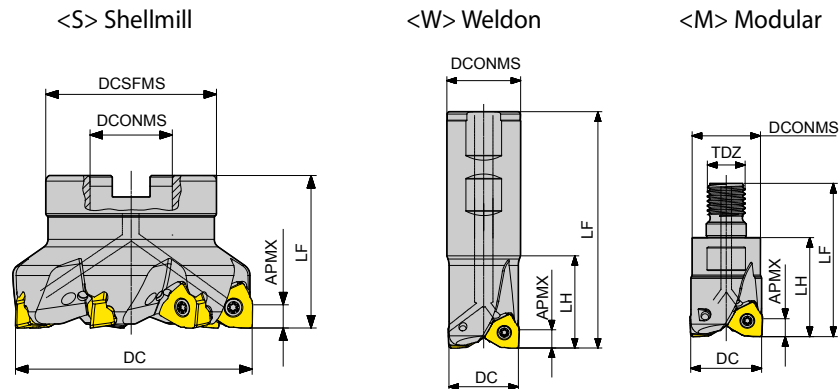


Milling - Shoulder Milling - Cutter

Cutters for WNEX

Entering Angle : 90°
6 Corner Negative



CICT : Number of Inserts
CBDP : Connection Bore Depth

□ : p. 131

Unit: inch

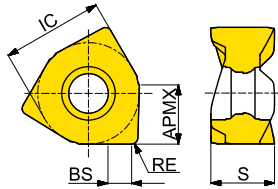
Series	APMX	Designation	EDP 1700..	DC	CICT	LF	TYPE	DCON	LH	CBDP	DCSFMS	🔹
NEW WNEX 0806	.276	E90 - WN08 - D125Z2W125 - L450I	0913	1.250	2	4.500	Weldon	1.250	2.250	-	-	●
		E90 - WN08 - D125Z2W125 - L750I	1077	1.250	2	7.500		1.250	2.500	-	-	●
		E90 - WN08 - D150Z4W125 - L450I	0914	1.500	4	4.500		1.250	1.500	-	-	●
		E90 - WN08 - D150Z4W125 - L750I	1078	1.500	4	7.500		1.250	2.500	-	-	●
		F90 - WN08 - D200Z4S075I	0915	2.000	4	1.575	Shellmill	.750	-	.750	1.732	●
		F90 - WN08 - D200Z5S075I	1079	2.000	5	1.575		.750	-	.750	1.732	●
		F90 - WN08 - D250Z5S075I	0916	2.500	5	1.575		.750	-	.750	1.732	●
		F90 - WN08 - D300Z7S100I	0917	3.000	7	2.00		1.000	-	.750	2.189	●
		F90 - WN08 - D300Z9S100I	1080	3.000	9	2.00		1.000	-	.750	2.189	●
		F90 - WN08 - D400Z9S150I	0918	4.000	9	2.50		1.500	-	1.060	3.503	●
		F90 - WN08 - D400Z11S150I	1081	4.000	11	2.50		1.500	-	1.060	3.503	●
		F90 - WN08 - D500Z11S150I	1082	5.000	11	2.50		1.500	-	1.060	3.503	●
F90 - WN08 - D500Z14S150I	1083	5.000	14	2.50	1.500	-	1.060	3.503	●			
M90 - WN08 - D125Z2M16I	1084	1.250	2	2.410	Modular	M16	1.500	-	1.130	●		
M90 - WN08 - D150Z3M16I	1085	1.500	3	2.410		M16	1.750	-	1.130	●		

* Clamping Torque (Nm) 3.0Nm

WNEX0806	Screw	Wrench	Handle	BIT
Description	TP154011 - GS	TPWBTP15	DH - H4	DB - TP15
EDP	18000251	18000217	18000189	18000208

Milling - Shoulder Milling - Inserts

WNEX - Shoulder Milling Negative (6 Corners)



Series	IC	S
WNE* 0806	.508	.246

EDP 1200..

●: Stock item ○: Order made item

H20	P15	P25	P30	P30	P30	P40	K10	K15
P20			K30	M30 S30	M30	M40 S40		
YG012	YG712	YG713	YG622	YG612	YG602	YG613	YG5020	YG501
● 0856	● 0857			● 0855			● 0858	
● 0859	● 0792			● 0854		● 0793	● 0794	● 0795
● 0877	● 0878			● 0885			● 0879	
● 0861	● 0862			● 0860			● 0863	
● 0882	● 0883			● 0886			● 0884	
				● 0864		● 0865		
				● 0866		● 0867		
				● 0875		● 0876		
				● 0868		● 0869		
				● 0880		● 0881		

WNEX	Designation	RE (in)	Fz (in/tooth)	BS (in)
	WNEX 080604R	.016	.002 ~ .010	.126
	WNEX 080608R	.031	.002 ~ .010	.11
	WNEX 080612R	.047	.002 ~ .010	.094
	WNEX 080616R	.063	.002 ~ .010	.079
	WNEX 080620R	.079	.002 ~ .010	.063
	WNEX 080604R - ST	.016	.002 ~ .007	.142
	WNEX 080608R - ST	.031	.002 ~ .007	.13
	WNEX 080612R - ST	.047	.002 ~ .007	.11
	WNEX 080616R - ST	.063	.002 ~ .007	.094
	WNEX 080620R - ST	.079	.002 ~ .007	.075

NEW
WNEX
General



NEW
- ST
Stainless Steel
Super Alloy

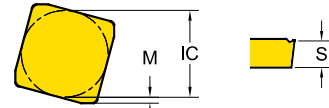


Milling - Code System Insert ISO Code System

1 A Shape	2 P Relief Angle (AN)	3 K Tolerance	4 T Clamping & Chipbreaker	5 16 Insert Size	6 04 Insert Thickness (S)	7 08 CornerRadius
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1 - Shape

