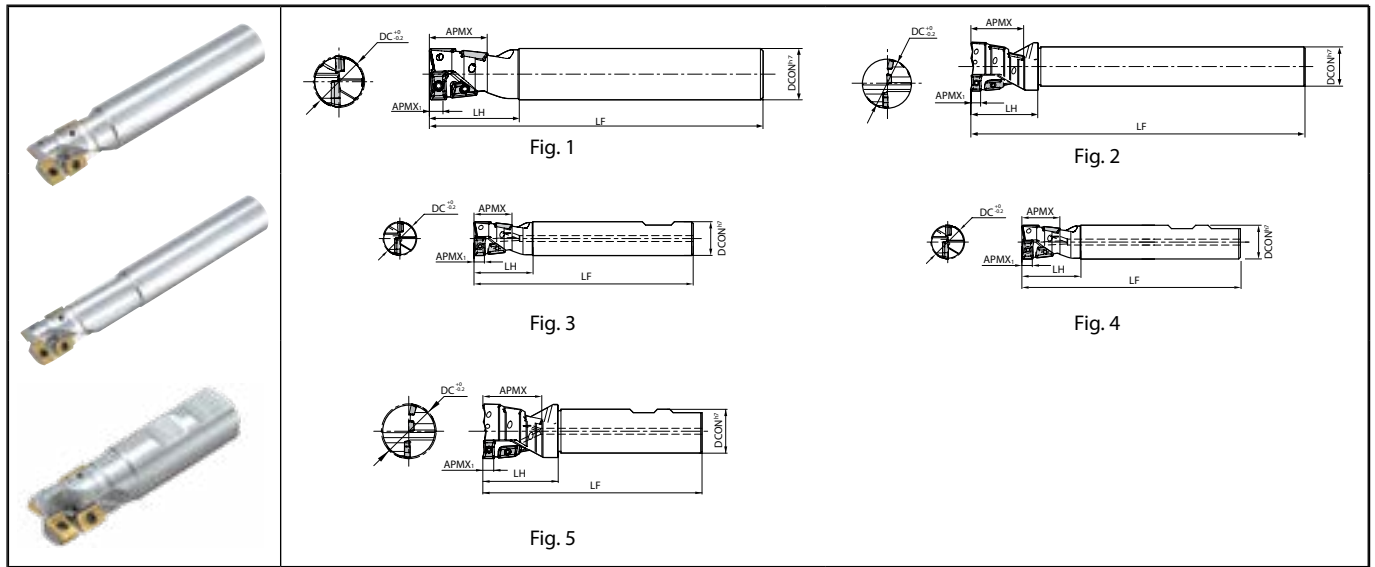


MEY



Toolholder dimensions

Description	Availability	Inserts	Flutes	Dimension (mm)						A.R. (°)	R.R. (°)	Coolant hole	Fig.	Spare parts			Applicable inserts M232		
				DC	DCON	LF	LH	APMX	APMX <sub>i</sub>					Anti-seize compound	Screw	Wrench			
Standard	●	4	2	16	16	120	31	19	4.5	+11	-11	No	1	P-37	SB-2040TRG	DTM-6	Center Edge : GOMT08T208ER-D Side Edge : JOMT08T208ER-D		
				17	16	120	31	19	4.5	+11	-11							1	
				20	20	130	35	22	6	-9	-9							1	
				21	20	130	35	22	6	-9	-9							1	
				25	25	140	40	28	7.5	-11	-11							1	
				26	25	140	40	28	7.5	-11	-11							1	
				32	32	150	50	36	9.5	+13	-9							-9	1
				33															
				40	40	160	55	42	7.5	-11	-11							2	
				50	50	170	70	54	9.5	-9	-9							2	
Long head	●	4	2	16	16	140	51	19	4.5	+11	-11	No	1	P-37	SB-2040TRG	DTM-6	Center Edge : GOMT08T208ER-D Side Edge : JOMT08T208ER-D		
				20	20	150	53	22	6	-9	-9							1	
				25	25	170	70	28	7.5	+13	-11							1	
				32	32	180	80	36	9.5	-9	-9							1	
Long shank	●	4	2	16	16	190	61	19	4.5	+11	-11	No	1	P-37	SB-2040TRG	DTM-6	Center Edge : GOMT08T208ER-D Side Edge : JOMT08T208ER-D		
				17	16	190	31	19	4.5	+11	-11							1	
				20	20	200	63	22	6	-9	-9							1	
				21	20	200	35	22	6	-9	-9							1	
				25	25	220	80	28	7.5	-11	-11							1	
				26	25	220	40	28	7.5	-11	-11							1	
				32	32	230	90	36	9.5	+13	-9							-9	1
				33															
				40	40	240	55	42	7.5	-11	-11							2	
				50	50	250	70	54	9.5	-9	-9							2	

