

For Swiss Type Automatic Lathes MS plus End Mill Series

# MP2ES/3ES/4EC

New  
Product

## Fracture Resistance & Burr Reduction to Combat Problems Commonly Encountered with Small Swiss Type Automatic Lathes



For Swiss Type Automatic Lathes  
MS plus End Mill Series

# MP2ES/3ES/4EC

**Achieves Stable Machining without Chipping  
Even when Machining Overuses the Cutting Edge**

## Adoption of New High-Toughness Substrate

Fracture resistance is greatly improved and stable machining is accomplished by using a high-toughness carbide substrate.

## Optimized Cutting Edge Shape

The optimized rake angle suppresses burrs.

## Improved Cutting Edge Machining

To improve the fracture resistance of the cutting edge, a small gash land is used for  $\varnothing 6\text{mm}$  or greater.

## Optimization of Cutting Edge and Overall Tool Length

In order to take into account the protrusion of the small Swiss Type Automatic Lathes, the cutting edge and overall tool length have been optimized.

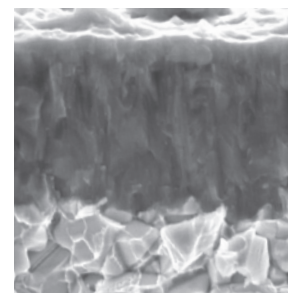
## (Al, Ti, Cr)N Multilayer Coating (MS plus)

**Suitable coating for a broad range of workpiece materials such as carbon steels and stainless steels.**

Our original coating technology incorporates a multilayer of (Al, Ti)N and (Al, Cr)N. It allows machining of a wide range of workpiece materials.

### Properties of MS plus coating

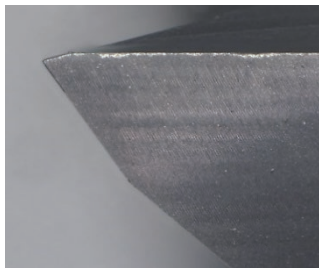
	(Al,Ti,Cr)N multilayer	(Al,Ti)N	(Al,Cr)N
Hardness (HV)	3200	2800	3100
Oxidation Temperature (F°)	2.012	1.472	2.012
Adhesion (N)	100	80	80



# Cutting Performance

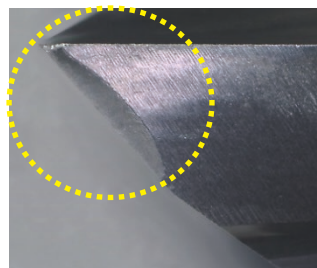
## Machining 304 - Comparison of Fracture Resistance

The round, stainless steel bar is machined using a D-cut. The adoption of the high toughness cemented carbide and gash land provides highly improved fracture resistance.



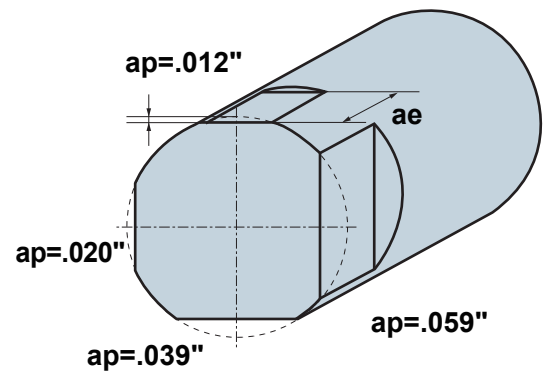
**MP3ES**

After machining of 2 pieces



Conventional

After machining 1 piece  
Fracture of the tip of the tool.

