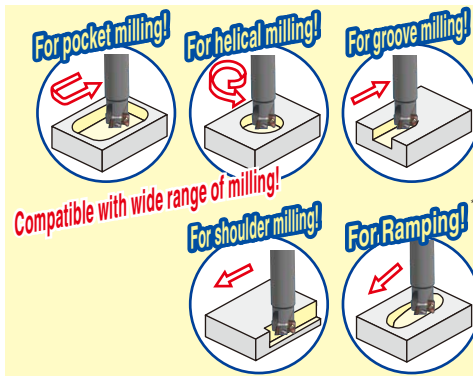


WEX Type



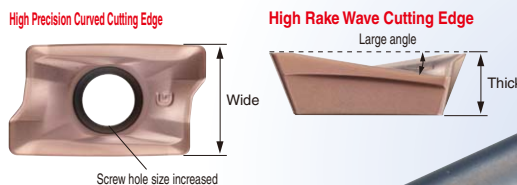
*Ramping angle depends on the cutter diameter. Please refer to the following table.

Tool Dia.	Ramp Angle	
	2000 Type	3000 Type
ø14	1°40'	
ø16	1°20'	
ø20	1°	
ø25	0°45'	1°30'
ø32	0°35'	1°
ø40	0°25'	0°45'
ø50	0°20'	0°30'
ø63	0°15'	0°20'
ø80		0°15'
From ø100		Impossible

Characteristics

Precision Insert with Strong Cutting Edge and Low Cutting Force Design

- Unique curved cutting edge design lowers cutting force yet improves cutting edge strength.
- Achieving high quality finish with **high precision cutting edge**
- Smooth cutting even for deep grooves and low rigidity machines.



Wide Variety of Inserts

- 6 types of chipbreakers. (L, G, H, E, EH, S Types)
- 7 new milling grades available for a wide range of work materials.

(Steel Milling Grades)
ACP100, ACP200, ACP300
(Cast Iron Milling Grades)
ACK200, ACK300
(Stainless Steel • Exotic Alloy+Gradet)
ACM200 **New**, ACM300 **New**
(Aluminium Milling Grades)
DL1000, H1



Highly Durable Body

- Special surface treatment improves corrosion resistance and scratch resistance.
- Increased screw size improves clamping force and durability.

Internal Coolant-holes are a Standard Feature for the Whole Series

- Improved chip evacuation with air or coolant supply.

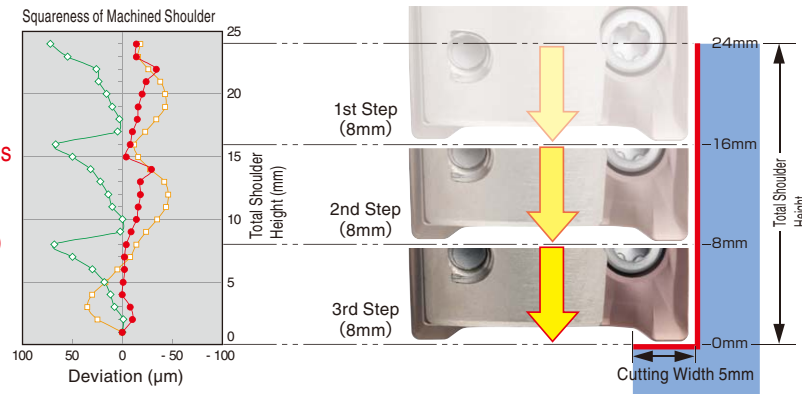
Product Range

	Cat. No.	Description	External Diameter (mm)							Shape
			ø10	ø25	ø40	ø50	ø63	ø80	ø125	
Shell Type	WEX 2000F	Standard Type			40		63			
	WEX 3000F	Standard Type			40		63			
	WEX 3000R	Standard Type						80	125	
	WEXF 3000R	Fine Pitch Type						80	125	
Shank Type	WEX 2000E	Standard Type	14				63			
	WEX 2000EL	Long Type	14		40					
	WEX 3000E	Standard Type		25			63			
	WEX 3000ES	Short Type			50		63			
	WEX 3000EL	Long Type		25		40				
	WEX 3000E-C	Coarse Pitch Type			40		63			
	WEX 3000ES-C	Short, Coarse Pitch Type			50		63			
Modular Type	WEX 2000M	Modular Type	16		40					
	WEX 3000M	Modular Type		25		40				

