



SUMITOMO

CARBIDE - CBN - DIAMOND

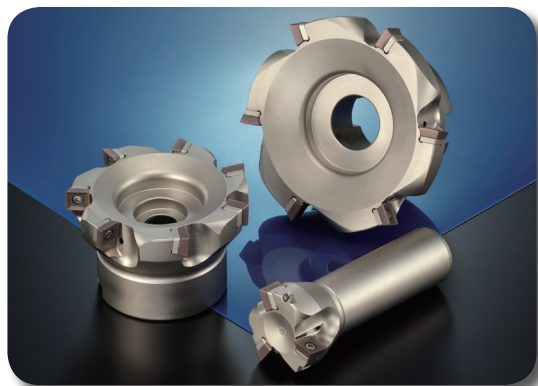
WFX Series



High Performance Milling Systems

**Four-cornered shoulder mill for steel,
stainless steel, and cast iron
machining**





Features & Benefits

WFX WaveMill is a screw-down type cutter capable of using 4-cornered inserts. Ideal cutting edge design offers exceptional squareness.

■ Characteristics

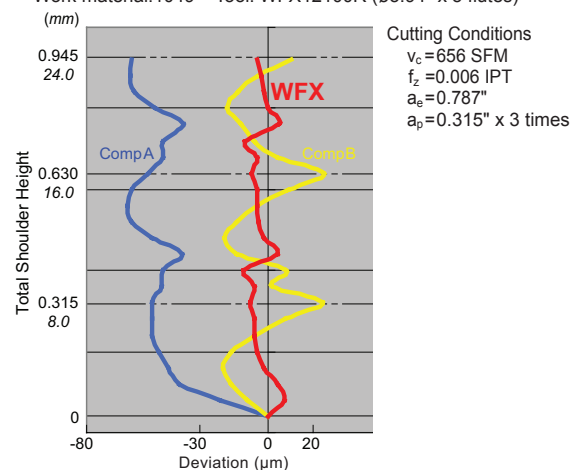
The insert shape is optimized for shoulder milling; when combined with a high-precision body it leaves a superior machined surface finish.

- Maximum depth of cut (a_p) = 0.394" (10.0mm)
- With oil hole = $\varnothing 5"$ or less (125 mm)
- 3 types of chipbreakers

■ Performance

(1) Squareness

Work material: 1049 Tool: WFX12100R ($\varnothing 3.94"$ x 5 flutes)



■ Grades

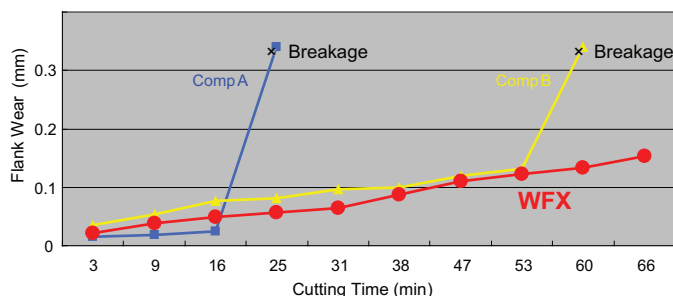
The WFX type is the first series to offer the newly developed multi-layer PVD coating structure on these grades: **ACP200**, **ACP300**, and **ACK300**. With excellent resistance against wear, fracture, and adhesion, the grades achieve 1.5 times longer tool life than conventional coating.



(2) Wear Resistance

Work material: 4140 Tool: WFX12100R ($\varnothing 3.94"$ x 1 flute test)

Cutting Conditions $v_c = 656$ SFM $f_z = 0.006$ IPT $a_e = 1.181"$ $a_p = 0.1969"$



(3) Surface Finish

Work material: 4140

Tool: WFX12100R ($\varnothing 3.94"$ x 5 flutes)

