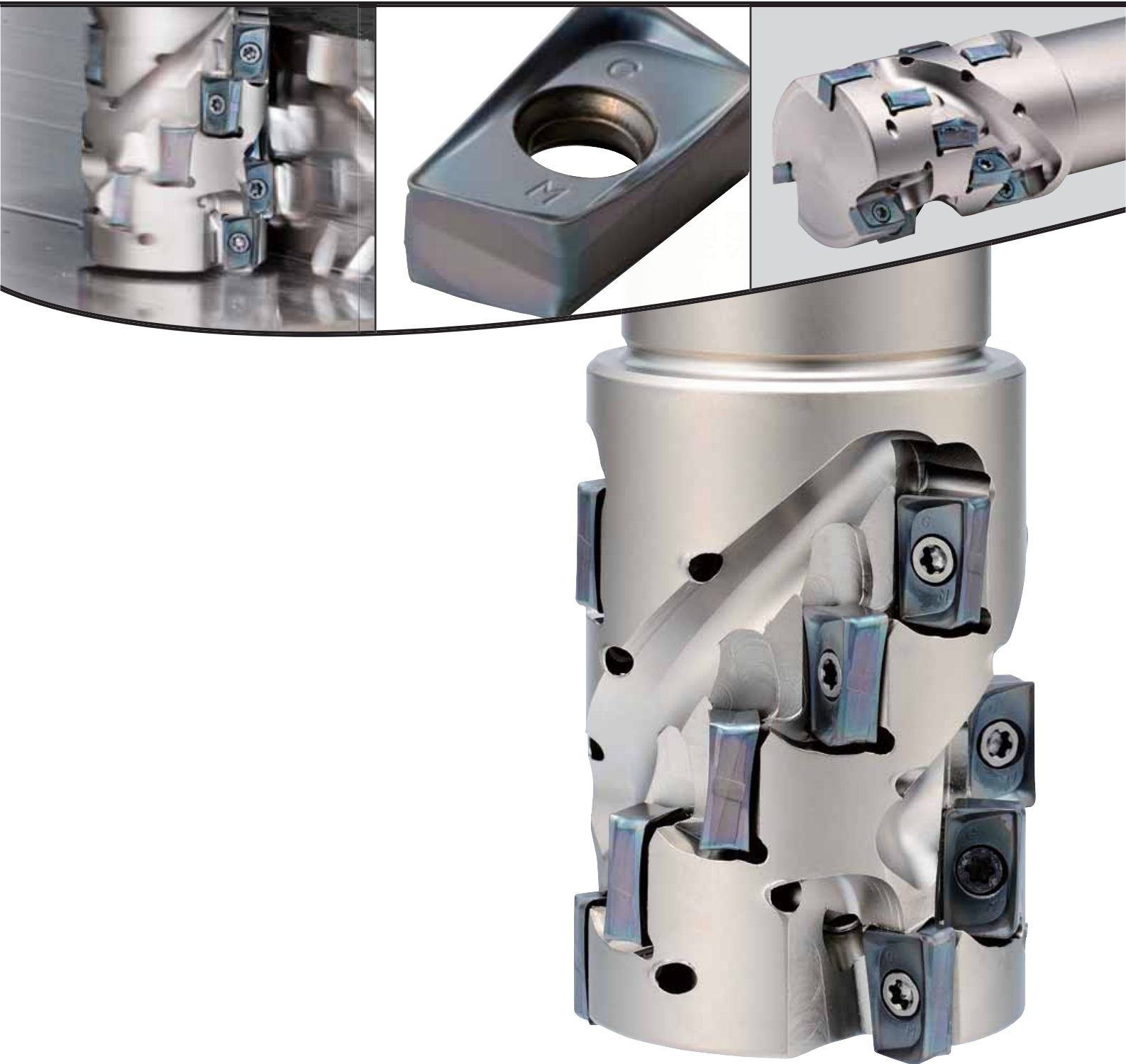


THE NEW VALUE FRONTIER



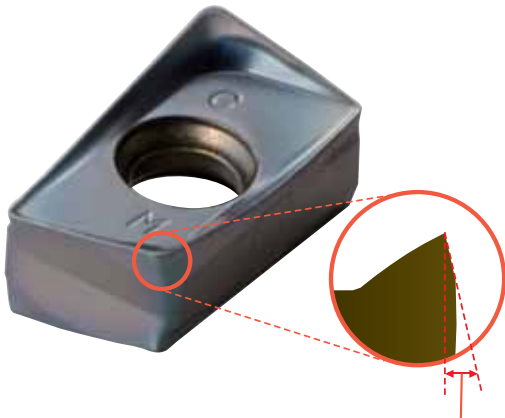
# MEWH Helical End Mill

Double sided inserts with 4 cutting edges



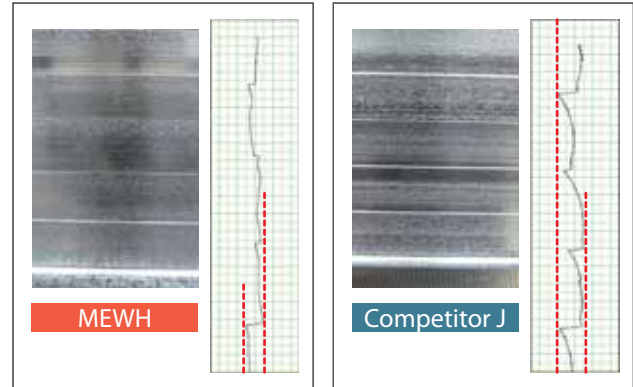
# MEWH Helical End Mill

KYOCERA's unique molding technology reduces cutting force equivalent to positive type inserts. Excellent surface finish and stable machining due to MEW design concept.



Tough cutting edge

## Comparison of surface finish



Better surface finish compared to competitor J

34CrMo4 Vc=120m/min apxae=45x5mm fz=0.1mm/t Dry

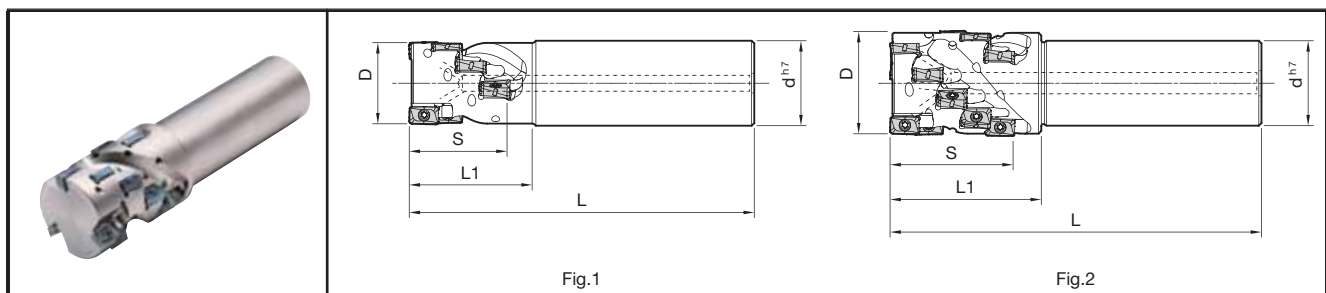
Chipbreaker	Application	Shape
<b>GM</b>	General Purpose	
<b>SM</b>	Low Cutting Force	
<b>GH</b>	Tough Edge	

Vc=120m/min apxae=20x15mm Dry

Chipbreaker	Workpiece	fz=0.15mm/t		fz=0.2mm/t	
<b>GM</b>	34CrMo4				
