MITSUBISHI MATERIALS

C009B

CUTTING TOOLS 2020 - 2021

TURNING TOOLS
MILLING TOOLS
DRILLING TOOLS

DIAEDGE

MITSUBISHI MATERIALS

For People, Society and the Earth

We will become the leading business group
committed to creating a sustainable world
through materials innovation, with use of our unique
and distinctive technologies, for People, Society and the Earth.

STATEMENT

YOUR GLOBAL CRAFTSMAN STUDIO

Mitsubishi Materials is not just a tool manufacturer

We are committed to responding promptly to customers' challenges and to actively contribute to their success with the dedication of a professional craftsman.

We will strive to become the only tool manufacturer globally offering "your personal craftsman studio", a unique service for our customers.

It is the place where you can:
Find state-of-the-art technologies and products.
Find solutions, anytime, from anywhere in the world.
Share our excitement about the latest technology trends and product innovation.

It is the studio where we think, share, create and develop together with our customers, exciting solutions to meet their specific needs.

YOUR GLOBAL CRAFTSMAN STUDIO
MITSUBISHI MATERIALS

The meaning of our logo
Our logo shows people, standing on a circle, holding hands. The circle represents the earth. Holding hands reflect our commitment to grow and succeed "hand in hand" with our customers and closely work with them to improve performance across the globe. The shape of the logo embodies a variety of ideas. It captures the image of "cutting tools" combined with the dominant letter "M" of the Mitsubishi Materials brand name. It also depicts a flame that symbolises our passion for craftsmanship.

Now available!

A magazine for communication to
encourage excitement about manufacturing

YOUR GLOBAL CRAFTSMAN STUDIO

Access the MMC Magazine here
http://www.carbide.mht.co.th/magazine

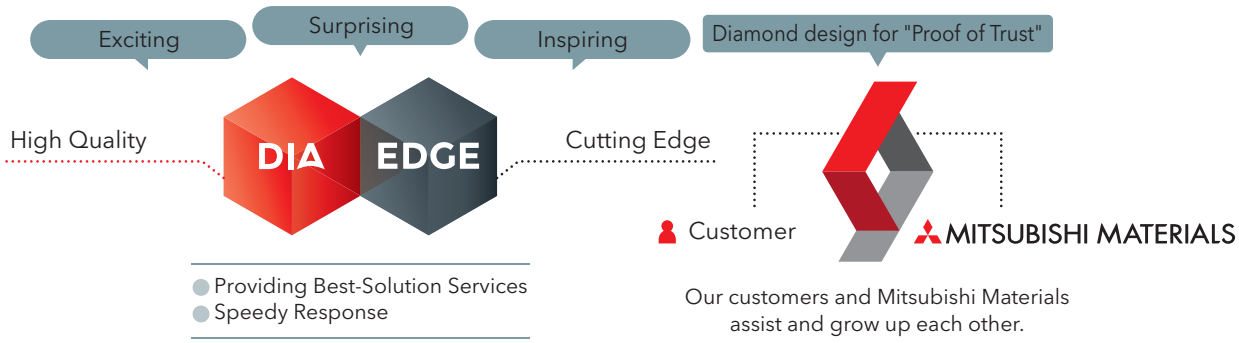
PRODUCT BRAND

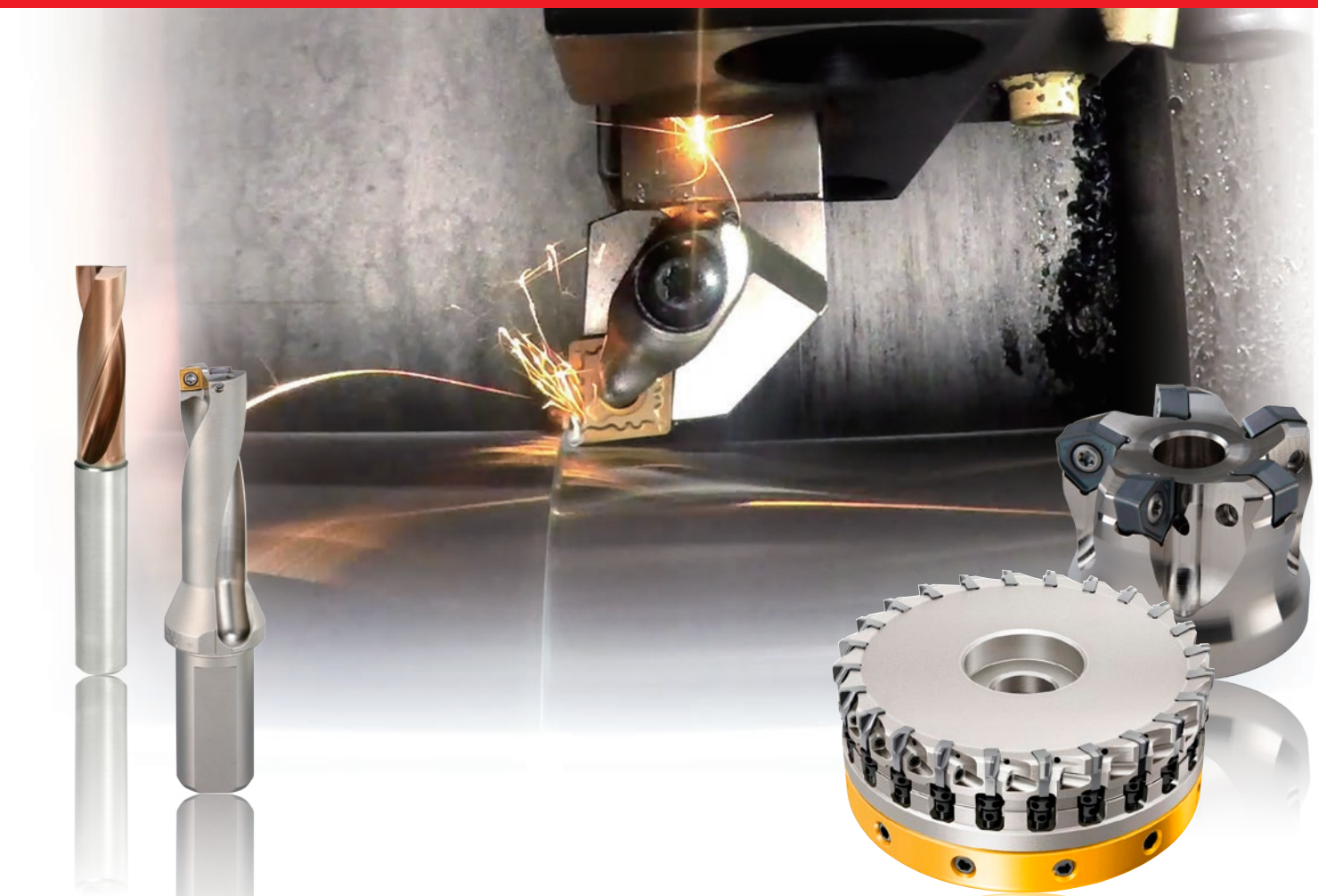
With "DIAEDGE," Mitsubishi Materials Metalworking Solutions Company will aim to become the leading company in carbide product business while sharing ideas, creations and feelings with customers through the provision of optimised carbide product solutions and services.

DIAEDGE

Together with our customers, creating a better future

Announcing DIAEDGE, our new brand of tools
that brings together our cutting-edge technologies, exciting all who use them.
Our aim is not only to offer value with our tools,
but to think together with our customers, share inspiration with them,
and continue to take on new challenges.





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Cutting Tools Catalogue PR3

Tool Solutions

We propose tools for the requirements of best quality and productivity improvement.

TURNING TOOLS-1(Insert Grade) PR4
TURNING TOOLS-2(Insert Breaker, Grooving, Cutting Off) PR6
INDEXABLE MILLING PR7
SOLID END MILLS PR8
DRILLING PR9

Industrial Solutions

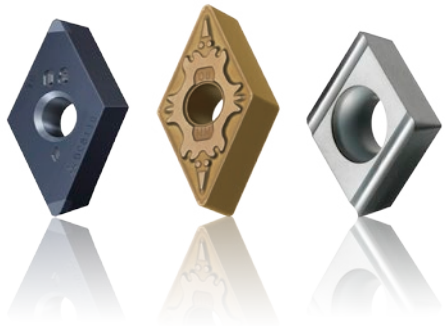
We propose tools for special materials and severe environments of special cutting.

AEROSPACE PR10
AUTOMOTIVE PR12
MEDICAL PR14

Customer Service

We provide the best support for your machining site questions and needs.

CUTTING SOLUTION SERVICE PR16
WEB SERVICE PR18



TURNING TOOLS

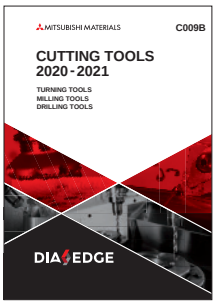
TURNING INSERTS A001
CBN & PCD TURNING INSERTS B001
EXTERNAL TURNING TOOLS C001
SMALL TOOLS D001
BORING BARS E001
GROOVING/CUTTING OFF F001
THREADING G001
HSK-T TOOLS H001
BRAZED TOOLS I001

ROTATING TOOLS

SOLID END MILLS J001
EXCHANGEABLE HEAD END MILLS K001
ROTATING TOOL INSERTS L001
INDEXABLE MILLING M001
TOOLING SYSTEM N001
DRILLING P001

SPARE PARTS Q001

TECHNICAL DATA R001



HOW TO USE THIS CATALOGUE

In this catalogue, our company's cutting tools are broadly divided into two types: turning tools and rotating tools, with separate respective sections for each machining method. Please select the search method that matches your requirements when using the catalogue.

1. **Search for tool types from the INDEX**
2. **To find the series of products from the contents of the inside title.**
   Contents of each block are listed on each inside title.
3. **To find the product according to application.**
   The classification page of each block provides the series of products to be selected according to applications and purposes.
4. **Search using the alphabetical index.**
   All tools are listed in the alphabetical index at the front of the catalogue.
5. **How to use the block sections.**
   A usage guide for each block is shown on the left of each index (not for all blocks). Refer to this page to know how to read the product information and how the page is organised.

OTHER WAYS TO USE THE CATALOGUE

The following PR materials are also available in addition to this catalogue, for use as necessary.

1. **Catalogues for individual products**
   - Access the following URL and download "Tool News" for the applicable cutting tool.
     Information about tool features and examples of cutting applications are available in greater detail.
     http://www.carbide.mht.co.th/download/tools_news
2. **Online catalogue (electronic catalogue with search functions)**
   - Access the following URL to search for applicable cutting tools and view detailed information.
     CAD data, tooling sheets, and other resources are also available for download.
     http://www.mitsubishicarbide.net/mht/enuk/

Tool Solutions

TURNING TOOLS

MC6000 Series

» A011
» A016
» A017
» A034

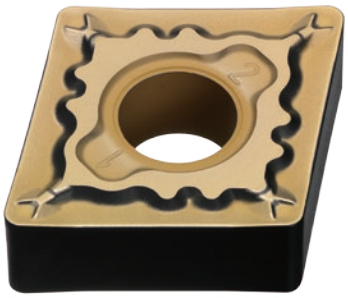
ISO Insert Series
for Steel Turning

P

TOOL NEWS

Pushing the boundaries of steel turning.

MC6015
MC6025
MC6035
+ FP/LP
MP/RP



MC5000 Series

» A013
» A019

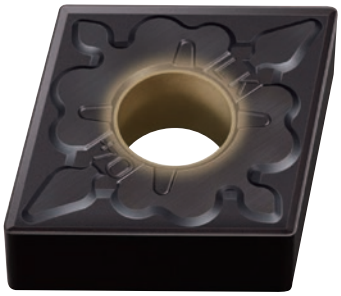
ISO Insert Series
for Cast Iron Turning

K

TOOL NEWS

Reduced cycle times.

MC5005
MC5015
+ LK
MK
RK



MC7000 Series
MP7000 Series

» A012
» A018

ISO Insert Series
for Stainless Steel Turning

M

TOOL NEWS

A revolution in stainless steel turning.
Excellent resistance to notch wear and with good burr control. Long tool life achieved due to high plastic deformation resistance.

MC7015
MC7025
MP7035
+ LM
MM
RM
GM

MP9000 Series
MT9000 Series

» A014
» A021
» A022
» A036

ISO Turning Inserts
for Difficult-to-cut Materials

S

TOOL NEWS

MP9000 Series

The high Al-rich (Al,Ti)N single layer coating significantly reduces edge fracturing.

MP9005
MP9015
MP9025
MT9005
MT9015
+ FS/LS
MS/RS

MS6015

» D002

PVD Coated Carbide Grade for Carbon Steel Turning **P**

TOOL NEWS

Series continues to evolve. The chip breaker made of the mould makes the finished surface very much improved.

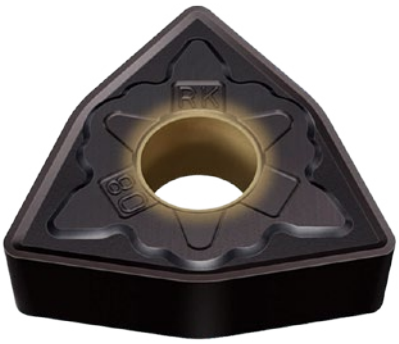
MH515

» A035

CVD Coated Carbide Grade **K**

TOOL NEWS

Improved peeling off resistance for steel casting stainless and ductile cast irons machining.



BC8100/MB8100 Series

» B006
» B010
» B015

CBN-series for Hardened Steel Turning **H**

TOOL NEWS

New generation CBN grades. Wear and fracture resistance greatly improved for a wide range of continuous and interrupted applications.

MB4120

» B012
» B015

CBN Grade for Sintered Alloys and Cast Irons **K**

TOOL NEWS

Excellent fracture resistance and stable cutting improves productivity.

Tool Solutions

TURNING TOOLS

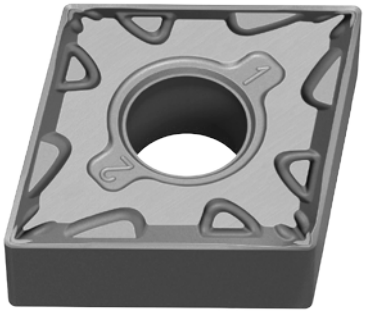
FP Breaker

» A011
» A016
» A017

Finish Cutting Breaker for Carbon Steel and Alloy Steel

TOOL NEWS

Better choice for finish cutting of steels offers good chip control in wide cutting conditions.



FS-P/LS-P Breaker

» A021
» D002

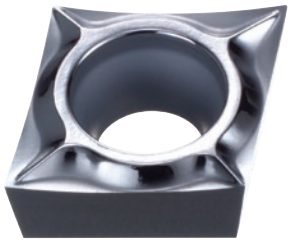
New Breaker System for Front Turning

TOOL NEWS

Polished (mirror-surface) finish of insert surfaces drastically improves welding resistance extending tool life.

FS-P Breaker

For Finish Cutting of Titanium Alloys



LS-P Breaker

For Light Cutting of Titanium Alloys

NEW

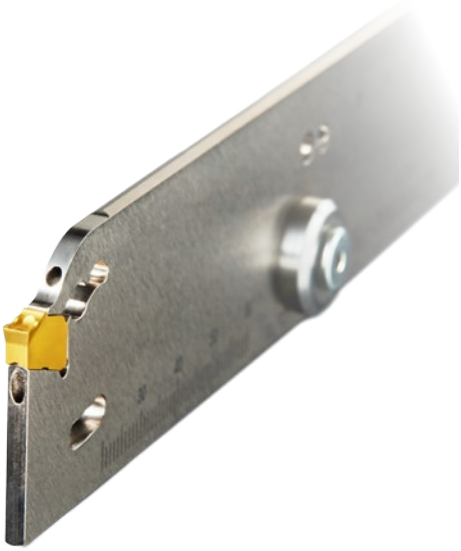
GW series

» F106

Cutting Off & Grooving Holder

TOOL NEWS

Long lasting, easy to use. Cutting off & grooving holder.



GY series

» F004

Grooving & Cutting Off System

TOOL NEWS

Grooving revolution. Innovative clamping system ensures reliable grooving.

Tool Solutions

INDEXABLE MILLING

NEW

WJX series

» M172

Double-sided Insert Type
High Feed Radius Milling Cutter

TOOL NEWS

Improved sharpness and stability to achieve high efficiency machining.

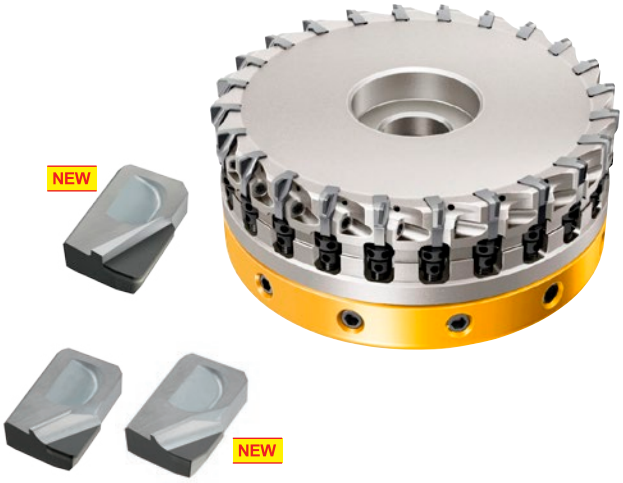
FMAX series

» M066

High Feed Finish Milling
Cutter

TOOL NEWS

Feed Maximum (FMAX) milling cutter for ultra efficient and accurate finishing.



NEW

VPX series

» M110

Multi-functional Cutter
for High Efficiency Machining

TOOL NEWS

Boost your milling with a tough tangential insert !

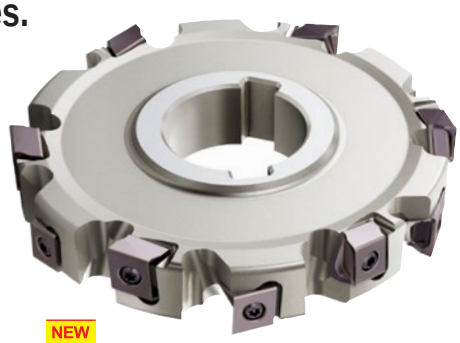
VAS400/500series

» M090

Exchangeable Inserts
Side Cutter

TOOL NEWS

Side cutter with low cutting resistance. Vertical mount double-sided insert for VAS series.



NEW

Strong Cutting Edge Type R Breaker

Low Resistance Type M Breaker

Tool Solutions

SOLID END MILLS

MSplus series

» J034

Carbide End Mills

TOOL NEWS

Tough applications require ‘’Plus” performance.

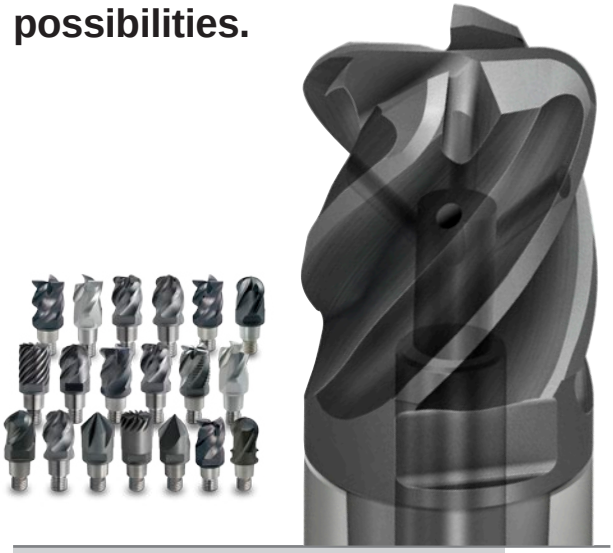
iMX End Mill Series

» K001

Exchangeable Head End Mills

TOOL NEWS

Carbide + Carbide double face contact with head type expands the application possibilities.



SMART MIRACLE Series

» J036

Vibration Control End Mills for Machining Difficult-to-cut Materials

TOOL NEWS

Revolutionary performance for difficult-to-cut materials.

IMPACT MIRACLE REVOLUTION

» J038

For Machining of Hardened Steels

TOOL NEWS

Revolutionary hardened steel. New coating provides amazingly long life.

Tool Solutions

DRILLING

MFE series

» P015

Solid Carbide Flat Bottom Drills

TOOL NEWS

Shorter processes for many types of machining. High efficiency drilling in various types of machining.

MVX series

» P230

Indexable Drill

TOOL NEWS

High rigidity body produced by utilising the latest technology.

MVE/MVS series

» P020

Solid Carbide Drills

TOOL NEWS

Solid carbide drills with TRI-cooling technology.

NEW

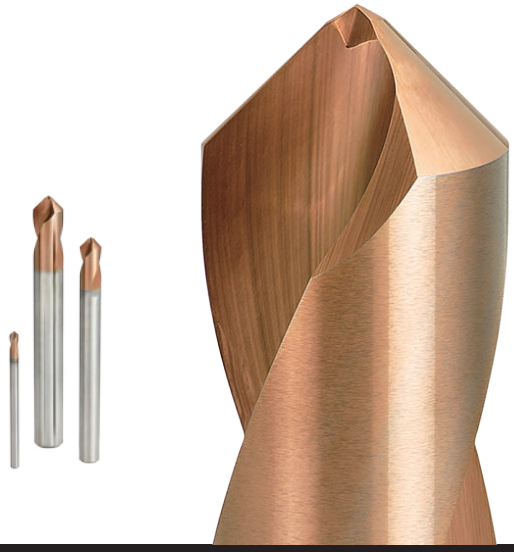
DLE series

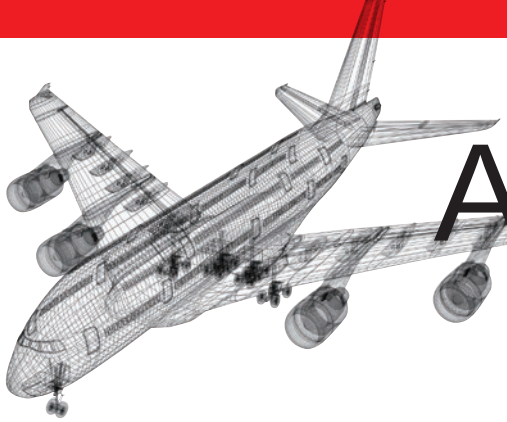
» P012

Solid Carbide Drills for Centreing and Chamfering

TOOL NEWS

Sharpness and excellent fracture resistance can achieve stable processing for stainless steels.





AEROSPACE

We offer latest cutting tools that enable high efficiency machining of difficult-to-cut parts in response to meet the needs of aerospace industry.

http://www.carbide.mht.co.th/solution/industry/aerospace

AIR FRAME CFRP Wing

1 MC Series » P090

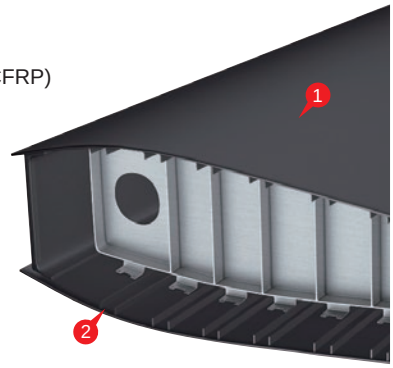
Drill for CFRP Machining

1 MCCH/ MCAH » P094

Hand Tool (Standalone CFRP)

2 DFC End Mill Series » J040

End Mill for CFRP Rough Machining



AIR FRAME Wing Rib

1 AXD » M134

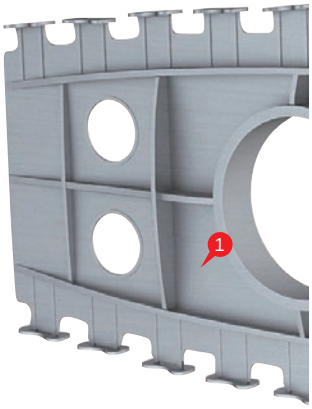
For Machining of Aluminium and Difficult-to-cut Materials

1 iMX » K017 » K046

Exchangeable Head End Mills for Machining of Aluminium Alloys

1 ALIMASTER » J041

High Efficiency Machining for Aluminium Alloys



AIR FRAME Hinge

1 VFX » M220

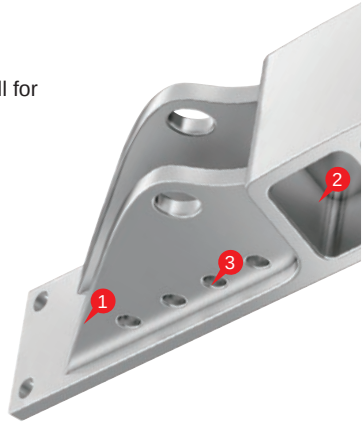
For Titanium Alloy Milling

3 MMS » P057

Solid Carbide Drill for Stainless Steel

2 VPX » M110

Multi-functional Cutter for High Efficiency Machining



AIR FRAME Flap Track

1 AJX » M162

High Feed Radius Milling Cutter

1 CoolStar » J167

Multi-coolant Hole End Mill

1 ARP » M186

Round Insert Cutter for Difficult-to-cut Materials

ENGINE Combustion Casing

❶ **ARP** » M186
Round Insert Cutter for Difficult-to-cut Materials

❷ **VPX** » M110
Multi-functional Cutter for High Efficiency Machining

❸ **Ceramic Corner Radius End Mills** » J338
Ceramic End Mills

ENGINE Blisk

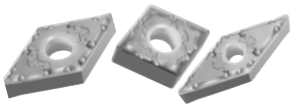
❶ **VQT6UR** » J358
Barrel End Mill for Finish Cutting of Titanium Alloys

❶ **SMART MIRACLE End Mill Series** » J297
Vibration Control End Mills for Machining Difficult-to-cut Materials

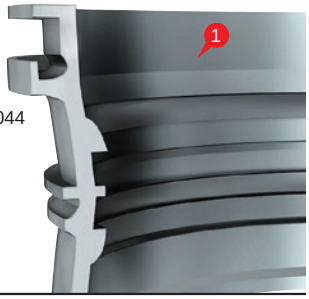
❶ **SMART MIRACLE Vibration Control Ball Nose End Mill** » J270
Vibration Control End Mills for Machining Difficult-to-cut Materials

ENGINE Fan Casing

❶ **JT Holder**
Internal Lubrication Bite Holder

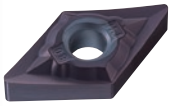


❶ **LS/MS/RS MP/MT9000** » A044
ISO Turning Inserts for Difficult-to-cut Materials



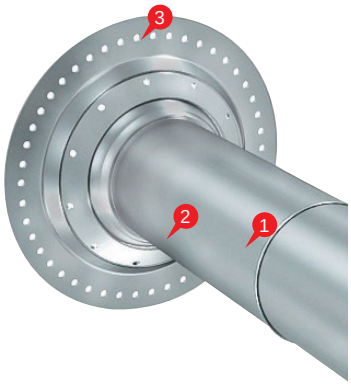
ENGINE Shaft

❶ **HSK-T** » H004
For Turning Mills



❷ **FJ/MS/GJ VP05RT/ VP10RT** » A042
Special Breakers for Difficult-to-cut Materials

❸ **MVS** » P004
Carbide Solid Drill with Oil Hole

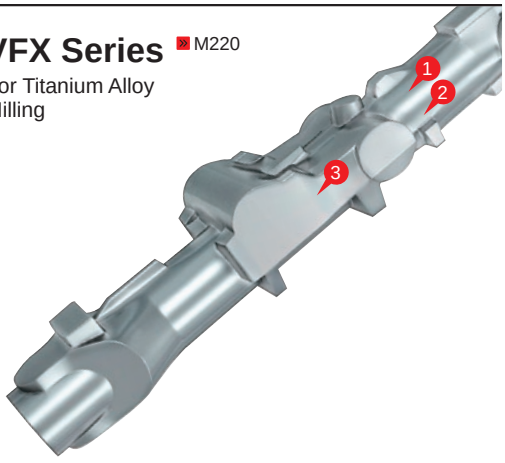


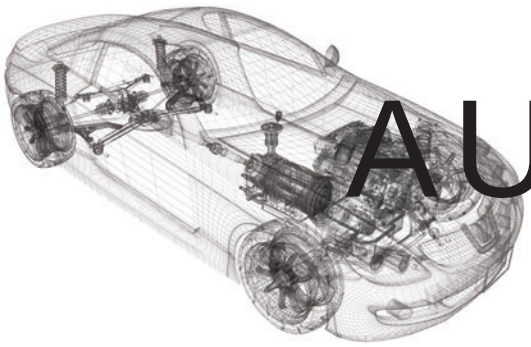
LANDING GEAR Shaft

❶ **MNS** » P076
Solid Carbide Drill for High Efficiency Machining of Aluminium Alloys

❷ **SMART MIRACLE Vibration Control Ball Nose End Mill** » J270
Vibration Control End Mills for Machining Difficult-to-cut Materials

❸ **VFX Series** » M220
For Titanium Alloy Milling





AUTOMOTIVE

We offer high performance cutting tools that use latest technology to meet the needs of the automotive industry.

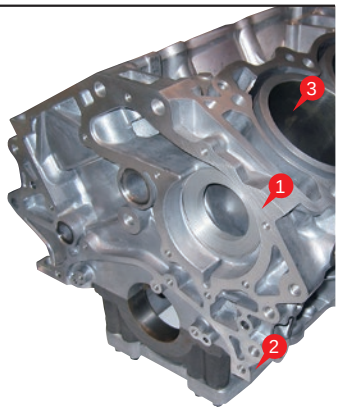
http://www.carbide.mht.co.th/solution/industry/automotive

ENGINE Cylinder Block

1 FMAX » M066
Face Milling Cutter for High Efficiency Finish Cutting of Aluminium Alloys

2 VAS400 / VAS500 » M090
Exchangeable Inserts Side Cutter Series

3 BMR » M260
Boring Cutter

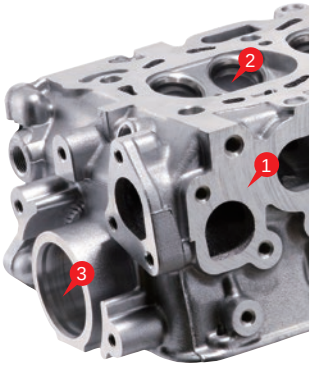


ENGINE Cylinder Head

1 FMAX » M066
Face Milling Cutter for High Efficiency Finish Cutting of Aluminium Alloys

2 HVF » N002
Hydro Clamp Valve Finisher

3 Cam Holes Reamer
High Precision Drilling Reamer with Guide Pad



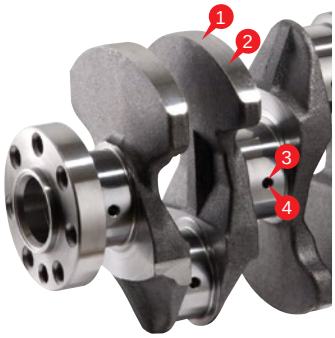
ENGINE Crank Shaft/ Cam Shaft

1 MC6000 Series » A034
ISO Insert Series for Steel Turning

3 MFE » P015
Solid Carbide Flat Bottom Drills

2 MC5000 Series » A034
Insert Series for Machining Ordinary Cast Irons and Ductile Cast Irons

4 MVS Long Drill » P004
Carbide Solid Drill for Deep Drilling



AXLE Steering Knuckle

1 VAS400 / VAS500 » M090
Exchangeable Inserts Side Cutter Series

2 MVS » P004
Carbide Solid Drill with Oil Hole

TRANSMISSION
Transmission Case / Valve Body

1 FMAX » M066
2 Face Milling Cutter for High Efficiency Finish Cutting of Aluminium Alloys

3 MAS » P083
Solid Carbide Drill for High-Efficiency Machining of Aluminium Alloys

4 Straight Flute Drill
Carbide Solid Drill for Precision Machining of Core Holes

TRANSMISSION
Gears / Epicyclic Carriers

1 MC6015 / MC6025 » A034
ISO Insert Series for Steel Turning

2 BC81 Series » B006
Coated CBN-Series for Hardened Steel Turning

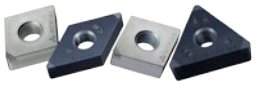
3 Mono Block Helical Broach

4 Hob Cutter

4 Skiving Cutter

TRANSMISSION
Shaft / CVT Pulley

1 MC6015 / MC6025 » A034
ISO Insert Series for Steel Turning



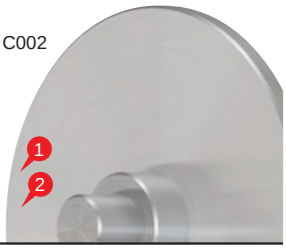
2 BC81 Series » B006
Coated CBN-Series for Hardened Steel Turning

3 GY Series » F004
Tool Holder for Grooving

TURBO CHARGER
Waste Gate Valve

1 MP9000 Series » A036
ISO Turning Inserts for Difficult-to-cut Materials

2 DOUBLE CLAMP HOLDER » C002
One Action High Rigidity General Purpose Tool Holder

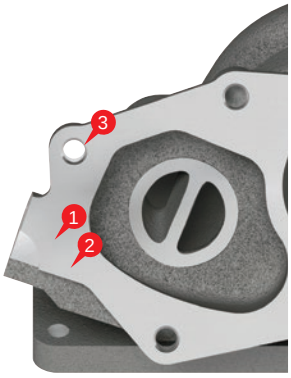


TURBO CHARGER
Turbine Housing

1 MP9000 Series » L008
Insert for Titanium Alloys and Heat Resistant Alloys

2 VPX200 / VPX300 » M110
Multi-functional Cutter for High Efficiency Machining

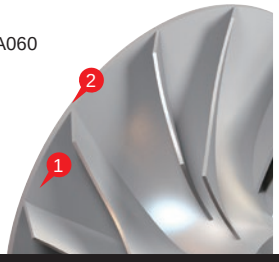
3 MH515 » A035
CVD Coated Carbide Grade



TURBO CHARGER
Compressor Impeller

1 C4LATB » J356
Taper Ball End Mill for Aluminium Impellers

2 AZ Breaker » A060
Breakers for Aluminium Alloy Turning



MEDICAL

We provide cutting tools and total applications most suitable for machining of difficult-to-cut materials used in medical parts.

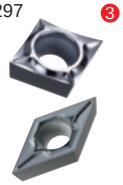
http://www.carbide.mht.co.th/solution/industry/medical

HIP-SYSTEM

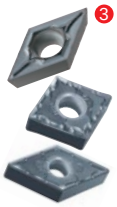
1 **VQMHVRB** » J297
Vibration Control End Mills for Machining Difficult-to-cut Materials

2 **MMS** » P057
Solid Carbide Drill for Stainless Steel

4 **VQ4SVB** » J270
4-Flute Vibration Control Ball End Mill



3 **MT9015** » A039
LS/MS Breaker
Insert for Machining of Titanium Alloy



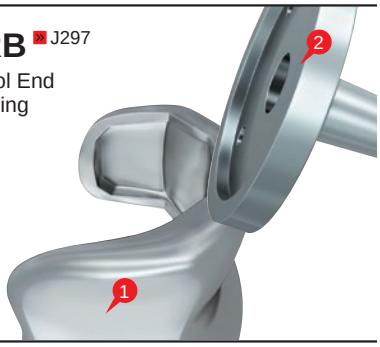
3 **MP9005/ MP9015**
LS/MS Breaker
ISO Turning Inserts for Difficult-to-cut Materials

KNEE-SYSTEM

1 **VQ4SVB** » J270
4-Flute Vibration Control Ball End Mill

2 **iMX-B4HV** » K026
For Difficult-to-cut Materials
Exchangeable Head End Mills

2 **VQMHVRB** » J297
Vibration Control End Mills for Machining Difficult-to-cut Materials



BONE PLATES

1 **VF2WB** » J219
2 Flute IMPACT MIRACLE Wide Ball Nose End Mill

2 **VQ4SVB** » J270
4-Flute Vibration Control Ball End Mill

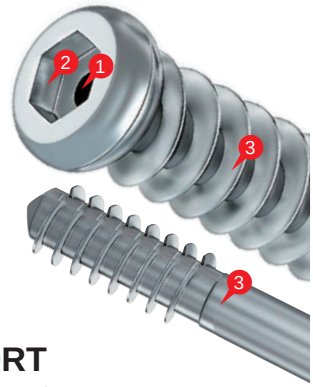
3 **MFE** » P015
Solid Carbide Flat Bottom Drills

SCREWS

1 **MVS Long Drill** » P004
Solid Carbide Drill for Deep Drilling

2 **VQXL** » J160
3-4 Flute Short cut length, Long Neck End Mill

2 **MPXLRB** » J288
2 Flute Corner Radius, Short cut length, Long Neck End Mill

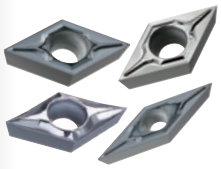


3 **Tools for Small Parts Machining**
VP15TF/VP20RT

Cutting Off » F010 » F014
GY Series for Swiss Style Lathes

Back Turning » D002
SMB Breaker for Back Turning

3 **MP9005/ MP9015/MT9005**
LS/MS/FS-P/LS-P Breaker
ISO Turning Inserts for Difficult-to-cut Materials



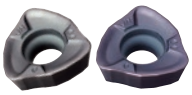
SPINE

1 VQMHV/JHV » J154
Vibration Control End Mills for Machining Difficult-to-cut Materials

2 MVS » P004
Carbide Solid Drill with Oil Hole

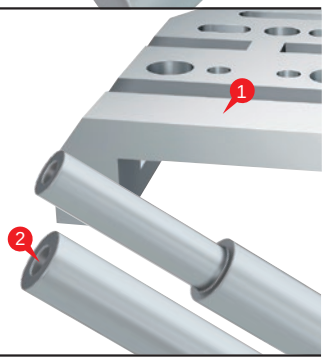
INSTRUMENT

1 AJX » M162
High Feed Radius Milling Cutter



Inserts for Steel Cutting
MP9120/MP9130/MP9140/VP15TF

2 MVS » P004
Carbide Solid Drill with Oil Hole

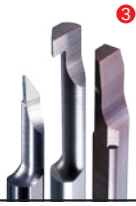


SMALL PARTS

COLLAR/SLEEVE for TURBO CHARGER

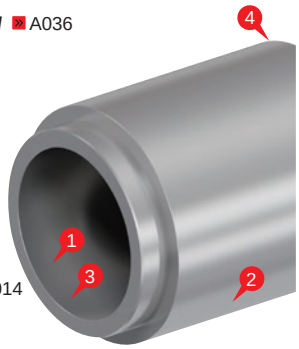
1 MMS » P057
Solid Carbide Drill for Stainless Steel

2 MP9005/MP9015/LS/MS Breaker » A036
ISO Turning Inserts for Difficult-to-cut Materials



3 MICRO-MINI TWIN » E019
Tool for Ultra-small Bore Turning

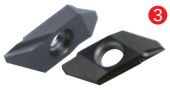
4 GY Series » F014
Grooving Tool Holder for Swiss Style Lathes



TURBINE IMPELLER SHAFT

1 MP9000 Series » A036
ISO Turning Inserts for Difficult-to-cut Materials

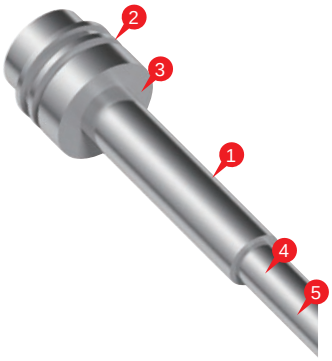
2 GT Series » D016
Tools for External Grooving



3 BTAT » D012
Tools for External Back Turning

4 MMT Series » G002
Threading Tools

5 DLE » P012
Solid Carbide Drills for Centreing and Chamfering



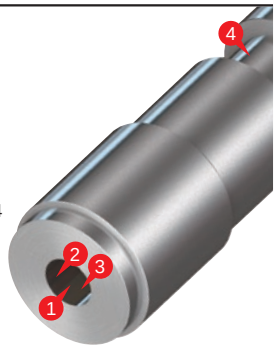
SLEEVE for INJECTOR

1 MMS » P057
Solid Carbide Drill for Stainless Steel

3 MICRO-MINI TWIN » E019
Tool for Ultra-small Bore Turning

2 MFE » P015
Solid Carbide Flat Bottom Drills

4 GY Series » F014
Grooving Tool Holder for Swiss Style Lathes



Customer Service

Cutting Solution Service

Machining Technology Centre

RESPONSIVE, ATTRACTIVE, PROACTIVE

Mitsubishi Materials Corporation, Metalworking Solutions Company, offers a "Comprehensive Craftsman Studio" which addresses the individual needs and requirements of our customers' in order to make their business successful. Here the Machining Technology Centre is the front-line base. It is fully equipped with advanced machines, measuring instruments, extensive cutting data, knowledge, technologies as well as having a team of highly-experienced technical staff members. All of which allows Mitsubishi Materials Corporation to offer the best solution and services for our valued customers.

MTEC Saitama (East Japan Technical Centre)

MTEC Gifu (Central Japan Technical Centre)

MTEC Valencia (SPAIN)

MTEC Stuttgart (GERMANY)

MTEC Querétaro (MEXICO)

MTEC Bangkok (THAILAND)

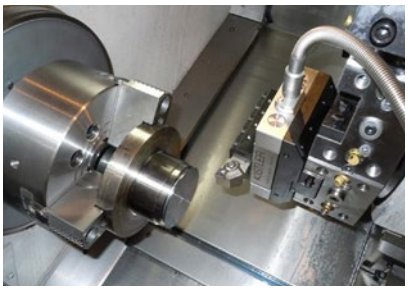
MTEC TianJin (CHINA)

MTEC North Carolina (USA)

We try answering any questions and demands from customers around the world and providing detailed solutions as well as meeting customers' expectations along with a sustainable growth of technical skills and services.

We identify the potential needs of customers and develop innovation tools to cultivate new markets for widening future business possibilities.

Showing and demonstration, Attractive events and practical seminars present the new possibilities in machining which evoke a feeling of curiosity.



1 TRAINING

Practical "Hands-on" training with real demonstration

- **Cutting Academy**
- **e-learning**
- Regional seminar
- Requested Seminar

2 CUTTING TEST

Visualizing your machining

- Test Cutting
- Selection of optimal machining conditions
- Improvements in tool life and machining quality
- Predictive tests before line input
- High-speed camera/ Cutting force/ 3D measuring device etc.

3 TECHNICAL SUPPORT

"RESPONSIVE", with the provision of technical services

- Production line diagnosis/ Process improvement
- Tooling
- Cutting Simulation
- Telephone Technical counseling

http://www.carbide.mht.co.th/solution/purpose

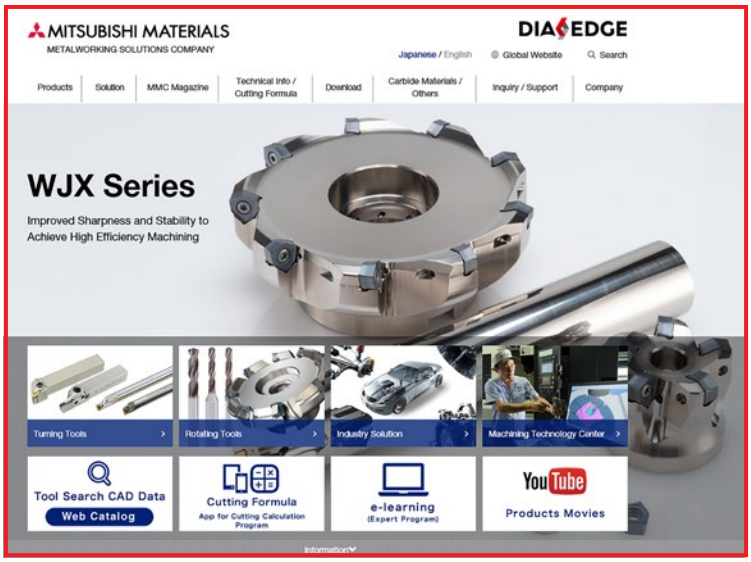
For details, please contact your nearest sales office. (Refer to "Domestic Sales Offices" at the end of the catalogue)

Customer Service

Web Service

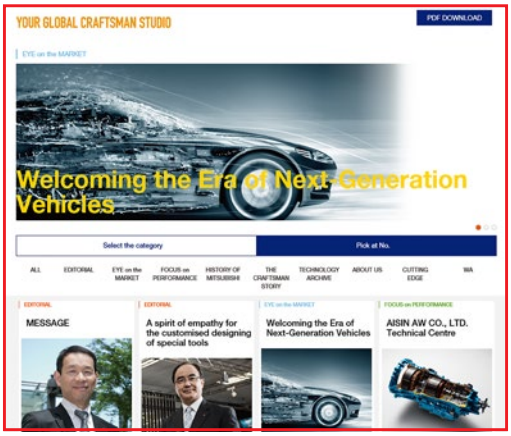
Mitsubishi Materials Website

- We deliver latest solution technical information, exhibitions and event information.
- You can view various promotional leaflets as well as PDF version of General Catalogue on the website.

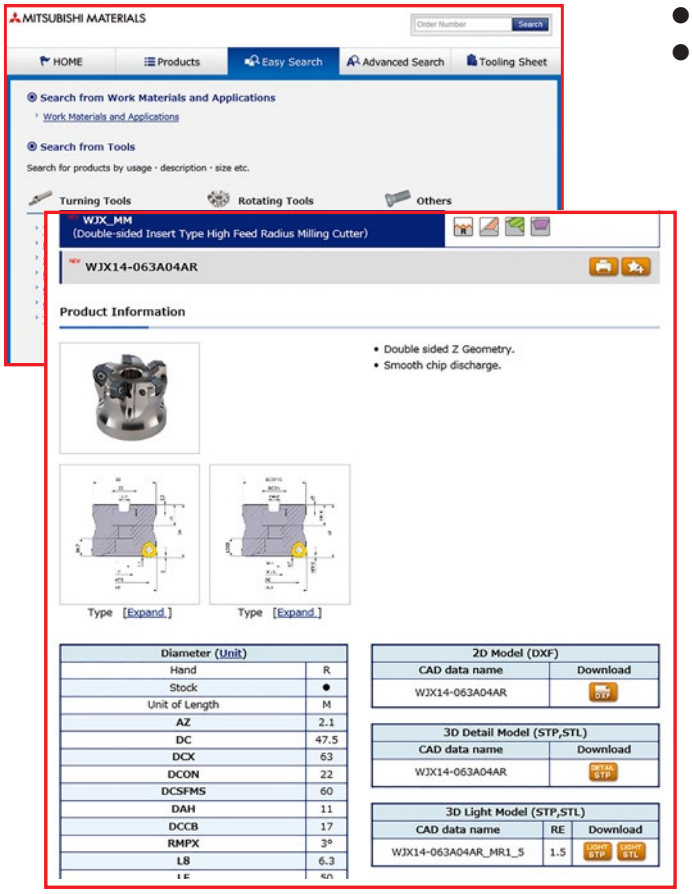


http://www.carbide.mht.co.th

Access to the website here

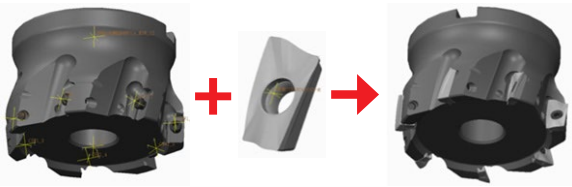


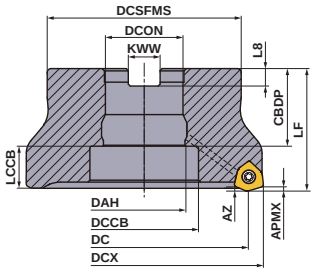
Mitsubishi Materials Web Catalogue



- You can search from materials and cutting applications.
- We are constantly updating various CAD data corresponding to ISO 13399.
  - 2D Model (DXF)
  - 3D Detail Model (STP)
  - 3D Light Model (STP/STL)

3D Detail Model (STP) Example





http://www.mitsubishicarbide.net/mht/enuk/

Access to the web catalogue here

2020-2021

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DIAEDGE

USING THIS CATALOGUE

1. This catalogue is as of April 2019.

2. Please note that products in this catalogue are continuously reviewed and updated. The products therefore may be changed in the future and thus become different from the catalogue.

3. Stock status is mentioned for the products in this catalogue. However, please note that the products here may be replaced by new grades and products in the future.

   Note 1) Please contact us for dimensions not mentioned in this catalogue.
   Note 2) Please contact us regarding order numbers and grades that are not mentioned in this catalogue.

4. Stock status indication

   ● : Inventory maintained. **□ : Non stock, produced to order only.** **▲ : Inventory maintained. To be replaced by new products.**

HOW TO USE THIS CATALOGUE

In this catalogue, our company's cutting tools are broadly divided into two types: turning tools and rotating tools, with separate respective sections for each machining method. Please select the search method that matches your requirements when using the catalogue.

1. **Search for tool types from the CONTENTS.**

2. **To find the series of products from the index of the inside title**.
   Index of each block are listed on each inside title.

3. **To find the product according to application.**
   The classification page of each block provides the series of products to be selected according to applications and purposes.

4. **Search using the alphabetical index.**
   All tools are listed in the alphabetical index at the front of the catalogue.

5. **How to use the block sections.**
   A usage guide for each block is shown on the left of each index (not for all blocks). Refer to this page to know how to read the product information and how the page is organised.

OTHER WAYS TO USE THE CATALOGUE

The following PR materials are also available in addition to this catalogue, for use as necessary.

1. **Catalogues for individual products**
   - Access the following URL and download "Tool News" for the applicable cutting tool.
     Information about tool features and examples of cutting applications are available in greater detail.

http://www.carbide.mht.co.th/download/tools_news

2. **Online catalogue (electronic catalogue with search functions)**
   - Access the following URL to search for applicable cutting tools and view detailed information.
     CAD data, tooling sheets, and other resources are also available for download.

http://www.mitsubishicarbide.net/mht/enuk/

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BAP300 type	Spare parts (For BAP300 type face mill)	Q028
BAP300 type	Spare parts (For BAP300 type end mill)	Q034

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BAP3500 type	Spare parts (For BAP3500 type end mill)	Q034
BAP400 type	Spare parts (For BAP400 type face mill)	Q028
BAP400 type	Spare parts (For BAP400 type end mill)	Q034
BAP400R type	Spare parts (For BAP400 type end mill)	Q034
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BC○	Clamp set (For BC type cartridge)	N009
BC○○	Clamp set (For BC type cartridge)	N009
BCP○○○	Shim pin	H013, N009, Q013
BF407R type	Spare parts (For BF407 type face mill)	Q028
BF-CCGT○○○○○○TA2	Insert (Class G tolerance)	B051
BF-CCGT○○○○○○TS2	Insert (Class G tolerance)	B051
BF-CNGG○○○○○○TA4	Insert (Class G tolerance)	B028
BF-CNGM○○○○○○TA2	Insert (Class G tolerance)	B030
BF-CNGM○○○○○○TS2	Insert (Class G tolerance)	B030
BF-DCGT○○○○○○TA2	Insert (Class G tolerance)	B055
BF-DCGT○○○○○○TS2	Insert (Class G tolerance)	B055
BF-DNGG○○○○○○TA4	Insert (Class G tolerance)	B033
BF-DNGM○○○○○○TA2	Insert (Class G tolerance)	B035
BF-DNGM○○○○○○TS2	Insert (Class G tolerance)	B035
BM-CCGT○○○○○○TA2	Insert (Class G tolerance)	B051
BM-CNGM○○○○○○TA2	Insert (Class G tolerance)	B030
BM-DCGT○○○○○○TA2	Insert (Class G tolerance)	B055
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BSX500 type	Spare parts (For BSX500 type face mill)	Q029
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BTAT605000RX	Insert for external back turning	D012
BTAT○○○○○○MR-B	Insert for external back turning	D012
BTAT○○○○○○R/L-B	Insert for external back turning	D012
BTAT○○○○○○○-SMB	Insert for external back turning	D012
BTBT○○○○○○MR-SMB	Insert for external back turning	D013
BTBT○○○○○○R/L	Insert for external back turning	D013
BTBT○○○○○○R/L-B	Insert for external back turning	D013
BTBT○○○○○○R/L-SMB	Insert for external back turning	D013
BTVHR○○○○-○○	Small tools holder (External back turning)	D014
BTVT○○○○○○R-B	Insert for external back turning	D014
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BXD7000 type	Spare parts (For BXD7000 type face mill)	Q029
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C2LA	Carbide end mill	J106
C2LS	Carbide end mill	J100
C2MA	Carbide end mill	J104
C2MB	Carbide end mill	J252
C2MHA	Carbide end mill	J108
C2MS	Carbide end mill	J095
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C2SS	Carbide end mill	J094
C3SA	Carbide end mill	J128
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CAS51T	Set screw	Q003
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CBN2XLRB	CBN end mill	J280
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CBT○○	Breaker piece	Q016
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CSVTFXL	Insert for external front turning, Copying	D027
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K

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L

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NP-SNMA○○○○○○T	Insert (Class M tolerance)	B038
NP-SNMM○○○○○○R/L-F	Insert (Class M tolerance)	B069
NP-TCGW○○○○○○FA3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○FS3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○GA3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○GS3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○SE3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○SF3	Insert (Class G tolerance)	B057
NP-TCGW○○○○○○TS3	Insert (Class G tolerance)	B057
NP-TNGA○○○○○○FS3	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○FS6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○G3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○GA3	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GA6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GH3	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GH6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GN3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○GN6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GS3	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○GS6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○SE3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○SF3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○T3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○TA3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○TA6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○TH3	Insert (Class G tolerance)	B040
NP-TNGA○○○○○○TH6	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○TS3	Insert (Class G tolerance)	B039
NP-TNGA○○○○○○TS6	Insert (Class G tolerance)	B039
NP-TNMA○○○○○○F	Insert (Class M tolerance)	B040
NP-TNMA○○○○○○G	Insert (Class M tolerance)	B041
NP-TNMA○○○○○○GS	Insert (Class M tolerance)	B040
NP-TNMA○○○○○○T	Insert (Class M tolerance)	B041
NP-TNMM○○○○○○R/L-F	Insert (Class M tolerance)	B069
NP-TPGB○○○○○○FS3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○GA3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○GH3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○GS3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○SE3	Insert (Class G tolerance)	B059
NP-TPGB○○○○○○SF3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○TA3	Insert (Class G tolerance)	B058
NP-TPGB○○○○○○TH3	Insert (Class G tolerance)	B058
NP-TPGX○○○○○○F	Insert (Class G tolerance)	B059
NP-TPGX○○○○○○G	Insert (Class G tolerance)	B059
NP-TPGX○○○○○○GA3	Insert (Class G tolerance)	B059
NP-TPGX○○○○○○GS3	Insert (Class G tolerance)	B059
NP-TPGX○○○○○○T	Insert (Class G tolerance)	B059
NP-TPMB○○○○○○G	Insert (Class M tolerance)	B059
NP-TPMH○○○○○○R/L-F	Insert (Class M tolerance)	B075
NP-TPMX○○○○○○R/L-F	Insert (Class M tolerance)	B075
NP-VBGT○○○○○○R-F	Insert (Class G tolerance)	B077
NP-VBGW○○○○○○FS2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○G	Insert (Class G tolerance)	B062
NP-VBGW○○○○○○GA2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○GH2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○GS2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○SE2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○SF2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○TA2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○TH2	Insert (Class G tolerance)	B061
NP-VBGW○○○○○○TS2	Insert (Class G tolerance)	B061
NP-VCGT○○○○○○R-F	Insert (Class G tolerance)	B077
NP-VCGW○○○○○○FS2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○GA2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○GH2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○GS2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○TA2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○TH2	Insert (Class G tolerance)	B062
NP-VCGW○○○○○○TS2	Insert (Class G tolerance)	B062

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NP-VNGA○○○○○○G2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○FS2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○FS4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○G2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○GA2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○GA4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○GH2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○GH4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○GN2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○GS2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○GS4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○SE2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○SF2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○T2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○TA2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○TA4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○TH2	Insert (Class G tolerance)	B043
NP-VNGA○○○○○○TH4	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○TS2	Insert (Class G tolerance)	B042
NP-VNGA○○○○○○TS4	Insert (Class G tolerance)	B042
NP-VNMA○○○○○○F	Insert (Class M tolerance)	B043
NP-VNMA○○○○○○G	Insert (Class M tolerance)	B043
NP-VNMA○○○○○○GS	Insert (Class M tolerance)	B043
NP-VNMA○○○○○○T	Insert (Class M tolerance)	B043
NP-VNMM○○○○○○R/L-F	Insert (Class M tolerance)	B070
NP-WCMW○○○○○○FA	Insert (Class M tolerance)	B063
NP-WFC42ZFER2	Insert (For BF407•QBF407 type face mill)	L055
NP-WNGA○○○○○○FS3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○FS6	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GA3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GA6	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GAWS3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GH3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GS3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GS6	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○GSWS3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○SE3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○SF3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○TA3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○TH3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○TS3	Insert (Class G tolerance)	B044
NP-WNGA○○○○○○TS6	Insert (Class G tolerance)	B044
NPX type	Spare parts (For NPX type drill)	Q043
NR10000 type	Spare parts (For NR10000 type face mill)	Q030
NS○○○	Clamp screw	Q006
NS○○○W	Clamp screw	Q006
NSE300 type	Spare parts (For NSE300 type end mill)	Q037
NSE300 type	Spare parts (For NSE300 type face mill)	Q031
NSE400 type	Spare parts (For NSE400 type end mill)	Q037
NSE400 type	Spare parts (For NSE400 type face mill)	Q031
NTF type	NT holder	Q025
NV○ type	Boring unit (Vertical type)	Q027
NVPN type	Cartridge (For boring unit)	Q027
NVSP type	Cartridge (For boring unit)	Q027

O

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OCTACUT○○○○○○○	OCTACUT type face mill	M181, M182
OCTACUT○○○S32○○	OCTACUT type end mill	M180
OEMX○○○○E○R1	Insert (For OCTACUT type cutter)	L033, L053, M183
OEMX○○○○E○R1-JS	Insert (For OCTACUT type cutter)	L033, M183
ORGW○○○N9	O ring	F111

P

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P425 type	Spare parts (For P425 type face mill)	Q031
P525 type	Spare parts (For P525 type face mill)	Q031
P○○○AM	Pin	E035-E038
PCBNR/L○○○○○○○	LL holder	C009, Q018
PCFN type	Spare parts (For LL holder)	Q018
PCLNR/L○○○○○○○	LL holder	C008, Q018
PCLNR/L○○CA○○	LL type cartridge	N006
PDHNR/L○○○○○○○	LL holder	C011
PDJNR/L○○○○○○○	LL holder	C010
PMC○○R○○○AM○○○○	PMC type end mill	M254
PMF○○○○○A○○R	PMF type end mill	M256
PMFA○○R	Cartridge (For PMF type end mill)	M256
PMR○○○○○○A○○R	PMR type end mill	M258
PMR○○○○○○○R	PMR type end mill	M258
PRDCN○○○○○○○	LL holder	C024, Q018
PRGCR/L○○○○○○○	LL holder	C024, Q018
P○○S	Lock pin	C020, G038, F126, Q014
PS○○	Shim	Q010
PSBNR/L○○○○○○○	LL holder	C012, Q018
PSDNN○○○○○○○	LL holder	C014
PSKNR/L○○○○○○○	LL holder	C015, Q018
PSKNR/L○○CA○○	LL type cartridge	N006
PSSNR/L○○○○○○○	LL holder	C013, Q018
PSSNR/L○○CA○○	LL type cartridge	N006
PSTNR/L○○○○○○○	LL holder	C013
PSYNR○○CA○○	LL type cartridge	N006
PT○○	Shim	Q010
PTAN type	Spare parts (For LL holder)	Q018
PTBN type	Spare parts (For LL holder)	Q018
PTFE type	Spare parts (For AL holder)	Q022
PTFNR/L○○○○○○○	LL holder	C017, Q018
PTFNR/L○○CA○○	LL type cartridge	N006
PTGE type	Spare parts (For AL holder)	Q022
PTGNR/L○○○○○○○	LL holder	C016, Q018
PTGNR/L○○CA○○	LL type cartridge	N006
PTTNR○○CA○○	LL type cartridge	N006
PTTN type	Spare parts (For LL holder)	Q018
PT○○T○R	Shim	Q011
P○○○US	Lock pin	Q014
PV○○○	Shim	Q012
PVJNR/L○○○○○○○	MP holder	C018