APMX<sub>i</sub> shows the edge length of the complete 2-insert part.  
Coat anti-seize compound thinly on portion of taper and thread when insert is fixed.

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

M230

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	Flutes	Dimension (mm)						A.R. (°)	R.R. (°)	Coolant hole	Fig.	Spare parts			Applicable inserts ● M232				
				DC	DCON	LF	LH	APMX	APMX1					Anti-seize compound	Screw	Wrench					
Weldon MEY 16-S16-80W-H 17-S16-80W-H 20-S20-85W-H 21-S20-85W-H 25-S25-95W-H 32-S32-110W-H 33-S32-110W-H 40-S32-130W-H	●	4	2	16	16	80	31	19	4.5	+11	-11	No	P-37				Center Edge : GOMT08T208ER-D Side Edge : JOMT08T208ER-D				
	●			17						-9								3	SB-2040TRG	DTM-6	
	●			20	20	85	35	22	6	-9	3							SB-2555TRG	DT-8	Center Edge : GOMT100308ER-D Side Edge : JOMT100308ER-D	
	●			21							3							SB-3070TRG	DT-10	Center Edge : GOMT13T308ER-D Side Edge : JOMT13T308ER-D	
	●			25	25	95	40	28	7.5	-11	-11							4	SB-4070TRG	DT-15	Center Edge : GOMT160408ER-D Side Edge : JOMT160408ER-D
	●			32	32	110	50	36	9.5	+13	-9							4	SB-3070TRG	DT-10	Center Edge : GOMT13T308ER-D Side Edge : JOMT13T308ER-D
	●			33														4			
	●			40	40	130	55	42	7.5	-11	-11							5	SB-3070TRG	DT-10	Center Edge : GOMT13T308ER-D Side Edge : JOMT13T308ER-D

APMX1 shows the edge length of the complete 2-insert part.

Coat anti-seize compound thinly on portion of taper and thread when insert is fixed.

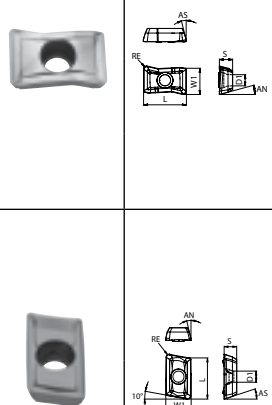
Applicable Inserts

Description		Applicable Inserts ● M232			
		Side Edge	No. of Inserts	Center Edge	No. of Inserts
MEY 16-S16(-...) 17-S16(-...) 20-S20(-...) 21-S20(-...) 25-S25(-...) 26-S25(-...) 32-S32(-...) 33-S32(-...) 40-S32(-...) 50-S42(-...)	JOMT08T208ER-D	3	GOMT08T208ER-D	1	
	JOMT100308ER-D		GOMT100308ER-D		
	JOMT13T308ER-D		GOMT13T308ER-D		
	JOMT160408ER-D	GOMT160408ER-D			
	JOMT13T308ER-D	6	GOMT13T308ER-D		
	JOMT160408ER-D		GOMT160408ER-D		