<b>GM</b>	1.0040				
<b>SM</b>					

Chips are constantly evacuated in the opposite direction of the cutter feed without clogging.

## MEWH End Mill (with coolant hole)






### Toolholder Dimension

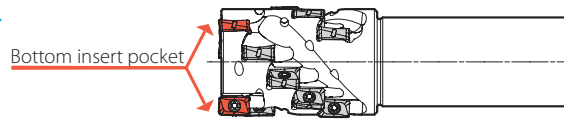
Description	Std.	No. of Flute	No. of Stage	No. of Insert	Dimension (mm)					A.R. (MAX)	R.R	Shape	Spare Parts			Applicable Insert
					øD	ød	L	L1	S				Clamp Screw	Wrench	Anti-seize Compound	
MEWH 025-S25-10-3-2T	●	2	3	6	25	25	120	37	28	+13°	-20°	Fig.1	SB-3065TRP	DTPM-8	MP-1	LOMU1004..
032-S32-10-4-2T	●		4	8	32	32	130	46	37							
040-S32-10-5-2T	●		5	10	40		140	57	46							
040-S32-10-5-3T	●			15												
MEWH 040-S32-15-4-2T	●	2	4	8	40	32	160	63	53	+13°	-20°	Fig.2	SB-4090TRP	DTPM-15	MP-1	LOMU1505..
050-S42-15-4-2T	●		4	8	50	42	160	63	53							
050-S42-15-4-3T	●			12												

