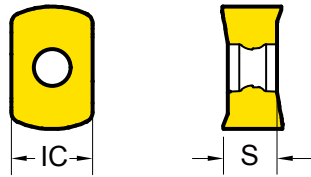


Milling - High Feed Milling - Inserts

ENMX - High Feed Negative (4 Corners)



Refer to
Milling Cutter
p.208 - 210



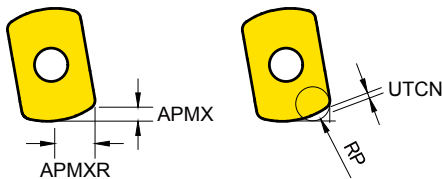
Series	IC	S
ENMX 0402	4.0	2.35
ENMX 0604	6.3	4.21
ENMX 0905	9.0	5.40

EDP 1200.. ●: Stock item ○: Order made item

	ENMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	APMX (mm)	H20	P15	P25	P30	P30	P30	P40	K10	K15	S40
							P20	YG712	YG713	YG622	YG612	YG602	YG613	YG5020	YG501	YG904
	General	ENMX 0604	0.8	0.3 - 2.0	-	1.0	● 0734				● 0822	● 0474	● 0606			● 1186
		ENMX 0905	1.0	0.3 - 2.5	-	1.5	● 0736				● 0824	● 0702	● 0703			
	- ST Stainless Steel	ENMX 0402 - ST	0.5	0.2 - 0.8	-	0.5					● 1064		● 1065			
		ENMX 0604 - ST	0.8	0.1 - 0.8	-	1.0					● 0973	● 0623	● 0625			● 1184
		ENMX 0905 - ST	1.0	0.2 - 1.2	-	1.5					● 0974	● 0705	● 0706			● 1187
	- TR Hardened Steel	ENMX 0402 - TR	0.5	0.2 - 1.3	-	0.5	● 1060	● 1062			● 1059		● 1061			
		ENMX 0604 - TR	0.8	0.3 - 2.5	-	1.0	● 0733	● 0504	○ 0636		● 0823	● 0459				● 1185
		ENMX 0905 - TR	1.0	0.3 - 3.0	-	1.5	● 0735				● 0825	● 0600	● 0874			

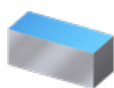
ENMX - High Feed Negative (4 Corners) Technical Information

ENMX 0402



APMXR Radial AP Max
0.5

RP Programmed Corner R	UTCN Uncut Thickness	Overcut
0.8	0	0.25
0.9	0	0.22
1	0.01	0.19



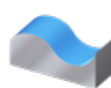
General



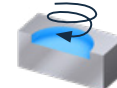
Plunging



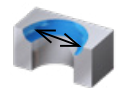
Ramping



Profiling



Helical Interpolation



Enlarge Hole

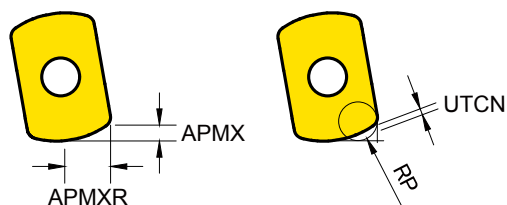
DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Diameter Minimum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
8	0.5	2.4	0.5	0.9	0.22	16	0.2	11.6	0.1	5.6
10	0.5	2.4	0.7	0.9	0.22	20	0.4	15	0.2	7.6
11	0.5	2.4	0.7	0.9	0.22	22	0.4	16.8	0.2	8.6
12	0.5	2.4	1	0.9	0.22	24	0.5	18.4	0.4	9.6
13	0.5	2.4	1.1	0.9	0.22	26	0.5	20	0.5	10.6
16	0.5	2.4	1	0.9	0.22	32	0.5	25.7	0.5	13.6
17	0.5	2.4	1	0.9	0.22	34	0.5	27.6	0.5	14.6
20	0.5	2.4	0.9	0.9	0.22	40	0.5	33.6	0.5	17.6
21	0.5	2.4	0.7	0.9	0.22	42	0.5	35.6	0.5	18.6
25	0.5	2.4	0.7	0.9	0.22	50	0.5	43.4	0.5	22.6
32	0.5	2.4	0.5	0.9	0.22	64	0.5	57.4	0.5	29.6

Milling - High Feed Milling - Inserts

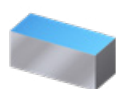
ENMX - High Feed Negative (4 Corners) Technical Information

ENMX 0604

Unit: mm



DCX Cutting Diameter Maximum	APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
16	3.5	R2.0	0.31	0.00
16~	3.7	R2.5	0.18	0.18
		R3.0	0.07	0.36



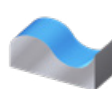
General



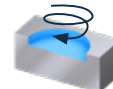
Plunging



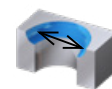
Ramping



Profiling



Helical Interpolation

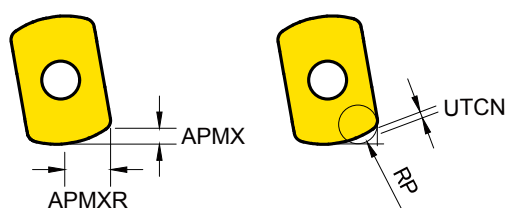


Enlarge Hole

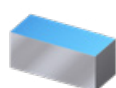
DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
16	0.9	3.5	2.4°	2.0	0.3	22	32	0.9	12.5
17	0.9	3.5	1.9°	2.0	0.3	24	34	0.9	13.5
20	1	3.7	1.8°	2.0	0.31	29	40	1	16.3
21	1	3.7	1.8°	2.0	0.31	31	42	1	17.3
25	1	3.7	1.2°	2.0	0.31	39	50	1	21.3
26	1	3.7	1.2°	2.0	0.31	41	52	1	22.3
32	1	3.7	0.8°	2.0	0.31	53	64	1	28.3
33	1	3.7	0.8°	2.0	0.31	55	66	1	29.3
40	1	3.7	0.6°	2.0	0.31	69	80	1	36.3
50	1	3.7	0.5°	2.0	0.31	89	98	1	46.3
63	1	3.7	0.4°	2.0	0.31	115	126	1	59.3

ENMX 0905

Unit: mm



APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
4.7	R2.5	0.56	0
	R3.0	0.40	0.10
	R3.5	0.24	0.25
	R4.0	0.10	0.41
	R4.5	0	0.49



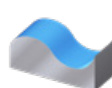
General



Plunging



Ramping



Profiling



Helical Interpolation



Enlarge Hole

DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
25	1.5	5	3.8°	2.5	0.56	42	50	1.5	20
26	1.5	5	3.4°	2.5	0.56	44	52	1.5	21
32	1.5	5	2.3°	2.5	0.56	56	64	1.5	27
33	1.5	5	2.2°	2.5	0.56	58	66	1.5	28
40	1.5	5	1.6°	2.5	0.56	72	80	1.5	35
50	1.5	5	1.1°	2.5	0.56	92	100	1.5	45
63	1.5	5	0.8°	2.5	0.56	118	126	1.5	57
80	1.5	5	0.6°	2.5	0.56	152	160	1.5	74