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



GOMT/JOMT

Insert		Description	No. of edges	Dimension (mm)					Angle (°)		Carbide	Applicable toolholder ● M230 ● M231
				S	D1	RE	L	W1	AN	AS		
		GOMT 08T208ER-D	2	2.78	2.3	0.8	8.7	5.21	17	13	●●	MEY16-S16(-...) MEY17-S16(-...)
		GOMT 100308ER-D	2	3.3	2.8	0.8	10.7	6.56	17	13	●●	MEY20-S20(-...) MEY21-S20(-...)
		GOMT 13T308ER-D	2	3.85	3.4	0.8	13.2	8.36	17	13	●●	MEY25-S25(-...) MEY26-S25(-...) MEY40-S32(-...)
		GOMT 160408ER-D	2	4.76	4.4	0.8	16.7	10.03	17	13	●●	MEY32-S32(-...) MEY33-S32(-...) MEY50-S42(-...)
		JOMT 08T208ER-D	2	2.78	2.3	0.8	8.5	5.14	13	17	●●	MEY16-S16(-...) MEY17-S16(-...)
		JOMT 100308ER-D	2	3.18	2.8	0.8	10.2	6.41	13	17	●●	MEY20-S20(-...) MEY21-S20(-...)
		JOMT 13T308ER-D	2	3.7	3.4	0.8	13.2	8.07	13	17	●●	MEY25-S25(-...) MEY26-S25(-...) MEY40-S32(-...)
		JOMT 160408ER-D	2	4.5	4.4	0.8	16.7	9.72	13	17	●●	MEY32-S32(-...) MEY33-S32(-...) MEY50-S42(-...)

Handed insert shows Right-hand

Recommended cutting conditions ● M232

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	★	
Nodular cast iron	★	
Non-ferrous metals		N
Heat-resistant alloy		S
Titanium alloy		
Hard materials		H

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

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

M232

Recommended cutting conditions

Workpiece material	fz (mm/t)		Recommended insert grades (Vc: m/min)	
			MEGACOAT NANO EX	
	Drilling	Shouldering, slotting	PR1810	PR1825
Carbon steel	0.08~0.15	0.05~0.25	-	★ 120~250
Alloy steel	0.08~0.15	0.05~0.25	-	★ 100~220
Mold steel	0.08~0.12	0.05~0.15	-	★ 80~180
Stainless steel	0.08~0.12	0.05~0.15	-	★ 120~220
Cast iron	0.05~0.20	0.05~0.25	★ 100~220	-

★: 1st Recommendation ☆: 2nd Recommendation

Caution of drilling

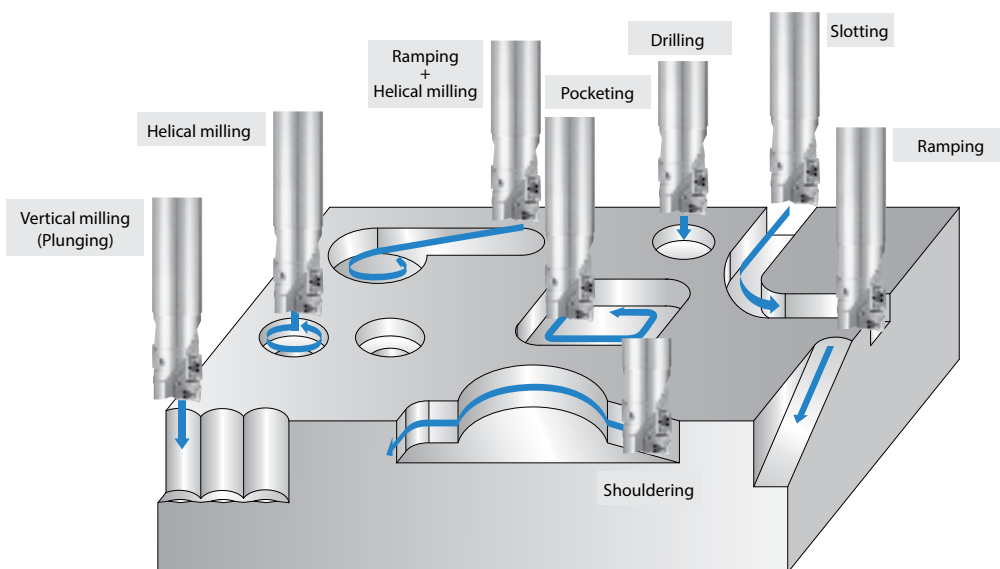
1. Drilling conditions should be calculated as one flute line.
2. Use compressed air during drilling.
3. Carbon steel other than low carbon steel can be drilled to a depth of 0.5D without step feeding.  
For soft steel or sticky material such as stainless steel, Step feed drilling (0.5 ~ 1.0mm) is recommended.
4. For stainless steel drilling, coolant is recommended.
5. Please refer to right list for maximum hole depth.