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PVVNN○○○○○○○	MP holder	C019, Q020
P○○○W	Lock pin	Q014
PWLNR/L○○○○○○○	LL holder	C021
P○○○WS	Lock pin	Q014
Q		
QB○○○○○○○	Q type quick change	N021
QBF407R type	Spare parts (For Qing cutter)	Q031
QBP415 type	Spare parts (For Qing cutter)	Q031
QF10000 type	Spare parts (For Qing cutter)	Q031
QFA○○○○○○	T type quick change	N019
QFA○○○○○B○R/L	Q type quick change	N018
QFA○○○○○N○R/L	Q type quick change	N018
QFB○○○○○○	Q type quick change	N019
QING	Qing cutter	M271
QOGT○○○○R-G1	Insert (For AQX type end mill)	L034, M157
QOMT○○○○R-M2	Insert (For AQX type end mill)	L034, M157
QPAR1	Guide plate	Q031, Q032
QPCR1	Guide plate	Q031
QSE415 type	Spare parts (For Qing cutter)	Q032
QWGR1	Wedge-T	Q031
R		
RBH○○○○N	Arbor (For MICRO-DEX/MICRO-MINI type boring bar)	E018, E023, F122, G035
RCGT○○○○M0-AZ	Insert (Class G tolerance)	A156
RCMT○○○○M0	Insert (Class M tolerance)	A156
RCMX○○○○M0	Insert (Class M tolerance)	A156
RCMX○○○○M0-RR	Insert (Class M tolerance)	A156
RDMW○○○○M0E	Insert (For ARX type end mill)	L034, M192
REMX1705SN	Insert (For OCTACUT type cutter)	L034, M183
REMX○○○○EN-JS	Insert (For OCTACUT type cutter)	L034, M183
RGEN2004M0○N	Insert (For SG20 type cutter)	L035, M065
RKY25S	Wrench	M066–M068
RNGN○○○○○○	Insert (Class G tolerance)	B046
RNMG○○○○○○	Insert (Class M tolerance)	A114
RN-S○○	Clamp screw	Q006
RPH/MT○○○○M0E4-○	Insert (For ARP type cutter)	L034, M189
RPMT○○○○M0E-JS	Insert (For BRP type cutter)	L035, M199
RPMW○○○○M0○	Insert (For BRP type cutter)	L035, M199
RS○○○○T	Clamp screw	Q006
RTG○○○	Insert (For TL holder)	A179, B063, C035
S		
S○	Clamp screw	Q006
S2SDA	HSS end mill	J392
SBA○○○-ES-M	Parts for ABS head	N025
SBA○○○-ES-M○	Parts for ABS head	N025
SBAHR○○○○	Boring holder	D030
SBAT○○○○○○L	Insert (For SBAHR type holder)	D030
SBAT○○○○○○L-B	Insert (For SBAHR type holder)	D030
SBH○○○○R	Square type holder (For MICRO-DEX/MICRO-MINI type boring bar)	E024, F123, G034
SBR○○○	MI holder	N015
SCACR/L○○○○○○○-SM	Small tools holder (External front turning)	D008
SCD43	Shim	Q029
SCLCR/L○○○○○○○	SP holder	C022
SCLCR/L○○○○○○○-SM	Small tools holder (External front turning)	D008
SC○○M○○S10-BT○○	Arbors for screw-in tools	M270
SC○○M○○S○○-HSK63A	Arbors for screw-in tools	M270
SC○○M○○S○○○S/L	Arbors for screw-in tools	M269
SC○○M○○S○○○SW/LW	Arbors for screw-in tools	M269
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SCMT○○○○○○-FM	Insert (Class M tolerance)	A157
SCMT○○○○○○-FP	Insert (Class M tolerance)	A157
SCMT○○○○○○-FV	Insert (Class M tolerance)	A157
SCMT○○○○○○-LM	Insert (Class M tolerance)	A157
SCMT○○○○○○-LP	Insert (Class M tolerance)	A157
SCMT○○○○○○-MK	Insert (Class M tolerance)	A158
SCMT○○○○○○-MM	Insert (Class M tolerance)	A157
SCMT○○○○○○-MP	Insert (Class M tolerance)	A157
SCMT○○○○○○-MS	Insert (Class M tolerance)	A158
SCMW○○○○○○	Insert (Class M tolerance)	A158
SCP○○○R/L	Shim	Q031
SD	Straight shank drill	P176, P178
SD○○	Set bolt	E042, Q006
SDEN1203AEN	Insert (For FMSD type cutter)	L035
SDFC type	Spare parts (For SP holder)	Q021
SDJCR/L○○○○○○○	SP holder	C023, Q021
SDJCR/L○○○○○○○-SM	Small tools holder (External front turning)	D009
SDJER/L○○○○○○○	AL holder	C032
SDKN1203AEN	Insert (For FMSD type cutter)	L035
SDKN○○○○AE○○	Insert (For FMSD type cutter)	L035
SDLS	Straight shank drill	P179
SDNCN○○○○○○○	SP holder	C023
SDNCR/L○○○○○○○-SM	Small tools holder (External front turning)	D009
SDNEN○○○○○○○	AL holder	C032
SDXC type	Spare parts (For SP holder)	Q021
SE300 type	Spare parts (For SE300 type end mill)	Q037
SE300 type	Spare parts (For SE300 type face mill)	Q032
SE400 type	Spare parts (For SE400 type face mill)	Q032
SE415 type	Spare parts (For SE415 type face mill)	Q032
SE445 type	Spare parts (For SE445 type face mill)	Q032
SE545 type	Spare parts (For SE545 type face mill)	Q032
SE515R○○○○○○	SE515 type face mill	M062
SEA42C10GR/L	Insert (For E404/FE404 type cutter)	L035, M267
SECN1203AFFR1	Insert (For SE445 type cutter)	L053
SECN○○○○AFTN1	Insert (For SE445 type cutter)	L035
SECN○○○○EF○R1	Insert (For SE415/SE515 type cutter)	L036, L053, M063
SED2KMG	Key way slotting end mill	J091
SED2KPG	Key way slotting end mill	J092
SEE2L	Carbide end mill	J110
SEE4L	Carbide end mill	J186
SEEN○○○○AF○N1	Insert (For SE445/545 type cutter)	L035, L036

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SEF○○○	Setting fixture	M268
SEG4SA	Carbide end mill	J185
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SEKN○○○○AF○N1	Insert (For SE445/545 type cutter)	L035, L036
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SEKN○○○○EF○R	Insert (For SE415 type cutter)	L036
SEKN○○○○EF○R1	Insert (For SE415/515 type cutter)	L036, M063
SEMT13T3AGSN-○○	Insert (For ASX445 type cutter)	L037, M033
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SEPDS	HSS milling shank drill	P140
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SETS○○	Clamp screw	G019, G038, H016, Q006
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SFCN1203ZFFR/L2	Insert (For BF407/QBF407 type cutter)	L037, L053
SG20R○○○○○	SG20 type face mill	M064
SH○○○-FSDUCL○○	Small tools holders (For opposite tool posts)	D026
SHP400 type	Spare parts (For SHP400 type end mill)	Q037
SHP400 type	Spare parts (For SHP400 type face mill)	Q033
SL32○○-90	Sleeve (For H100THB32-135)	H022
SLCS○○○	Clamp screw	Q006
SLCW○○	Clamp wedge	Q021
SLN○○	Nut	Q021
SL-ONEN120404ASN	Insert (For AOX445 type cutter)	L053, M061
SLP○○	Lock pin	Q021
SLSTN○○	Shim	Q021
SMGHR○○○○○○○	SMG holder	F118, G026
SMGTR○○○○○○○	Insert (For SMG holder)	F118
SMGTR○○○○○○○○	Insert (For SMG holder)	G027
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SNC43B2○	Insert (For DN/BN425 type face mill)	L038
SN○F43B2○	Insert (For DN/BN425 type face mill)	L038
SNGA○○○○○○	Insert (Class G tolerance)	A120, B038, B069
SNGG○○○○○○R/L	Insert (Class G tolerance)	A118
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SNGU○○○○○○AN○R/L-○	Insert (For WSX445 type face mill)	L038, M023
SNK43B2○	Insert (For DN/BN425 type face mill)	L038
SNMA○○○○○○	Insert (Class M tolerance)	A120
SNMG○○○○○○	Insert (Class M tolerance)	A118
SNMG○○○○○○-C	Insert (Class M tolerance)	A116
SNMG○○○○○○-FH	Insert (Class M tolerance)	A115
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SNMG○○○○○○-FS	Insert (Class M tolerance)	A115
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SNMG○○○○○○-LP	Insert (Class M tolerance)	A115
SNMG○○○○○○-MA	Insert (Class M tolerance)	A117
SNMG○○○○○○-MH	Insert (Class M tolerance)	A117
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SNMG○○○○○○-RK	Insert (Class M tolerance)	A119
SNMG○○○○○○-R/L-1G	Insert (Class M tolerance)	A116
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SNMM○○○○○○-HX	Insert (Class M tolerance)	A119
SNMM○○○○○○-HZ	Insert (Class M tolerance)	A120
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SOET12T308PEER-JL	Insert (For ASX400 type cutter)	L038, M084
SOGT12T308PEFR-JP	Insert (For ASX400 type cutter)	L038, M084
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SOMT12T3○○PEER/L-○○	Insert (For ASX400 type cutter)	L039, M084, M095
SOMX○○○○○○-○○	Insert (For MVX type drill)	L056, L057, P237
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SPEN1203EETR1	Insert (For FBP415/QBP415 type cutter)	L053
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SPGX○○○○○○	Insert (Class G tolerance)	A159, B073
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VAPDSCB	VIOLET drill, Short flute length, High precision, For counter boring	P168
VAPDSSUS	VIOLET drill, Short, High precision, For stainless steel	P155
VAS400	VAS400 type side cutter	M090
VAS500	VAS500 type side cutter	M092
VASFPR	VIOLET end mill	J402
VBET○○○○○○R/L-SN	Insert (Class E tolerance)	A169
VBET○○○○○○R/L-SR	Insert (Class E tolerance)	A169
VBET○○○○○○R/LW-SN	Insert (Class E tolerance)	A169
VBGT○○○○○○R/L-F	Insert (Class G tolerance)	A167
VBMT○○○○○○	Insert (Class M tolerance)	A168
VBMT○○○○○○-FM	Insert (Class M tolerance)	A167
VBMT○○○○○○-FP	Insert (Class M tolerance)	A167
VBMT○○○○○○-FV	Insert (Class M tolerance)	A167
VBMT○○○○○○-LM	Insert (Class M tolerance)	A167
VBMT○○○○○○-LP	Insert (Class M tolerance)	A167
VBMT○○○○○○-LS	Insert (Class M tolerance)	A168
VBMT○○○○○○-MK	Insert (Class M tolerance)	A168
VBMT○○○○○○-MM	Insert (Class M tolerance)	A168
VBMT○○○○○○-MP	Insert (Class M tolerance)	A168
VBMT○○○○○○-MS	Insert (Class M tolerance)	A168
VBMT○○○○○○-MV	Insert (Class M tolerance)	A169
VBMT○○○○○○-SV	Insert (Class M tolerance)	A168
VBMW○○○○○○	Insert (Class M tolerance)	A169
VC2C	MIRACLE end mill	J082
VC2JS	MIRACLE end mill	J080
VC2MS	MIRACLE end mill	J077
VC2SS	MIRACLE end mill	J075
VC3MB	MIRACLE end mill	J268
VC4JC	MIRACLE end mill	J170
VC4JRB	MIRACLE end mill	J326
VC4MC	MIRACLE end mill	J168
VC4SRB	MIRACLE end mill	J324
VC4STB	MIRACLE end mill	J352
VCGT○○○○○○-AZ	Insert (Class G tolerance)	A170
VCGT○○○○○○M-LS	Insert (Class G tolerance)	A171
VCGT○○○○○○M-LS-P	Insert (Class G tolerance)	A171
VCGT○○○○○○R/L-F	Insert (Class G tolerance)	A170
VCHFRB	MIRACLE end mill	J328,J329
VCHSM	MIRACLE drill, Medium, For hardened material	P135
VCLD	MIRACLE end mill	J193
VCMDSC	MIRACLE end mill	J172
VCMH	MIRACLE end mill	J126
VCMHDRB	MIRACLE end mill	J332
VCMT○○○○○○	Insert (Class M tolerance)	A172
VCMT○○○○○○-FM	Insert (Class M tolerance)	A170
VCMT○○○○○○-FP	Insert (Class M tolerance)	A170
VCMT○○○○○○-FV	Insert (Class M tolerance)	A170
VCMT○○○○○○-LM	Insert (Class M tolerance)	A170
VCMT○○○○○○-LP	Insert (Class M tolerance)	A170
VCMT○○○○○○-LS	Insert (Class M tolerance)	A171
VCMT○○○○○○-MK	Insert (Class M tolerance)	A171
VCMT○○○○○○-MM	Insert (Class M tolerance)	A171
VCMT○○○○○○-MP	Insert (Class M tolerance)	A171
VCMT○○○○○○-MS	Insert (Class M tolerance)	A171
VCMT○○○○○○-MV	Insert (Class M tolerance)	A172
VCMT○○○○○○-SV	Insert (Class M tolerance)	A171
VCMW○○○○○○	Insert (Class M tolerance)	A172
VCPSRB	MIRACLE end mill	J318, J322
VCSSS	MIRACLE drill, Short, For steel (3mm shank series)	P134
VCT13R	Cartridge (For V10000 type cutter)	M070
VCXB	MIRACLE end mill	J228
VDGX○○○○○○R/L	Insert (Class G tolerance)	A173

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VDGX○○○○○○R/L-F	Insert (Class G tolerance)	B080
VF2MD	IMPACT MIRACLE end mill	J068
VF2MV	IMPACT MIRACLE end mill	J070
VF2SDB	IMPACT MIRACLE end mill	J216
VF2SDBL	IMPACT MIRACLE end mill	J217
VF2WB	IMPACT MIRACLE end mill	J219
VF2XL	IMPACT MIRACLE end mill	J072
VF2XLB	IMPACT MIRACLE end mill	J222
VF2XLBS	IMPACT MIRACLE end mill	J220
VF3XB	IMPACT MIRACLE end mill	J260
VF4MB	IMPACT MIRACLE end mill	J272
VF4MD	IMPACT MIRACLE end mill	J164
VF4MV	IMPACT MIRACLE end mill	J166
VF6MHV	IMPACT MIRACLE end mill	J189
VF6MHVRB	IMPACT MIRACLE end mill	J344
VF6SVRCH	IMPACT MIRACLE end mill	J369
VF8MHVCH	IMPACT MIRACLE end mill	J194
VF8MHVRBCH	IMPACT MIRACLE end mill	J350
VFFDRB	IMPACT MIRACLE end mill	J316
VFHVRB	IMPACT MIRACLE end mill	J306, J312
VFMD	IMPACT MIRACLE end mill	J191
VFMDRB	IMPACT MIRACLE end mill	J348
VFMFPR	IMPACT MIRACLE end mill	J368
VFMHVCH	IMPACT MIRACLE end mill	J167
VFMHVRBCH	IMPACT MIRACLE end mill	J304
VFR2SB	IMPACT MIRACLE REVOLUTION end mill	J212
VFR2SBF	IMPACT MIRACLE REVOLUTION end mill	J214
VFR2SSB	IMPACT MIRACLE REVOLUTION end mill	J210
VFSD	IMPACT MIRACLE end mill	J190
VFSDRB	IMPACT MIRACLE end mill	J346
VFSFPR	IMPACT MIRACLE end mill	J365
VFSFPRCH	IMPACT MIRACLE end mill	J367
VFX5-○○○○○○A○○○R	VFX5 type end mill	M220
VFX6-○○○A○○A○○○R	VFX6 type end mill	M224
VIP400 type	Spare parts (VIP400 type face mill)	Q033
VIP445 type	Spare parts (VIP445 type face mill)	Q033
VIPER type	Spare parts (VIPER type end mill)	Q038
VNGA○○○○○○	Insert (Class G tolerance)	A131, B043, B070
VNGG○○○○○○-FJ	Insert (Class G tolerance)	A128
VNGG○○○○○○R/L	Insert (Class G tolerance)	A131
VNGG○○○○○○-R/L-F	Insert (Class G tolerance)	A128
VNGM○○○○○○-MJ	Insert (Class G tolerance)	A129
VNMA○○○○○○	Insert (Class M tolerance)	A131
VNMG○○○○○○	Insert (Class M tolerance)	A130
VNMG○○○○○○-FH	Insert (Class M tolerance)	A128
VNMG○○○○○○-FP	Insert (Class M tolerance)	A128
VNMG○○○○○○-FS	Insert (Class M tolerance)	A128
VNMG○○○○○○-GK	Insert (Class M tolerance)	A130
VNMG○○○○○○-GM	Insert (Class M tolerance)	A130
VNMG○○○○○○-LK	Insert (Class M tolerance)	A129
VNMG○○○○○○-LM	Insert (Class M tolerance)	A128
VNMG○○○○○○-LP	Insert (Class M tolerance)	A128
VNMG○○○○○○-LS	Insert (Class M tolerance)	A129
VNMG○○○○○○-MA	Insert (Class M tolerance)	A130
VNMG○○○○○○-MH	Insert (Class M tolerance)	A130
VNMG○○○○○○-MJ	Insert (Class M tolerance)	A129
VNMG○○○○○○-MK	Insert (Class M tolerance)	A129
VNMG○○○○○○-MM	Insert (Class M tolerance)	A129
VNMG○○○○○○-MP	Insert (Class M tolerance)	A129
VNMG○○○○○○-MS	Insert (Class M tolerance)	A130
VNMG○○○○○○-SA	Insert (Class M tolerance)	A129
VNMG○○○○○○-SH	Insert (Class M tolerance)	A129
VOS400	VOS400 type side cutter	M094
VOX400-○○○○○○R	VOX400 type face mill	M076, M077
VOX400R○○○○○○	VOX400 type face mill	M076
VPET○○○○○○R/L-SRF	Insert (Class E tolerance)	A174
VPGT○○○○○○M-SMG	Insert (Class G tolerance)	A174
VPX200-○○○A○○AR	VPX200 type face mill	M112
VPX200R○○○○AM○○○○	VPX200 type screw-in end mill	M111
VPX200R○○○○SA○○S/L	VPX200 type end mill	M110
VPX300-○○○A○○AR	VPX300 type face mill	M124
VPX300R○○○○AM○○○○	VPX300 type screw-in end mill	M123
VPX300R○○○○○CA	VPX300 type face mill	M124
VPX300R○○○○SA○○S/L	VPX300 type end mill	M122
VQ4SVB	SMART MIRACLE end mill	J270
VQ6MHVCH	SMART MIRACLE end mill with coolant hole	J188
VQ6MHVRBCH	SMART MIRACLE end mill	J342
VQJHV	SMART MIRACLE end mill	J158
VQMHV	SMART MIRACLE end mill	J154
VQMHVRB	SMART MIRACLE end mill	J297
VQMHVRBF	SMART MIRACLE end mill	J302
VQMHZV	SMART MIRACLE end mill	J116
VQMHZVOH	SMART MIRACLE end mill	J122
VQSVR	SMART MIRACLE end mill	J362
VQT5MVRB	SMART MIRACLE end mill	J340
VQT6UR	SMART MIRACLE BARREL end mill	J359
VQXL	SMART MIRACLE end mill	J160
VSD	VIOLET drill, Straight shank	P170
VTDS	VIOLET drill, Short, Taper shank	P172

W

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WA-M10	Washer	F112
WBGT○○○○○○R/L-F	Insert (Class G tolerance)	A175
WBMT○○○○○○R/L-MV	Insert (Class M tolerance)	A175
WCGT○○○○○○R/L	Insert (Class G tolerance)	A176
WCMT○○○○○○	Insert (Class M tolerance)	A176
WCMW○○○○○○	Insert (Class M tolerance)	B078
WCS○○○○○○H	Shim screw	M032, Q008
WEC○○AF○R5C	Wiper insert (For SE445/545 type cutter)	L050
WEC○○EF○R5C	Wiper insert (For SE415/515 type cutter)	L050, M063
WEEW13T3AG○R○C	Wiper insert (For ASX445 type cutter)	L050, L055, M034
WFC42ZFER2	Wiper insert (For BF407/QBF407 type cutter)	L055
WJX14-○○○A○○AR	WJX type face mill	M172, M173
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WJX14R○○○○SA42S/L	WJX type end mill	M175
WNEU1305ZEN4C-M	Wiper insert (For AHX440S type cutter)	L050, M040
WNEU2006ZEN7C-WK	Wiper insert (For AHX640S/640W type cutter)	L051, M048, M056
WNEU2007ZEN7C-○○	Wiper insert (For AHX640S type cutter)	L051, M048
WNGU1406ANEN8C-M	Wiper insert (For WSX445 type cutter)	L051, M023
WNMA○○○○○○	Insert (Class M tolerance)	A136
WNMG○○○○○○	Insert (Class M tolerance)	A135
WNMG○○○○○○-C	Insert (Class M tolerance)	A133
WNMG○○○○○○-FH	Insert (Class M tolerance)	A132
WNMG○○○○○○-FP	Insert (Class M tolerance)	A132
WNMG○○○○○○-FS	Insert (Class M tolerance)	A132
WNMG○○○○○○-FY	Insert (Class M tolerance)	A132
WNMG○○○○○○-GH	Insert (Class M tolerance)	A136
WNMG○○○○○○-GJ	Insert (Class M tolerance)	A136
WNMG○○○○○○-GK	Insert (Class M tolerance)	A135
WNMG○○○○○○-GM	Insert (Class M tolerance)	A135
WNMG○○○○○○-LK	Insert (Class M tolerance)	A133
WNMG○○○○○○-LM	Insert (Class M tolerance)	A132
WNMG○○○○○○-LP	Insert (Class M tolerance)	A132
WNMG○○○○○○-LS	Insert (Class M tolerance)	A133
WNMG○○○○○○-MA	Insert (Class M tolerance)	A135
WNMG○○○○○○-MH	Insert (Class M tolerance)	A135
WNMG○○○○○○-MJ	Insert (Class M tolerance)	A133
WNMG○○○○○○-MK	Insert (Class M tolerance)	A134
WNMG○○○○○○-MM	Insert (Class M tolerance)	A134
WNMG○○○○○○-MP	Insert (Class M tolerance)	A134
WNMG○○○○○○-MS	Insert (Class M tolerance)	A134
WNMG○○○○○○-MW	Insert (Class M tolerance)	A135
WNMG○○○○○○-RK	Insert (Class M tolerance)	A136
WNMG○○○○○○-RM	Insert (Class M tolerance)	A135
WNMG○○○○○○-RP	Insert (Class M tolerance)	A135
WNMG○○○○○○-RS	Insert (Class M tolerance)	A136
WNMG○○○○○○-SA	Insert (Class M tolerance)	A133
WNMG○○○○○○-SH	Insert (Class M tolerance)	A133
WNMG○○○○○○-SW	Insert (Class M tolerance)	A133
WNMG○○○○○○-SY	Insert (Class M tolerance)	A133
WOEW12T308PE○○8C	Wiper insert (For ASX400 type cutter)	L051, M084
WOEX1206PER5C	Wiper insert (For VOX400 type cutter)	L051, M078
WPC42EEER/L10C	Wiper insert (For FBP415/QBP415 type cutter)	L051
WPGT○○○○○○	Insert (Class G tolerance)	B078
WPGT○○○○○○R/L-FS	Insert (Class G tolerance)	A177
WPMT○○○○○○-MV	Insert (Class M tolerance)	A177
WPS○	Lock screw	Q022
WPSTN○○	Shim	Q012
WPSWC43	Shim	Q012
WPSWN43	Shim	Q012
WPT4405	Plate (For TAW type drill)	P219-P223, P229
W○○-S1	Seal washer	M221, M225
W○-S1	Seal washer	M221
WS1	Wedge screw	Q008
WS○○LH	Stopper	P218
WS○○○○○○T	Clamp screw	Q008
WS○○○○○○TPS	Clamp screw	P218, Q008
WS○○○○○○TPS-○○LH	Spare parts set	P218
WSX445-○○○○○○○L	WSX445 type face mill	M021
WSX445L○○○○○○○	WSX445 type face mill	M019
WSX445-○○○○○○○R	WSX445 type face mill	M018, M020
WSX445R○○○○○○○	WSX445 type face mill	M018
WSX445R○○○○SA32M	WSX445 type end mill	M022

X

XCMT○○○○○○-SVX	Insert (Class M tolerance)	A178
XDGT1550PD○R-G○○	Insert (For BXD4000 type cutter)	L045, M153
XDGX1750○○PD○R-○○	Insert (For AXD4000 type cutter)	L046, M136
XDGX2270○○PDER-GLA	Insert (For AXD7000 type cutter)	L047, M144
XDGX2270○○PDFR-○○	Insert (For AXD7000 type cutter)	L047, M144
XNMU16○○○○R-○S	Insert (For VFX5 type cutter)	L048, M222
XNMU19○○○○R-○S	Insert (For VFX6 type cutter)	L048, M226
XPGT○○○○PD○R-G○○	Insert (For BAP3500 type cutter)	L049
XPMT○○○○PDER-M○○	Insert (For BAP3500 type end mill)	L049

Z

ZCMX○○○○○○ER-○	Insert (For DCCC type end mill)	L049, M213
ZR type	Spare parts (For ZR type end mill)	Q038

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01-○	Insert (For brazed tools holder)	I002
1LA	HSS end mill	J379
1MA	HSS end mill	J378
02-○	Insert (For brazed tools holder)	I002
2LS	HSS end mill	J388
2MK	HSS end mill	J391
2MS	HSS end mill	J386
2SS	HSS end mill	J384
03-○	Insert (For brazed tools holder)	I002
3KD	Triangular shank drill, (Type 6.5)(Type 10)(Type 13)	P207
04-○	Insert (For brazed tools holder)	I002
4LC	HSS end mill	J400
4MC	HSS end mill	J398
05-○	Insert (For brazed tools holder)	I002
06-○	Insert (For brazed tools holder)	I002
07-○	Insert (For brazed tools holder)	I003
08-○	Insert (For brazed tools holder)	I003
09E1	Insert (For brazed tools holder)	I003
31-○	31 type brazed tools holder	I005
32-○	32 type brazed tools holder	I005
33-○	33 type brazed tools holder	I005
34-○	34 type brazed tools holder	I005
35-○	35 type brazed tools holder	I005
36-○	36 type brazed tools holder	I005
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47-◌	47 type brazed tools holder	I007
49-◌	49 type brazed tools holder	I007
51-◌	51 type brazed tools holder	I007
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GUN REAMER		P252
Arbors for screw-in tools		M269
Setting fixture		M268
GUN REAMER with diamond compound		P253

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SAFETY OF CUTTING TOOL PRODUCTS

1. Use of Cutting Tool Products

Packages of Mitsubishi products carry a safety warning label. However, tools are not labeled with detailed warning indications. Please read the "Safety of Cutting Tool Products" in this catalogue before handling cutting tool products and cemented carbide materials. Moreover, as a part of your workers' safety education, please notify the contents of the "Safety of Cutting Tool Products" to all workers.

2. Basic Characteristics of Hard Tool Materials

In Terms of "Safety of Cutting Tool Products"

Hard Tool Materials : General term for tool materials like cemented carbide alloy, cermet, ceramics, sintered CBN, sintered diamond, high speed steel and alloy steel, etc.

Physical Characteristics

Appearance : Varies depending on the type of material. Eg. grey, black, gold, etc.
Smell : None
Hardness, Specific Gravity :

Hard Tool Materials	Hardness (HV)	Specific Gravity	Hard Tool Materials	Hardness (HV)	Specific Gravity
High Speed Steel (HSS)	200－1200kg/mm²	7－9	Sintered CBN	2000－5000kg/mm²	3－5
Cemented Carbide	500－3000kg/mm²	9－16	Sintered Diamond	8000－12000kg/mm²	3－5
Cermet	500－3000kg/mm²	5－9	Alloy Steel	200－1200kg/mm²	7－9
Ceramics	1000－4000kg/mm²	2－7	Diamond Electroforming Product	8000－12000kg/mm²	3－5

Constituents

Carbide, nitride, carbon nitride, oxide, such as W, Ti, Al, Si, Ta, B, V and metals such as Fe, Co, Ni, Cr, Mo.

3. Safety of Cutting Tool Products

○Hard tool materials have a large specific gravity. Thus, they require special attention as heavy materials when the size or quantity is large.

○Cutting tool products generate dust and mist during grinding operations or heating. This dust and mist can be harmful when coming in contact with the eyes or skin, or if substantial quantities are swallowed. When grinding and machining, it is recommended to use local exhaust ventilation and respirators, a dust protective mask, glasses, gloves etc. If dust makes contact with the hands, thoroughly wash the affected area with soap and water. Don't eat in the exposed area, and wash hands thoroughly before eating. Remove dust from the clothing by a cleaning or washing, but don't shake off.

○Cobalt and nickel contained in carbide or other cutting tool materials are reported as possibly carcinogenic to humans. It is also reported that cobalt and nickel dust and mist can affect the skin, respiratory organs and heart through repeated or prolonged contact.

○For further information, please refer to Safety Data Sheet.

Home page: http://www.carbide.mht.co.th/download/safety

4. Handling Cutting Tool Products

○Surface conditions affect toughness of cutting tools. Therefore, use a diamond grinding wheel for finishing.

○Hard tool materials are extremely hard and brittle at the same time. Thus, they may be broken by shocks and tightening with excess force.

○Hard tool materials and ferrous materials have different thermal expansion ratios. Shrinkage or swell fit products may suffer from cracks when applied temperature is higher or lower than the appropriate temperature for the tool.

○Pay special attention on storing hard tool materials. Toughness of hard tool materials is lowered when they corrode due to coolant and other liquid.

○When brazing hard tool materials, if the temperature is too high or too low from the melting point of the brazing material, loosening and breakage may occur.

○After regrinding cutting tools, make sure that there are no cracks.

○Machining hard tool materials on EDM may cause cracks on the surface due to electrons remaining after the EDM operation, resulting in lowering of the toughness. Eliminate these cracks by grinding, etc.

SUGGESTIONS ON HOW TO USE CUTTING TOOLS

Products	Hazard	Countermeasure
All Cutting Tools	◎Cutting tools have sharp cutting edges. Handling them with bare hands may cause injuries.	★Take precautions such as wearing gloves especially when handling tools and during installation.
	◎Improper use of tools and application of inappropriate cutting conditions may cause the tool to break and be expelled from the machine providing risk of injury.	★Ensure safety guards and goggles are used. ★Refer to handling explanatory notes and catalogues. Use tools under recommended cutting conditions.
	◎Impact load and rapid increase of cutting resistance due to excessive wear may cause the tool to break and be expelled from the machine providing risk of injury.	★Ensure safety guards and goggles are used. ★Exchange tools before excessive wear occurs.
	◎Cutting tools and workpieces become extremely hot during cutting. Touching them with bare hands may cause burns.	★Take precautions such as wearing gloves.
	◎Expelled hot chips produced in cutting produces risk of injuries and burns.	★Ensure safety guards and goggles are used. ★During swarf removal and machine cleaning ensure the machine is stopped and wear gloves. Please use tools, such as cutting nippers and cutting clippers.
	◎In cutting, sparks, hot chips and heat generation caused by tool breakage provides a risk of igniting a fire.	★Avoid using cutting tools in places where there is a possibility of igniting a fire. ★In case of using non-water soluble oil, make sure to have a fire prevention countermeasure.
	◎Using machines, chucks, and tools with poor balance at high revolutions may cause tools to break providing risk of injuries.	★Ensure safety guards and goggles are used. ★Check the machine for vibration, chattering, and abnormal noise.
	◎Handling machined parts with burrs using bare hands may cause injuries.	★Wear gloves.
Indexable Inserts Type Tools	◎If inserts and spare parts are not held securely, they may become loose and be expelled producing risk of injuries.	★Clean insert locating seat and spare parts before setting inserts. ★Use the tool provided for setting inserts, and ensure the inserts and spare parts are clamped securely. Do not use the tool provided for things other than prescribed inserts and spare parts.
	◎Clamping inserts and spare parts too tightly by using tools such as extension pipes may cause them to break and be expelled.	★Do not use extra tools for more leverage. Only use the tool provided.
	◎When applying high cutting speed, spare parts and inserts may be expelled due to centrifugal force. Pay special attention on each safety guidline.	★Refer to the handling explanatory notes and catalogues. Use tools under recommended cutting conditions.
Cutters and Other Rotating Tools	◎Milling cutters have sharp edges. Handling them with bare hands may cause injuries.	★Take precautions such as wearing gloves.
	◎Poor balance or off center revolving of tools may cause vibration and chattering which could cause the tool to break and be expelled.	★Apply cutting speed within the range of recommended cutting conditions. ★Adjust accuracy and balance of spindles and bearings periodically to prevent off center revolving and chattering caused by wear on these parts.
Drilling Tools	◎Through cutting in cases when the workpiece revolves may produce a disk shaped peice with sharp edges when the cutting tool breaks through.	★Ensure safety guards and goggles are used. Also install a cover on the chuck.
	◎Drills with an extremely small diameter have a very sharp point which may puncture the skin if not handled carefully. If the drill breaks during cutting, the broken pieces may be expelled.	★Handle with care. Take precautions such as wearing gloves and goggles.
Brazed Tools	◎Weakening of the braze and breakage of inserts may cause injury.	★Before using them, ensure they are brazed securely. ★Do not use them under conditions which produce very high temperature.
Others	◎Machine and tools may be damaged if they are used for purposes other than the prescribed application.	★Use them strictly for the prescribed application.

INFORMATION

This catalogue completes the basic precautions for safety use of our company's products.
For further information, please refer to the guideline, catalogues or contact us. We are not responsible for any accidents causing by modifying tools without our permission.

HOW TO READ THE STANDARD OF TURNING INSERTS

●How this section page is organised

①Organised according to turning insert shape.
(Refer to the index on the next page.)
②Inserts are arranged in order of :
- Negative inserts (with hole|without hole)
- Positive inserts (with hole|without hole)

③Breakers are arranged in order of :
Finish Cutting→Light Cutting→Medium Cutting →Rough Cutting→Heavy Cutting

●Graph of chip control by work material

Shows recommended chip breakers and chip control range according to work material and cutting application.
Graphs are colored according to cutting applications (Finish→Light→Medium→Rough→Heavy) and contain recommended breakers for each application.

Finish Cutting : Light Cutting : Medium Cutting :
Rough Cutting : Heavy Cutting :

GRADE APPLICATION RECOMMENDED FOR EACH WORK MATERIAL
cutting conditions suitable for each type of work material is shown as a general guide to select the grade.
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

SHAPE & ANGLE MARK

INDICATION OF NEGATIVE/ POSITIVE TYPE

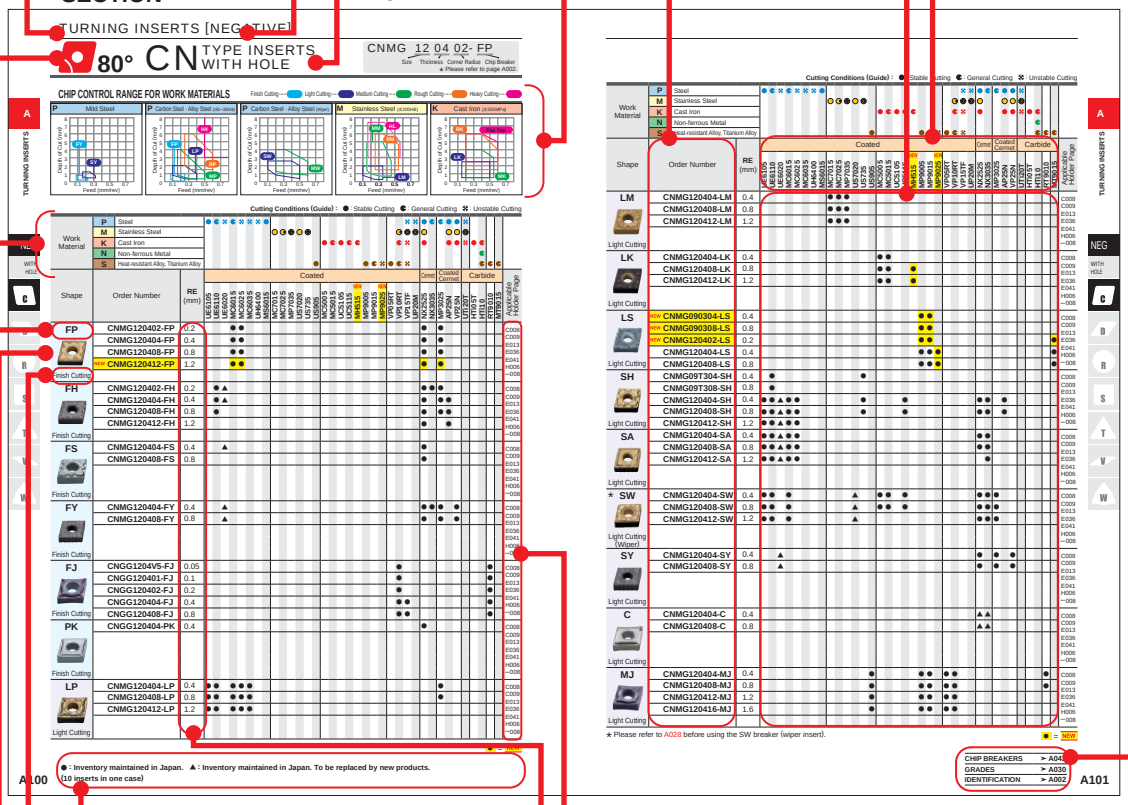
PRODUCT SECTION

TITLE OF PRODUCT ACCORDING TO THE INSERT TYPE

STOCK STATUS

INSERT GRADES

INSERT NUMBER



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

CUTTING APPLICATION
is shown in order of: Finish|Light →Medium→Rough→Heavy.

PHOTO OF INSERT

INDICATION OF CHIPBREAKER
indicates the designation for a chipbreaker.

PAGE REFERENCE
·CHIP BREAKERS
·GRADES
·TECHNICAL DATA
indicates reference pages, on the right hand page of each double-page spread.

APPLICABLE HOLDER PAGE
indicates reference pages for details of applicable holders.

INSERT CORNER RADIUS (RE)

●To Order : Please specify
①insert number and ②grade.

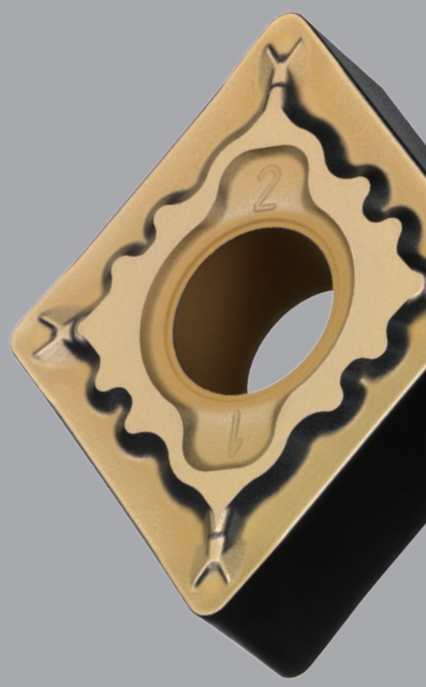
TURNING TOOLS

INSERT STANDARDS
INSERT GRADES

IDENTIFICATION ····· A002
HOLE GEOMETRY ····· A004
PRECISION BREAKER SYSTEM ····· A006
TOOL NAVI ····· A009
OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING ··· A010
PRECISION BREAKER SYSTEM ····· A026
WIPER INSERT ····· A028
GRADES FOR TURNING ····· A030
TURNING APPLICATION RANGE ····· A031
COATED CARBIDE (CVD) ····· A034
COATED CARBIDE (PVD) ····· A036
CERMET ····· A037
COATED CERMET ····· A038
CEMENTED CARBIDE ····· A039
MICRO-GRAIN CEMENTED CARBIDE ····· A040
CLASSIFICATION OF INSERTS ····· A042
RECOMMENDED CUTTING CONDITIONS ····· A076

STANDARD OF INSERTS

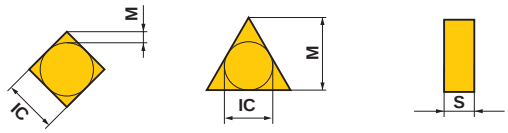
NEGATIVE INSERTS WITH HOLE
CN○○TYPE···RHOMBIC 80° ····· A100
DN○○TYPE···RHOMBIC 55° ····· A107
RN○○TYPE···ROUND ····· A114
SN○○TYPE···SQUARE 90° ····· A115
TN○○TYPE···TRIANGULAR 60° ····· A121
VN○○TYPE···RHOMBIC 35° ····· A128
WN○○TYPE···TRIGON 80° ····· A132
NEGATIVE INSERTS WITHOUT HOLE
CN○○TYPE···RHOMBIC 80° ····· A137
SN○○TYPE···SQUARE 90° ····· A138
TN○○TYPE···TRIANGULAR 60° ····· A139
POSITIVE INSERTS WITH HOLE
CC○○TYPE···RHOMBIC 80° ····· A140
CP○○TYPE···RHOMBIC 80° ····· A148
DC○○TYPE···RHOMBIC 55° ····· A149
DE○○TYPE···RHOMBIC 55° ····· A155
RC○○TYPE···ROUND ····· A156
SC○○TYPE···SQUARE 90° ····· A157
SP○○TYPE···SQUARE 90° ····· A159
TC○○TYPE···TRIANGULAR 60° ····· A160
TE○○TYPE···TRIANGULAR 60° ····· A163
TP○○TYPE···TRIANGULAR 60° ····· A164
VB○○TYPE···RHOMBIC 35° ····· A167
VC○○TYPE···RHOMBIC 35° ····· A170
VD○○TYPE···RHOMBIC 35° ····· A173
VP○○TYPE···RHOMBIC 35° ····· A174
WB○○TYPE···TRIGON 80° ····· A175
WC○○TYPE···TRIGON 80° ····· A176
WP○○TYPE···TRIGON 80° ····· A177
XC○○TYPE···RHOMBIC 25° ····· A178
POSITIVE INSERTS WITHOUT HOLE
RTG TYPE ····· A179
SP○○TYPE···SQUARE 90° ····· A180
TC○○TYPE···TRIANGULAR 60° ····· A181
TP○○TYPE···TRIANGULAR 60° ····· A182

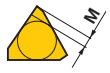


IDENTIFICATION

Symbol	Insert Shape
H	Hexagonal
O	Octagonal
P	Pentagonal
S	Square
T	Triangular
C	Rhombic 80°
D	Rhombic 55°
E	Rhombic 75°
F	Rhombic 50°
M	Rhombic 86°
V	Rhombic 35°
W	Trigon
L	Rectangular
A	Parallelogram 85°
B	Parallelogram 82°
K	Parallelogram 55°
R	Round
X	Special Design

① Insert Shape





Triangular insert with a facet (Secondary Cutting Edge)

③ Tolerance Class

Symbol	Tolerance of Nose Height **M** (mm)	Tolerance of Inscribed Circle **IC** (mm)	Tolerance of Thickness **S** (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05−±0.15	±0.025
K*	±0.013	±0.05−±0.15	±0.025
L*	±0.025	±0.05−±0.15	±0.025
M*	±0.08−±0.18	±0.05−±0.15	±0.13
N*	±0.08−±0.18	±0.05−±0.15	±0.025
U*	±0.13−±0.38	±0.08−±0.25	±0.13

The surface of insert with * mark is sintered.

Detail of M Class Insert Tolerance

●Tolerance of Nose Height **M** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.08	±0.08	±0.08	±0.11	±0.16	–
9.525	±0.08	±0.08	±0.08	±0.11	±0.16	–
12.70	±0.13	±0.13	±0.13	±0.15	–	–
15.875	±0.15	±0.15	±0.15	±0.18	–	–
19.05	±0.15	±0.15	±0.15	±0.18	–	–
25.40	–	±0.18	–	–	–	–
31.75	–	±0.20	–	–	–	–

●Tolerance of Inscribed Circle **IC** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.05	±0.05	±0.05	±0.05	±0.05	–
9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
12.70	±0.08	±0.08	±0.08	±0.08	–	±0.08
15.875	±0.10	±0.10	±0.10	±0.10	–	±0.10
19.05	±0.10	±0.10	±0.10	±0.10	–	±0.10
25.40	–	±0.13	–	–	–	±0.13
31.75	–	±0.15	–	–	–	±0.15

③ Tolerance Class

① ③

C N M G

② ④

② Normal Clearance

Symbol	Normal Clearance
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Other Normal Clearance

Major Normal Clearance

④ Fixing and/or for Chip Breaker

Metric

Symbol	Hole	Hole Configuration	Chip Breaker	Figure	Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole + One Countersink (40−60°)	No		A	With Hole	Cylindrical Hole	No	
T	With Hole		One Sided		M	With Hole	Cylindrical Hole	Single Sided	
Q	With Hole	Cylindrical Hole + Double Countersink (40−60°)	No		G	With Hole	Cylindrical Hole	Double Sided	
U	With Hole		Double Sided		N	Without Hole	–	No	
B	With Hole	Cylindrical Hole + One Countersink (70−90°)	No		R	Without Hole	–	Single Sided	
H	With Hole		One Sided		F	Without Hole	–	Double Sided	
C	With Hole	Cylindrical Hole + Double Countersink (70−90°)	No		X	–	–	–	Special Design
J	With Hole		Double Sided						

Symbol							Diameter of Inscribed Circle (mm)
R	W	V	D	C	S	T	
	02		04	03	03	06	3.97
	L3	08	05	04	04	08	4.76
	03	09	06	05	05	09	5.56
06							6.00
	04	11	07	06	06	11	6.35
	05	13	09	08	07	13	7.94
08							8.00
09	06	16	11	09	09	16	9.525
10							10.00
12							12.00
12	08	22	15	12	12	22	12.70
15	10		19	16	15	27	15.875
16							16.00
19	13		23	19	19	33	19.05
20							20.00
			27	22	22	38	22.225
25							25.00
25			31	25	25	44	25.40
31			38	32	31	54	31.75
32							32.00

⑤ Insert Size

*Thickness is from the bottom of the insert to the top of the cutting edge.

Symbol	Thickness (mm)
S1	1.39
01	1.59
T0	1.79
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

⑥ Insert Thickness

⑤	⑥	⑦	⑧	⑨	⑩
12	04	08	(E)	(N)-	MP

⑦ Insert Corner Configuration

Symbol	Corner Radius (mm)
00	Sharp Nose
V3	0.03
V5	0.05
01	0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2
00 : Inch M0 : Metric	Round Insert

⑧ Cutting Edge Symbol

Figure	Feature	Symbol
	Sharp Cutting Edges	F
	Round Cutting Edges	E
	Chamfered Cutting Edges	T
	Chamfered and Rounded Cutting Edges	S
–	(-) Corner R tolerance	M

Mitsubishi Materials omit the honing symbol.

⑨ Cutting Direction

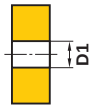
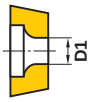
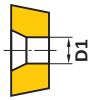
Figure	Hand	Symbol
	Right	R
	Left	L
	Neutral	N

⑩ Chip Breaker

LP	MP	RP
LM	MM	RM
LK	MK	RK
LS	MS	RS
FP	LP	MP
MA	SW	MW
HZ	HX	HV

The above table shown as reference example.

HOLE GEOMETRY

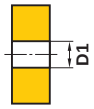
Type A	Type B	Type C	Type D
			

NEGATIVE

Insert Number		Dimensions (mm) D1	Hole Type
CNGA CNGG CNGM CNMA CNMG CNMM CNMP	0903○○	3.81	A
	09T3○○	3.81	A
	0904○○	3.81	A
	1204○○	5.16	A
	1606○○	6.35	A
	1906○○	7.93	A
	2509○○	9.12	A
DNGA DNGG DNGM DNMA DNMG DNMM DNMX	1104○○	3.81	A
	1504○○	5.16	A
	1506○○	5.16	A
SNGA SNGG SNMA SNMG SNMM	0903○○	3.81	A
	1204○○	5.16	A
	1506○○	6.35	A
	1906○○	7.93	A
	2507○○	9.12	A
	2509○○	9.12	A
TNGA TNGG TNGM TNMA TNMG TNMM TNMX	1103○○	2.26	A
	1603○○	3.81	A
	1604○○	3.81	A
	2204○○	5.16	A
	2706○○	6.35	A
	3309○○	7.93	A
VNGA VNGM VNGG VNMA VNMG VNMM	1604○○	3.81	A
WNGA WNMA WNMG	0603○○	3.81	A
	06T3○○	3.81	A
	0604○○	3.81	A
	0804○○	5.16	A
	1006○○	6.35	A
RNMG	090300	3.81	A
	120400	5.16	A
	150600	6.35	A
	190600	7.93	A
	250900	9.12	A
	310900	12.7	A

POSITIVE

Insert Number		Dimensions (mm) D1	Hole Type
CCET	0602○○	2.8	B
	09T3○○	4.4	B
CCGB CCMB CCGH CCMH	0602○○	2.8	B
CCGT	03S1○○	2.0	B
	04T0○○	2.4	B
	0602○○	2.8	B
	09T3○○	4.4	B
	1204○○	5.5	B
CCMT	0602○○	2.8	B
	0803○○	3.4	B
	09T3○○	4.4	B
	1204○○	5.5	B
CCGW CCMW	03S1○○	2.0	B
	04T0○○	2.4	B
	0602○○	2.8	B
	09T3○○	4.4	B
	1204○○	5.5	B
CPGT	0802○○	3.4	B
	0903○○	4.4	B
CPGB CPMB CPMH	0802○○	3.5	D
	0903○○	4.5	D
CPMX	0802○○	3.5	D
	0903○○	4.6	D
DCET DCGT	0702○○	2.8	B
	11T3○○	4.4	B
DCGW DCMW DCMT	0702○○	2.8	B
	11T3○○	4.4	B
	1504○○	5.5	B
DEGX	1504○○	5.1	C
RCMX	1003M0	3.6	D
	1204M0	4.2	D
	1606M0	5.2	D
	2006M0	6.5	D
	2507M0	7.2	D
	3209M0	9.5	D

Type A	Type B	Type C	Type D
			

POSITIVE

Insert Number		Dimensions (mm) D1	Hole Type
RCGT RCMT	0602M0	2.8	B
	0803M0	3.4	B
	10T3M0	4.4	B
SCMT SCMW	09T3○○	4.4	B
	1204○○	5.5	B
SPMW	0903○○	4.6	B
	1203○○	5.7	B
SPMT	0903○○	4.4	B
	1203○○	5.5	B
SPGX	0903○○	4.8	D
	1203○○	5.9	D
TCGT TCMT TCGW TCMW	0601○○	2.3	B
	0802○○	2.3	B
	0902○○	2.5	B
	1102○○	2.8	B
	1303○○	3.4	B
	16T3○○	4.4	B
TEGX	1603○○	4.4	D
TPGX	0802○○	2.5	C
	0902○○	3.0	C
	1103○○	3.5	C
	1603○○	4.8	D
	1604○○	4.8	D
TPMX	0802○○	2.7	C
	0902○○	3.2	C
	1103○○	3.7	C
	1103○○R/L	3.5	C
	1603○○	4.8	D
TPGB TPMB TPGH TPMH	0802○○	2.4	D
	0902○○	2.9	D
	1103○○	3.4	D
	1603○○	4.4	D
TPGT	1603○○	4.4	B
TPGV	0902○○	2.8	B
	1103○○	3.4	B

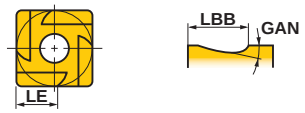
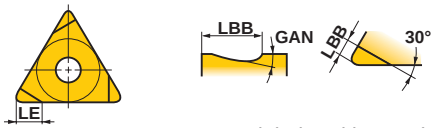
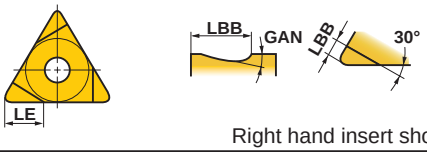
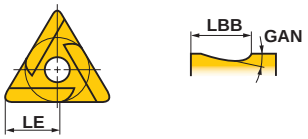
Insert Number		Dimensions (mm) D1	Hole Type
VBET VBGT VBMT VBGW	1103○○	2.9	B
	1604○○	4.4	B
VCGT VCMT VCGW VCMW	0802○○	2.4	B
	1103○○	2.8	B
	1303○○	3.4	B
	1604○○	4.4	B
VPET VPGT	0802○○	2.42	B
	1103○○	2.85	B
VDGX	1603○○	4.5	D
WBGT WBMT	0201○○	2.3	B
	L302○○	2.3	B
WCGT WCMT WCGW WCMW	0201○○	2.3	B
	L302○○	2.3	B
	0402○○	2.8	B
	06T3○○	4.4	B
WPGT WPMT	0402○○	2.8	B
	0603○○	4.4	B
XCMT	1503○○	2.8	B

PRECISION BREAKER SYSTEM

STANDARD OF INSERTS WITH HAND OF TOOL

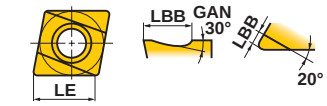
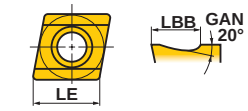
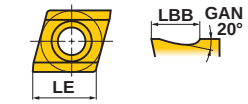
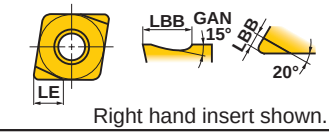
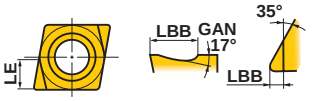
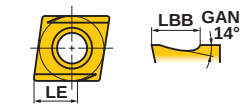
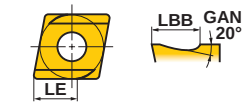
●NEGATIVE INSERTS

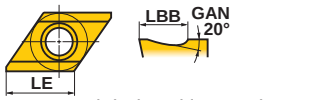
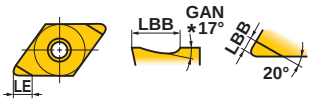
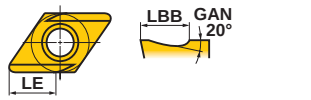
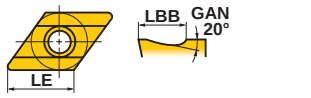
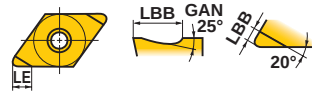
Unit : mm

Geometry	Insert Number	LBB	LE	GAN
Right hand insert shown.	DNGG150404R/L	2.8	14.9	15
	DNGG150408R/L	2.8	14.3	15
	DNGG150604R/L	2.8	14.9	15
	DNGG150608R/L	2.8	14.3	15
 Right hand insert shown.	SNGG090304R/L	1.8	1.6	15
	SNGG090308R/L	1.8	1.6	15
	SNGG120404R/L	2.3	3.7	15
	SNGG120408R/L	2.3	3.7	15
 Right hand insert shown.	TNGG160402R/L-FS	1.3	2.7	15
	TNGG160404R/L-FS	1.3	2.8	15
	TNGG160408R/L-FS	1.3	3.1	15
 Right hand insert shown.	TNGG160402R/L-F	2.5	5.1	15
	TNGG160404R/L-F	2.5	5.2	15
	TNGG160408R/L-F	2.5	5.5	15
Right hand insert shown.	TNGG160402R/L-K	1.5	7.1	15
	TNGG160404R/L-K	1.5	5.4	15
	TNGG160408R/L-K	1.5	5.1	15
 Right hand insert shown.	TNGG110302R/L	1.3	3.2	15
	TNGG110304R/L	1.3	3.0	15
	TNGG110308R/L	1.3	2.7	15
	TNGG160304R/L	2.3	5.4	15
	TNGG160402R/L	1.3	8.7	15
	TNGG160404R/L	2.3	5.4	15
	TNGG160408R/L	2.3	5.1	15
	TNGG220404R/L	2.8	9.4	15
	TNGG220408R/L	2.8	9.1	15
Right hand insert shown.	VNGG160404R/L	1.8	15.6	15
Right hand insert shown.	VNGG160402R/L-F	2.5	7.4	15
	VNGG160404R/L-F	2.5	7.6	15

●POSITIVE INSERTS

Unit : mm

Geometry	Insert Number	LBB	LE
 Right hand insert shown.	CCET0602V3R/L-SR	2.2	6.4
	CCET060201R/L-SR	2.2	6.3
	CCET060202R/L-SR	2.2	6.2
	CCET060204R/L-SR	2.2	6.0
	CCET09T3V3R/L-SR	3.2	9.6
	CCET09T301R/L-SR	3.2	9.5
	CCET09T302R/L-SR	3.2	9.4
	CCET09T304R/L-SR	3.2	9.2
 Right hand insert shown.	CCET060200R/L-SN	1.0	6.4
	CCET0602V3R/L-SN	1.0	6.4
	CCET060201R/L-SN	1.0	6.3
	CCET060202R/L-SN	1.0	6.2
	CCET060204R/L-SN	1.0	6.0
	CCET09T300R/L-SN	1.5	9.6
	CCET09T3V3R/L-SN	1.5	9.6
	CCET09T301R/L-SN	1.5	9.5
	CCET09T302R/L-SN	1.5	9.4
	CCET09T304R/L-SN	1.5	9.2
 Right hand insert shown.	CCET0602V3R/LW-SN	1.0	6.4
	CCET09T3V3R/LW-SN	1.5	9.6
 Right hand insert shown.	CCGH060202(M)R/L-F	1.2	3.6
	CCGH060204(M)R/L-F	1.4	4.4
 Left hand insert shown.	CCGT03S1V3L-F	0.8	1.4
	CCGT03S101(M)R/L-F	0.8	1.4
	CCGT03S102(M)R/L-F	0.8	1.5
	CCGT03S104(M)R/L-F	0.8	1.6
	CCGT04T0V3L-F	1.0	1.7
	CCGT04T001(M)R/L-F	1.0	1.8
	CCGT04T002(M)R/L-F	1.0	1.8
	CCGT04T004(M)R/L-F	1.0	2.0
 Right hand insert shown.	CCGT0602V3R/L-SS	1.0	3.0
	CCGT060201(M)R/L-SS	1.0	3.0
	CCGT060202(M)R/L-SS	1.0	3.0
	CCGT09T3V3R/L-SS	1.0	5.0
	CCGT09T301(M)R/L-SS	1.0	5.0
	CCGT09T302(M)R/L-SS	1.0	5.0
	CCGT09T304MR/L-SS	1.0	5.0
 Right hand insert shown.	CCGT0602V3R-SN	1.0	3.0
	CCGT060201(M)R/L-SN	1.0	3.0
	CCGT060202(M)R/L-SN	1.0	3.0
	CCGT09T3V3R/L-SN	1.5	5.0
	CCGT09T301(M)R/L-SN	1.5	5.0
	CCGT09T302(M)R/L-SN	1.5	5.0
	CCGT09T304(M)R/L-SN	1.5	5.0
Right hand insert shown.	CPGT080204R/L-F	1.8	5.5
	CPGT090302R/L-F	1.8	5.4
	CPGT090304R/L-F	1.8	5.5

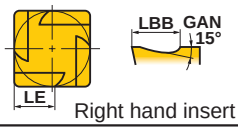
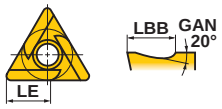
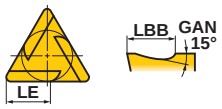
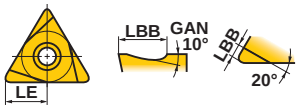
Geometry	Insert Number	LBB	LE
Right hand insert shown.	DCET0702V3R/L-SR	2.5	7.7
	DCET070201R/L-SR	2.5	7.6
	DCET070202R/L-SR	2.5	7.4
	DCET070204R/L-SR	2.5	7.1
	DCET11T3V3R/L-SR	3.7	11.6
	DCET11T301R/L-SR	3.7	11.4
	DCET11T302R/L-SR	3.7	11.3
	DCET11T304R/L-SR	3.7	11.0
Right hand insert shown.	DCET070200R/L-SN	1.0	7.7
	DCET0702V3R/L-SN	1.0	7.7
	DCET070201R/L-SN	1.0	7.6
	DCET070202R/L-SN	1.0	7.4
	DCET070204R/L-SN	1.0	7.1
	DCET11T300R/L-SN	1.5	11.6
	DCET11T3V3R/L-SN	1.5	11.6
	DCET11T301R/L-SN	1.5	11.4
	DCET11T302R/L-SN	1.5	11.3
	DCET11T304R/L-SN	1.5	11.0
 Right hand insert shown.	DCET0702V3R/LW-SN	1.0	7.7
	DCET11T3V3R/LW-SN	1.5	11.6
 *DCGT11T3○○type : 14° Right hand insert shown.	DCGT070202R/L-F	1.0	3.0
	DCGT070204R/L-F	1.0	3.2
	DCGT11T302R/L-F	1.0	3.0
	DCGT11T304R/L-F	1.0	3.2
Right hand insert shown.	DCGT0702V3R/L-SS	1.0	3.5
	DCGT070201R/L-SS	1.0	3.5
	DCGT070202(M)R/L-SS	1.0	3.5
	DCGT11T3V3R-SS	1.0	6.5
	DCGT11T301(M)R/L-SS	1.0	6.5
	DCGT11T302(M)R/L-SS	1.0	6.5
	DCGT11T304MR/L-SS	1.0	6.5
 Right hand insert shown.	DCGT0702V3R-SN	1.0	3.5
	DCGT070201(M)R/L-SN	1.0	3.5
	DCGT070202(M)R/L-SN	1.0	3.5
	DCGT11T3V3R/L-SN	1.5	6.5
	DCGT11T301(M)R/L-SN	1.5	6.5
	DCGT11T302(M)R/L-SN	1.5	6.5
	DCGT11T304(M)R/L-SN	1.5	6.5
 Right hand insert shown.	DEGX150402R/L	2.8	15.2
	DEGX150404R/L	2.8	14.9
 Right hand insert shown.	DEGX150402R/L-F	2.5	7.4
	DEGX150404R/L-F	2.5	7.6

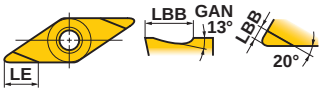
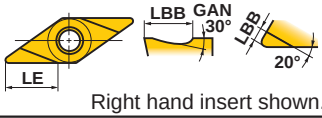
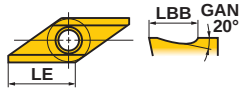
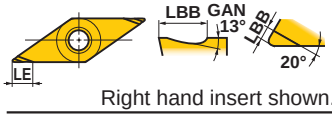
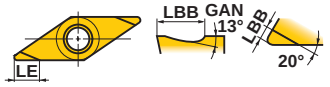
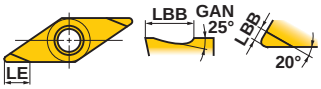
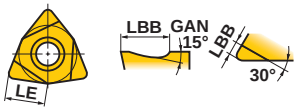
PRECISION BREAKER SYSTEM

STANDARD OF INSERTS WITH HAND OF TOOL

●POSITIVE INSERTS

Unit : mm

Geometry	Insert Number	LBB	LE
 Right hand insert shown.	SPGR090304R	1.8	1.6
Left hand insert shown.	TCGT0601V3L-F	1.0	2.9
	TCGT060101L-F	1.0	3.0
	TCGT060102R/L-F	1.0	3.0
	TCGT060104R/L-F	1.0	3.2
 Right hand insert shown.	TEGX160302R/L	2.0	6.0
	TEGX160304R/L	2.0	6.0
★TPGH1603□□type : 14° Right hand insert shown.	TPGH080202R/L-FS	0.9	2.7
	TPGH080204R/L-FS	0.9	2.9
	TPGH090202R/L-FS	1.0	3.0
	TPGH090204R/L-FS	1.0	3.2
	TPGH110302R/L-FS	1.4	4.2
	TPGH110304R/L-FS	1.4	4.4
	TPGH160304R/L-FS	2.0	6.1
	TPGH160308R/L-FS	2.0	6.5
 Right hand insert shown.	TPGR110304R/L	1.3	3.0
	TPGR160304R/L	2.3	5.4
	TPGR160308R/L	2.3	5.1
 Right hand insert shown.	TPGX080202R/L	1.3	3.9
	TPGX080204R/L	1.3	4.1
	TPGX090202R/L	1.6	4.8
	TPGX090204R/L	1.6	5.0
	TPGX090208R/L	1.4	4.7
	TPGX110302L	1.8	5.4
	TPGX110304R/L	1.8	5.5
	TPGX110308R/L	1.8	5.9

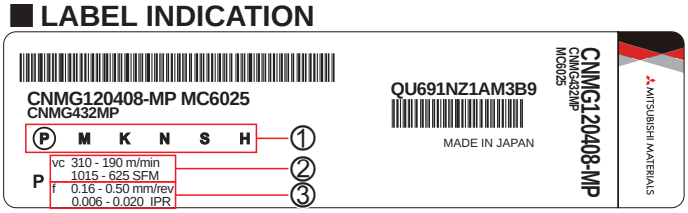
Geometry	Insert Number	LBB	LE
 Right hand insert shown.	VBGT110302R/L-F	1.0	3.0
	VBGT110304R/L-F	1.0	3.2
	VBGT160402R/L-F	1.5	4.5
	VBGT160404R/L-F	1.5	4.7
 Right hand insert shown.	VBET1103V3R/L-SR	2.5	7.3
	VBET110301R/L-SR	2.5	7.3
	VBET110302R/L-SR	2.5	7.4
	VBET110304R/L-SR	2.5	7.6
Right hand insert shown.	VBET110300R/L-SN	1.0	11.0
	VBET1103V3R/L-SN	1.0	11.0
	VBET110301R/L-SN	1.0	10.8
	VBET110302R/L-SN	1.0	10.5
	VBET110304R/L-SN	1.0	11.0
 Right hand insert shown.	VBET1103V3R/LW-SN	1.0	11.0
 Right hand insert shown.	VPET080201R-SRF	0.8	2.4
	VPET080202R-SRF	0.8	2.5
	VPET1103V3R-SRF	1.0	2.9
	VPET110301R-SRF	1.0	3.0
	VPET110302R-SRF	1.0	3.0
 Right hand insert shown.	VCGT080202R/L-F	0.8	2.5
	VCGT080204R/L-F	0.8	2.6
 Right hand insert shown.	VDGX160302R/L	2.0	6.0
	VDGX160304R/L	2.0	6.1
Right hand insert shown.	WBGT0201V3L-F	1.0	2.0
	WBGT020101L-F	1.0	2.0
	WBGT020102L-F	1.0	2.1
	WBGT020104L-F	1.0	2.2
	WBGTL302V3L-F	1.0	2.0
	WBGTL30201L-F	1.0	2.0
	WBGTL30202R/L-F	1.0	2.1
	WBGTL30204R/L-F	1.0	2.2
 Right hand insert shown.	WCGT020102R/L	1.0	2.1
	WCGT020104R/L	1.0	2.2
	WCGTL30202L	1.0	2.1
	WCGTL30204L	1.0	2.2
Right hand insert shown.	WPGT040204R/L-FS	1.0	3.2
	WPGT060304R/L-FS	1.0	3.2

TOOL NAVI

■ OUTLINE

TOOL NAVI supports our customers with information and suitable cutting conditions for each work material by selecting an optimal indexable insert together with the optional tool.

