The New Value Frontier

KYOCERA

MEV

High performance, multi-functional milling cutters

Newly developed triangle inserts provide numerous solutions

High performance - low cutting forces and higher rigidity for excellent chatter resistance

Multi-functional - can be used in shouldering, slotting, and ramping applications

High performance milling

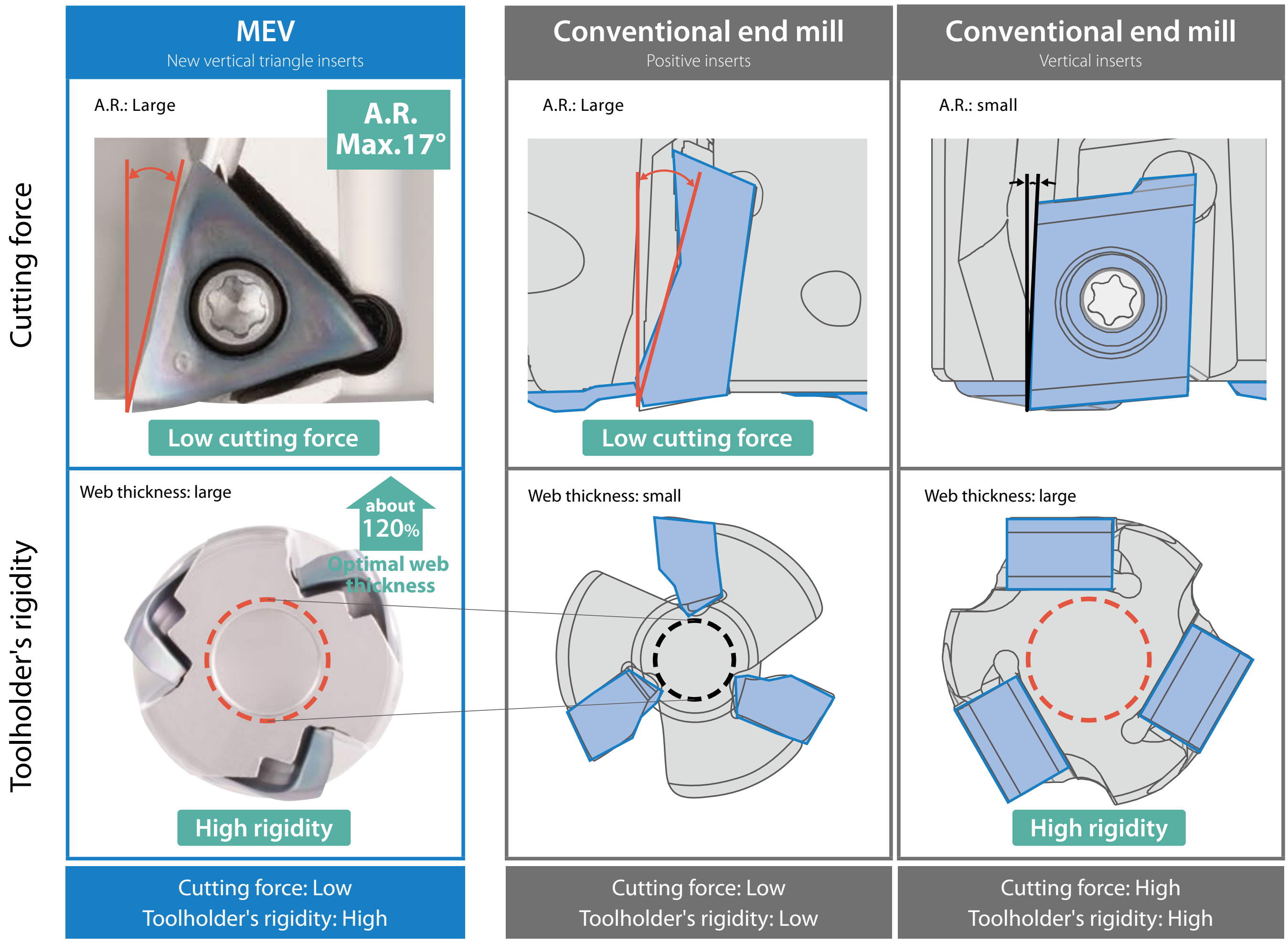
MEV

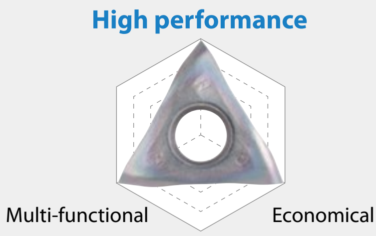
Newly developed triangular inserts providing low cutting force and increased toolholder rigidity. High performance, economical, and multi-functional milling solutions.

1 High performance: low cutting force and high rigidity

Newly developed vertical triangle inserts with 3 cutting edges achieve stable machining with reduced chattering.