Symbol	Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
A	Parallelogram 80°	
R	Round	



3 - Tolerance Class

Symbol	Inner Circle IC (in)	Nose Height M (in)	Thickness S (in)
C	±.0010	±.0005	±.0010
E	±.001	±.0010	±.001
G	±.001	±.0010	±.005
H	±.0005	±.0005	±.0010
K*	±.002~.006*	±.0005	±.005
M*	±.002~.006*	±.003~.010*	±.005
U*	±.003~.010*	±.005~.015*	±.005

* Tolerance is different by insert IC size. Please see ISO 1832

4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
N	No clamping hole	X	
R		One Face	
W	Screw Hole	X	
T		One Face	
U		Both Faces	
X		Special	

5 - Insert Size

* No Standard for milling insert size

6 - Insert Thickness

* No Standard for milling insert thickness

2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
N	No Relief Angle	
B	Relief 5°	
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	

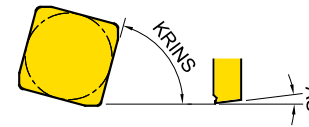
Milling - Code System Insert ISO Code System

8 PDTR Corner Geometry	9 - TR Chipbreaker	10 YG602 Grade
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7 - Corner Radius (RE)

Symbol	Thickness - S (in)	Symbol	Thickness - S (in)
04	.016	16	.063
08	.031	20	.079
12	.047	24	.094

8 - Corner Geometry



8 - 1	8 - 2	8 - 3	8 - 4
P Cutting Edge Angle (KRINS)	D Wiper Edge Clearance (AS)	T Edge Condition	R Feed Direction

8 - 1 - Cutting Edge Angle (KRINS)

Symbol	Cutting Edge Angle (KRINS)
P	90°
A	45°
D	60°
E	75°
F	85°
Z	Special

8 - 3 - Edge Condition

Symbol	Edge Condition	
F	Sharp	
E	Rounded	
T	Chamfered	
S	Chamfered and Rounded	

8 - 2 - Wiper Edge Clearance (AS)

Symbol	Wiper Edge Clearance (AS)
N	0°
P	11°
D	15°
E	20°
F	25°
Z	Special

8 - 4 - Feed Direction

Symbol	Feed Direction	
R	Right - hand Insert	
N	Neutral Insert	
L	Left - hand Insert	

Milling Grades and Chip breakers

Milling Grades

Milling Grades	P Steel				M Stainless steel			K Cast iron				N Non - ferrous				S Super alloys				H Hardened Steel					
	P10	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35	H05	H15	H25	H35
YG012			012																					012	
YG712			712																						
YG713			713																						
YG622			622									622													
YG612			612					612												612					
YG602			602					602				602								602					
YG613			613					613																	
YG501												501													
CVD YG5020												5020													
Uncoated YG50																50									

NEW **YG012**
H10 - H30
P10 - P30

Optimized Milling Grade for Pre - Hardened & Hardened steel

- Applied Extreme Oxidation PVD layer and Crack - free Substrate
- Excellent Cutting performance for Die & Mold application

YG712
P10 - P30

Milling Grade for Medium of Steel Application

- Superior wear resistance and excellent toughness in high speed machining
- Coating layer with high hardness and oxidation resistance

YG713
P15 - P25

Milling Grade for General Steel Application

- Multi - layer TiAlN structure realizes stronger crater and flank wear resistance
- Fine - grained carbide and balanced substrate

YG622
P20 - P35
K20 - K40

Optimized Grade for High Alloyed or Prehardened Steel

Excellent for High Temperature Hardness and Oxidation Resistance at High Speed

NEW **YG612**
P20 - P40
M20 - M40
S20 - S40

Specialized Multi - Nano Coated Grade with high wear resistance and chipping resistance

- Special Multi - Nano coating prevent crack and providing predictable tool life
- Special universal Grade can achieve stable tool life in any workpiece

Milling Grades and Chip breakers

Milling Grades

<p>YG602</p> <p>P20 - P35 M20 - M40 K20 - K40 S15 - S25</p>	<p>Universal grade for General Milling Application</p> <ul style="list-style-type: none"> Ultra Dense PVD Coating with optimal thermal resistance & strength Sub - Micron substrate designed for demanding application
<p>YG613</p> <p>P30 - P50 M30 - M40</p>	<p>Milling Grade for Stainless Steel Application</p> <ul style="list-style-type: none"> New coating layer with lubrication preventing built - up edge on ultra fine grain substrate with high toughness. The toughest substrate provides excellent cutting performance in stainless steel
<p>YG501</p> <p>K05 - K25</p>	<p>Hard Milling grade for Cast Iron</p> <ul style="list-style-type: none"> Substrate especially designed for high wear resistance Excellent wear resistance in cast iron milling application
<p>YG5020</p> <p>K01 - K30</p>	<p>CVD Milling grade for Cast Iron</p> <ul style="list-style-type: none"> CVD coating for Excellent wear resistance Improved Toughness for chipping resistance
<p>YG50</p> <p>N05 - N20</p>	<p>Uncoated Milling Grade for Aluminium</p> <ul style="list-style-type: none"> Submicron carbide substrate for high wear resistance Preventing built up edge with shining surface

Milling Chipbreakers

-AL		<ul style="list-style-type: none"> For Aluminum Very Sharp Geometry
-ST		<ul style="list-style-type: none"> For Stainless Steel, Super Alloy Sharp Geometry
-GN (General Type)		<ul style="list-style-type: none"> First Choice for General Application
-TR		<ul style="list-style-type: none"> For Hardened Steels Reinforced Geometry
...W / ...N		<ul style="list-style-type: none"> For Hardened Material and Cast Irons