■ LABEL INDICATION



*1 The above is an example. There may be inserts recommended for multiple work materials.
*2 Please contact us for recommended cutting conditions using coefficient values other than the above.

① Work materials

P : Steel (Material reference : Carbon steel, alloy steel 180HB)
M : Stainless steel (Material reference : Austenitic stainless steel 180HB)
K : Cast iron (Material reference : Gray cast iron, ductile cast iron 180HB)
N : Aluminium alloy, non-ferrous metal
S : Material reference : Titanium alloy 320HB, Ni, Co-Based Alloy 400HB
H : Hardened steel 60HRC

② Cutting speed standards

Work Material	Tool Life		Work Material	Hardness
	Life	Performance		
P	90min	15min	Carbon steel, alloy steel	180HB
M	90min	15min	Stainless steel	180HB
K	90min	15min	Cast iron	180HB
S	25min	5min	Titanium alloy	320HB
			Ni, Co-Based alloy	400HB
H	80min	10min	Hardened steel	60HRC

*3. N :Life based on each grade. For stable choose the performance cutting speed and for unstable choose the tool life feed rate.
*4. The tool life is based on the following (VB wear). Some materials include elements other than this.
PMKS ··· VB=0.3mm
H ··· VB=0.1mm

③ Feed rate

Minimum and maximum feed rate settings are based on the chip control range of the chip breaker.

■ TOOL LIFE

Cutting speed has a large affect on tool life. TOOL NAVI is based on Taylor's equation (relationship vc T^n=C between tool grade, cutting conditions, and tool life). Therefore, performance speed and tool life is found for each work material. When the customer requires a different tool life, obtain coefficient values of the grade you use from the charts below. Multiply the coefficient values by the cutting speed to calculate a new cutting speed.

● P Grade (Steel) cutting speed coefficient values.

Grade \ Tool Life	15min	30min	45min	60min	90min
UE6105	1.00	0.79	0.69	0.63	0.55
MC6015	1.00	0.82	0.72	0.67	0.59
MC6025	1.00	0.83	0.75	0.69	0.62
MC6035	1.00	0.88	0.82	0.78	0.73
MP3025	1.00	0.85	0.77	0.72	0.65
NX2525	1.00	0.87	0.80	0.76	0.70

● M Grade (Stainless Steel) cutting speed coefficient values.

Grade \ Tool Life	15min	30min	45min	60min	90min
MC7015	1.00	0.83	0.75	0.70	0.63
MC7025	1.00	0.90	0.84	0.80	0.75
MP7035	1.00	0.84	0.76	0.71	0.62
US735	1.00	0.78	0.68	0.61	0.53

● K Grade (Cast Iron) cutting speed coefficient values.

Grade \ Tool Life	15min	30min	45min	60min	90min
MC5005	1.00	0.83	0.75	0.70	0.63
MC5015	1.00	0.83	0.75	0.69	0.62

(ex.) Medium cutting of steel
The 1st recommendation : MC6025
Indexable inserts : CNMG120408-MP
Recommended cutting speed : vc=310m/min
(Tool life : 15min.)

⬇

Tool life required by the customer : 30min.

310×0.83≒257m/min

■ HARDNESS OF THE WORK MATERIAL

Hardness of the work material also affects tool life. Mitsubishi's TOOL NAVI suggests cutting speed variations when hardness differs. Obtain the suitable coefficient value for each type of work material from the chart below. Multiply the coefficient value by the recommended cutting speed of the grade you use to calculate a new cutting speed.

Work Material	Soft ← (Hardness of Workpiece) → Hard											
	120HB	140HB	160HB	180HB	200HB	220HB	240HB	260HB	280HB	300HB	320HB	340HB
P	1.34	1.19	1.08	1.00	0.92	0.85	0.80	0.75	0.71	0.68	0.64	0.61
M	1.41	1.23	1.10	1.00	0.91	0.85	0.78	0.72	0.68	0.64	0.61	0.58
K	1.27	1.19	1.09	1.00	0.97	0.91	0.88	0.85	0.81	0.78	0.75	0.72

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING

●Selection of optimum inserts for turning

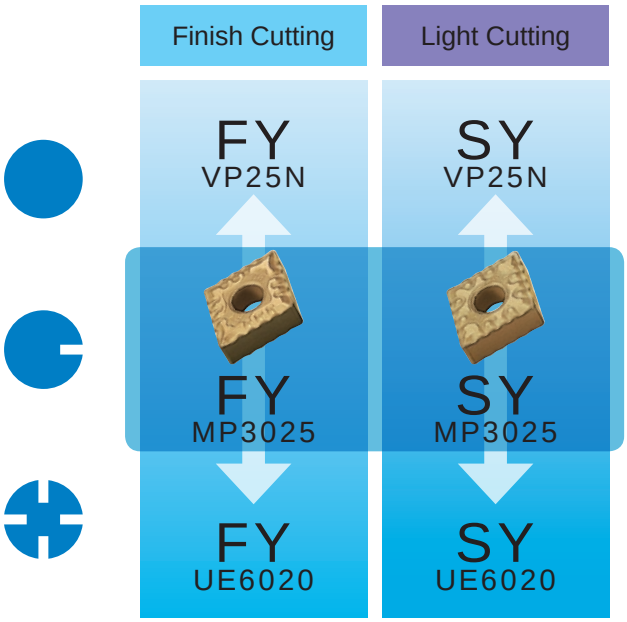
The following diagrams show for each type of work material, the optimal combination of suitable grades and chip breakers for each application area in turning.

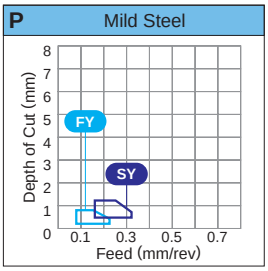
■CUTTING CONDITIONS

Stable Cutting	Continuous Cutting Constant Depth of Cut Pre-Machined Securely Clamped Component Cutting
General Cutting	
Unstable Cutting	Heavy Interrupted Cutting Irregular Depth of Cut Low Clamping Rigidity Cutting

■CUTTING AREA

F	Finish Cutting
L	Light Cutting
M	Medium Cutting
R	Rough Cutting
H	Heavy Cutting



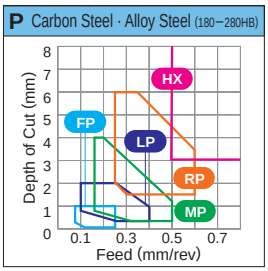


P Mild Steel (Ex : SS400, S10C)

NEGATIVE INSERTS

vc : Cutting Speed
f : Feed
ap : Depth of Cut

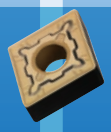
	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FY	VP25N	285−450	0.09−0.23	0.20−0.80
	L	SY	VP25N	260−410	0.16−0.33	0.50−1.20
General Cutting	F	FY	MP3025	275−425	0.09−0.23	0.20−0.80
	L	SY	MP3025	255−385	0.16−0.33	0.50−1.20
Unstable Cutting	F	FY	UE6020	285−465	0.09−0.23	0.20−0.80
	L	SY	UE6020	260−425	0.16−0.33	0.50−1.20



●	Stable Cutting
◔	General Cutting
✚	Unstable Cutting

F	Finish Cutting
L	Light Cutting
M	Medium Cutting
R	Rough Cutting
H	Heavy Cutting

	Finish Cutting	Light Cutting	Medium Cutting	Rough Cutting	Heavy Cutting
●	FP NX2525	LP MC6015	MP MC6015	RP MC6015	HX MC6025
◔	FP MP3025	LP MC6015	MP MC6015	RP MC6015	HX MC6025
✚	FP MC6025	LP MC6025	MP MC6025	RP MC6025	HX MC6035



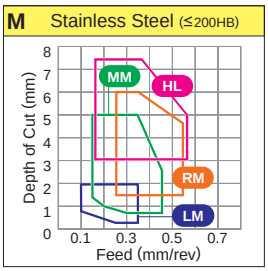
P Carbon Steel • Alloy Steel (Ex : S45C, SCM440)

NEGATIVE INSERTS

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
● Stable Cutting	F	FP	NX2525	210–300	0.08–0.25	0.10–1.00
	L	LP	MC6015	210–360	0.10–0.40	0.30–2.00
	M	MP	MC6015	195–330	0.16–0.50	0.30–4.00
	R	RP	MC6015	185–310	0.25–0.60	1.50–6.00
	H	HX	MC6025	165–265	0.50–1.26	3.00–11.00
◔ General Cutting	F	FP	MP3025	215–330	0.08–0.25	0.10–1.00
	L	LP	MC6015	210–360	0.10–0.40	0.30–2.00
	M	MP	MC6015	195–330	0.16–0.50	0.30–4.00
	R	RP	MC6015	185–310	0.25–0.60	1.50–6.00
	H	HX	MC6025	165–265	0.50–1.26	3.00–11.00
✚ Unstable Cutting	F	FP	MC6025	230–375	0.08–0.25	0.10–1.00
	L	LP	MC6025	210–345	0.10–0.40	0.30–2.00
	M	MP	MC6025	195–315	0.16–0.50	0.30–4.00
	R	RP	MC6025	185–295	0.25–0.60	1.50–6.00
	H	HX	MC6035	140–200	0.50–1.26	3.00–11.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



●	Stable Cutting
◐	General Cutting
✚	Unstable Cutting

L	Light Cutting
M	Medium Cutting
R	Rough Cutting

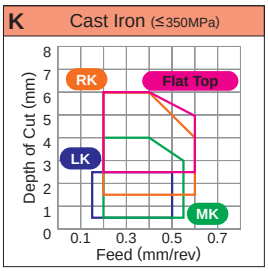
	Light Cutting	Medium Cutting	Rough Cutting	Heavy Cutting
●	LM MC7015	MM MC7015	RM MC7015	HL US735
◐	LM MC7025	MM MC7025	RM MC7025	HL US735
✚	LM MP7035	MM MP7035	RM MP7035	HL US735

M Stainless Steel (Ex : SUS304, SUS316)

NEGATIVE INSERTS

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	L	LM	MC7015	180—285	0.10—0.30	0.30—2.00
	M	MM	MC7015	160—260	0.15—0.45	0.70—5.00
	R	RM	MC7015	155—245	0.25—0.55	1.50—6.00
	H	HL	US735	75—140	0.40—1.00	1.50—8.00
General Cutting	L	LM	MC7025	165—220	0.10—0.30	0.30—2.00
	M	MM	MC7025	150—200	0.15—0.45	0.70—5.00
	R	RM	MC7025	140—190	0.25—0.55	1.50—6.00
	H	HL	US735	75—140	0.40—1.00	1.50—8.00
Unstable Cutting	L	LM	MP7035	95—155	0.10—0.30	0.30—2.00
	M	MM	MP7035	90—145	0.15—0.45	0.70—5.00
	R	RM	MP7035	85—135	0.25—0.55	1.50—6.00
	H	HL	US735	75—140	0.40—1.00	1.50—8.00



●	Stable Cutting
◐	General Cutting
✚	Unstable Cutting

L	Light Cutting
M	Medium Cutting
R	Rough Cutting
H	Heavy Cutting

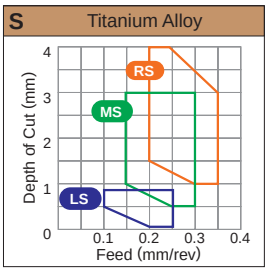
K Cast Iron • Ductile Cast Iron (Ex : FC300)

NEGATIVE INSERTS

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	Grade	1st Recommendation vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	L	LK	MC5005	230—365	0.10—0.40	0.30—2.00
	M	MK	MC5005	210—335	0.20—0.55	1.00—4.00
	R	RK	MC5005	195—315	0.25—0.60	1.50—6.00
	H	Flat Top	MC5005	195—315	0.20—0.60	2.50—6.00
General Cutting	L	LK	MC5015	205—335	0.10—0.40	0.30—2.00
	M	MK	MC5015	190—305	0.20—0.55	1.00—4.00
	R	RK	MC5015	180—285	0.25—0.60	1.50—6.00
	H	Flat Top	MC5015	180—285	0.20—0.60	2.50—6.00
Unstable Cutting	L	LK	MC5015	205—335	0.10—0.40	0.30—2.00
	M	MK	MC5015	190—305	0.20—0.55	1.00—4.00
	R	RK	MC5015	180—285	0.25—0.60	1.50—6.00
	H	Flat Top	MC5015	180—285	0.20—0.60	2.50—6.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



- Stable Cutting
- General Cutting
- Unstable Cutting

- F Finish Cutting
- L Light Cutting
- M Medium Cutting
- R Rough Cutting

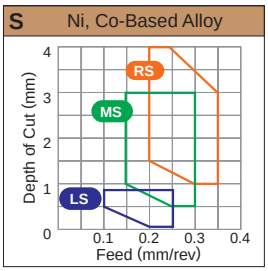
	Finish Cutting	Light Cutting	Medium Cutting	Rough Cutting
Stable Cutting	LS(M) MT9015	LS(M) MT9015	MS MT9015	RS MT9015
General Cutting	LS(M) MT9015	LS(M) MT9015	MS MT9015	RS MT9015
Unstable Cutting	FJ RT9010	MJ(M) RT9010	MS RT9010	GJ RT9010

S Titanium Alloy (Ex : Ti-6Al-4V)

NEGATIVE INSERTS

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	LS(M)	MT9015	40—85	0.10—0.25	0.20—0.80
	L	LS(M)	MT9015	40—85	0.10—0.25	0.20—0.80
	M	MS	MT9015	40—80	0.10—0.25	0.50—4.00
	R	RS	MT9015	35—75	0.20—0.35	1.00—4.00
General Cutting	F	LS(M)	MT9015	40—85	0.10—0.25	0.20—0.80
	L	LS(M)	MT9015	40—85	0.10—0.25	0.20—0.80
	M	MS	MT9015	40—80	0.10—0.25	0.50—4.00
	R	RS	MT9015	35—75	0.20—0.35	1.00—4.00
Unstable Cutting	F	FJ	RT9010	45—95	0.07—0.20	0.10—1.00
	L	MJ(M)	RT9010	40—85	0.07—0.25	0.40—1.50
	M	MS	RT9010	40—80	0.10—0.25	0.50—4.00
	R	GJ	RT9010	35—75	0.16—0.35	1.00—3.00



●	Stable Cutting
◔	General Cutting
✚	Unstable Cutting

F	Finish Cutting
L	Light Cutting
M	Medium Cutting
R	Rough Cutting

	Finish Cutting	Light Cutting	Medium Cutting	Rough Cutting
●	LS(M) MP9005	LS(M) MP9005	MS MP9005	RS MP9015
◔	LS(M) MP9015	LS(M) MP9015	MS MP9015	RS MP9015
✚	FJ VP15TF	LS(M) MP9025	MS MP9025	RS MP9025

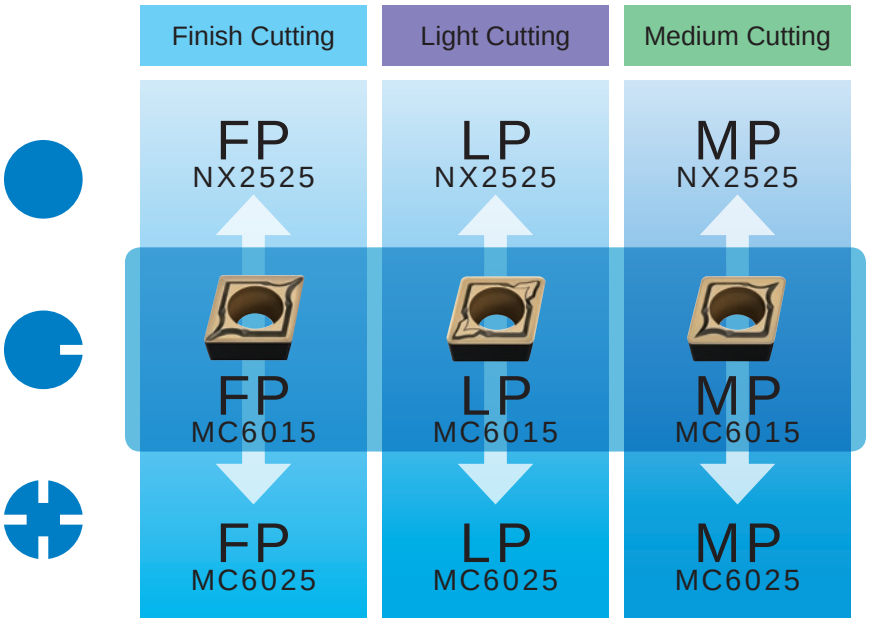
S Ni, Co-Based Alloy (Ex : Inconel718)

NEGATIVE INSERTS

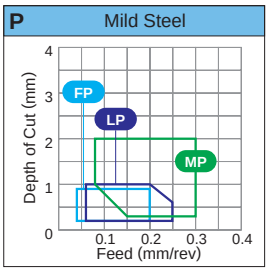
vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	LS(M)	MP9005	30—110	0.10—0.25	0.20—0.80
	L	LS(M)	MP9005	30—110	0.10—0.25	0.20—0.80
	M	MS	MP9005	30—100	0.10—0.25	0.50—4.00
	R	RS	MP9015	20—75	0.20—0.35	1.00—4.00
General Cutting	F	LS(M)	MP9015	25—85	0.10—0.25	0.20—0.80
	L	LS(M)	MP9015	25—85	0.10—0.25	0.20—0.80
	M	MS	MP9015	25—80	0.10—0.25	0.50—4.00
	R	RS	MP9015	20—75	0.20—0.35	1.00—4.00
Unstable Cutting	F	FJ	VP15TF	20—40	0.07—0.20	0.10—1.00
	L	LS(M)	MP9025	20—30	0.10—0.25	0.20—0.80
	M	MS	MP9025	20—30	0.10—0.25	0.50—4.00
	R	RS	MP9025	15—25	0.20—0.35	1.00—4.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting

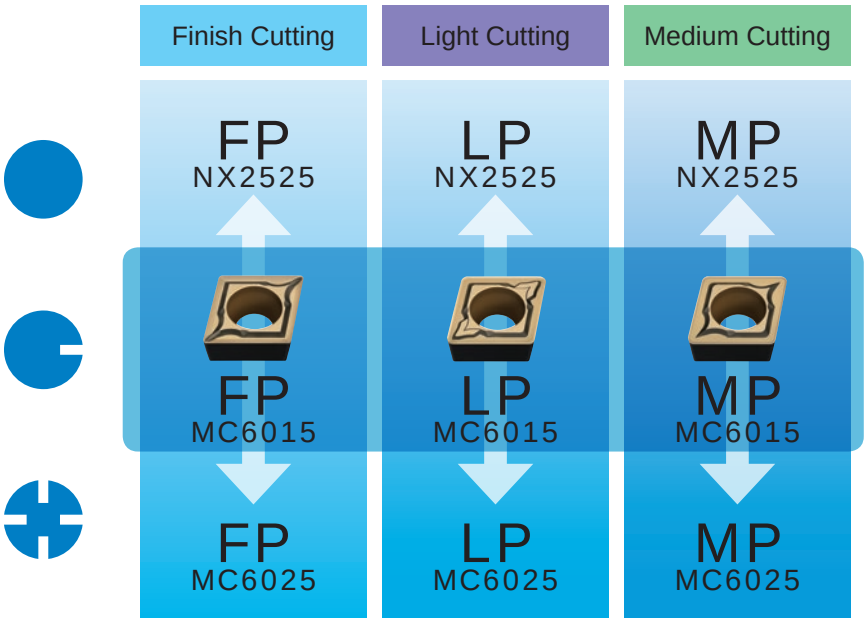


P Mild Steel (Ex : SS400, S10C)

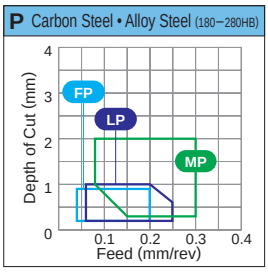
7°POSITIVE INSERTS WITH HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FP	NX2525	225—320	0.04—0.20	0.20—0.90
	L	LP	NX2525	225—320	0.06—0.25	0.20—1.00
	M	MP	NX2525	185—270	0.08—0.30	0.30—2.00
General Cutting	F	FP	MC6015	250—425	0.04—0.20	0.20—0.90
	L	LP	MC6015	250—425	0.06—0.25	0.20—1.00
	M	MP	MC6015	210—355	0.08—0.30	0.30—2.00
Unstable Cutting	F	FP	MC6025	250—405	0.04—0.20	0.20—0.90
	L	LP	MC6025	250—405	0.06—0.25	0.20—1.00
	M	MP	MC6025	210—340	0.08—0.30	0.30—2.00



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting



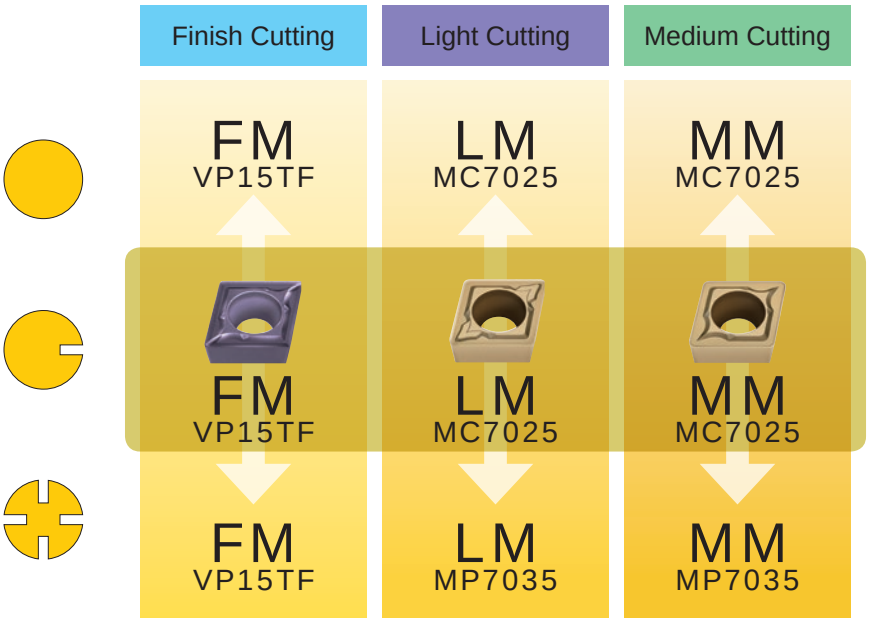
P Carbon Steel • Alloy Steel (Ex : S45C, SCM440)

7°POSITIVE INSERTS WITH HOLE

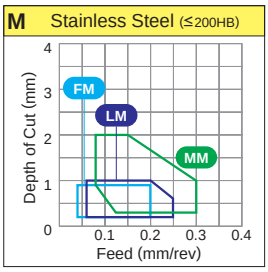
vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FP	NX2525	165–240	0.04–0.20	0.20–0.90
	L	LP	NX2525	165–240	0.06–0.25	0.20–1.00
	M	MP	NX2525	140–200	0.08–0.30	0.30–2.00
General Cutting	F	FP	MC6015	185–315	0.04–0.20	0.20–0.90
	L	LP	MC6015	185–315	0.06–0.25	0.20–1.00
	M	MP	MC6015	155–260	0.08–0.30	0.30–2.00
Unstable Cutting	F	FP	MC6025	185–300	0.04–0.20	0.20–0.90
	L	LP	MC6025	185–300	0.06–0.25	0.20–1.00
	M	MP	MC6025	155–250	0.08–0.30	0.30–2.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting



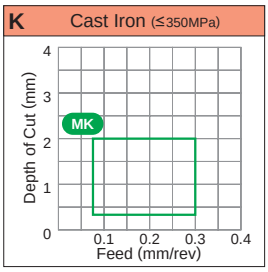
M Stainless Steel (Ex : SUS304, SUS316)

7°POSITIVE INSERTS WITH HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
	L	LM	MC7025	140—190	0.06—0.25	0.20—1.00
	M	MM	MC7025	120—160	0.08—0.30	0.30—2.00
General Cutting	F	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
	L	LM	MC7025	140—190	0.06—0.25	0.20—1.00
	M	MM	MC7025	120—160	0.08—0.30	0.30—2.00
Unstable Cutting	F	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
	L	LM	MP7035	85—135	0.06—0.25	0.20—1.00
	M	MM	MP7035	70—115	0.08—0.30	0.30—2.00

- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting



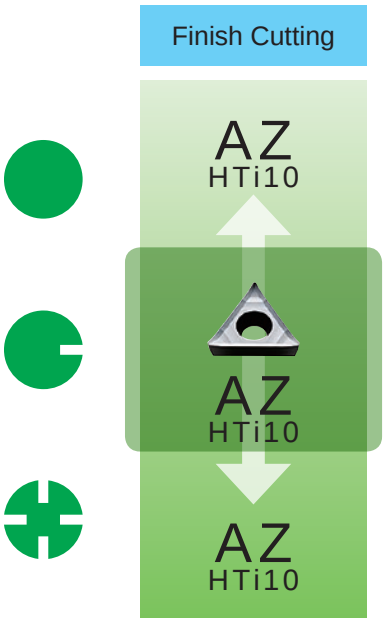
K Cast Iron • Ductile Cast Iron (Ex : FC300)

7°POSITIVE INSERTS WITH HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	MK	MC5005	165—265	0.08—0.30	0.30—2.00
	L	MK	MC5005	165—265	0.08—0.30	0.30—2.00
	M	MK, Flat Top	MC5005	165—265	0.08—0.30	0.30—2.00
General Cutting	F	MK	MC5015	150—240	0.08—0.30	0.30—2.00
	L	MK	MC5015	150—240	0.08—0.30	0.30—2.00
	M	MK, Flat Top	MC5015	150—240	0.08—0.30	0.30—2.00
Unstable Cutting	F	MK	MC5015	150—240	0.08—0.30	0.30—2.00
	L	MK	MC5015	150—240	0.08—0.30	0.30—2.00
	M	MK, Flat Top	MC5015	150—240	0.08—0.30	0.30—2.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting

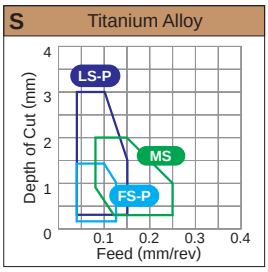
N Aluminium Alloy (Ex : A6061, A7075)

7°POSITIVE INSERTS WITH HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	Grade	1st Recommendation vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	AZ	HTi10	300—700	0.10—0.40	0.20—3.00
General Cutting	F	AZ	HTi10	300—700	0.10—0.40	0.20—3.00
Unstable Cutting	F	AZ	HTi10	300—700	0.10—0.40	0.20—3.00

- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting



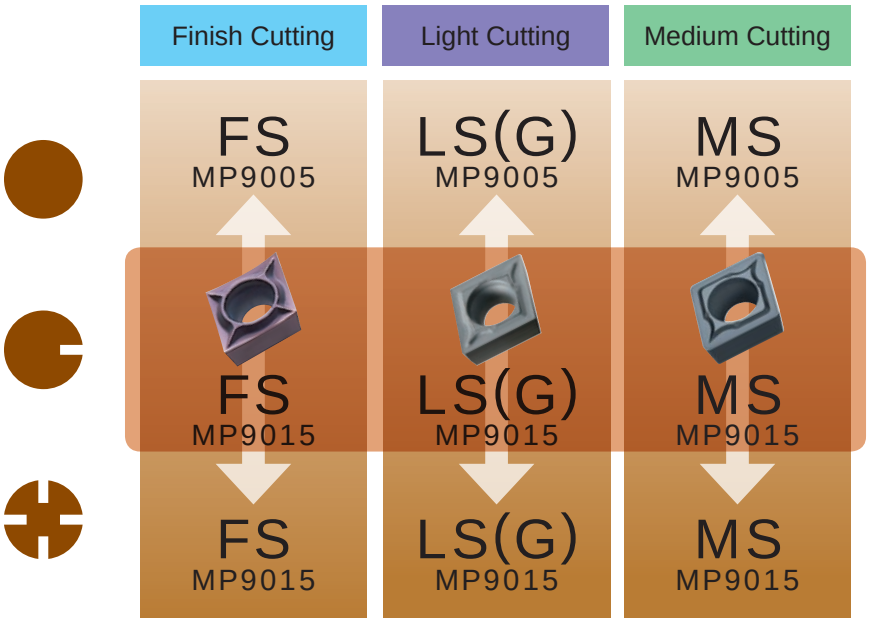
S Titanium Alloy (Ex : Ti-6Al-4V)

7°POSITIVE INSERTS WITH HOLE

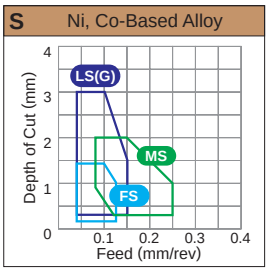
vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	Grade	1st Recommendation vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FS-P	MT9005	40—80	0.04—0.12	0.20—1.40
	L	LS-P	MT9005	40—80	0.04—0.15	0.30—3.00
	M	MS	MT9005	35—65	0.08—0.25	0.30—2.00
General Cutting	F	FS-P	MT9005	40—80	0.04—0.12	0.20—1.40
	L	LS-P	MT9005	40—80	0.04—0.15	0.30—3.00
	M	MS	MT9005	35—65	0.08—0.25	0.30—2.00
Unstable Cutting	F	FS-P	MT9005	40—80	0.04—0.12	0.20—1.40
	L	LS-P	MT9005	40—80	0.04—0.15	0.30—3.00
	M	MS	MT9005	35—65	0.08—0.25	0.30—2.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting



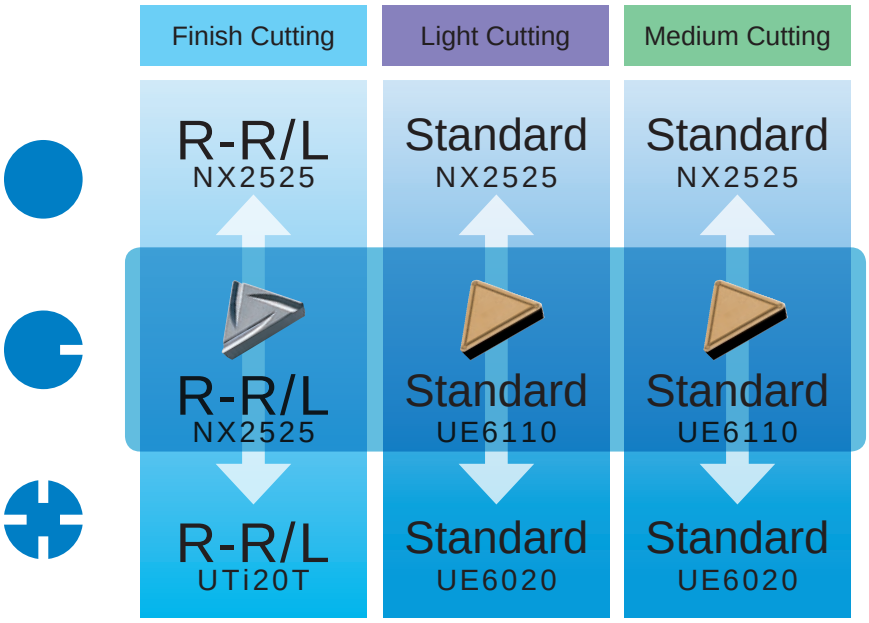
S Ni, Co-Based Alloy (Ex : Inconel718)

7°POSITIVE INSERTS WITH HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	FS	MP9005	25—95	0.04—0.12	0.20—1.40
	L	LS(G)	MP9005	25—95	0.04—0.15	0.30—3.00
	M	MS	MP9005	20—80	0.08—0.25	0.30—2.00
General Cutting	F	FS	MP9015	20—75	0.04—0.12	0.20—1.40
	L	LS(G)	MP9015	20—75	0.04—0.15	0.30—3.00
	M	MS	MP9015	20—60	0.08—0.25	0.30—2.00
Unstable Cutting	F	FS	MP9015	20—75	0.04—0.12	0.20—1.40
	L	LS(G)	MP9015	20—75	0.04—0.15	0.30—3.00
	M	MS	MP9015	20—60	0.08—0.25	0.30—2.00

* The G class is recommended for the above FS/LS breaker



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting

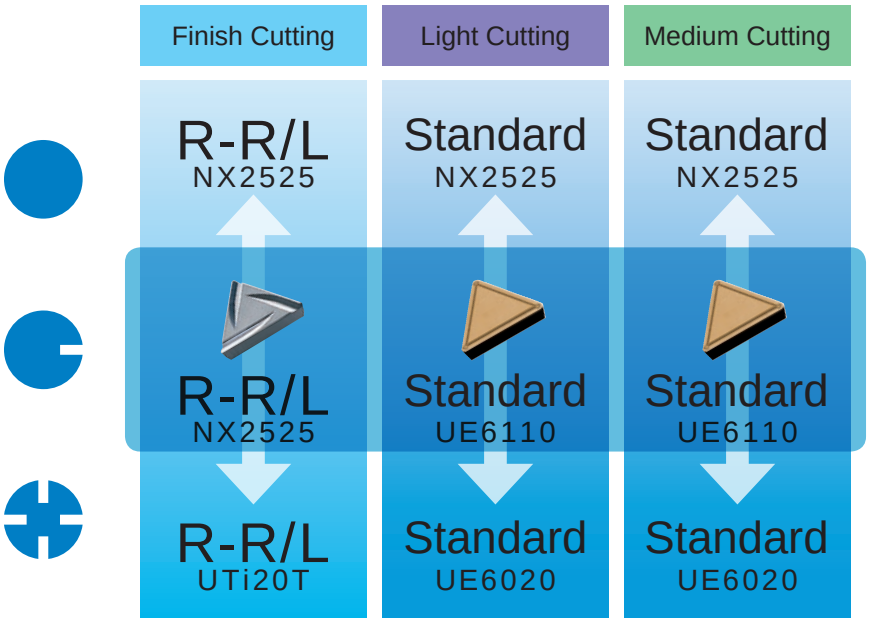
P Mild Steel (Ex : SS400, S10C)

11°POSITIVE INSERTS WITHOUT HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	R-R/L	NX2525	225—320	0.05—0.12	0.20—0.60
	L	Standard	NX2525	185—270	0.08—0.30	0.30—2.00
	M	Standard	NX2525	185—270	0.08—0.30	0.30—2.00
General Cutting	F	R-R/L	NX2525	225—320	0.05—0.12	0.20—0.60
	L	Standard	UE6110	210—355	0.08—0.30	0.30—2.00
	M	Standard	UE6110	210—355	0.08—0.30	0.30—2.00
Unstable Cutting	F	R-R/L	UTi20T	115—165	0.05—0.12	0.20—0.60
	L	Standard	UE6020	195—320	0.08—0.30	0.30—2.00
	M	Standard	UE6020	195—320	0.08—0.30	0.30—2.00

OPTIMUM GRADES AND CHIP BREAKERS FOR EXTERNAL TURNING



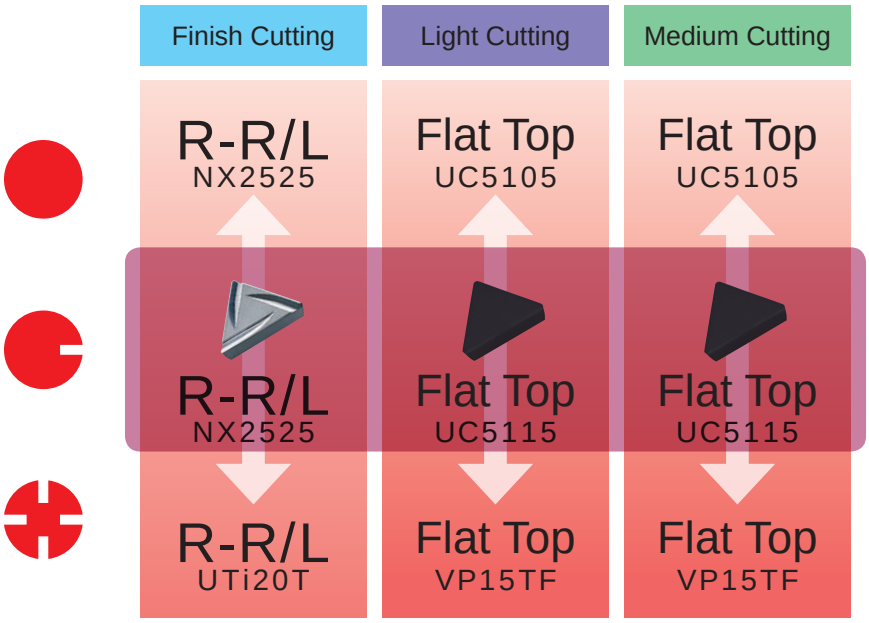
- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting

P Carbon Steel • Alloy Steel (Ex : S45C, SCM440)

11°POSITIVE INSERTS WITHOUT HOLE

vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	R-R/L	NX2525	165—240	0.05—0.12	0.20—0.60
	L	Standard	NX2525	140—200	0.08—0.30	0.30—2.00
	M	Standard	NX2525	140—200	0.08—0.30	0.30—2.00
General Cutting	F	R-R/L	NX2525	165—240	0.05—0.12	0.20—0.60
	L	Standard	UE6110	155—260	0.08—0.30	0.30—2.00
	M	Standard	UE6110	155—260	0.08—0.30	0.30—2.00
Unstable Cutting	F	R-R/L	UTi20T	85—120	0.05—0.12	0.20—0.60
	L	Standard	UE6020	145—240	0.08—0.30	0.30—2.00
	M	Standard	UE6020	145—240	0.08—0.30	0.30—2.00



- Stable Cutting
- General Cutting
- Unstable Cutting
- F Finish Cutting
- L Light Cutting
- M Medium Cutting

K Cast Iron • Ductile Cast Iron (Ex : FC300)

11°POSITIVE INSERTS WITHOUT HOLE

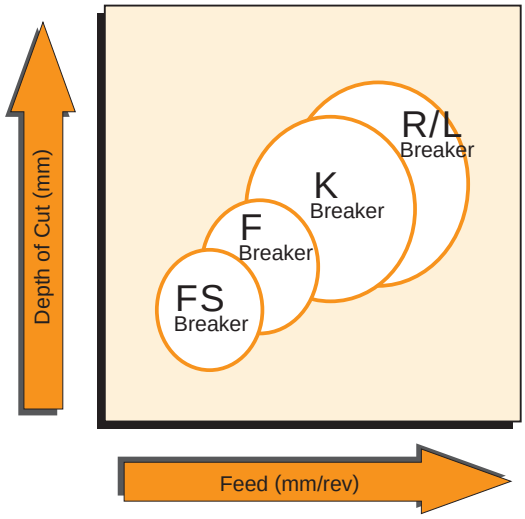
vc : Cutting Speed
f : Feed
ap : Depth of Cut

	Cutting Area	Chip Breaker	1st Recommendation Grade	vc (m/min)	f (mm/rev)	ap (mm)
Stable Cutting	F	R-R/L	NX2525	145—200	0.05—0.12	0.20—0.60
	L	Flat Top	UC5105	135—245	0.08—0.30	0.30—2.00
	M	Flat Top	UC5105	135—245	0.08—0.30	0.30—2.00
General Cutting	F	R-R/L	NX2525	145—200	0.05—0.12	0.20—0.60
	L	Flat Top	UC5115	130—240	0.08—0.30	0.30—2.00
	M	Flat Top	UC5115	130—240	0.08—0.30	0.30—2.00
Unstable Cutting	F	R-R/L	UTi20T	80—115	0.05—0.12	0.20—0.60
	L	Flat Top	VP15TF	115—160	0.08—0.30	0.30—2.00
	M	Flat Top	VP15TF	115—160	0.08—0.30	0.30—2.00

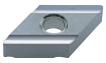
PRECISION BREAKER SYSTEM

ANGULAR AND PARALLEL CHIP BREAKERS (NEGATIVE INSERTS)

■CHIP CONTROL RANGE

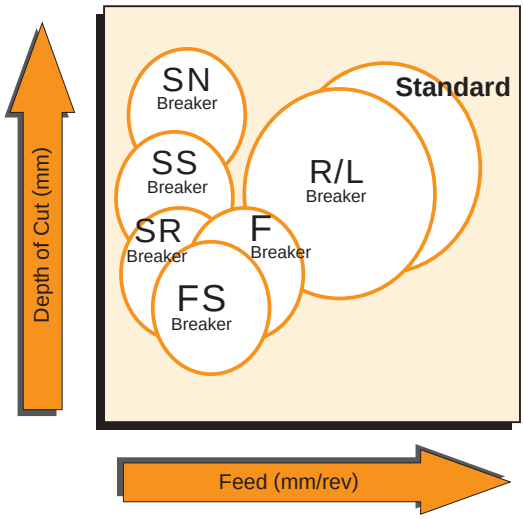


■FEATURES OF CHIP BREAKER

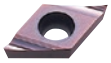
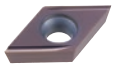
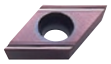
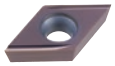
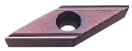
Breaker	Features	DNGG Type	SNGG Type	TNGG Type	VNGG Type
FS	● For precision finishing. ● Small width lead breaker for good chip control. ● Sharp cutting edge gives a good surface finish.	—	—		—
F	● For finish cutting. ● Lead breaker controls chip flow. ● Sharp cutting edge gives a good surface finish.	—	—		—
K	● Parallel breaker for light cutting. ● Excellent chip control for low to medium feed rates.	—	—		—
R/L	● Parallel breaker for medium cutting. ● Good chip control for medium feed rates.				

ANGULAR AND PARALLEL CHIP BREAKERS (POSITIVE INSERTS)

■CHIP CONTROL RANGE



■FEATURES OF CHIP BREAKER

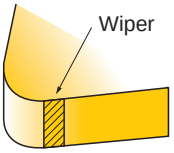
Breaker	Features	**CCET** Type	**CCGT** Type	**DCET** Type	**DCGT** Type	**VBET** Type
SR	● The wide lead breaker for medium cutting is suitable for automatic lathe machining. ● The insert design for low resistance controls chip flow.		—		—	
SS	● The parallel breaker for light cutting is suitable for automatic lathe machining. ● Excellent chip control at low feed rates.	—		—		—
SN	● The parallel breaker for general purpose is suitable for automatic lathe machining. ● Excellent chip control for low to medium feed rates.					

Breaker	Features	CCGH/CCGT Type	CPGT Type	DCGT Type	TPGH Type	TCGT Type	VBGT/VCGT Type	WBGT Type	WCGT Type	WPGT Type
FS	● For precision finishing. ● Small width lead breaker for excellent chip control. ● Sharp cutting edge gives a good surface finish.	—	—	—		—	—	—	—	
F	● For finish cutting. ● Lead breaker controls chip flow. ● Sharp cutting edge gives a good surface finish.				—				—	—
R/L	● Lead breaker for light cutting. ● Good chip control for low to medium feed rates.	—	—	—	—	—	—	—		—
Standard	● For light cutting. ● Good chip control for low to medium feed rates.	—		—	—	—	—	—	—	

WIPER INSERT

What is a Wiper Insert?

- The wiper insert is designed with a wiper edge that is situated where the straight edge meets the corner radius.
- In comparison to conventional breakers, the surface finish does not deteriorate even if the feed rate is doubled.
- Machining at high feed rates improves cutting efficiency.



●Improving Surface Finish

Under the same machining conditions as conventional breakers, but with the feed rate increased, the surface finish of the workpiece can be improved.

●Improving Efficiency

High feed rates not only shortened machining times but also make it possible to combine roughing and finishing operations.

●Increased Tool Life

When a change to high feed conditions, the time required to cut one component is decreased, thus more parts can be machined with each insert. In addition, the high feed rate prevents rubbing, therefore, delaying the progression of wear and increasing the tool life of the insert.

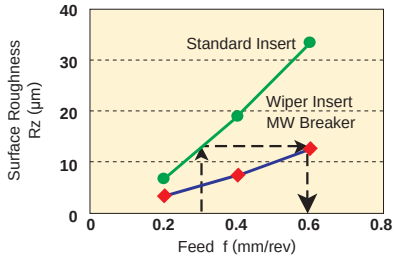
●Improving Chip Control

Under high feed conditions, the chips generated become thicker and are more easily broken, thus, chip control is improved.

Wiper insert + High feed (The feed rate is doubled.) = **Standard insert + The conventional feed condition**

Finished surface Same surface roughness

*Please use a wiper insert at high feed rate.



<Cutting Conditions>
Workpiece : JIS S45C
Insert : CNMG120408-○○
Cutting Speed=200m/min
Depth of Cut=1.5mm
Feed Speed=0.2−0.6mm/rev
Wet Outer Diameter Cutting

<Ex>The surface roughness does not deteriorate even if the feed rate is doubled (0.3→0.6)!

■A wiper insert + machining at high feed rate

- Reduced machining time (per workpieces)
- Increased number of workpieces (per definitive time period)
- Improving chip control

■A wiper insert + machining at conventional feed rate

- Eliminating the finishing step by roughing and finishing together (Separate roughing and finishing steps → Single-step machining)

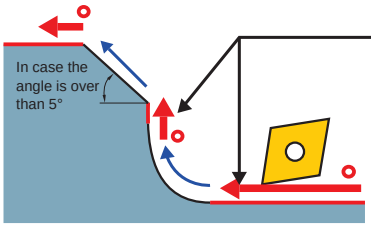
- Reducing cycle times
- Increased productivity
- Avoiding Line-Stoppage

<The Realization of Reduced Costs!!>

■The estimate of finished surface roughness when using a wiper insert

The effects of wiper inserts on external machining, boring and facing.

*The surface roughness when machining at corner R or taper angle over 5°, is the same as machining with standard inserts.



$$Rz(W)=Rz\times0.5$$

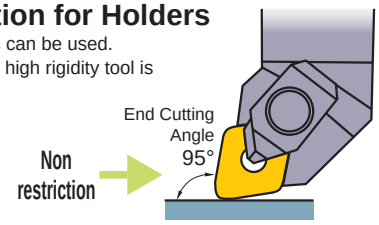
Rz(W) = Finished surface roughness when using a wiper insert.
Rz : Finished surface roughness from conventional conditions. (When using a standard insert)

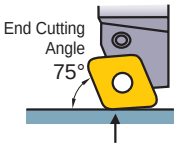
Effective uses of a wiper insert
Non effective uses of a wiper insert

■Special attention is not necessary when using CNMG • WNMG • CCMT types

●No Restriction for Holders

A standard holders can be used.
(*A double clamp, high rigidity tool is recommended.)

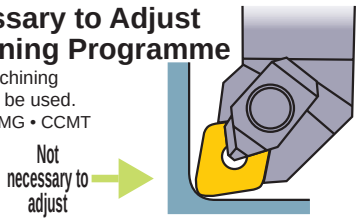




The CNMG type can be used as a wiper at the 100°corner.

■Not Necessary to Adjust the Machining Programme

Conventional machining programmes can be used.
(The CNMG • WNMG • CCMT types are based on the ISO/ANSI.)

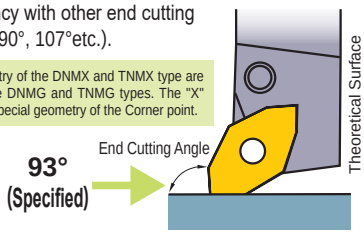


■Special attention is necessary when using the DNMX • TNMX types due to the special top face geometry

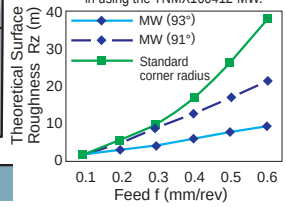
●Restriction for Holders

Use a holder with end cutting angle 93° for improving wiper efficiency. A holder with end cutting angle 91° can improve wiper efficiency (see the following figure), however, there is no wiper efficiency with other end cutting angles (60°, 90°, 107°etc.).

The hole geometry of the DNMX and TNMX type are the same as the DNMG and TNMG types. The "X" represents the special geometry of the Corner point.

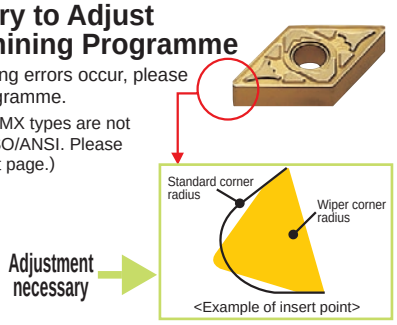


Ex):Theoretical surface roughness of holders in using the TNMX160412-MW.



●Necessary to Adjust the Machining Programme

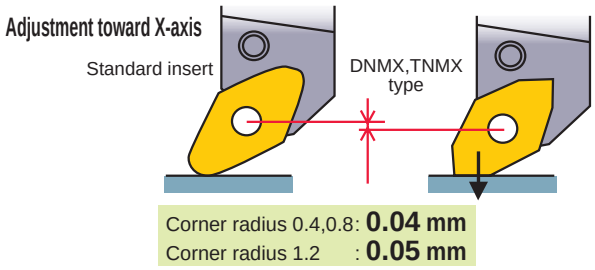
When machining errors occur, please adjust the programme.
(The DNMX•TNMX types are not based on the ISO/ANSI. Please refer to the next page.)

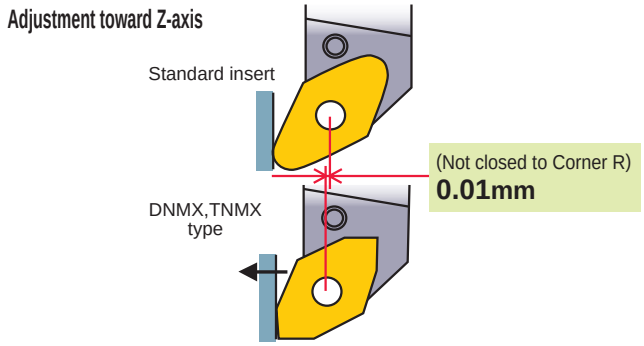


■Adjustment of machining programmes for DNMX • TNMX types

Basic Process) Adjusting Toward X-axis and Z-axis

Adjusting the differential between a standard insert and Z-axis / X-axis.



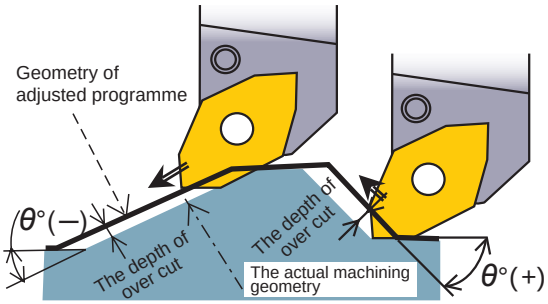


A) Adjusting a Taper

*Necessary to maintain a correct taper.

Adjust the relief angle toward the normal line.

Note1) Adjust the angle toward the normal line in the case where the adjustment number is minus (θ =60°−70°) and is not machined completely.



Classification

Corner Radius	Taper Angle θ°															
	-25−-15	-10	-5	**0**	5	10	15	20−35	40	45	50	55	60−65	70	75−85	**90**
1.2	0.04	0.03	0.01	**0**	0.02	0.03	0.04	0.05	0.04	0.04	0.02	0.01	-0.01	0	0.01	**0**
0.8	0.03	0.02	0.01	**0**	0.01	0.02	0.03	0.04	0.03	0.03	0.02	0	-0.01	0	0.01	**0**
0.4	0.02	0.01	0.01	**0**	0.01	0.01	0.02	0.02	0.02	0.01	0.01	0	-0.01	-0.01	0	**0**

The number→+numbers:adjustment of relief angle, -numbers:adjustment of drive-in angle (mm)

B) Adjusting a Corner R

*Necessary to maintain a correct corner radius.

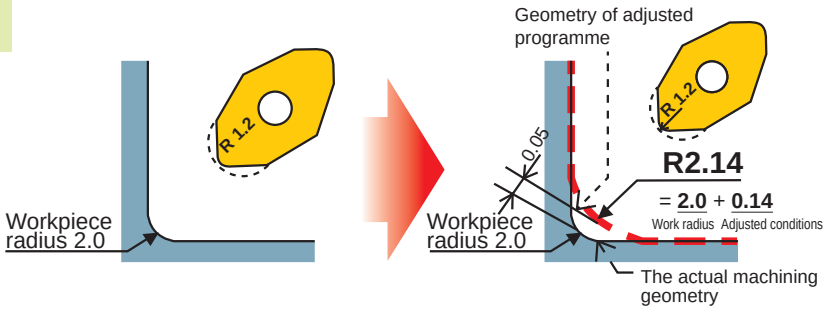
Adjust the work diameter same as the taper to prevent over-cut.

The value of adjustment to work R = Work R + the adjustment value

*No adjusting the corner radius in this case.

The corner radius of the insert	The adjustment amount on the workpiece radius.
Corner Radius 0.4 →	Work Radius**+0.05**(mm)
Corner Radius 0.8 →	Work Radius**+0.11**(mm)
Corner Radius 1.2 →	Work Radius**+0.14**(mm)

Ex) : In case of machining R 2.0 when using a corner R 1.2 type insert.



The Easy-to-correct Method

In correcting corner radius:
It is not necessary to adjust the machining programme, however, machining errors can occur within max. ±0.03mm due to correcting by an approximate number.

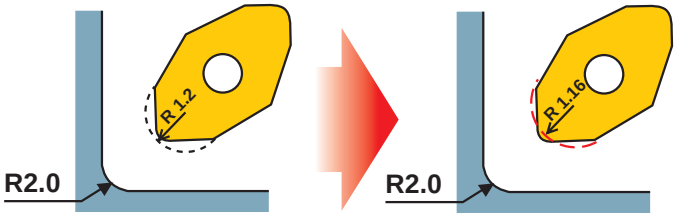
Corner Radius Correction Input the correction number of each corner radius.

The value of corrected corner radius = approximation

*No adjusting the machining the programme in this case.

The corner radius of a insert	The value of corrected corner radius = approximation
Corner Radius 0.4 →	**R0.36**(mm)
Corner Radius 0.8 →	**R0.76**(mm)
Corner Radius 1.2 →	**R1.16**(mm)

Ex):In the case of machining a corner with a radius R 2.0 when using an insert with a corner radius R 1.2.



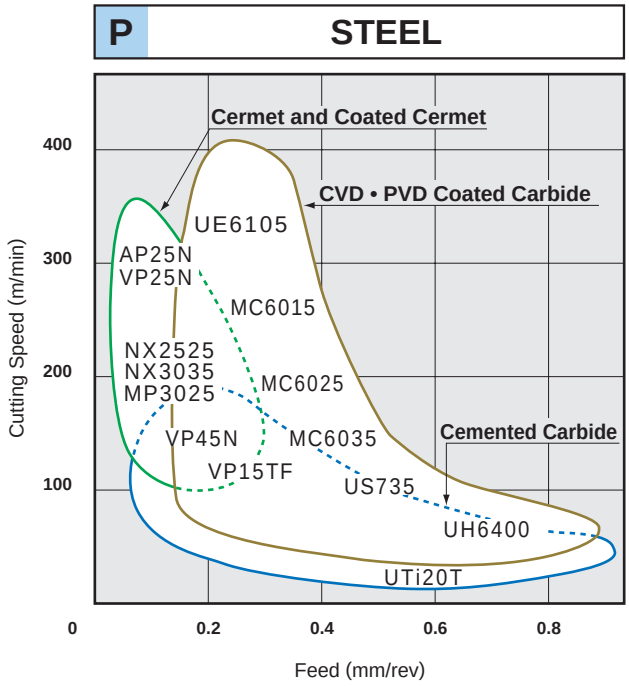
Others) The value of correction is same for both DNMX and TNMX. Discriminate them by the size of corner radius.