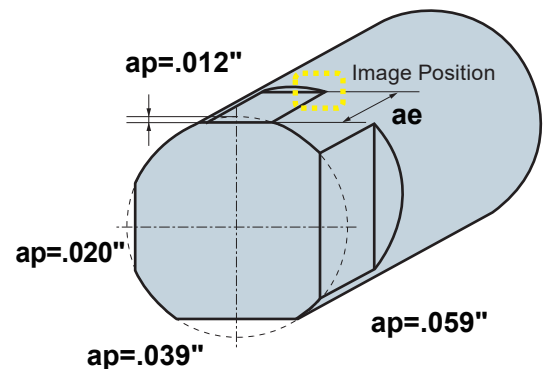
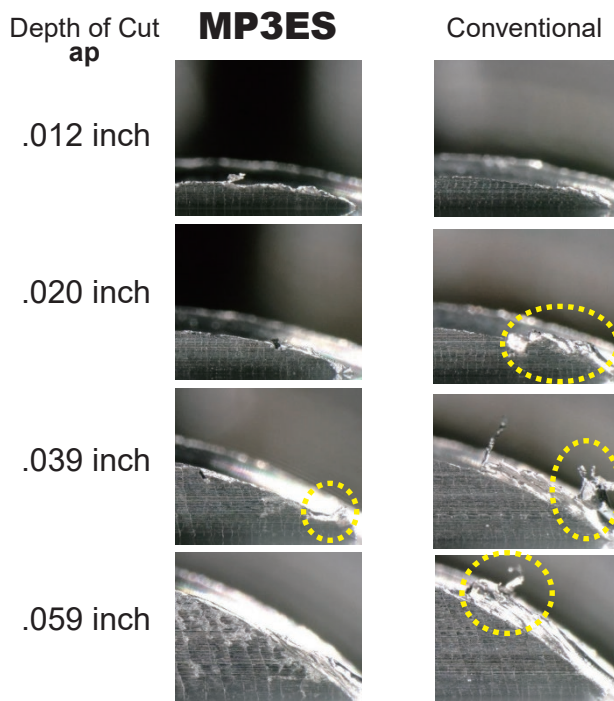


<Cutting Conditions>

Workpiece Material : AISI 304  
 Tool : MP3ESD0800S08  
 Cutting Speed :  $vc = 165$  SFM  
 Feed Rate :  $f = 5.9$  IPM  
 Feed per Tooth :  $fr = .0010$  inch  
 Depth of Cut :  $ap = .012-.059$  inch  
                    $ae = .236$   
 Cutting Mode : Wet Cutting (Oil)  
 Machine : Small Automatic Lathe  
 Tool Post : Gang Type Tool Post

## Machined 304 - Comparison of Burr Generation

The optimized cutting edge shape suppresses the occurrence of burrs.



<Cutting Conditions>

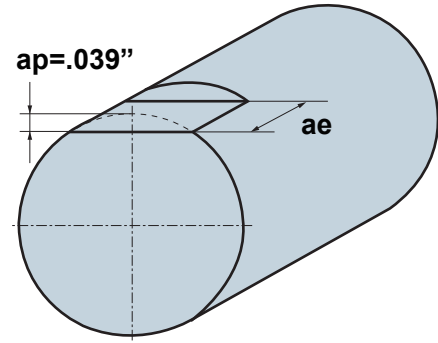
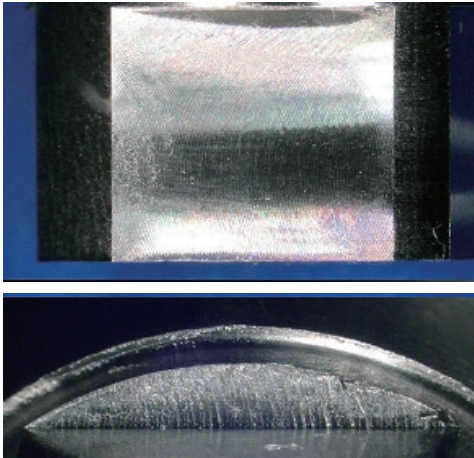
Workpiece Material : AISI 304  
 Tool : MP3ESD0800S08  
 Cutting Speed :  $vc = 165$  SFM  
 Feed Rate :  $f = 5.9$  IPM  
 Feed per Tooth :  $fr = .0010$  inch  
 Depth of Cut :  $ap = .012-.059$  inch  
                    $ae = .236$   
 Cutting Mode : Wet Cutting (Oil)  
 Machine : Small Automatic Lathe  
 Tool Post : Gang Type Tool Post

## Cutting Performance

### Machined 304 - Comparison of Surface Finishes

The surface finish is greatly improved due to the improved chatter resistance.