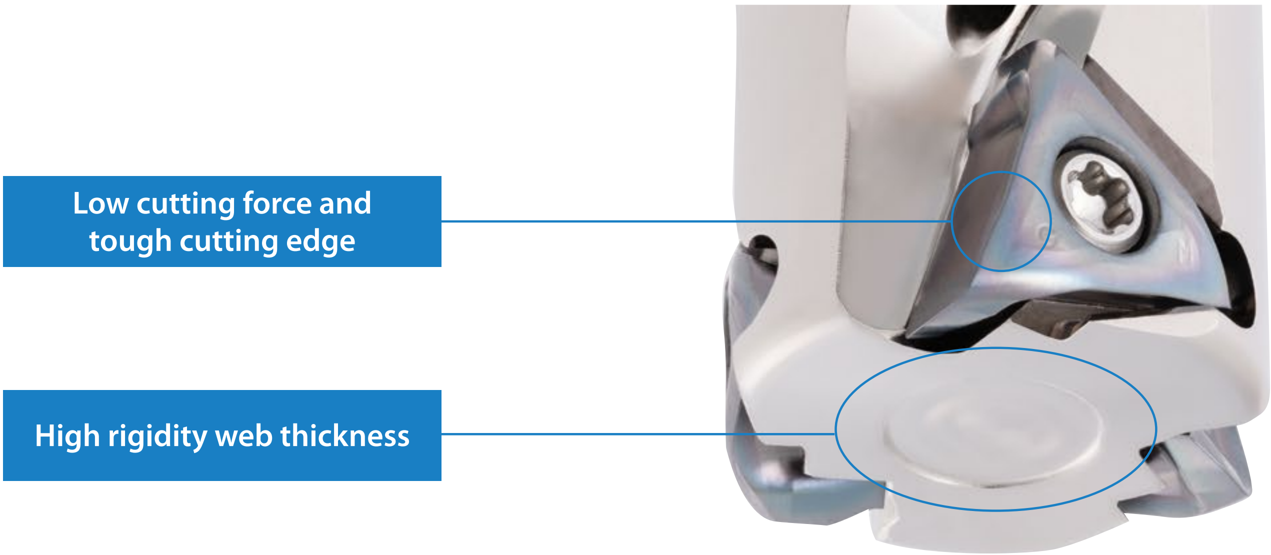
MEV vs. competitor





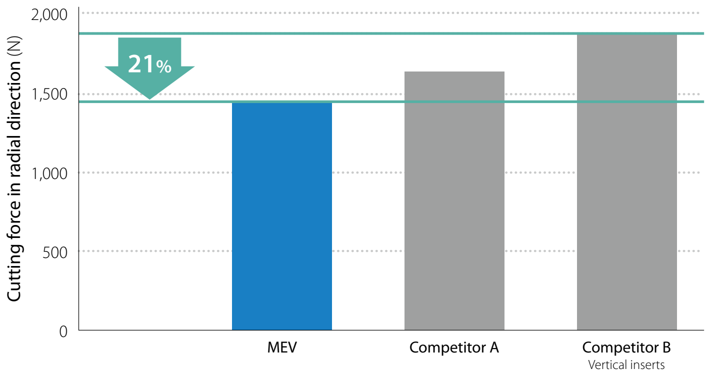
The MEV's large A.R. produces lower cutting forces and the vertical triangle inserts provide a higher rigidity.

The great performance of the multi-purpose MEV triangle inserts combines both advantages of conventional positive and negative type inserts.



Keeping A.R. max. at 17°, provides lower cutting force than the positive insert types of competitors

Cuttting force comparison (internal evaluation)

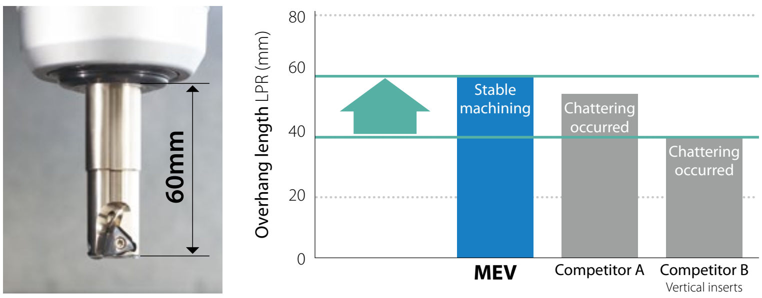


Cutting conditions: Vc = 200 m/min, ap × ae = 3 × 18 mm, fz = 0.10 mm/t, ø20 (3 inserts), Dry, workpiece: 42CrMo4

Low cutting force and large optimal web thickness provides excellent chattering resistance

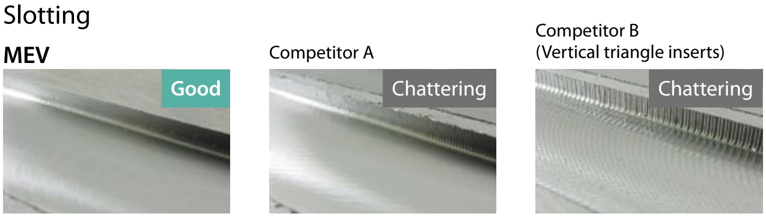
Chattering resistance comparison (internal evaluation)

Shouldering



Cutting conditions: Vc = 200 m/min, ap × ae = 3 × 18 mm, fz = 0.10 mm/t, ø20 (3 inserts), dry, workpiece: 42CrMo4

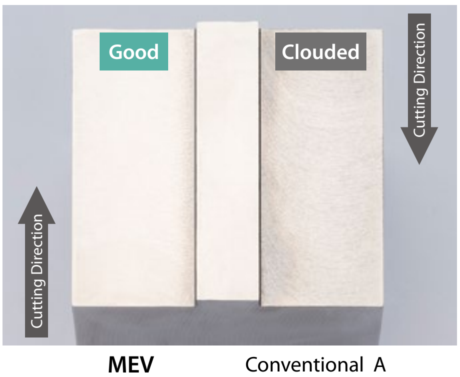
Slotting



Cutting conditions: Vc = 220 m/min, ap = 3 mm (Slotting), fz = 0.10 mm/t, ø20 (3 inserts), dry, workpiece: 42CrMo4