Cutting Performance

(1) Shoulder milling with better squareness

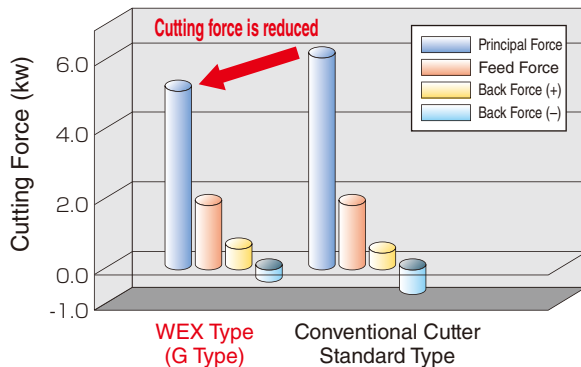
High accuracy cutting edges provide very small step marks
(Less than half of competitor's)



(Cutting Conditions)	
Work Material	: SS400
Tool	: WEX3032E(φ32)
Insert	: AXMT170508PEER-G
Grade	: ACP200
Cutting Speed	: $V_c=150\text{m/min}$
Feed Rate	: $f_z=0.15\text{mm/t}$ ($v_f=675\text{mm/min}$)
Cutting Width	: $a_e=5\text{mm}$
Cutting Depth	: $a_p=8\text{mm} \times 3 \text{ Passes Dry}$

(2) Cutting Force

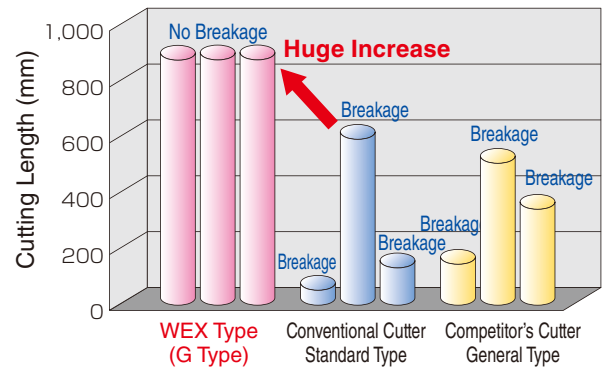
Cutting resistance (main component) is approx 15% lower than conventional cutters.



(Cutting Conditions)	
Work Material	: S50
Tool	: WEX3032E(φ32)
Insert	: AXMT170508 PEER-G
Grade	: ACP200
Cutting Speed	: $V_c=100\text{m/min}$
Feed Rate	: $f_z=0.2\text{mm/t}$ ($v_f=1,200\text{mm/min}$)
Cutting Width	: $a_e=8\text{mm}$
Cutting Depth	: $a_p=10\text{mm Dry}$

(3) Fracture Resistance

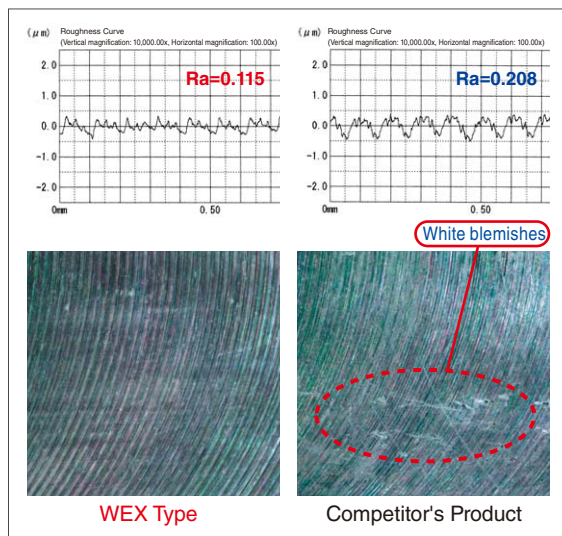
Huge increase in fracture resistance with improved cutting edge strength.