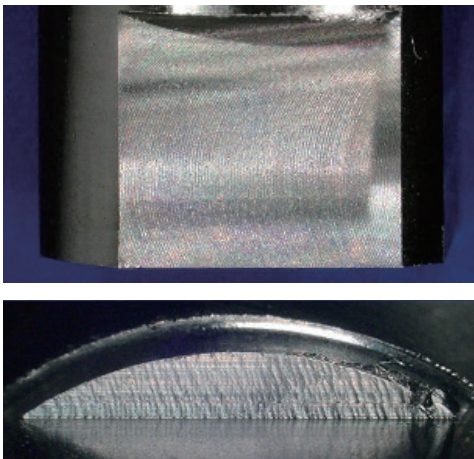
**MP3ES**  
Ra .008  $\mu$ -inch



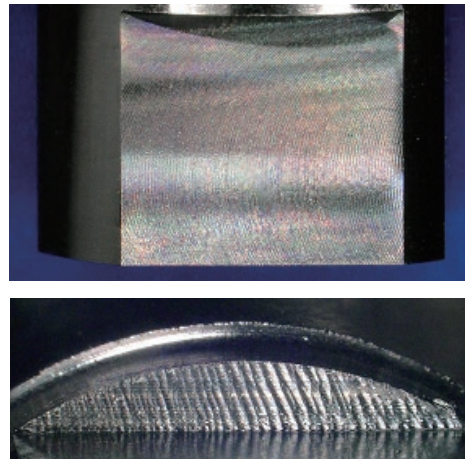
<Cutting Conditions>

Workpiece Material : JIS SUS304  
Tool : MP3ESD0800S08  
Cutting Speed :  $vc = 165$  SFM  
Feed Rate :  $f = 5.9$  IPM  
Feed per Tooth :  $fr = .0010$  inch  
Depth of Cut :  $ap = .039$  inch  
                   $ae = .236$   
Cutting Mode : Wet Cutting (Oil)  
Machine : Small Automatic Lathe  
Tool Post : Gang Type Tool Post

Conventional A  
Ra .024  $\mu$ -inch

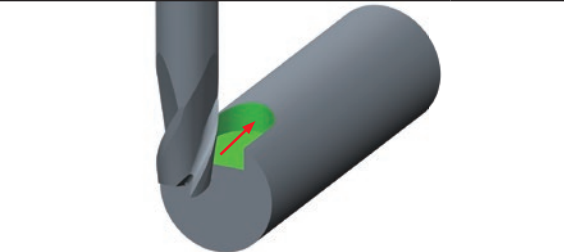
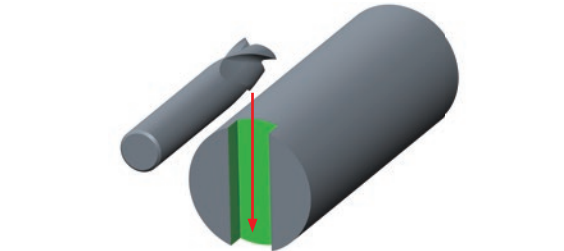
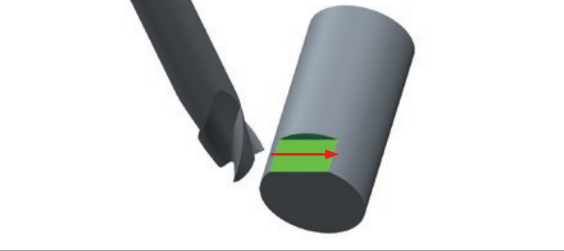
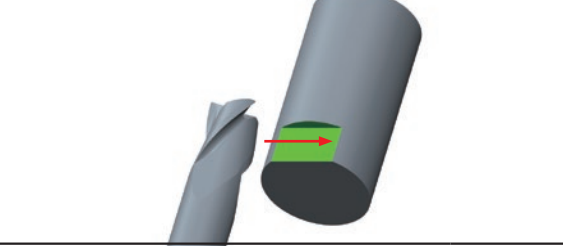


Conventional B  
Ra .030  $\mu$ -inch



## Selection of End Mill for Swiss Type Lathe

① The number of Flutes must be selected according to the type of machining.

Cuttig Mode	Type	MP2ES	MP3ES	MP4EC
	Flutes	2 Flute	3 Flute	4 Flute
Slotting of External		⊙	○	×
Slotting of Facing		⊙	○	×
Face Milling		△	⊙	○
Shoulder Milling		△	○	⊙

## ② Selecting Tools Other Than Small Swiss Type Automatic Lathe End Mills

End Mills with an overall tool length of LF=50 mm or less can be used even with small Swiss Type automatic lathe end mills. Select the necessary tools according to the workpiece material and machining method (such as every 0.1 or radius).

