	PVD			-
 		SDKW 09T204FN	9.525	2.78	3.4	0.4	15		●		MCSE104-30D MCSE104
		SDKW 09T204TN	9.525	2.78	3.4	0.4	15	●	●		MCSE104-30D MCSE104
		SEKW 120304FN 120308FN	12.7	3.18	5.5	0.4 0.8	20		● ●		MCSE106(-W), MCSE108-...D MCSE110-30D, MCSE115(-W) MCSE120-60D, MCSE227(-W) MCSE336(-W)
		SEKW 120304TN 120308TN	12.7	3.18	5.5	0.4 0.8	20	● ●	● ●		
  Low cutting force		SDMT 09T204C	9.525	2.78	3.4	0.4	15	●	●	●	MCSE104-30D MCSE104
		SEMT 120304C	12.7	3.18	5.5	0.4	20	●	●		MCSE106(-W), MCSE108-...D MCSE110-30D, MCSE115(-W) MCSE120-60D, MCSE227(-W) MCSE336(-W)

Recommended cutting conditions ➡ M282

● : Standard item R : Right-hand only L : Left-hand only □ : Check availability

M



Milling

Applicable inserts

Description		Applicable inserts  M281		
				
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)		Recommended insert grades (Vc: m/min)		
			MEGACOAT	Carbide	Cermet
	DC ₂ (ø4~ø20)	DC ₂ (ø27~ø36)	PR1825	KW10	TN100M
Carbon steel	0.05~0.25	0.2~0.4	★ 120~250	-	★ 100~180
Alloy steel	0.05~0.25	0.2~0.4	★ 100~220	-	★ 100~180
Mold steel	0.05~0.25	0.2~0.4	★ 80~180	-	★ 100~150
Stainless steel	0.05~0.2	0.1~0.3	★ 120~220	-	☆ 100~180
Cast iron	0.1~0.3	0.3~0.5	-	☆ 80~150	-
Non-ferrous metals	0.1~0.3	0.3~0.5	-	★ 100~300	-

★: 1st Recommendation ☆: 2nd Recommendation