Provides excellent surface finish and superior cutting accuracy of the wall

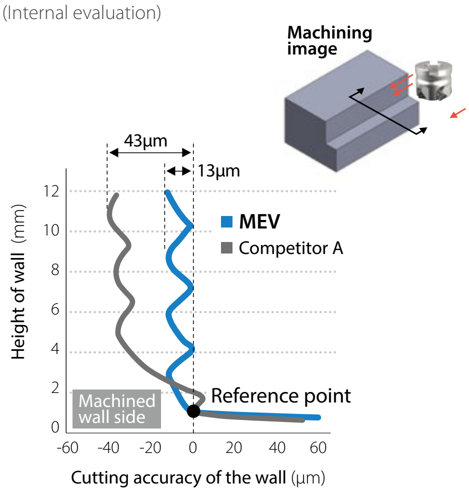
Surface finish comparison (internal evaluation)



Cutting conditions : Vc = 180 m/min, ap × ae = 3 × 40 mm, fz = 0.1 mm/t, ø50 (5 inserts), dry, workpiece: C50

Cutting accuracy of wall example

(Internal evaluation)



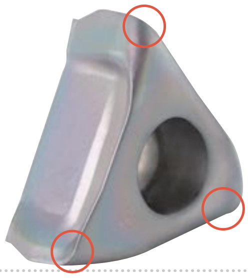
Cutting conditions: Vc = 200 m/min, ap × ae = 3 × 10 mm (4 pass), fz = 0.15 mm/t, ø50 (5 inserts), dry, workpiece: C50

*Accuracy of the wall surface varies depending on cutting conditions, machining environment, and insert combination.

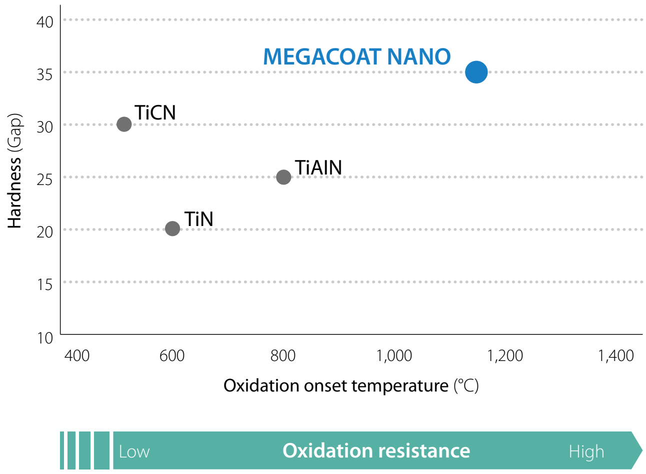
2 The economical choice: 3 cutting edge insert with long tool life

Insert

Unique triangle inserts with 3 cutting edges. PR15 series utilizes MEGACOAT NANO coating technology with excellent wear and adhesion resistance.

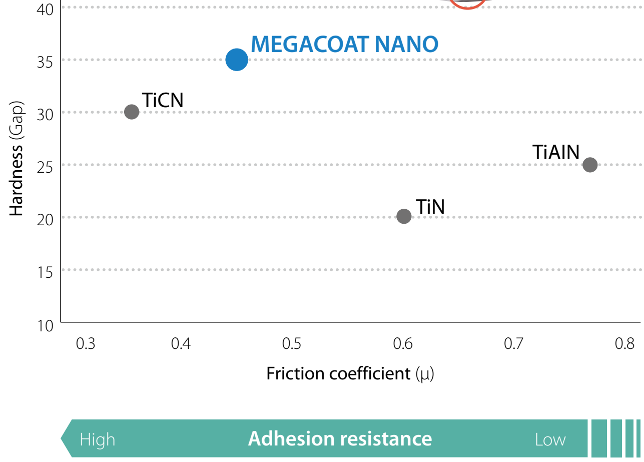


Coating properties (abrasion resistance)



Achieve long tool life with the combination of a tough substrate and a special nano coating layer

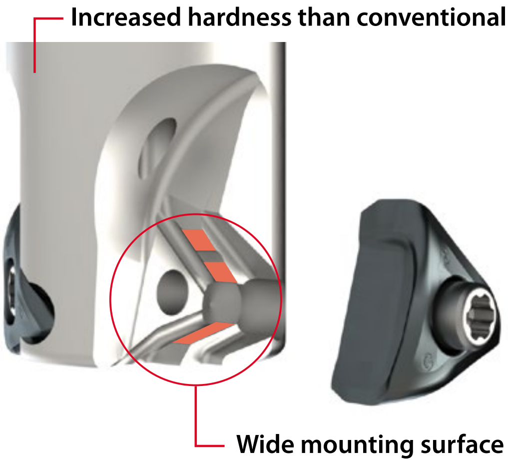
Coating properties (adhesion resistance)



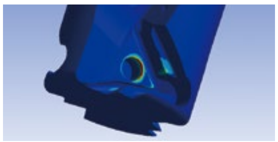
Stable machining with excellent wear resistance

Toolholder

Engineered with state-of-the-art simulation and analysis technology, the MEV is built to reduce stress on the cutter body. Increased hardness and wide contact surface for improved durability.