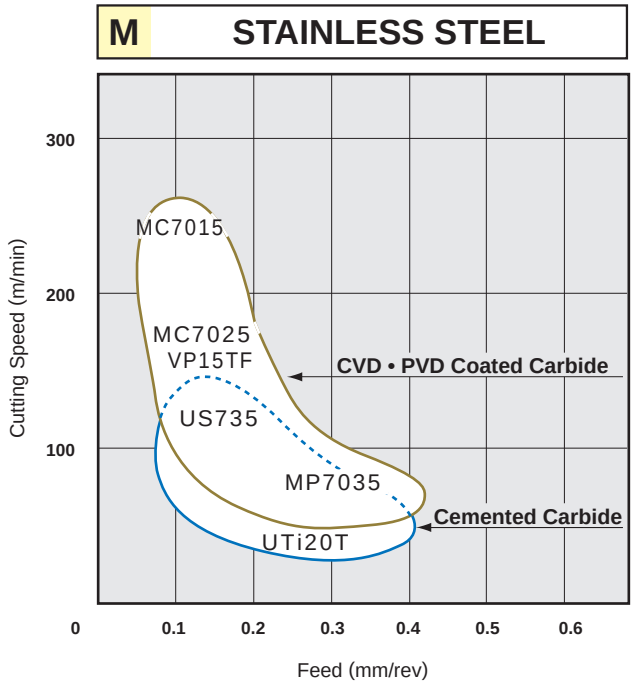
GRADES FOR TURNING

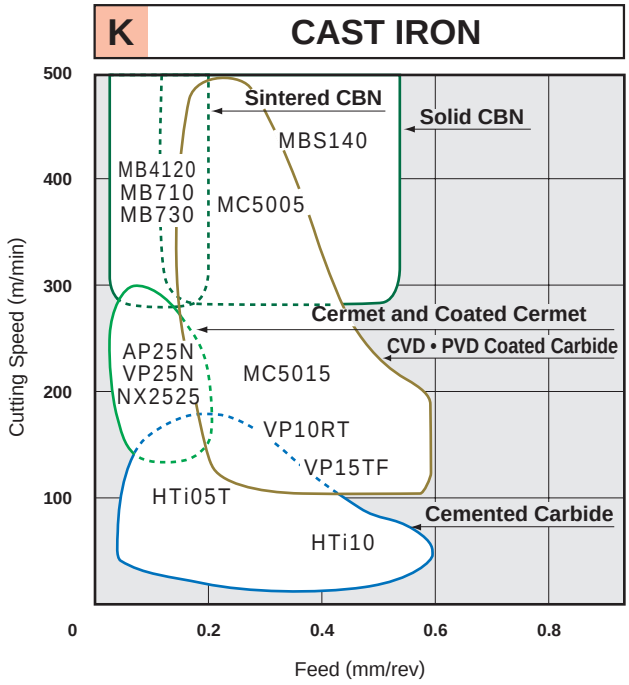
●INDEXABLE INSERT GRADES FOR TURNING

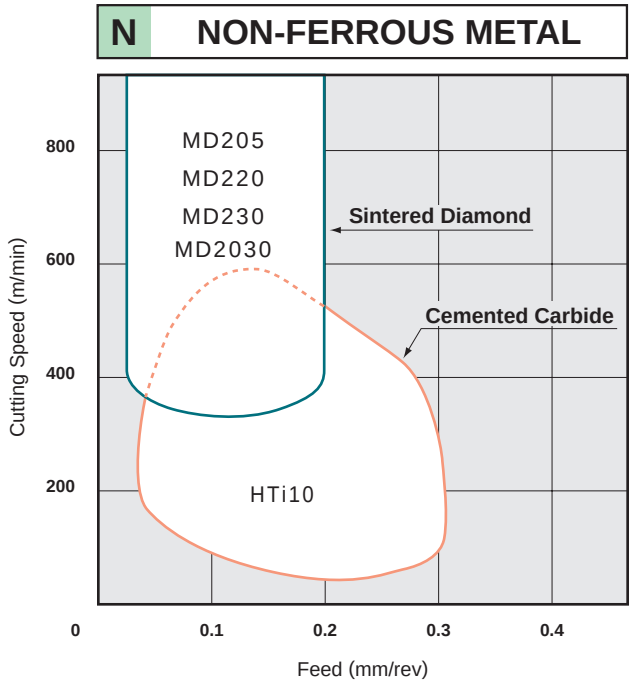
ISO			Coated Carbide						Cermet	Coated Cermet	Cemented Carbide	Coated CBN	CBN	PCD (Sintered Diamond)
			CVD				PVD							
Steel	P	10	UE6105	MC6015	UE6110	MY5015	VP10RT	MS6015	NX2525	AP25N				
		20				MC6025			NX3035	VP25N				
		30				UE6020		VP15TF		MP3025	UTi20T			
		40				MC6035	UH6400	VP20MF		VP45N				
								VP20RT						
								UP20M						
Stainless Steel	M	10	MC7015				VP10RT		NX2525	AP25N				
		20	US7020					VP15TF		VP25N				
		30				MC7025		VP20MF			UTi20T			
		40				US735		VP20RT						
								UP20M						
								MP7035						
Cast Iron	K	10	MC5005	UC5105			VP10RT		NX2525	AP25N	HTi05T		MB710	
		20			MC5015	UC5115		VP15TF		VP25N	HTi10		MB730	
		30				MY5015		VP20RT			UTi20T		MB4120 NEW	
													MBS140	
Non-Ferrous Metal	N	10												MD205
		20									HTi10			MD220
		30												MD230
														MD2030
Heat Resistant Alloy • Ti Alloy	S	10	US905				MP9005				MT9005		MB730	
		20					VP05RT				RT9005			
		30					MP9015				MT9015			
							VP10RT				RT9010			
							MP9025 NEW							
							VP20RT							
Hardened Steel	H	10										BC8105	MB8110 NEW	
		20										BC8110	MB8120 NEW	
		30										BC8120		MB8130 NEW
												BC8130		

TURNING APPLICATION RANGE





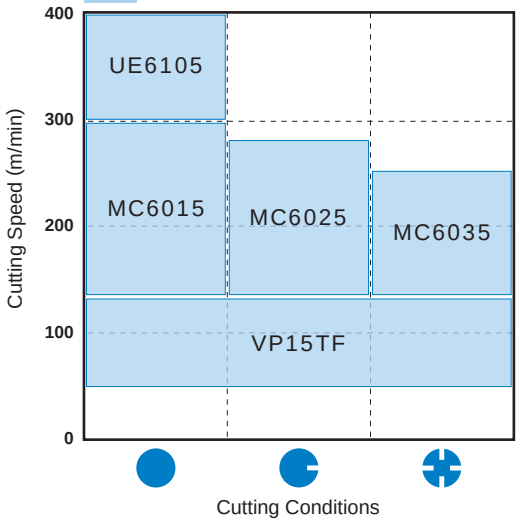




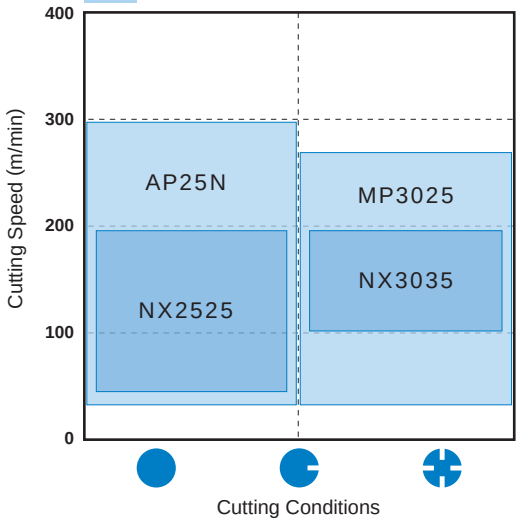
TURNING APPLICATION RANGE

●**Recommendation of the insert grade based on cutting speed and conditions for each workpiece.**

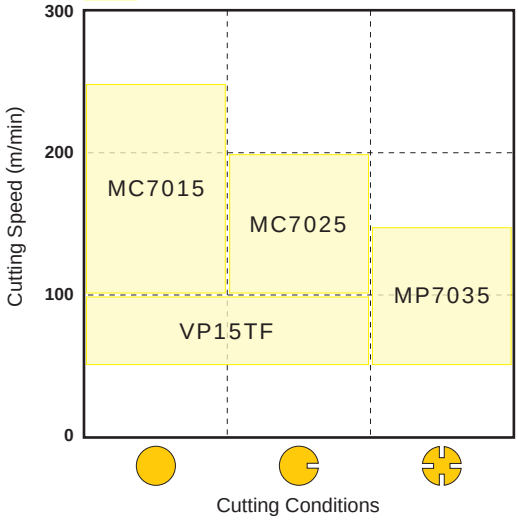
P STEEL (Medium to Rough Cutting)



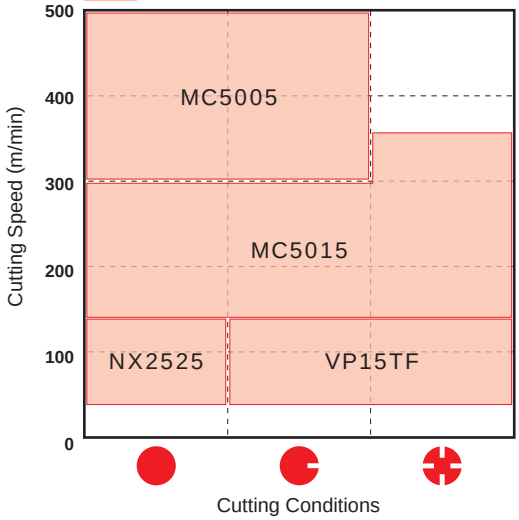
P STEEL (Finish Cutting)



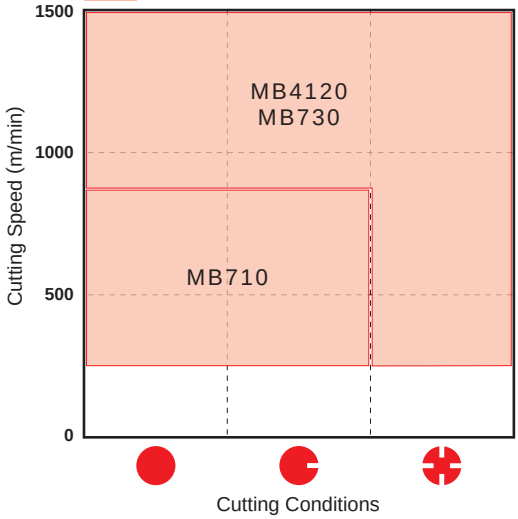
M STAINLESS STEEL



K CAST IRON



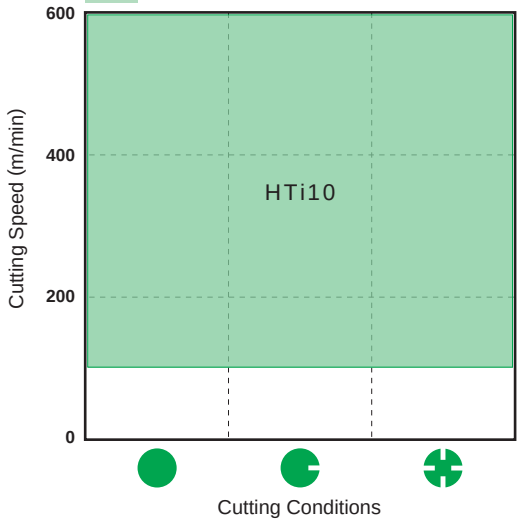
K CAST IRON (CBN)



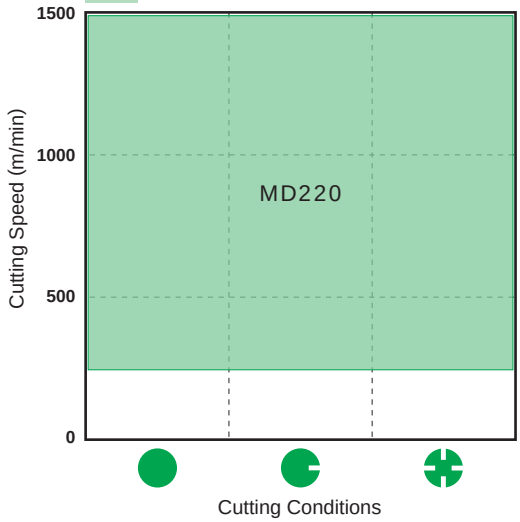
■CUTTING CONDITIONS

●	Stable Cutting	Continuous Cutting Constant Depth of Cut Pre-Machined Securely Clamped Component Cutting
◐	General Cutting	
✚	Unstable Cutting	Heavy Interrupted Cutting Irregular Depth of Cut Low Clamping Rigidity Cutting

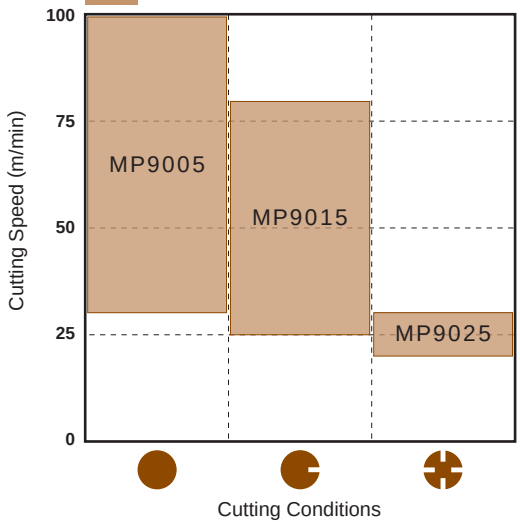
N NON-FERROUS METAL



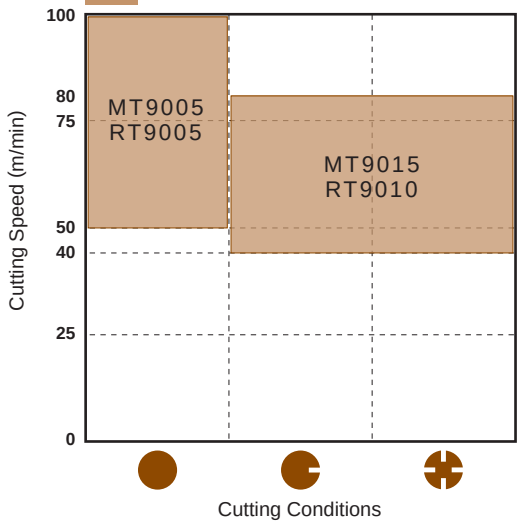
N NON-FERROUS METAL (PCD)



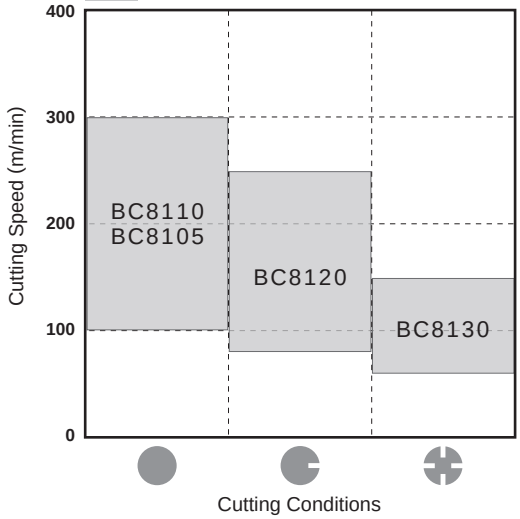
S HEAT RESISTANT ALLOY



S TITANIUM ALLOY



H HARDENED MATERIALS (CBN)



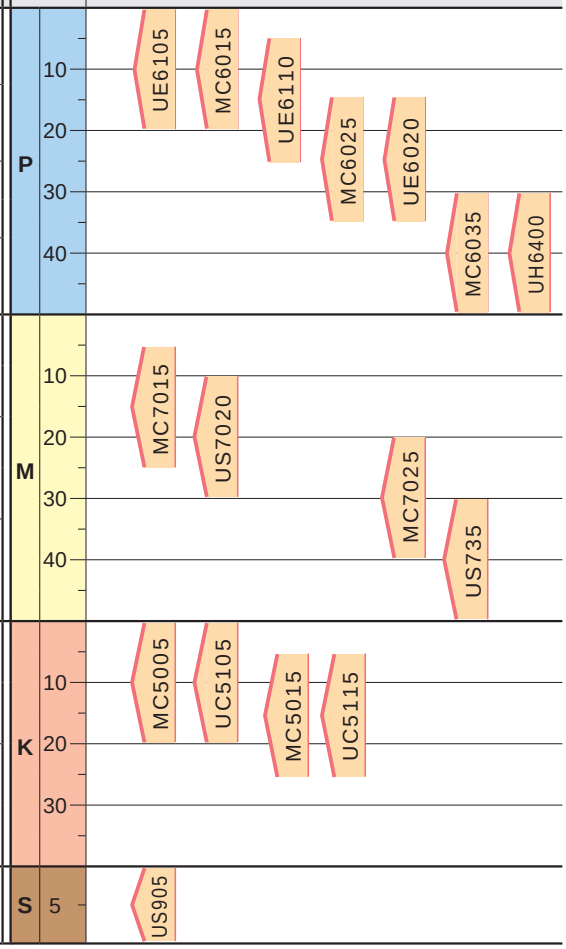
COATED CARBIDE (CVD)

- Special tough fibrous structure improves wear and fracture resistance.
- It covers a wide application range and thus reduces the number of tools required.

■ SELECTION STANDARD

●TURNING

Work Material		Cutting Mode	Recommended Grade	Recommended Cutting Speed (m/min)
P	Steel	Continuous Cutting	**UE6105**	300 (200 — 400)
			MC6015	250 (150 — 400)
			MC6025	200 (100 — 280)
		Interrupted Cutting	**MC6035**	150 (80 — 200)
M	Stainless Steel	Continuous Cutting	**MC7015**	200 (160 — 250)
			MC7025	150 (120 — 200)
		Continuous and Interrupted Cutting	**US735**	100 (80 — 120)
K	Cast Iron Ductile Cast Iron	Continuous Cutting	**MC5005**	300 (200 — 400)
		Interrupted Cutting	**MC5015**	250 (150 — 300)
S	Heat Resistant Alloy	Continuous and Interrupted Cutting	**US905**	80 (50 — 100)

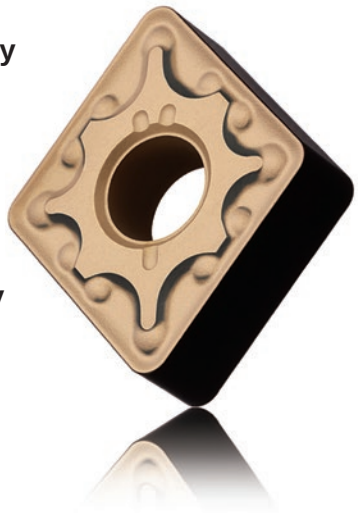


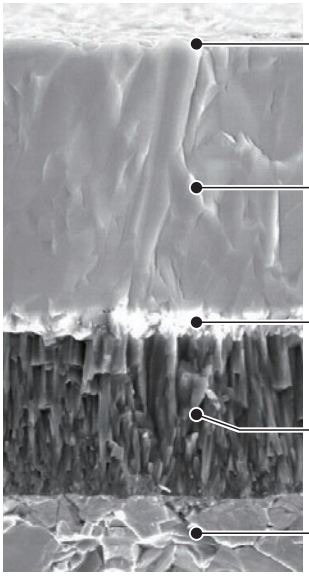
High reliability for a wide range of steel machining.

MC6015

Nano-Texture Technology
The optimized crystal growth in linear direction of Nano-texture coating technology maintains fine surface and provides outstanding wear and chipping under high speed cutting conditions.

TOUGH-Grip Technology
The interface between the layers is controlled at the nano level, allowing the TOUGH-grip layer extremely high levels of adhesion to prevent delamination.





Smooth coating surface
Prevents abnormal damage, welding and chipping

Ultra thick layer Nano-texture Al_2O_3
Delivers outstanding wear resistance even at high temperature

TOUGH-Grip
Prevents delamination of a coating

Nano-texture TiCN
Provides superior wear resistance and chipping resistance

Special carbide substrate
Prevents crack development
Stable tool life

■ GRADE CHARACTERISTICS

Work Material		Grade	Substrate	Coating Layer	
			Hardness (HRA)	Composition	Thickness
P	Steel	**UE6105**	90.8	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		MC6015	90.2	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		UE6110	90.3	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		MC6025	90.2	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		UE6020	90.0	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		MC6035	89.5	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
		UH6400	89.5	Accumulated TiCN-Al_2O_3-Ti Compound	Thick
M	Stainless Steel	**MC7015**	90.7	TiCN-Al_2O_3-TiN	Thin
		US7020	90.5	TiCN-Al_2O_3-TiN	Thin
		MC7025	89.4	TiCN-Al_2O_3-TiN	Thin
		US735	89.0	Ti Compound	Thin
K	Cast Iron Ductile Cast Iron	**MC5005**	91.0	TiCN-Al_2O_3	Thick
		UC5105	92.2	TiCN-Al_2O_3	Thick
		MC5015	91.0	TiCN-Al_2O_3	Thick
		UC5115	91.0	TiCN-Al_2O_3	Thick
	Heat Resistant Cast Steel	**MH515**	91.0	TiCN-Al_2O_3	Thick
S	Heat Resistant Alloy	**US905**	92.2	TiCN-Al_2O_3-TiN	Thin

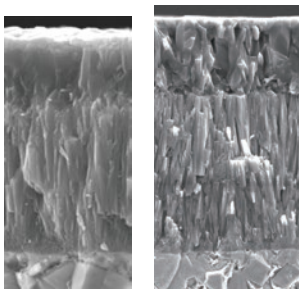
Note 1) Hardness shows representative value of the substrate.

For interrupted cutting, medium to low surface speeds

MC6035

Prevents severe damage for increased stability

The smooth coating surface provides excellent welding resistance.
With the thickened TiCN, MC6035 also achieves superior wear resistance for increased stability.

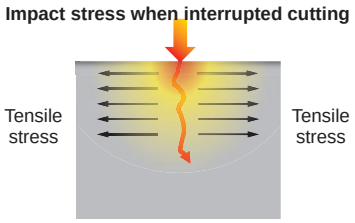


MC6035 MC6025

Reducing the effect of severe fracturing

By reducing the tensile stress in the coating layer during interrupted cutting, crack development caused by impact stress is prevented.

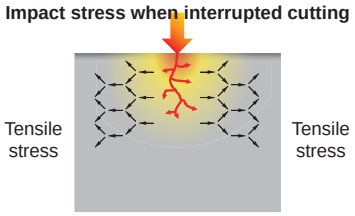
Impact stress when interrupted cutting



Conventional coating

Conventional products tend to result in fracturing because impact stress is transmitted deep into the coating layer during interrupted cutting.

Impact stress when interrupted cutting



MC6035

MC6035 has succeeded in alleviating tensile stress in the coating layer therefore, cracks that can develop by impact stress can be prevented when interrupted cutting.

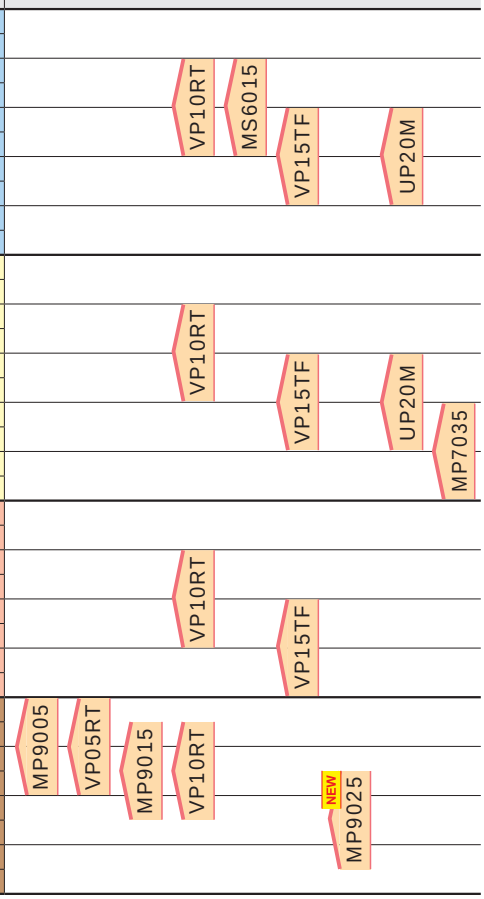
COATED CARBIDE (PVD)

- PVD coating prolongs tool life under the same cutting conditions compared to uncoated carbide.
- Coating of tools with sharp edges is possible without softening or changing the edge quality of the substrate.

■ SELECTION STANDARD

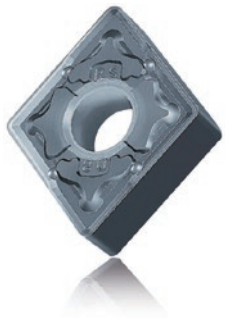
●TURNING

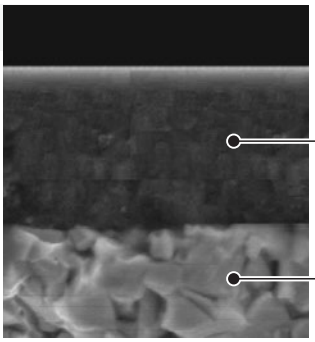
	Work Material	Recommended Grade	Recommended Cutting Speed (m/min)
P	Steel	**VP10RT**	120 (100 – 150)
		VP15TF	120 (100 – 150)
		UP20M	120 (100 – 150)
M	Stainless Steel	**VP10RT**	120 (100 – 150)
		VP15TF	120 (100 – 150)
		VP20MF	120 (100 – 150)
		UP20M	120 (100 – 150)
K	Cast Iron	**VP10RT**	120 (100 – 150)
		VP15TF	120 (100 – 150)
		VP20RT	120 (100 – 150)
S	Heat Resistant Alloy	**MP9005**	60 (30 – 100)
		MP9015	50 (25 – 80)
		MP9025	25 (20 – 30)



ISO Turning Inserts for Difficult to Cut Materials

MP9005/MP9015/MP9025 NEW





ISO Grade	Grade	Concept	Application
S01	**MP9005**	Top-quality grade focusing on wear resistance	Heat Resistant Alloy Finish-Medium Cutting
S10	**MP9015**	First recommendation for general applications	Heat Resistant Alloy Medium-Rough Cutting
S30	NEW **MP9025**	Prevents severe damage for increased stability.	Heat Resistant Alloy Interrupted • Light-Rough Cutting

CERMET

- The optimized alloy structure and special alloy binder improves both wear and fracture resistance.
- It covers a wide application range and reduces the number of tools required.
- NX3035 for wet cutting.
- NX2525 for dry cutting.

■SELECTION STANDARD

●TURNING

Work Material		Cutting Mode	Recommended Grade	Recommended Cutting Speed (m/min)	ISO	Application Range
P	Steel	Continuous Cutting	**NX2525**	220 (180 — 250)	P 10	NX2525
		Interrupted Cutting	**NX3035**	200 (190 — 260)	P 20	NX3035
K	Cast Iron Ductile Cast Iron	Finishing	**NX2525**	180 (150 — 210)	K 10 20	NX2525

■GRADE CHARACTERISTICS

Grade	Hardness (HRA)
NX2525	92.2
NX3035	91.5

Note 1) Hardness shows representative value of the substrate.

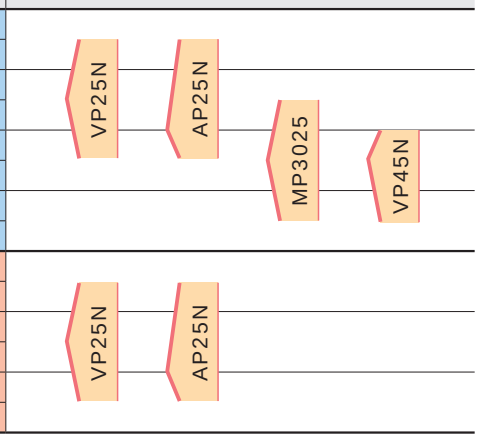
COATED CERMET

●Coated cermet (PVD coating) has superior wear and fracture resistance, and therefore provides a stable cutting performance.

■SELECTION STANDARD

●TURNING

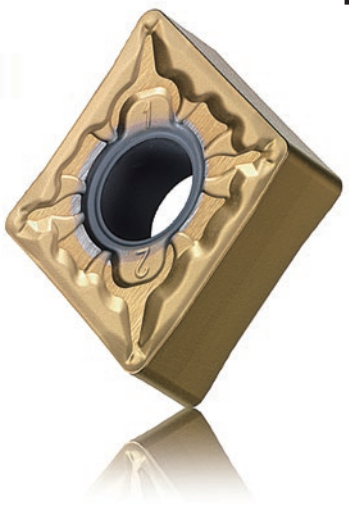
Work Material		Cutting Mode	Recommended Grade	Recommended Cutting Speed (m/min)
P	Steel	Continuous Cutting	**VP25N** **AP25N**	240 (190 — 290)
		Interrupted Cutting	**MP3025**	230 (180 — 280)
K	Cast Iron Ductile Cast Iron	Finishing	**VP25N** **AP25N**	160 (110 — 230)

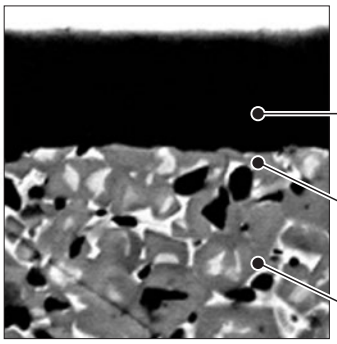


Effective for production of small parts.

MP3025

MP3025 provides improved adhesion for coating layer due to the newly-developed special substrate. Uniform flank wear allows prolonged machining that maintains excellent surface finish.





Ti-compound PVD coating provides excellent wear and welding resistance.

Substrate surface provides excellent adhesion strength for coating layer.

Substrate with superior fracture resistance and thermal shock resistance.

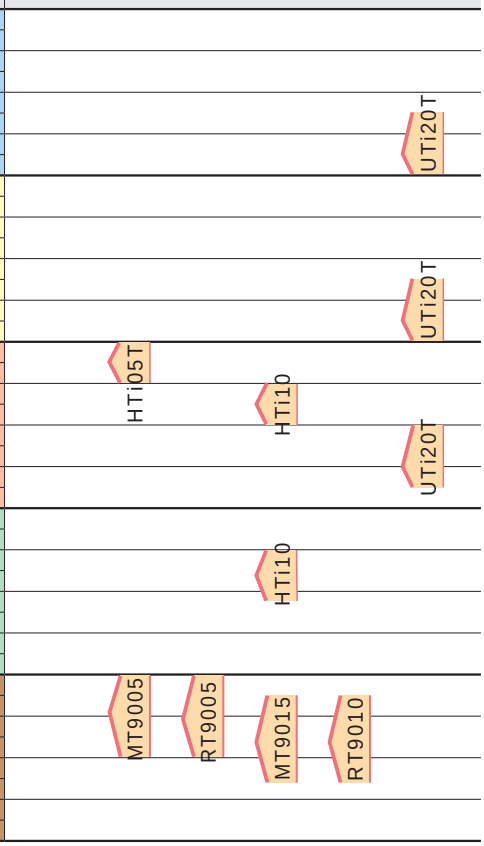
CEMENTED CARBIDE

●UTi grades are available for steel and cast iron. HTi grades are available for non-ferrous and non-metal materials and are also suitable for cast iron.

■SELECTION STANDARD

●TURNING

	Work Material	Recommended Grade	Recommended Cutting Speed (m/min)
P	Steel	**UTi20T**	100 (60 — 130)
M	Stainless Steel	**UTi20T**	100 (60 — 130)
K	Cast Iron	**HTi05T**	120 (80 — 150)
		HTi10	100 (50 — 150)
		UTi20T	100 (50 — 150)
N	Non-Ferrous Metal	**HTi10**	300 (100 — 600)
S	Heat Resistant Alloy Ti Alloy	**MT9005 RT9005**	70 (50 — 100)
		MT9015 RT9010	60 (40 — 80)



■MAIN COMPONENT AND APPLICATION

ISO	Main Component	Characteristics	Work Material
P M	WC-TiC-TaC-Co	Heat / deformation resistance.	Carbon steel, alloy steel, stainless steel and cast iron
K N	WC-Co	High rigidity and wear resistance.	Cast iron, non-ferrous metals, and non-metal
S	WC-Co	High heat resistance and wear resistance.	Heat resistant alloy, Ti alloy

■GRADE CHARACTERISTICS

ISO	Grade	Hardness (HRA)
P M	**UTi20T**	90.5
K N	**HTi05T**	92.5
	HTi10	92.0
S	**MT9005/RT9005**	92.2
	MT9015/RT9010	92.0

Note 1) Hardness shows representative value of the substrate.

MICRO-GRAIN CEMENTED CARBIDE (SOLID TOOLS)

●Compared to normal cemented carbide, micro-grain types have higher wear resistance and toughness.

■SELECTION STANDARD

Cutting Tool	Recommended Grade	Work Material
PCB Miniature Drill	**SF10** **MF10** **MF20**	Non-Metal
Solid Carbide Drill Turning Inserts Milling Inserts	**TF15**	Steel • Cast Iron
Solid End Mill	**HTi10** **TF15** **MF10**	Steel • Cast Iron
Gear Hob Reamer Tap etc.	**TF15** **MF20** **MF30**	Steel • Cast Iron, etc.

■GRADE CHARACTERISTICS

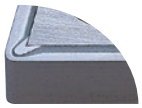
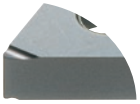
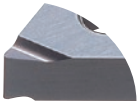
Grade	Grade Characteristics *		ISO	Wear Resistance	Fracture Resistance	Corrosion Resistance
	Hardness(HRA)	T.R.S (GPa)				
HTi10	92.0	3.2	K10	◎	○	○
TF15	91.0	4.0	K20	◎	○	◎
SF10	92.7	3.8	K01	◎	○	◎
MF10	93.0	4.0	K01	◎	○	◎
MF20	92.0	4.4	K10	○	◎	◎
MF30	90.7	4.3	K20	○	◎	◎

* After HIP
Note 1) Hardness shows representative value of the substrate.

Memo

CLASSIFICATION

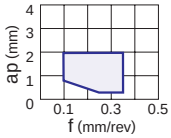
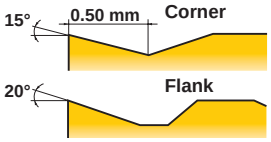
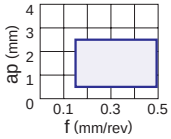
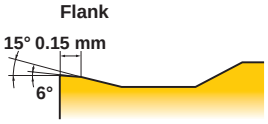
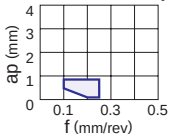
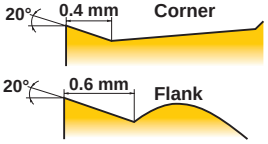
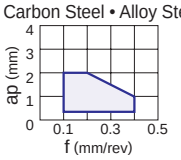
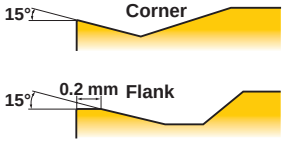
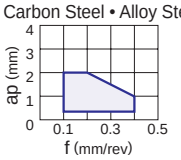
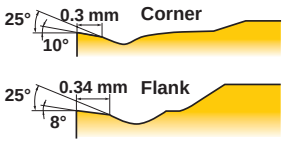
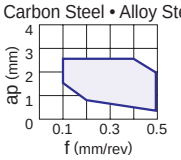
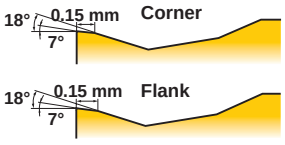
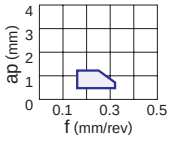
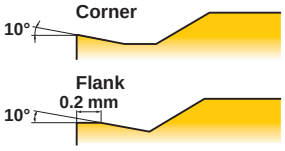
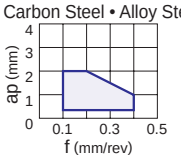
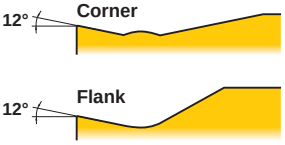
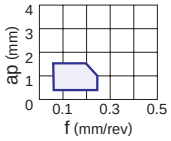
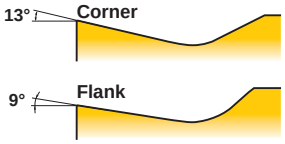
NEGATIVE INSERTS WITH HOLE

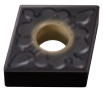
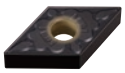
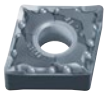
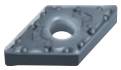
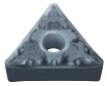
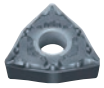
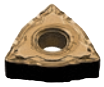
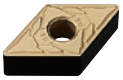
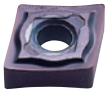
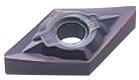
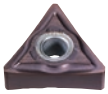
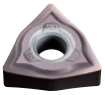
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FP	**First recommendation for finishing carbon steel and alloy steel** Controls chip clogging during high-feed cutting and prevents chips of soft work materials from running onto their surfaces. Large rake angle suppress chatter vibration and deformation in processing of low rigidity work material.	Carbon Steel • Alloy Steel ap (mm) 0–4, f (mm/rev) 0.1 0.3 0.5 Corner 20°, Flank 20° CNMG120408-FP
		FH	**First recommendation for finishing carbon steel and alloy steel** Stable chip control even at small depth of cut.	Carbon Steel • Alloy Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Corner 12°, Flank 12° CNMG120408-FH
		FS	**Alternative chipbreaker for finishing mild steel** Stable chip control even at small depth of cut. Sharp edge gives best performance.	Mild Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Corner 16°, Flank 8° CNMG120408-FS
		FY	**First recommendation for finishing mild steel** Effectively controls adhesive chips. Suitable for mild steel finishing.	Mild Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Corner 15°, Flank 15° 0.2 mm CNMG120408-FY
	G	FJ	**Alternative chip breaker for finishing difficult-to-cut materials** Ideal for heat-resistant alloy and titanium alloy. The sharp edge produces good cutting surface. The curved edge allows smooth chip discharge.	Difficult-to-Cut Materials ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Corner 14°, Flank 9° CNGG120404-FJ
		PK 	**Alternative chipbreaker for finishing carbon steel and alloy steel** G class insert tolerance is suitable for workpieces requiring close dimensional tolerances. Stable chip control even at small depth of cut.	Carbon Steel • Alloy Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Corner 15°, Flank 15° CNGG120404-PK
		R/L-FS 	**Chipbreaker for precise finishing** A narrow lead chipbreaker for good chip control. The sharp edge produces a good surface finish.	Carbon Steel • Alloy Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Flank 14° TNGG160404R-FS
		R/L-F 	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. The sharp edge produces a good surface finish.	Carbon Steel • Alloy Steel ap (mm) 0–3, f (mm/rev) 0.1 0.2 0.3 0.4 Flank 14° TNGG160404R-F
Light Cutting	M	LP	**First recommendation for light cutting of carbon steel and alloy steel** Stable chip control at light cutting range. The curved edge allows smooth chip discharge.	Carbon Steel • Alloy Steel ap (mm) 0–4, f (mm/rev) 0.1 0.3 0.5 Corner 15° 0.1 mm, Flank 11° 0.2 mm CNMG120408-LP

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNMG_FP A100	DNMG_FP A107	SNMG_FP A115	TNMG_FP A121	VNMG_FP A128	WNMG_FP A132		FP
	CNMG_FH A100	DNMG_FH A107	SNMG_FH A115	TNMG_FH A121	VNMG_FH A128	WNMG_FH A132		FH
	CNMG_FS A100	DNMG_FS A107	SNMG_FS A115	TNMG_FS A121	VNMG_FS A128	WNMG_FS A132		FS
	CNMG_FY A100	DNMG_FY A107		TNMG_FY A121		WNMG_FY A132		FY
	CNGG_FJ A100	DNGG_FJ A107			VNGG_FJ A128			FJ
	CNGG_PK A100	DNGG_PK A107		TNGG_PK A121				PK
				TNGG_R/L-FS A121				R/L-FS
				TNGG_R/L-F A122	VNGG_R/L-F A128			R/L-F
	CNMG_LP A100	DNMG_LP A108	SNMG_LP A115	TNMG_LP A122	VNMG_LP A128	WNMG_LP A132		LP

CLASSIFICATION

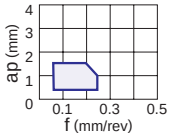
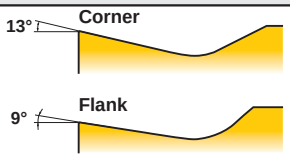
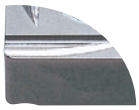
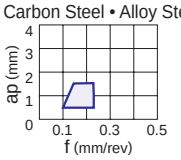
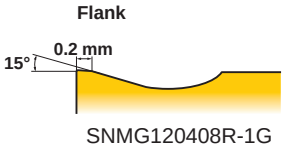
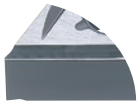
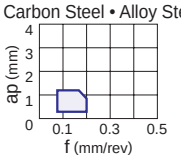
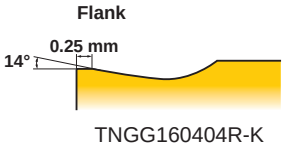
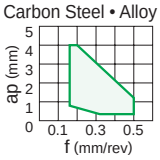
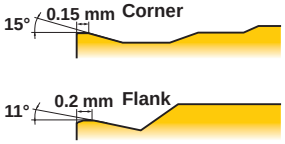
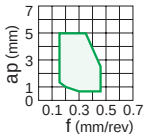
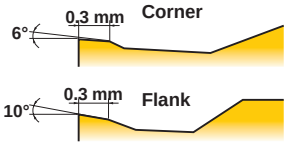
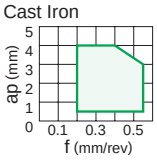
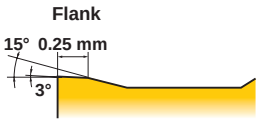
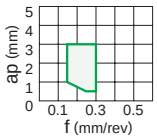
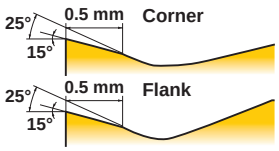
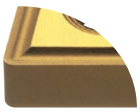
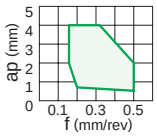
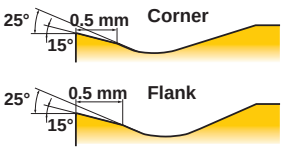
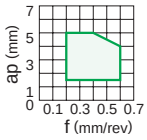
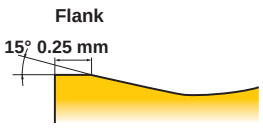
NEGATIVE INSERTS WITH HOLE

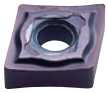
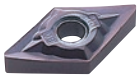
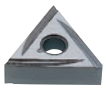
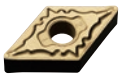
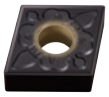
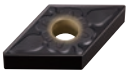
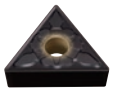
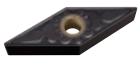
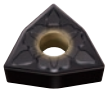
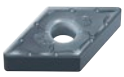
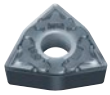
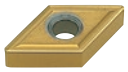
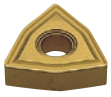
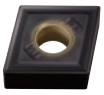
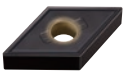
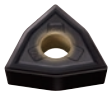
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Light Cutting	M	**LM**	**First recommendation for light cutting of stainless steel** Stable chip control at light cutting range. Breaker with high rake angle provides excellent burr control.	Stainless Steel   CNMG120408-LM
		LK	**First recommendation for light cutting of cast iron** Narrow positive land provides low cutting resistance and excellent finish.	Cast Iron   CNMG120408-LK
		LS	**First recommendation for light cutting of difficult-to-cut materials** **Alternative chipbreaker for light cutting of stainless steel** Enhanced chip disposal for depth of cut smaller than the corner R.	Heat Resistant Alloy   CNMG120408-LS
		SH	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Can be used at low depth of cuts and high feed rates. The curved edge allows smooth chip discharge. Recommended for workpieces in the 160－250HB range.	Carbon Steel • Alloy Steel   CNMG120408-SH
		SA	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Superior chip control at small depth of cuts. Covers copying and back turning with wavy edge. Recommended for workpieces in the 200－300HB range.	Carbon Steel • Alloy Steel   CNMG120408-SA
		SW	**Wiper insert for light cutting of carbon steel, alloy steel, stainless steel and cast iron** In comparison to conventional chip breakers, the surface finish is maintained even if the feed per revolution is doubled. Wiper design for increased productivity and improved surface finish.	Carbon Steel • Alloy Steel   CNMG120408-SW
		SY	**First recommendation for light cutting of mild steel** Effectively controls adhesive chips. Suitable for mild steel light cutting.	Mild Steel   CNMG120408-SY
		C	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Suitable for light cutting. The curved edge allows smooth chip discharge.	Carbon Steel • Alloy Steel   CNMG120408-C
		MJ	**Alternative chip breaker for light cutting of difficult-to-cut materials** Ideal for heat-resistant alloy and titanium alloy. The sharp edge produces a good surface finish. The curved edge allows smooth chip discharge. Excellent notch wear resistance for light to medium cutting.	Difficult-to-Cut Materials   CNMG120408-MJ

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNMG_LM A101	DNMG_LM A108	SNMG_LM A115	TNMG_LM A122	VNMG_LM A128	WNMG_LM A132		LM
	CNMG_LK  A101	DNMG_LK  A108	SNMG_LK A115	TNMG_LK A122	VNMG_LK A129	WNMG_LK A133		LK
	CNMG_LS  A101	DNMG_LS  A108		TNMG_LS  A122	VNMG_LS A129	WNMG_LS  A133		LS
	CNMG_SH A101	DNMG_SH A108	SNMG_SH A115	TNMG_SH A122	VNMG_SH A129	WNMG_SH A133		SH
	CNMG_SA A101	DNMG_SA A109	SNMG_SA A116	TNMG_SA A122	VNMG_SA A129	WNMG_SA  A133		SA
	CNMG_SW A101	DNMX_SW  A109		TNMX_SW A123		WNMG_SW A133		SW
	CNMG_SY A101	DNMG_SY A109	SNMG_SY A116	TNMG_SY A123		WNMG_SY A133		SY
	CNMG_C A101	DNMG_C A109	SNMG_C A116	TNMG_C A123		WNMG_C A133		C
	CNMG_MJ  A101	DNMG_MJ  A109		TNMG_MJ  A123	VNMG_MJ A129	WNMG_MJ  A133		MJ(M)

CLASSIFICATION

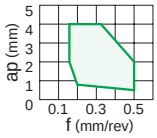
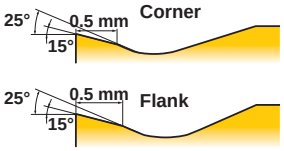
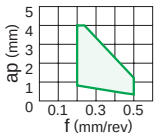
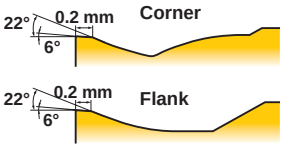
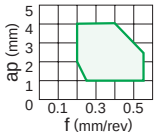
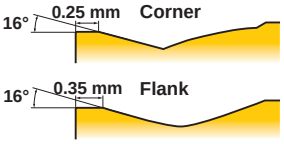
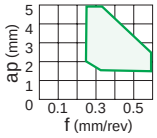
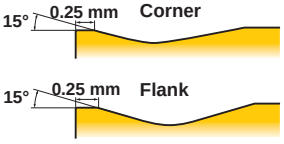
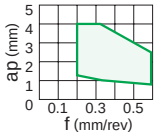
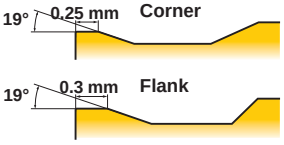
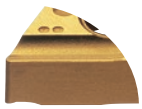
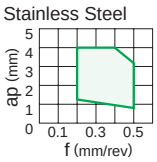
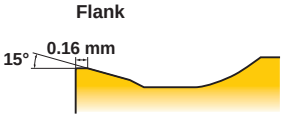
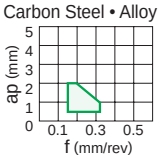
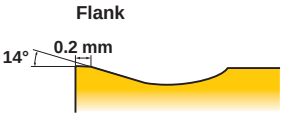
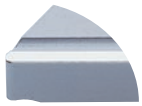
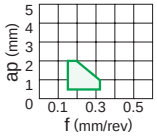
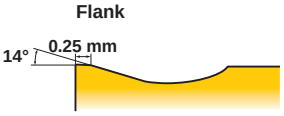
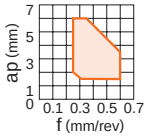
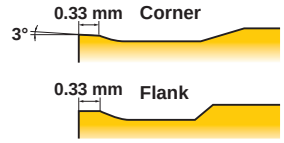
NEGATIVE INSERTS WITH HOLE

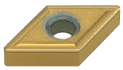
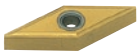
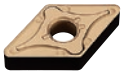
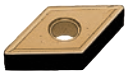
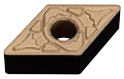
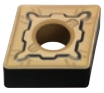
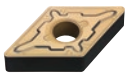
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Light Cutting	G	**MJ**	**Alternative chip breaker for light cutting of difficult-to-cut materials** Double sided chipbreaker, Single sided chipbreaker (D type, V type). The sharp edge produces a good surface finish. Ideal for heat-resistant alloy and titanium alloy. The curved edge allows smooth chip discharge.	Difficult-to-Cut Materials   CNGG120408-MJ
	M	**R/L-1G** 	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Parallel chipbreaker controls chip flow. Suitable for finish-light cutting. Precision chipbreaker.	Carbon Steel • Alloy Steel   SNMG120408R-1G
	G	**R/L-K** 	**Chipbreaker for Light cutting** Parallel chipbreaker. Excellent chip control at low to medium feed rates.	Carbon Steel • Alloy Steel   TNGG160404R-K
Medium Cutting	M	**MP**	**First recommendation for medium cutting of carbon steel and alloy steel** Suitable for medium to light cutting. Breaker geometry appropriate for copying and back turning. Cutting edge geometry for an optimum balance of sharpness and fracture resistance.	Carbon Steel • Alloy Steel   CNMG120408-MP
		MM	**First recommendation for medium cutting of stainless steel** Optimized land geometry by simulation analysis technology controls the plastic deformation of the corner and achieves the long tool life.	Stainless Steel   CNMG120408-MM
		MK	**First recommendation for medium cutting of cast iron** Optimum balance between sharpness and high edge strength for general use.	Cast Iron   CNMG120408-MK
		MS	**First recommendation for medium cutting of difficult-to-cut materials,** **Alternative chip breaker for medium cutting of stainless steel.** A large two-step rake corner creates chips without squeezing and entangled shapes. Applicable to MP9005, MP9015, MP9025, MT9015	Difficult-to-Cut Materials   CNMG120408-MS
		MS 	**Alternative chipbreaker for medium cutting of stainless steel, mild steel and difficult-to-cut materials** The sharp edge gives best performance. Flat top breaker shape offers high edge strength. Applicable to grades other than MP9005, MP9015, MP9025, MT9015	Stainless Steel   CNMG120408-MS
		GK	**Alternative chip breaker for medium cutting for cast iron** Breakers are suitable for a wide range of applications. Maintenance of high stability by the flat-land.	Cast Iron   CNMG120408-GK

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNGG_MJ  A102	DNGM_MJ  A109			VNGM_MJ A129			MJ(G)
			SNMG_R/L-1G A116	TNMG_R/L-1G A123				R/L-1G
				TNGG_R/L-K  A123				R/L-K
	CNMG_MP A102	DNMG_MP  A109	SNMG_MP A116	TNMG_MP A123	VNMG_MP A129	WNMG_MP A134		MP
	CNMG_MM A102	DNMG_MM A110	SNMG_MM A116	TNMG_MM A123	VNMG_MM A129	WNMG_MM A134		MM
	CNMG_MK  A102	DNMG_MK  A110	SNMG_MK A117	TNMG_MK  A123	VNMG_MK  A129	WNMG_MK  A134		MK
	CNMG_MS A102	DNMG_MS  A110	SNMG_MS A117	TNMG_MS A124	VNMG_MS A130	WNMG_MS  A134		MS
	CNMG_MS A103	DNMG_MS  A110	SNMG_MS A117	TNMG_MS A124	VNMG_MS A130	WNMG_MS  A134		MS
	CNMG_GK  A103	DNMG_GK  A110	SNMG_GK A117	TNMG_GK A124	VNMG_GK A130	WNMG_GK  A135		GK

CLASSIFICATION

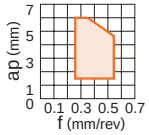
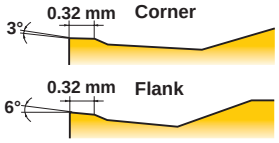
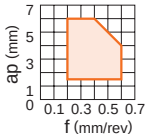
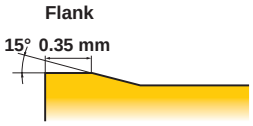
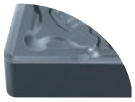
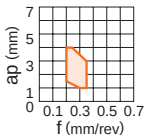
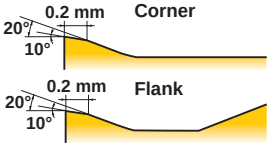
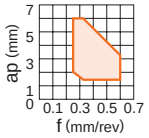
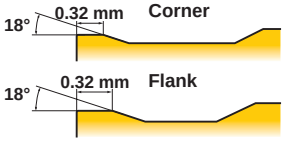
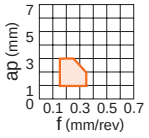
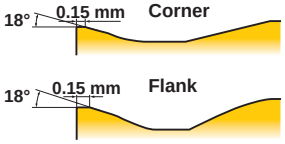
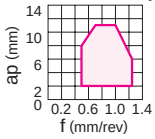
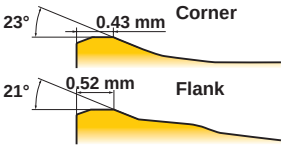
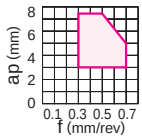
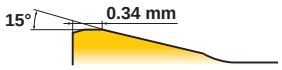
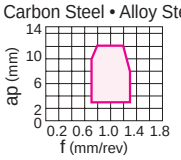
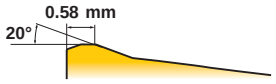
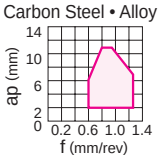
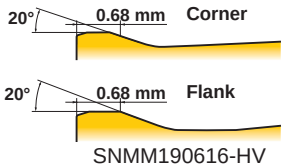
NEGATIVE INSERTS WITH HOLE

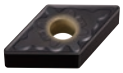
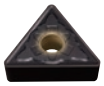
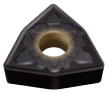
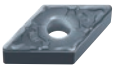
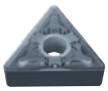
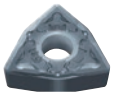
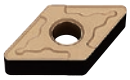
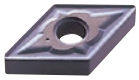
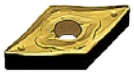
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Medium Cutting	M	**GM**	**Alternative chip breaker for light to medium cutting of stainless steel** Alternative chip breaker of main chip breaker LM and MM. Excellent notch wear resistance for light to medium cutting.	Stainless Steel   CNMG120408-GM
		MA	**First recommendation for medium cutting of carbon steel and alloy steel** Ideal for general cutting applications. Positive land provides sharp cutting action.	Carbon Steel • Alloy Steel   CNMG120408-MA
		MH	**Alternative chipbreaker for medium cutting of carbon steel and alloy steel** Flat land offers high edge strength. Good chip control with suitable chip pocket.	Carbon Steel • Alloy Steel   CNMG120408-MH
		Standard	**Alternative chipbreaker for medium cutting of carbon steel and alloy steel** Flat land offers high edge strength. Flat top breaker shape offers high edge strength.	Carbon Steel • Alloy Steel   CNMG120408
		MW	**Wiper insert for medium cutting carbon steel, alloy steel, stainless steel and cast iron** The wiper allows up to two times higher feed. A wide chip pocket prevents chip jamming.	Carbon Steel • Alloy Steel   CNMG120408-MW
		R/L-ES 	**Alternative chipbreaker for medium cutting of stainless steel** Good balance of edge strength and sharpness. Right- or left-hand breaker for unidirectional chip control.	Stainless Steel   TNMG160404R-ES
		R/L-2G	**Alternative chipbreaker for medium cutting of carbon steel and alloy steel** Good balance of edge strength and sharpness. Right- or left-hand breaker for unidirectional chip control. Precision chipbreaker.	Carbon Steel • Alloy Steel   TNMG160404R-2G
	G	**R/L** 	**Medium cutting** Parallel chipbreaker. Good chip control for medium feed rates.	Carbon Steel • Alloy Steel   TNGG160408R
Rough Cutting	M	**RP**	**First recommendation for rough cutting of carbon steel and alloy steel** For interrupted cuts and removing scale. Good balance of cutting edge strength and low cutting resistance because of suitable rake angle.	Carbon Steel • Alloy Steel   CNMG120408-RP

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNMG_GM A103	DNMG_GM  A111	SNMG_GM A117	TNMG_GM A124	VNMG_GM  A130	WNMG_GM A135		GM
	CNMG_MA A103	DNMG_MA  A111	SNMG_MA A117	TNMG_MA A124	VNMG_MA A130	WNMG_MA A135		MA
	CNMG_MH A103	DNMG_MH A111	SNMG_MH A117	TNMG_MH A124	VNMG_MH A130	WNMG_MH A135		MH
	CNMG A104	DNMG  A111	SNMG A118	TNMG A125	VNMG A130	WNMG A135	RNMG A114	Standard
	CNMG_MW A104	DNMX_MW  A111		TNMX_MW A125		WNMG_MW A135		MW
				TNMG_R/L-ES A125				R/L-ES
				TNMG_R/L-2G A125				R/L-2G
		DNGG_R/L A111	SNGG_R/L A118	TNGG_R/L A125	VNGG_R/L A131			R/L
	CNMG_RP  A104	DNMG_RP  A112	SNMG_RP A118	TNMG_RP A126		WNMG_RP A135		RP

CLASSIFICATION

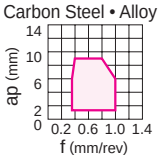
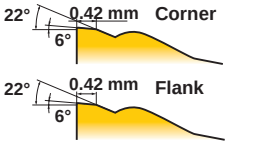
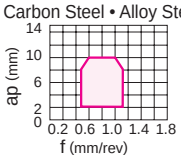
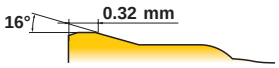
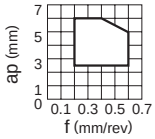
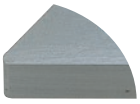
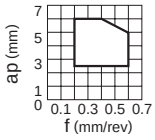
NEGATIVE INSERTS WITH HOLE

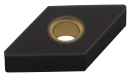
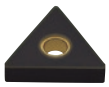
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Rough Cutting	M	**RM**	**First recommendation for rough cutting of stainless steel** Excellent fracture resistance at interrupted cutting due to the optimum land angle and honing geometry.	Stainless Steel   CNMG120408-RM
		RK	**For rough cutting of carbon steel, alloy steel and First recommendation for rough cutting cast iron** Seating surface and wide land 3 or more times that of conventional products and provide high cutting stability for interrupted machining and scale removal.	Cast Iron   CNMG120408-RK
		RS 	**First recommendation for rough cutting of difficult-to-cut materials** **Alternative chip breaker for rough cutting of stainless steels** Positive land increases welding resistance and suppresses chip welding and abrasion at low speed cutting.	Difficult-to-Cut Materials   CNMG120408-RS
		GH	**Alternative chip breaker for rough cutting of carbon steel, alloy steel and cast iron** For interrupted cuts and removing scale. A combination of wide land and a large chip pocket allows high feed rates.	Carbon Steel • Alloy Steel   CNMG120408-GH
		GJ	**Alternative chip breaker for rough cutting of difficult-to-cut materials** Excellent balance of edge sharpness and strength. Edge geometry with high face wear resistance.	Difficult-to-Cut Materials   CNMG120408-GJ
Heavy Cutting	M	**HX**	**First recommendation for heavy cutting of carbon steel and alloy steel** Covers the medium range of the heavy cutting region. Owing to the straight edge and chamfer, it gives a balance of sharpness and strength. Variable land and a wavy chipbreaker for good chip control.	Carbon Steel • Alloy Steel   CNMM190616-HX
		HL	**First recommendation for heavy cutting of stainless steel** **Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Low resistance due to narrow flat land. Achieves high chip breaking ability.	Stainless Steel   CNMM190616-HL
		HR	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** High cutting edge strength. Excellent chip discharge even with high feed and high depth of cut.	Carbon Steel • Alloy Steel   CNMM250924-HR
		HV	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Covers the upper end of the heavy cutting region. Wide land and large chamfer offer high edge strength. A wide chipbreaker prevents chip jamming.	Carbon Steel • Alloy Steel   SNMM190616-HV

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNMG_RM A104	DNMG_RM A112	SNMG_RM A118	TNMG_RM A126		WNMG_RM A135		RM
	CNMG_RK A105	DNMG_RK  A112	SNMG_RK A119	TNMG_RK  A126		WNMG_RK  A136		RK
	CNMG_RS A105	DNMG_RS  A112	SNMG_RS A119	TNMG_RS  A126		WNMG_RS  A136		RS
	CNMG_GH A105	DNMG_GH  A112	SNMG_GH A119	TNMG_GH A126		WNMG_GH A136		GH
	CNMG_GJ A105	DNMG_GJ  A112				WNMG_GJ A136		GJ
	CNMM_HX A105		SNMM_HX A119					HX
	CNMM_HL A105	DNMM_HL  A113	SNMM_HL A119	TNMM_HL A127				HL
	CNMM_HR A106		SNMM_HR A119					HR
	CNMM_HV A106		SNMM_HV A119					HV

CLASSIFICATION

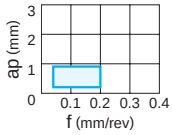
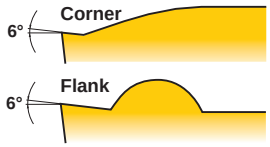
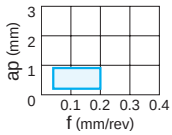
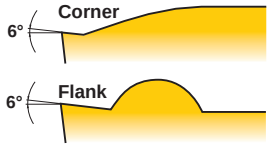
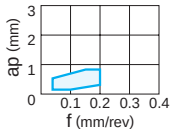
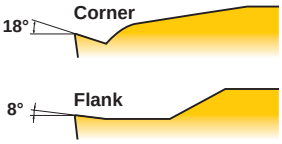
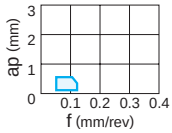
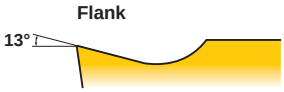
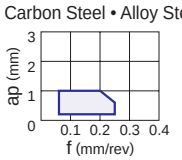
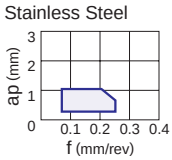
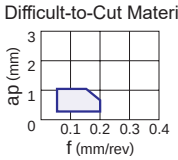
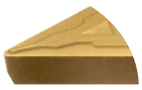
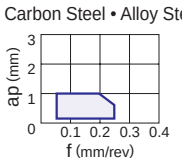
NEGATIVE INSERTS WITH HOLE

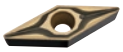
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry	
Heavy Cutting	M	HZ	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Covers the lower end of the heavy cutting region. Low cutting resistance due to positive land and curved edge. Teardrop dots improve chip control without increasing cutting resistance.	Carbon Steel • Alloy Steel   CNMM190616-HZ	
		HM	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel and stainless steel** Flat land provides outstanding balance between cutting edge strength and sharpness.	Carbon Steel • Alloy Steel   CNMM190616-HM	
For Cast Iron	M	Flat Top	**First recommendation for heavy cutting of cast iron** Flat Top. Most effective for unstable machining due to its high edge strength.	Cast Iron  CNMA120408	
	G	Flat Top 	**For heavy cutting of cast iron** Flat Top. Most effective for unstable machining due to its high edge strength. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron  DNGA150408	

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CNMM_HZ A106	DNMM_HZ A113	SNMM_HZ A120	TNMM_HZ A127				HZ
	CNMM_HM A106		SNMM_HM A120					HM
	CNMA A106	DNMA  A113	SNMA A120	TNMA  A127	VNMA A131	WNMA A136		Flat Top(M)
		DNGA A113	SNGA A120	TNGA A127	VNGA A131			Flat Top(G)

CLASSIFICATION

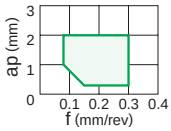
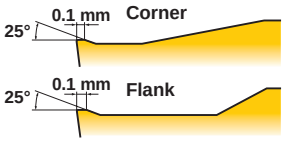
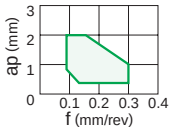
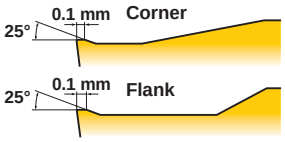
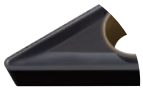
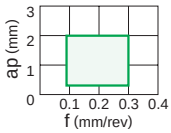
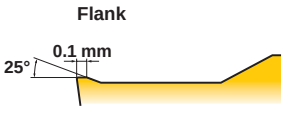
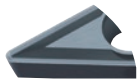
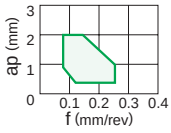
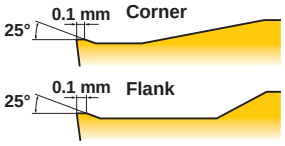
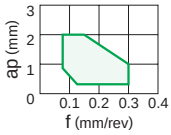
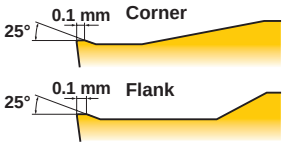
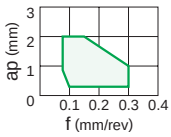
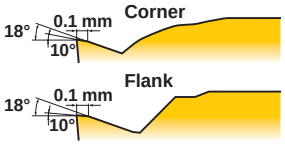
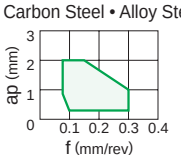
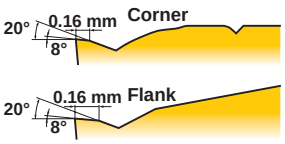
5° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FP	**First recommendation for finishing carbon steel, alloy steel and mild steel** Breaker protrusion at the corner tip controls chips even at small depth of cut. Maintains the edge strength at the corner and prevents sudden fractures.	Carbon Steel • Alloy Steel   VBMT110304-FP
		FM	**First recommendation for finishing stainless steel** Breaker protrusion at the corner tip controls chips even at small depth of cut. Maintains the edge strength at the corner and prevents sudden fractures.	Stainless Steel   VBMT110304-FM
		FV	**First recommendation for finishing carbon steel, alloy steel, mild steel and stainless steel** Suitable for low depths of cut and low feed rates. Sharp cutting edge and low resistance design achieves excellent cutting performance.	Carbon Steel • Alloy Steel   VBMT110304-FV
	G	R/L-F	**Finishing** Lead chipbreaker controls chip flow. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   VBGT110304R-F
Light Cutting	M	LP	**First recommendation for light cutting of carbon steel and alloy steel** Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. Breaker protrusion suitable for depth of cut area achieves a wide range of chip control.	Carbon Steel • Alloy Steel  VBMT110304-LP
		LM	**First recommendation for light cutting of stainless steel** Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. Breaker protrusion suitable for depth of cut area achieves a wide range of chip control.	Stainless Steel  VBMT110304-LM
		NEW LS	**First recommendation for light cutting of difficult-to-cut materials** Prevents welding of the insert and controls white turbidity of the surface finish.	Difficult-to-Cut Materials  VBMT110304-LS
		SV 	**Alternative chipbreaker for carbon steel, alloy steel and stainless steel** Large rake angle provides sharp cutting action. A peninsular dot ensures chip control at depths of cut under 1mm.	Carbon Steel • Alloy Steel  VBMT110304-SV

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
					VBMT_FP  A167			FP
					VBMT_FM A167			FM
					VBMT_FV A167			FV
					VBGT_R/L-F A167	WBGT_R/L-F A175		R/L-F
					VBMT_LP A167			LP
					VBMT_LM A167			LM
					VBMT_LS NEW A168			NEW LS
					VBMT_SV A168			SV

CLASSIFICATION

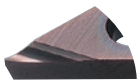
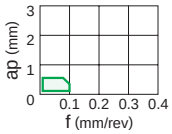
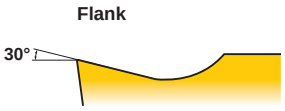
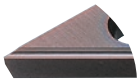
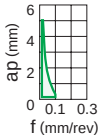
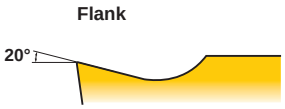
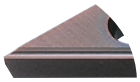
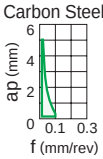
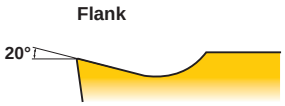
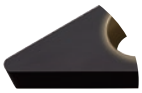
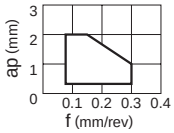
5° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry	
Medium Cutting	M	MP	**First recommendation for medium cutting of carbon steel, alloy steel and mild steel** Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Carbon Steel • Alloy Steel   VBMT160404-MP	
		MM	**First recommendation for medium cutting of stainless steel** Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Stainless Steel   VBMT160404-MM	
		MK 	**First recommendation for medium cutting of cast iron** Optimum balance between sharpness and high edge strength for general use.	Cast Iron   VBMT160404-MK	
		NEW MS 	**First recommendation for medium cutting of difficult-to-cut materials** A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Difficult-to-Cut Materials   VBMT160404-MS	
		Standard	**Alternative chipbreaker for Medium cutting of carbon steel, alloy steel and stainless steel** Balance of edge strength and sharpness due to a combination of a flat land and large rake angle.	Carbon Steel • Alloy Steel   VBMT160404	
		MV	**Alternative chipbreaker for Medium cutting of carbon steel, alloy steel, mild steel and stainless steel** A positive insert with a large rake angle achieves sharp cutting edge performance. The double breakers and round-shaped dots in the rake face achieve a wide range of chip discharge.	Carbon Steel • Alloy Steel   VBMT160404-MV	
		R/L-MV	**Alternative chipbreaker for Medium cutting of carbon steel, alloy steel, mild steel and stainless steel** A positive insert with a large rake angle achieves sharp cutting edge performance. The double breakers and round-shaped dots in the rake face achieve a wide range of chip discharge.	Carbon Steel • Alloy Steel   WBMTL30204R-MV	