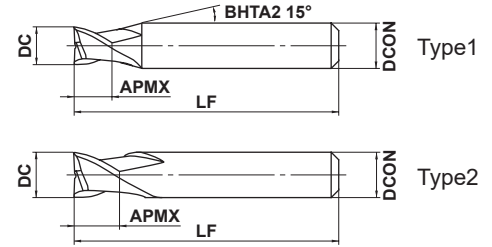
# For Swiss Type Automatic Lathes MS plus End Mill Series

## MP2ES NEW

End mill, 2 flute, For swiss type lathe



Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy	Copper Alloy	Aluminum Alloy
○	○	○		○	○	○	



	3 ≤ DC ≤ 10				
	0.010 - 0.030				
	4 ≤ DCON ≤ 6	7 ≤ DCON ≤ 10			
	0 - 0.008	0 - 0.009			

● 2 flute end mill.

Order Number	DC	APMX	LF	DCON	(mm)		
					* No.F	Stock	Type
MP2ESD0300S04	3	4.5	50	4	2	●	1
MP2ESD0400S04	4	6	50	4	2	●	2
MP2ESD0500S06	5	7.5	50	6	2	●	1
MP2ESD0600S06	6	9	50	6	2	★	2
MP2ESD0700S07	7	10.5	50	7	2	★	2
MP2ESD0800S08	8	12	50	8	2	★	2
MP2ESD1000S10	10	15	50	10	2	●	2

\* Number of Flutes

DC = Dia.  
APMX = Length of Cut

LF = Overall Length  
DCON = Shank Dia.

● : USA Stock ★ : Stocked in Japan

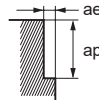
## Recommended Cutting Conditions

### Side Milling

(inch)

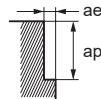
Dia. DC (mm) (inch)		Carbon steel, Cast iron, Alloy steel (-30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	10000	23.6	.118	.024	7000	15.7	.118	.024	6000	11.8	.118	.024
<b>4</b>	<b>.157</b>	7500	23.6	.157	.024	5200	15.7	.157	.024	4500	11.8	.157	.024
<b>5</b>	<b>.197</b>	6000	23.6	.197	.024	4200	15.7	.197	.024	3600	11.8	.197	.024
<b>6</b>	<b>.236</b>	5000	23.6	.236	.024	3500	15.7	.236	.024	3000	11.8	.236	.024
<b>7</b>	<b>.276</b>	4500	22.0	.276	.024	3200	14.2	.276	.024	2700	11.0	.276	.024
<b>8</b>	<b>.315</b>	4000	20.5	.315	.024	2800	13.8	.315	.024	2400	10.2	.315	.024
<b>10</b>	<b>.394</b>	3200	17.7	.394	.024	2200	11.8	.394	.024	1900	9.1	.394	.024

Depth of Cut



Dia. DC (mm) (inch)		Hardened steel (45-55HRC) AISI H13				Copper, Copper Alloy			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	5000	4.7	.118	.008	13000	30.7	.118	.024
<b>4</b>	<b>.157</b>	4000	4.7	.157	.008	9500	29.9	.157	.024
<b>5</b>	<b>.197</b>	3200	4.7	.197	.008	7600	29.9	.197	.024
<b>6</b>	<b>.236</b>	2700	4.7	.236	.008	6400	30.3	.236	.024
<b>7</b>	<b>.276</b>	2300	4.3	.276	.008	5500	26.8	.276	.024
<b>8</b>	<b>.315</b>	2000	4.3	.315	.008	4800	24.4	.315	.024
<b>10</b>	<b>.394</b>	1600	3.9	.394	.008	3800	20.9	.394	.024

Depth of Cut



Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

# For Swiss Type Automatic Lathes MS plus End Mill Series

## MP2ES

End mill, 2 flute, For swiss type lathe

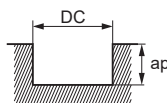
### Recommended Cutting Conditions

#### Slotting

(inch)

Workpiece Material		Carbon steel, Cast iron, Alloy steel (–30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		
Dia. DC		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
(mm)	(inch)									
<b>3</b>	<b>.118</b>	10000	23.6	.024	7000	15.7	.024	6000	11.8	.024
<b>4</b>	<b>.157</b>	7500	23.6	.024	5200	15.7	.024	4500	11.8	.024
<b>5</b>	<b>.197</b>	6000	23.6	.024	4200	15.7	.024	3600	11.8	.024
<b>6</b>	<b>.236</b>	5000	23.6	.024	3500	15.7	.024	3000	11.8	.024
<b>7</b>	<b>.276</b>	4500	22.0	.024	3200	14.2	.024	2700	11.0	.024
<b>8</b>	<b>.315</b>	4000	20.5	.024	2800	13.8	.024	2400	10.2	.024
<b>10</b>	<b>.394</b>	3200	17.7	.024	2200	11.8	.024	1900	9.1	.024

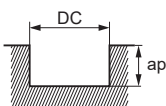
Depth of Cut



DC: Dia.

