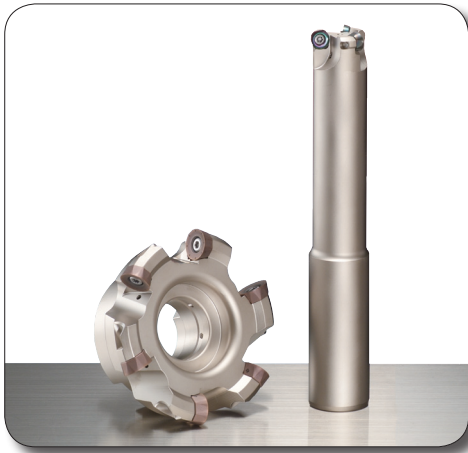


# WRCX SERIES

Applicable Insert: QPMT, QPET

## Multi-purpose Milling

## Multi-application WaveMill

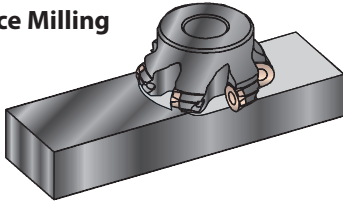


### Features & Benefits

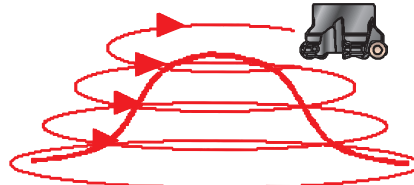
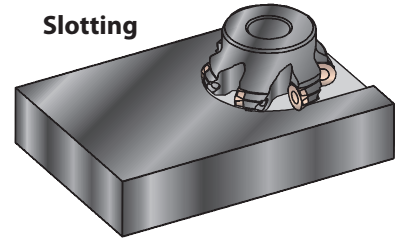
- 8 corner polygon inserts withstand extraordinary feed rates while providing improved finishes
- Highly durable cutter body made of special alloyed steel and protected by a hard surface treatment
- Wide application range that includes face milling, ramping, slotting, 3-D interpolation, and helical boring
- Pocket design eliminates insert rotation and breakage during aggressive machining
- Wide flute relief provides excellent chip evacuation

### Application Examples

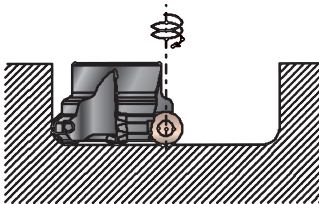
#### Face Milling



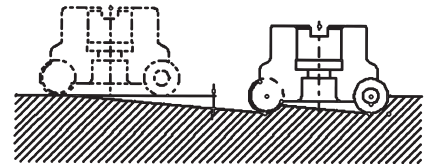
#### Slotting



#### 3-D Interpolation/Surfacing



#### Helical Boring



#### Ramping

### Recommended Running Conditions

ISO	Work Material	Grades	øD = 1.00" - 1.25"		øD = 1.50" - 3.00"		øD = 4.00" - 6.00"	
			SFM	IPT	SFM	IPT	SFM	IPT
P	Carbon Steel	ACP200	260-395-525	.004-.012-.016	330-525-655	.008-.016-.024	490-655-820	.012-.016-.024
	Alloy Steel (HRC<40)	ACP200	195-330-460	.004-.008-.012	330-460-590	.008-.012-.016	330-525-655	.004-.012-.020
M	Stainless Steel (304)	ACP200, ACP300	195-330-395	.004-.006-.008	260-395-525	.004-.008-.012	525-590-655	.006-.008-.012
K	Gray Cast Iron	ACK200, ACK300	195-260-395	.004-.008-.012	260-395-525	.004-.008-.016	330-490-655	.004-.006-.008
N	Non-ferrous Metal	H1, DL1000	655-1640-3280	.004-.008-.012	655-1640-3280	.004-.012-.016	655-1640-3280	.008-.016-.024

Min.-OPTIMUM-Max.

Indexable Milling

Shoulder Milling

Face Milling

High Feed Milling

Multi-purpose

Modular Tooling

UFO & SumiMill

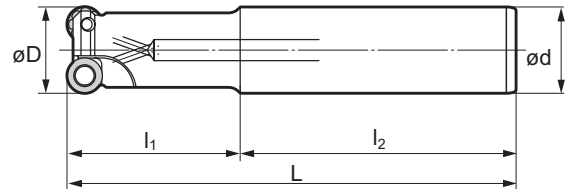
Discontinued

# Multi-purpose Milling Multi-application WaveMill

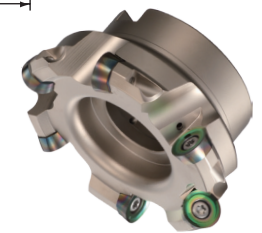
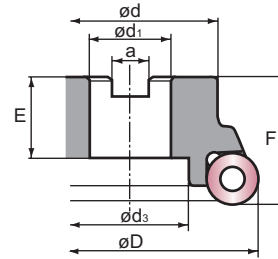
# WRCX SERIES