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
					VBMT_MP A168			MP
					VBMT_MM A168			MM
					VBMT_MK A168			MK
					VBMT_MS NEW A168			NEW MS
					VBMT A168			Standard
					VBMT_MV A169			MV
						WBMT_R/L-MV A175		R/L-MV

CLASSIFICATION

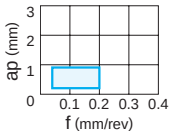
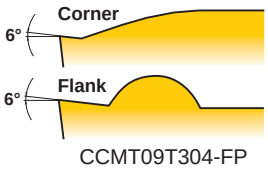
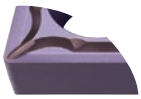
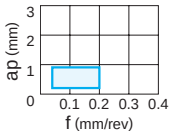
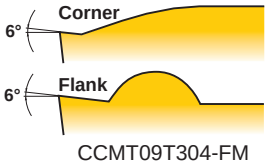
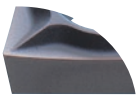
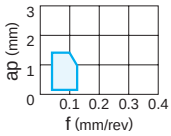
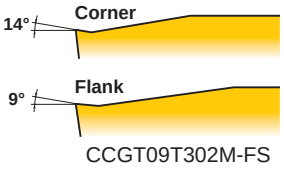
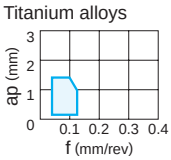
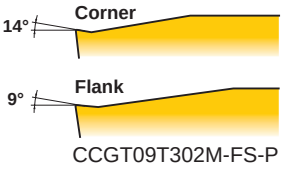
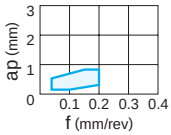
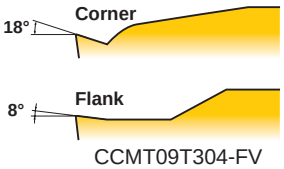
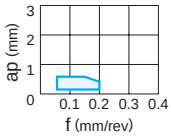
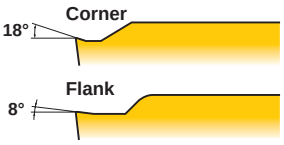
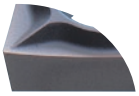
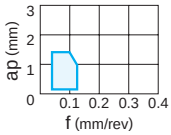
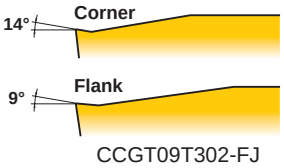
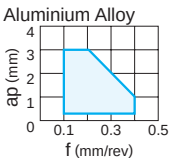
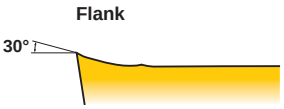
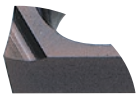
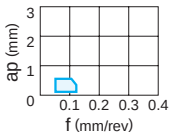
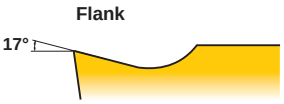
5° POSITIVE INSERTS WITH HOLE

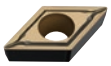
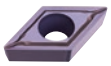
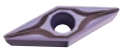
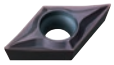
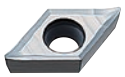
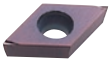
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry	
Medium Cutting	E	R/L-SR 	**Chipbreaker for Medium cutting of automatic lathe machining** A wide lead chipbreaker. Insert designed for low resistance chip control.	Carbon Steel • Alloy Steel   VBET1103V3R-SR	
		R/L-SN 	**Chipbreaker for Medium cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control for low to medium feed rates.	Carbon Steel • Alloy Steel   VBET1103V3R-SN	
		R/LW-SN 	**Chipbreaker for Medium cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control for low to medium feed rates. The wiper produces good cutting surface.	Carbon Steel • Alloy Steel   VBET1103V3RW-SN	
For Cast Iron	M	Flat Top 	**Chipbreaker for Heavy cutting of cast iron** Flat top. Most effective for unstable machining due to its high edge strength.	Cast Iron  VBMW160408	

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
					VBET_R/L-SR A169			R/L-SR
					VBET_R/L-SN A169			R/L-SN
					VBET_R/LW-SN A169			R/LW-SN
					VBMW A169			Flat Top

CLASSIFICATION

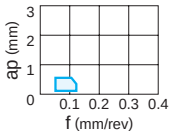
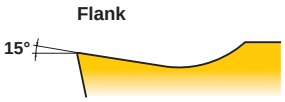
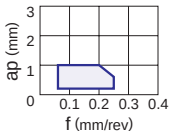
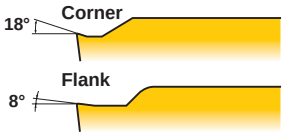
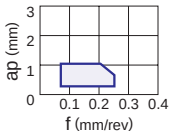
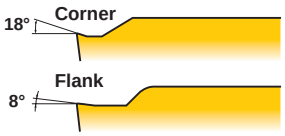
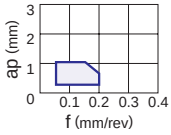
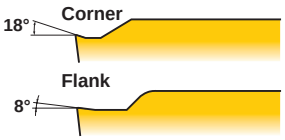
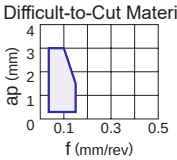
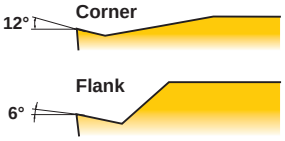
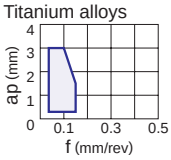
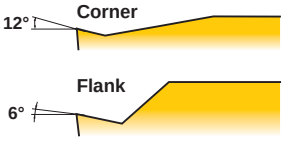
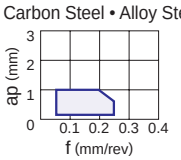
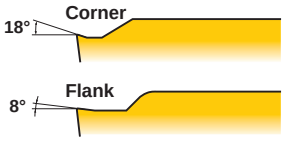
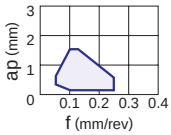
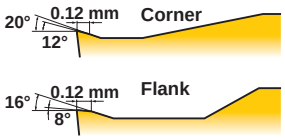
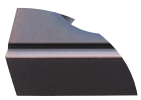
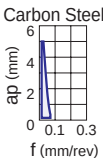
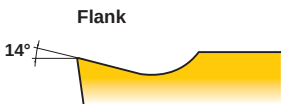
7° POSITIVE INSERTS WITH HOLE

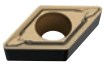
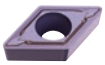
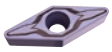
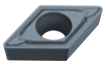
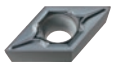
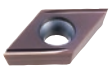
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FP	**First recommendation for finishing carbon steel, alloy steel and mild steel** Breaker protrusion at the corner tip controls chips even at small depth of cut. Maintains the edge strength at the corner and prevents sudden fractures.	Carbon Steel • Alloy Steel   CCMT09T304-FP
		FM 	**First recommendation for finishing stainless steel** Breaker protrusion at the corner tip controls chips even at small depth of cut. Maintains the edge strength at the corner and prevents sudden fractures.	Stainless Steel   CCMT09T304-FM
	G	NEW FS 	**First recommendation for finishing difficult-to-cut materials** Ideal for heat-resistant alloy, titanium alloy and Cobalt chromium alloy. The sharp edge produces a good surface finish. The curved edge allows smooth chip discharge.	Difficult-to-Cut Materials   CCGT09T302M-FS
		NEW FS-P	**First recommendation for finishing titanium alloys** Ideal for Cobalt chromium alloy and Copper alloy. The sharp edge produces a good surface finish. The curved edge allows smooth chip discharge. Lapping of the top surface gives a mirror finish for improved welding resistance.	Titanium alloys   CCGT09T302M-FS-P
	M	FV	**Alternative chipbreaker for finishing carbon steel, alloy steel, mild steel and stainless steel** Suitable for low depths of cut and low feed rates. Sharp cutting edge and low resistance design achieves excellent cutting performance.	Carbon Steel • Alloy Steel   CCMT09T304-FV
		SVX	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Chip control is improved by having a chip breaker geometry suitable for copying.	Carbon Steel • Alloy Steel   XCMT150304-SVX
	G	FJ 	**Alternative chipbreaker for finishing difficult-to-cut materials** Ideal for heat-resistant alloy and titanium alloy. The sharp edge produces a good surface finish. The curved edge allows smooth chip discharge.	Difficult-to-Cut Materials   CCGT09T302-FJ
		AZ	**Chipbreaker for for aluminium alloy** The high rake angle and 3D curved cutting edge provides sharpness at the cutting point. Additionally the 3D shape of the rake face enables excellent chip control. Lapping of the top surface gives a mirror finish for improved welding resistance.	Aluminium Alloy   DCGT11T304-AZ
		R/L-F 	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   CCGT03S102L-F

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Rhombic 25°	Round	Breaker Name and Cross Section
	CCMT_FP A140	DCMT_FP  A149	SCMT_FP A157	TCMT_FP A160	VCMT_FP A170				FP
	CCMT_FM A140	DCMT_FM  A149	SCMT_FM A157	TCMT_FM A160	VCMT_FM  A170				FM
	CCGT_FS NEW A140	DCGT_FS NEW  A149							NEW FS
	CCGT_FS-P NEW A140	DCGT_FS-P NEW A149							NEW FS-P
	CCMT_FV A140	DCMT_FV A149	SCMT_FV A157	TCMT_FV A160	VCMT_FV A170				FV
							XCMT_SVX A178		SVX
	CCGT_FJ A140								FJ
	CCGT_AZ A141	DCGT_AZ  A149		TCGT_AZ A160	VCGT_AZ A170			RCGT_AZ A156	AZ
	CCGT_L-F CCGH_R/L-F A141	DCGT_R/L-F  A150		TCGT_R/L-F A160	VCGT_R/L-F A170				R/L-F

CLASSIFICATION

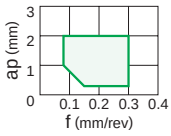
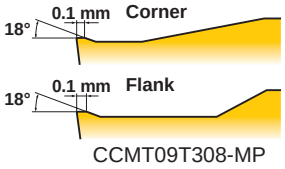
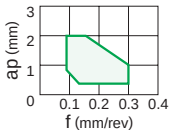
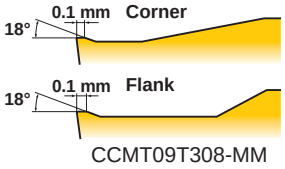
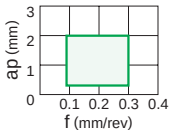
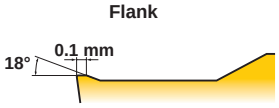
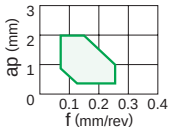
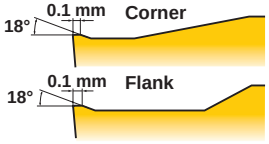
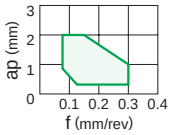
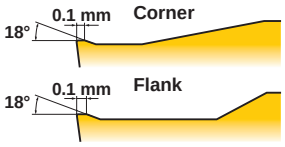
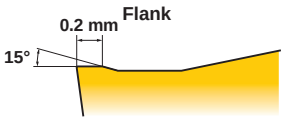
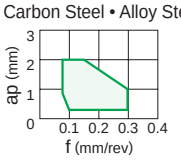
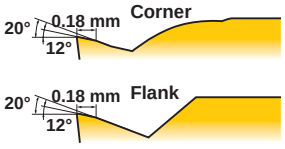
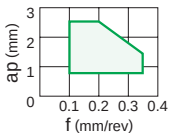
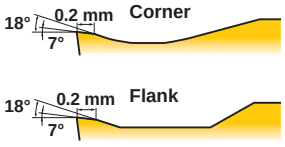
7° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	G	R/L	**Chipbreaker for finishing** Lead chipbreaker. Excellent chip control at low feed rates.	Carbon Steel • Alloy Steel   WCGT020104R
Light Cutting	M	LP	**First recommendation for light cutting of carbon steel, alloy steel and mild steel** Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. Breaker protrusion suitable for depth of cut area achieves a wide range of chip control.	Carbon Steel • Alloy Steel   CCMT09T308-LP
		LM	**First recommendation for light cutting of stainless steel** Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. Breaker protrusion suitable for depth of cut area achieves a wide range of chip control.	Stainless Steel   CCMT09T308-LM
		NEW LS	**First recommendation for light cutting of difficult-to-cut materials** Prevents welding of the insert and controls cloudy surface of the surface finish.	Difficult-to-Cut Materials   CCMT09T308-LS
	G	NEW LS	**First recommendation for light cutting of difficult-to-cut materials** Ideal for heat-resistant alloy, titanium alloy and Cobalt chromium alloy. Parallel cutting edge. Achieves stable chip control in a wide range of areas from low to medium depth of cuts.	Difficult-to-Cut Materials   CCGT09T304M-LS
		NEW LS-P	**First recommendation for light cutting of titanium alloys** Ideal for Cobalt chromium alloy and Copper alloy. Parallel cutting edge. Achieves stable chip control in a wide range of areas from low to medium depth of cuts. Lapping of the top surface gives a mirror finish for improved welding resistance.	Titanium alloys   CCGT09T304M-LS-P
	M	SV	**Alternative chipbreaker for light cutting of carbon steel, alloy steel, mild steel and stainless steel** Large rake angle provides sharp cutting action. A peninsular dot ensures chip control at depths of cut under 1mm.	Carbon Steel • Alloy Steel   CCMH060204-SV
		SW	**Wiper insert for light cutting of carbon steel, alloy steel, mild steel and stainless steel** In comparison to conventional chip breakers, the surface finish is maintained even if the feed per revolution is doubled. Positive land improves sharpness.	Carbon Steel • Alloy Steel   CCMT09T304-SW
	G	R/L-SS 	**Chipbreaker for light cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control at low feed rates.	Carbon Steel • Alloy Steel   CCGT09T302R-SS

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Rhombic 25°	Round	Breaker Name and Cross Section
						WCGT_R/L A176			R/L
	CCMT_LP A141	DCMT_LP  A150	SCMT_LP A157	TCMT_LP A161	VCMT_LP A170				LP
	CCMT_LM A142	DCMT_LM  A150	SCMT_LM A157	TCMT_LM A161	VCMT_LM  A170				LM
	CCMT_LS NEW A142	DCMT_LS NEW  A150		TCMT_LS NEW A161	VCMT_LS NEW A171				NEW LS(M)
	CCGT_LS NEW A142	DCGT_LS NEW  A150			VCGT_LS NEW A171				NEW LS(G)
	CCGT_LS-P NEW A142	DCGT_LS-P NEW A150			VCGT_LS-P NEW A171				NEW LS-P
	CCMH_SV A142	DCMT_SV A151			VCMT_SV A171				SV
	CCMT_SW A142								SW
	CCGT_R/L-SS A143	DCGT_R/L-SS  A151							R/L-SS

CLASSIFICATION

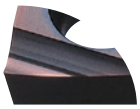
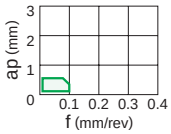
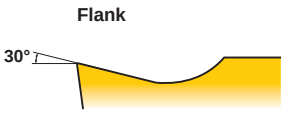
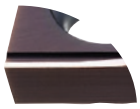
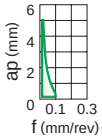
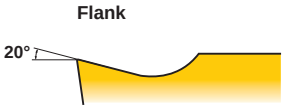
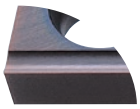
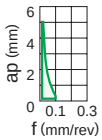
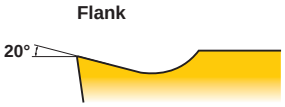
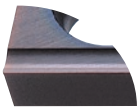
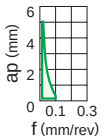
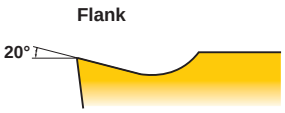
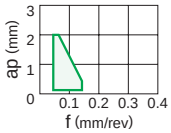
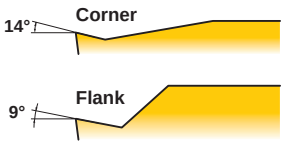
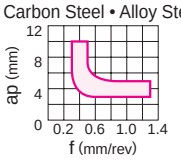
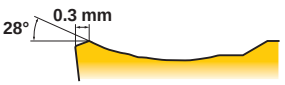
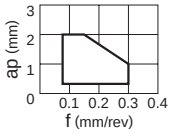
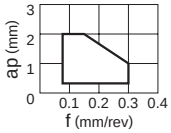
7° POSITIVE INSERTS WITH HOLE

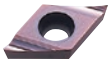
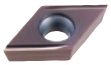
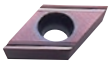
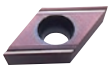
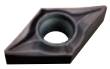
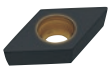
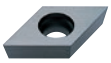
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Medium Cutting	M	**MP**	**First recommendation for medium cutting of carbon steel, alloy steel and mild steel** Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Carbon Steel • Alloy Steel   CCMT09T308-MP
		MM	**First recommendation for medium cutting of stainless steel** Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Stainless Steel   CCMT09T308-MM
		MK	**First recommendation for medium cutting of cast iron** Optimum balance between sharpness and high edge strength for general use.	Cast Iron   CCMT09T308-MK
		NEW **MS**	**First recommendation for medium cutting of difficult-to-cut materials** A wide chip pocket controls increasing of the cutting resistance and reduces vibration and chip jamming even at large depth of cut.	Difficult-to-Cut Materials   CCMT09T308-MS
		Standard	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron** Balance of edge strength and sharpness due to a combination of a flat land and large rake angle.	Carbon Steel • Alloy Steel   CCMT09T308  RCMX1204M0
		MV	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel, mild steel and stainless steel** A positive insert and the large rake angle achieve sharp cutting edge performance. The double breakers and round shape in the rake face achieve a wide range of chip discharge.	Carbon Steel • Alloy Steel   CCMH060204-MV
		MW	**Wiper insert for medium cutting of carbon steel, alloy steel, mild steel and stainless steel** The wiper allows up to two times higher feed. A wide chip pocket prevents chip jamming.	Carbon Steel • Alloy Steel   CCMT09T308-MW

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Rhombic 25°	Round	Breaker Name and Cross Section
	CCMT_MP A143	DCMT_MP A151	SCMT_MP A157	TCMT_MP A161	VCMT_MP A171				MP
	CCMT_MM A143	DCMT_MM A151	SCMT_MM A157	TCMT_MM A161	VCMT_MM A171				MM
	CCMT_MK A143	DCMT_MK A151	SCMT_MK A158	TCMT_MK A161	VCMT_MK A171				MK
	CCMT_MS NEW A144	DCMT_MS NEW A152	SCMT_MS NEW A158	TCMT_MS NEW A161	VCMT_MS NEW A171				NEW MS
	CCMT A144	DCMT A152	SCMT A158	TCMT A162	VCMT A172	WCMT A176		RCMT A156	Standard
								RCMX A156	
	CCMH_MV A144	DCMT_MV A152			VCMT_MV A172				MV
	CCMT_MW A144								MW

CLASSIFICATION

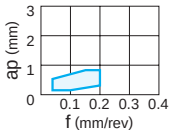
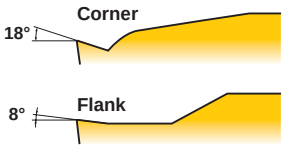
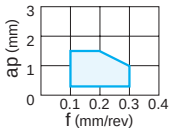
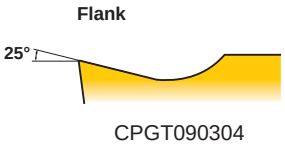
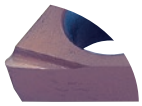
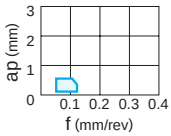
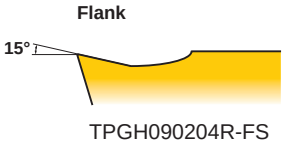
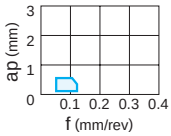
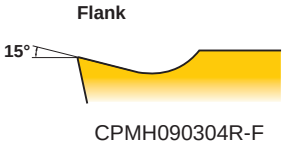
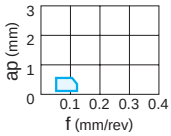
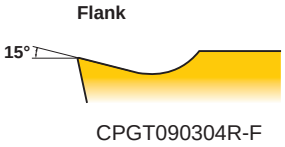
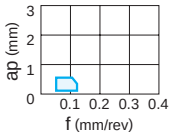
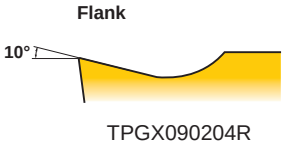
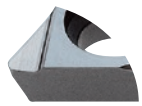
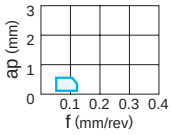
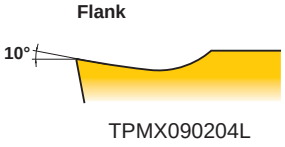
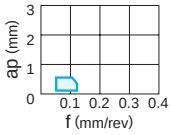
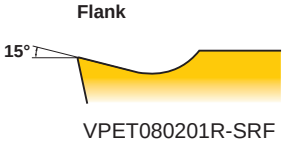
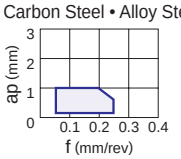
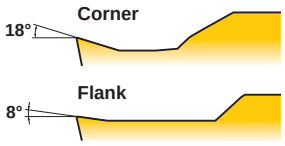
7° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry	
Medium Cutting	E	R/L-SR 	**Chipbreaker for medium cutting of automatic lathe machining** A wide lead chipbreaker. Insert designed for low resistance chip control.	Carbon Steel • Alloy Steel 	 CCET09T3V3R-SR
	G	R/L-SN 	**Chipbreaker for medium cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control at low to medium feed rates.	Carbon Steel • Alloy Steel 	 CCGT09T3V3R-SN
	E	R/L-SN 	**Chipbreaker for medium cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control at low to medium feed rates. Suitable for precise machining with E class tolerance.	Carbon Steel • Alloy Steel 	 CCET09T3V3R-SN
		R/LW-SN 	**Chipbreaker for medium cutting of automatic lathe machining** A parallel chipbreaker. Excellent chip control at low to medium feed rates. The wiper produces a good surface finish.	Carbon Steel • Alloy Steel 	 CCET09T3V3RW-SN
	G	SMG	**Chipbreaker for medium cutting of automatic lathe machining** 3D moulded chipbreaker provides good chip control. G class insert gives sharp cutting action, allowing high precision machining. Breaker geometry appropriate for copying and back turning.	Carbon Steel • Alloy Steel 	 CCGT09T304M-SMG
Heavy Cutting	M	RR	**Chipbreaker for heavy cutting of carbon steel and alloy steel** A wide groove chipbreaker prevents chips from jamming at large depths of cut. Small dimples improve chip control at small depths of cut.	Carbon Steel • Alloy Steel 	 RCMX2006M0-RR
For Cast Iron	M	Flat Top	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to its high edge strength.	Cast Iron 	CCMW09T308
	G	Flat Top	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to its high edge strength. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron 	CCGW09T300

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Rhombic 25°	Round	Breaker Name and Cross Section
	CCET_R/L-SR A145	DCET_R/L-SR  A152							R/L-SR
	CCGT_R/L-SN A145	DCGT_R/L-SN  A153							R/L-SN(G)
	CCET_R/L-SN A146	DCET_R/L-SN  A153							R/L-SN(E)
	CCET_R/LW-SN A146	DCET_R/LW-SN  A154							R/LW-SN
	CCGT_SMG A146	DCGT_SMG  A154							SMG
								RCMX_RR A156	RR
	CCMW A147	DCMW  A154	SCMW A158	TCMW A162	VCMW A172				Flat Top(M)
	CCGW A147	DCGW  A154							Flat Top(G)

CLASSIFICATION

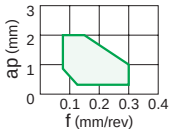
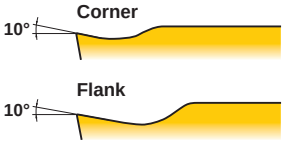
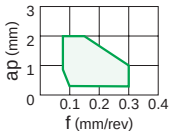
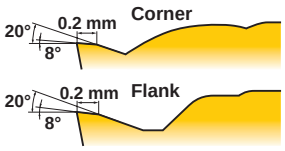
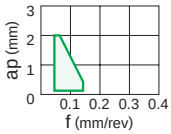
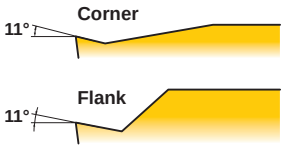
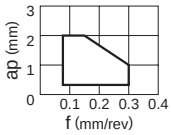
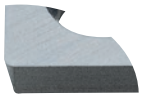
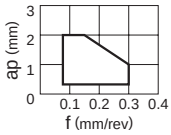
11° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FV	**First recommendation for finishing carbon steel, alloy steel, mild steel and stainless steel** Suitable for low depths of cut and low feed rates. Sharp cutting edge and low resistance design achieves excellent cutting performance.	Carbon Steel • Alloy Steel   CPMH090304-FV
	G	Standard	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Good chip control for low to medium feed rates.	Aluminium Alloy   CPGT090304
		R/L-FS 	**Chipbreaker for finishing carbon steel, alloy steel, stainless steel, cast iron and aluminium alloy** Small wide lead chipbreaker. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   TPGH090204R-FS
	M	R/L-F	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   CPMH090304R-F
	G	R/L-F	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   CPGT090304R-F
		R/L	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Good chip control for low to medium feed rates.	Carbon Steel • Alloy Steel   TPGX090204R
	M	L 	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Good chip control for low to medium feed rates.	Carbon Steel • Alloy Steel   TPMX090204L
	E	SRF	**Chipbreaker for finishing** Lead chipbreaker controls chip flow. Sharp cutting edge gives a good surface finish.	Carbon Steel • Alloy Steel   VPET080201R-SRF
Light Cutting	M	SV	**First recommendation for light cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron** Large rake angle provides sharp cutting action. A peninsular dot ensures chip control at depths of cut under 1mm.	Carbon Steel • Alloy Steel   CPMH090304-SV

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CPMH_FV A148			TPMH_FV A164				FV
	CPGT A148							Standard
				TPGH_R/L-FS A164		WPGT_R/L-FS A177		R/L-FS
	CPMH_R/L-F A148							R/L-F(M)
	CPGT_R/L-F A148							R/L-F(G)
				TPGX_R/L A165				R/L
				TPMX_L A165				L
					VPET_R/L-SRF A174			SRF
	CPMH_SV A148			TPMH_SV A165				SV

CLASSIFICATION

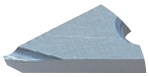
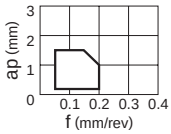
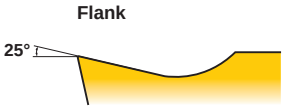
11° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry	
Medium Cutting	M	**Standard**	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel and stainless steel** Standard, general purpose chipbreaker.	Carbon Steel • Alloy Steel 	 CPMX090304	
		MV	**First recommendation for medium cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron** A positive insert and large rake angle achieves sharp cutting edge performance. Double breakers in the rake face achieve a wide range of chip discharge.	Carbon Steel • Alloy Steel 	 CPMH090304-MV	
	G	**SMG**	**Chipbreaker for medium cutting of automatic lathe machining** 3D moulded chipbreaker provides good chip control. G class insert gives sharp cutting action, allowing high precision machining. Breaker geometry appropriate for copying and back turning.	Carbon Steel • Alloy Steel 	 VPGT110301M-SMG	
For Cast Iron	M	**Flat Top**	**Chipbreaker for Heavy cutting of cast iron** Flat top. Most effective for unstable machining due to its high edge strength.	Cast Iron 	SPMW120308	
	G	**Flat Top** 	**Chipbreaker for Heavy cutting of cast iron** Flat top. Most effective for unstable machining due to its high edge strength. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron 	SPGX120308	

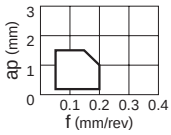
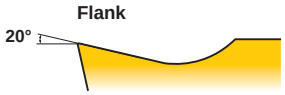
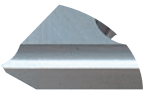
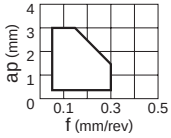
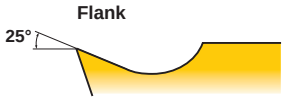
	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
	CPMX A148		SPMT A159	TPMX A165				Standard
	CPMH_MV A148			TPMH_MV A165		WPMT_MV A177		MV
					VPGT_SMG A174			SMG
			SPMW A159					Flat Top(M)
			SPGX A159	TPGX A166				Flat Top(G)

CLASSIFICATION

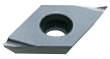
15° POSITIVE INSERTS WITH HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
For Aluminium Alloy	G	R/L 	**Chipbreaker for aluminium alloy cutting** Lead chipbreaker. Sharp cutting edge gives a good surface finish.	Aluminium Alloy   VDGX160302R

20° POSITIVE INSERTS WITH HOLE

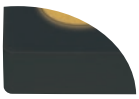
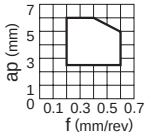
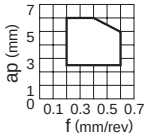
Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
For Aluminium Alloy	G	R/L-F	**Chipbreaker for aluminium alloy cutting** Lead chipbreaker. Sharp cutting edge gives a good surface finish.	Aluminium Alloy   DEGX150402R-F
		R/L 	**Chipbreaker for aluminium alloy cutting** A parallel chipbreaker. Sharp cutting edge gives a good surface finish. Good chip control for medium feed rates.	Aluminium Alloy   DEGX150402R

	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
					VDGX_R/L A173			R/L

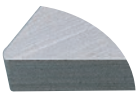
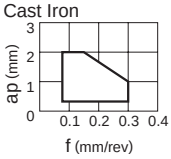
	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°	Round	Breaker Name and Cross Section
		DEGX_R/L-F  A155						R/L-F
		DEGX_R/L A155		TEGX_R/L A163				R/L

CLASSIFICATION

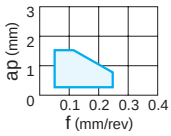
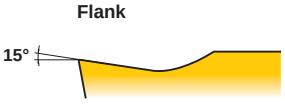
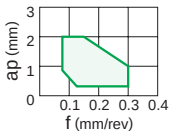
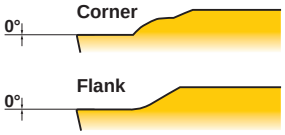
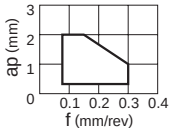
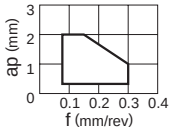
NEGATIVE INSERTS WITHOUT HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
For Cast Iron	M	Flat Top 	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to high edge strength and stable insert clamping.	Cast Iron  SNMN120408
For Cast Iron	G	Flat Top	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to high edge strength and stable insert clamping. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron  SNGN120408

7° POSITIVE INSERTS WITHOUT HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
For Cast Iron	G	Flat Top 	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to high edge strength and stable insert clamping. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron  TNGN160408

11° POSITIVE INSERTS WITHOUT HOLE

Application	Tolerance	Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	G	R/L	**Chipbreaker for finishing** A parallel chipbreaker. Good chip control for low to medium feed rates.	Carbon Steel • Alloy Steel   SPGR090304R
Light to Medium Cutting	M	Standard	**Chipbreaker for light to medium cutting of carbon steel, alloy steel and stainless steel** Standard, general purpose chipbreaker.	Carbon Steel • Alloy Steel   SPMR090308
For Cast Iron	M	Flat Top	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to high edge strength and stable insert clamping.	Cast Iron  SPMN090308
For Cast Iron	G	Flat Top	**Chipbreaker for heavy cutting of cast iron** Flat top. Most effective for unstable machining due to high edge strength and stable insert clamping. Can be used on workpieces requiring close tolerances due to G class insert tolerance.	Cast Iron  SPGN090308

	Rhombic 80°	Square 90°	Triangular 60°	Breaker Name and Cross Section
	CNMN A137	SNMN A138	TNMN A139	Flat Top(M)
		SNGN A138	TNGN A139	Flat Top(G)

	Rhombic 80°	Square 90°	Triangular 60°	Breaker Name and Cross Section
			TCGN A181	Flat Top

	Rhombic 80°	Square 90°	Triangular 60°	Breaker Name and Cross Section
		SPGR_R A180	TPGR_R/L A182	R/L
		SPMR A180	TPMR A182	Standard
		SPMN A180	TPMN A182	Flat Top(M)
		SPGN A180	TPGN A182	Flat Top(G)

SPECIAL PURPOSE INSERTS

Application	Tolerance	Tool Holder Type	Inserts
Special	G	TL Type	RTG A179

RECOMMENDED CUTTING CONDITIONS

■ NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Mild Steel (ASTM A36, AISI 1010)	≤180HB	●	F	1	FY	VP25N	285—450	0.09—0.23	0.20—0.80
		●	F	2	FY	NX2525	270—385	0.09—0.23	0.20—0.80
		●	F	3	FS	NX2525	270—385	0.09—0.23	0.20—0.70
		●	L	1	SY	VP25N	260—410	0.16—0.33	0.50—1.20
		●	L	2	SY	NX2525	245—350	0.16—0.33	0.50—1.20
		◐	F	1	FY	MP3025	275—425	0.09—0.23	0.20—0.80
		◐	F	2	FY	NX3035	260—370	0.09—0.23	0.20—0.80
		◐	F	3	FS	NX2525	270—385	0.09—0.23	0.20—0.70
		◐	L	1	SY	MP3025	255—385	0.16—0.33	0.50—1.20
		◐	L	2	SY	NX3035	240—340	0.16—0.33	0.50—1.20
		✠	F	1	FY	UE6020	285—465	0.09—0.23	0.20—0.80
		✠	F	2	FS	UE6020	285—465	0.09—0.23	0.20—0.70
		✠	L	1	SY	UE6020	260—425	0.16—0.33	0.50—1.20
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 — 280HB	●	F	1	FP	NX2525	210—300	0.08—0.25	0.10—1.00
		●	F	2	FH	AP25N	220—345	0.08—0.20	0.20—1.00
		●	F	3	FH	NX2525	210—300	0.08—0.20	0.20—1.00
		●	F	4	R/L-F	MP3025	215—330	0.05—0.15	0.10—0.50
		●	F	5	PK	NX2525	200—285	0.10—0.30	0.20—1.00
		●	L	1	LP	MC6015	210—360	0.10—0.40	0.30—2.00
		●	L	2	LP	UE6105	225—410	0.10—0.40	0.30—2.00
		●	L	3	SH	UE6105	225—410	0.10—0.40	0.30—2.00
		●	L	4	LP	MP3025	195—300	0.10—0.40	0.30—2.00
		●	L	5	SH	AP25N	200—315	0.10—0.40	0.30—2.00
		●	L	6	SH	NX2525	190—275	0.10—0.40	0.30—2.00
		●	L	7	SA	UE6105	225—410	0.10—0.40	0.30—2.00
		●	L	8	SA	NX2525	190—275	0.10—0.40	0.30—2.00
		●	L	9	SW	UE6105	225—410	0.10—0.50	0.30—2.50
		●	L	10	SW	MP3025	195—300	0.10—0.50	0.30—2.50
		●	L	11	SW	NX2525	190—275	0.10—0.50	0.30—2.50
		●	L	12	R/L-K	MP3025	195—300	0.08—0.20	0.30—1.20
		●	M	1	MP	MC6015	195—330	0.16—0.50	0.30—4.00
		●	M	2	MP	UE6105	205—375	0.16—0.50	0.30—4.00
		●	M	3	MP	MP3025	180—275	0.16—0.50	0.30—4.00
		●	M	4	MA	UE6105	205—375	0.20—0.50	0.30—4.00
		●	M	5	MH	UE6105	205—375	0.20—0.55	1.00—4.00
		●	M	6	Std	UE6105	205—375	0.25—0.60	1.50—5.00
		●	M	7	Std	MP3025	180—275	0.25—0.60	1.50—5.00
		●	M	8	Std	NX2525	175—250	0.25—0.60	1.50—5.00
		●	M	9	Std	UTi20T	90—130	0.25—0.60	1.50—5.00
		●	M	10	MW	UE6105	205—375	0.20—0.60	0.90—4.00
		●	M	11	R/L	MP3025	180—275	0.15—0.32	0.40—2.00
		●	R	1	RP	MC6015	185—310	0.25—0.60	1.50—6.00
		●	R	2	RP	UE6105	190—355	0.25—0.60	1.50—6.00
		●	R	3	GH	UE6105	190—355	0.25—0.60	1.50—6.00
		●	H	1	HX	MC6025	165—265	0.50—1.26	3.00—11.00
		●	H	2	HX	UE6110	165—280	0.50—1.26	3.00—11.00
		●	H	3	HV	MC6025	135—220	0.70—1.30	4.00—12.00

Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Cutting Area : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 | 280HB	●	**H**	4	**HV**	**UE6110**	135—230	0.70—1.30	4.00—12.00
		●	**H**	5	**HZ**	**MC6025**	165—265	0.40—1.20	2.00—10.00
		●	**H**	6	**HZ**	**UE6110**	165—280	0.40—1.20	2.00—10.00
		●	**H**	7	**HL**	**MC6025**	165—265	0.40—1.00	1.50—8.00
		●	**H**	8	**HM**	**MC6025**	165—265	0.50—1.10	2.00—10.00
		◐	**F**	1	**FP**	**MP3025**	215—330	0.08—0.25	0.10—1.00
		◐	**F**	2	**FH**	**MP3025**	215—330	0.08—0.20	0.20—1.00
		◐	**F**	3	**FH**	**NX3035**	200—285	0.08—0.20	0.20—1.00
		◐	**F**	4	**FH**	**UE6110**	230—395	0.08—0.20	0.20—1.00
		◐	**L**	1	**LP**	**MC6015**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	2	**SH**	**MC6015**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	3	**SA**	**MC6015**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	4	**LP**	**UE6110**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	5	**SH**	**UE6110**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	6	**SA**	**UE6110**	210—360	0.10—0.40	0.30—2.00
		◐	**L**	7	**LP**	**MP3025**	195—300	0.10—0.40	0.30—2.00
		◐	**L**	8	**SH**	**NX3035**	185—260	0.10—0.40	0.30—2.00
		◐	**L**	9	**SA**	**NX3035**	185—260	0.10—0.40	0.30—2.00
		◐	**L**	10	**SW**	**MC6015**	210—360	0.10—0.50	0.30—2.50
		◐	**L**	11	**SW**	**UE6110**	210—360	0.10—0.50	0.30—2.50
		◐	**L**	12	**SW**	**NX3035**	185—260	0.10—0.50	0.30—2.50
		◐	**M**	1	**MP**	**MC6015**	195—330	0.16—0.50	0.30—4.00
		◐	**M**	2	**MA**	**MC6015**	195—330	0.20—0.50	0.30—4.00
		◐	**M**	3	**MH**	**MC6015**	195—330	0.20—0.55	1.00—4.00
		◐	**M**	4	**Std**	**MC6015**	195—330	0.25—0.60	1.50—5.00
		◐	**M**	5	**MP**	**UE6110**	195—330	0.16—0.50	0.30—4.00
		◐	**M**	6	**MA**	**UE6110**	195—330	0.20—0.50	0.30—4.00
		◐	**M**	7	**MA**	**NX3035**	170—240	0.20—0.50	0.30—4.00
		◐	**M**	8	**MH**	**UE6110**	195—330	0.20—0.55	1.00—4.00
		◐	**M**	9	**Std**	**UE6110**	195—330	0.25—0.60	1.50—5.00
		◐	**M**	10	**Std**	**NX3035**	170—240	0.25—0.60	1.50—5.00
		◐	**M**	11	**MW**	**MC6015**	195—330	0.20—0.60	0.90—4.00
		◐	**M**	12	**MW**	**UE6110**	195—330	0.20—0.60	0.90—4.00
		◐	**R**	1	**RP**	**MC6015**	185—310	0.25—0.60	1.50—6.00
		◐	**R**	2	**RP**	**UE6110**	185—310	0.25—0.60	1.50—6.00
		◐	**R**	3	**GH**	**UE6110**	185—310	0.25—0.60	1.50—6.00
		◐	**H**	1	**HX**	**MC6025**	165—265	0.50—1.26	3.00—11.00
		◐	**H**	2	**HX**	**UE6020**	155—255	0.50—1.26	3.00—11.00
		◐	**H**	3	**HV**	**MC6025**	135—220	0.70—1.30	4.00—12.00
		◐	**H**	4	**HV**	**UE6020**	125—210	0.70—1.30	4.00—12.00
		◐	**H**	5	**HZ**	**MC6025**	165—265	0.40—1.20	2.00—10.00
		◐	**H**	6	**HL**	**MC6025**	165—265	0.40—1.00	1.50—8.00
		◐	**H**	7	**HM**	**MC6025**	165—265	0.50—1.10	2.00—10.00
		◐	**H**	8	**HR**	**MC6025**	135—220	0.70—1.30	3.00—12.00
		◐	**H**	9	**HZ**	**UE6110**	165—280	0.40—1.20	2.00—10.00
		◐	**H**	10	**HAS**	**UE6020**	155—255	0.40—1.10	2.00—9.00
		✠	**F**	1	**FP**	**MC6025**	230—375	0.08—0.25	0.10—1.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 – 280HB	✠	**F**	2	**FP**	**MC6015**	230—395	0.08—0.25	0.10—1.00
		✠	**F**	3	**FH**	**UE6110**	230—395	0.08—0.20	0.20—1.00
		✠	**F**	4	**FH**	**UE6020**	220—360	0.08—0.20	0.20—1.00
		✠	**L**	1	**LP**	**MC6025**	210—345	0.10—0.40	0.30—2.00
		✠	**L**	2	**LP**	**MC6035**	185—260	0.10—0.40	0.30—2.00
		✠	**L**	3	**SH**	**MC6025**	210—345	0.10—0.40	0.30—2.00
		✠	**L**	4	**SA**	**MC6025**	210—345	0.10—0.40	0.30—2.00
		✠	**L**	5	**SH**	**UE6020**	200—330	0.10—0.40	0.30—2.00
		✠	**L**	6	**SA**	**UE6020**	200—330	0.10—0.40	0.30—2.00
		✠	**M**	1	**MP**	**MC6025**	195—315	0.16—0.50	0.30—4.00
		✠	**M**	2	**MP**	**MC6035**	170—240	0.16—0.50	0.30—4.00
		✠	**M**	3	**MP**	**UE6020**	185—300	0.16—0.50	0.30—4.00
		✠	**M**	4	**MA**	**MC6025**	195—315	0.20—0.50	0.30—4.00
		✠	**M**	5	**MA**	**MC6035**	170—240	0.20—0.50	0.30—4.00
		✠	**M**	6	**MA**	**UE6020**	185—300	0.20—0.50	0.30—4.00
		✠	**M**	7	**MH**	**MC6025**	195—315	0.20—0.55	1.00—4.00
		✠	**M**	8	**MH**	**MC6035**	170—240	0.20—0.55	1.00—4.00
		✠	**M**	9	**MH**	**UE6020**	185—300	0.20—0.55	1.00—4.00
		✠	**M**	10	**Std**	**MC6025**	195—315	0.25—0.60	1.50—5.00
		✠	**M**	11	**Std**	**MC6035**	170—240	0.25—0.60	1.50—5.00
		✠	**M**	12	**Std**	**UE6020**	185—300	0.25—0.60	1.50—5.00
		✠	**M**	13	**MW**	**MC6025**	195—315	0.20—0.60	0.90—4.00
		✠	**M**	14	**MW**	**UE6020**	185—300	0.20—0.60	0.90—4.00
		✠	**R**	1	**RP**	**MC6025**	185—295	0.25—0.60	1.50—6.00
		✠	**R**	2	**RP**	**MC6035**	160—225	0.25—0.60	1.50—6.00
		✠	**R**	3	**GH**	**UE6020**	175—285	0.25—0.60	1.50—6.00
		✠	**H**	1	**HX**	**MC6035**	140—200	0.50—1.26	3.00—11.00
		✠	**H**	2	**HX**	**UH6400**	140—195	0.50—1.26	3.00—11.00
		✠	**H**	3	**HV**	**MC6035**	115—165	0.70—1.30	4.00—12.00
		✠	**H**	4	**HV**	**UH6400**	115—160	0.70—1.30	4.00—12.00
		✠	**H**	5	**HZ**	**UE6020**	155—255	0.40—1.20	2.00—10.00
		✠	**H**	6	**HZ**	**MC6035**	140—200	0.40—1.20	2.00—10.00
		✠	**H**	7	**HZ**	**UH6400**	140—195	0.40—1.20	2.00—10.00
		✠	**H**	8	**HL**	**MC6035**	140—200	0.40—1.00	1.50—8.00
		✠	**H**	9	**HM**	**MC6035**	140—200	0.50—1.10	2.00—10.00
		✠	**H**	10	**HR**	**MC6035**	115—165	0.70—1.30	3.00—12.00
		✠	**H**	11	**HAS**	**UH6400**	140—195	0.40—1.10	2.00—9.00

Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Cutting Area : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Austenitic Stainless Steel (AISI 304, AISI 316)	≤200HB	●	**L**	1	**LM**	**MC7015**	180—285	0.10—0.30	0.30—2.00
		●	**L**	2	**SH**	**US735**	95—185	0.10—0.40	0.30—2.00
		●	**L**	3	**SH**	**NX2525**	65—135	0.10—0.40	0.30—2.00
		●	**L**	4	**SW**	**US7020**	110—275	0.10—0.50	0.30—2.50
		●	**M**	1	**MM**	**MC7015**	165—260	0.15—0.45	0.70—5.00
		●	**M**	2	**GM**	**MC7015**	165—260	0.16—0.50	0.50—4.00
		●	**M**	3	**MS**	**US7020**	100—250	0.16—0.50	0.50—4.00
		●	**M**	4	**MA**	**US7020**	100—250	0.20—0.50	0.30—4.00
		●	**M**	5	**MH**	**US7020**	100—250	0.20—0.55	1.00—4.00
		●	**M**	6	**MW**	**US7020**	100—250	0.20—0.60	0.90—4.00
		●	**R**	1	**RM**	**MC7015**	155—245	0.25—0.55	1.50—6.00
		●	**R**	2	**GH**	**US7020**	95—235	0.25—0.60	1.50—6.00
		●	**H**	1	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		●	**H**	2	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		●	**H**	3	**GH**	**US7020**	95—235	0.25—0.60	1.50—6.00
		◐	**L**	1	**LM**	**MC7025**	165—220	0.10—0.30	0.30—2.00
		◐	**L**	2	**SH**	**US735**	95—185	0.10—0.40	0.30—2.00
		◐	**M**	1	**MM**	**MC7025**	150—200	0.15—0.45	0.70—5.00
		◐	**M**	2	**GM**	**MC7025**	150—200	0.16—0.50	0.50—4.00
		◐	**M**	3	**MA**	**MC7025**	150—200	0.20—0.50	0.30—4.00
		◐	**M**	4	**MS**	**US735**	90—170	0.16—0.50	0.50—4.00
		◐	**M**	5	**MA**	**US735**	90—170	0.20—0.50	0.30—4.00
		◐	**R**	1	**RM**	**MC7025**	140—190	0.25—0.55	1.50—6.00
		◐	**R**	2	**GH**	**US735**	85—160	0.25—0.60	1.50—6.00
		◐	**H**	1	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		◐	**H**	2	**HM**	**US735**	75—140	0.50—1.10	2.00—10.00
		✠	**L**	1	**LM**	**MP7035**	95—155	0.10—0.30	0.30—2.00
		✠	**L**	2	**SH**	**US735**	95—185	0.10—0.40	0.30—2.00
		✠	**M**	1	**MM**	**MP7035**	90—145	0.15—0.45	0.70—5.00
		✠	**M**	2	**GM**	**MP7035**	90—145	0.16—0.50	0.50—4.00
		✠	**M**	3	**MA**	**MP7035**	90—145	0.20—0.50	0.30—4.00
		✠	**M**	4	**MS**	**US735**	90—170	0.16—0.50	0.50—4.00
		✠	**M**	5	**MS**	**VP15TF**	80—135	0.16—0.50	0.50—4.00
		✠	**M**	6	**MS**	**UP20M**	100—150	0.16—0.50	0.50—4.00
		✠	**M**	7	**MS**	**UTi20T**	80—115	0.16—0.50	0.50—4.00
		✠	**M**	8	**MA**	**VP15TF**	80—135	0.20—0.50	0.30—4.00
		✠	**M**	9	**Std**	**VP15TF**	80—135	0.25—0.60	1.50—5.00
		✠	**R**	1	**RM**	**MP7035**	85—135	0.25—0.55	1.50—6.00
		✠	**R**	2	**GH**	**US735**	85—160	0.25—0.60	1.50—6.00
		✠	**H**	1	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		✠	**H**	2	**HM**	**US735**	75—140	0.50—1.10	2.00—10.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Austenitic Stainless Steel (AISI 304LN, AISI 316LN)	>200HB	●	L	1	LM	MC7015	150—240	0.10—0.30	0.30—2.00
		●	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		●	L	3	SH	NX2525	55—115	0.10—0.40	0.30—2.00
		●	L	4	SW	US7020	90—230	0.10—0.50	0.30—2.50
		●	M	1	MM	MC7015	135—215	0.15—0.45	0.70—5.00
		●	M	2	GM	MC7015	135—215	0.16—0.50	0.50—4.00
		●	M	3	MS	US7020	80—210	0.16—0.50	0.50—4.00
		●	M	4	MA	US7020	80—210	0.20—0.50	0.30—4.00
		●	M	5	MH	US7020	80—210	0.20—0.55	1.00—4.00
		●	M	6	MW	US7020	80—210	0.20—0.60	0.90—4.00
		●	R	1	RM	MC7015	130—205	0.25—0.55	1.50—6.00
		●	R	2	GH	US7020	75—195	0.25—0.60	1.50—6.00
		●	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		●	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
		◐	L	1	LM	MC7025	135—180	0.10—0.30	0.30—2.00
		◐	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		◐	M	1	MM	MC7025	125—165	0.15—0.45	0.70—5.00
		◐	M	2	GM	MC7025	125—165	0.16—0.50	0.50—4.00
		◐	M	3	MA	MC7025	125—165	0.20—0.50	0.30—4.00
		◐	M	4	MS	US735	75—140	0.16—0.50	0.50—4.00
		◐	M	5	MA	US735	75—140	0.20—0.50	0.30—4.00
		◐	R	1	RM	MC7025	115—155	0.25—0.55	1.50—6.00
		◐	R	2	GH	US735	70—135	0.25—0.60	1.50—6.00
		◐	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		◐	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
		✠	L	1	LM	MP7035	80—130	0.10—0.30	0.30—2.00
		✠	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		✠	M	1	MM	MP7035	75—120	0.15—0.45	0.70—5.00
		✠	M	2	GM	MP7035	75—120	0.16—0.50	0.50—4.00
		✠	M	3	MA	MP7035	75—120	0.20—0.50	0.30—4.00
		✠	M	4	MS	US735	75—140	0.16—0.50	0.50—4.00
		✠	M	5	MS	VP15TF	65—110	0.16—0.50	0.50—4.00
		✠	M	6	MS	UP20M	80—125	0.16—0.50	0.50—4.00
		✠	M	7	MS	UTi20T	65—95	0.16—0.50	0.50—4.00
		✠	M	8	MA	VP15TF	65—110	0.20—0.50	0.30—4.00
		✠	M	9	Std	VP15TF	65—110	0.25—0.60	1.50—5.00
		✠	R	1	RM	MP7035	70—115	0.25—0.55	1.50—6.00
		✠	R	2	GH	US735	70—135	0.25—0.60	1.50—6.00
		✠	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		✠	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
Two-phase Stainless Steel (AISI 329)	≤280HB	●	L	1	LM	MC7015	120—190	0.10—0.30	0.30—2.00
		●	L	2	SH	US735	65—125	0.10—0.40	0.30—2.00
		●	L	3	SH	NX2525	40—90	0.10—0.40	0.30—2.00
		●	L	4	SW	US7020	70—185	0.10—0.50	0.30—2.50
		●	M	1	MM	MC7015	110—175	0.15—0.45	0.70—5.00
		●	M	2	GM	MC7015	110—175	0.16—0.50	0.50—4.00
		●	M	3	MS	US7020	65—170	0.16—0.50	0.50—4.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Two-phase Stainless Steel (AISI 329)	≤280HB	●	M	4	MA	US7020	65—170	0.20—0.50	0.30—4.00
		●	M	5	MH	US7020	65—170	0.20—0.55	1.00—4.00
		●	M	6	MW	US7020	65—170	0.20—0.60	0.90—4.00
		●	R	1	RM	MC7015	105—165	0.25—0.55	1.50—6.00
		●	R	2	GH	US7020	60—160	0.25—0.60	1.50—6.00
		●	H	1	HL	US735	50—95	0.40—1.00	1.50—8.00
		●	H	2	HM	US735	50—95	0.50—1.10	2.00—10.00
		◐	L	1	LM	MC7025	110—145	0.10—0.30	0.30—2.00
		◐	L	2	SH	US735	65—125	0.10—0.40	0.30—2.00
		◐	M	1	MM	MC7025	100—135	0.15—0.45	0.70—5.00
		◐	M	2	GM	MC7025	100—135	0.16—0.50	0.50—4.00
		◐	M	3	MA	MC7025	100—135	0.20—0.50	0.30—4.00
		◐	M	4	MS	US735	60—115	0.16—0.50	0.50—4.00
		◐	M	5	MA	US735	60—115	0.20—0.50	0.30—4.00
		◐	R	1	RM	MC7025	95—125	0.25—0.55	1.50—6.00
		◐	R	2	GH	US735	55—105	0.25—0.60	1.50—6.00
		◐	H	1	HL	US735	50—95	0.40—1.00	1.50—8.00
		◐	H	2	HM	US735	50—95	0.50—1.10	2.00—10.00
		✢	L	1	LM	MP7035	65—105	0.10—0.30	0.30—2.00
		✢	L	2	SH	US735	65—125	0.10—0.40	0.30—2.00
		✢	M	1	MM	MP7035	60—95	0.15—0.45	0.70—5.00
		✢	M	2	GM	MP7035	60—95	0.16—0.50	0.50—4.00
		✢	M	3	MA	MP7035	60—95	0.20—0.50	0.30—4.00
		✢	M	4	MS	US735	60—115	0.16—0.50	0.50—4.00
		✢	M	5	MS	VP15TF	50—90	0.16—0.50	0.50—4.00
		✢	M	6	MS	UP20M	65—100	0.16—0.50	0.50—4.00
		✢	M	7	MS	UTi20T	50—75	0.16—0.50	0.50—4.00
		✢	M	8	MA	VP15TF	50—90	0.20—0.50	0.30—4.00
		✢	M	9	Std	VP15TF	50—90	0.25—0.60	1.50—5.00
		✢	R	1	RM	MP7035	55—90	0.25—0.55	1.50—6.00
		✢	R	2	GH	US735	55—105	0.25—0.60	1.50—6.00
		✢	H	1	HL	US735	50—95	0.40—1.00	1.50—8.00
		✢	H	2	HM	US735	50—95	0.50—1.10	2.00—10.00
Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430)	≤200HB	●	L	1	LM	MC7015	180—285	0.10—0.30	0.30—2.00
		●	L	2	SH	US735	95—185	0.10—0.40	0.30—2.00
		●	L	3	SH	NX2525	65—135	0.10—0.40	0.30—2.00
		●	L	4	SW	US7020	110—275	0.10—0.50	0.30—2.50
		●	M	1	MM	MC7015	165—260	0.15—0.45	0.70—5.00
		●	M	2	GM	MC7015	165—260	0.16—0.50	0.50—4.00
		●	M	3	MS	US7020	100—250	0.16—0.50	0.50—4.00
		●	M	4	MA	US7020	100—250	0.20—0.50	0.30—4.00
		●	M	5	MH	US7020	100—250	0.20—0.55	1.00—4.00
		●	M	6	MW	US7020	100—250	0.20—0.60	0.90—4.00
		●	R	1	RM	MC7015	155—245	0.25—0.55	1.50—6.00
		●	R	2	GH	US7020	95—235	0.25—0.60	1.50—6.00
		●	H	1	HL	US735	75—140	0.40—1.00	1.50—8.00
		●	H	2	HM	US735	75—140	0.50—1.10	2.00—10.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430)	≤200HB	◐	**L**	1	**LM**	**MC7025**	165—220	0.10—0.30	0.30—2.00
		◐	**L**	2	**SH**	**US735**	95—185	0.10—0.40	0.30—2.00
		◐	**M**	1	**MM**	**MC7025**	150—200	0.15—0.45	0.70—5.00
		◐	**M**	2	**GM**	**MC7025**	150—200	0.16—0.50	0.50—4.00
		◐	**M**	3	**MA**	**MC7025**	150—200	0.20—0.50	0.30—4.00
		◐	**M**	4	**MA**	**US735**	90—170	0.20—0.50	0.30—4.00
		◐	**M**	5	**MS**	**US735**	90—170	0.16—0.50	0.50—4.00
		◐	**R**	1	**RM**	**MC7025**	140—190	0.25—0.55	1.50—6.00
		◐	**R**	2	**GH**	**US735**	85—160	0.25—0.60	1.50—6.00
		◐	**H**	1	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		◐	**H**	2	**HM**	**US735**	75—140	0.50—1.10	2.00—10.00
		✠	**L**	1	**LM**	**MP7035**	95—155	0.10—0.30	0.30—2.00
		✠	**L**	2	**SH**	**US735**	95—185	0.10—0.40	0.30—2.00
		✠	**M**	1	**MM**	**MP7035**	90—145	0.15—0.45	0.70—5.00
		✠	**M**	2	**GM**	**MP7035**	90—145	0.16—0.50	0.50—4.00
		✠	**M**	3	**MA**	**MP7035**	90—145	0.20—0.50	0.30—4.00
		✠	**M**	4	**MS**	**US735**	90—170	0.16—0.50	0.50—4.00
		✠	**M**	5	**MS**	**VP15TF**	80—135	0.16—0.50	0.50—4.00
		✠	**M**	6	**MS**	**UP20M**	100—150	0.16—0.50	0.50—4.00
		✠	**M**	7	**MS**	**UTi20T**	80—115	0.16—0.50	0.50—4.00
		✠	**M**	8	**MA**	**VP15TF**	80—135	0.20—0.50	0.30—4.00
		✠	**M**	9	**Std**	**VP15TF**	80—135	0.25—0.60	1.50—5.00
		✠	**R**	1	**RM**	**MP7035**	85—135	0.25—0.55	1.50—6.00
		✠	**R**	2	**GH**	**US735**	85—160	0.25—0.60	1.50—6.00
		✠	**H**	1	**HL**	**US735**	75—140	0.40—1.00	1.50—8.00
		✠	**H**	2	**HM**	**US735**	75—140	0.50—1.10	2.00—10.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Ferritic and Martensitic Stainless Steel (AISI 431, AISI 420)	>200HB	●	L	1	LM	MC7015	150—240	0.10—0.30	0.30—2.00
		●	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		●	L	3	SH	NX2525	55—115	0.10—0.40	0.30—2.00
		●	L	4	SW	US7020	90—230	0.10—0.50	0.30—2.50
		●	M	1	MM	MC7015	135—215	0.15—0.45	0.70—5.00
		●	M	2	GM	MC7015	135—215	0.16—0.50	0.50—4.00
		●	M	3	MS	US7020	80—210	0.16—0.50	0.50—4.00
		●	M	4	MA	US7020	80—210	0.20—0.50	0.30—4.00
		●	M	5	MH	US7020	80—210	0.20—0.55	1.00—4.00
		●	M	6	MW	US7020	80—210	0.20—0.60	0.90—4.00
		●	R	1	RM	MC7015	130—205	0.25—0.55	1.50—6.00
		●	R	2	GH	US7020	75—195	0.25—0.60	1.50—6.00
		●	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		●	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
		◐	L	1	LM	MC7025	135—180	0.10—0.30	0.30—2.00
		◐	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		◐	M	1	MM	MC7025	125—165	0.15—0.45	0.70—5.00
		◐	M	2	MA	MC7025	125—165	0.20—0.50	0.30—4.00
		◐	M	3	MA	US735	75—140	0.20—0.50	0.30—4.00
		◐	M	4	MS	US735	75—140	0.16—0.50	0.50—4.00
		◐	R	1	RM	MC7025	115—155	0.25—0.55	1.50—6.00
		◐	R	2	GH	US735	70—135	0.25—0.60	1.50—6.00
		◐	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		◐	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
		✢	L	1	LM	MP7035	80—130	0.10—0.30	0.30—2.00
		✢	L	2	SH	US735	80—155	0.10—0.40	0.30—2.00
		✢	M	1	MM	MP7035	75—120	0.15—0.45	0.70—5.00
		✢	M	2	GM	MP7035	75—120	0.16—0.50	0.50—4.00
		✢	M	3	MA	MP7035	75—120	0.20—0.50	0.30—4.00
		✢	M	4	MS	US735	75—140	0.16—0.50	0.50—4.00
		✢	M	5	MS	VP15TF	65—110	0.16—0.50	0.50—4.00
		✢	M	6	MS	UP20M	80—125	0.16—0.50	0.50—4.00
		✢	M	7	MS	UTi20T	65—95	0.16—0.50	0.50—4.00
		✢	M	8	MA	VP15TF	65—110	0.20—0.50	0.30—4.00
		✢	M	9	Std	VP15TF	65—110	0.25—0.60	1.50—5.00
		✢	R	1	RM	MP7035	70—115	0.25—0.55	1.50—6.00
		✢	R	2	GH	US735	70—135	0.25—0.60	1.50—6.00
		✢	H	1	HL	US735	60—120	0.40—1.00	1.50—8.00
		✢	H	2	HM	US735	60—120	0.50—1.10	2.00—10.00
Hardened Stainless Steel (AISI 630, AISI 631)	<450HB	●	L	1	LM	MC7015	100—160	0.10—0.30	0.30—2.00
		●	L	2	LS(M)	MP9005	125—175	0.10—0.25	0.20—0.80
		●	L	3	SH	US735	55—100	0.10—0.40	0.30—2.00
		●	L	4	SH	NX2525	35—75	0.10—0.40	0.30—2.00
		●	L	5	SW	US7020	60—150	0.10—0.50	0.30—2.50
		●	M	1	MM	MC7015	90—145	0.15—0.45	0.70—5.00
		●	M	2	GM	MC7015	90—145	0.16—0.50	0.50—4.00
		●	M	3	MS	US7020	55—140	0.16—0.50	0.50—4.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Hardened Stainless Steel (AISI 630, AISI 631)	<450HB	●	M	4	MA	US7020	55—140	0.20—0.50	0.30—4.00
		●	M	5	MS	MP9005	115—160	0.16—0.50	0.50—4.00
		●	M	6	MH	US7020	55—140	0.20—0.55	1.00—4.00
		●	M	7	MW	US7020	55—140	0.20—0.60	0.90—4.00
		●	R	1	RM	MC7015	85—135	0.25—0.55	1.50—6.00
		●	R	2	GH	US7020	50—130	0.25—0.60	1.50—6.00
		●	H	1	HL	US735	40—80	0.40—1.00	1.50—8.00
		●	H	2	HM	US735	40—80	0.50—1.10	2.00—10.00
		◐	L	1	LM	MC7025	90—120	0.10—0.30	0.30—2.00
		◐	L	2	SH	US735	55—100	0.10—0.40	0.30—2.00
		◐	L	3	LS(M)	MP9015	120—165	0.10—0.25	0.20—0.80
		◐	M	1	MM	MC7025	80—110	0.15—0.45	0.70—5.00
		◐	M	2	GM	MC7025	80—110	0.16—0.50	0.50—4.00
		◐	M	3	MA	MC7025	80—110	0.20—0.50	0.30—4.00
		◐	M	4	MS	US735	50—95	0.16—0.50	0.50—4.00
		◐	M	5	MA	US735	50—95	0.20—0.50	0.30—4.00
		◐	M	6	MS	MP9015	110—150	0.16—0.50	0.50—4.00
		◐	R	1	RM	MC7025	75—105	0.25—0.55	1.50—6.00
		◐	R	2	GH	US735	45—90	0.25—0.60	1.50—6.00
		◐	R	3	RS	MP9015	100—140	0.20—0.35	1.00—4.00
		◐	H	1	HL	US735	40—80	0.40—1.00	1.50—8.00
		◐	H	2	HM	US735	40—80	0.50—1.10	2.00—10.00
		✠	L	1	LM	MP7035	55—85	0.10—0.30	0.30—2.00
		✠	L	2	SH	US735	55—100	0.10—0.40	0.30—2.00
		✠	L	3	LS(M)	MP9025	80—95	0.10—0.25	0.20—0.80
		✠	M	1	MM	MP7035	50—80	0.15—0.45	0.70—5.00
		✠	M	2	GM	MP7035	50—80	0.16—0.50	0.50—4.00
		✠	M	3	MA	MP7035	50—80	0.20—0.50	0.30—4.00
		✠	M	4	MS	US735	50—95	0.16—0.50	0.50—4.00
		✠	M	5	MS	VP15TF	40—75	0.16—0.50	0.50—4.00
		✠	M	6	MS	UP20M	55—80	0.16—0.50	0.50—4.00
		✠	M	7	MS	UTi20T	40—60	0.16—0.50	0.50—4.00
		✠	M	8	MA	VP15TF	40—75	0.20—0.50	0.30—4.00
		✠	M	9	Std	VP15TF	40—75	0.25—0.60	1.50—5.00
		✠	M	1	MS	MP9025	75—90	0.16—0.50	0.50—4.00
		✠	R	1	RM	MP7035	45—75	0.25—0.55	1.50—6.00
		✠	R	2	GH	US735	45—90	0.25—0.60	1.50—6.00
		✠	R	3	RS	MP9025	70—85	0.20—0.35	1.00—4.00
		✠	H	1	HL	US735	40—80	0.40—1.00	1.50—8.00
		✠	H	2	HM	US735	40—80	0.50—1.10	2.00—10.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
K									
Gray Cast Iron (FC300)	≤350MPa	●	L	1	LK	MC5005	230—365	0.10—0.40	0.30—2.00
		●	L	2	MA	MC5005	210—335	0.20—0.50	0.30—4.00
		●	L	3	MA	UC5105	170—310	0.20—0.50	0.30—4.00
		●	M	1	MK	MC5005	210—335	0.20—0.55	1.00—4.00
		●	M	2	GK	MC5005	210—335	0.25—0.60	1.50—5.00
		●	M	3	Std	UC5105	170—310	0.25—0.60	1.50—5.00
		●	M	4	Std	NX2525	155—210	0.25—0.60	1.50—5.00
		●	M	5	MW	MC5005	210—335	0.20—0.60	0.90—4.00
		●	R	1	RK	MC5005	195—315	0.25—0.60	1.50—6.00
		●	R	2	Flat	MC5005	195—315	0.20—0.60	2.50—6.00
		●	R	3	GH	UC5105	160—290	0.25—0.60	1.50—6.00
		●	R	4	Flat	UC5105	160—290	0.20—0.60	2.50—6.00
		●	R	5	Flat	HTi10	95—140	0.20—0.60	2.50—6.00
		●	R	6	Flat	HTi05T	105—185	0.20—0.60	2.50—6.00
		●	H	1	Flat	MC5005	195—315	0.20—0.60	2.50—6.00
		●	H	2	Flat	UC5105	160—290	0.20—0.60	2.50—6.00
		◐	L	1	LK	MC5015	205—335	0.10—0.40	0.30—2.00
		◐	L	2	MA	MC5015	190—305	0.20—0.50	0.30—4.00
		◐	L	3	MA	UC5115	165—300	0.20—0.50	0.30—4.00
		◐	L	4	SW	MC5015	205—335	0.10—0.50	0.30—2.50
		◐	L	5	SW	UC5115	180—330	0.10—0.50	0.30—2.50
		◐	M	1	MK	MC5015	190—305	0.20—0.55	1.00—4.00
		◐	M	2	GK	MC5015	190—305	0.25—0.60	1.50—5.00
		◐	M	3	Std	UC5115	165—300	0.25—0.60	1.50—5.00
		◐	M	4	Std	HTi10	105—150	0.25—0.60	1.50—5.00
		◐	M	5	MH	UC5115	165—300	0.20—0.55	1.00—4.00
		◐	M	6	MP	UC5115	165—300	0.16—0.50	0.30—4.00
		◐	M	7	MW	MC5015	190—305	0.20—0.60	0.90—4.00
		◐	M	8	MW	UC5115	165—300	0.20—0.60	0.90—4.00
		◐	R	1	RK	MC5015	180—285	0.25—0.60	1.50—6.00
		◐	R	2	Flat	MC5015	180—285	0.20—0.60	2.50—6.00
		◐	R	3	GH	UC5115	155—285	0.25—0.60	1.50—6.00
		◐	R	4	Flat	UC5115	155—285	0.20—0.60	2.50—6.00
		◐	H	1	Flat	MC5015	180—285	0.20—0.60	2.50—6.00
		◐	H	2	Flat	UC5115	155—285	0.20—0.60	2.50—6.00
		✚	L	1	LK	MC5015	205—335	0.10—0.40	0.30—2.00
		✚	L	2	MA	MC5015	190—305	0.20—0.50	0.30—4.00
		✚	L	3	MA	UC5115	165—300	0.20—0.50	0.30—4.00
		✚	M	1	MK	MC5015	190—305	0.20—0.55	1.00—4.00
		✚	M	2	GK	MC5015	190—305	0.25—0.60	1.50—5.00
		✚	M	3	Std	UC5115	165—300	0.25—0.60	1.50—5.00
		✚	M	4	Std	UTi20T	85—120	0.25—0.60	1.50—5.00
		✚	R	1	RK	MC5015	180—285	0.25—0.60	1.50—6.00
		✚	R	2	Flat	MC5015	180—285	0.20—0.60	2.50—6.00
		✚	R	3	GH	UC5115	155—285	0.25—0.60	1.50—6.00
		✚	R	4	Flat	UC5115	155—285	0.20—0.60	2.50—6.00
		✚	R	5	Flat	UTi20T	80—110	0.20—0.60	2.50—6.00
		✚	H	1	Flat	MC5015	180—285	0.20—0.60	2.50—6.00
		✚	H	2	Flat	UC5115	155—285	0.20—0.60	2.50—6.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
K									
Ductile Cast Iron (FCD450)	≤450MPa	●	L	1	LK	MC5005	215—350	0.10—0.40	0.30—2.00
		●	L	2	MA	MC5005	195—315	0.20—0.50	0.30—4.00
		●	L	3	MA	UC5105	160—290	0.20—0.50	0.30—4.00
		●	M	1	MK	MC5005	195—315	0.20—0.55	1.00—4.00
		●	M	2	GK	MC5005	195—315	0.25—0.60	1.50—5.00
		●	M	3	Std	UC5105	160—290	0.25—0.60	1.50—5.00
		●	M	4	Std	NX2525	145—195	0.25—0.60	1.50—5.00
		●	R	1	RK	MC5005	185—300	0.25—0.60	1.50—6.00
		●	R	2	Flat	MC5005	185—300	0.20—0.60	2.50—6.00
		●	R	3	GH	UC5105	150—275	0.25—0.60	1.50—6.00
		●	R	4	Flat	UC5105	150—275	0.20—0.60	2.50—6.00
		●	R	5	Flat	HTi10	90—135	0.20—0.60	2.50—6.00
		●	R	6	Flat	HTi05T	100—175	0.20—0.60	2.50—6.00
		●	H	1	Flat	MC5005	185—300	0.20—0.60	2.50—6.00
		●	H	2	Flat	UC5105	150—275	0.20—0.60	2.50—6.00
		◐	L	1	LK	MC5015	195—315	0.10—0.40	0.30—2.00
		◐	L	2	MA	MC5015	180—285	0.20—0.50	0.30—4.00
		◐	L	3	MA	UC5115	155—285	0.20—0.50	0.30—4.00
		◐	L	4	SW	MC5015	195—315	0.10—0.50	0.30—2.50
		◐	L	5	SW	UC5115	170—310	0.10—0.50	0.30—2.50
		◐	M	1	MK	MC5015	180—285	0.20—0.55	1.00—4.00
		◐	M	2	GK	MC5015	180—285	0.25—0.60	1.50—5.00
		◐	M	3	Std	UC5115	155—285	0.25—0.60	1.50—5.00
		◐	M	4	Std	HTi10	95—140	0.25—0.60	1.50—5.00
		◐	M	5	MP	UC5115	155—285	0.16—0.50	0.30—4.00
		◐	R	1	RK	MC5015	170—275	0.25—0.60	1.50—6.00
		◐	R	2	Flat	MC5015	170—275	0.20—0.60	2.50—6.00
		◐	R	3	GH	UC5115	145—270	0.25—0.60	1.50—6.00
		◐	R	4	Flat	UC5115	145—270	0.20—0.60	2.50—6.00
		◐	H	1	Flat	MC5015	170—275	0.20—0.60	2.50—6.00
		◐	H	2	Flat	UC5115	145—270	0.20—0.60	2.50—6.00
		✠	L	1	LK	MC5015	195—315	0.10—0.40	0.30—2.00
		✠	L	2	MA	MC5015	180—285	0.20—0.50	0.30—4.00
		✠	L	3	MA	UC5115	155—285	0.20—0.50	0.30—4.00
		✠	M	1	MK	MC5015	180—285	0.20—0.55	1.00—4.00
		✠	M	2	GK	MC5015	180—285	0.25—0.60	1.50—5.00
		✠	M	3	Std	UC5115	155—285	0.25—0.60	1.50—5.00
		✠	M	4	Std	UTi20T	80—110	0.25—0.60	1.50—5.00
		✠	R	1	RK	MC5015	170—275	0.25—0.60	1.50—6.00
		✠	R	2	Flat	MC5015	170—275	0.20—0.60	2.50—6.00
		✠	R	3	GH	UC5115	145—270	0.25—0.60	1.50—6.00
		✠	R	4	Flat	UC5115	145—270	0.20—0.60	2.50—6.00
		✠	R	5	Flat	UTi20T	75—105	0.20—0.60	2.50—6.00
		✠	H	1	Flat	MC5015	170—275	0.20—0.60	2.50—6.00
		✠	H	2	Flat	UC5115	145—270	0.20—0.60	2.50—6.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
K									
Ductile Cast Iron (FCD700)	≤800MPa	●	**L**	1	**LK**	**MC5005**	195—310	0.10—0.40	0.30—2.00
		●	**L**	2	**MA**	**MC5005**	175—280	0.20—0.50	0.30—4.00
		●	**L**	3	**MA**	**UC5105**	140—260	0.20—0.50	0.30—4.00
		●	**M**	1	**MK**	**MC5005**	175—280	0.20—0.55	1.00—4.00
		●	**M**	2	**GK**	**MC5005**	175—280	0.25—0.60	1.50—5.00
		●	**M**	3	**Std**	**UC5105**	140—260	0.25—0.60	1.50—5.00
		●	**M**	4	**Std**	**NX2525**	130—175	0.25—0.60	1.50—5.00
		●	**R**	1	**RK**	**MC5005**	165—270	0.25—0.60	1.50—6.00
		●	**R**	2	**Flat**	**MC5005**	165—270	0.20—0.60	2.50—6.00
		●	**R**	3	**GH**	**UC5105**	135—250	0.25—0.60	1.50—6.00
		●	**R**	4	**Flat**	**UC5105**	135—250	0.20—0.60	2.50—6.00
		●	**R**	5	**Flat**	**HTi10**	80—120	0.20—0.60	2.50—6.00
		●	**R**	6	**Flat**	**HTi05T**	90—155	0.20—0.60	2.50—6.00
		●	**H**	1	**Flat**	**MC5005**	165—270	0.20—0.60	2.50—6.00
		●	**H**	2	**Flat**	**UC5105**	135—250	0.20—0.60	2.50—6.00
		◐	**L**	1	**LK**	**MC5015**	175—285	0.10—0.40	0.30—2.00
		◐	**L**	2	**MA**	**MC5015**	160—255	0.20—0.50	0.30—4.00
		◐	**L**	3	**MA**	**UC5115**	140—255	0.20—0.50	0.30—4.00
		◐	**L**	4	**SW**	**MC5015**	175—285	0.10—0.50	0.30—2.50
		◐	**L**	5	**SW**	**UC5115**	150—280	0.10—0.50	0.30—2.50
		◐	**M**	1	**MK**	**MC5015**	160—255	0.20—0.55	1.00—4.00
		◐	**M**	2	**GK**	**MC5015**	160—255	0.25—0.60	1.50—5.00
		◐	**M**	3	**Std**	**UC5115**	140—255	0.25—0.60	1.50—5.00
		◐	**M**	4	**Std**	**HTi10**	85—125	0.25—0.60	1.50—5.00
		◐	**M**	5	**MP**	**UC5115**	140—255	0.16—0.50	0.30—4.00
		◐	**R**	1	**RK**	**MC5015**	150—245	0.25—0.60	1.50—6.00
		◐	**R**	2	**Flat**	**MC5015**	150—245	0.20—0.60	2.50—6.00
		◐	**R**	3	**GH**	**UC5115**	130—240	0.25—0.60	1.50—6.00
		◐	**R**	4	**Flat**	**UC5115**	130—240	0.20—0.60	2.50—6.00
		◐	**H**	1	**Flat**	**MC5015**	150—245	0.20—0.60	2.50—6.00
		◐	**H**	2	**Flat**	**UC5115**	130—240	0.20—0.60	2.50—6.00
		✢	**L**	1	**LK**	**MC5015**	175—285	0.10—0.40	0.30—2.00
		✢	**L**	2	**MA**	**MC5015**	160—255	0.20—0.50	0.30—4.00
		✢	**L**	3	**MA**	**UC5115**	140—255	0.20—0.50	0.30—4.00
		✢	**M**	1	**MK**	**MC5015**	160—255	0.20—0.55	1.00—4.00
		✢	**M**	2	**GK**	**MC5015**	160—255	0.25—0.60	1.50—5.00
		✢	**M**	3	**Std**	**UC5115**	140—255	0.25—0.60	1.50—5.00
		✢	**M**	4	**Std**	**UTi20T**	70—100	0.25—0.60	1.50—5.00
		✢	**R**	1	**RK**	**MC5015**	150—245	0.25—0.60	1.50—6.00
		✢	**R**	2	**Flat**	**MC5015**	150—245	0.20—0.60	2.50—6.00
		✢	**R**	3	**GH**	**UC5115**	130—240	0.25—0.60	1.50—6.00
		✢	**R**	4	**Flat**	**UC5115**	130—240	0.20—0.60	2.50—6.00
		✢	**R**	5	**Flat**	**UTi20T**	65—95	0.20—0.60	2.50—6.00
		✢	**H**	1	**Flat**	**MC5015**	150—245	0.20—0.60	2.50—6.00
		✢	**H**	2	**Flat**	**UC5115**	130—240	0.20—0.60	2.50—6.00

