

iMX-PROMOTION

EXCHANGEABLE HEAD END MILL SERIES



**BUY ONE IMX HEAD
AND GET A FREE
STEEL SHANK**

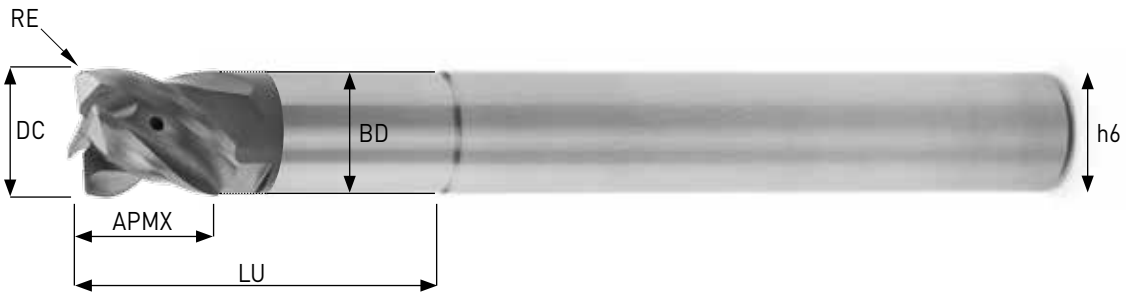
*Until stocks last!



**UP TO 60%
PRICE ADVANTAGE***

*based on List-Prices.





			DC	APMX	LU	BD	RE
SQUARE	 <p>iMX-S4HV-S Square head, 4 flute, irregular helix flutes with through coolant holes. Highest productivity due to efficient chip evacuation. High process security due to smooth and stable cutting action.</p>		10	10.5	2.5 x DC	9.7	-
			12	12.5	2.5 x DC	11.7	-
			16	16.5	2.5 x DC	15.5	-
			20	21	2.5 x DC	19.5	-
RADIUS	 <p>iMX-C4HV-S Corner radius head, 4 flute, irregular helix flutes with through coolant holes. Special design to reduce the cutting forces. High reliability even in unstable applications.</p>		10	10.5	2.5 x DC	9.7	1
			12	12.5	2.5 x DC	11.7	1
			16	16.5	2.5 x DC	15.5	1
			20	21	2.5 x DC	19.5	1
ROUGHING	 <p>iMX-R4F Roughing type head, 4 flute. Special cutting edge geometry reduce cutting forces. High reliability even in unstable applications.</p>		10	10.5	2.5 x DC	9.7	-
			12	12.5	2.5 x DC	11.7	-
			16	16.5	2.5 x DC	15.5	-
			20	21	2.5 x DC	19.5	-
BALL	 <p>iMX-B4HV-E Ball nose head, 4 flute, irregular helix flutes with through coolant hole. Effective chip evacuation through special cutting geometry and coolant holes, enables best surface qualities.</p>		10	10.5	2.5 x DC	9.7	5
			12	12.5	2.5 x DC	11.7	6
			16	16.5	2.5 x DC	15.5	8
			20	21	2.5 x DC	19.5	10
ALU SQUARE	 <p>iMX-S3A Square head, 3 flute, for aluminium alloys. Highest process reliability due to polished rake surfaces and extremely sharp cutting edges. Large chip pocket for efficient chip evacuation. Ideal for slotting and plunging.</p>		10	8.5	2.5 x DC	9.7	-
			12	10.1	>2.5 x DC	9.7	-
			12	10.1	2.5 x DC	11.7	-
			14	11.7	>2.5 x DC	11.7	-
			16	13.3	2.5 x DC	15.5	-
			18	14.9	>2.5 x DC	15.5	-
			20	17	2.5 x DC	19.5	-
			22	18.6	>2.5 x DC	19.5	-