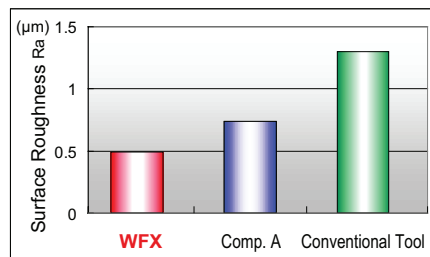
Cutting Conditions

$v_c = 656$ SFM

$f_z = 0.004$ IPT

$a_e = 3.543"$

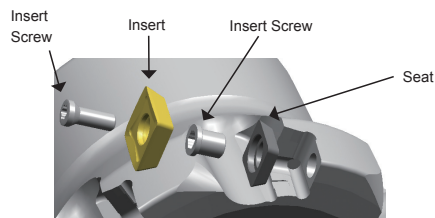
$a_p = 0.118"$



Spare Parts

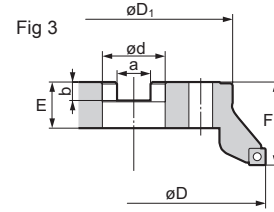
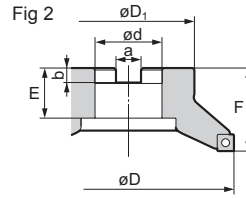
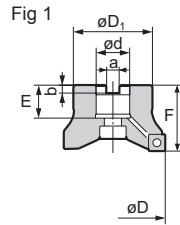
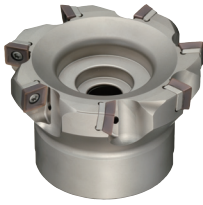
Applicable Cutters	Seat	Seat Screw	Insert Screw	Torque	Wrench (insert)	Wrench (seat)
WFX12040E	-	-	BFTX03512IP	3.0N * m	TRDR15IP	-
Other WFX types	WFXS4R	BW0507F	BFTX03512IP	3.0N * m	TRDR15IP	LH035

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"



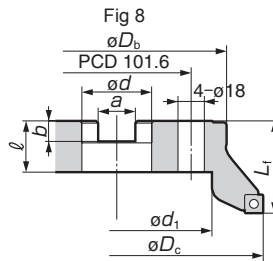
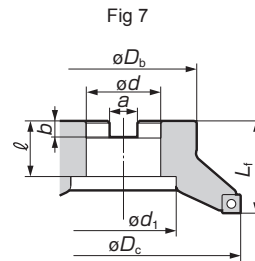
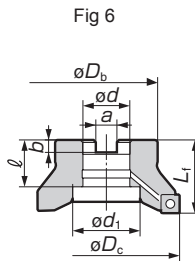
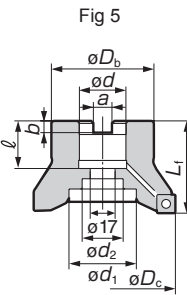
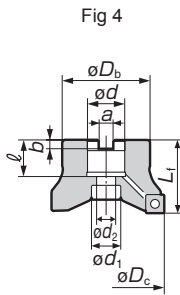
Recommended Cutting Conditions

ISO	Work Material	Rating	Cutting Speed v_c (SFM/m/min) Min.-Optimum-Max	Feed Rate f_z (IPT/mm/t) Min.-Optimum-Max	D.O.C. (In/mm)	Grades
P	General Steel	G	492-656-820 150-200-250	0.004-0.006-0.008 0.10-0.15-0.20	< 0.394 < 10.0	ACP200 ACP300
	Soft Steel	G	591-869-1148 180-265-350	0.004-0.006-0.008 0.10-0.15-0.20	< 0.394 < 10.0	ACP200 ACP300
	Die Steel	S	328-492-656 100-150-200	0.004-0.006-0.008 0.10-0.15-0.20	< 0.236 < 6.0	ACP200 ACP300
M	Stainless Steel	S	525-672-820 160-205-250	0.004-0.006-0.008 0.10-0.15-0.20	< 0.394 < 10.0	ACP300
K	Cast Iron	S	328-574-820 100-175-250	0.004-0.006-0.008 0.10-0.15-0.20	< 0.394 < 10.0	ACK200 ACK300