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
S									
Titanium Alloy (Ti-6Al-4V)	–	●	**F**	1	**LS(M)**	**MT9015**	40—85	0.10—0.25	0.20—0.80
		●	**F**	2	**FJ**	**RT9010**	45—95	0.07—0.20	0.10—1.00
		●	**L**	1	**LS(M)**	**MT9015**	40—85	0.10—0.25	0.20—0.80
		●	**L**	2	**MJ(M)**	**RT9010**	40—85	0.07—0.25	0.40—1.50
		●	**M**	1	**MS**	**MT9015**	40—80	0.10—0.25	0.50—4.00
		●	**M**	2	**MS**	**RT9010**	40—80	0.10—0.25	0.50—4.00
		●	**R**	1	**RS**	**MT9015**	35—75	0.20—0.35	1.00—4.00
		●	**R**	2	**GJ**	**RT9010**	35—75	0.16—0.35	1.00—3.00
		◐	**F**	1	**LS(M)**	**MT9015**	40—85	0.10—0.25	0.20—0.80
		◐	**F**	2	**FJ**	**RT9010**	45—95	0.07—0.20	0.10—1.00
		◐	**L**	1	**LS(M)**	**MT9015**	40—85	0.10—0.25	0.20—0.80
		◐	**L**	2	**MJ(M)**	**RT9010**	40—85	0.07—0.25	0.40—1.50
		◐	**L**	3	**MJ(G)**	**RT9010**	40—85	0.07—0.25	0.40—1.50
		◐	**M**	1	**MS**	**MT9015**	40—80	0.10—0.25	0.50—4.00
		◐	**M**	2	**MS**	**RT9010**	40—80	0.10—0.25	0.50—4.00
		◐	**R**	1	**RS**	**MT9015**	35—75	0.20—0.35	1.00—4.00
		◐	**R**	2	**GJ**	**RT9010**	35—75	0.16—0.35	1.00—3.00
		✠	**F**	1	**FJ**	**RT9010**	45—95	0.07—0.20	0.10—1.00
		✠	**L**	1	**MJ(M)**	**RT9010**	40—85	0.07—0.25	0.40—1.50
		✠	**L**	2	**MJ(G)**	**RT9010**	40—85	0.07—0.25	0.40—1.50
		✠	**M**	1	**MS**	**RT9010**	40—80	0.10—0.25	0.50—4.00
		✠	**R**	1	**GJ**	**RT9010**	35—75	0.16—0.35	1.00—3.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
S									
Heat Resistant Alloy (Inconel718)	–	●	**F**	1	**LS(M)**	**MP9005**	30—110	0.10—0.25	0.20—0.80
		●	**F**	2	**FJ**	**VP10RT**	30—60	0.07—0.20	0.10—1.00
		●	**L**	1	**LS(M)**	**MP9005**	30—110	0.10—0.25	0.20—0.80
		●	**L**	2	**MJ(M)**	**MP9005**	30—110	0.07—0.25	0.40—1.50
		●	**L**	3	**MJ(M)**	**VP05RT**	30—65	0.07—0.25	0.40—1.50
		●	**L**	4	**MJ(M)**	**US905**	55—110	0.07—0.25	0.40—1.50
		●	**L**	5	**MJ(G)**	**VP10RT**	25—55	0.07—0.25	0.40—1.50
		●	**M**	1	**MS**	**MP9005**	30—100	0.10—0.25	0.50—4.00
		●	**M**	2	**MS**	**VP05RT**	30—60	0.10—0.25	0.50—4.00
		●	**M**	3	**MS**	**US905**	50—100	0.10—0.25	0.50—4.00
		●	**R**	1	**RS**	**MP9015**	20—75	0.20—0.35	1.00—4.00
		●	**R**	2	**GJ**	**VP10RT**	20—45	0.16—0.35	1.00—3.00
		●	**R**	3	**GJ**	**US905**	45—95	0.16—0.35	1.00—3.00
		◐	**F**	1	**LS(M)**	**MP9015**	25—85	0.10—0.25	0.20—0.80
		◐	**F**	2	**FJ**	**VP10RT**	30—60	0.07—0.20	0.10—1.00
		◐	**L**	1	**LS(M)**	**MP9015**	25—85	0.10—0.25	0.20—0.80
		◐	**L**	2	**MJ(M)**	**MP9015**	25—85	0.07—0.25	0.40—1.50
		◐	**L**	3	**MJ(M)**	**VP10RT**	25—55	0.07—0.25	0.40—1.50
		◐	**M**	1	**MS**	**MP9015**	25—80	0.10—0.25	0.50—4.00
		◐	**M**	2	**MA**	**MP9015**	25—80	0.10—0.30	0.50—3.00
		◐	**M**	3	**MS**	**VP10RT**	25—50	0.10—0.25	0.50—4.00
		◐	**R**	1	**RS**	**MP9015**	20—75	0.20—0.35	1.00—4.00
		◐	**R**	2	**GJ**	**VP10RT**	20—45	0.16—0.35	1.00—3.00
		✠	**F**	1	**FJ**	**VP15TF**	20—40	0.07—0.20	0.10—1.00
		✠	**L**	1	**LS(M)**	**MP9025**	20—30	0.10—0.25	0.20—0.80
		✠	**L**	2	**MJ(G)**	**VP15TF**	20—35	0.07—0.25	0.40—1.50
		✠	**M**	1	**MS**	**MP9025**	20—30	0.10—0.25	0.50—4.00
		✠	**M**	2	**MA**	**MP9025**	20—30	0.10—0.30	0.50—3.00
		✠	**M**	3	**MS**	**VP15TF**	20—35	0.10—0.25	0.50—4.00
		✠	**R**	1	**RS**	**MP9025**	15—25	0.20—0.35	1.00—4.00
		✠	**R**	2	**GJ**	**VP15TF**	15—30	0.16—0.35	1.00—3.00

RECOMMENDED CUTTING CONDITIONS

■ 7° POSITIVE INSERT TYPE

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Mild Steel (ASTM A36, AISI 1010)	≤180HB	●	F	1	FP	NX2525	225—320	0.04—0.20	0.20—0.90
		●	F	2	FV	NX2525	225—320	0.04—0.20	0.20—0.90
		●	F	3	R/L-F	MP3025	230—355	0.05—0.12	0.10—0.50
		●	L	1	LP	NX2525	225—320	0.06—0.25	0.20—1.00
		●	L	2	Std	UE6110	210—355	0.08—0.30	0.30—2.00
		●	L	3	MV	MP3025	190—295	0.08—0.30	0.30—2.00
		●	L	4	Std	MP3025	190—295	0.08—0.30	0.30—2.00
		●	M	1	MP	NX2525	185—270	0.08—0.30	0.30—2.00
		◐	F	1	FP	MC6015	250—425	0.04—0.20	0.20—0.90
		◐	F	2	FP	UE6110	250—425	0.04—0.20	0.20—0.90
		◐	F	3	FP	MP3025	230—355	0.04—0.20	0.20—0.90
		◐	F	4	FV	MP3025	230—355	0.04—0.20	0.20—0.90
		◐	F	5	FV	NX3035	220—310	0.04—0.20	0.20—0.90
		◐	L	1	LP	MC6015	250—425	0.06—0.25	0.20—1.00
		◐	L	2	LP	UE6110	250—425	0.06—0.25	0.20—1.00
		◐	L	3	LP	MP3025	230—355	0.06—0.25	0.20—1.00
		◐	L	4	Std	UE6110	210—355	0.08—0.30	0.30—2.00
		◐	L	5	SW	MC6015	250—425	0.06—0.24	0.20—1.50
		◐	L	6	SW	MP3025	230—355	0.06—0.24	0.20—1.50
		◐	M	1	MP	MC6015	210—355	0.08—0.30	0.30—2.00
		◐	M	2	MP	UE6110	210—355	0.08—0.30	0.30—2.00
		◐	M	3	MP	MP3025	190—295	0.08—0.30	0.30—2.00
		◐	M	4	MW	MC6015	210—355	0.10—0.35	0.80—2.50
		✠	F	1	FP	MC6025	250—405	0.04—0.20	0.20—0.90
		✠	F	2	FV	UE6020	235—385	0.04—0.20	0.20—0.90
		✠	L	1	LP	MC6025	250—405	0.06—0.25	0.20—1.00
		✠	L	2	SV	MC6025	250—405	0.06—0.25	0.20—1.00
		✠	L	3	Std	UE6020	195—320	0.08—0.30	0.30—2.00
		✠	L	4	SW	MC6025	250—405	0.06—0.24	0.20—1.50
		✠	M	1	MP	MC6025	210—340	0.08—0.30	0.30—2.00
		✠	M	2	MW	MC6025	210—340	0.10—0.35	0.80—2.50
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 | 280HB	●	F	1	FP	NX2525	165—240	0.04—0.20	0.20—0.90
		●	F	2	FV	NX2525	165—240	0.04—0.20	0.20—0.90
		●	F	3	R/L-F	MP3025	170—260	0.05—0.12	0.10—0.50
		●	L	1	LP	NX2525	165—240	0.06—0.25	0.20—1.00
		●	L	2	Std	UE6110	155—260	0.08—0.30	0.30—2.00
		●	L	3	MV	MP3025	140—220	0.08—0.30	0.30—2.00
		●	L	4	Std	MP3025	140—220	0.08—0.30	0.30—2.00
		●	L	5	SV	MP3025	170—260	0.06—0.25	0.20—1.00
		●	L	6	SW	MP3025	170—260	0.06—0.24	0.20—1.50
		●	M	1	MP	NX2525	140—200	0.08—0.30	0.30—2.00
		●	M	2	MW	MP3025	140—220	0.10—0.35	0.80—2.50
		◐	F	1	FP	MC6015	185—315	0.04—0.20	0.20—0.90
		◐	F	2	FP	UE6110	185—315	0.04—0.20	0.20—0.90
		◐	F	3	FP	MP3025	170—260	0.04—0.20	0.20—0.90
		◐	F	4	FV	MP3025	170—260	0.04—0.20	0.20—0.90
		◐	F	5	FV	NX3035	160—230	0.04—0.20	0.20—0.90

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 | 280HB		**L**	1	**LP**	**MC6015**	185—315	0.06—0.25	0.20—1.00
			L	2	**LP**	**UE6110**	185—315	0.06—0.25	0.20—1.00
			L	3	**LP**	**MP3025**	170—260	0.06—0.25	0.20—1.00
			L	4	**Std**	**UE6110**	155—260	0.08—0.30	0.30—2.00
			L	5	**SW**	**MC6015**	185—315	0.06—0.24	0.20—1.50
			L	6	**SW**	**MP3025**	170—260	0.06—0.24	0.20—1.50
			M	1	**MP**	**MC6015**	155—260	0.08—0.30	0.30—2.00
			M	2	**MP**	**UE6110**	155—260	0.08—0.30	0.30—2.00
			M	3	**MP**	**MP3025**	140—220	0.08—0.30	0.30—2.00
			M	4	**MW**	**MC6015**	155—260	0.10—0.35	0.80—2.50
			F	1	**FP**	**MC6025**	185—300	0.04—0.20	0.20—0.90
			F	2	**FV**	**UE6020**	175—285	0.04—0.20	0.20—0.90
			L	1	**LP**	**MC6025**	185—300	0.06—0.25	0.20—1.00
			L	2	**SV**	**MC6025**	185—300	0.06—0.25	0.20—1.00
			L	3	**Std**	**UE6020**	145—240	0.08—0.30	0.30—2.00
			L	4	**SW**	**MC6025**	185—300	0.06—0.24	0.20—1.50
			M	1	**MP**	**MC6025**	155—250	0.08—0.30	0.30—2.00
			M	2	**MW**	**MC6025**	155—250	0.10—0.35	0.80—2.50
Carbon Steel • Alloy Steel (AISI 4340)	280 | 350HB		**M**	1	**MP**	**NX2525**	95—140	0.08—0.30	0.30—2.00
			M	1	**MP**	**MC6015**	110—185	0.08—0.30	0.30—2.00
			M	2	**MP**	**UE6110**	110—185	0.08—0.30	0.30—2.00
			M	3	**MP**	**MP3025**	100—155	0.08—0.30	0.30—2.00
			M	1	**MP**	**MC6025**	110—175	0.08—0.30	0.30—2.00

RECOMMENDED CUTTING CONDITIONS

■ 7° POSITIVE INSERT TYPE

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Austenitic Stainless Steel (AISI 304, AISI 316)	≤200HB	●	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	140—190	0.06—0.25	0.20—1.00
		●	L	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	120—160	0.08—0.30	0.30—2.00
		◐	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		◐	L	1	LM	MC7025	140—190	0.06—0.25	0.20—1.00
		◐	L	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		◐	M	1	MM	MC7025	120—160	0.08—0.30	0.30—2.00
		✠	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		✠	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		✠	L	1	LM	MP7035	85—135	0.06—0.25	0.20—1.00
		✠	L	2	LM	VP15TF	75—125	0.06—0.25	0.20—1.00
		✠	L	3	Std	US735	70—135	0.08—0.30	0.30—2.00
		✠	M	1	MM	MP7035	70—115	0.08—0.30	0.30—2.00
		✠	M	2	MM	VP15TF	60—105	0.08—0.30	0.30—2.00
Austenitic Stainless Steel (AISI 304LN, AISI 316LN)	>200HB	●	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	120—160	0.06—0.25	0.20—1.00
		●	L	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	100—130	0.08—0.30	0.30—2.00
		◐	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		◐	L	1	LM	MC7025	120—160	0.06—0.25	0.20—1.00
		◐	L	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		◐	M	1	MM	MC7025	100—130	0.08—0.30	0.30—2.00
		✠	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		✠	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		✠	L	1	LM	MP7035	70—115	0.06—0.25	0.20—1.00
		✠	L	2	LM	VP15TF	60—105	0.06—0.25	0.20—1.00
		✠	L	3	Std	US735	60—110	0.08—0.30	0.30—2.00
		✠	M	1	MM	MP7035	60—95	0.08—0.30	0.30—2.00
		✠	M	2	MM	VP15TF	50—90	0.08—0.30	0.30—2.00
Two-phase Stainless Steel (AISI 329)	≤280HB	●	F	1	FM	VP15TF	50—85	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	45—90	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	95—130	0.06—0.25	0.20—1.00
		●	L	2	Std	US735	45—90	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	80—105	0.08—0.30	0.30—2.00
		◐	F	1	FM	VP15TF	50—85	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	45—90	0.08—0.30	0.30—2.00
		◐	L	1	LM	MC7025	95—130	0.06—0.25	0.20—1.00
		◐	L	2	Std	US735	45—90	0.08—0.30	0.30—2.00
		◐	M	1	MM	MC7025	80—105	0.08—0.30	0.30—2.00
		✠	F	1	FM	VP15TF	50—85	0.04—0.20	0.20—0.90
		✠	F	2	Std	US735	45—90	0.08—0.30	0.30—2.00
		✠	L	1	LM	MP7035	55—90	0.06—0.25	0.20—1.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Two-phase Stainless Steel (AISI 329)	≤280HB	✠	L	2	LM	VP15TF	50—85	0.06—0.25	0.20—1.00
		✠	L	3	Std	US735	45—90	0.08—0.30	0.30—2.00
		✠	M	1	MM	MP7035	45—75	0.08—0.30	0.30—2.00
		✠	M	2	MM	VP15TF	40—70	0.08—0.30	0.30—2.00
Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430)	≤200HB	●	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	140—190	0.06—0.25	0.20—1.00
		●	L	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	120—160	0.08—0.30	0.30—2.00
		◐	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		◐	L	1	LM	MC7025	140—190	0.06—0.25	0.20—1.00
		◐	L	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		◐	M	1	MM	MC7025	120—160	0.08—0.30	0.30—2.00
		✠	F	1	FM	VP15TF	75—125	0.04—0.20	0.20—0.90
		✠	F	2	Std	US735	70—135	0.08—0.30	0.30—2.00
		✠	L	1	LM	MP7035	85—135	0.06—0.25	0.20—1.00
		✠	L	2	LM	VP15TF	75—125	0.06—0.25	0.20—1.00
		✠	L	3	Std	US735	70—135	0.08—0.30	0.30—2.00
		✠	M	1	MM	MP7035	70—115	0.08—0.30	0.30—2.00
		✠	M	2	MM	VP15TF	60—105	0.08—0.30	0.30—2.00
Ferritic and Martensitic Stainless Steel (AISI 431, AISI 420)	>200HB	●	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	120—160	0.06—0.25	0.20—1.00
		●	L	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	100—130	0.08—0.30	0.30—2.00
		◐	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		◐	L	1	LM	MC7025	120—160	0.06—0.25	0.20—1.00
		◐	L	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		◐	M	1	MM	MC7025	100—130	0.08—0.30	0.30—2.00
		✠	F	1	FM	VP15TF	60—105	0.04—0.20	0.20—0.90
		✠	F	2	Std	US735	60—110	0.08—0.30	0.30—2.00
		✠	L	1	LM	MP7035	70—115	0.06—0.25	0.20—1.00
		✠	L	2	LM	VP15TF	60—105	0.06—0.25	0.20—1.00
		✠	L	3	Std	US735	60—110	0.08—0.30	0.30—2.00
		✠	M	1	MM	MP7035	60—95	0.08—0.30	0.30—2.00
		✠	M	2	MM	VP15TF	50—90	0.08—0.30	0.30—2.00
Hardened Stainless Steel (AISI 630, AISI 631)	<450HB	●	F	1	FM	VP15TF	40—70	0.04—0.20	0.20—0.90
		●	F	2	Std	US735	40—75	0.08—0.30	0.30—2.00
		●	L	1	LM	MC7025	80—105	0.06—0.25	0.20—1.00
		●	L	2	LS(M)	MP9015	105—140	0.06—0.20	0.20—1.00
		●	L	3	Std	US735	40—75	0.08—0.30	0.30—2.00
		●	M	1	MM	MC7025	65—85	0.08—0.30	0.30—2.00
		●	M	2	MS	MP9015	85—120	0.08—0.25	0.30—2.00
		◐	F	1	FM	VP15TF	40—70	0.04—0.20	0.20—0.90
		◐	F	2	Std	US735	40—75	0.08—0.30	0.30—2.00

RECOMMENDED CUTTING CONDITIONS

■ 7° POSITIVE INSERT TYPE

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
M									
Hardened Stainless Steel (AISI 630, AISI 631)	<450HB	◐	**L**	1	**LM**	**MC7025**	80—105	0.06—0.25	0.20—1.00
		◐	**L**	2	**LS(M)**	**MP9015**	105—140	0.06—0.20	0.20—1.00
		◐	**L**	3	**Std**	**US735**	40—75	0.08—0.30	0.30—2.00
		◐	**M**	1	**MM**	**MC7025**	65—85	0.08—0.30	0.30—2.00
		◐	**M**	2	**MS**	**MP9015**	85—120	0.08—0.25	0.30—2.00
		✣	**F**	1	**FM**	**VP15TF**	40—70	0.04—0.20	0.20—0.90
		✣	**F**	2	**Std**	**US735**	40—75	0.08—0.30	0.30—2.00
		✣	**L**	1	**LM**	**MP7035**	45—75	0.06—0.25	0.20—1.00
		✣	**L**	2	**LM**	**VP15TF**	40—70	0.06—0.25	0.20—1.00
		✣	**L**	3	**Std**	**US735**	40—75	0.08—0.30	0.30—2.00
		✣	**M**	1	**MM**	**MP7035**	40—60	0.08—0.30	0.30—2.00
		✣	**M**	2	**MM**	**VP15TF**	35—60	0.08—0.30	0.30—2.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
K									
Gray Cast Iron (FC300)	≤350MPa	●	**F**	1	**MK**	**MC5005**	165—265	0.08—0.30	0.30—2.00
		●	**L**	1	**MK**	**MC5005**	165—265	0.08—0.30	0.30—2.00
		●	**M**	1	**Flat**	**MC5005**	165—265	0.08—0.30	0.30—2.00
		◐	**F**	1	**MK**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		◐	**F**	2	**Std**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		◐	**L**	1	**MK**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		◐	**L**	2	**Std**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		◐	**M**	1	**Flat**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		◐	**M**	2	**Flat**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		✚	**F**	1	**MK**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		✚	**F**	2	**Std**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		✚	**L**	1	**MK**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		✚	**L**	2	**Std**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		✚	**M**	1	**Flat**	**MC5015**	150—240	0.08—0.30	0.30—2.00
		✚	**M**	2	**Flat**	**UC5115**	130—240	0.08—0.30	0.30—2.00
Ductile Cast Iron (FCD450)	≤450MPa	●	**F**	1	**MK**	**MC5005**	155—250	0.08—0.30	0.30—2.00
		●	**L**	1	**MK**	**MC5005**	155—250	0.08—0.30	0.30—2.00
		●	**M**	1	**Flat**	**MC5005**	155—250	0.08—0.30	0.30—2.00
		◐	**F**	1	**MK**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		◐	**F**	2	**Std**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		◐	**L**	1	**MK**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		◐	**L**	2	**Std**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		◐	**M**	1	**Flat**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		◐	**M**	2	**Flat**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		✚	**F**	1	**MK**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		✚	**F**	2	**Std**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		✚	**L**	1	**MK**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		✚	**L**	2	**Std**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		✚	**M**	1	**Flat**	**MC5015**	140—230	0.08—0.30	0.30—2.00
		✚	**M**	2	**Flat**	**UC5115**	125—225	0.08—0.30	0.30—2.00
Ductile Cast Iron (FCD700)	≤800MPa	●	**F**	1	**MK**	**MC5005**	140—225	0.08—0.30	0.30—2.00
		●	**L**	1	**MK**	**MC5005**	140—225	0.08—0.30	0.30—2.00
		●	**M**	1	**Flat**	**MC5005**	140—225	0.08—0.30	0.30—2.00
		◐	**F**	1	**MK**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		◐	**F**	2	**Std**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		◐	**L**	1	**MK**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		◐	**L**	2	**Std**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		◐	**M**	1	**Flat**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		◐	**M**	2	**Flat**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		✚	**F**	1	**MK**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		✚	**F**	2	**Std**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		✚	**L**	1	**MK**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		✚	**L**	2	**Std**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		✚	**M**	1	**Flat**	**MC5015**	125—205	0.08—0.30	0.30—2.00
		✚	**M**	2	**Flat**	**UC5115**	110—200	0.08—0.30	0.30—2.00

RECOMMENDED CUTTING CONDITIONS

■ 7° POSITIVE INSERT TYPE

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
N									
Aluminium Alloy (A6061, A7075)	Si<5%	●	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		◐	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		✠	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
Aluminium Alloy (AC4B)	5%≦Si≦10%	●	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		◐	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		✠	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
Aluminium Alloy (ADC12, A390)	Si>10%	●	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		◐	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00
		✠	**F**	1	**AZ**	**HTi10**	300—700	0.10—0.40	0.20—3.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
S									
Titanium Alloy (Ti-6Al-4V)	–	●	**F**	1	**FS-P**	**MT9005**	40—80	0.04—0.12	0.20—1.40
		●	**F**	2	**FJ**	**RT9010**	35—75	0.04—0.12	0.20—1.40
		●	**L**	1	**LS-P**	**MT9005**	40—80	0.04—0.15	0.30—3.00
		●	**L**	2	**LS(M)**	**MT9005**	40—80	0.06—0.20	0.20—1.00
		●	**M**	1	**MS**	**MT9005**	35—65	0.08—0.25	0.30—2.00
		◐	**F**	1	**FS-P**	**MT9005**	40—80	0.04—0.12	0.20—1.40
		◐	**F**	2	**FJ**	**RT9010**	35—75	0.04—0.12	0.20—1.40
		◐	**L**	1	**LS-P**	**MT9005**	40—80	0.04—0.15	0.30—3.00
		◐	**L**	2	**LS(M)**	**MT9005**	40—80	0.06—0.20	0.20—1.00
		◐	**M**	1	**MS**	**MT9005**	35—65	0.08—0.25	0.30—2.00
		✠	**F**	1	**FS-P**	**MT9005**	40—80	0.04—0.12	0.20—1.40
		✠	**F**	2	**FJ**	**RT9010**	35—75	0.04—0.12	0.20—1.40
		✠	**L**	1	**LS-P**	**MT9005**	40—80	0.04—0.15	0.30—3.00
		✠	**L**	2	**LS(M)**	**MT9005**	40—80	0.06—0.20	0.20—1.00
		✠	**M**	1	**MS**	**MT9005**	35—65	0.08—0.25	0.30—2.00
S									
Heat Resistant Alloy (Inconel718)	–	●	**F**	1	**FS**	**MP9005**	25—95	0.04—0.12	0.20—1.40
		●	**F**	2	**FJ**	**VP10RT**	20—45	0.04—0.12	0.20—1.40
		●	**L**	1	**LS(G)**	**MP9005**	25—95	0.04—0.15	0.30—3.00
		●	**L**	2	**LS(M)**	**MP9005**	25—95	0.06—0.20	0.20—1.00
		●	**M**	1	**MS**	**MP9005**	20—80	0.08—0.25	0.30—2.00
		◐	**F**	1	**FS**	**MP9015**	20—75	0.04—0.12	0.20—1.40
		◐	**F**	2	**FJ**	**VP10RT**	20—45	0.04—0.12	0.20—1.40
		◐	**L**	1	**LS(G)**	**MP9015**	20—75	0.04—0.15	0.30—3.00
		◐	**L**	2	**LS(M)**	**MP9015**	20—75	0.06—0.20	0.20—1.00
		◐	**M**	1	**MS**	**MP9015**	20—60	0.08—0.25	0.30—2.00
		✠	**F**	1	**FS**	**MP9015**	20—75	0.04—0.12	0.20—1.40
		✠	**F**	2	**FJ**	**VP10RT**	20—45	0.04—0.12	0.20—1.40
		✠	**L**	1	**LS(G)**	**MP9015**	20—75	0.04—0.15	0.30—3.00
		✠	**L**	2	**LS(M)**	**MP9015**	20—75	0.06—0.20	0.20—1.00
		✠	**M**	1	**MS**	**MP9015**	20—60	0.08—0.25	0.30—2.00

RECOMMENDED CUTTING CONDITIONS

■ 11° POSITIVE INSERT TYPE

Breker : **Std** : Standard **Flat** : Flat Top

Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P									
Mild Steel (ASTM A36, AISI 1010)	≤180HB	●	**F**	1	**R-R/L**	**NX2525**	225—320	0.05—0.12	0.20—0.60
		●	**L**	1	**R-Std**	**NX2525**	185—270	0.08—0.30	0.30—2.00
		●	**M**	1	**R-Std**	**NX2525**	185—270	0.08—0.30	0.30—2.00
		◐	**F**	1	**R-R/L**	**NX2525**	225—320	0.05—0.12	0.20—0.60
		◐	**L**	1	**R-Std**	**UE6110**	210—355	0.08—0.30	0.30—2.00
		◐	**L**	2	**R-Std**	**MP3025**	190—295	0.08—0.30	0.30—2.00
		◐	**L**	3	**R-Std**	**NX3035**	180—255	0.08—0.30	0.30—2.00
		◐	**M**	1	**R-Std**	**UE6110**	210—355	0.08—0.30	0.30—2.00
		◐	**M**	2	**R-Std**	**MP3025**	190—295	0.08—0.30	0.30—2.00
		◐	**M**	3	**R-Std**	**NX3035**	180—255	0.08—0.30	0.30—2.00
		✠	**F**	1	**R-R/L**	**UTi20T**	115—165	0.05—0.12	0.20—0.60
		✠	**L**	1	**R-Std**	**UE6020**	195—320	0.08—0.30	0.30—2.00
		✠	**L**	2	**N-Flat**	**UE6020**	195—320	0.08—0.30	0.30—2.00
		✠	**L**	3	**N-Flat**	**UP20M**	105—160	0.08—0.30	0.30—2.00
		✠	**M**	1	**R-Std**	**UE6020**	195—320	0.08—0.30	0.30—2.00
		✠	**M**	2	**N-Flat**	**UE6020**	195—320	0.08—0.30	0.30—2.00
		✠	**M**	3	**N-Flat**	**UP20M**	105—160	0.08—0.30	0.30—2.00
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140)	180 | 280HB	●	**F**	1	**R-R/L**	**NX2525**	165—240	0.05—0.12	0.20—0.60
		●	**L**	1	**R-Std**	**NX2525**	140—200	0.08—0.30	0.30—2.00
		●	**M**	1	**R-Std**	**NX2525**	140—200	0.08—0.30	0.30—2.00
		◐	**F**	1	**R-R/L**	**NX2525**	165—240	0.05—0.12	0.20—0.60
		◐	**L**	1	**R-Std**	**UE6110**	155—260	0.08—0.30	0.30—2.00
		◐	**L**	2	**R-Std**	**MP3025**	140—220	0.08—0.30	0.30—2.00
		◐	**L**	3	**R-Std**	**NX3035**	135—190	0.08—0.30	0.30—2.00
		◐	**M**	1	**R-Std**	**UE6110**	155—260	0.08—0.30	0.30—2.00
		◐	**M**	2	**R-Std**	**MP3025**	140—220	0.08—0.30	0.30—2.00
		◐	**M**	3	**R-Std**	**NX3035**	135—190	0.08—0.30	0.30—2.00
		✠	**F**	1	**R-R/L**	**UTi20T**	85—120	0.05—0.12	0.20—0.60
		✠	**L**	1	**R-Std**	**UE6020**	145—240	0.08—0.30	0.30—2.00
		✠	**L**	2	**N-Flat**	**UE6020**	145—240	0.08—0.30	0.30—2.00
		✠	**L**	3	**N-Flat**	**UP20M**	80—120	0.08—0.30	0.30—2.00
		✠	**M**	1	**R-Std**	**UE6020**	145—240	0.08—0.30	0.30—2.00
		✠	**M**	2	**N-Flat**	**UE6020**	145—240	0.08—0.30	0.30—2.00
		✠	**M**	3	**N-Flat**	**UP20M**	80—120	0.08—0.30	0.30—2.00

CUTTING CONDITIONS : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
CUTTING AREA : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

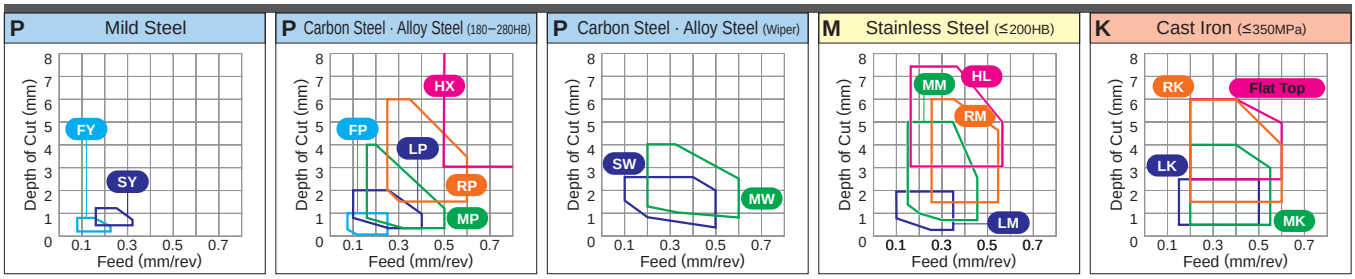
Work Material	Hardness	Cutting Mode		Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
K									
Gray Cast Iron (FC300)	≤350MPa	●	**F**	1	**R-R/L**	**NX2525**	145—200	0.05—0.12	0.20—0.60
		●	**L**	1	**N-Flat**	**UC5105**	135—245	0.08—0.30	0.30—2.00
		●	**L**	2	**N-Flat**	**NX2525**	120—165	0.08—0.30	0.30—2.00
		●	**L**	3	**R-Std**	**NX2525**	120—165	0.08—0.30	0.30—2.00
		●	**M**	1	**N-Flat**	**UC5105**	135—245	0.08—0.30	0.30—2.00
		●	**M**	2	**N-Flat**	**NX2525**	120—165	0.08—0.30	0.30—2.00
		●	**M**	3	**R-Std**	**NX2525**	120—165	0.08—0.30	0.30—2.00
		◐	**F**	1	**R-R/L**	**NX2525**	145—200	0.05—0.12	0.20—0.60
		◐	**F**	2	**R-R/L**	**HTi10**	100—140	0.05—0.12	0.20—0.60
		◐	**L**	1	**N-Flat**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		◐	**L**	2	**N-Flat**	**UE6110**	125—200	0.08—0.30	0.30—2.00
		◐	**M**	1	**N-Flat**	**UC5115**	130—240	0.08—0.30	0.30—2.00
		◐	**M**	2	**N-Flat**	**UE6110**	125—200	0.08—0.30	0.30—2.00
		✚	**F**	1	**R-R/L**	**UTi20T**	80—115	0.05—0.12	0.20—0.60
		✚	**L**	1	**N-Flat**	**VP15TF**	115—160	0.08—0.30	0.30—2.00
		✚	**M**	1	**N-Flat**	**VP15TF**	115—160	0.08—0.30	0.30—2.00
Ductile Cast Iron (FCD450)	≤450MPa	●	**F**	1	**R-R/L**	**NX2525**	140—190	0.05—0.12	0.20—0.60
		●	**L**	1	**N-Flat**	**UC5105**	125—235	0.08—0.30	0.30—2.00
		●	**L**	2	**N-Flat**	**NX2525**	115—155	0.08—0.30	0.30—2.00
		●	**L**	3	**R-Std**	**NX2525**	115—155	0.08—0.30	0.30—2.00
		●	**M**	1	**N-Flat**	**UC5105**	125—235	0.08—0.30	0.30—2.00
		●	**M**	2	**N-Flat**	**NX2525**	115—155	0.08—0.30	0.30—2.00
		●	**M**	3	**R-Std**	**NX2525**	115—155	0.08—0.30	0.30—2.00
		◐	**F**	1	**R-R/L**	**NX2525**	140—190	0.05—0.12	0.20—0.60
		◐	**F**	2	**R-R/L**	**HTi10**	95—135	0.05—0.12	0.20—0.60
		◐	**L**	1	**N-Flat**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		◐	**L**	2	**N-Flat**	**UE6110**	120—190	0.08—0.30	0.30—2.00
		◐	**M**	1	**N-Flat**	**UC5115**	125—225	0.08—0.30	0.30—2.00
		◐	**M**	2	**N-Flat**	**UE6110**	120—190	0.08—0.30	0.30—2.00
		✚	**F**	1	**R-R/L**	**UTi20T**	75—105	0.05—0.12	0.20—0.60
		✚	**L**	1	**N-Flat**	**VP15TF**	110—150	0.08—0.30	0.30—2.00
		✚	**M**	1	**N-Flat**	**VP15TF**	110—150	0.08—0.30	0.30—2.00
Ductile Cast Iron (FCD700)	≤800MPa	●	**F**	1	**R-R/L**	**NX2525**	125—170	0.05—0.12	0.20—0.60
		●	**L**	1	**N-Flat**	**UC5105**	115—210	0.08—0.30	0.30—2.00
		●	**L**	2	**N-Flat**	**NX2525**	105—140	0.08—0.30	0.30—2.00
		●	**L**	3	**R-Std**	**NX2525**	105—140	0.08—0.30	0.30—2.00
		●	**M**	1	**N-Flat**	**UC5105**	115—210	0.08—0.30	0.30—2.00
		●	**M**	2	**N-Flat**	**NX2525**	105—140	0.08—0.30	0.30—2.00
		●	**M**	3	**R-Std**	**NX2525**	105—140	0.08—0.30	0.30—2.00
		◐	**F**	1	**R-R/L**	**NX2525**	125—170	0.05—0.12	0.20—0.60
		◐	**F**	2	**R-R/L**	**HTi10**	85—120	0.05—0.12	0.20—0.60
		◐	**L**	1	**N-Flat**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		◐	**L**	2	**N-Flat**	**UE6110**	105—170	0.08—0.30	0.30—2.00
		◐	**M**	1	**N-Flat**	**UC5115**	110—200	0.08—0.30	0.30—2.00
		◐	**M**	2	**N-Flat**	**UE6110**	105—170	0.08—0.30	0.30—2.00
		✚	**F**	1	**R-R/L**	**UTi20T**	65—95	0.05—0.12	0.20—0.60
		✚	**L**	1	**N-Flat**	**VP15TF**	95—135	0.08—0.30	0.30—2.00
		✚	**M**	1	**N-Flat**	**VP15TF**	95—135	0.08—0.30	0.30—2.00

80° CN TYPE INSERTS WITH HOLE

CNMG 12 04 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
			Coated																										Cermet		Coated Cermet			Carbide				
	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣				
	M	Stainless Steel									◐	◐	✣	◐	✣											◐	✣	✣	◐			◐	◐	✣				
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
FP Finish Cutting	CNMG120402-FP	0.2				●	●																						●		●								C008 C009 E013 E036 E041 H006 –008
	CNMG120404-FP	0.4				●	●																						●		●								
	CNMG120408-FP	0.8				●	●																						●		●								
	NEW CNMG120412-FP	1.2				●	●																						●		●								
FH Finish Cutting	CNMG120402-FH	0.2		●	▲																								●	●	●								C008 C009 E013 E036 E041 H006 –008
	CNMG120404-FH	0.4		●	▲																								●		●	●							
	CNMG120408-FH	0.8		●																									●		●	●							
	CNMG120412-FH	1.2																											●			●							
FS Finish Cutting	CNMG120404-FS	0.4			▲																								●										C008 C009 E013 E036 E041 H006 –008
	CNMG120408-FS	0.8																											●										
FY Finish Cutting	CNMG120404-FY	0.4			▲																								●	●	●		●						C008 C009 E013 E036 E041 H006 –008
	CNMG120408-FY	0.8			▲																								●		●		●						
FJ Finish Cutting	CNGG1204V5-FJ	0.05																								●											●		C008 C009 E013 E036 E041 H006 –008
	CNGG120401-FJ	0.1																								●											●		
	CNGG120402-FJ	0.2																								●											●		
	CNGG120404-FJ	0.4																								●	●										●		
	CNGG120408-FJ	0.8																								●	●										●		
PK Finish Cutting	CNGG120404-PK	0.4																											●										C008 C009 E013 E036 E041 H006 –008
LP Light Cutting	CNMG120404-LP	0.4	●	●		●	●	●																							●								C008 C009 E013 E036 E041 H006 –008
	CNMG120408-LP	0.8	●	●		●	●	●																							●								
	CNMG120412-LP	1.2	●	●		●	●	●																															

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515	MP9005	MP9015	MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠										◐	✠	✠		○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐				◐	✠			●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐
			Coated																										Cermet		Coated Cermet			Carbide				
Shape	Order Number	RE (mm)																			NEW			NEW														
LM Light Cutting	CNMG120404-LM	0.4									●	●	●																									
	CNMG120408-LM	0.8									●	●	●																									
	CNMG120412-LM	1.2									●	●	●																									
LK Light Cutting	CNMG120404-LK	0.4															●	●																				
	CNMG120408-LK	0.8															●	●			●																	
	CNMG120412-LK	1.2															●	●			●																	
LS Light Cutting	NEW CNMG090304-LS	0.4																				●	●															
	NEW CNMG090308-LS	0.8																				●	●															
	NEW CNMG120402-LS	0.2																				●	●															●
	CNMG120404-LS	0.4																				●	●	●														●
	CNMG120408-LS	0.8																				●	●	●														●
SH Light Cutting	CNMG09T304-SH	0.4		●											●																							
	CNMG09T308-SH	0.8		●																																		
	CNMG120404-SH	0.4	●	●	▲	●	●								●					●									●	●		●						
	CNMG120408-SH	0.8	●	●	▲	●	●								●					●									●	●		●						
	CNMG120412-SH	1.2	●	●	▲	●	●																															
SA Light Cutting	CNMG120404-SA	0.4	●	●	▲	●	●																						●	●								
	CNMG120408-SA	0.8	●	●	▲	●	●																						●	●								
	CNMG120412-SA	1.2	●	●	▲	●	●																							●								
* SW Light Cutting (Wiper)	CNMG120404-SW	0.4	●	●		●								▲			●	●		●									●	●	●							
	CNMG120408-SW	0.8	●	●		●								▲			●	●		●									●	●	●							
	CNMG120412-SW	1.2	●	●		●								▲															●	●	●							
SY Light Cutting	CNMG120404-SY	0.4			▲																								●		●		●					
	CNMG120408-SY	0.8			▲																								●		●		●					
C Light Cutting	CNMG120404-C	0.4																											▲	▲								
	CNMG120408-C	0.8																											▲	▲								
MJ Light Cutting	CNMG120404-MJ	0.4														●						●	●		●	●											●	
	CNMG120408-MJ	0.8														●						●	●		●	●											●	
	CNMG120412-MJ	1.2														●						●	●		●	●												
	CNMG120416-MJ	1.6														●						●	●		●	●												

Applicable Holder Page
C008
C009
E013
E036
E041
H006
–008

* Please refer to A028 before using the SW breaker (wiper insert).

● = NEW

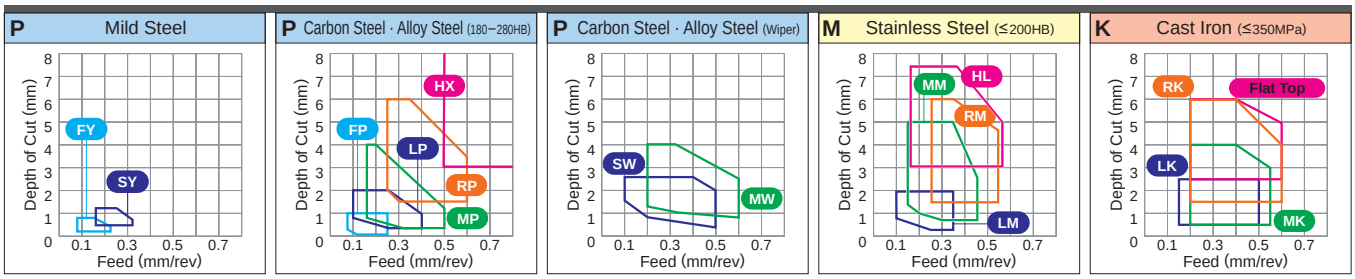
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CN TYPE INSERTS WITH HOLE

CNGG 12 04 04- MJ
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	● ◐ ✣ ◐ ✣ ✣ ✣ ●
M	Stainless Steel	○ ◐ ✣ ○ ✣ ◐ ✣ ✣ ○ ○ ○ ✣
K	Cast Iron	● ◐ ● ◐ ◐ ◐ ● ◐ ✣ ● ● ● ✣ ● ◐
N	Non-ferrous Metal	◐
S	Heat-resistant Alloy, Titanium Alloy	● ● ◐ ✣ ● ◐ ✣ ◐ ◐ ◐

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
MJ	**CNGG120404-MJ**	0.4																								●	●									●	●		C008
	CNGG120408-MJ	0.8																								●	●									●	●		C009
																																							E013 E036 E041 H006 −008
Light Cutting																																							
MP	**CNMG120404-MP**	0.4	●	●	▲	●	●	●												●											●								
	CNMG120408-MP	0.8	●	●	▲	●	●	●												●											●								C008
	CNMG120412-MP	1.2	●	●	▲	●	●	●												●											●								C009
	CNMG120416-MP	1.6	●	●	▲	●	●	●												●																			E013
	CNMG160608-MP	0.8	●	●	▲		●													●																			E036
	CNMG160612-MP	1.2	●	●	▲		●													●																			E041
	CNMG160616-MP	1.6	●	●	▲		●													●																			H006 −008
Medium Cutting																																							
MM	**CNMG120408-MM**	0.8									●	●	●																										
	CNMG120412-MM	1.2									●	●	●																										
	CNMG120416-MM	1.6									●	●	●																										C008
	CNMG160608-MM	0.8									●	●	●																										C009
	CNMG160612-MM	1.2									●	●	●																										E013
	CNMG160616-MM	1.6									●	●	●																										E036
	CNMG190608-MM	0.8									●	●	●																										E041
	CNMG190612-MM	1.2									●	●	●																										H006 −008
Medium Cutting	**CNMG190616-MM**	1.6									●	●	●																										
MK	**CNMG120404-MK**	0.4															●	●																					
	CNMG120408-MK	0.8															●	●																					
	CNMG120412-MK	1.2															●	●																					C008
	CNMG120416-MK	1.6															●	●																					C009
	CNMG160608-MK	0.8															●	●																					E013
	CNMG160612-MK	1.2															●	●																					E036
	CNMG160616-MK	1.6															●	●																					E041
	CNMG190612-MK	1.2															●	●																					H006 −008
Medium Cutting	**CNMG190616-MK**	1.6															●	●																					
* **MS**	NEW **CNMG090304-MS**	0.4																				●	●																C008
	NEW **CNMG090308-MS**	0.8																				●	●																C009
	CNMG120404-MS	0.4																				●	●	●													●		E013
	CNMG120408-MS	0.8																				●	●	●													●		E036
Medium Cutting	**CNMG120412-MS**	1.2																				●	●	●													●		E041 H006 −008

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																								Cermet		Coated Cermet			Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
P	Steel		●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
M	Stainless Steel										○	◐	✠	○	✠										◐	✠	✠	○				○	○	✠				
K	Cast Iron																●	◐	●	◐	◐				◐	✠		●				●	●	✠	●	◐		
N	Non-ferrous Metal																																			◐		
S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
* MS Medium Cutting	CNMG160612-MS	1.2																				●	●															●	C008 C009 E013 E036 E041 H006 −008
	CNMG160616-MS	1.6																				●	●															●	
MS Medium Cutting	CNMG090304-MS	0.4													●																								C008 C009 E013 E036 E041 H006 −008
	CNMG090308-MS	0.8		●											●																								
	CNMG09T304-MS	0.4													●																			●					
	CNMG09T308-MS	0.8		●											●																								
	CNMG120404-MS	0.4		●	▲									▲	●	●									●	●	●	●								●	●		
	CNMG120408-MS	0.8		●	▲									▲	●	●									●	●	●	●						●		●	●		
	CNMG120412-MS	1.2		●										▲	●	●									●	●	●										●		
	CNMG160608-MS	0.8													●																								
	CNMG160612-MS	1.2													●																								
	CNMG190612-MS	1.2													●																								
Medium Cutting	CNMG190616-MS	1.6													●																								
GK Medium Cutting	CNMG120404-GK	0.4															●	●																					C008 C009 E013 E036 E041 H006 −008
	CNMG120408-GK	0.8															●	●			●																		
	CNMG120412-GK	1.2															●	●			●																		
GM Medium Cutting	CNMG120404-GM	0.4									●	●	●																										C008 C009 E013 E036 E041 H006 −008
	CNMG120408-GM	0.8									●	●	●																										
	CNMG120412-GM	1.2									●	●	●																										
MA Medium Cutting	CNMG120404-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●	●	●			●	●			●			●									C008 C009 E013 E036 E041 H006 −008
	CNMG120408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●	●		●	●			●			●									
	CNMG120412-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●	●		●	●			●			●									
	CNMG120416-MA	1.6	●	●	▲									▲	●					●			●																
	CNMG160608-MA	0.8	●	●	▲	●	●	●							●					●																			
	CNMG160612-MA	1.2	●	●	▲	●	●	●						▲	●					●																			
	CNMG160616-MA	1.6	●	●		●	●	●							●					●																			
	CNMG190612-MA	1.2	●	●	▲	●	●	●						▲	●				●	●																			
	CNMG190616-MA	1.6		●	▲	●	●	●							●					●																			
MH Medium Cutting	CNMG120404-MH	0.4	●	●	▲									▲																									C008 C009 E013 E036 E041 H006 −008
	CNMG120408-MH	0.8	●	●	▲	●	●	●						▲						●																			
	CNMG120412-MH	1.2	●	●	▲	●	●	●						▲						●																			
	CNMG120416-MH	1.6	●	●	▲															●																			
	CNMG160608-MH	0.8	●	●																●																			
	CNMG160612-MH	1.2	●	●	▲	●	●	●						▲						●																			
	CNMG160616-MH	1.6	●	●																●																			
	CNMG190612-MH	1.2	●	●	▲	●	●	●						▲						●																			
	CNMG190616-MH	1.6	●	●	▲																																		

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

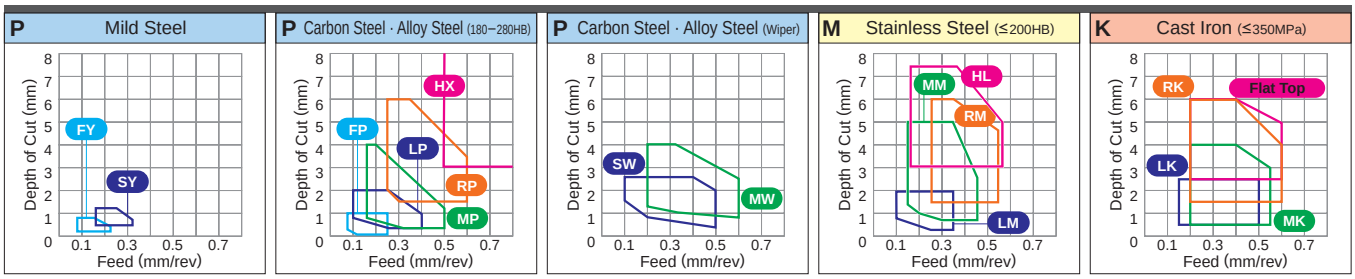
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CN TYPE INSERTS WITH HOLE

CNMG 09 03 08
Size Thickness Corner Radius
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
Standard	**CNMG090308**	0.8		●																																			
	CNMG09T304	0.4		●		●	●																						●										
	CNMG09T308	0.8		●		●	●																						●										
	CNMG120404	0.4	●	●	▲	●	●												●	●									●	●	●			●		●			
	CNMG120408	0.8	●	●	▲	●	●	●											●	●							●		●		●			●		●			C008
	CNMG120412	1.2	●	●	▲	●	●	●											●	●							●		●										C009
	CNMG120416	1.6	●	●		●	●												●	●																			E013
	CNMG160608	0.8	●	●	▲	●	●	●																															E036
	CNMG160612	1.2	●	●	▲	●	●	●											●	●																			E041
	CNMG160616	1.6	●	●		●	●	●											●	●																			H006
	CNMG190608	0.8	●	●	▲	●	●	●																															–008
	CNMG190612	1.2	●	●	▲	●	●	●											●	●																			
Medium Cutting	**CNMG190616**	1.6	●	●	▲	●	●	●												●																			
* **MW**	**CNMG120408-MW**	0.8	●	●	▲	●	●							▲			●	●	●	●																			C008
	CNMG120412-MW	1.2	●	●	▲	●	●							▲			●	●	●	●																			C009
Medium Cutting (Wiper)																																							E013 E036 E041 H006 –008
RP	**CNMG120408-RP**	0.8	●	●		●	●	●																															
	CNMG120412-RP	1.2	●	●		●	●	●																															C008
	CNMG120416-RP	1.6	●	●		●	●	●																															C009
	CNMG160612-RP	1.2	●	●		●	●	●																															E013
	CNMG160616-RP	1.6	●	●		●	●	●																															E036
	CNMG190612-RP	1.2	●	●		●	●	●																															E041
Rough Cutting	**CNMG190616-RP**	1.6	●	●		●	●	●																															H006 –008
RM	**CNMG120408-RM**	0.8									●	●	●																										
	CNMG120412-RM	1.2									●	●	●																										C008
	CNMG120416-RM	1.6									●	●	●																										C009
	CNMG160612-RM	1.2									●	●	●																										E013
	CNMG160616-RM	1.6									●	●	●																										E036
	CNMG190612-RM	1.2									●	●	●																										E041
Rough Cutting	**CNMG190616-RM**	1.6									●	●	●																										H006 –008

* Please refer to A028 before using the MW breaker (wiper insert).