(Cutting Conditions)	
Work Material	: SCM440
Tool	: WEX3032E(φ32)
Insert	: AXMT170508PEER-G
Grade	: ACP200
Cutting Speed	: $V_c=100\text{m/min}$
Feed Rate	: $f_z=0.4\text{mm/t}$ ($v_f=1,260\text{mm/min}$)
Cutting Width	: $a_e=25\text{mm}$
Cutting Depth	: $a_p=3\text{mm Dry}$

(4) Surface Finish (Aluminum Milling)

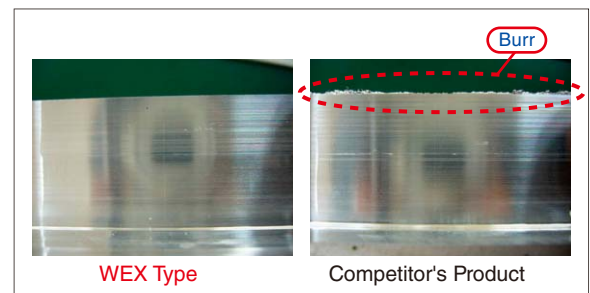
Smooth surface free of white blemishes



(Cutting Conditions)	
Work Material	: A5052
Tool	: WEX3032E(φ32)
Insert	: AXET170504PEFR-S(H1)
Cutting Speed	: $V_c=800\text{m/min}$
Feed Rate	: $f_z=0.1\text{mm/t}$ ($v_f=2,400\text{mm/min}$)
Cutting Width	: $a_e=16\text{mm}$
Cutting Depth	: $a_p=10\text{mm Dry}$

(5) Burr on Machined Shoulder (Aluminum Milling)

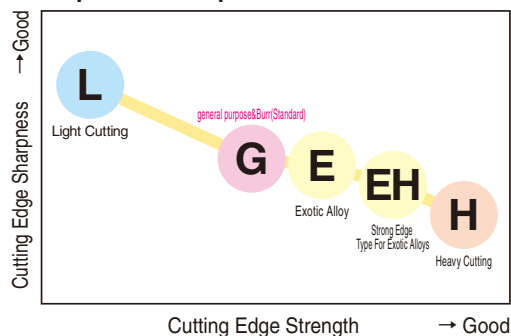
High rake edge type significantly reduces burr.



(Cutting Conditions)	
Work Material	: A5052
Tool	: WEX3032E(φ32)
Insert	: AXET170504PEFR-S(H1)
Cutting Speed	: $V_c=800\text{m/min}$
Feed Rate	: $f_z=0.1\text{mm/t}$ ($v_f=2,400\text{mm/min}$)
Cutting Width	: $a_e=5\text{mm}$
Cutting Depth	: $a_p=12\text{mm Dry}$

Chipbreaker Selection

■ Chipbreaker Map



Stainless Steel · For Exotic Alloy machining

E Type Chipbreaker

For 2000 Type

R0.4 / R1.2

For 3000 Type

**R0.4 / R1.2 /
R1.6 / R2.0 / R3.0**

Work Material	P Steel K Cast Iron			M Stainless Steel S Exotic Alloy		N Non-Ferrous
Breaker	L Type	G Type	H Type	E Type	EH Type	S Type
Feature	Low Cutting Force	General Purpose	Strong Edge	General-Purpose Type For Exotic Alloys	Strong Edge Type For Exotic Alloys	High Rake Type
2000 Type Insert Figure	Not Available					
3000 Type Insert Figure						
Application	Light cut, low rigidity milling and reduce burrs	Main breaker General purpose to interrupted milling	Roughing, heavy interrupted and hardened steel milling	Light Cutting to General-Purpose	Heavy Interrupted Machining	Non-Ferrous Metal