Workpiece Material		Hardened steel (45–55HRC) AISI H13			Copper, Copper Alloy		
Dia. DC		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
(mm)	(inch)						
<b>3</b>	<b>.118</b>	5000	4.7	.008	13000	30.7	.024
<b>4</b>	<b>.157</b>	4000	4.7	.008	9500	29.9	.024
<b>5</b>	<b>.197</b>	3200	4.7	.008	7600	29.9	.024
<b>6</b>	<b>.236</b>	2700	4.7	.008	6400	30.3	.024
<b>7</b>	<b>.276</b>	2300	4.3	.008	5500	26.8	.024
<b>8</b>	<b>.315</b>	2000	4.3	.008	4800	24.4	.024
<b>10</b>	<b>.394</b>	1600	3.9	.008	3800	20.9	.024

Depth of Cut



DC: Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

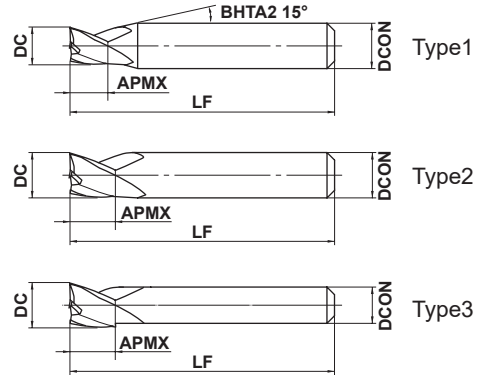


# MP3ES NEW

End mill, 3 flute, For swiss type lathe



Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Heat Resistant Alloy	Copper Alloy	Aluminum Alloy
○	○	○		○	○	○	



	3 ≤ DC ≤ 12				
	0.010 - 0.030				
	4 ≤ DCON ≤ 6	7 ≤ DCON ≤ 10	DCON = 12		
	0 - 0.008	0 - 0.009	0 - 0.011		

● 3 flute end mill.

Order Number	DC	APMX	LF	DCON	(mm)		
					* No.F	Stock	Type
MP3ESD0300S04	3	4.5	50	4	3	●	1
MP3ESD0400S04	4	6	50	4	3	★	2
MP3ESD0500S06	5	7.5	50	6	3	●	1
MP3ESD0600S06	6	9	50	6	3	★	2
MP3ESD0700S07	7	10.5	50	7	3	●	2
MP3ESD0800S08	8	12	50	8	3	★	2
MP3ESD0900S10	9	13.5	50	10	3	★	1
MP3ESD1000S10	10	15	50	10	3	●	2
MP3ESD1200S10	12	15	50	10	3	●	3
MP3ESD1200S12	12	15	50	12	3	★	2

\* Number of Flutes

DC = Dia.  
APMX = Length of Cut

LF = Overall Length  
DCON = Shank Dia.

● : USA Stock ★ : Stocked in Japan

# For Swiss Type Automatic Lathes MS plus End Mill Series

## MP3ES

End mill, 3 flute, For swiss type lathe

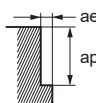
### Recommended Cutting Conditions

#### Side Milling

(inch)

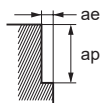
Dia. DC (mm) (inch)		Carbon steel, Cast iron, Alloy steel (–30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	10000	28.3	.118	.024	7000	18.9	.118	.024	6000	14.2	.118	.024
<b>4</b>	<b>.157</b>	7500	28.3	.157	.024	5200	18.9	.157	.024	4500	14.2	.157	.024
<b>5</b>	<b>.197</b>	6000	28.3	.197	.024	4200	18.9	.197	.024	3600	14.2	.197	.024
<b>6</b>	<b>.236</b>	5000	28.3	.236	.024	3500	18.9	.236	.024	3000	14.2	.236	.024
<b>7</b>	<b>.276</b>	4500	26.4	.276	.024	3200	17.3	.276	.024	2700	13.4	.276	.024
<b>8</b>	<b>.315</b>	4000	24.4	.315	.024	2800	16.5	.315	.024	2400	12.2	.315	.024
<b>9</b>	<b>.354</b>	3500	22.8	.354	.024	2500	15.0	.354	.024	2100	11.4	.354	.024
<b>10</b>	<b>.394</b>	3200	21.3	.394	.024	2200	14.2	.394	.024	1900	11.0	.394	.024
<b>12</b>	<b>.472</b>	2700	19.3	.472	.024	1900	12.6	.472	.024	1600	9.8	.472	.024