WFX Cutter Bodies - INCH

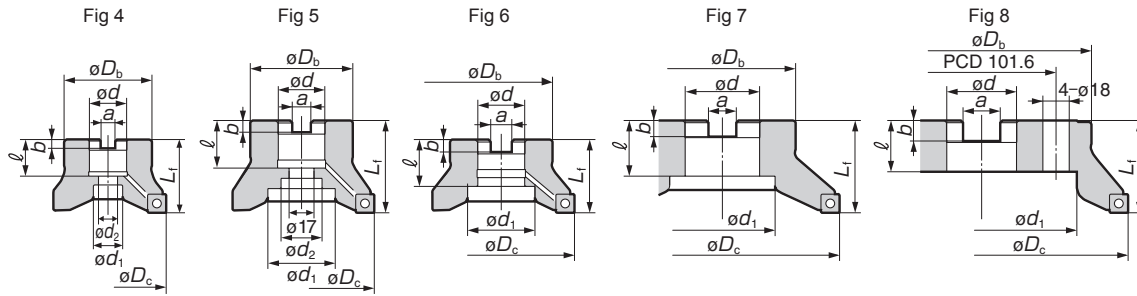
Cat. No.	Stock	Dimensions (inch)							No. of Teeth	Pitch	Fig
		ϕD	ϕD_1	F	ϕd	a	b	E			
WFX42000R	●	2.000	1.500	1.750	0.750	0.312	0.187	0.750	3	Coarse	1
WFX42500R	●	2.500	1.750	1.750	1.000	0.375	0.218	0.750	4		1
WFX43000R	●	3.000	2.250	1.750	1.000	0.375	0.218	0.750	4		1
WFX44000R	●	4.000	2.870	2.000	1.250	0.500	0.280	0.750	5		1
WFX45000R	●	5.000	3.750	2.500	1.500	0.625	0.380	1.000	6		1
WFX46000R	●	6.000	4.380	2.500	1.500	0.625	0.380	1.060	8		2
WFX48000R	●	8.000	5.120	2.500	2.500	1.000	0.560	1.595	10		3
WFXF42000R	●	2.000	1.500	1.750	0.750	0.312	0.187	1.020	4	Fine	1
WFXF42500R	●	2.500	1.750	1.750	1.000	0.375	0.218	1.020	5		1
WFXF43000R	●	3.000	2.250	1.750	1.000	0.375	0.218	1.020	6		1
WFXF44000R	●	4.000	2.870	2.000	1.250	0.500	0.280	1.060	7		1
WFXF45000R	●	5.000	3.750	2.500	1.500	0.625	0.380	1.060	8		1
WFXF46000R	●	6.000	4.380	2.500	1.500	0.625	0.380	1.060	12		2
WFXF48000R	●	8.000	5.120	2.500	2.500	1.000	0.560	1.595	16		3
WFXX42000R	●	2.000	1.500	1.750	0.750	0.312	0.187	1.020	5	Super Fine	1
WFXX42500R	●	2.500	1.750	1.750	1.000	0.375	0.218	1.020	6		1
WFXX43000R	●	3.000	2.250	1.750	1.000	0.375	0.218	1.020	8		1
WFXX44000R	●	4.000	2.870	2.000	1.250	0.500	0.280	1.060	10		1
WFXX45000R	●	5.000	3.750	2.500	1.500	0.625	0.380	1.060	12		1



WFX Cutter Bodies - METRIC (Coarse Pitch)

Cat. No.	Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
		ϕD_c	ϕD_b	Lf	ϕd	a	b	ℓ	ϕd_1	ϕd_2			
WFX 12050RS	★	50	40	40	22	10.4	6.3	20	18	11	3	0.2	4
WFX 12063RS	★	63	50	40	22	10.4	6.3	20	18	11	4	0.4	4
WFX 12080RS	★	80	60	50	27	12.4	7	25	20	13.5	4	0.9	4
WFX 12100RS	★	100	70	50	32	14.4	8.5	32	46	-	5	1.3	6
WFX 12080R	★	80	60	50	25.4	9.5	6	25	20	13	4	0.9	4
WFX 12100R	★	100	70	63	31.75	12.7	8	32.5	46	28	5	1.7	5
WFX 12125R	★	125	80	63	38.1	15.9	10	35.5	55	30	6	2.4	4
WFX 12160R	★	160	100	63	50.8	19	11	38	72	-	8	3.7	7
WFX 12200R	★	200	150	63	47.625	25.4	14	35	130	-	10	6.3	8
WFX 12250R	★	250	190	63	47.625	25.4	14	35	150	-	12	11.0	8

★: Worldwide Warehouse Item



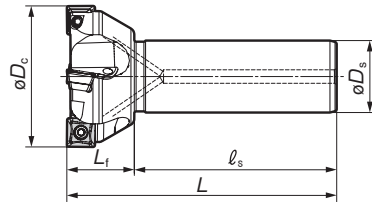
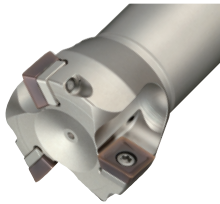
WFXF Cutter Bodies - METRIC (Fine Pitch)