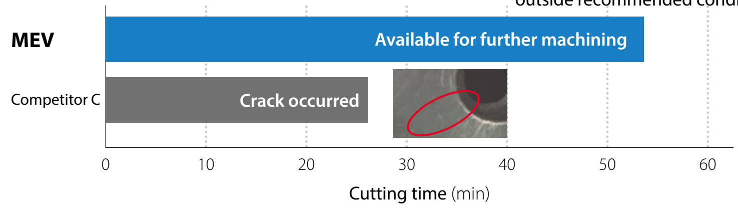
Simulation and analysis



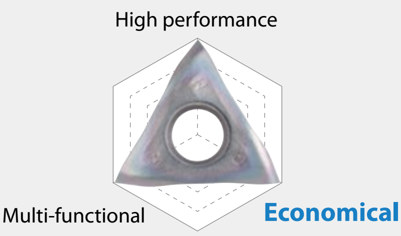
Prevents breakage from toolholder with decreased max. stress

Toolholder durability comp. (Internal evaluation)

*Comparison at high feed rate outside recommended conditions



Cutting conditions: Vc = 120 m/min, ap × ae = 5 × 7.5 mm, fz = 0.25 mm/t, ø20 (1 insert), dry, workpiece: 42CrMo4

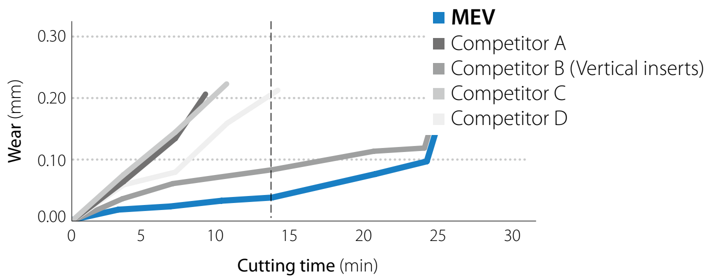


3 cutting edges combined with PR15 series MEGACOAT NANO coating technology maintains long tool life.

Improved toolholder toughness and durability.

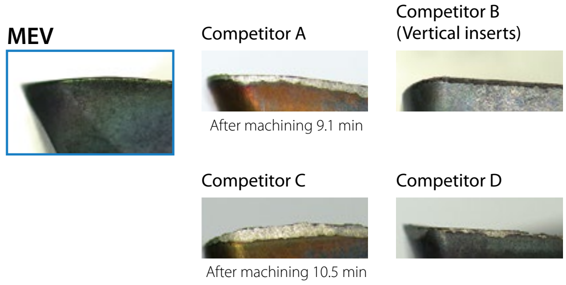
Long tool life with excellent wear resistance

Wear resistance comparison (internal evaluation)



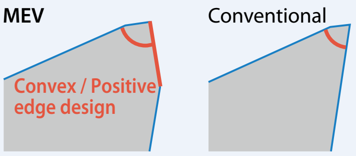
Cutting conditions: Vc = 180 m/min, ap × ae = 3 × 10 mm, fz = 0.1 mm/t, ø20, dry, workpiece: X153CrMoV12 (30~35HS)

Cutting edge (after machining 14 min)



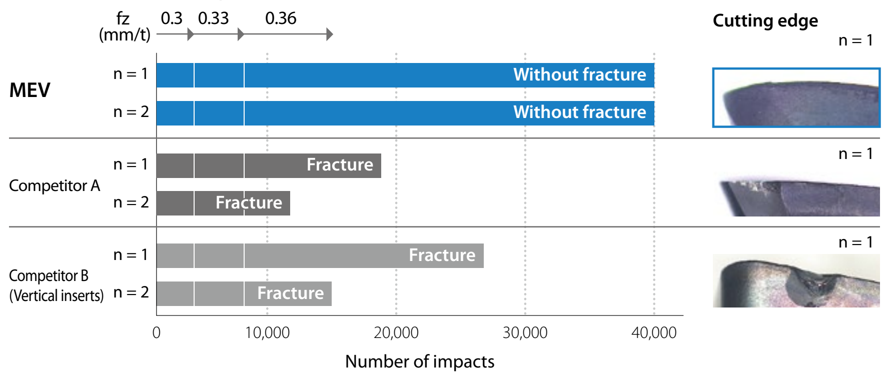
Improved stability with superior fracture resistance

Cutting edge cross-section



The MEV features a larger cutting edge to increase strength

Wear resistance comparison (internal evaluation)



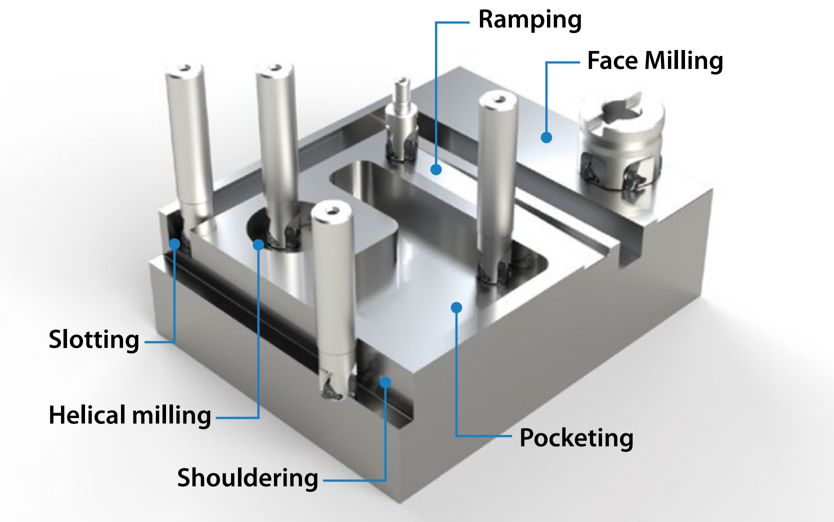
Cutting conditions: Vc = 120 m/min, ap × ae = 2 × 10 mm, fz = 0.3 - 0.36 mm/t, ø20 (1 insert), dry, workpiece: 42CrMo4 (37~39HS)