: Std. Item

## Applicable Inserts

Insert	Description	Dimension (mm)				MEGACOAT NANO			CVD carbide	Applicable Toolholder	
		A	T	∅d	W	rε	PR1535	PR1525	PR1510		CA6535
 General Purpose	LOMU 100404ER-GM	6.6	4.0	3.4	10.9	0.4	N	N	N	N	MEWH...-10..
	LOMU 100408ER-GM					0.8	N	N	N	N	
	LOMU 100412ER-GM*					1.2	N	N	N	N	
	LOMU 150504ER-GM	9.2	5.6	4.8	15.7	0.4	N	N	N	N	MEWH...-15..
LOMU 150508ER-GM	0.8					N	N	N	N		
LOMU 150510ER-GM	1.0						N				
LOMU 150512ER-GM	1.2					N	N	N	N		
 Low Cutting Force	LOMU 100408ER-SM	6.6	4.0	3.4	10.9	0.8	N	N	N	N	MEWH...-10..
	LOMU 150508ER-SM	9.2	5.6	4.8	15.7	0.8	N	N	N	N	MEWH...-15..
 Tough Edge (Heavy Milling)	LOMU 100408ER-GH	6.6	4.0	3.4	10.9	0.8		N	N		MEWH...-10..
	LOMU 150508ER-GH	9.2	5.6	4.8	15.7	0.8		N	N		MEWH...-15..

\*Caution: LOMU100412ER-GM can be used at the bottom insert pocket only.



: Std. Item

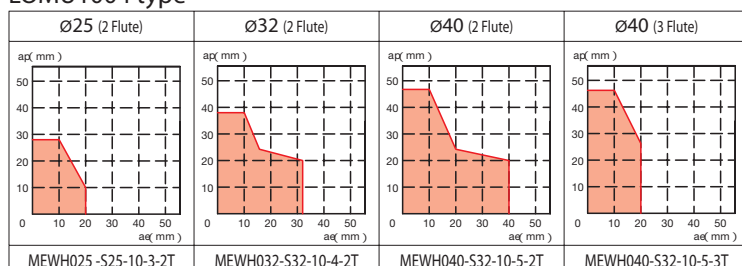
## Recommended Cutting Conditions

Chip breaker	Workpiece Material	fz (mm/t)	Vc (m/min) Recommended Insert Grade			
		Toolholder Description	MEGACOAT NANO			CVD
		MEWH025 ~ MEWH050	PR1535	PR1525	PR1510	CA6535
GM	Carbon Steel	0.06 ~ 0.1 ~ 0.2	-	120 ~ 180 ~ 250	-	-
	Alloy Steel	0.06 ~ 0.1 ~ 0.14	-	100 ~ 160 ~ 220	-	-
	Mold Steel	0.06 ~ 0.08 ~ 0.12	-	80 ~ 140 ~ 180	-	-
	Austenitic Stainless Steel	0.06 ~ 0.08 ~ 0.12	100 ~ 160 ~ 200	100 ~ 160 ~ 200	-	-
	Martensitic Stainless Steel	0.06 ~ 0.08 ~ 0.1	150 ~ 200 ~ 250	-	-	180 ~ 240 ~ 300
	Precipitation Hardened Stainless Steel	0.06 ~ 0.08 ~ 0.1	90 ~ 120 ~ 150	-	-	-
	Gray Cast Iron	0.06 ~ 0.1 ~ 0.17	-	-	120 ~ 180 ~ 250	-
	Nodular Cast Iron	0.06 ~ 0.08 ~ 0.12	-	-	100 ~ 150 ~ 200	-
	Ni-base Heat resistant Alloy	0.06 ~ 0.08 ~ 0.1	20 ~ 30 ~ 50	-	-	20 ~ 30 ~ 50
Titanium Alloys	0.06 ~ 0.08 ~ 0.12	40 ~ 60 ~ 80	-	30 ~ 50 ~ 70	-	
SM	Carbon Steel	0.06 ~ 0.1 ~ 0.17	-	120 ~ 180 ~ 250	-	-
	Alloy Steel	0.06 ~ 0.08 ~ 0.12	-	100 ~ 160 ~ 220	-	-
	Mold Steel	0.06 ~ 0.08 ~ 0.12	-	80 ~ 140 ~ 180	-	-
	Austenitic Stainless Steel	0.06 ~ 0.08 ~ 0.12	100 ~ 160 ~ 200	100 ~ 160 ~ 200	-	-
	Martensitic Stainless Steel	0.06 ~ 0.08 ~ 0.1	150 ~ 200 ~ 250	-	-	180 ~ 240 ~ 300
	Precipitation Hardened Stainless Steel	0.06 ~ 0.08 ~ 0.1	90 ~ 120 ~ 150	-	-	-
	Ni-base Heat resistant Alloy	0.06 ~ 0.08 ~ 0.1	20 ~ 30 ~ 50	-	-	20 ~ 30 ~ 50
	Titanium Alloys	0.06 ~ 0.08 ~ 0.12	40 ~ 60 ~ 80	-	30 ~ 50 ~ 70	-
GH	Carbon Steel	0.06 ~ 0.1 ~ 0.2	-	120 ~ 180 ~ 250	-	-
	Alloy Steel	0.06 ~ 0.1 ~ 0.14	-	100 ~ 160 ~ 220	-	-
	Mold Steel	0.06 ~ 0.08 ~ 0.12	-	80 ~ 140 ~ 180	-	-
	Austenitic Stainless Steel	0.06 ~ 0.08 ~ 0.12	-	100 ~ 150 ~ 200	-	-
	Gray Cast Iron	0.06 ~ 0.1 ~ 0.2	-	-	120 ~ 180 ~ 250	-
	Nodular Cast Iron	0.06 ~ 0.08 ~ 0.15	-	-	100 ~ 150 ~ 200	-