Depth of Cut



Dia. DC (mm) (inch)		Hardened steel (45–55HRC) AISI H13				Copper, Copper Alloy			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	5000	5.5	.118	.008	13000	37.0	.118	.024
<b>4</b>	<b>.157</b>	4000	5.5	.157	.008	9500	35.8	.157	.024
<b>5</b>	<b>.197</b>	3200	5.5	.197	.008	7600	35.8	.197	.024
<b>6</b>	<b>.236</b>	2700	5.5	.236	.008	6400	36.2	.236	.024
<b>7</b>	<b>.276</b>	2300	5.1	.276	.008	5500	32.3	.276	.024
<b>8</b>	<b>.315</b>	2000	5.1	.315	.008	4800	29.1	.315	.024
<b>9</b>	<b>.354</b>	1800	5.1	.354	.008	4200	27.6	.354	.024
<b>10</b>	<b>.394</b>	1600	4.7	.394	.008	3800	25.2	.394	.024
<b>12</b>	<b>.472</b>	1300	4.7	.472	.008	3200	22.8	.472	.024

Depth of Cut



Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

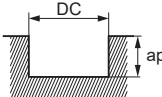
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

## Slotting

(inch)

Dia. DC (mm) (inch)		Carbon steel, Cast iron, Alloy steel (–30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
<b>3</b>	<b>.118</b>	10000	28.3	.024	7000	18.9	.024	6000	14.2	.024
<b>4</b>	<b>.157</b>	7500	28.3	.024	5200	18.9	.024	4500	14.2	.024
<b>5</b>	<b>.197</b>	6000	28.3	.024	4200	18.9	.024	3600	14.2	.024
<b>6</b>	<b>.236</b>	5000	28.3	.024	3500	18.9	.024	3000	14.2	.024
<b>7</b>	<b>.276</b>	4500	26.4	.024	3200	17.3	.024	2700	13.4	.024
<b>8</b>	<b>.315</b>	4000	24.4	.024	2800	16.5	.024	2400	12.2	.024
<b>9</b>	<b>.354</b>	3500	22.8	.024	2500	15.0	.024	2100	11.4	.024
<b>10</b>	<b>.394</b>	3200	21.3	.024	2200	14.2	.024	1900	11.0	.024
<b>12</b>	<b>.472</b>	2700	19.3	.024	1900	12.6	.024	1600	9.8	.024

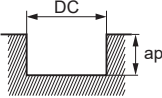
Depth of Cut



DC:Dia.

Dia. DC (mm) (inch)		Hardened steel (45–55HRC) AISI H13			Copper, Copper Alloy		
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
<b>3</b>	<b>.118</b>	5000	5.5	.008	13000	37.0	.024
<b>4</b>	<b>.157</b>	4000	5.5	.008	9500	35.8	.024
<b>5</b>	<b>.197</b>	3200	5.5	.008	7600	35.8	.024
<b>6</b>	<b>.236</b>	2700	5.5	.008	6400	36.2	.024
<b>7</b>	<b>.276</b>	2300	5.1	.008	5500	32.3	.024
<b>8</b>	<b>.315</b>	2000	5.1	.008	4800	29.1	.024
<b>9</b>	<b>.354</b>	1800	5.1	.008	4200	27.6	.024
<b>10</b>	<b>.394</b>	1600	4.7	.008	3800	25.2	.024
<b>12</b>	<b>.472</b>	1300	4.7	.008	3200	22.8	.024

Depth of Cut



DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

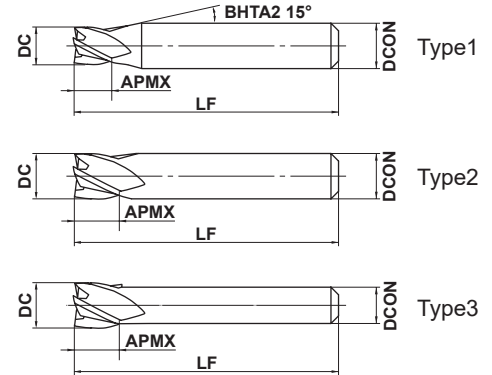
# For Swiss Type Automatic Lathes MS plus End Mill Series