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515	MP9005	MP9015	MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
RK	**CNMG120408-RK**	0.8															●	●			●																		C008 C009 E013 E036 E041 H006 −008
	CNMG120412-RK	1.2															●	●			●																		
	CNMG120416-RK	1.6															●	●																					
	CNMG160608-RK	0.8															●	●																					
	CNMG160612-RK	1.2															●	●																					
	CNMG160616-RK	1.6															●	●																					
	CNMG190612-RK	1.2															●	●																					
Rough Cutting	**CNMG190616-RK**	1.6															●	●																					
RS	**CNMG120408-RS**	0.8																					●	●														●	C008 C009 E013 E036 E041 H006 −008
	CNMG120412-RS	1.2																					●	●														●	
	CNMG120416-RS	1.6																					●	●														●	
	CNMG160612-RS	1.2																					●															●	
	CNMG160616-RS	1.6																					●															●	
	CNMG190612-RS	1.2																					●															●	
Rough Cutting	**CNMG190616-RS**	1.6																					●															●	
GH	**CNMG120408-GH**	0.8	●	●	▲									▲	●				●	●																			C008 C009 E013 E036 E041 H006 −008
	CNMG120412-GH	1.2	●	●	▲									▲	●				●	●																			
	CNMG120416-GH	1.6	●	●															●	●																			
	CNMG160612-GH	1.2	●	●	▲									▲	●				●	●																			
	CNMG160616-GH	1.6	●	●															●	●																			
	CNMG190612-GH	1.2	●	●	▲										●				●	●																			
Rough Cutting	**CNMG190616-GH**	1.6	●	●	▲									▲	●				●	●																			
GJ	**CNMG120408-GJ**	0.8														●										●	●										●		C008 C009 E013 E036 E041 H006 −008
	CNMG120412-GJ	1.2														●										●	●										●		
	CNMG120416-GJ	1.6														●										●	●										●		
	CNMG160612-GJ	1.2														●										●											●		
	CNMG190612-GJ	1.2														●										●											●		
Rough Cutting	**CNMG190616-GJ**	1.6														●										●											●		
HX	**CNMM120408-HX**	0.8					●	●																															C008 C009 E013 E036 E041 H006 −008
	CNMM120412-HX	1.2					●	●																															
	CNMM160612-HX	1.2					●	●																															
	CNMM160616-HX	1.6					●	●																															
	CNMM190612-HX	1.2		●	▲		●	●	●																														
	CNMM190616-HX	1.6		●	▲		●	●	●																														
	CNMM190624-HX	2.4		●	▲		●	●	●																														
Heavy Cutting	**CNMM250924-HX**	2.4		●	▲		●	●	●																														
HL	**CNMM120408-HL**	0.8					●	●							●																								C008 C009 E013 E036 E041 H006 −008
	CNMM120412-HL	1.2					●	●							●																								
	CNMM120416-HL	1.6						●																															
	CNMM160612-HL	1.2					●	●							●																								
	CNMM160616-HL	1.6					●	●							●																								
	CNMM190612-HL	1.2					●	●							●																								
	CNMM190616-HL	1.6					●	●							●																								
Heavy Cutting	**CNMM190624-HL**	2.4					●	●							●																								

● = NEW

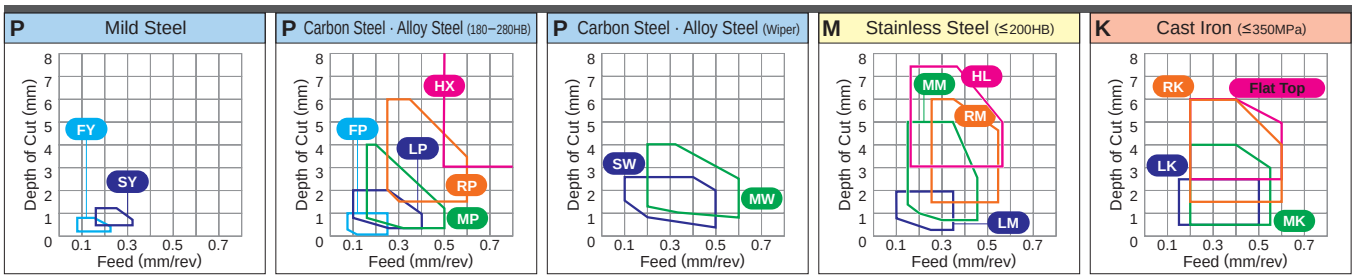
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CN TYPE INSERTS WITH HOLE

CNMM 25 09 24- HR
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
Work Material	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣				
	M	Stainless Steel									○	◐	✣	○	✣											◐	✣	✣	○			○	○	✣				
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
			Coated																										Cermet		Coated Cermet			Carbide					
HR Heavy Cutting	**CNMM250924-HR**	2.4					●	●																															–
HV Heavy Cutting	**CNMM190616-HV**	1.6		●	▲		●	●	●																														C008 C009
	CNMM190624-HV	2.4		●	▲		●	●	●																														
	CNMM250924-HV	2.4		●	▲		●	●	●																														
HZ Heavy Cutting	**CNMM120408-HZ**	0.8		●	▲		●	●																															C008 C009 E013 E036 E041 H006 –008
	CNMM120412-HZ	1.2		●	▲		●	●																															
	CNMM120416-HZ	1.6						●																															
	CNMM160612-HZ	1.2		●	▲																																		
	CNMM160616-HZ	1.6		●	▲																																		
	CNMM190612-HZ	1.2		●	▲				●																														
	CNMM190616-HZ	1.6		●	▲				●																														
HM Heavy Cutting	**CNMM160612-HM**	1.2					●	●							●																								C008 C009 E013 E036 E041 H006 –008
	CNMM160616-HM	1.6					●	●							●																								
	CNMM190612-HM	1.2					●	●							●																								
	CNMM190616-HM	1.6					●	●							●																								
	CNMM190624-HM	2.4					●	●							●																								
	CNMM250924-HM	2.4					●	●																															
Flat Top	**CNMA120404**	0.4															●	●	●	●															●	●			C008 C009 E013 E036 E041 H006 –008
	CNMA120408	0.8															●	●	●	●	●														●	●			
	CNMA120412	1.2															●	●	●	●	●																		
	CNMA120416	1.6															●	●	●	●																			
	CNMA160612	1.2															●	●	●	●																			
	CNMA160616	1.6															●	●	●	●																			
	CNMA190612	1.2															●	●	●	●																			
	CNMA190616	1.6															●	●	●	●																			
	CNMA190624	2.4															●	●																					

● = NEW

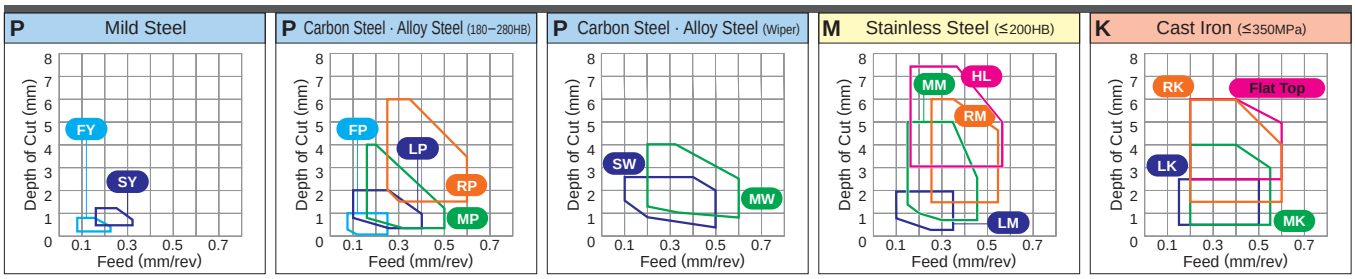
● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

55° DN TYPE INSERTS WITH HOLE

DNMG 15 04 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
FP	**DNMG150402-FP**	0.2				●	●																						●		●								C010 C011 E013 E036 –041 H009 –011
	DNMG150404-FP	0.4				●	●																						●		●								
	DNMG150408-FP	0.8				●	●																						●		●								
	NEW **DNMG150412-FP**	1.2				●	●																						●		●								
	DNMG150602-FP	0.2				●	●																						●		●								
	DNMG150604-FP	0.4				●	●																						●		●								
	DNMG150608-FP	0.8				●	●																						●		●								
Finish Cutting	NEW **DNMG150612-FP**	1.2				●	●																						●		●								
FH	**DNMG150402-FH**	0.2		●	▲																								●	●	●								C010 C011 E013 E036 –041 H009 –011
	DNMG150404-FH	0.4		●																									●	●	●	●							
	DNMG150408-FH	0.8		●																									●		●	●							
	DNMG150602-FH	0.2		●	▲																								●	●	●								
	DNMG150604-FH	0.4		●	▲																										●								
Finish Cutting	**DNMG150608-FH**	0.8		●	▲																										●								
FS	**DNMG150404-FS**	0.4																											●										C010 C011 E013 E036 –041 H009 –011
	DNMG150408-FS	0.8			▲																								●										
Finish Cutting																																							
FY	**DNMG150404-FY**	0.4			▲																								●	●	●		●						C010 C011 E013 E036 –041 H009 –011
	DNMG150408-FY	0.8			▲																								●		●		●						
	DNMG150604-FY	0.4																													●								
	DNMG150608-FY	0.8			▲																										●								
Finish Cutting																																							
FJ	**DNGG150404-FJ**	0.4																								●	●										●		C010 C011 E013 E036 –041 H009 –011
	DNGG150408-FJ	0.8																								●	●										●		
Finish Cutting																																							
PK	**DNGG150404-PK**	0.4																											●										C010 C011 E013 E036 –041 H009 –011
Finish Cutting																																							

● = NEW

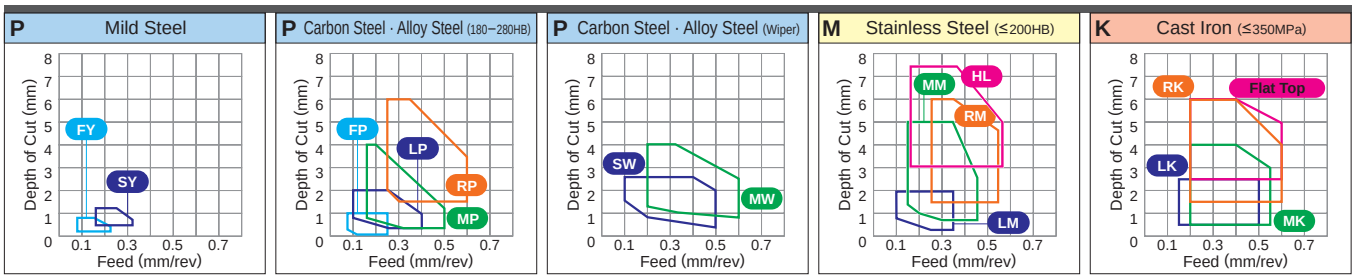
CHIP BREAKERS	➤ A042
GRADES	➤ A030
IDENTIFICATION	➤ A002

55° DN TYPE INSERTS WITH HOLE

DNMG 11 04 04- LP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	● ◐ ✣ ◐ ✣ ✣ ✣ ●
M	Stainless Steel	○ ◐ ✣ ○ ✣ ◐ ✣ ✣ ○ ○ ○ ✣
K	Cast Iron	● ◐ ● ◐ ◐ ◐ ◐ ● ● ● ✣ ● ● ✣
N	Non-ferrous Metal	◐
S	Heat-resistant Alloy, Titanium Alloy	● ● ◐ ◐ ◐ ◐ ◐ ◐ ◐

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
LP	DNMG110404-LP	0.4	●	●		●	●	●																							●								
	DNMG110408-LP	0.8	●	●		●	●	●																							●								
	DNMG150404-LP	0.4	●	●		●	●	●																							●								C010 C011 E013 E036 –041 H009 –011
	DNMG150408-LP	0.8	●	●		●	●	●																							●								
	DNMG150412-LP	1.2	●	●		●	●	●																							●								
	DNMG150604-LP	0.4	●	●		●	●	●																							●								
	DNMG150608-LP	0.8	●	●		●	●	●																							●								
Light Cutting	DNMG150612-LP	1.2	●	●		●	●	●																															
LM	DNMG110404-LM	0.4									●	●	●																										C010 C011 E013 E036 –041 H009 –011
	DNMG110408-LM	0.8									●	●	●																										
	DNMG150404-LM	0.4									●	●	●																										
	DNMG150408-LM	0.8									●	●	●																										
	DNMG150412-LM	1.2									●	●	●																										
	DNMG150604-LM	0.4									●	●	●																										
	DNMG150608-LM	0.8									●	●	●																										
Light Cutting	DNMG150612-LM	1.2									●	●	●																										
LK	DNMG110408-LK	0.8															●	●																					C010 C011 E013 E036 –041 H009 –011
	DNMG150404-LK	0.4															●	●			●																		
	DNMG150408-LK	0.8															●	●																					
	DNMG150412-LK	1.2															●	●																					
	DNMG150604-LK	0.4															●	●																					
	DNMG150608-LK	0.8															●	●																					
Light Cutting	DNMG150612-LK	1.2															●	●																					
LS	NEW DNMG150402-LS	0.2																				●	●	●														●	C010 C011 E013 E036 –041 H009 –011
	DNMG150404-LS	0.4																				●	●	●														●	
	DNMG150408-LS	0.8																				●	●	●														●	
	DNMG150604-LS	0.4																				●	●	●														●	
Light Cutting	DNMG150608-LS	0.8																				●	●	●														●	
SH	DNMG110404-SH	0.4	●	●											●																								C010 C011 E013 E036 –041 H009 –011
	DNMG110408-SH	0.8	●	●											●																								
	DNMG150404-SH	0.4	●	●	▲	●	●								●					●									●	●		●							
	DNMG150408-SH	0.8	●	●	▲	●	●								●					●									●	●		●							
	DNMG150412-SH	1.2	●	●	▲	●	●								●					●									●			●							
	DNMG150604-SH	0.4	●	●																																			
	DNMG150608-SH	0.8	●	●																●																			
Light Cutting	DNMG150612-SH	1.2	●	●																●																			

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
			Coated																										Cermet		Coated Cermet			Carbide					
SA	DNMG150404-SA	0.4	●	●	▲	●	●																						●	●									C010 C011 E013 E036 −041 H009 −011
	DNMG150408-SA	0.8	●	●	▲	●	●																						●	●									
	DNMG150412-SA	1.2	●	●	▲	●	●																							●									
	DNMG150604-SA	0.4	●	●	▲																									●									
	DNMG150608-SA	0.8	●	●	▲																									●									
Light Cutting	DNMG150612-SA	1.2	●	●	▲																									●									
* SW	DNMX110404-SW	0.4	●			●																																	C010 E013 E036 E038 E040 H009 H011
	DNMX110408-SW	0.8	●			●																																	
	DNMX150404-SW	0.4	●	●		●								▲															●	●	●								
	DNMX150408-SW	0.8	●	●		●								▲															●	●	●								
	DNMX150412-SW	1.2	●	●		●								▲															●	●									
	DNMX150604-SW	0.4	●	●		●								▲															●	●	●								
	DNMX150608-SW	0.8	●	●		●								▲															●	●	●								
Light Cutting (Wiper)	DNMX150612-SW	1.2	●	●		●								▲															●	●									
SY	DNMG150404-SY	0.4			▲																								●	●	●								C010 C011 E013 E036 −041 H009 −011
	DNMG150408-SY	0.8			▲																								●		●		●						
	DNMG150604-SY	0.4																													●								
	DNMG150608-SY	0.8			▲																										●								
Light Cutting																																							
C	DNMG150404-C	0.4																											▲	▲									C010 C011 E013 E036 −041 H009 −011
	DNMG150408-C	0.8																											▲	▲									
	DNMG150604-C	0.4																											▲	▲									
	DNMG150608-C	0.8																											▲	▲									
Light Cutting																																							
MJ	DNMG150404-MJ	0.4														●						●	●		●	●											●		C010 C011 E013 E036 −041 H009 −011
	DNMG150408-MJ	0.8														●						●	●		●	●											●		
	DNMG150412-MJ	1.2														●						●	●		●	●													
	DNMG150416-MJ	1.6														●						●	●		●	●													
	DNMG150604-MJ	0.4														●						●	●		●	●													
	DNMG150608-MJ	0.8														●						●	●		●	●													
	DNMG150612-MJ	1.2														●						●	●		●	●													
Light Cutting	DNMG150616-MJ	1.6														●						●	●		●	●													
MJ	DNGM150404-MJ	0.4																								●	●									●	●		C010 C011 E013 E036 −041 H009 −011
	DNGM150408-MJ	0.8																								●	●									●	●		
Light Cutting																																							
MP	DNMG150404-MP	0.4	●	●	▲	●	●	●												●											●								C010 C011 E013 E036 −041 H009 −011
	DNMG150408-MP	0.8	●	●	▲	●	●	●												●											●								
	DNMG150412-MP	1.2	●	●	▲	●	●	●												●											●								
	DNMG150416-MP	1.6	●	●	▲	●	●	●												●																			
	DNMG150604-MP	0.4	●	●	▲	●	●	●												●											●								
	DNMG150608-MP	0.8	●	●	▲	●	●	●												●											●								
	DNMG150612-MP	1.2	●	●	▲	●	●	●												●											●								
Medium Cutting	DNMG150616-MP	1.6	●	●	▲	●	●	●												●																			

* Please refer to A028 before using the SW breaker (wiper insert).

● = NEW

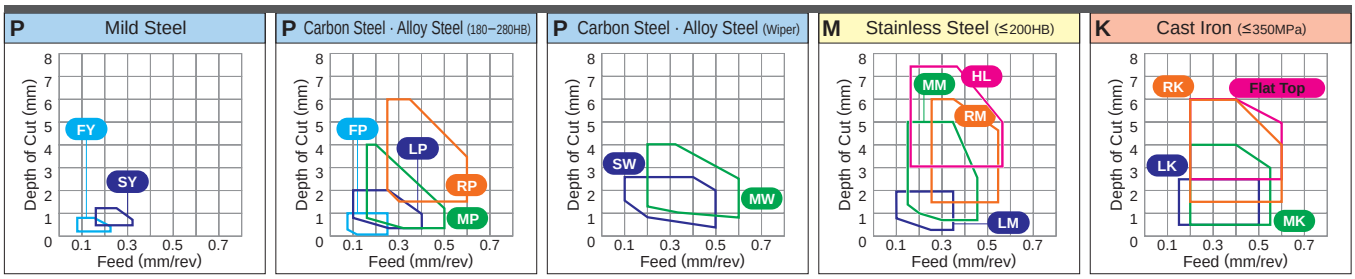
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

55° DN TYPE INSERTS WITH HOLE

DNMG 15 04 08- MM
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
MM	DNMG150408-MM	0.8									●	●	●																										C010 C011 E013 E036 –041 H009 –011
	DNMG150412-MM	1.2									●	●	●																										
	DNMG150608-MM	0.8									●	●	●																										
	DNMG150612-MM	1.2									●	●	●																										
Medium Cutting																																							
MK	DNMG110408-MK	0.8															●	●																					C010 C011 E013 E036 –041 H009 –011
	DNMG150404-MK	0.4															●	●																					
	DNMG150408-MK	0.8															●	●																					
	DNMG150412-MK	1.2															●	●																					
	DNMG150604-MK	0.4															●	●																					
	DNMG150608-MK	0.8															●	●																					
Medium Cutting	DNMG150612-MK	1.2															●	●																					
* MS	DNMG150404-MS	0.4																				●	●	●														●	C010 C011 E013 E036 –041 H009 –011
	DNMG150408-MS	0.8																				●	●	●														●	
	DNMG150412-MS	1.2																				●	●	●														●	
	DNMG150604-MS	0.4																				●	●	●														●	
	DNMG150608-MS	0.8																				●	●	●														●	
Medium Cutting	DNMG150612-MS	1.2																				●	●	●														●	
MS	DNMG110408-MS	0.8		●											●																								C010 C011 E013 E036 –041 H009 –011
	DNMG150404-MS	0.4		●	▲									▲	●	●									●	●	●												
	DNMG150408-MS	0.8		●										▲	●	●									●	●	●	●									●		
	DNMG150412-MS	1.2		●											●	●									●	●													
	DNMG150604-MS	0.4		●										▲	●	●									●	●		●											
	DNMG150608-MS	0.8		●										▲	●	●									●	●													
Medium Cutting	DNMG150612-MS	1.2		●												●									●	●													
GK	DNMG150404-GK	0.4															●	●			●																		C010 C011 E013 E036 –041 H009 –011
	DNMG150408-GK	0.8															●	●																					
	DNMG150412-GK	1.2															●	●																					
	DNMG150604-GK	0.4															●	●																					
	DNMG150608-GK	0.8															●	●																					
Medium Cutting	DNMG150612-GK	1.2															●	●																					

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
			Coated																										Cermet		Coated Cermet			Carbide					
GM	**DNMG150404-GM**	0.4									●	●	●																										C010 C011 E013 E036 −041 H009 −011
	DNMG150408-GM	0.8									●	●	●																										
	DNMG150412-GM	1.2									●	●	●																										
	DNMG150604-GM	0.4									●	●	●																										
	DNMG150608-GM	0.8									●	●	●																										
Medium Cutting	**DNMG150612-GM**	1.2									●	●	●																										
MA	**DNMG110404-MA**	0.4	●	●		●	●																																C010 C011 E013 E036 −041 H009 −011
	DNMG110408-MA	0.8	●	●		●	●																																
	DNMG110412-MA	1.2	●	●		●	●																																
	DNMG150404-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●	●	●			●				●			●									
	DNMG150408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●	●			●			●									
	DNMG150412-MA	1.2	●	●	▲	●	●	●				●	●		●		●	●		●			●	●			●			●									
	DNMG150604-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●					●				●			●									
	DNMG150608-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●	●			●			●									
	DNMG150612-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●	●			●			●									
Medium Cutting	**DNMG150616-MA**	1.6		●																																			
MH	**DNMG150404-MH**	0.4	●	●	▲																																		C010 C011 E013 E036 −041 H009 −011
	DNMG150408-MH	0.8	●	●	▲	●	●	●						▲						●																			
	DNMG150412-MH	1.2	●	●	▲	●	●	●						▲						●																			
	DNMG150604-MH	0.4	●	●																●																			
	DNMG150608-MH	0.8	●	●	▲	●	●	●						▲						●																			
Medium Cutting	**DNMG150612-MH**	1.2	●	●	▲	●	●	●												●																			
Standard	**DNMG110408**	0.8		●																	●																		C010 C011 E013 E036 −041 H009 −011
	DNMG150404	0.4	●	●	▲	●	●												●	●									●	●	●					●			
	DNMG150408	0.8	●	●	▲	●	●	●											●	●							●		●	●	●					●			
	DNMG150412	1.2	●	●	▲	●	●	●											●	●							●		●										
	DNMG150416	1.6		●		●	●	●																															
	DNMG150604	0.4	●	●	▲	●	●												●	●									●		●								
	DNMG150608	0.8	●	●	▲	●	●	●											●	●							●		●		●								
	DNMG150612	1.2	●	●	▲	●	●	●											●	●							●												
Medium Cutting	**DNMG150616**	1.6		●		●	●	●																															
* **MW**	**DNMX150408-MW**	0.8	●	●		●											●	●	●	●																			C010 E013 E036 E038 E040 H009 H011
	DNMX150412-MW	1.2	●	●		●											●	●	●	●																			
	DNMX150608-MW	0.8	●	●		●								▲			●	●	●	●																			
	DNMX150612-MW	1.2	●	●		●											●	●																					
Medium Cutting (Wiper)																																							
R/L	**DNGG150404R**	0.4																											●	●				●		●			C010 C011 E013 E036 −041 H009 −011
	DNGG150404L	0.4																											●	●				●		●			
	DNGG150408R	0.8																											●	●				●					
	DNGG150408L	0.8																											●	●									
	DNGG150604R	0.4																												●				●					
	DNGG150604L	0.4																												●									
	DNGG150608R	0.8																												●									
Medium Cutting	**DNGG150608L**	0.8																												●									

* Please refer to A028 before using the MW breaker (wiper insert).

● = NEW

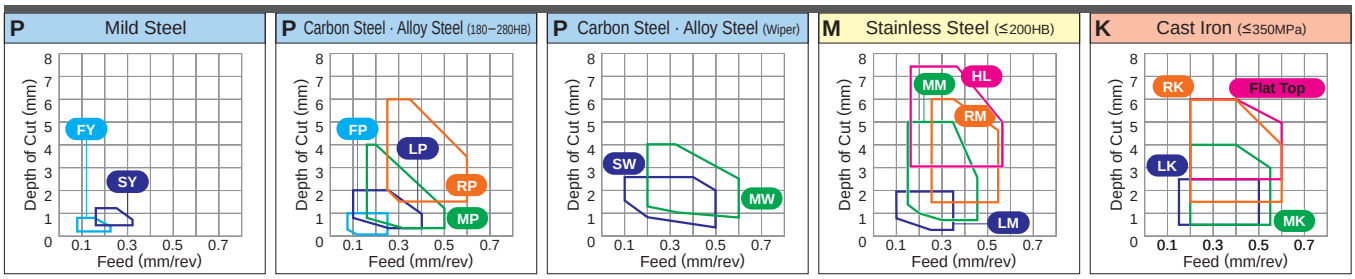
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

55° DN TYPE INSERTS WITH HOLE

DNMG 15 04 08- RP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

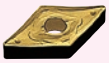
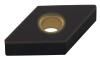
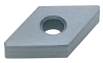
Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
RP	DNMG150408-RP	0.8	●	●		●	●	●																															
	DNMG150412-RP	1.2	●	●		●	●	●																															C010 C011 E013 E036 −041 H009 −011
	DNMG150416-RP	1.6	●	●		●	●	●																															
	DNMG150608-RP	0.8	●	●		●	●	●																															
	DNMG150612-RP	1.2	●	●		●	●	●																															
Rough Cutting	DNMG150616-RP	1.6	●	●		●	●	●																															
RM	DNMG150408-RM	0.8									●	●	●																										
	DNMG150412-RM	1.2									●	●	●																										C010 C011 E013 E036 −041 H009 −011
	DNMG150416-RM	1.6									●	●	●																										
	DNMG150608-RM	0.8									●	●	●																										
	DNMG150612-RM	1.2									●	●	●																										
Rough Cutting	DNMG150616-RM	1.6									●	●	●																										
RK	DNMG150408-RK	0.8															●	●																					
	DNMG150412-RK	1.2															●	●																					C010 C011 E013 E036 −041 H009 −011
	DNMG150608-RK	0.8															●	●																					
	DNMG150612-RK	1.2															●	●																					
Rough Cutting																																							
RS	DNMG150408-RS	0.8																					●	●														●	
	DNMG150412-RS	1.2																					●	●														●	C010 C011 E013 E036 −041 H009 −011
	DNMG150416-RS	1.6																					●															●	
	DNMG150608-RS	0.8																					●	●														●	
	DNMG150612-RS	1.2																					●	●														●	
Rough Cutting	DNMG150616-RS	1.6																					●															●	
GH	DNMG150408-GH	0.8	●	●	▲										●				●	●																			C010 C011 E013 E036 −041 H009 −011
	DNMG150412-GH	1.2	●	●	▲									▲	●				●	●																			
	DNMG150608-GH	0.8	●	●	▲										●				●	●																			
	DNMG150612-GH	1.2	●	●	▲										●				●	●																			
Rough Cutting																																							
GJ	DNMG150408-GJ	0.8														●										●	●										●		
	DNMG150412-GJ	1.2														●										●	●										●		C010 C011 E013 E036 −041 H009 −011
	DNMG150416-GJ	1.6														●										●	●										●		
	DNMG150608-GJ	0.8														●										●													
	DNMG150612-GJ	1.2														●										●													
Rough Cutting	DNMG150616-GJ	1.6														●										●													

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy													●							●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	Applicable Holder Page
HL  Heavy Cutting	**DNMM150408-HL**	0.8	C010 C011 E013 E036 –041 H009 –011
	DNMM150412-HL	1.2	
	DNMM150608-HL	0.8	
	DNMM150612-HL	1.2	
HZ Heavy Cutting	**DNMM150408-HZ**	0.8	C010 C011 E013 E036 –041 H009 –011
	DNMM150412-HZ	1.2	
	DNMM150608-HZ	0.8	
	DNMM150612-HZ	1.2	
Flat Top 	**DNMA150404**	0.4	C010 C011 E013 E036 –041 H009 –011
	DNMA150408	0.8	
	DNMA150412	1.2	
	DNMA150604	0.4	
	DNMA150608	0.8	
	DNMA150612	1.2	
Flat Top 	**DNGA150404**	0.4	C010 C011 E013 E036 –041 H009 –011
	DNGA150408	0.8	

Shape	Order Number	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
		Coated																										Cermet		Coated Cermet			Carbide				
HL	**DNMM150408-HL**					●	●							●																							
	DNMM150412-HL					●	●							●																							
	DNMM150608-HL					●	●							●																							
	DNMM150612-HL					●	●							●																							
HZ	**DNMM150408-HZ**		●	▲		●	●																														
	DNMM150412-HZ		●	▲		●	●																														
	DNMM150608-HZ		●	▲		●	●																														
	DNMM150612-HZ		●	▲		●	●																														
Flat Top	**DNMA150404**															●	●	●	●																●		
	DNMA150408															●	●	●	●									●						●	●		
	DNMA150412															●	●	●	●																		
	DNMA150604															●	●																				
	DNMA150608															●	●	●	●																		
	DNMA150612															●	●	●	●																		
Flat Top	**DNGA150404**																																		●		
	DNGA150408																																	●	●		

● = NEW

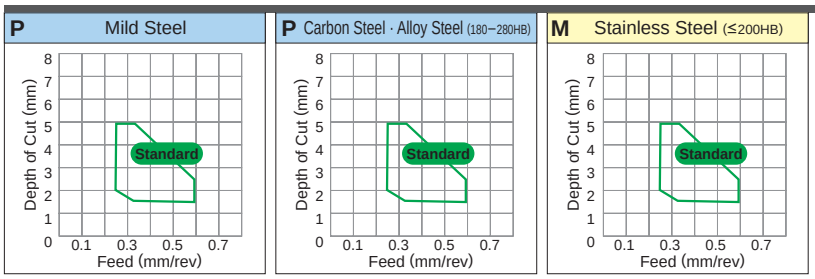
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

RN TYPE INSERTS WITH HOLE

RNMG 12 04 00
Size Thickness Corner Radius
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
			Coated																										Cermet		Coated Cermet			Carbide				
Work Material	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣				
	M	Stainless Steel									◐	◐	✣	◐	✣											◐	✣	✣	◐			◐	◐	✣				
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐

Shape	Order Number	IC (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
Standard Medium Cutting	**RNMG120400**	12.7		●	▲	●	●																																—

● = NEW

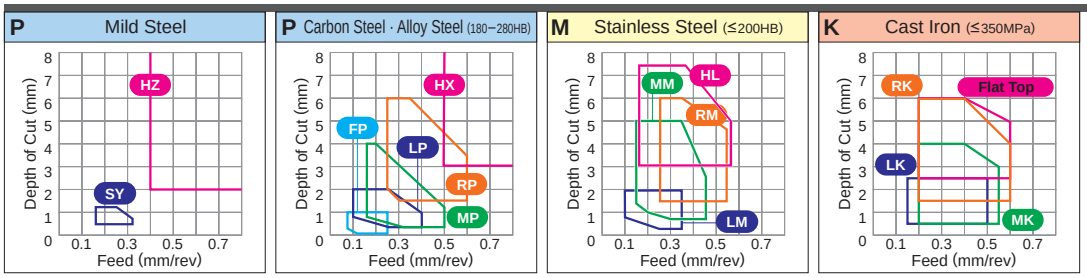
● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

90° SN TYPE INSERTS WITH HOLE

SNMG 12 04 04- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
			Coated																										Cermet		Coated Cermet			Carbide				
	P	Steel	●	◐	✣	◐	✣	✣	✣	●																		✣	✣	●	◐	◐	●	●	✣				
	M	Stainless Steel									○	◐	✣	○	✣											◐	✣	✣	○			○	○	✣					
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐			
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
FP Finish Cutting	**SNMG120404-FP**	0.4				●	●																						●		●								C012 –015 E014 E035
	SNMG120408-FP	0.8				●	●																						●		●								
	NEW **SNMG120412-FP**	1.2				●	●																						●		●								
FH Finish Cutting	**SNMG090304-FH**	0.4																											●										C012 –015 E014 E035
	SNMG090308-FH	0.8																											●										
	SNMG120404-FH	0.4		●																									●		●								
	SNMG120408-FH	0.8		●																											●								
FS Finish Cutting	**SNMG120408-FS**	0.8																											●										C012 –015 E014 E035
LP Light Cutting	**SNMG120404-LP**	0.4	●	●		●	●	●																							●								C012 –015 E014 E035
	SNMG120408-LP	0.8	●	●		●	●	●																							●								
	SNMG120412-LP	1.2	●	●		●	●	●																															
LM Light Cutting	**SNMG120404-LM**	0.4									●	●	●																										C012 –015 E014 E035
	SNMG120408-LM	0.8									●	●	●																										
LK Light Cutting	**SNMG120408-LK**	0.8															●	●																					C012 –015 E014 E035
	SNMG120412-LK	1.2															●	●																					
SH Light Cutting	**SNMG120404-SH**	0.4		●																●																			C012 –015 E014 E035
	SNMG120408-SH	0.8	●	●	▲															●									●										
	SNMG120412-SH	1.2		●	▲															●																			

● = NEW

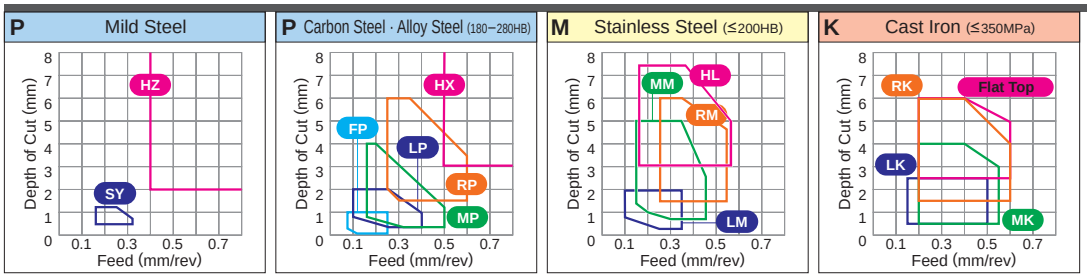
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

90° SN TYPE INSERTS WITH HOLE

SNMG 12 04 04- SA
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting····· Rough Cutting····· Heavy Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																								Cermet		Coated Cermet			Carbide						Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
SA Light Cutting	**SNMG120404-SA**	0.4		●																										●									C012 –015 E014 E035
	SNMG120408-SA	0.8	●	●	▲																									●									
	SNMG120412-SA	1.2		●	▲																									●									
SY Light Cutting	**SNMG120408-SY**	0.8			▲																										●								C012 –015 E014 E035
C Light Cutting	**SNMG090304-C**	0.4																											▲										C012 –015 E014 E035
	SNMG090308-C	0.8																											▲										
	SNMG120408-C	0.8																											▲	▲									
	SNMG120416-C	1.6																											▲										
R/L-1G Light Cutting	**SNMG120404L-1G**	0.4																											●										C012 –015 E014 E035
	SNMG120404R-1G	0.4																											●										
	SNMG120408R-1G	0.8																											●										
MP Medium Cutting	**SNMG120404-MP**	0.4	●	●	▲	●	●	●												●											●								C012 –015 E014 E035
	SNMG120408-MP	0.8	●	●	▲	●	●	●												●											●								
	SNMG120412-MP	1.2	●	●	▲	●	●	●												●											●								
MM Medium Cutting	**SNMG120408-MM**	0.8									●	●	●																										C012 –015 E014 E035
	SNMG120412-MM	1.2									●	●	●																										
	SNMG120416-MM	1.6									●	●	●																										
	SNMG150608-MM	0.8									●	●	●																										
	SNMG150612-MM	1.2									●	●	●																										
	SNMG150616-MM	1.6									●	●	●																										
	SNMG190612-MM	1.2									●	●	●																										
	SNMG190616-MM	1.6									●	●	●																										

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																								Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
	◐	✠	◐	✠	✠	✠	●	◐	✠	◐	✠	◐	✠	◐	✠	●	◐	◐	◐	◐	✠	✠	●	◐	✠	✠	●	◐	◐	●	●	✠	●	◐	◐	◐	◐	
MK	**SNMG120408-MK**	0.8															●	●																					
	SNMG120412-MK	1.2															●	●																					
	SNMG120416-MK	1.6															●	●																					C012
	SNMG150612-MK	1.2															●	●																					–015
	SNMG150616-MK	1.6															●	●																					E014
	SNMG190612-MK	1.2															●	●																					E035
Medium Cutting	**SNMG190616-MK**	1.6															●	●																					
* **MS**	**SNMG120404-MS**	0.4																				●	●															●	
	SNMG120408-MS	0.8																				●	●	●														●	C012
	SNMG120412-MS	1.2																				●	●	●														●	–015
	SNMG150612-MS	1.2																				●	●															●	E014
	SNMG150616-MS	1.6																				●	●															●	E035
Medium Cutting	NEW **SNMG190612-MS**	1.2																				●	●																
MS	**SNMG090304-MS**	0.4													●																								
	SNMG090308-MS	0.8													●																								
	SNMG120404-MS	0.4		●										▲	●																								C012
	SNMG120408-MS	0.8		●	▲									▲	●	●									●	●	●	●						●			●		–015
	SNMG120412-MS	1.2		●										▲	●	●									●	●	●												E014
	SNMG120416-MS	1.6													●																								E035
Medium Cutting	**SNMG190616-MS**	1.6													●																								
GK	**SNMG120404-GK**	0.4															●	●			●																		
	SNMG120408-GK	0.8															●	●																					C012
	SNMG120412-GK	1.2															●	●			●																		–015
																																							E014
Medium Cutting																																							E035
GM	**SNMG120404-GM**	0.4									●	●	●																										
	SNMG120408-GM	0.8									●	●	●																										C012
	SNMG120412-GM	1.2									●	●	●																										–015
																																							E014
Medium Cutting																																							E035
MA	**SNMG120404-MA**	0.4	●	●	▲	●	●					●	●		●		●	●		●			●				●			●									
	SNMG120408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●				●			●									
	SNMG120412-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●				●			●									
	SNMG120416-MA	1.6																		●			●																C012
	SNMG150608-MA	0.8	●	●	▲										●																								–015
	SNMG150612-MA	1.2	●	●	▲	●	●	●							●					●																			E014
	SNMG150616-MA	1.6		●		●	●	●																															E035
	SNMG190612-MA	1.2	●	●	▲	●	●	●												●																			
Medium Cutting	**SNMG190616-MA**	1.6	●	●	▲	●	●	●							●																								
MH	**SNMG120408-MH**	0.8	●	●	▲	●	●	●						▲						●																			
	SNMG120412-MH	1.2	●	●	▲	●	●	●						▲						●																			C012
	SNMG190612-MH	1.2	●	●	▲															●																			–015
	SNMG190616-MH	1.6	●	●	▲																																		E014
Medium Cutting																																							E035

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

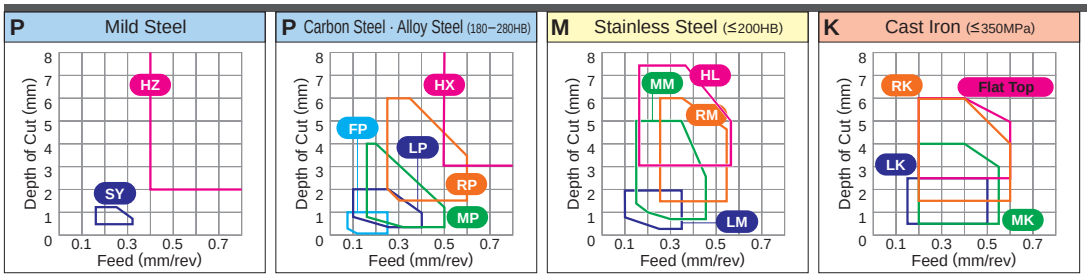
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

90° SN TYPE INSERTS WITH HOLE

SNMG 09 03 04
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
Standard	**SNMG090304**	0.4	●	●	▲	●	●																						●	●	●			●					C012 –015 E014 E035
	SNMG090308	0.8	●	●	▲	●	●																						●	●	●			●	●	●			
	SNMG120404	0.4	●	●	▲	●	●																						●		●			●		●			
	SNMG120408	0.8	●	●	▲	●	●	●											●	●							●		●	●	●			●	●	●			
	SNMG120412	1.2	●	●	▲	●	●	●											●	●										●				●	●				
	SNMG120416	1.6		●	▲	●	●	●											●	●										●				●					
	SNMG120420	2.0			▲	●	●	●																															
	SNMG150612	1.2	●	●	▲	●	●	●											●	●																			
	SNMG150616	1.6				●	●	●																															
	SNMG190612	1.2	●	●	▲	●	●	●											●	●														●					
Medium Cutting	**SNMG190616**	1.6	●	●	▲	●	●	●												●														●					
R/L	**SNGG090304R**	0.4																											●	●				●		●			C012 –015 E014 E035
	SNGG090304L	0.4																											●	●				●					
	SNGG090308R	0.8																											●	●									
	SNGG090308L	0.8																											●	●									
	SNGG120404R	0.4																											●	●	●			●					
	SNGG120404L	0.4																											●	●	●			●					
	SNGG120408R	0.8																											●	●	●								
Medium Cutting	**SNGG120408L**	0.8																											●	●	●			●		●			
RP	**SNMG120408-RP**	0.8	●	●		●	●	●																															C012 –015 E014 E035
	SNMG120412-RP	1.2	●	●		●	●	●																															
	SNMG120416-RP	1.6	●	●		●	●	●																															
	SNMG150612-RP	1.2	●	●		●	●	●																															
	SNMG150616-RP	1.6	●	●		●	●	●																															
	SNMG190612-RP	1.2	●	●		●	●	●																															
Rough Cutting	**SNMG190616-RP**	1.6	●	●		●	●	●																															
RM	**SNMG120408-RM**	0.8									●	●	●																										C012 –015 E014 E035
	SNMG120412-RM	1.2									●	●	●																										
	SNMG120416-RM	1.6									●	●	●																										
	SNMG150612-RM	1.2									●	●	●																										
	SNMG150616-RM	1.6									●	●	●																										
	SNMG190612-RM	1.2									●	●	●																										
Rough Cutting	**SNMG190616-RM**	1.6									●	●	●																										

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
P	Steel		●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
M	Stainless Steel										○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
K	Cast Iron																●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
N	Non-ferrous Metal																																			◐		
S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
RK	SNMG120408-RK	0.8															●	●																					
	SNMG120412-RK	1.2															●	●																					
	SNMG120416-RK	1.6															●	●																					C012 –015 E014 E035
	SNMG150612-RK	1.2															●	●																					
	SNMG150616-RK	1.6															●	●																					
	SNMG190612-RK	1.2															●	●																					
Rough Cutting	SNMG190616-RK	1.6															●	●																					
RS	SNMG120408-RS	0.8																					●	●														●	
	SNMG120412-RS	1.2																					●	●														●	
	SNMG120416-RS	1.6																					●															●	C012 –015 E014 E035
	SNMG150616-RS	1.6																					●															●	
	NEW SNMG190612-RS	1.2																					●																
Rough Cutting	SNMG190616-RS	1.6																					●															●	
GH	SNMG120408-GH	0.8	●	●	▲									▲	●				●	●																			
	SNMG120412-GH	1.2	●	●	▲									▲	●				●	●																			
	SNMG120416-GH	1.6	●	●											●																								C012 –015 E014 E035
	SNMG150612-GH	1.2	●	●																																			
	SNMG150616-GH	1.6		●																																			
	SNMG190612-GH	1.2	●	●											●																								
Rough Cutting	SNMG190616-GH	1.6	●	●										▲	●																								
HX	SNMM120408-HX	0.8					●	●																															
	SNMM120412-HX	1.2					●	●																															
	SNMM150612-HX	1.2					●	●																															C012 –015 E014 E035
	SNMM190612-HX	1.2		●	▲		●	●	●																														
	SNMM190616-HX	1.6		●	▲		●	●	●																														
	SNMM190624-HX	2.4		●	▲		●	●	●																														
	SNMM250724-HX	2.4		●	▲		●	●	●																														
Heavy Cutting	SNMM250924-HX	2.4		●	▲		●	●	●																														
HL	SNMM120408-HL	0.8					●	●							●																								
	SNMM120412-HL	1.2					●	●							●																								C012 –015 E014 E035
	SNMM150612-HL	1.2					●	●							●																								
	SNMM190612-HL	1.2					●	●							●																								
	SNMM190616-HL	1.6					●	●							●																								
Heavy Cutting	SNMM190624-HL	2.4					●	●							●																								
HR	SNMM250724-HR	2.4					●	●																															–
	SNMM250924-HR	2.4					●	●																															
Heavy Cutting																																							
HV	SNMM190616-HV	1.6		●	▲		●	●	●																														C012 –014
	SNMM190624-HV	2.4		●	▲		●	●	●																														
	SNMM250724-HV	2.4		●	▲		●	●	●																														
	SNMM250924-HV	2.4		●	▲		●	●	●																														
Heavy Cutting																																							

● = NEW

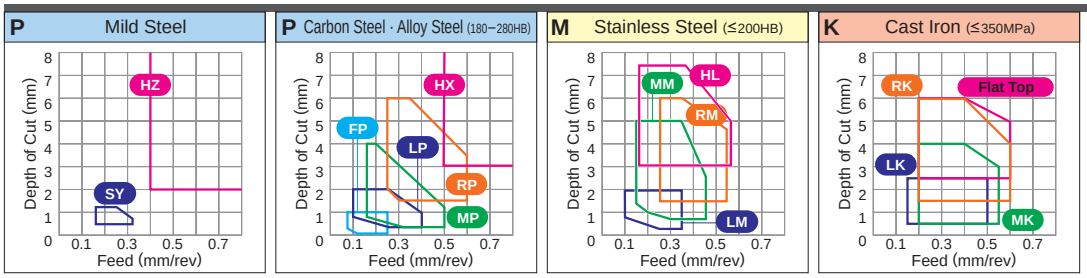
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

90° SN TYPE INSERTS WITH HOLE

SNMM 12 04 08- HZ
Size / Thickness / Corner Radius / Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
HZ Heavy Cutting	**SNMM120408-HZ**	0.8		●	▲		●	●																														
	SNMM120412-HZ	1.2		●	▲		●	●																														C012 –015 E014 E035
	SNMM150612-HZ	1.2		●	▲																																	
	SNMM190612-HZ	1.2		●	▲				●																													
	SNMM190616-HZ	1.6		●	▲				●																													
HM Heavy Cutting	**SNMM150612-HM**	1.2					●	●							●																							
	SNMM190612-HM	1.2					●	●							●																							
	SNMM190616-HM	1.6					●	●							●																							C012 –014
	SNMM190624-HM	2.4					●	●							●																							
	SNMM250724-HM	2.4					●	●																														
	SNMM250924-HM	2.4					●	●																														
Flat Top	**SNMA090304**	0.4																																	●			
	SNMA090308	0.8															●	●	●	●															●			
	SNMA120408	0.8															●	●	●	●														●	●	●			
	SNMA120412	1.2															●	●	●	●																●			C012 –015 E014 E035
	SNMA120416	1.6															●	●	●	●																			
	SNMA150612	1.2															●	●																					
	SNMA150616	1.6															●	●																					
	SNMA190612	1.2															●	●	●	●																			
	SNMA190616	1.6															●	●	●	●																			
Flat Top	**SNGA090304**	0.4																											●										
	SNGA120404	0.4																																		●			C012 –015 E014 E035
	SNGA120408	0.8																											●						●	●			

● = NEW

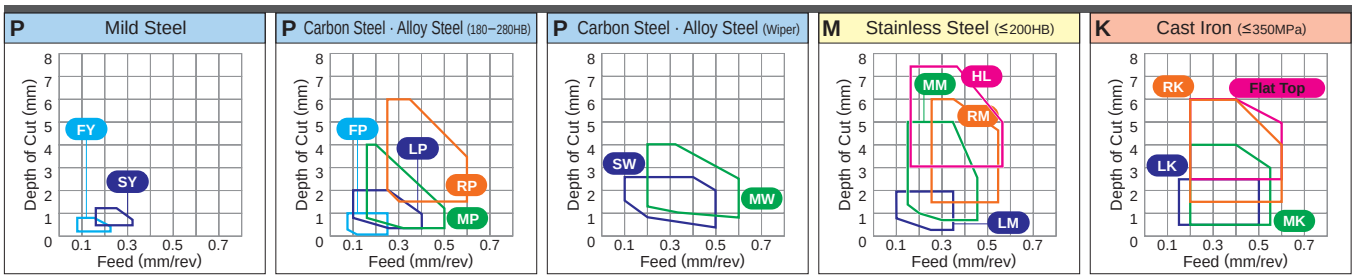
● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

60° TN TYPE INSERTS WITH HOLE

TNMG 16 04 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
FP	TNMG160402-FP	0.2				●	●																						●		●								C016
	TNMG160404-FP	0.4				●	●																						●		●								C017
	TNMG160408-FP	0.8				●	●																						●		●								E014
	NEW TNMG160412-FP	1.2				●	●																						●		●								E035
Finish Cutting																																							E040
FH	TNMG110304-FH	0.4																											●										C016
	TNMG160402-FH	0.2		●	▲																								●	●	●								C017
	TNMG160404-FH	0.4		●																									●	●	●	●							E014
	TNMG160408-FH	0.8		●	▲																								●	●	●	●							E035
Finish Cutting																																							E040
FS	TNMG160404-FS	0.4			▲																								●										C016
	TNMG160408-FS	0.8			▲																								●										C017
																																							E014
																																							E035
Finish Cutting																																							E040
FY	TNMG160404-FY	0.4			▲																								●	●	●		●						C016
	TNMG160408-FY	0.8			▲																								●		●		●						C017
																																							E014
																																							E035
Finish Cutting																																							E040
PK	TNGG160404-PK	0.4																											●										C016
	TNGG160408-PK	0.8																											●										C017
																																							E014
																																							E035
Finish Cutting																																							E040
R/L-FS	TNGG160402R-FS	0.2								●																			●										C016
	TNGG160402L-FS	0.2								●																			●										C017
	TNGG160404R-FS	0.4								●																			●										E014
	TNGG160404L-FS	0.4								●																			●										E035
	NEW TNGG160408R-FS	0.8								●																													E040
Finish Cutting	NEW TNGG160408L-FS	0.8								●																													

● = NEW

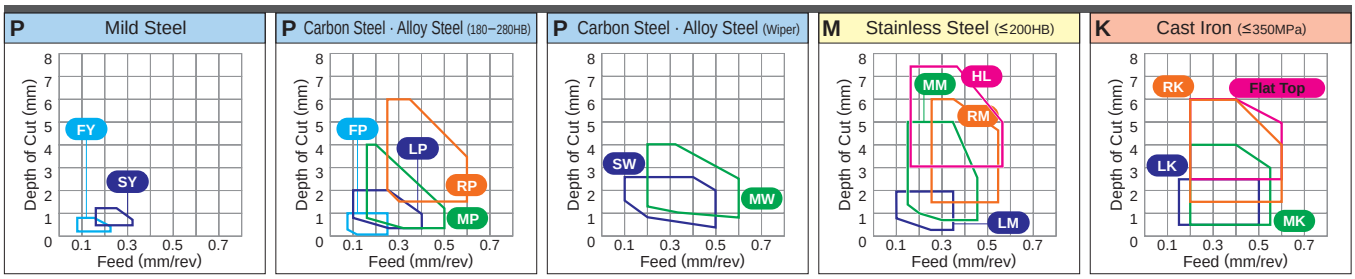
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TN TYPE INSERTS WITH HOLE

TNGG 16 04 02 R- F
Size / Thickness / Corner Radius / R/L / Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					
	P	Steel	●	◐	✣	◐	✣	✣	✣	●															✣	✣	●	◐	◐	●	●	✣					
	M	Stainless Steel									○	◐	✣	○	✣									◐	✣	✣	○			○	○	✣					
	K	Cast Iron															●	◐	●	◐	●			◐	✣		●			●	●	✣	●	◐			
	N	Non-ferrous Metal																																◐			
	S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	✣	●	◐	✣								◐	◐	◐	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
R/L-F Finish Cutting	TNGG160402R-F	0.2																									●		●	●	●								C016 C017 E014 E035 E040
	TNGG160402L-F	0.2																									●		●	●	●								
	TNGG160404R-F	0.4																									●		●	●	●								
	TNGG160404L-F	0.4																									●		●	●	●								
	TNGG160408R-F	0.8																									●		●	●	●								
	TNGG160408L-F	0.8																									●		●	●	●								
LP Light Cutting	TNMG160404-LP	0.4	●	●		●	●	●																							●								C016 C017 E014 E035 E040
	TNMG160408-LP	0.8	●	●		●	●	●																							●								
	TNMG160412-LP	1.2	●	●		●	●	●																							●								
	TNMG220408-LP	0.8	●	●		●	●	●																							●								
	TNMG220412-LP	1.2	●	●		●	●	●																															
LM Light Cutting	TNMG160404-LM	0.4									●	●	●																										C016 C017 E014 E035 E040
	TNMG160408-LM	0.8									●	●	●																										
	TNMG160412-LM	1.2									●	●	●																										
LK Light Cutting	TNMG160404-LK	0.4															●	●																					C016 C017 E014 E035 E040
	TNMG160408-LK	0.8															●	●																					
	TNMG160412-LK	1.2															●	●																					
LS Light Cutting	NEW TNMG160402-LS	0.2																				●	●	●														●	C016 C017 E014 E035 E040
	TNMG160404-LS	0.4																				●	●	●														●	
	TNMG160408-LS	0.8																				●	●	●														●	
SH Light Cutting	TNMG160404-SH	0.4	●	●	▲	●	●								●				●								●	●		●								C016 C017 E014 E035 E040
	TNMG160408-SH	0.8	●	●	▲	●	●								●				●								●	●		●									
	TNMG220408-SH	0.8	●	●											●																								
SA Light Cutting	TNMG160404-SA	0.4	●	●	▲	●	●																						●	●									C016 C017 E014 E035 E040
	TNMG160408-SA	0.8	●	●	▲	●	●																						●	●									
	TNMG160412-SA	1.2	●	●	▲																									●									
	TNMG220408-SA	0.8	●	●	▲																																		
	TNMG220412-SA	1.2		●																																			

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
			Coated																										Cermet		Coated Cermet			Carbide				
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠										◐	✠	✠		○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
* SW Light Cutting (Wiper)	TNMX160404-SW	0.4	●	●		●								▲															●	●	●								C017
	TNMX160408-SW	0.8	●	●		●								▲															●	●	●								
SY Light Cutting	TNMG160404-SY	0.4			▲																								●	●	●		●						C016 C017 E014 E035 E040
	TNMG160408-SY	0.8			▲																								●		●		●						
C Light Cutting	TNMG160404-C	0.4																											▲	▲									C016 C017 E014 E035 E040
	TNMG160408-C	0.8																											▲	▲									
	TNMG220404-C	0.4																											▲	▲									
	TNMG220408-C	0.8																												▲									
MJ Light Cutting	TNMG160404-MJ	0.4														●						●	●		●	●											●		C016 C017 E014 E035 E040
	TNMG160408-MJ	0.8														●						●	●		●	●												●	
	TNMG160412-MJ	1.2														●						●	●		●	●													
R/L-1G Light Cutting	TNMG160404R-1G	0.4																											●										C016 C017 E014 E035 E040
	TNMG160404L-1G	0.4																											●										
	TNMG220404R-1G	0.4																											●										
	TNMG220404L-1G	0.4																											●										
R/L-K Light Cutting	TNGG160402R-K	0.2																											●	●	●								C016 C017 E014 E035 E040
	TNGG160402L-K	0.2																											●	●	●								
	TNGG160404R-K	0.4																											●	●	●								
	TNGG160404L-K	0.4																												●	●								
	TNGG160408R-K	0.8																													●								
	TNGG160408L-K	0.8																													●								
MP Medium Cutting	TNMG160404-MP	0.4	●	●	▲	●	●	●												●											●								C016 C017 E014 E035 E040
	TNMG160408-MP	0.8	●	●	▲	●	●	●												●											●								
	TNMG160412-MP	1.2	●	●	▲	●	●	●												●											●								
	TNMG220408-MP	0.8	●	●	▲	●	●	●												●																			
	TNMG220412-MP	1.2	●	●	▲	●	●	●												●																			
MM Medium Cutting	TNMG160408-MM	0.8									●	●	●																										C016 C017 E014 E035 E040
	TNMG160412-MM	1.2									●	●	●																										
	TNMG220408-MM	0.8									●	●	●																										
	TNMG220412-MM	1.2									●	●	●																										
	TNMG220416-MM	1.6									●	●	●																										
MK Medium Cutting	TNMG160404-MK	0.4															●	●																					C016 C017 E014 E035 E040
	TNMG160408-MK	0.8															●	●																					
	TNMG160412-MK	1.2															●	●																					
	TNMG220408-MK	0.8															●	●																					
	TNMG220412-MK	1.2															●	●																					
	TNMG220416-MK	1.6															●	●																					

* Please refer to A028 before using the SW breaker (wiper insert).