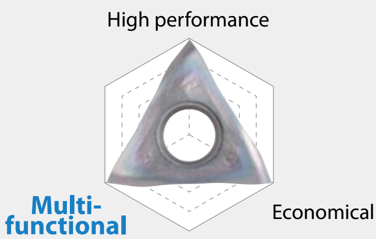
3 Multi-functional: The MEV can perform a wide variety of machining processes

Great performance in shouldering, slotting, and ramping applications (D.O.C. 6 mm or less)

Chip example (slotting)

Cutting conditions: Vc = 150 m/min, ap = 6 mm (Slotting)
fz = 0.2 mm/t, ø20 (3 insert), dry, workpice: ST44-2





Good chip evacuation with a unique insert chipbreaker design.

Stable machining in applications like slotting and ramping where chip recutting issues are common.

MEV (End mills)

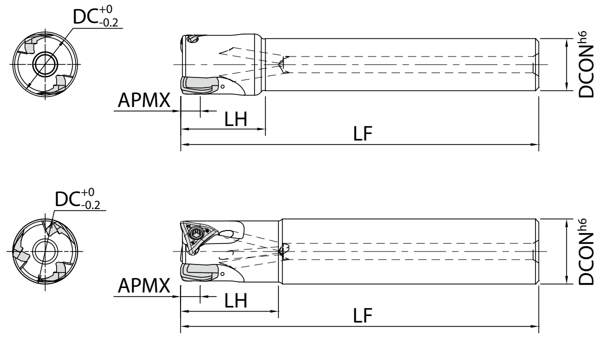


Fig.1

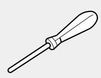
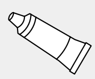
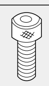
Fig.2

Toolholder dimensions

Description				Availability	No. of inserts	Dimensions (mm)					Rake angle		Coolant hole	Weight (kg)	Drawing	Max. revolution (min⁻¹)
						DC	DCON	LF	LH	APMX	A.R.(MAX.)	R.R.				
Cylindrical shank	Standard (Straight)	MEV	20-S16-06-2T	●	2	20	16	110	26	6	+17°	−38°	Yes	0.2	Fig.1	32,000
			22-S20-06-3T	●	3	22	20					−37°				29,000
			25-S20-06-3T	●		25		120	29					0.3		25,000
			28-S25-06-3T	●		28	25					−36°		0.4		23,000
			30-S25-06-4T	●	4	30		130	32					0.5		21,500
			32-S25-06-4T	●		32						−36°				20,000
			40-S32-06-5T	●	5	40	32	150	50					1.0		16,000
			50-S32-06-5T	●		50		120	40		+16°	−36°		0.9		13,000
	Same size shank	MEV	20-S20-06-2T	●	2	20	20	110	30	6	+17°	−38°	Yes	0.2	Fig.2	32,000
			20-S20-06-3T	●	3											
			25-S25-06-2T	●	2	25	25	120	32			−37°		0.4		25,000
			25-S25-06-3T	●	3											
			32-S32-06-3T	●		32	32	130	40			−36°		0.7		20,000
			32-S32-06-4T	●	4											
	Long shank	MEV	20-S18-06-150-2T	●	2	20	18	150	30	6	+17°	−38°	Yes	0.3	Fig.1	32,000
			20-S20-06-150-2T	●			20		40						Fig.2	
			25-S25-06-170-2T	●		25	25	170	50			−37°		0.6		25,000
			32-S32-06-200-2T	●		32	32	200	65			−36°		1.1		20,000

●: Available

Spare parts and applicable inserts

Description			Parts				Applicable inserts	
			Clamp screw	Wrench	Anti-seize compound	Arbor bolt		
							 General purpose	 Low cutting force
End mills	MEV	...-06-...T	SB-3076TRP	DTPM-10	P-37	–	TOMT06...-GM	TOMT06...-SM
Face mills	MEV	032R-06-4T-M				HH8X25		
		040R-06-5T-M						
		050R-06-5T-M				HH10X30		
Modular heads	MEV	20-M10-06-2T				–		
		20-M10-06-3T				–		
		25-M12-06-3T				–		
		32-M16-06-4T				–		

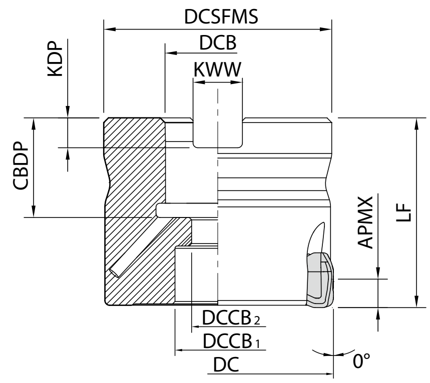
Recommended torque for insert screw 2.0 N･m

Caution with max. revolution

When running an end mill or a cutter at the maximum revolution, the insert or the cutter may be damaged by centrifugal force.