Stainless Steel · Exotic Alloy+Breaker E / EH Type

■ Characteristics of E/EH Type Chipbreaker

① Improved Adhesion Resistance

Smooth cutting edge design allows smooth chip flow

② Improved Cutting Performance

Strong cutting edge realized by optimizing edge treatment and rake angle

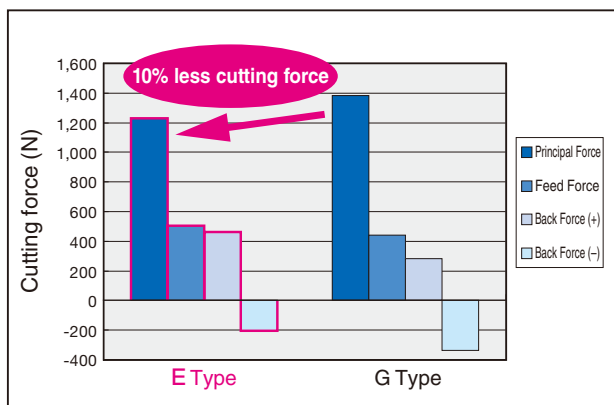


E / EH Type



L / G Type

■ Performance Comparison



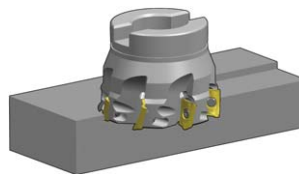
Cutting Conditions

Work Material: SUS304

Tool: WEX2050F

 $V_c=180\text{m/min}$ $f_z=0.15\text{mm/t}$ $a_e=20\text{mm}$ $a_p=3\text{mm}$ Dry

■ Tool Life Comparison



	E Type	G Type
Damage		
Cutting Length	1.5 m	0.9 m

Cutting Conditions

Work Material: SUS304

Tool: WEX2050F

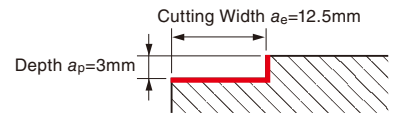
 $V_c=120\text{m/min}$ $f_z=0.15\text{mm/t}$ $a_e=20\text{mm}$ $a_p=3\text{mm}$ Dry

■ Recommended Cutting Conditions

WEX2000 Type

Tool: WEX2025E Insert: AXMT123508PEER-G

Cutting Conditions: Depth 3mm, Cutting Width 12.5mm, Dry



ISO Classification	Work Material	Work Hardness (HB)	Chipbreaker	Grades																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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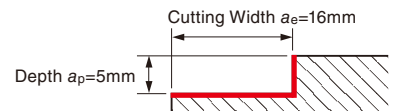
- The recommended cutting conditions may not be practical under certain operating conditions (i.e., machine, work shape, clamping system).
- For groove milling, adjust feed rate to around 70% of the above values.

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

WEX3000 Type

Tool: WEX3032E Insert: AXMT170508PEER-G

Cutting Conditions: Depth 5mm, Cutting Width 16mm, Dry



ISO Classification	Work Material		Work Hardness (HB)	Chipbreaker	Grades																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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- For groove milling, adjust feed rate to around 70% of the above values.

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

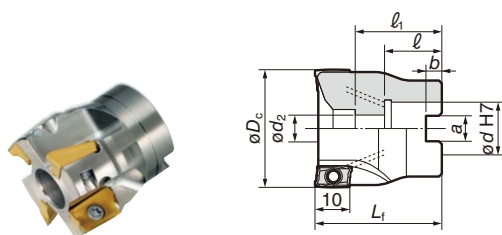
WEX 2000F Type

Rake Angle	Radial	16° to 18°
	Axial	23° to 25°

10mm	90°
------	-----

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel

High Efficiency Machining for Steel, Stainless Steel, Cast Iron, Exotic Alloy, and Non-Ferrous Metal



Body (Standard Type)

Metric

Cat. No.		Stock	Dimensions (mm)								No. of Teeth	Weight (kg)
			$\varnothing D_c$	$\varnothing d$	$\varnothing d_2$	a	b	L_f	ℓ_1	ℓ		
Metric	WEX 2040F	●	40	16	9	8.4	5.6	40	28	18	6	0.19
	2050F	●	50	22	11	10.4	6.3	40	26	20	7	0.29
	2063F	●	63	22	11	10.4	6.3	40	26	20	8	0.51

Inserts are not included.

Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

Grade		Coated Carbide						Carbide	DLC	Dimensions
Application		P	M	K	N	S	H			
High Speed/Light		●	●	●	●	●	●	●	●	
General Purpose		●	●	●	●	●	●	●	●	
Roughing		●	●	●	●	●	●	●	●	
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	DL1000
AXMT 123504PEER-G		●	●	●	●	●				0.4
123508PEER-G		●	●	●	●	●				0.8
123512PEER-G		●	●	●	●	●				1.2
AXMT 123504PEER-H		●	●	●	●	●				0.4
123508PEER-H		●	●	●	●	●				0.8
123512PEER-H		●	●	●	●	●				1.2
AXMT 123504PEER-E							●	●		0.4
123508PEER-E							●	●		0.8
123512PEER-E							●	●		1.2
AXMT 123508PEER-EH				▲			●	●		0.8
AXET 123502PEFR-S									●	0.2
123504PEFR-S									●	0.4
123508PEFR-S									●	0.8