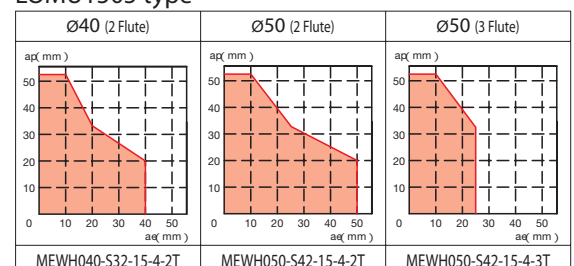
Machining with coolant is recommended for Ni-base heat resistant alloy, titanium alloy and stainless steel.

## Cutting Performance

### LOMU1004 type

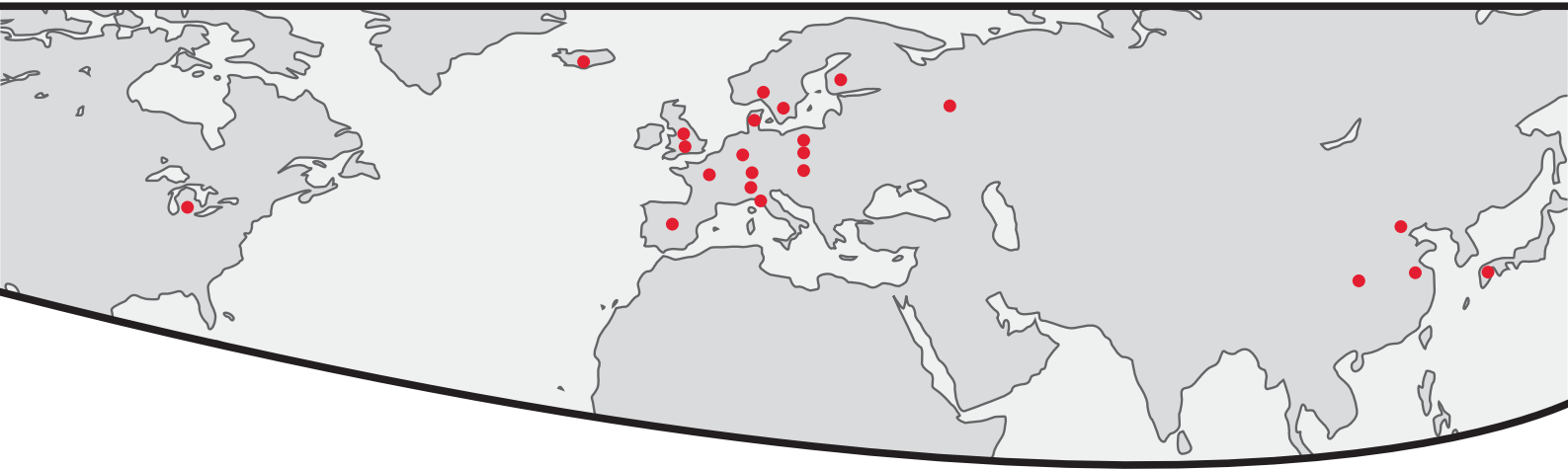


### LOMU1505 type



Cutting Condition: Vc=120m/min, fz=0.08~0.12mm/t, GM Chipbreaker, Workpiece: 34CrMo4, Overhang Length: "L1" of the dimension table.

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