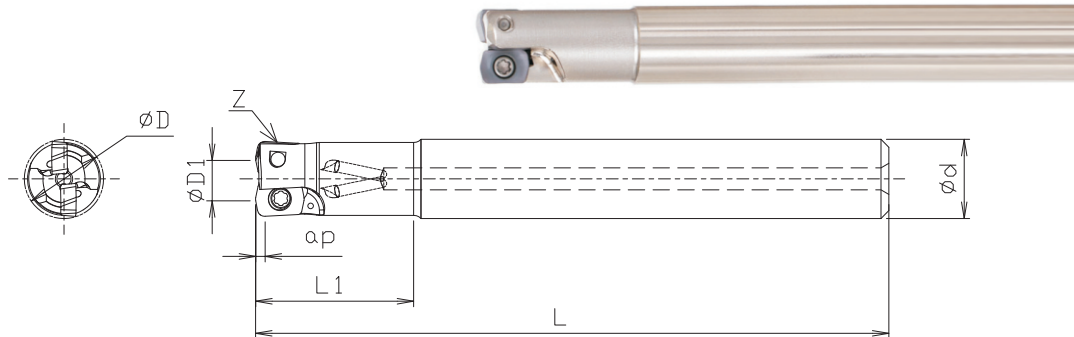


MFH SERIES

Micro-Diameter , High-Feed Milling



- ★Durable Design Aids in Chatter Resistance.
- ★Stable High Feed Machining on a Wide Range of Applications.
- ★Controls Chip Biting with Convex Cutting Edge.
- ★Replaces Solid End Mills to Reduce Machining Costs.



● Standard Type

Designation	Size(mm)							Clamping Screw	Wrench
	D	D1	d	L	L1	Z	Max.ap		
MFH08-S10-120-1T	8	4.2	10	120	35	1	0.5	TB1002	TBP02
MFH10-S10-120-2T	10	6.2	10	120	35	2	0.5		
MFH12-S12-120-3T	12	8.2	12	120	35	3	0.5		

● Non-interference Type

Designation	Size(mm)							Clamping Screw	Wrench
	D	D1	d	L	L1	Z	Max.ap		
MFH10-S08-120-2T	10	6.2	8	120	35	2	0.5	TB1002	TBP02
MFH12-S10-120-3T	12	8.2	10	120	35	3	0.5		
MFH14-S12-120-3T	14	10.2	12	120	35	3	0.5		

Face Milling
MF-PN6 Series

High-Feed Milling
MFH Series

Shoulder Milling
TAN90 Series

Profile Milling
TRD Series

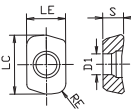
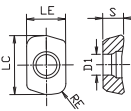
Slot Milling
TLXFD/SD Series

Multi-Functional Milling
Modular Bapm Series

MFH SERIES

Micro-Diameter , High-Feed Milling

● Applicable Inserts

		Usage Classification		P	Steel	★								
		★ 1st Choice ☆ 2nd Choice	M	Stainless	★									
			K	Cast iron	★									
			N	Non-ferrous										
			S	Superalloys	★									
			H	Hard materials		★								
		Insert		Insert No.	Size(mm)					Coated Carbide		Carbide		
LC	LE				S	D1	RE	TY125	TH105	TY602	TY622	HC200		
		BPMT020210R-UF	6.38	4.19	2.59	2.1	1.0	●						
		BPGT020210R-UH	6.38	4.19	2.59	2.1	1.0	●						

● Recommended Cutting Conditions

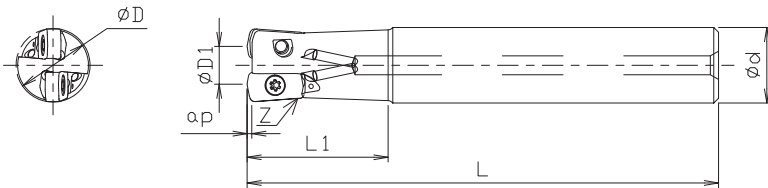
ISO	Workpiece material	Hardness	Grade	Cutting Speed	Feed
				Vc (m/min)	fz (mm/t)
P	Carbon Steel	≤ HB300	TY125	100-300	0.2-0.8
	Alloy Steel	HB200-300		100-300	0.2-0.8
	Mold Steel	< HRC40		100-200	0.2-0.5
M	Stainless Steel	≤ HB200		100-150	0.2-0.5
K	Gray Cast Iron	HB150-250		100-300	0.2-0.8
	Ductile Cast Iron	HB150-250		80-200	0.2-0.6
S	Ni-base HeatResistant Alloy	< HRC40		20-50	0.1-0.3
	Titanium Alloy	< HRC40		30-60	0.1-0.3
H	Hard Materials	HRC40-50	TH105	80-150	0.1-0.5
		HRC50-60		50-70	0.1-0.3

MRH SERIES

High-Feed Milling



- ★ High feed milling for small diameters and small machining centers.
- ★ Economical inserts with 4 cutting edges.
- ★ Both of standard type and non-interference type are available.