Coat anti-seize compound thinly on portion of taper and thread prior to installation.

MEV (Face mills)

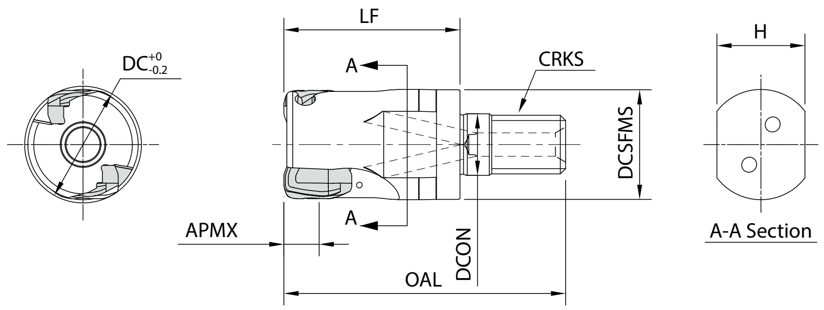


Toolholder dimensions

Description		Avail-ability	No. of inserts	Dimensions (mm)										Rake angle		Coolant hole	Weight (Kg)	Max. revolution (min^{-1})
				DC	DCSFMS	DCB	DCCB1	DCCB2	LF	CBDP	KDP	KWW	APMX	A.R. (MAX.)	R.R.			
MEV	032R-06-4T-M	●	4	32	30	16	13.5	9	35	19	5.6	8.4	6	+17°	−36°	Yes	0.1	20,000
	040R-06-5T-M	●	5	40	38		15		40								0.2	16,000
	050R-06-5T-M	●	5	50	48	22	18	11		21	6.3	10.4		+16°			0.4	13,000

● : Available

MEV (Modular heads)

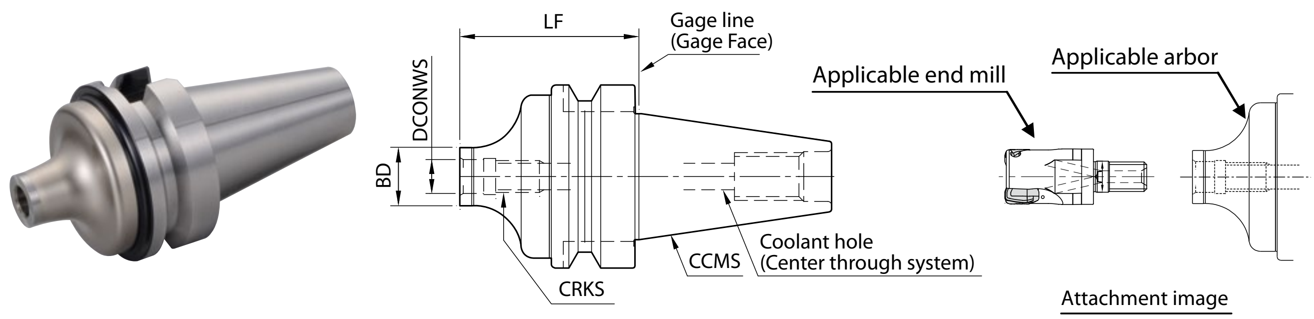


Toolholder dimensions

Description		Avail-ability	No. of inserts	Dimensions (mm)								Rake angle		Coolant hole	Max. revolution (min^{-1})
				DC	DCSFMS	DCON	OAL	LF	CRKS	H	APMX	A.R. (MAX.)	R.R.		
MEV	20-M10-06-2T	●	2	20	18.7	10.5	48	30	M10×P1.5	15	6	+17°	−38°	Yes	32,000
	20-M10-06-3T	●	3												
	25-M12-06-3T	●		25	23	12.5	56	35	M12×P1.75	19			−37°		25,000
	32-M16-06-4T	●	4	32	30	17	62	40	M16×P2.0	24			−36°		20,000

● : Available

BT arbor for exchangeable head / double-face clamping spindle

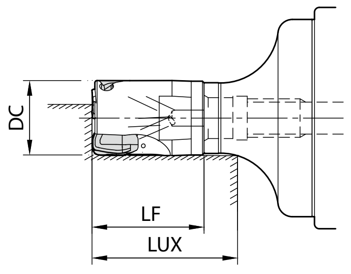


Dimensions

Description		Avail-ability	Dimensions (mm)				Coolant hole	Arbor (Double-face clamping spindle)	Applicable end mill
			LF	BD	DCONWS	CRKS		CCMS	
BT30K-	M10-45	●	45	18.7	10.5	M10×P1.5	Yes	BT30	MEV20-M10··
	M12-45	●		23	12.5	M12×P1.75			MEV25-M12··
BT40K-	M10-60	●	60	18.7	10.5	M10×P1.5	Yes	BT40	MEV20-M10··
	M12-55	●	55	23	12.5	M12×P1.75			MEV25-M12··
	M16-65	●	65	30	17	M16×P2.0			MEV32-M16··