## MP4EC NEW

End mill, 4 flute, For swiss type lathe



Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy	Copper Alloy	Aluminum Alloy
○	○	○		○	○	○	



	3 ≤ DC ≤ 12	DC = 14			
	0.010 - 0.030	0.010 - 0.040			
	4 ≤ DCON ≤ 6	7 ≤ DCON ≤ 10	DCON = 12		
	0 - 0.008	0 - 0.009	0 - 0.011		

● 4 flute end mill.

Order Number	DC	APMX	LF	DCON	* No.F	Stock	Type
MP4ECD0300S04	3	4.5	50	4	4	●	1
MP4ECD0350S04	3.5	5	50	4	4	★	1
MP4ECD0400S04	4	6	50	4	4	●	2
MP4ECD0500S06	5	7.5	50	6	4	●	1
MP4ECD0600S06	6	9	50	6	4	●	2
MP4ECD0700S07	7	10.5	50	7	4	★	2
MP4ECD0800S07	8	12	50	7	4	★	3
MP4ECD0800S08	8	12	50	8	4	●	2
MP4ECD0900S10	9	13.5	50	10	4	●	1
MP4ECD1000S07	10	15	50	7	4	★	3
MP4ECD1000S10	10	15	50	10	4	●	2
MP4ECD1200S10	12	15	50	10	4	●	3
MP4ECD1200S12	12	15	50	12	4	★	2
MP4ECD1400S10	14	15	50	10	4	●	3

\* Number of Flutes

DC = Dia.                      LF = Overall Length  
 APMX = Length of Cut      DCON = Shank Dia.

● : USA Stock   ★ : Stocked in Japan

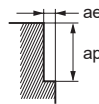
## Recommended Cutting Conditions

### Side Milling

(inch)

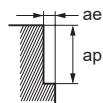
Dia. DC (mm) (inch)		Carbon steel, Cast iron, Alloy steel (–30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	10000	35.4	.118	.024	7000	23.6	.118	.024	6000	17.7	.118	.024
<b>3.5</b>	<b>.138</b>	8500	35.4	.138	.024	6000	23.6	.138	.024	5100	17.7	.138	.024
<b>4</b>	<b>.157</b>	7500	35.4	.157	.024	5200	23.6	.157	.024	4500	17.7	.157	.024
<b>5</b>	<b>.197</b>	6000	35.4	.197	.024	4200	23.6	.197	.024	3600	17.7	.197	.024
<b>6</b>	<b>.236</b>	5000	35.4	.236	.024	3500	23.6	.236	.024	3000	17.7	.236	.024
<b>7</b>	<b>.276</b>	4500	33.1	.276	.024	3200	21.3	.276	.024	2700	16.5	.276	.024
<b>8</b>	<b>.315</b>	4000	30.7	.315	.024	2800	20.5	.315	.024	2400	15.4	.315	.024
<b>9</b>	<b>.354</b>	3500	28.3	.354	.024	2500	18.9	.354	.024	2100	14.2	.354	.024
<b>10</b>	<b>.394</b>	3200	26.8	.394	.024	2200	17.7	.394	.024	1900	13.4	.394	.024
<b>12</b>	<b>.472</b>	2700	24.4	.472	.024	1900	16.1	.472	.024	1600	12.2	.472	.024
<b>14</b>	<b>.551</b>	2300	21.7	.551	.024	1600	13.8	.551	.024	1400	11.0	.551	.024

Depth of cut



Dia. DC (mm) (inch)		Hardened steel (45–55HRC) AISI H13				Copper, Copper Alloy			
		Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Width of Cut ae
<b>3</b>	<b>.118</b>	5000	7.1	.118	.008	13000	47.2	.118	.024
<b>3.5</b>	<b>.138</b>	4500	7.1	.138	.008	11000	47.2	.138	.024
<b>4</b>	<b>.157</b>	4000	7.1	.157	.008	9500	43.3	.157	.024
<b>5</b>	<b>.197</b>	3200	7.1	.197	.008	7600	43.3	.197	.024
<b>6</b>	<b>.236</b>	2700	7.1	.236	.008	6400	43.3	.236	.024
<b>7</b>	<b>.276</b>	2300	6.3	.276	.008	5500	39.4	.276	.024
<b>8</b>	<b>.315</b>	2000	6.3	.315	.008	4800	37.0	.315	.024
<b>9</b>	<b>.354</b>	1800	5.9	.354	.008	4200	33.9	.354	.024
<b>10</b>	<b>.394</b>	1600	5.5	.394	.008	3800	31.9	.394	.024
<b>12</b>	<b>.472</b>	1300	4.7	.472	.008	3200	28.7	.472	.024
<b>14</b>	<b>.551</b>	1200	4.7	.551	.008	2700	25.6	.551	.024