Standard Type

Designation	Size(mm)							Clamping Screw	Wrench
	D	D1	d	L	L1	Z	Max.ap		
MRH16-S16-03-2T	16	8	16	100	30	2	1	M3065-S	FT08
MRH20-S20-03-3T	20	12	20	130	50	3	1		
MRH25-S25-03-3T	25	17	25	140	60	3	1		
MRH32-S32-03-4T	32	24	32	150	70	4	1		

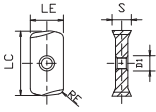
Non-interference Type

Designation	Size(mm)							Clamping Screw	Wrench
	D	D1	d	L	L1	Z	Max.ap		
MRH17-S16-03-2T	17	9	16	150	25	2	1	M3065-S	FT08
MRH21-S20-03-3T	21	13	20	150	30	3	1		
MRH26-S25-03-3T	26	18	25	150	35	3	1		

MRH SERIES

High-Feed Milling

● Applicable Inserts

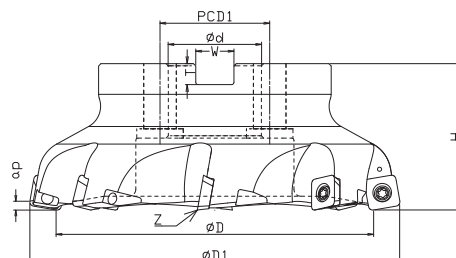
		Usage Classification											
				P	Steel	★		★					
★ 1st Choice ☆ 2nd Choice		M	Stainless	☆	★	★							
		K	Cast iron										
		N	Non-ferrous										
		S	Superalloys		★								
		H	Hard materials										
Insert		Insert No.	Size(mm)					Coated Carbide				Carbide	
			LC	LE	S	D1	RE	KX402	KX405	TY602	TY622	HC200	
		LOGU030310ER-GM	11.9	6.2	3.96	3.45	1.0	●	●	●			

● Recommended Cutting Conditions

ISO	Workpiece material	Hardness	Grade	Cutting Speed	Feed
				Vc (m/min)	fz (mm/t)
P	Carbon Steel	≤ HB300	KX402/TY602	120-250	0.2-1.2
	Alloy Steel	HB200-300		100-220	0.2-1.2
	Mold Steel	< HRC40		80-180	0.2-0.9
	Mold Steel	HRC40-50		60-130	0.2-0.5
M	Stainless Steel	≤ HB200	KX405/TY602	100-200	0.2-0.9
S	Ni-base HeatResistant Alloy	—	KX405	20-50	0.2-0.6
	Titanium Alloy	—		40-80	0.2-0.6

MRH SERIES

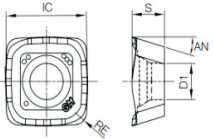
High-Feed Milling



Designation	Size(mm)								Clamping Screw	Wrench
	D	D1	d	H	W	T	Z	Max.ap		
MRH050R-14-3T-22M	27	50	22	50	10.4	6	3	2	M5011-S	WT20
MRH063R-14-4T-22M	40	63	22	50	10.4	6	4	2		
MRH080R-14-5T-M	57	80	27	63	12.4	7	5	2		
MRH100R-14-7T-M	77	100	32	63	14.4	8	7	2		
MRH125R-14-7T-M	102	125	40	63	16.4	9	7	2		
MRH160R-14-8T-M	137	160	40	63	16.4	9	8	2		

● Applicable Inserts

Usage Classification	P	Steel	★															
	M	Stainless	☆	★														
	K	Cast iron																
	N	Non-ferrous																
	S	Superalloys		★														
	H	Hard materials																

Insert	Insert No.	Size(mm)										Coated Carbide		Carbide	
		IC	S	D1	RE	AN	KX402	KX405	TY602	TY622	HC200				
		SOMT140520ER-GM	14.1	5.56	5.8	2.0	16°	●	●						

● Recommended Cutting Conditions

ISO	Workpiece material	Hardness	Grade	Cutting Speed	Feed
				Vc (m/min)	fz (mm/t)
P	Carbon Steel	≤HB300	KX402	120-250	0.5-2.0
	Alloy Steel	HB200-300		100-220	0.5-2.0
	Mold Steel	<HRC40		80-180	0.2-1.8
	Mold Steel	HRC40-50		60-130	0.2-1.0
M	Stainless Steel	≤HB200	KX405	100-200	0.5-1.2
S	Ni-base HeatResistant Alloy	—		20-50	0.2-0.8
	Titanium Alloy	—		40-80	0.2-0.8