Cutting dia. (DC)	Max. hole depth (mm)
ø16	13
ø17	13
ø20	17
ø21	17
ø25	22
ø26	22
ø32	29
ø33	29
ø40	36
ø50	40

Shape of the bottom of the drilled hole

Cutting dia.	a (mm)	Shape of the bottom
ø16, ø17	0.5	
ø20, ø21	0.64	
ø25, ø26	0.85	
ø32, ø33	1.12	
ø40	1.54	
ø50	1.65	

Examples of MEY multi-function machining

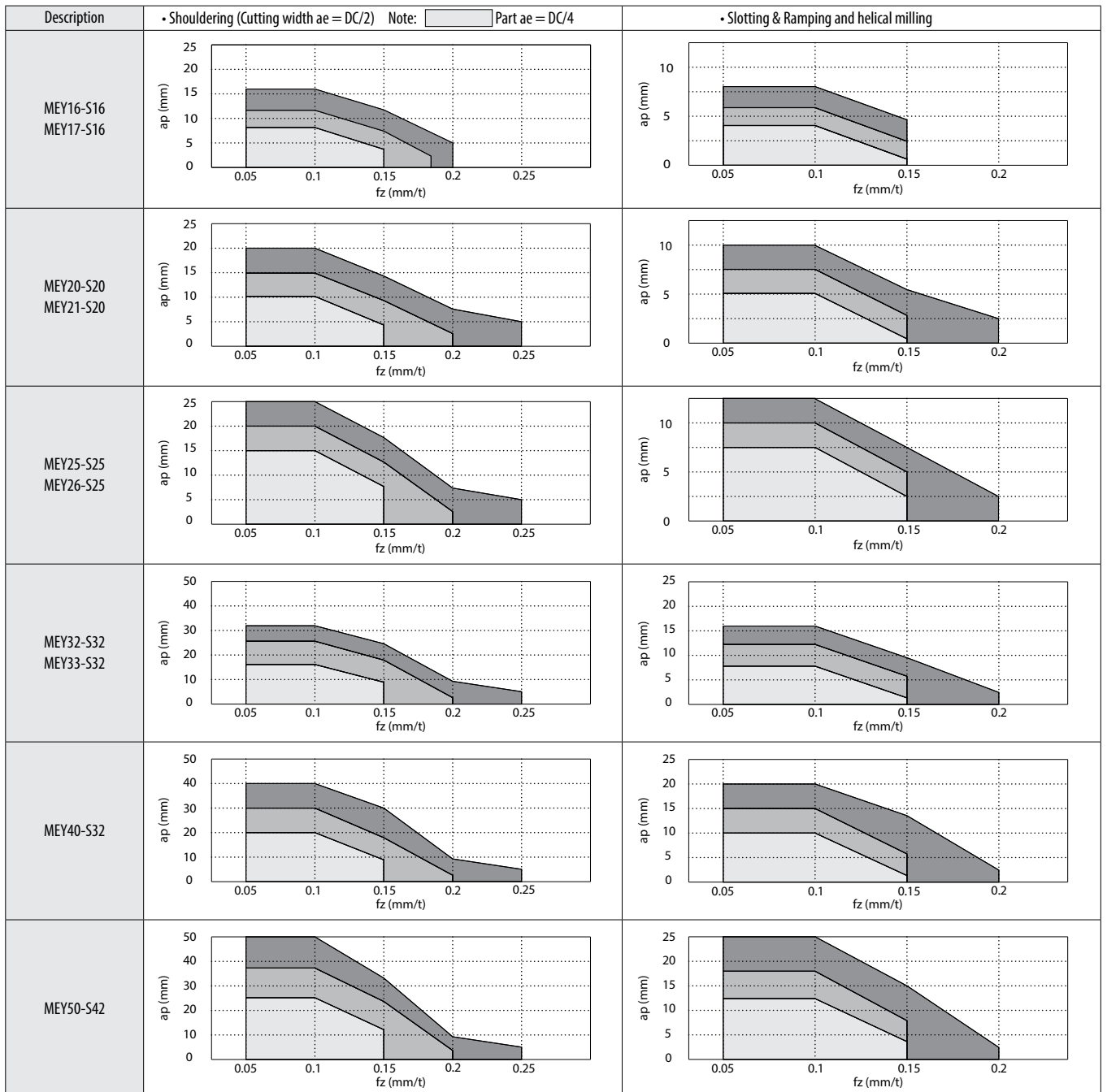


Cutting performance of MEY

Workpiece material: C50

Cutting dia.	Description	Overhang length LPR (mm)			Cutting dia.	Description	Overhang length LPR (mm)			Shape
ø16	MEY16-S16	31	[~61]	(Not recommended)	ø25	MEY25-S25	40	[~70]	(Not recommended)	
	MEY16-S16-140H	-	~61	[~91]		MEY25-S25-170H	-	70	[~100]	
	MEY16-S16-190	-	61	~91		MEY25-S25-220	-	~80	~100	
ø17	MEY17-S16	31	[~61]	(Not recommended)	ø26	MEY26-S25	40	[~70]	(Not recommended)	
	MEY17-S16-190	31	~61	~91		MEY26-S25-220	40	~70	~100	
ø20	MEY20-S20	35	[~65]	(Not recommended)	ø32	MEY32-S32	50	[~80]	(Not recommended)	
	MEY20-S20-150H	-	~65	[~95]		MEY32-S32-180H	-	~80	[~110]	
	MEY20-S20-200	-	65	~95		MEY32-S32-230	-	90	~110	
ø21	MEY21-S20	35	[~65]	(Not recommended)	ø33	MEY33-S32	50	[~80]	(Not recommended)	
	MEY21-S20-200	35	~65	~95		MEY33-S32-230	50	~80	~110	
ø40	MEY40-S32	55	[~85]	[~115]	ø50	MEY50-S42	70	[~100]	[~130]	
	MEY40-S32-240	55	~85	~115		MEY50-S42-250	70	~100	~130	

When using in [ ] dimension, be careful that the chucking length to the shank may get too short.