Cat. No.	Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
		ϕD_c	ϕD_b	L_f	ϕd	a	b	ℓ	ϕd_1	ϕd_2			
WFXF 12050RS	★	50	40	40	22	10.4	6.3	20	18	11	4	0.2	1
WFXF 12063RS	★	63	50	40	22	10.4	6.3	20	18	11	5	0.4	1
WFXF 12080RS	★	80	60	50	27	12.4	7	25	20	13.5	6	0.9	1
WFXF 12100RS	★	100	70	50	32	14.4	8.5	32	46	-	7	1.2	3
WFXF 12080R	★	80	60	50	25.4	9.5	6	25	20	13	6	0.9	1
WFXF 12100R	★	100	70	63	31.75	12.7	8	32.5	46	28	7	1.6	2
WFXF 12125R	★	125	80	63	38.1	15.9	10	35.5	55	30	8	2.4	1
WFXF 12160R	★	160	100	63	50.8	19	11	38	72	-	12	3.5	4
WFXF 12200R	★	200	150	63	47.625	25.4	14	35	130	-	16	6.2	5
WFXF 12250R	★	250	190	63	47.625	25.4	14	35	150	-	18	10.9	5

★: Worldwide Warehouse Item

Inserts are not included. * Cutters $\phi 160$ mm or above do not have coolant holes.

Please use JISB1176 "hexagonal bolt" ($\phi 80$: M12 $\times$ 30-35mm, $\phi 100$: M16 $\times$ 40-45mm) for securing the $\phi 80$ or $\phi 100$ cutter to the arbor.



Body (Shank Type)

Cat. No.	Stock	Dimensions (mm)						No. of Teeth
		ϕD_c	ϕD_s	L_f	ℓ_s	L		
WFX 12040E	★	40	32	30	90	120	3	
WFX 12050E	★	50	32	30	90	120	3	
WFX 12063E	★	63	32	30	90	120	4	
WFX 12080E	★	80	32	30	90	120	4	

$\phi 40$ mm cutters do not have a seat.

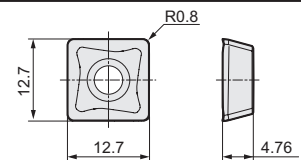
Body (Shank, Fine Pitched Type)

Cat. No.	Stock	Dimensions (mm)						No. of Teeth
		ϕD_c	ϕD_s	L_f	ℓ_s	L		
WFXF 12050E	★	50	32	30	90	120	4	
WFXF 12063E	★	63	32	30	90	120	5	
WFXF 12080E	★	80	32	30	90	120	6	

★: Worldwide Warehouse Item

Inserts

Cat. No.	Coated Carbide					Carbide			Cermet		
	ACP100	ACP200	ACP300	ACK200	ACK300						
SOMT 120408PDER-L	●	●	●	●	●						
SOMT 120408PDER-G	●	●	●	●	●						
SOMT 120408PDER-H	●	●	●	●	●						





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CARBIDE - CBN - DIAMOND

Sumitomo Electric Carbide, Inc.

Headquarters

1001 Business Center Drive
Mount Prospect, IL 60056-2181
P.O. Box 545, Mt. Prospect, IL 60056-0545
Phone: (800) 950-5202
Phone: (847) 635-0044
Fax: (847) 635-7866
<http://www.sumicarbide.com>

Detroit Branch

14496 Sheldon Road #230
Plymouth, MI 48170
Phone: (800) 239-5177
Phone: (734) 451-0200
Fax: (734) 451-5338

Cincinnati Branch

4450 Carver Woods Drive
Cincinnati, OH 45242-5545
Phone: (800) 879-1887
Phone: (513) 891-4000
Fax: (513) 794-2911

Huntsville Branch

5650 Sanderson Street NW
Suite J
Huntsville, AL 35805
Phone: (256) 895-2845
Fax: (256) 895-3150

Torrance Branch

21241 South Western Avenue
Suite 120
Torrance, CA 90501
Phone: (800) 950-5202
Fax: (310) 782-0211

Sumitomo Hardmetal Mexico (SHMM)

Av. Aguascalientes Sur #2625
Fracc. Jardines de las Fuentes
Aguascalientes, AGS Mexico
C.P. 20278
Phone: 011-52-449-993-2740
Fax: 011-52-449-993-2753