 Roughing

 Finishing

iMX-PROMOTION

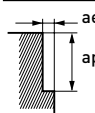

1. SELECT HEAD TYPE

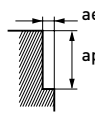

2. RECEIVE A FREE STEEL SHANK

KIT ORDER NUMBER	1. HEAD	2. STEEL SHANK FREE OF CHARGE	PROMOTIONAL PRICE	REGULAR KIT LIST-PRICE (HEAD+SHANK)
PR-IMX10S4HV10010S	1x IMX10S4HV10010S	1x IMX10-U10N009L070S	75,00 €	189,60 €
PR-IMX12S4HV12012S	1x IMX12S4HV12012S	1x IMX12-U12N011L080S	89,00 €	225,00 €
PR-IMX16S4HV16016S	1x IMX16S4HV16016S	1x IMX16-U16N016L080S	119,00 €	296,00 €
PR-IMX20S4HV20021S	1x IMX20S4HV20021S	1x IMX20-U20N020L090S	140,00 €	352,00 €
PR-IMX10C4HV10010S	1x IMX10C4HV100R10010S	1x IMX10-U10N009L070S	75,00 €	186,30 €
PR-IMX12C4HV12012S	1x IMX12C4HV120R10012S	1x IMX12-U12N011L080S	89,00 €	222,00 €
PR-IMX16C4HV16016S	1x IMX16C4HV160R10016S	1x IMX16-U16N016L080S	115,00 €	284,00 €
PR-IMX20C4HV20021S	1x IMX20C4HV200R10021S	1x IMX20-U20N020L090S	135,00 €	344,00 €
PR-IMX10R4F10010	1x IMX10R4F10010	1x IMX10-U10N009L070S	70,00 €	182,60 €
PR-IMX12R4F12012	1x IMX12R4F12012	1x IMX12-U12N011L080S	85,00 €	216,30 €
PR-IMX16R4F16016	1x IMX16R4F16016	1x IMX16-U16N016L080S	115,00 €	282,00 €
PR-IMX20R4F20021	1x IMX20R4F20021	1x IMX20-U20N020L090S	140,00 €	353,00 €
PR-IMX10B4HV10010E	1x IMX10B4HV10010E	1x IMX10-U10N009L070S	90,00 €	218,00 €
PR-IMX12B4HV12012E	1x IMX12B4HV12012E	1x IMX12-U12N011L080S	110,00 €	262,00 €
PR-IMX16B4HV16016E	1x IMX16B4HV16016E	1x IMX16-U16N016L080S	140,00 €	336,00 €
PR-IMX20B4HV20021E	1x IMX20B4HV20021E	1x IMX20-U20N020L090S	170,00 €	419,00 €
PR-IMX10S3A10008	1x IMX10S3A10008	1x IMX10-U10N009L070S	65,00 €	166,50 €
PR-IMX10S3A12010	1x IMX10S3A12010	1x IMX10-U10N009L070S	75,00 €	196,40 €
PR-IMX12S3A12010	1x IMX12S3A12010	1x IMX12-U12N011L080S	72,00 €	195,90 €
PR-IMX12S3A14011	1x IMX12S3A14011	1x IMX12-U12N011L080S	89,00 €	225,00 €
PR-IMX16S3A16013	1x IMX16S3A16013	1x IMX16-U16N016L080S	95,00 €	249,00 €
PR-IMX16S3A18014	1x IMX16S3A18014	1x IMX16-U16N016L080S	110,00 €	270,00 €
PR-IMX20S3A20017	1x IMX20S3A20017	1x IMX20-U20N020L090S	120,00 €	297,00 €
PR-IMX20S3A22018	1x IMX20S3A22018	1x IMX20-U20N020L090S	140,00 €	351,00 €

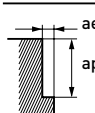

RECOMMENDED CUTTING CONDITIONS

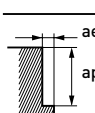

iMX-S4HV-S / iMX-C4HV-S

Material	Carbon steel, Alloy steel, Mild Steel, Copper, Copper alloys						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel						Austenitic and Ferritic stainless steel, Precipitation hardening stainless steel, Titanium alloy						
	DC	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae
	10	150	4800	0.09	1700	10	2	120	3800	0.06	910	10	2	100	3200	0.075	960	10	2
	12	150	4000	0.09	1400	12	2.4	120	3200	0.065	830	12	2.4	100	2700	0.08	860	12	2.4
	16	150	3000	0.1	1200	16	3.2	120	2400	0.075	720	16	3.2	100	2000	0.09	720	16	3.2
	20	150	2400	0.1	960	20	4	120	1900	0.075	570	20	4	100	1600	0.09	580	20	4
	10	100	3200	0.04	510	5		80	2500	0.03	300	5		75	2400	0.03	290	5	
	12	100	2700	0.05	540	6		80	2100	0.04	340	6		75	2000	0.04	320	6	
	16	100	2000	0.07	560	8		80	1600	0.05	320	8		75	1500	0.06	360	8	
	20	100	1600	0.07	450	10		80	1300	0.05	260	10		75	1200	0.06	290	10	

Material	Precipitation hardening stainless steel, Cobalt chromium alloy						Heat resistant alloys						
	DC	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae
	10	75	2400	0.06	580	10	2	40	1300	0.04	210	10	1
	12	75	2000	0.065	520	12	2.4	40	1100	0.045	200	12	1.2
	16	75	1500	0.075	450	16	3.2	40	800	0.05	160	16	1.6
	20	75	1200	0.075	360	20	4	40	640	0.05	130	20	2
	10	60	1900	0.025	190	5		30	950	0.02	76	2	
	12	60	1600	0.035	220	6		30	800	0.03	96	2.4	
	16	60	1200	0.05	240	8		30	600	0.05	120	3.2	
	20	60	950	0.05	190	10		30	480	0.05	96	4	