●: Available

Actual end mill depth

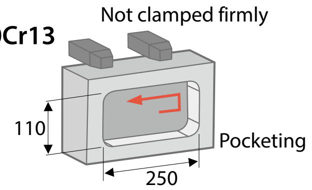


Arbor description		Applicable end mill			Actual end mill depth (mm)
		Description	Cutting dia.	Dimensions	LUX
			DC	LF	
BT30K-	M10-45	MEV20-M10··	20	30	36.8
	M12-45	MEV25-M12··	25	35	42.8
BT40K-	M10-60	MEV20-M10··	20	30	38.7
	M12-55	MEV25-M12··	25	35	44.6
	M16-65	MEV32-M16··	32	40	51.2

Case study

Parts for machinary X30Cr13

Vc = 180 m/min
ap × ae = 1 × ~50 mm
fz = 0.1 mm/t dry
MEV50-S32-06-5T (5 inserts)
TOMT060508ER-GM PR1535



Cutting time

MEV Vf = 575 mm/min x1.6

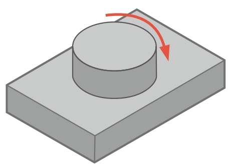
Comp. E Vf = 350 mm/min

Quiet machining even when cutting speed increased
The MEV shows 1.6 times machining efficiency and good bottom surface finish

(User evaluation)

Plate ST44-2

Vc = 180 m/min
ap = 3 mm
fz = 0.14 mm/t dry
MEV22-S20-06-3T (ø22-3 Inserts)
TOMT060508ER-GM PR1525



Number of parts produced

MEV 160 pcs/edge x2.4

Comp. F 65 pcs/edge

The MEV achieved 2.4 times longer tool life than competitor F.
Quieter machining with excellent surface finish

(User evaluation)

Applicable inserts

Classification of usage			PR1525	PR1535	CA6535
	P	Carbon steel • Alloy steel	★	☆	
	P	Mold steel	★	☆	
	M	Austenitic stainless steel	☆	★	
	M	Martensitic stainless steel		☆	★
	M	Precipitation hardened stainless steel		★	
	K	Gray cast iron	☆		
	K	Nodular cast iron	☆		
	N	Non-ferrous material			
	S	Heat resistant alloy		☆	★
	S	Titanium alloy		★	
	H	Hard materials	□		

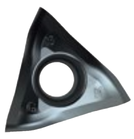
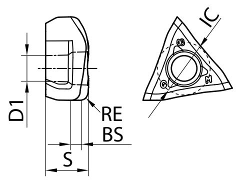
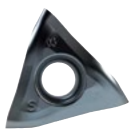
★ : Roughing / 1st choice

☆ : Roughing / 2nd choice

■ : Finishing / 1st choice

□ : Finishing / 2nd choice

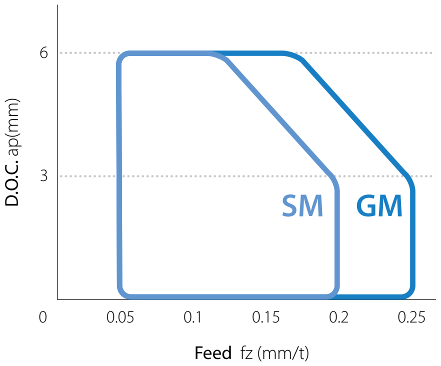
In case hardness is under 45 HRC

Insert		Description	Dimensions (mm)					MEGACOAT NANO		CVD Coating
			IC	S	D1	BS	RE	PR1525	PR1535	CA6535
 General purpose		TOMT 060508ER-GM	7.2	5.7	3.4	1.5	0.8	●	●	●
 Low cutting force		TOMT 060508ER-SM	7.2	5.7	3.4	1.5	0.8	●	●	●

