

Machining Center Machining Plastic Injection Mold Image

1. Face Milling Roughing

MFWN Mini

Fracture-Resistant Inserts and Low Cutting Forces
Excellent Performance in a Economical Size

MFWN90080R-05-9T-M
WNMU050408EN-GM PR1525



Vc=150m/min
ap=1.0 ~ 2.0mm
fz =0.15mm/t

2. Slant Finishing

4MFR

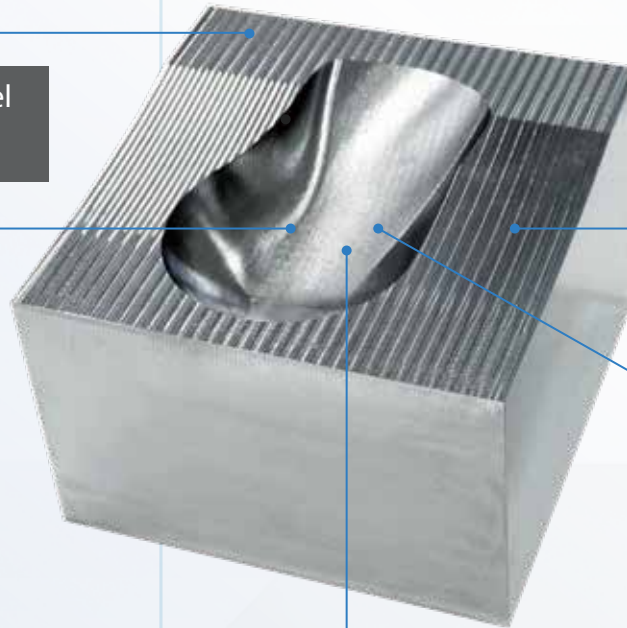
Unequal Flute Spacing and
Variable Lead Design Provide
Greater Chatter Resistance

4MFR120-260-R30

Vc=85m/min
ap=0.5 ~ 2.0mm
fz =0.09mm/t



Workpiece : Mold Steel
100x100x70



SGS
Solid Carbide Tools

SGS solid tools created through
the exploration of advanced
cutting tool technology

SGS Solid Tools

3. Pocketing Roughing

MFH Mini

High Feed Endmill with Chattering Resistance
Reduces Cutting Forces at Initial Impact
with a Convex Helical Edge Design

MFH20-S20-03-4T
LOGU030310ER-GM
PR1535



Vc=150m/min
ap=1.0mm
fz =0.4mm/t

4. Pocketing Semi-finishing

Unequal Flute Spacing and
Variable Lead Design Provide
Greater Chatter Resistance

Z-Carb (Z1MB)
ø10 46345



Vc=55m/min
ap=0.9mm
fz =0.027mm/t

5. Pocketing Finishing

Unequal Flute Spacing and
Variable Lead Design Provide
Greater Chatter Resistance

Z-Carb (Z1MB)
ø6 46343



Vc=55m/min
ap=0.1mm
fz =0.012mm/t