Depth of cut



Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

# For Swiss Type Automatic Lathes MS plus End Mill Series

## MP4EC

End mill, 4 flute, For small automatic lathes

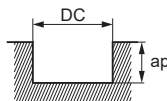
### Recommended Cutting Conditions

#### Slotting

(inch)

Dia. DC		Carbon steel, Cast iron, Alloy steel (–30HRC)			Alloy steel, Tool steel, Pre-hardened steel			Austenitic stainless steel, Titanium alloy		
		AISI 1050, AISI No 35 B, AISI P20			AISI H13, AISI W1-10, AISI P21			AISI 304, AISI 306, Ti-6Al-4V		
(mm)	(inch)	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
<b>3</b>	<b>.118</b>	10000	35.4	.024	7000	23.6	.024	6000	17.7	.024
<b>3.5</b>	<b>.138</b>	8500	35.4	.024	6000	23.6	.024	5100	17.7	.024
<b>4</b>	<b>.157</b>	7500	35.4	.024	5200	23.6	.024	4500	17.7	.024
<b>5</b>	<b>.197</b>	6000	35.4	.024	4200	23.6	.024	3600	17.7	.024
<b>6</b>	<b>.236</b>	5000	35.4	.024	3500	23.6	.024	3000	17.7	.024
<b>7</b>	<b>.276</b>	4500	33.1	.024	3200	21.3	.024	2700	16.5	.024
<b>8</b>	<b>.315</b>	4000	30.7	.024	2800	20.5	.024	2400	15.4	.024
<b>9</b>	<b>.354</b>	3500	28.3	.024	2500	18.9	.024	2100	14.2	.024
<b>10</b>	<b>.394</b>	3200	26.8	.024	2200	17.7	.024	1900	13.4	.024
<b>12</b>	<b>.472</b>	2700	24.4	.024	1900	16.1	.024	1600	12.2	.024
<b>14</b>	<b>.551</b>	2300	21.7	.024	1600	13.8	.024	1400	11.0	.024

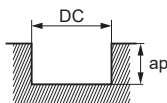
Depth of Cut



DC:Dia.

Dia. DC		Hardened steel (45–55HRC)			Copper, Copper Alloy		
		AISI H13					
(mm)	(inch)	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap	Revolution (min <sup>-1</sup> )	Feed rate (IPM)	Depth of Cut ap
<b>3</b>	<b>.118</b>	5000	7.1	.008	13000	47.2	.024
<b>3.5</b>	<b>.138</b>	4500	7.1	.008	11000	47.2	.024
<b>4</b>	<b>.157</b>	4000	7.1	.008	9500	43.3	.024
<b>5</b>	<b>.197</b>	3200	7.1	.008	7600	43.3	.024
<b>6</b>	<b>.236</b>	2700	7.1	.008	6400	43.3	.024
<b>7</b>	<b>.276</b>	2300	6.3	.008	5500	39.4	.024
<b>8</b>	<b>.315</b>	2000	6.3	.008	4800	37.0	.024
<b>9</b>	<b>.354</b>	1800	5.9	.008	4200	33.9	.024
<b>10</b>	<b>.394</b>	1600	5.5	.008	3800	31.9	.024
<b>12</b>	<b>.472</b>	1300	4.7	.008	3200	28.7	.024
<b>14</b>	<b>.551</b>	1200	4.7	.008	2700	25.6	.024

Depth of Cut



DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.

Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 3) When drilling, please set the feed rate at 1/3 or below the values above.

Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

# Memo

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A series of horizontal dashed lines for writing, spanning the width of the page.



For Swiss Type Automatic Lathes  
MS plus End Mill Series

# MP2ES/3ES/4EC

**For your safety**

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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Customer Service : 800-523-0800  
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El Marques, Queretaro, CP76246, Mexico  
TEL : +52-442-221-6136 FAX : +52-442-221-6134

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