Spare Parts

Screw	Spanner	Anti-seizure Cream
		
BFTX0306IP	TRDR08IP	SUMI-P

(N·m) Recommended Tightening Torque (N·m)

Recommended Cutting Conditions H87

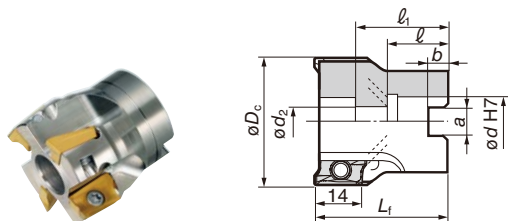
Rake Angle	Radial	12° to 15°
	Axial	29° to 24°



SEC-Wave Mill

WEX 3000F / R WEXF 3000R Type

High Efficiency Machining for Steel, Stainless Steel, Cast Iron, Exotic Alloy, and Non-Ferrous Metal



Body (Standard Type)

Cat. No.		Stock	Dimensions (mm)								No. of Teeth	Weight (kg)
			ϕD_c	ϕd	ϕd_2	a	b	L_f	ℓ_1	ℓ		
Metric	WEX 3040F	●	40	16	9	8.4	5.6	40	28	18	4	0.16
	3050F	●	50	22	11	10.4	6.3	40	26	20	5	0.25
	3063F	●	63	22	11	10.4	6.3	40	26	20	6	0.48
Inch	WEX 3080R	●	*80	25.4	13	9.5	6	50	31	25	4	1.06
	3100R	●	*100	31.75	17	12.7	8	63	39.5	32.5	5	1.99
	3125R	●	125	38.1	30	15.9	10	63	42.5	35.5	6	2.89

Body (Fine Pitch Type)

Inch	WEXF 3080R	●	*80	25.4	13	9.5	6	50	31	25	7	0.98
	3100R	●	*100	31.75	17	12.7	8	63	39.5	32.5	8	1.91
	3125R	●	125	38.1	30	15.9	10	63	42.5	35.5	9	2.80

Inserts are not included.



*Please use JIS B1176 hexagonal bolt ($\phi 80$: M12x30 to 35mm, $\phi 100$: M16x40 to 45mm) for securing $\phi 80/\phi 100$ cutter to the arbor.

Inserts (Common) P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

		Coated Carbide						Carbide	DLC	Dimensions
Grade										
Application	High Speed/Light	P						M	N	
	General Purpose	P	P	K			M	S	N	
	Roughing	P	P	K			M	S	N	
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	DL1000
AXMT 170508PEER-L		●	●	●	●	●				0.8
AXMT 170504PEER-G		●	●	●	●	●				0.4
170508PEER-G		●	●	●	●	●				0.8
170512PEER-G		●	●	●	●	●				1.2
170516PEER-G		●	●	●	●	●				1.6
170520PEER-G *		●	●	●	●	●				2.0
170530PEER-G *		●	●	●	●	●				3.0
AXMT 170508PEER-H		●	●	●	●	●				0.8
170512PEER-H		●	●	●	●	●				1.2
AXMT 170504PEER-E							●	●		0.4
170508PEER-E			▲				●	●		0.8
170512PEER-E							●	●		1.2
170516PEER-E							●	●		1.6
170520PEER-E *							●	●		2.0
170530PEER-E *							●	●		3.0
AXMT 170508PEER-EH			▲				●	●		0.8
AXET 170502PEFR-S									●	0.2
170504PEFR-S									●	0.4
170508PEFR-S									●	0.8

* Cutter body modification is required.

Spare Parts

Screw	Spanner	Anti-seizure Cream
BFTX0409IP	TRDR15IP	SUMI-P

Recommended Tightening Torque (N · m)

*Cutter body modification is required when attaching an R3.0 insert with a 2.0 nose radii.



Rework this edge.
Reworking guidelines
For 2.0 nose radii: C1
(AXMT170520PEER)
For 3.0 nose radii: C1.5
(AXMT170530PEER)

Standard: C0.5.

