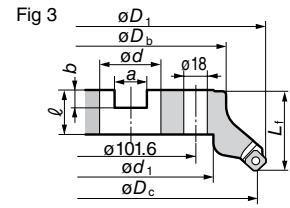
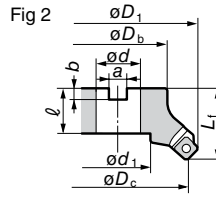
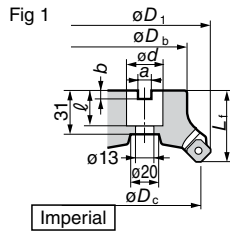
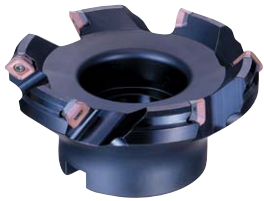


WGC3000/WGC(F)4000 Type

Rake Angle	Radial	-10° to -19° / -20° to -24°	4mm 45°	6mm 45°	<table border="1"> <tr> <td>P</td><td>M</td><td>K</td><td>N</td><td>S</td><td>H</td> </tr> <tr> <td>Steel</td><td>Stainless Steel</td><td>Cast Iron</td><td>Non-Ferrous Metal</td><td>Exotic Alloy</td><td>Hardened Steel</td> </tr> </table>	P	M	K	N	S	H	Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel
	P	M				K	N	S	H								
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel												
Axial	+20° / +20° to 22°	(3000Type) (4000Type)	(3000Type) (4000Type)														

General Milling for Steel, Cast Iron & Exotic Material



Body (WGC 3000 Type)

Cat. No.	Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
		ϕD_c	ϕD_1	ϕD_b	L_1	ϕd	ϕd_1	a	b	ℓ			
WGC 3080R	●	*80	89	60	50	25.4	—	9.5	6	25	6	1.1	1
3100R	●	100	109	70	50	31.75	46	12.7	8	32	7	1.5	2

Inserts are not included.

Body (WGC 4000 Type)

Cat. No.	Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
		ϕD_c	ϕD_1	ϕD_b	L_1	ϕd	ϕd_1	a	b	ℓ			
WGC 4080R	●	*80	93	60	50	25.4	—	9.5	6	25	4	1.0	1
4100R	●	100	113	70	50	31.75	46	12.7	8	32	5	1.5	2
4125R	●	125	138	80	63	38.1	56	15.9	10	38	6	2.6	2
4160R	●	160	173	100	63	50.8	72	19.1	11	38	7	4.0	2
4200R	●	200	213	130	63	47.625	130	25.4	14	35	8	6.6	3

Body (WGC(F) 4000 Type)

Cat. No.	Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
		ϕD_c	ϕD_1	ϕD_b	L_1	ϕd	ϕd_1	a	b	ℓ			
WGC(F) 4080R	●	*80	93	60	50	25.4	—	9.5	6	25	8	1.0	1
4100R	●	100	113	70	50	31.75	46	12.7	8	32	10	1.5	2
4125R	●	125	138	80	63	38.1	56	15.9	10	38	12	2.6	2
4160R	●	160	173	100	63	50.8	72	19.1	11	38	16	4.0	2
4200R	●	200	213	130	63	47.625	130	25.4	14	35	20	6.6	3

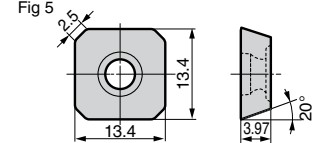
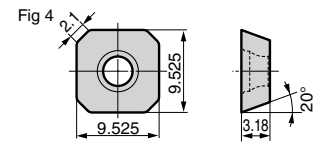


*Please use JIS B1176 hexagonal bolt (M12x30~35mm) for securing $\phi 80/\phi 100$ cutter to the arbour.