iMX-R4F

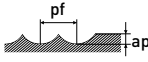
Material	Carbon steel, Alloy steel, Mild Steel, Copper, Copper alloys						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel						Austenitic and Ferritic stainless steel, Precipitation hardening stainless steel, Titanium alloy						
	DC	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae
	10	150	4800	0.045	860	8	4	120	3800	0.03	460	8	4	100	3200	0.038	480	8	4
	12	150	4000	0.045	720	9.6	4.8	120	3200	0.033	420	9.6	4.8	100	2700	0.04	430	9.6	4.8
	16	150	3000	0.05	600	12.8	6.4	120	2400	0.038	360	12.8	6.4	100	2000	0.045	360	12.8	6.4
	20	150	2400	0.05	480	16	8	120	1900	0.038	290	16	8	100	1600	0.045	290	16	8
	10	100	3200	0.04	510	5		80	2500	0.03	300	5		60	1900	0.02	150	4	
	12	100	2700	0.045	490	6		80	2100	0.032	270	6		60	1600	0.025	160	4.8	
	16	100	2000	0.05	400	8		80	1600	0.038	240	8		60	1200	0.03	140	6.4	
	20	100	1600	0.05	320	10		80	1300	0.038	200	10		60	950	0.034	130	8	

Material	Precipitation hardening stainless steel, Cobalt chromium alloy						Heat resistant alloys						
	DC	Vc	n	fz	Vf	ap	ae	Vc	n	fz	Vf	ap	ae
	10	75	2400	0.03	290	8	4	40	1300	0.04	210	8	1
	12	75	2000	0.033	260	9.6	4.8	40	1100	0.045	200	9.6	1.2
	16	75	1500	0.038	230	12.8	6.4	40	800	0.05	160	12.8	1.6
	20	75	1200	0.038	180	16	8	40	640	0.05	130	16	2
	10	40	1300	0.016	83	4							
	12	40	1100	0.02	88	4.8							
	16	40	800	0.024	77	6.4							
	20	40	640	0.027	70	8							

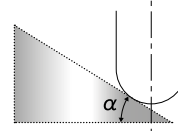
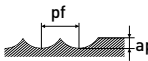
RECOMMENDED CUTTING CONDITIONS

iMX-B4HV-E

Material		Carbon steel, Alloy steel, Mild Steel, Pre-hardened steel, Copper, Copper alloys								Austenitic and Ferritic stainless steel, Precipitation hardening stainless steel, Cobalt chromium alloy, Titanium alloy											
		$\alpha < 15^\circ$				$\alpha > 15^\circ$						$\alpha < 15^\circ$				$\alpha > 15^\circ$					
DC	RE	Vc	n	fz	Vf	Vc	n	fz	Vf	ap	pf	Vc	n	fz	Vf	Vc	n	fz	Vf	ap	pf
10	5	300	9600	0.106	4100	200	6400	0.07	1800	1	2.5	225	7200	0.105	3000	150	4800	0.067	1300	1	2.5
12	6	300	8000	0.125	4000	200	5300	0.085	1800	1.2	3	225	6000	0.125	3000	150	4000	0.08	1300	1.2	3
16	8	300	6000	0.134	3200	200	4000	0.088	1400	1.6	4	225	4500	0.14	2500	150	3000	0.09	1100	1.6	4
20	10	300	4800	0.156	3000	200	3200	0.1	1300	2	5	225	3600	0.16	2300	150	2400	0.105	1000	2	5

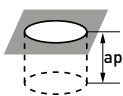
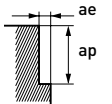


Material		Heat resistant alloys									
		$\alpha < 15^\circ$				$\alpha > 15^\circ$					
DC	RE	Vc	n	fz	Vf	Vc	n	fz	Vf	ap	pf
10	5	60	1900	0.055	420	40	1300	0.035	180	0.5	1
12	6	60	1600	0.055	350	40	1100	0.035	150	0.6	1.2
16	8	60	1200	0.062	300	40	800	0.04	130	0.8	1.6
20	10	60	1000	0.062	250	40	640	0.04	100	1	2



iMX-S3A

Material		Aluminium alloy						
DC		Vc	n	fz	Vf	ap	ae	ap2
10		500	16000	0.117	5600	8	3	
12		500	13000	0.118	4600	9.6	3.6	
16		500	10000	0.153	4600	12.8	4.8	
20		500	8000	0.175	4200	16	6	
22		500	7200	0.190	4100	17.5	6.5	
10		500	16000	0.068	3300	5		
12		500	13000	0.072	2800	6		
16		500	10000	0.093	2800	8		
20		500	8000	0.108	2600	10		
22		500	7200	0.116	2500	11		
10		300	9600	0.1	960	5		2.5
12		300	8000	0.1	800	6		2.5
16		300	6000	0.1	600	8		2.5
20		300	4800	0.1	480	10		2.5
22		300	4300	0.1	430	11		2.5



iMX-PROMOTION

EXCHANGEABLE HEAD END MILL SERIES



Steel Holder



Solid Carbide Holder



MMC HARTMETALL GMBH

Comeniusstr. 2 · 40670 Meerbusch · Germany

Phone +49 2159 91890 · Fax +49 2159 918966

Email admin@mmchg.de

www.mitsubishicarbide.com | www.mmc-hardmetal.com

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