Recommended Cutting Conditions

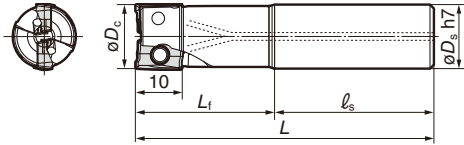
WEX 2000E / EL Type

Rake Angle	Radial	10° to 18°
	Axial	14° to 25°

10mm	90°
------	-----

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel

High Efficiency Machining for Steel, Stainless Steel, Cast Iron, Exotic Alloy, and Non-Ferrous Metal



Modular Type H130

■ Body (Standard Type)

Cat. No.	Stock	Dimensions (mm)					No. of Teeth	Weight (kg)
		øD _c	øD _s	L _f	L _s	L		
WEX 2014E	●	14	16	25	55	80	1	0.10
2016E	●	16	16	25	75	100	2	0.13
2018E	●	18	16	25	75	100	2	0.14
2020E	●	20	20	30	80	110	3	0.22
2022E	●	22	20	30	80	110	3	0.23
WEX 2025E	●	25	25	35	85	120	4	0.38
2028E	●	28	25	35	85	120	4	0.39
2030E	●	30	25	35	85	120	4	0.40
2032E	●	32	32	40	90	130	5	0.70
2040E	●	40	32	30	120	150	6	0.91
WEX 2050E	●	50	32	30	120	150	7	1.02
2063E	●	63	32	30	120	150	8	1.22

Inserts are not included.

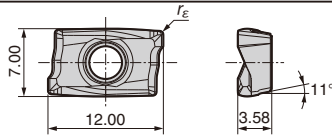
■ Body (Long Type)

Cat. No.	Stock	Dimensions (mm)					No. of Teeth	Weight (kg)
		øD _c	øD _s	L _f	L _s	L		
WEX 2014EL	●	14	16	25	95	120	1	0.14
2016EL	●	16	16	25	120	145	2	0.19
2018EL	●	18	16	25	120	145	2	0.19
2020EL	●	20	20	40	110	150	2	0.32
2022EL	●	22	20	30	120	150	2	0.33
WEX 2025EL	●	25	25	50	120	170	2	0.55
2028EL	●	28	25	30	140	170	2	0.59
2030EL	●	30	25	30	140	170	2	0.60
2032EL	●	32	32	60	120	180	2	0.99
2040EL	●	40	32	30	150	180	2	1.12

Inserts are not included.

■ Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel



Grade		Coated Carbide						Carbide	DLC	Dimensions
Application		P	M	K	N	S	H			
High Speed/Light		●	●	●	●	●	●	●	●	r _E
General Purpose		●	●	●	●	●	●	●	●	
Roughing		●	●	●	●	●	●	●	●	r _E
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	
AXMT 123504PEER-G		●	●	●	●	●	●	●	●	0.4
123508PEER-G		●	●	●	●	●	●	●	●	0.8
123512PEER-G		●	●	●	●	●	●	●	●	1.2
AXMT 123504PEER-H		●	●	●	●	●	●	●	●	0.4
123508PEER-H		●	●	●	●	●	●	●	●	0.8
123512PEER-H		●	●	●	●	●	●	●	●	1.2
AXMT 123504PEER-E		●	●	●	●	●	●	●	●	0.4
123508PEER-E		●	●	●	●	●	●	●	●	0.8
123512PEER-E		●	●	●	●	●	●	●	●	1.2
AXMT 123508PEER-EH		●	●	●	●	●	●	●	●	0.8
AXET 123502PEFR-S		●	●	●	●	●	●	●	●	0.2
123504PEFR-S		●	●	●	●	●	●	●	●	0.4
123508PEFR-S		●	●	●	●	●	●	●	●	0.8

■ Spare Parts

Screw	Spanner	Anti-seizure Cream	Applicable Endmill
BFTX0305IP	TRDR08IP	SUMI-P	WEX2014E (EL) to WEX2018E (EL)
BFTX0306IP			WEX2020E (EL) to WEX2063E

(N·m) Recommended Tightening Torque (N·m)

■ Recommended Cutting Conditions H87

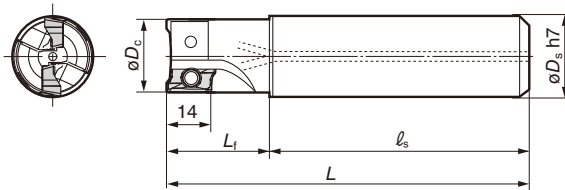
Rake Angle	Radial	8° to 15°
	Axial	16° to 24°