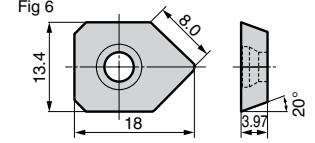
Insert

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

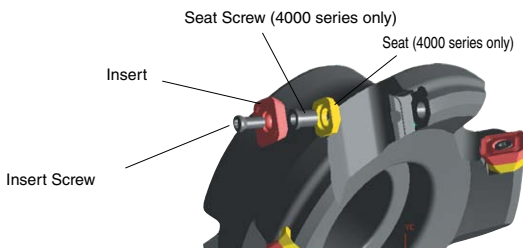
Application	Grade	Coated Carbide		DLC	Carbide	Cermat	SUMIDIA	Fig	Application						
		ACP100	ACP200	ACP300	ACK200	ACK300	DL1000			A30N	EH520	HI	TZ50A	DA1000	DA2200
High Speed/Light	P				N		N								
General Purpose		M	M	K	N	P	S	P							
Roughing		M	M	K	N										
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	DL1000	A30N	EH520	HI	TZ50A	DA1000	DA2200	Fig	Application
SEET 0903AGFN-L	●	●	●	●	●	●	●							4	WGC 3000 Type
0903AGSN-G	●	●	●	●	●	●	●							4	
0903AGSN-N	●	●	●	●	●	●	●							4	
SEMT 0903AGSN-L	●	●	●	●	●	●	●							4	
SEET 13T3AGFN-L	●	●	●	●	●	●	●							5	WGC 4000 Type
13T3AGSN-G	●	●	●	●	●	●	●							5	
13T3AGSN-N	●	●	●	●	●	●	●							5	
SEMT 13T3AGSN-L	●	●	●	●	●	●	●							5	
SEET 13T3AGSN-G	●	●	●	●	●	●	●							5	WGC(F) 4000 Type
13T3AGSN-H	●	●	●	●	●	●	●							5	
NF-SECW 13T3AGTN-N	—	—	—	—	—	—	—	—	—	—	—	●	▲	5	
NF-XEEW 13T3AGFR-W	—	—	—	—	—	—	—	—	—	—	—	●	▲	6	
XEEW 13T3AGER-W	—	—	—	—	—	—	—	—	—	—	—	●	▲	6	



Wiper Insert (Be careful during installation)



Parts



Applicable Cutters	Seat	Seat Screw	Insert Screw	Spanner (For Insert)	Spanner (For Seat)
WGC3000 Type	—	—	BFTX0307IP (N·m 2.0)	TRDR10IP	—
WGC(F)4000 Type	WGCS13R	BW0507F	BFTX03512IP (N·m 3.0)	TRDR15IP	LH035

* SUMI-P anti-seizure cream is included in the package.

(N·m) Recommended Tightening Torque (N·m)

Recommended Cutting Conditions WGC3000 Type

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	150-200-250	0.10-0.15-0.20	ACP200
	Soft Steel	≤180HB	180-265-350	0.10-0.18-0.25	ACP200
	Die Steel	200 to 220HB	100-150-200	0.15-0.18-0.20	ACP200
M	Stainless Steel	—	160-205-250	0.15-0.18-0.20	ACP300
K	Cast Iron	250HB	100-175-250	0.15-0.18-0.20	ACK200
N	Non-Ferrous Alloy	—	500-750-1000	0.15-0.23-0.30	DL1000

Recommended Cutting Conditions WGC(F)4000 Type

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	150-200-250	0.10-0.20-0.30	ACP200
	Soft Steel	≤180HB	180-265-350	0.10-0.25-0.40	ACP200
	Die Steel	200 to 220HB	100-150-200	0.15-0.20-0.25	ACP200
M	Stainless Steel	—	160-205-250	0.15-0.23-0.30	ACP300
K	Cast Iron	250HB	100-175-250	0.15-0.23-0.30	ACK200
N	Non-Ferrous Alloy	—	500-750-1000	0.15-0.23-0.30	DL1000

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.