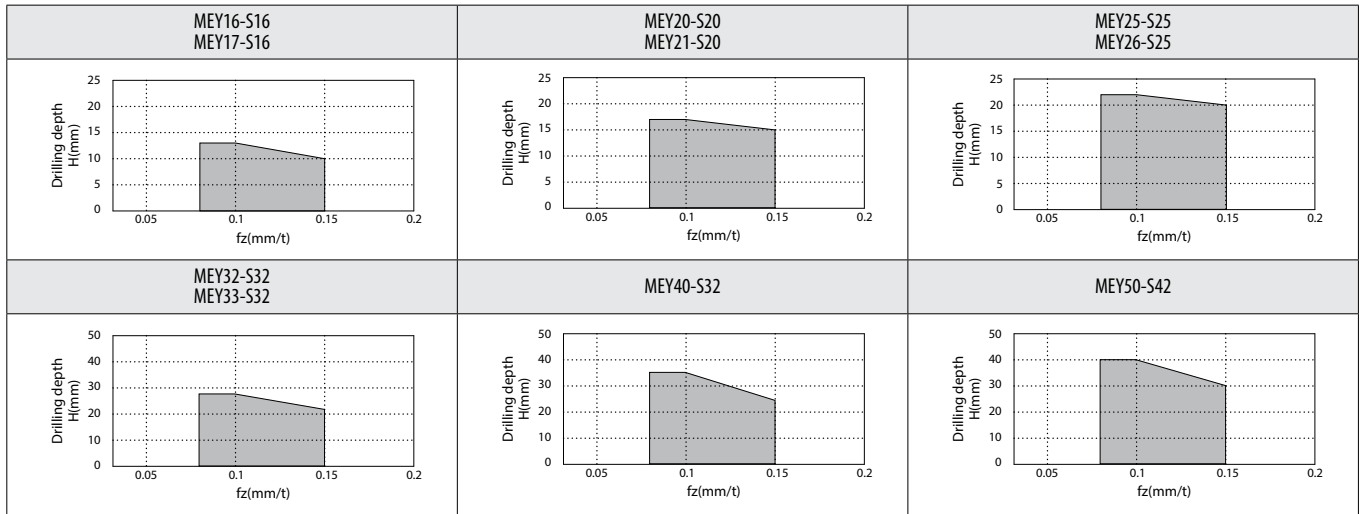


M

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

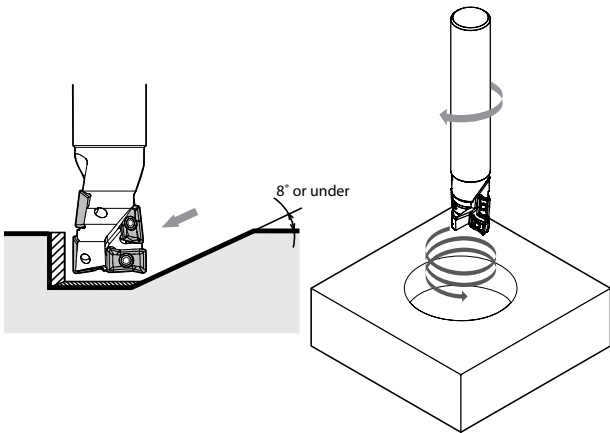
**Drilling (Standard/long head/long shank: C50)**



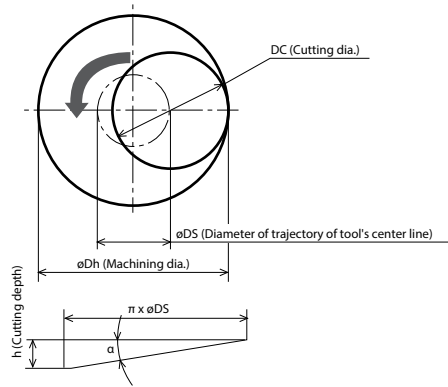
**How to use MEY effectively**

**Ramping/Helical milling**

- Ramping angle is recommended to be 8° or under.  
Sinking depth per revolution when helical milling should be 1/2DC or under.
- Use compressed air during machining.



**Helical milling factors**



øDS (How to find diameter of trajectory of tool's center line)

$$\text{øDS} = \text{øDh} - \text{DC}$$

h How to find "h"

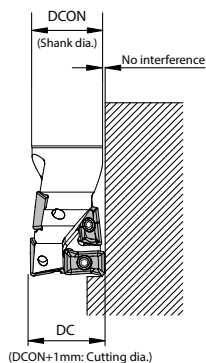
$$h = \pi \times \text{øDS} \times \tan \alpha$$

( $\alpha$  should be 8° or under )

**Shouldering**

- Tools with 1mm larger cutting diameter than shank diameter are available.  
High wall shouldering is possible.

Lineup	(mm)	
Description	DC	DCON
MEY17-S16	17	16
MEY21-S20	21	20
MEY26-S25	26	25
MEY33-S32	33	32
MEY17-S16-190	17	16
MEY21-S20-200	21	20
MEY26-S25-220	26	25
MEY33-S32-230	33	32



M



Milling