SEC-Wave Mill

WEX 3000 E / ES / EL E-C / ES-CType

High Efficiency Machining for Steel, Stainless Steel, Cast Iron, Exotic Alloy, and Non-Ferrous Metal



Body (Standard Type)

Cat. No.	Stock	Dimensions (mm)						No. of Teeth	Weight (kg)
		øDc	øDs	Lf	ls	L			
WEX 3025E-20	●	25	20	35	85	120	2	0.25	
3025E	●	25	25	35	85	120	2	0.37	
3028E	●	28	25	35	85	120	2	0.39	
3030E	●	30	25	40	90	130	3	0.42	
3032E-25	●	32	25	40	90	130	3	0.43	
WEX 3032E	●	32	32	40	90	130	3	0.67	
3035E	●	35	32	40	90	130	3	0.69	
3040E	●	40	32	50	120	170	4	1.01	
3050E	●	50	32	50	120	170	5	1.23	
3063E	●	63	32	50	120	170	6	1.58	

Body (Short Type)

WEX 3050ES	●	50	32	25	110	135	5	0.86	
3050ES-42	●	50	42	25	110	135	5	1.36	
3063ES	●	63	32	25	110	135	6	1.02	
3063ES-42	●	63	42	25	110	135	6	1.52	

Inserts are not included.

Body (Long Type)

Cat. No.	Stock	Dimensions (mm)						No. of Teeth	Weight (kg)
		øDc	øDs	Lf	ls	L			
WEX 3025EL	●	25	25	50	120	170	2	0.54	
3028EL	●	28	25	50	120	170	2	0.56	
3030EL	●	30	25	60	120	180	2	0.60	
3032EL	●	32	32	60	120	180	2	0.95	
3035EL	●	35	32	60	120	180	2	0.98	
WEX 3040EL	●	40	32	80	140	220	2	1.38	

Body (Coarse Pitch Type)

WEX 3040E-C	●	40	32	50	120	170	3	1.04	
3050E-C	●	50	32	50	120	170	3	1.28	
3063E-C	●	63	32	50	120	170	4	1.64	

Body (Short, Coarse Pitch Type)

WEX 3050ES-C	●	50	32	25	110	135	3	0.91	
3050ES-C-42	●	50	42	25	110	135	3	1.41	
3063ES-C	●	63	32	25	110	135	4	1.07	
3063ES-C-42	●	63	42	25	110	135	4	1.57	

Inserts are not included.

Inserts (Common)

		Coated Carbide						Carbide	DLC	Dimensions
		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	HI	
Application	High Speed/Light	P			K		M	S	N	
	General Purpose	P	P	P	K		M	S	N	
	Roughing	P	P	P	K		M	S	N	
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	HI	DL1000
AXMT 170508PEER-L		●	●	●	●	●				0.8
AXMT 170504PEER-G		●	●	●	●	●				0.4
170508PEER-G		●	●	●	●	●				0.8
170512PEER-G		●	●	●	●	●				1.2
170516PEER-G		●	●	●	●	●				1.6
170520PEER-G *		●	●	●	●	●				2.0
170530PEER-G *		●	●	●	●	●				3.0
AXMT 170508PEER-H		●	●	●	●	●				0.8
170512PEER-H		●	●	●	●	●				1.2
AXMT 170504PEER-E							●	●		0.4
170508PEER-E			▲				●	●		0.8
170512PEER-E							●	●		1.2
170516PEER-E							●	●		1.6
170520PEER-E *							●	●		2.0
170530PEER-E *							●	●		3.0
AXMT 170508PEER-EH			▲				●	●		0.8
AXET 170502PEFR-S								●	●	0.2
170504PEFR-S								●	●	0.4
170508PEFR-S								●	●	0.8

* Cutter body modification is required.

Spare Parts

Screw	Spanner	Anti-seizure Cream
		
BFTX0409IP	3.0	TRDR15IP
		SUMI-P

Recommended Tightening Torque (N · m)

*Cutter body modification is required when attaching an R3.0 insert with a 2.0 nose radii.



Rework this edge.
Reworking guidelines
For 2.0 nose radii: C1
(AXMT170520PEER)
For 3.0 nose radii: C1.5
(AXMT170530PEER)

Standard: C0.5.

Recommended Cutting Conditions

H87