● : Available

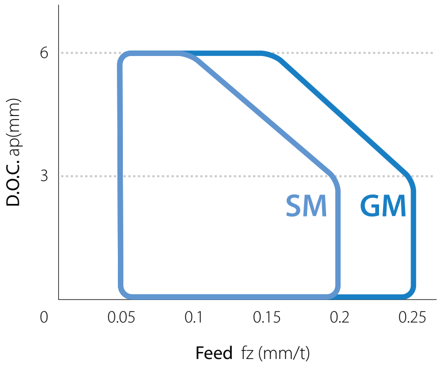
Recommended chipbreaker range

Shouldering



Cutting conditions: Vc = 150 m/min, ae = DC/2 mm, workpiece: C50

Slotting



Cutting conditions: Vc = 150 m/min, ae = DC mm, workpiece: C50

Recommended cutting conditions ★ : 1st recommendation ☆ : 2nd recommendation

Chipbreaker	Workpiece	Feed (fz: mm/t)	Recommended insert grade (Cutting speed Vc: m/min)		
			MEGACOAT NANO		CVD coating
			PR1535	PR1525	CA6535
GM	Carbon steel	0.08 – **0.15** – 0.25	☆ 120 – **180** – 250	★ 120 – **180** – 250	—
	Alloy steel	0.08 – **0.15** – 0.2	☆ 100 – **160** – 220	★ 100 – **160** – 220	—
	Mold steel	0.08 – **0.12** – 0.2	☆ 80 – **140** – 180	★ 80 – **140** – 180	—
	Austenitic stainless steel	0.08 – **0.12** – 0.15	☆ 100 – **160** – 200	☆ 100 – **160** – 200	—
	Martensitic stainless steel	0.08 – **0.12** – 0.2	☆ 150 – **200** – 250	—	★ 180 – **240** – 300
	Precipitation hardened stainless steel	0.08 – **0.12** – 0.2	★ 90 – **120** – 150	—	—
	Gray cast iron	0.08 – **0.18** – 0.25	—	☆ 120 – **180** – 250	—
	Nodular cast iron	0.08 – **0.15** – 0.2	—	☆ 100 – **150** – 200	—
	Ni-base heat-resistant alloy	0.08 – **0.12** – 0.15	☆ 20 – **30** – 50	—	★ 20 – **30** – 50
	Titanium alloy	0.08 – **0.15** – 0.2	☆ 40 – **60** – 80	—	—
SM	Carbon steel	0.08 – **0.15** – 0.2	☆ 120 – **180** – 250	★ 120 – **180** – 250	—
	Alloy steel	0.08 – **0.12** – 0.18	☆ 100 – **160** – 220	★ 100 – **160** – 220	—
	Mold steel	0.08 – **0.1** – 0.15	☆ 80 – **140** – 180	★ 80 – **140** – 180	—
	Austenitic stainless steel	0.08 – **0.1** – 0.15	★ 100 – **160** – 200	☆ 100 – **160** – 200	—
	Martensitic stainless steel	0.08 – **0.1** – 0.15	☆ 150 – **200** – 250	—	★ 180 – **240** – 300
	Precipitation hardened stainless steel	0.08 – **0.1** – 0.15	☆ 90 – **120** – 150	—	—
	Ni-base heat-resistant alloy	0.08 – **0.1** – 0.12	☆ 20 – **30** – 50	—	★ 20 – **30** – 50
	Titanium alloy	0.08 – **0.12** – 0.15	★ 40 – **60** – 80	—	—

The number in **bold font** is recommended starting conditions. Adjust the cutting speed and the feed rate within the above conditions according to the actual machining situation.
Cutting with coolant is recommended for ni-base heat resistant alloy and titanium alloy.
Cutting with coolant is recommended to get good finished surface.

Ramping reference data

Description	Cutter dia. DC (mm)	20	22	25	28	30	32	40	50
MEV… -06- …	Max. ramping angle RMPX (°)	1.00	0.80	0.65	0.60	0.55	0.50	0.40	0.30
	tan RMPX	0.017	0.014	0.011	0.010	0.010	0.009	0.007	0.005

Make ramping angle smaller if chips are too long

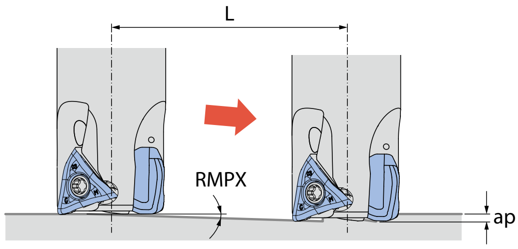
Ramping tips

Ramping angle should be under RMPX (maximum ramping angle) in the above cutting conditions

Reduce recommended feed rate in cutting conditions less than 70%

Formula for max. cutting Length (L) at max. ramping angle

$$L = \frac{ap}{\tan RMPX}$$

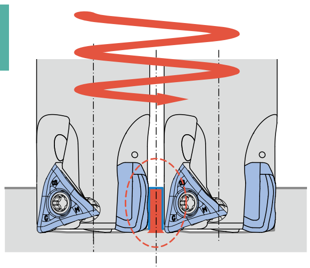


Helical milling tips

For helical milling, use between min. drilling dia. and max. drilling dia.

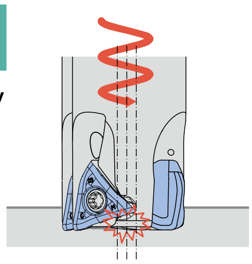
Exceeding max. cutting dia.

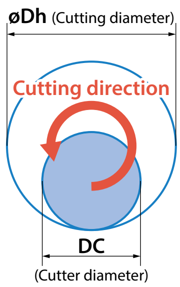
Center core remains after machining



Under min. cutting dia.

Center core hits holder body





Unit: mm

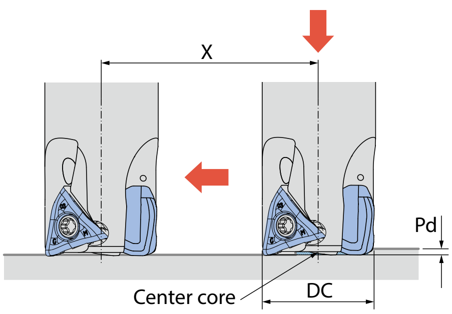
Description	Min. cutting dia.	Max. cutting dia.
MEV… -06- …	2×DC−5	2×DC−2

For helical milling, use between min. cutting diameter and max. cutting diameter

Keep machine depth per rotation less than max. ap (APMX) in the cutter dimensions chart

Use caution to eliminate incidences caused by producing long chips

Peck milling



Unit: mm

Description	Max. Pd cutting depth	Min. Cutting length x for flat bottom surface
MEV… -06- …	0.25	DC−3

It is recommended to reduce feed by 25% of recommendation until the center core is removed when traversing after drilling

Axial feed rate recommendation per revolution is f < 0.1mm/rev

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MFWN

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- Resistant to chattering and applicable to long overhang
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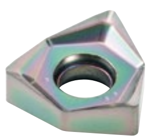
DLC coated insert grade
for aluminum machining



New grade PDL025

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The information contained in this brochure is current as of November 2019.

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