Applicable Insert: QPMT, QPET

WRCX Endmill - Weldon/Cylindrical Shank - INCH										
Catalog Number	Stock	Dimensions (inch)					Insert Dia.	# of Inserts	Ramp Angle	Shank Style
		øD	ød	L	l <sub>1</sub>	l <sub>2</sub>				
WRCX31000EW	•	1.000	1.000	4.341	2.060	2.281	0.375	2	11°30'	Weldon
WRCX31000ELC	•	1.000	1.000	10.000	3.750	6.250	0.375	2	11°30'	Cylindrical
WRCX31250EW	•	1.250	1.250	4.341	2.060	2.281	0.375	3	7°30'	Weldon
WRCX31250ELC	•	1.250	1.250	10.000	3.750	6.250	0.375	3	7°30'	Cylindrical
WRCX31500EW	•	1.500	1.500	4.341	2.060	2.281	0.375	4	5°30'	Weldon
WRCX31500ELC	•	1.500	1.500	10.000	3.750	6.250	0.375	4	5°30'	Cylindrical
WRCX41250EW	•	1.250	1.250	4.341	2.060	2.281	0.500	2	18°30'	Weldon
WRCX41250ELC	•	1.250	1.250	10.000	3.750	6.250	0.500	2	18°30'	Cylindrical
WRCX41500EW	•	1.500	1.500	4.341	2.060	2.281	0.500	3	12°30'	Weldon
WRCX41500ELC	•	1.500	1.500	10.000	3.750	6.250	0.500	3	12°30'	Cylindrical



WRCX Shell Mill - INCH												
Catalog Number	Stock	Dimensions (mm)								Insert Dia.	# of Inserts	Ramp Angle
		øD	ød	F	ød <sub>1</sub>	ød <sub>2</sub>	ød <sub>3</sub>	E	a			
WRCX32000R	•	2.000	1.50	1.75	0.750	0.406	0.609	1.020	0.312	0.375	4	5°30'
WRCX42000R	•	2.000	1.50	1.75	0.750	0.406	0.609	1.020	0.312	0.500	4	7°30'
WRCX42500R	•	2.500	1.75	1.75	1.000	0.531	0.797	1.020	0.375	0.500	4	5°30'
WRCX43000R	•	3.000	2.25	1.75	1.000	0.531	0.797	1.020	0.375	0.500	5	4°
WRCX63000R	•	3.000	2.25	1.75	1.000	0.531	0.797	1.020	0.375	0.750	5	7°30'
WRCX44000R	•	4.000	2.87	2.00	1.250	0.656	1.000	1.020	0.500	0.500	6	2°30'
WRCX64000R	•	4.000	2.87	2.00	1.250	0.656	1.000	1.020	0.500	0.750	6	4°30'
WRCX84000R	•	4.000	2.87	2.00	1.250	0.656	1.000	1.020	0.500	1.000	6	6°
WRCX65000R	•	5.000	3.75	2.50	1.500	-	2.000	1.060	0.625	0.750	6	3°15'
WRCX85000R	•	5.000	3.75	2.50	1.500	-	2.000	1.060	0.625	1.000	6	4°15'
WRCX66000R	•	6.000	3.75	2.50	1.500	-	2.000	1.060	0.625	0.750	8	3°15'
WRCX86000R	•	6.000	3.70	2.50	1.500	-	2.000	1.060	0.625	1.000	8	3°15'



Inserts									
Catalog Number	Fig. 1					Fig. 2			
	ACP100	ACP200	ACP300	ACK300	DL1000	Insert Dia.	T	Max D.O.C.	Fig.
QPMT32.510PPEN	•	•	•	•		0.375	0.156	0.1875	1
QPMT32.510PPEN-H	•	•	•	•		0.375	0.156	0.1875	2
QPMT4312PPEN	•	•	•	•		0.500	0.1875	0.250	1
QPMT4312PPEN-H	•	•	•	•		0.500	0.1875	0.250	2
QPMT6416PPEN	•	•	•	•		0.750	0.250	0.375	1
QPMT6416PPEN-H	•	•	•	•		0.750	0.250	0.375	2
QPMT8424PPEN	•	•	•	•		1.000	0.250	0.500	1
QPMT8424PPEN-H	•	•	•	•		1.000	0.250	0.500	2
QPET32.510PPENS*					•	0.375	0.156	0.1875	1
QPET4312PPENS*					•	0.500	0.1875	0.250	1
QPET6416PPENS*					•	0.750	0.250	0.375	1

Coolant Through Bolts	
Catalog Number	Cutter Size
BFXH 3/8 x 1	2.00"
BFXH 1/2 x 1 1/4	2.50"
BFXH 1/2 x 1 1/4	3.00"
BFXH 5/8 x 1 1/4	4.00"
BFXH 3/4 x 1 1/2	5.00"

Hardware		
Cutter	Wrench	Screw
WRCX3□□□R	TRDR15IP	BFTX03584IP
WRCX4□□□R		BFTX0409IP
WRCX6□□□R	TRDR20IP	BFTX0511IP
WRCX8□□□R		BFTX0615IP

\*4 indexes due to wiper

Indexable Milling

Shoulder Milling

Face Milling

High Feed Milling

Multi-purpose

Modular Tooling

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Discontinued