● = NEW

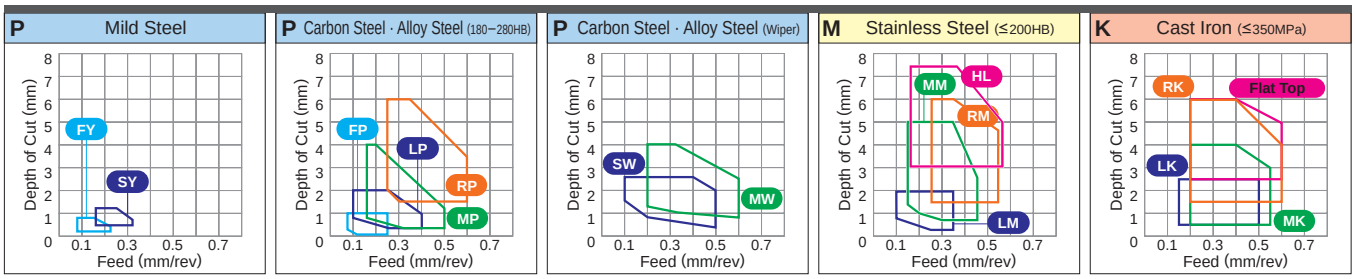
CHIP BREAKERS ➤ A042 GRADES ➤ A030 IDENTIFICATION ➤ A002

60° TN TYPE INSERTS WITH HOLE

TNMG 16 04 04-MS
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
* MS	TNMG160404-MS	0.4																				●	●															●	C016
	TNMG160408-MS	0.8																				●	●	●														●	C017
	TNMG160412-MS	1.2																				●	●	●														●	E014
	TNMG220408-MS	0.8																				●	●															●	E035
Medium Cutting	TNMG220412-MS	1.2																				●	●															●	E040
MS	TNMG160404-MS	0.4		●										▲	●	●									●	●	●							●					C016
	TNMG160408-MS	0.8		●	▲									▲	●	●									●	●	●	●		●							●		C017
	TNMG160412-MS	1.2		●											●	●									●	●													E014
	TNMG220408-MS	0.8		●										▲	●	●									●	●	●	●											E035
Medium Cutting	TNMG220412-MS	1.2													●																								E040
GK	TNMG160404-GK	0.4															●	●																					C016
	TNMG160408-GK	0.8															●	●																					C017
	TNMG160412-GK	1.2															●	●			●																		E014
	TNMG220408-GK	0.8															●	●																					E035
Medium Cutting	TNMG220412-GK	1.2															●	●																					E040
GM	TNMG160404-GM	0.4									●	●	●																										C016
	TNMG160408-GM	0.8									●	●	●																										C017
	TNMG160412-GM	1.2									●	●	●																										E014
	TNMG220408-GM	0.8									●	●	●																										E035
Medium Cutting	TNMG220412-GM	1.2									●	●	●																										E040
MA	TNMG160404-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●	●	●			●	●			●			●									C016
	TNMG160408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●	●			●			●									C017
	TNMG160412-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●		●			●				●			●									E014
	TNMG160416-MA	1.6																		●																			E035
	TNMG220408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●				●												E040
	TNMG220412-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●		●			●				●												
	TNMG220416-MA	1.6																		●			●																
	TNMG270608-MA	0.8	●	●	▲																																		
	TNMG270612-MA	1.2	●	●	▲										●																								
	NEW TNMG270616-MA	1.6																					●																
Medium Cutting	NEW TNMG330924-MA	2.4																					●																
MH	TNMG160404-MH	0.4	●	●	▲									▲						●																			C016
	TNMG160408-MH	0.8	●	●	▲	●	●	●						▲						●																			C017
	TNMG160412-MH	1.2	●	●	▲	●	●	●												●																			E014
	TNMG220408-MH	0.8	●	●	▲	●	●	●						▲						●																			E035
Medium Cutting	TNMG220412-MH	1.2	●	●	▲	●	●	●												●																			E040

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐
Shape	Order Number	RE (mm)	Coated																										Cermet		Coated Cermet			Carbide					Applicable Holder Page
Standard	**TNMG110304**	0.4		●	▲	●	●																											●		●			
	TNMG110308	0.8		●	▲	●	●																																
	TNMG160304	0.4		●		●	●																											●					
	TNMG160308	0.8		●	▲	●	●																											●					
	TNMG160404	0.4	●	●	▲	●	●												●	●							●		●	●	●			●	●	●			
	TNMG160408	0.8	●	●	▲	●	●	●											●	●							●		●	●	●			●	●	●			
	TNMG160412	1.2	●	●	▲	●	●	●											●	●									●										C016
	TNMG160416	1.6		●		●	●	●												●									●										C017
	TNMG220404	0.4	●	●	▲	●	●	●																						●				●					E014
	TNMG220408	0.8	●	●	▲	●	●	●												●									●	●				●					E035
	TNMG220412	1.2	●	●	▲	●	●	●												●																			E040
	TNMG220416	1.6		●	▲	●	●	●																															
	TNMG270608	0.8		●		●	●	●																															
	TNMG270612	1.2		●	▲	●	●	●																										●					
	TNMG270616	1.6		●	▲																																		
Medium Cutting	**TNMG330924**	2.4																																●					
*** MW**	**TNMX160408-MW**	0.8	●	●		●								▲			●	●		●																			
	TNMX160412-MW	1.2	●	●		●								▲			●	●	●	●																			
Medium Cutting (Wiper)																																							C017
R/L-ES	**TNMG160404R-ES**	0.4												▲	●																								
	TNMG160404L-ES	0.4												▲	●																								C016
	TNMG160408R-ES	0.8												▲	●																								C017
	TNMG160408L-ES	0.8												▲	●																								E014
	TNMG220408R-ES	0.8													●																								E035
Medium Cutting	**TNMG220408L-ES**	0.8													●																								E040
R/L-2G	**TNMG160404R-2G**	0.4																											●										
	TNMG160404L-2G	0.4																											●										C016
	TNMG160408R-2G	0.8																											●										C017
	TNMG160408L-2G	0.8																											●										E014
Medium Cutting																																							E035
																																							E040
R/L	**TNGG110302R**	0.2																												●									
	TNGG110302L	0.2																											●	●									
	TNGG110304R	0.4																											●	●									
	TNGG110304L	0.4																											●	●									
	TNGG110308R	0.8																												●									C016
	TNGG110308L	0.8																											●	●									C017
	TNGG160304R	0.4																											●	●				●					E014
	TNGG160304L	0.4																											●	●									E035
	TNGG160402R	0.2																											●	●	●			●		●			E040
	TNGG160402L	0.2																											●	●	●								
	TNGG160404R	0.4																											●	●	●			●	●	●			
Medium Cutting	**TNGG160404L**	0.4																											●	●	●			●		●			

* Please refer to A028 before using the MW breaker (wiper insert).

● = NEW

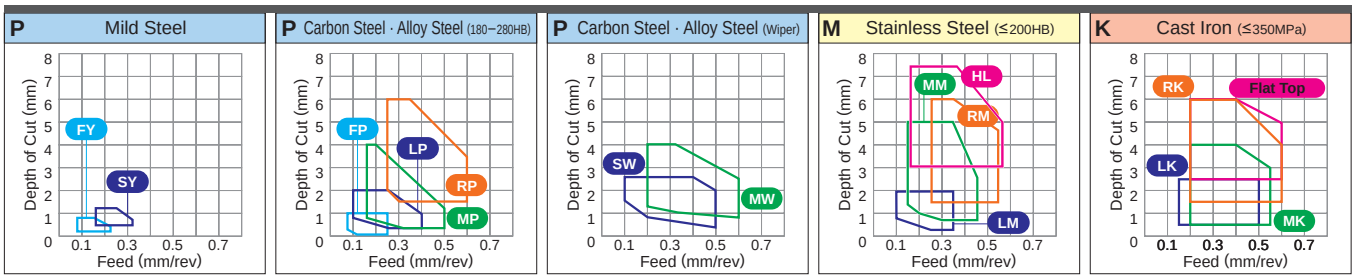
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TN TYPE INSERTS WITH HOLE

TNGG 16 04 08 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
R/L	TNGG160408R	0.8																										●	●	●			●	●	●			
	TNGG160408L	0.8																										●	●	●			●	●	●			C016
	TNGG220404R	0.4																										●	●				●					C017
	TNGG220404L	0.4																										●	●				●					E014
	TNGG220408R	0.8																										●	●				●					E035
Medium Cutting	TNGG220408L	0.8																										●	●				●					E040
RP	TNMG160408-RP	0.8	●	●		●	●	●																														
	TNMG160412-RP	1.2	●	●		●	●	●																														C016
	TNMG220408-RP	0.8	●	●		●	●	●																														C017
	TNMG220412-RP	1.2	●	●		●	●	●																														E014
	TNMG220416-RP	1.6	●	●		●	●	●																														E035
	TNMG270612-RP	1.2	●	●		●	●	●																														E040
Rough Cutting	TNMG270616-RP	1.6	●	●		●	●	●																														
RM	TNMG160408-RM	0.8									●	●	●																									
	TNMG160412-RM	1.2									●	●	●																									C016
	TNMG220408-RM	0.8									●	●	●																									C017
	TNMG220412-RM	1.2									●	●	●																									E014
Rough Cutting	TNMG220416-RM	1.6									●	●	●																									E035
																																						E040
RK	TNMG160408-RK	0.8															●	●																				
	TNMG160412-RK	1.2															●	●																				C016
	TNMG160416-RK	1.6															●	●																				C017
	TNMG220408-RK	0.8															●	●																				E014
	TNMG220412-RK	1.2															●	●																				E035
Rough Cutting	TNMG220416-RK	1.6															●	●																				E040
RS	TNMG160408-RS	0.8																					●	●													●	
	TNMG160412-RS	1.2																					●	●													●	C016
	TNMG220408-RS	0.8																					●														●	C017
	TNMG220412-RS	1.2																					●														●	E014
Rough Cutting																																						E035
																																						E040
GH	TNMG160408-GH	0.8	●	●	▲									▲	●			●	●																			
	TNMG160412-GH	1.2	●	●															●																			C016
	TNMG220408-GH	0.8	●	●	▲										●				●																			C017
	TNMG220412-GH	1.2	●	●	▲										●			●	●																			E014
	TNMG220416-GH	1.6	●	●																																		E035
	TNMG270612-GH	1.2	●	●	▲										●																							E040
Rough Cutting	TNMG270616-GH	1.6	●	●																																		

● = NEW

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(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	Applicable Holder Page
HL Heavy Cutting	**TNMM160408-HL**	0.8	C016
	TNMM160412-HL	1.2	C017
	TNMM220408-HL	0.8	E014
	TNMM220412-HL	1.2	E035
	TNMM220416-HL	1.6	E040
HZ Heavy Cutting	**TNMM160408-HZ**	0.8	C016
	TNMM160412-HZ	1.2	C017
	TNMM220408-HZ	0.8	E014
	TNMM220412-HZ	1.2	E035
	TNMM220416-HZ	1.6	E040
Flat Top	**TNMA160404**	0.4	C016 C017 E014 E035 E040
	TNMA160408	0.8	
	TNMA160412	1.2	
	TNMA160416	1.6	
	TNMA160420	2.0	
	TNMA220404	0.4	
	TNMA220408	0.8	
	TNMA220412	1.2	
	TNMA220416	1.6	
Flat Top	**TNGA110304**	0.4	C016 C017 E014 E035 E040
	TNGA110308	0.8	
	TNGA160402	0.2	
	TNGA160404	0.4	
	TNGA160408	0.8	
	TNGA220404	0.4	
	TNGA220408	0.8	

Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
TNMM160408-HL	0.8					●	●							●																								
TNMM160412-HL	1.2					●	●							●																								
TNMM220408-HL	0.8					●	●							●																								
TNMM220412-HL	1.2					●	●							●																								
TNMM220416-HL	1.6					●	●							●																								
TNMM160408-HZ	0.8		●	▲		●	●																															
TNMM160412-HZ	1.2					●	●																															
TNMM220408-HZ	0.8		●	▲																																		
TNMM220412-HZ	1.2		●	▲																																		
TNMM220416-HZ	1.6		●	▲																																		
TNMA160404	0.4															●	●	●	●															●	●			
TNMA160408	0.8															●	●	●	●														●	●	●			
TNMA160412	1.2															●	●	●	●																			
TNMA160416	1.6															●	●		●																			
TNMA160420	2.0															●	●																					
TNMA220404	0.4																																		●			
TNMA220408	0.8															●	●	●	●									●					●		●			
TNMA220412	1.2															●	●	●	●																			
TNMA220416	1.6															●	●	●	●														●					
TNGA110304	0.4																																		●			
TNGA110308	0.8																											●							●			
TNGA160402	0.2																											●							●			
TNGA160404	0.4																																●	●	●			
TNGA160408	0.8																																	●	●			
TNGA220404	0.4																																●					
TNGA220408	0.8																																	●				

● = NEW

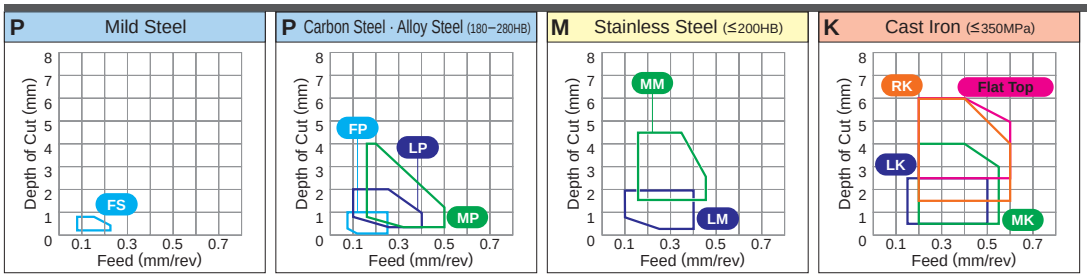
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VN TYPE INSERTS WITH HOLE

VNMG 16 04 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
FP Finish Cutting	VNMG160402-FP	0.2				●	●																						●		●								C018 –020 E015 E042
	VNMG160404-FP	0.4				●	●																						●		●								
	VNMG160408-FP	0.8				●	●																						●		●								
	NEW VNMG160412-FP	1.2				●	●																						●		●								
FH Finish Cutting	VNMG160402-FH	0.2		●	▲																								●	●	●								C018 –020 E015 E042
	VNMG160404-FH	0.4		●	▲																								●		●	●							
	VNMG160408-FH	0.8		●	▲																								●	●	●	●							
FS Finish Cutting	VNMG160404-FS	0.4			▲																								●										C018 –020 E015 E042
	VNMG160408-FS	0.8			▲																								●										
FJ Finish Cutting	VNGG1604V5-FJ	0.05																								●										●		C018 –020 E015 E042
	VNGG160401-FJ	0.1																								●										●		
	VNGG160402-FJ	0.2																								●										●		
R/L-F Finish Cutting	VNGG160402R-F	0.2																									●		●	●	●								C018 –020 E015 E042
	VNGG160402L-F	0.2																									●		●	●	●								
	VNGG160404R-F	0.4																									●		●	●	●								
	VNGG160404L-F	0.4																									●		●	●	●								
LP Light Cutting	VNMG160404-LP	0.4	●	●		●	●	●																							●								C018 –020 E015 E042
	VNMG160408-LP	0.8	●	●		●	●	●																							●								
LM Light Cutting	VNMG160404-LM	0.4									●	●	●																										C018 –020 E015 E042
	VNMG160408-LM	0.8									●	●	●																										

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																									Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
LK	VNMG160404-LK	0.4															●	●																					
	VNMG160408-LK	0.8															●	●																					C018 –020 E015 E042
Light Cutting																																							
LS	NEW VNMG160402-LS	0.2																				●	●	●														●	
	VNMG160404-LS	0.4																				●	●	●														●	C018 –020 E015 E042
	VNMG160408-LS	0.8																				●	●	●														●	
Light Cutting																																							
SH	VNMG160404-SH	0.4	●	●	▲	●	●																						●	●		●							
	VNMG160408-SH	0.8	●	●	▲	●	●																						●	●		●							C018 –020 E015 E042
Light Cutting																																							
SA	VNMG160404-SA	0.4				●	●																						●										
	VNMG160408-SA	0.8				●	●																						●										C018 –020 E015 E042
Light Cutting																																							
MJ	VNMG160404-MJ	0.4														●						●	●		●	●											●	
	VNMG160408-MJ	0.8														●						●	●		●	●											●	C018 –020 E015 E042
	VNMG160412-MJ	1.2														●						●	●		●	●												
Light Cutting																																							
MJ	VNGM160404-MJ	0.4																								●											●	
	VNGM160408-MJ	0.8																								●											●	C018 –020 E015 E042
Light Cutting																																							
MP	VNMG160404-MP	0.4	●	●	▲	●	●	●												●											●								
	VNMG160408-MP	0.8	●	●	▲	●	●	●												●											●								C018 –020 E015 E042
	VNMG160412-MP	1.2	●	●	▲	●	●	●												●																			
Medium Cutting																																							
MM	VNMG160408-MM	0.8									●	●	●																										
																																							C018 –020 E015 E042
Medium Cutting																																							
MK	VNMG160404-MK	0.4															●	●																					
	VNMG160408-MK	0.8															●	●			●																		C018 –020 E015 E042
	VNMG160412-MK	1.2															●	●																					
Medium Cutting																																							

● = NEW

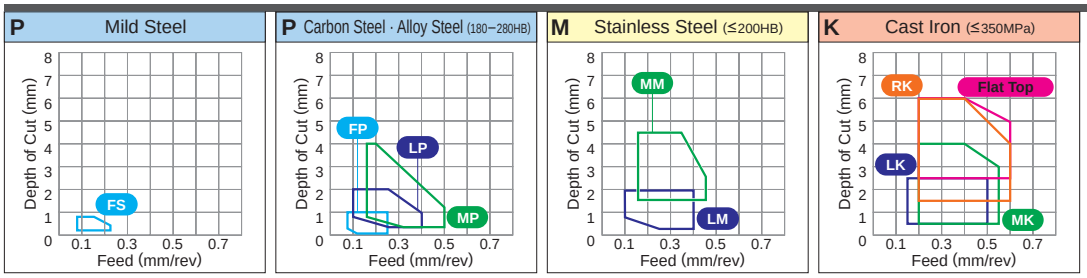
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VN TYPE INSERTS WITH HOLE

VNMG 16 04 04- MS
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
* MS	VNMG160404-MS	0.4																				●	●	●														●	
	VNMG160408-MS	0.8																				●	●	●														●	C018 –020 E015 E042
Medium Cutting																																							
MS	VNMG160404-MS	0.4		●										▲	●	●									●	●		●											
	VNMG160408-MS	0.8		●										▲	●	●									●	●				●							●		C018 –020 E015 E042
Medium Cutting																																							
GK	VNMG160404-GK	0.4															●	●																					
	VNMG160408-GK	0.8															●	●																					C018 –020 E015 E042
	VNMG160412-GK	1.2															●	●																					
Medium Cutting																																							
GM	VNMG160404-GM	0.4									●	●	●																										
	VNMG160408-GM	0.8									●	●	●																										C018 –020 E015 E042
Medium Cutting																																							
MA	VNMG160404-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●	●	●							●												
	VNMG160408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●							●												C018 –020 E015 E042
Medium Cutting																																							
MH	VNMG160404-MH	0.4	●	●	▲															●																			
	VNMG160408-MH	0.8	●	●	▲	●	●	●						▲						●																			C018 –020 E015 E042
Medium Cutting																																							
Standard	VNMG160404	0.4	●	●	▲	●	●											●	●								●		●	●	●		●		●			
	VNMG160408	0.8	●	●	▲	●	●	●										●	●								●		●	●	●		●		●			C018 –020 E015 E042
	VNMG160412	1.2	●	●		●	●	●										●	●										●									
Medium Cutting																																							

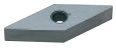
* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
			Coated																										Cermet		Coated Cermet			Carbide				
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠				
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠				
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐

Shape	Order Number	RE (mm)	Applicable Holder Page
R/L Medium Cutting	**VNGG160404R**	0.4	C018 –020 E015 E042
	VNGG160404L	0.4	
Flat Top	**VNMA160404**	0.4	C018 –020 E015 E042
	VNMA160408	0.8	
	VNMA160412	1.2	
Flat Top 	**VNGA160404**	0.4	C018 –020 E015 E042
	VNGA160408	0.8	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
R/L	**VNGG160404R**	0.4																											●	●				●		●		
	VNGG160404L	0.4																											●	●				●				
Flat Top	**VNMA160404**	0.4															●	●																				
	VNMA160408	0.8															●	●																				
	VNMA160412	1.2															●	●																				
Flat Top	**VNGA160404**	0.4																																	●	●		
	VNGA160408	0.8																																	●	●		

● = NEW

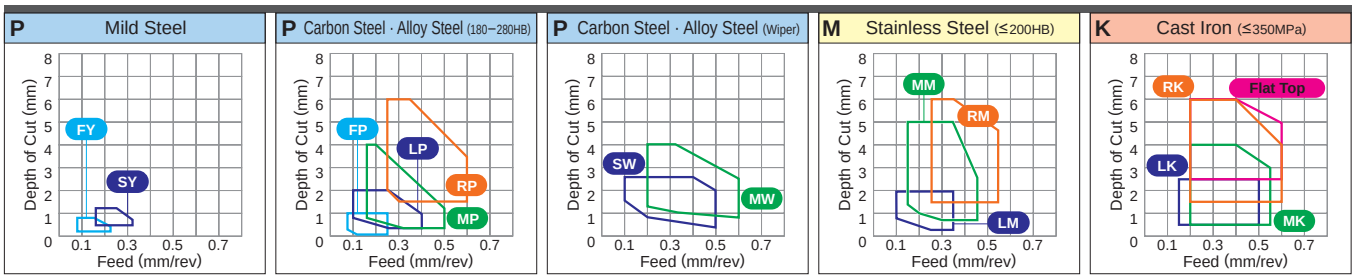
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° WN TYPE INSERTS WITH HOLE

WNMG 08 04 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

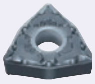
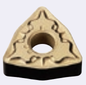
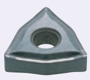
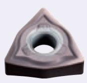
Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																									Cermet		Coated Cermet			Carbide						Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
FP	WNMG080402-FP	0.2				●	●																						●		●								
	WNMG080404-FP	0.4				●	●																						●		●								C021
	WNMG080408-FP	0.8				●	●																						●		●								E015
Finish Cutting	NEW WNMG080412-FP	1.2				●	●																						●		●								E039
FH	WNMG080404-FH	0.4		●																									●		●								
	WNMG080408-FH	0.8		●																									●		●	●							C021
Finish Cutting																																							E015 E039
FS	WNMG080404-FS	0.4			▲																								●										
	WNMG080408-FS	0.8			▲																								●										C021
Finish Cutting																																							E015 E039
FY	WNMG080404-FY	0.4																											●		●								
	WNMG080408-FY	0.8			▲																								●		●		●						C021
Finish Cutting																																							E015 E039
LP	WNMG060404-LP	0.4	●	●		●	●	●																							●								
	WNMG060408-LP	0.8	●	●		●	●	●																							●								
	WNMG06T304-LP	0.4	●	●		●	●	●																							●								C021
	WNMG06T308-LP	0.8	●	●		●	●	●																							●								E015
	WNMG080404-LP	0.4	●	●		●	●	●																							●								E037
	WNMG080408-LP	0.8	●	●		●	●	●																							●								E039
Light Cutting	WNMG080412-LP	1.2	●	●		●	●	●																															
LM	WNMG060404-LM	0.4									●	●	●																										
	WNMG060408-LM	0.8									●	●	●																										C021
	WNMG080404-LM	0.4									●	●	●																										E015
	WNMG080408-LM	0.8									●	●	●																										E039
Light Cutting																																							

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	Applicable Holder Page
			Coated																										Cermet		Coated Cermet			Carbide					
Work Material	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣					
	M	Stainless Steel									●	◐	✣	●	✣											◐	✣	✣	●			●	●	✣					
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐			
	N	Non-ferrous Metal																																		◐			
	S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	✣	●	◐	✣									◐	◐	◐	
LK	WNMG080404-LK	0.4															●	●																					C021 E015 E039
	WNMG080408-LK	0.8															●	●			●																		
Light Cutting	WNMG080412-LK	1.2															●	●			●																		
LS	NEW WNMG080402-LS	0.2																				●	●															●	C021 E015 E039
	WNMG080404-LS	0.4																				●	●	●														●	
Light Cutting	WNMG080408-LS	0.8																				●	●	●														●	
SH	WNMG06T304-SH	0.4	●	●											●																								C021 E015 E037 E039
	WNMG06T308-SH	0.8	●	●											●																								
	WNMG060404-SH	0.4	●	●											●																								
	WNMG060408-SH	0.8	●	●											●																								
	WNMG080404-SH	0.4	●	●		●	●								●					●									●										
	WNMG080408-SH	0.8	●	●	▲	●	●								●					●									●										
Light Cutting	WNMG080412-SH	1.2	●	●	▲	●	●								●					●																			
SA	WNMG080404-SA	0.4	●	●	▲	●	●																						●	●									C021 E015 E039
	WNMG080408-SA	0.8	●	●	▲	●	●																						●	●									
Light Cutting	WNMG080412-SA	1.2	●	●	▲	●	●																							●									
* SW	WNMG060404-SW	0.4	●	●		●								▲															●		●								C021 E015 E039
	WNMG060408-SW	0.8	●	●		●								▲															●		●								
Light Cutting	WNMG080404-SW	0.4	●	●		●								▲			●	●		●									●	●	●								
(Wiper)	WNMG080408-SW	0.8	●	●		●								▲			●	●		●									●	●	●								
	WNMG080412-SW	1.2	●	●		●								▲															●	●	●								
SY	WNMG080404-SY	0.4																											●		●								C021 E015 E039
Light Cutting	WNMG080408-SY	0.8			▲																								●	●	●		●						
C	WNMG080404-C	0.4																											▲	▲									C021 E015 E039
 Light Cutting	WNMG080408-C	0.8																												▲									
MJ	WNMG080408-MJ	0.8														●						●	●		●	●													C021 E015 E039
	WNMG080412-MJ	1.2														●						●	●		●	●													
Light Cutting	WNMG080416-MJ	1.6														●						●	●		●	●													

* Please refer to A028 before using the SW breaker (wiper insert).

● = NEW

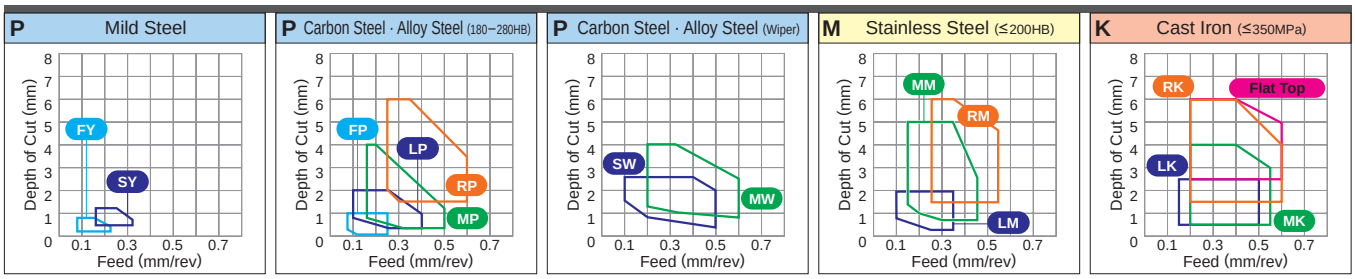
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° WN TYPE INSERTS WITH HOLE

WNMG 06 04 04- MP
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	MP9025 (NEW)	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015
	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣				
	M	Stainless Steel									○	◐	✣	○	✣											◐	✣	✣	○			○	○	✣				
	K	Cast Iron															●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐		
	N	Non-ferrous Metal																																		◐		
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐
Shape	Order Number	RE (mm)	Coated																										Cermet		Coated Cermet			Carbide					Applicable Holder Page
MP	WNMG060404-MP	0.4	●	●	▲	●	●	●												●																			C021 E015 E037 E039
	WNMG060408-MP	0.8	●	●	▲	●	●	●												●																			
	WNMG060412-MP	1.2	●	●	▲	●	●	●												●																			
	WNMG06T304-MP	0.4	●	●	▲	●	●	●												●																			
	WNMG06T308-MP	0.8	●	●	▲	●	●	●												●																			
	WNMG06T312-MP	1.2	●	●	▲	●	●	●												●																			
	WNMG080404-MP	0.4	●	●	▲	●	●	●												●											●							
	WNMG080408-MP	0.8	●	●	▲	●	●	●												●											●							
	WNMG080412-MP	1.2	●	●	▲	●	●	●												●											●							
Medium Cutting	WNMG080416-MP	1.6	●	●	▲	●	●	●												●																			
MM	WNMG060408-MM	0.8									●	●	●																										C021 E015 E039
	WNMG060412-MM	1.2									●	●	●																										
	WNMG080408-MM	0.8									●	●	●																										
	WNMG080412-MM	1.2									●	●	●																										
Medium Cutting																																							
MK	WNMG080404-MK	0.4															●	●																					C021 E015 E039
	WNMG080408-MK	0.8															●	●																					
	WNMG080412-MK	1.2															●	●																					
	WNMG080416-MK	1.6															●	●																					
Medium Cutting																																							
* MS	WNMG080404-MS	0.4																				●	●	●														●	C021 E015 E039
	WNMG080408-MS	0.8																				●	●	●														●	
	WNMG080412-MS	1.2																				●	●	●														●	
Medium Cutting																																							
MS	WNMG060404-MS	0.4		●										▲	●																								C021 E015 E037 E039
	WNMG060408-MS	0.8		●										▲	●																								
	WNMG06T304-MS	0.4		●										▲	●																								
	WNMG06T308-MS	0.8		●										▲	●																								
	WNMG080404-MS	0.4		●	▲									▲	●																								
	WNMG080408-MS	0.8		●	▲									▲	●	●									●	●	●										●		
Medium Cutting	WNMG080412-MS	1.2		●											●	●									●	●													

* Newly designed breakers : MP9005, MP9015, MP9025, MT9015

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																									Cermet		Coated Cermet			Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
P	Steel		●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠					
M	Stainless Steel										○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠					
K	Cast Iron																●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐			
N	Non-ferrous Metal																																			◐			
S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	✠	●	◐	✠									◐	◐	◐	
Shape	Order Number	RE (mm)																																					Applicable Holder Page
GK	WNMG060404-GK	0.4															●	●																					
	WNMG060408-GK	0.8															●	●																					C021
	WNMG080404-GK	0.4															●	●																					E015
	WNMG080408-GK	0.8															●	●			●																		E039
Medium Cutting	WNMG080412-GK	1.2															●	●			●																		
GM	WNMG060404-GM	0.4									●	●	●																										
	WNMG060408-GM	0.8									●	●	●																										C021
	WNMG080404-GM	0.4									●	●	●																										E015
	WNMG080408-GM	0.8									●	●	●																										E039
Medium Cutting	WNMG080412-GM	1.2									●	●	●																										
MA	WNMG06T304-MA	0.4	●	●											●																								
	WNMG06T308-MA	0.8	●	●											●																								
	WNMG06T312-MA	1.2	●	●											●																								
	WNMG060404-MA	0.4	●	●		●	●								●																								
	WNMG060408-MA	0.8	●	●		●	●					●	●		●		●	●									●												C021
	WNMG060412-MA	1.2	●	●		●	●					●	●		●		●	●									●												E015 E037
	WNMG080404-MA	0.4	●	●	▲	●	●					●	●	▲	●		●	●		●			●				●			●									E039
	WNMG080408-MA	0.8	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●				●			●									
	WNMG080412-MA	1.2	●	●	▲	●	●	●				●	●	▲	●		●	●	●	●			●				●			●									
	WNMG080416-MA	1.6	●	●																●			●																
Medium Cutting	WNMG100612-MA	1.2			▲																																		
MH	WNMG080404-MH	0.4	●	●	▲																																		
	WNMG080408-MH	0.8	●	●	▲	●	●	●						▲						●																			C021
	WNMG080412-MH	1.2	●	●	▲	●	●	●												●																			E015
Medium Cutting																																							E039
Standard	WNMG080404	0.4	●	●	▲	●	●												●	●									●		●								
	WNMG080408	0.8	●	●	▲	●	●	●											●	●							●		●		●			●					C021
	WNMG080412	1.2	●	●	▲	●	●	●											●	●							●							●					E015
	WNMG080416	1.6																		●																			E039
Medium Cutting																																							
* MW	WNMG060408-MW	0.8	●	●	▲	●	●										●	●	●	●																			
	WNMG060412-MW	1.2	●	●		●	●										●	●	●	●																			C021
	WNMG080408-MW	0.8	●	●	▲	●	●							▲			●	●	●	●																			E015
	WNMG080412-MW	1.2	●	●		●	●							▲			●	●	●	●																			E039
Medium Cutting (Wiper)																																							
RP	WNMG080408-RP	0.8	●	●		●	●	●																															
	WNMG080412-RP	1.2	●	●		●	●	●																															C021
																																							E015
																																							E039
Rough Cutting																																							
RM	WNMG060408-RM	0.8									●	●	●																										
	WNMG060412-RM	1.2									●	●	●																										C021
	WNMG080408-RM	0.8									●	●	●																										E015
	WNMG080412-RM	1.2									●	●	●																										E039
Rough Cutting																																							

* Please refer to A028 before using the MW breaker (wiper insert).

● = NEW

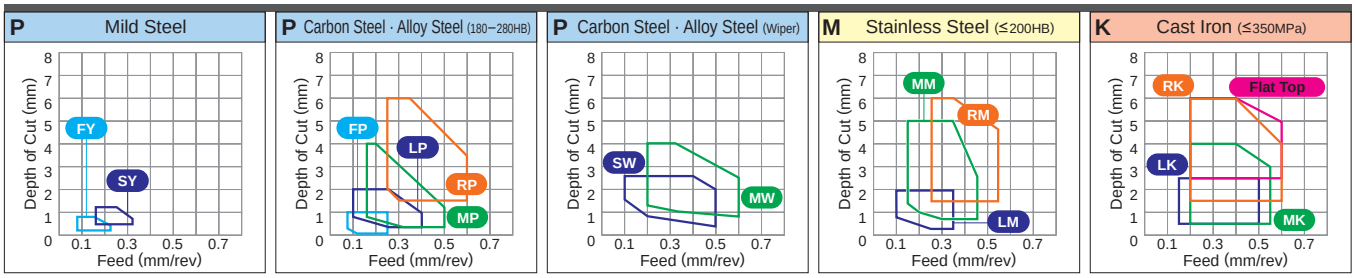
CHIP BREAKERS ➤ A042
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° WN TYPE INSERTS WITH HOLE

WNMG 08 04 08- RK
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
RK Rough Cutting	**WNMG080408-RK**	0.8															●	●																					
	WNMG080412-RK	1.2															●	●			●																		C021
	WNMG080416-RK	1.6															●	●			●																		E015
																																							E039
RS Rough Cutting	**WNMG080408-RS**	0.8																					●	●														●	
	WNMG080412-RS	1.2																					●	●														●	C021
	WNMG080416-RS	1.6																					●															●	E015
	WNMG100612-RS	1.2																					●															●	E039
GH Rough Cutting	**WNMG080408-GH**	0.8	●	●	▲									▲	●				●	●																			
	WNMG080412-GH	1.2	●	●	▲										●				●	●																			C021
																																							E015
																																							E039
GJ Rough Cutting	**WNMG080408-GJ**	0.8														●										●										●		
	WNMG080412-GJ	1.2														●										●										●		C021
	WNMG080416-GJ	1.6														●										●										●		E015
	WNMG100612-GJ	1.2																								●										●		E039
Flat Top	**WNMA060408**	0.8															●	●																					
	WNMA060412	1.2															●	●																					C021
	WNMA080404	0.4															●	●	●	●															●				E015
	WNMA080408	0.8															●	●	●	●															●				E039
	WNMA080412	1.2															●	●	●	●																			
	WNMA080416	1.6															●	●		●																			

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

CHIP BREAKERS ➤ A042

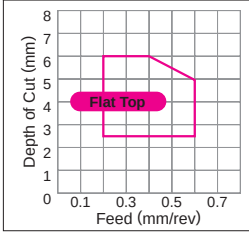
80° CN TYPE INSERTS WITHOUT HOLE

CNMN 12 04 08
Size Thickness Corner Radius
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Heavy Cutting·····

K Cast Iron (≤350MPa)



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
	P	Steel	●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣					
	M	Stainless Steel									○	◐	⊕	○	⊕										◐	⊕	⊕		○			○	○	⊕					
	K	Cast Iron															●	◐	●	◐	◐				◐	✣			●			●	●	✣	●	◐			
	N	Non-ferrous Metal																																		◐			
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✣	●	◐	✣									◐	◐	◐	
Shape	Order Number	RE (mm)																																					
Flat Top	CNMN120408	0.8															●	●																					–
	CNMN120412	1.2															●	●																					
	CNMN120416	1.6															●	●																					

● = NEW

CHIP BREAKERS ➤ A074
GRADES ➤ A030
IDENTIFICATION ➤ A002

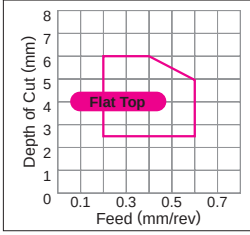
90° SN TYPE INSERTS WITHOUT HOLE

SNMN 12 04 08
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Heavy Cutting·····

K Cast Iron (≤350MPa)



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
P	Steel		●	◐	✣	◐	✣	✣	✣	●																	✣	✣	●	◐	◐	●	●	✣					
M	Stainless Steel										◐	◐	✣	◐	✣											◐	✣	✣	◐			◐	◐	✣					
K	Cast Iron																●	◐	●	◐	◐					◐	✣		●			●	●	✣	●	◐			
N	Non-ferrous Metal																																			◐			
S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	✣	●	◐	✣									◐	◐	◐	
Shape	Order Number	RE (mm)																																					
Flat Top	SNMN120408	0.8															●	●	●	●									●					●		●			–
	SNMN120412	1.2															●	●	●	●									●					●					
	SNMN120416	1.6															●	●	●	●																			
	SNMN190412	1.2																																●					
Flat Top	SNGN090308	0.8																																		●			–
	SNGN120404	0.4																																●		●			
	SNGN120408	0.8																																●					

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

CHIP BREAKERS ➤ A074
GRADES ➤ A030
IDENTIFICATION ➤ A002

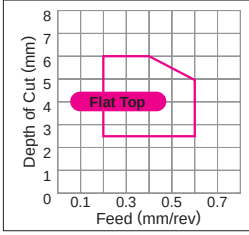
60° TN TYPE INSERTS WITHOUT HOLE

TNMN 16 03 08
Size Thickness Corner Radius
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Heavy Cutting·····

K Cast Iron (≤350MPa)



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet			Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	MC6035	UH6400	MS6015	MC7015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	NEW MP9025	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	UTi20T	HTi05T	HTi10	RT9010	MT9015	
	P	Steel	●	◐	✠	◐	✠	✠	✠	●																	✠	✠	●	◐	◐	●	●	✠					
	M	Stainless Steel									○	◐	✠	○	✠											◐	✠	✠	○			○	○	✠					
	K	Cast Iron															●	◐	●	◐	◐					◐	✠		●			●	●	✠	●	◐			
	N	Non-ferrous Metal																																		◐			
	S	Heat-resistant Alloy, Titanium Alloy														●						●	◐	✠	●	◐	✠									◐	◐	◐	
Shape	Order Number	RE (mm)																																					
Flat Top	TNMN160308	0.8																											●										–
	TNMN160408	0.8															●	●	●	●									●										
	TNMN160412	1.2															●	●	●	●																			
	TNMN160416	1.6															●	●	●	●																			
	TNMN160420	2.0																		●																			
	TNMN220408	0.8																											●										
	TNMN220412	1.2																																●					
Flat Top	TNGN110304	0.4																																		●			–
	TNGN110308	0.8																																		●			
	TNGN160404	0.4																																		●			
	TNGN160408	0.8																																		●			

● = NEW

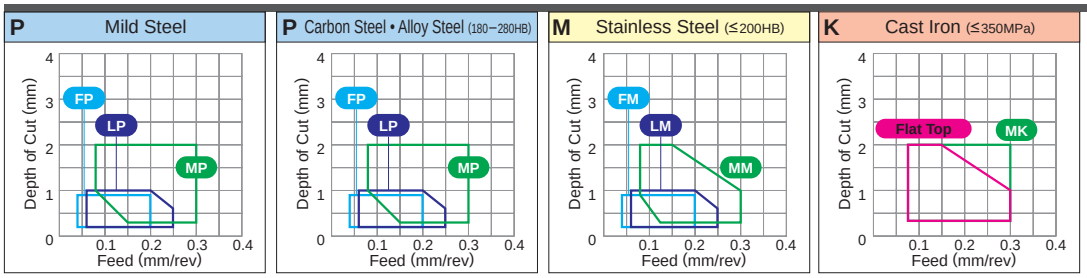
CHIP BREAKERS ➤ A074
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CC TYPE INSERTS WITH HOLE

CCMT 06 02 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●
	M	Stainless Steel								◐	✣	○	✣										◐	✣	✣	○			○	○		✣					
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
FP Finish Cutting	CCMT060202-FP	0.2		●		●	●																			●		●										C022 D008 E006 E030 E034
	CCMT060204-FP	0.4		●		●	●																			●		●										
	CCMT09T302-FP	0.2		●		●	●																			●		●										
	CCMT09T304-FP	0.4		●		●	●																			●		●										
	CCMT09T308-FP	0.8		●		●	●																			●		●										
FM Finish Cutting	CCMT060202-FM	0.2																						●														C022 D008 E006 E030 E034
	CCMT060204-FM	0.4																						●														
	CCMT09T302-FM	0.2																						●														
	CCMT09T304-FM	0.4																						●														
	CCMT09T308-FM	0.8																						●														
FS NEW Finish Cutting	CCGT060201M-FS	0.08																		●	●																	C022 D008 E006 E030 E034
	CCGT060202M-FS	0.18																		●	●																	
	CCGT09T301M-FS	0.08																		●	●																	
	CCGT09T302M-FS	0.18																		●	●																	
	CCGT09T304M-FS	0.38																		●	●																	
FS-P NEW Finish Cutting	CCGT060201M-FS-P	0.08																																		●		C022 D008 E006 E030 E034
	CCGT060202M-FS-P	0.18																																		●		
	CCGT09T301M-FS-P	0.08																																		●		
	CCGT09T302M-FS-P	0.18																																		●		
	CCGT09T304M-FS-P	0.38																																		●		
FV Finish Cutting	CCMT060202-FV	0.2			▲																			●		●	●		●		●							C022 D008 E006 E030 E034
	CCMT060204-FV	0.4			▲																			●		●	●		●		●							
	CCMT09T302-FV	0.2			▲																					●	●				●							
	CCMT09T304-FV	0.4			▲																					●	●		●		●							
	CCMT09T308-FV	0.8			▲																					●	●		●		●							
FJ Finish Cutting	CCGT0602V5-FJ	0.05																					●															C022 D008 E006 E030 E034
	CCGT060201-FJ	0.1																					●															
	CCGT060202-FJ	0.2																					●															
	CCGT09T3V5-FJ	0.05																					●															
	CCGT09T301-FJ	0.1																					●												●			
	CCGT09T302-FJ	0.2																					●												●			
	CCGT09T304-FJ	0.4																					●												●			

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																						Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	Applicable Holder Page
AZ	CCGT060202-AZ	0.2	C022 D008 E006 E030 E034
	CCGT060204-AZ	0.4	
	CCGT09T302-AZ	0.2	
	CCGT09T304-AZ	0.4	
	CCGT09T308-AZ	0.8	
	CCGT120402-AZ	0.2	
	CCGT120404-AZ	0.4	
Medium Cutting – Finish Cutting	CCGT120408-AZ	0.8	
R/L-F	⋆ CCGT03S1V3L-F	0.03	E016
	⋆ CCGT03S101L-F	0.1	
	⋆ CCGT03S102L-F	0.2	
	⋆ CCGT03S104L-F	0.4	
	⋆ CCGT04T0V3L-F	0.03	
	⋆ CCGT04T001L-F	0.1	
	⋆ CCGT04T002L-F	0.2	
	⋆ CCGT04T004L-F	0.4	
	NEW ⋆ CCGT03S101MR-F	0.08	E016
	NEW ⋆ CCGT03S101ML-F	0.08	
	NEW ⋆ CCGT03S102MR-F	0.18	
	NEW ⋆ CCGT03S102ML-F	0.18	
	NEW ⋆ CCGT03S104MR-F	0.38	
	NEW ⋆ CCGT03S104ML-F	0.38	
	NEW ⋆ CCGT04T001MR-F	0.08	
	NEW ⋆ CCGT04T001ML-F	0.08	
	NEW ⋆ CCGT04T002MR-F	0.18	
	NEW ⋆ CCGT04T002ML-F	0.18	
	NEW ⋆ CCGT04T004MR-F	0.38	
Finish Cutting	NEW ⋆ CCGT04T004ML-F	0.38	
R/L-F	CCGH060202R-F	0.2	C022 D008 E006 E030 E034
	CCGH060202L-F	0.2	
	CCGH060204R-F	0.4	
	CCGH060204L-F	0.4	
	NEW CCGH060202MR-F	0.18	C022 D008 E006 E030 E034
	NEW CCGH060202ML-F	0.18	
	NEW CCGH060204MR-F	0.38	
	NEW CCGH060204ML-F	0.38	
Finish Cutting			
LP	CCMT060204-LP	0.4	C022 D008 E006 E030 E034
	CCMT060208-LP	0.8	
	CCMT09T304-LP	0.4	
	CCMT09T308-LP	0.8	
Light Cutting			

⋆ Diameter of inscribed circle is special. (For SCLC type)

● = NEW

POSI 7°
WITH HOLE
C
D
R
S
T
V
W
X

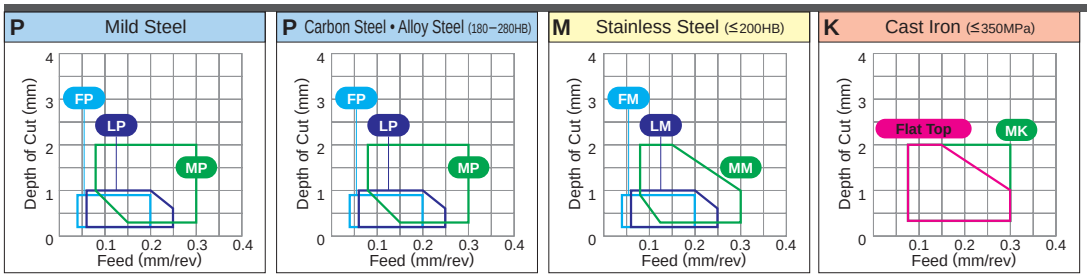
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CC TYPE INSERTS WITH HOLE

CCMT 06 02 04- LM
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																				Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
LM Light Cutting	**CCMT060204-LM**	0.4								●	●													●													C022 D008 E006 E030 E034
	CCMT060208-LM	0.8								●	●													●													
	CCMT09T304-LM	0.4								●	●													●													
	CCMT09T308-LM	0.8								●	●													●													
LS NEW Light Cutting	**CCMT060202-LS**	0.2																		●	●															●		C022 D008 E006 E030 E034
	CCMT060204-LS	0.4																		●	●															●		
	CCMT09T302-LS	0.2																		●	●															●		
	CCMT09T304-LS	0.4																		●	●															●		
	CCMT09T308-LS	0.8																		●	●															●		
LS NEW Light Cutting	**CCGT060201M-LS**	0.08																		●	●																	C022 D008 E006 E030 E034
	CCGT060202M-LS	0.18																		●	●																	
	CCGT09T301M-LS	0.08																		●	●																	
	CCGT09T302M-LS	0.18																		●	●																	
	CCGT09T304M-LS	0.38																		●	●																	
LS-P NEW Light Cutting	**CCGT060201M-LS-P**	0.08							●																											●		C022 D008 E006 E030 E034
	CCGT060202M-LS-P	0.18							●																											●		
	CCGT09T301M-LS-P	0.08							●																											●		
	CCGT09T302M-LS-P	0.18							●																											●		
	CCGT09T304M-LS-P	0.38							●																											●		
SV Light Cutting	**CCMH060202-SV**	0.2			▲		●				▲	●												●		●	●				●							C022 D008 E006 E030 E034
	CCMH060204-SV	0.4			▲		●				▲	●												●		●	●				●							
*** SW** Light Cutting (Wiper)	**CCMT060202-SW**	0.2		●	▲	●	●				▲															●		●		●								C022 D008 E006 E030 E034
	CCMT060204-SW	0.4		●	▲	●	●				▲						●									●		●		●								
	CCMT09T302-SW	0.2		●	▲	●	●				▲						●									●		●		●								
	CCMT09T304-SW	0.4		●	▲	●	●				▲						●									●		●		●								

* Please refer to A028 before using the SW breaker (wiper insert).

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																						Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
P	Steel		●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
M	Stainless Steel									◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
K	Cast Iron														●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
N	Non-ferrous Metal																																	◐			●
S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
R/L-SS	CCGT0602V3R-SS	0.03																						●														
	CCGT0602V3L-SS	0.03																						●														
	CCGT060201R-SS	0.1																						●														
	CCGT060201L-SS	0.1																						●														
	CCGT060202R-SS	0.2																						●														C022
	CCGT060202L-SS	0.2																						●														D008
	CCGT09T3V3R-SS	0.03																						●														E006
	CCGT09T3V3L-SS	0.03																						●														E030
	CCGT09T301R-SS	0.1																						●														E034
	CCGT09T301L-SS	0.1																						●														
	CCGT09T302R-SS	0.2																						●														
	CCGT09T302L-SS	0.2																						●														
	CCGT060201MR-SS	0.08							●																													
	NEW CCGT060201ML-SS	0.08							●																													
	CCGT060202MR-SS	0.18							●																													
	NEW CCGT060202ML-SS	0.18							●																													C022
	CCGT09T301MR-SS	0.08							●																													D008
	NEW CCGT09T301ML-SS	0.08							●																													E006
	CCGT09T302MR-SS	0.18							●																													E030
	NEW CCGT09T302ML-SS	0.18							●																													E034
	CCGT09T304MR-SS	0.38							●																													
Light Cutting	NEW CCGT09T304ML-SS	0.38							●																													
MP	CCMT060204-MP	0.4		●		●	●																			●		●										
	CCMT060208-MP	0.8		●		●	●																			●		●										
	CCMT09T304-MP	0.4		●		●	●																			●		●										C022
	CCMT09T308-MP	0.8		●		●	●																			●		●										D008
	CCMT120404-MP	0.4		●		●	●																			●		●										E006
	CCMT120408-MP	0.8		●		●	●																			●		●										E030
Medium Cutting	CCMT120412-MP	1.2		●		●	●																			●		●										E034
MM	CCMT060204-MM	0.4								●	●													●														
	CCMT060208-MM	0.8								●	●													●														
	CCMT09T304-MM	0.4								●	●													●														C022
	CCMT09T308-MM	0.8								●	●													●														D008
	CCMT120404-MM	0.4								●	●													●														E006
	CCMT120408-MM	0.8								●	●													●														E030
Medium Cutting	CCMT120412-MM	1.2								●	●													●														E034
MK	CCMT060204-MK	0.4													●	●																						
	CCMT060208-MK	0.8													●	●																						
	CCMT09T304-MK	0.4													●	●																						C022
	CCMT09T308-MK	0.8													●	●																						D008
	CCMT120404-MK	0.4													●	●																						E006
	CCMT120408-MK	0.8													●	●																						E030
Medium Cutting	CCMT120412-MK	1.2													●	●																						E034

● = NEW

POSI 7°
WITH HOLE

C D R S T V W X

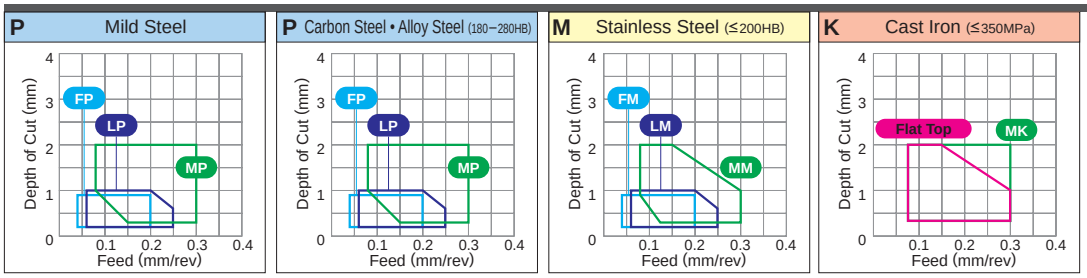
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CC TYPE INSERTS WITH HOLE

CCMT 06 02 02- MS
Size Thickness Corner Radius Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
MS NEW Medium Cutting	CCMT060202-MS	0.2																		●	●															●		
	CCMT060204-MS	0.4																		●	●															●		
	CCMT060208-MS	0.8																		●	●															●		C022
	CCMT09T302-MS	0.2																		●	●																	D008
	CCMT09T304-MS	0.4																		●	●															●		E006
	CCMT09T308-MS	0.8																		●	●															●		E030
	CCMT120404-MS	0.4																		●	●															●		E034
	CCMT120408-MS	0.8																		●	●															●		
	CCMT120412-MS	1.2																		●	●															●		
Standard Medium Cutting	CCMT060202	0.2		●	▲								●													●	●	●	●			●						
	CCMT060204	0.4	●	●	▲								●					●						●		●	●	●	●			●						
	CCMT060208	0.8		●	▲								●					●						●		●						●						
	CCMT080302	0.2		●																																		
	CCMT080304	0.4		●									●													●	●	●	●			●						C022
	CCMT080308	0.8		●									●																			●						D008
	CCMT09T302	0.2		●	▲								●													●	●	●	●									E006
	CCMT09T304	0.4	●	●	▲								●					●						●		●	●	●	●			●						E030
	CCMT09T308	0.8	●	●	▲								●					●						●		●	●	●	●			●						E034
	CCMT120404	0.4	●	●	▲								●					●						●		●	●	●	●			●						
	CCMT120408	0.8	●	●	▲								●					●						●		●	●	●				●						
	CCMT120412	1.2		●	▲								●					●									●											
MV Medium Cutting	CCMH060202-MV	0.2			▲		●					▲	●											●		●	●	●	●		●							C022
	CCMH060204-MV	0.4			▲		●					▲	●			●								●		●	●	●	●		●							D008
																																						E006 E030 E034
*** MW** Medium Cutting (Wiper)	CCMT060204-MW	0.4			▲	●	●					▲														●		●		●								
	CCMT060208-MW	0.8		●	▲	●	●					▲														●		●		●								C022
	CCMT09T304-MW	0.4		●	▲	●	●					▲														●		●		●								D008
	CCMT09T308-MW	0.8		●	▲	●	●					▲														●		●		●								E006
	CCMT120404-MW	0.4		●	▲	●	●					▲						●								●				●								E030
	CCMT120408-MW	0.8		●	▲	●	●					▲						●								●				●								E034

* Please refer to A028 before using the MW breaker (wiper insert).

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
R/L-SR	**CCET0602V3R-SR**	0.03																						●		●							●					
	CCET0602V3L-SR	0.03																						●		●							●					
	CCET060201R-SR	0.1																						●		●							●					
	CCET060201L-SR	0.1																						●		●							●					
	CCET060202R-SR	0.2																						●		●							●					
	CCET060202L-SR	0.2																						●		●							●					
	CCET060204R-SR	0.4																						●		●							●					C022
	CCET060204L-SR	0.4																						●		●							●					D008
	CCET09T3V3R-SR	0.03																						●		●							●					E006
	CCET09T3V3L-SR	0.03																						●		●							●					E030
	CCET09T301R-SR	0.1																						●		●							●					E034
	CCET09T301L-SR	0.1																						●		●							●					
	CCET09T302R-SR	0.2																						●		●							●					
	CCET09T302L-SR	0.2																						●		●							●					
	CCET09T304R-SR	0.4																						●		●							●					
Medium Cutting	**CCET09T304L-SR**	0.4																						●		●							●					
R/L-SN	**CCGT0602V3R-SN**	0.03																						●														
	CCGT060201R-SN	0.1																						●														
	CCGT060201L-SN	0.1																						●														
	CCGT060202R-SN	0.2																						●														
	CCGT060202L-SN	0.2																						●														C022
	CCGT09T3V3R-SN	0.03																						●														D008
	CCGT09T3V3L-SN	0.03																						●														E006
	CCGT09T301R-SN	0.1																						●														E030
	CCGT09T301L-SN	0.1																						●														E034
	CCGT09T302R-SN	0.2																						●														
	CCGT09T302L-SN	0.2																						●														
	CCGT09T304R-SN	0.4																						●														
	CCGT09T304L-SN	0.4																						●														
	CCGT060201MR-SN	0.08							●																													
	NEW **CCGT060201ML-SN**	0.08							●																													
	CCGT060202MR-SN	0.18							●																													
	NEW **CCGT060202ML-SN**	0.18							●																													C022
	CCGT09T301MR-SN	0.08							●																													D008
	NEW **CCGT09T301ML-SN**	0.08							●																													E006
	CCGT09T302MR-SN	0.18							●																													E030
	NEW **CCGT09T302ML-SN**	0.18							●																													E034
	CCGT09T304MR-SN	0.38							●																													
Medium Cutting	NEW **CCGT09T304ML-SN**	0.38							●																													

● = NEW

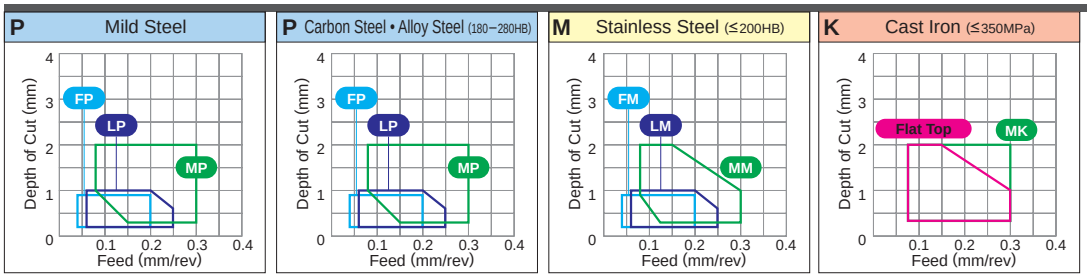
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CC TYPE INSERTS WITH HOLE

CCET 06 02 00 R SN
Size / Thickness / Corner Radius / R/L / Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●
	M	Stainless Steel								◐	✣	○	✣									◐	✣	✣	✣	○			○	○		✣					
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
R/L-SN	**CCET060200R-SN**	0																						●		●								●				
	CCET060200L-SN	0																						●		●								●				
	CCET0602V3R-SN	0.03																						●		●								●				
	CCET0602V3L-SN	0.03																						●		●								●				
	CCET060201R-SN	0.1																						●		●								●				
	CCET060201L-SN	0.1																						●		●								●				
	CCET060202R-SN	0.2																						●		●								●				
	CCET060202L-SN	0.2																						●		●								●				
	CCET060204R-SN	0.4																						●		●								●				C022
	CCET060204L-SN	0.4																						●		●								●				D008
	CCET09T300R-SN	0																						●		●								●				E006
	CCET09T300L-SN	0																						●		●								●				E030
	CCET09T3V3R-SN	0.03																						●		●								●				E034
	CCET09T3V3L-SN	0.03																						●		●								●				
	CCET09T301R-SN	0.1																						●		●								●				
	CCET09T301L-SN	0.1																						●		●								●				
	CCET09T302R-SN	0.2																						●		●								●				
	CCET09T302L-SN	0.2																						●		●								●				
	CCET09T304R-SN	0.4																						●		●								●				
Medium Cutting	**CCET09T304L-SN**	0.4																						●		●								●				
R/LW-SN *	**CCET0602V3RW-SN**	0.03																						●														C022
	CCET0602V3LW-SN	0.03																						●														D008
	CCET09T3V3RW-SN	0.03																						●														E006
	CCET09T3V3LW-SN	0.03																						●														E030
Medium Cutting (Wiper)																																						E034
SMG	**CCGT060201M-SMG**	0.08							●																													
	CCGT060202M-SMG	0.18							●															●														C022
	CCGT060204M-SMG	0.38							●															●														D008
	CCGT09T301M-SMG	0.08							●																													E006
	CCGT09T302M-SMG	0.18							●																													E030
Medium Cutting	**CCGT09T304M-SMG**	0.38							●																													E034

* Please refer to A028 before using the R/LW-SN breaker (wiper insert).

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																						Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
Flat Top	**CCMW060202**	0.2																																●				C022 D008 E006 E030 E034
	CCMW060204	0.4													●	●	●	●														●		●				
	CCMW060208	0.8													●	●																						
	CCMW09T304	0.4													●	●	●	●																●				
	CCMW09T308	0.8													●	●	●	●														●		●				
	CCMW09T312	1.2													●	●																						
	CCMW120404	0.4													●	●	●	●																●				
	CCMW120408	0.8													●	●	●	●																●				
	CCMW120412	1.2													●	●		●																				
Flat Top	**CCGW060200**	0																								●												C022 D008 E006 E030 E034
	CCGW0602V5	0.05																								●												
	CCGW09T300	0																								●												
	CCGW09T3V5	0.05																								●												

● = NEW

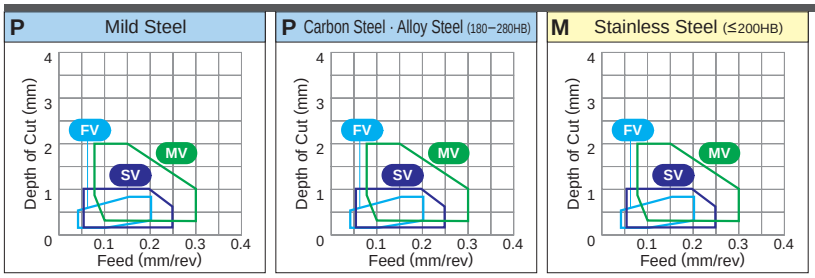
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° CP TYPE INSERTS WITH HOLE

CPMH 08 02 02- FV
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
FV	CPMH080202-FV	0.2			▲																			●		●	●	●										
	CPMH080204-FV	0.4			▲																			●		●	●	●										
	CPMH090302-FV	0.2			▲																			●		●	●	●										E006
	CPMH090304-FV	0.4			▲																			●		●	●	●										
Finish Cutting	CPMH090308-FV	0.8			▲																			●		●	●	●										
Standard	CPGT080202	0.2																															●					
	CPGT080204	0.4																															●					
	CPGT090302	0.2																															●					—
	CPGT090304	0.4																															●					
Finish Cutting																																						
R/L-F	CPMH080204R-F	0.4																						●		●							●					
	CPMH080204L-F	0.4																						●		●							●					
	CPMH090304R-F	0.4																						●		●							●					E006
	CPMH090304L-F	0.4																						●		●			●				●					
Finish Cutting																																						
R/L-F	CPGT080204R-F	0.4																								●												
	CPGT080204L-F	0.4																								●												
	CPGT090302R-F	0.2																								●												—
	CPGT090302L-F	0.2																								●												
	CPGT090304R-F	0.4																								●												
Finish Cutting	CPGT090304L-F	0.4																								●												
SV	CPMH080202-SV	0.2			▲		●					▲	●											●		●	●	●			●							
	CPMH080204-SV	0.4			▲		●					▲	●											●		●	●	●			●							
	CPMH090302-SV	0.2			▲		●					▲	●											●		●	●	●			●							E006
	CPMH090304-SV	0.4			▲		●					▲	●											●		●	●	●			●							
Light Cutting	CPMH090308-SV	0.8			▲		●					▲	●											●		●	●	●			●							
Standard	CPMX080204	0.4		●																					●													
	CPMX080208	0.8		●																					●													
	CPMX090304	0.4		●																					●	●						●						—
	CPMX090308	0.8		●	▲																				●							●					
Medium Cutting																																						
MV	CPMH080204-MV	0.4			▲		●					▲	●			●								●		●	●	●	●		●							
	CPMH080208-MV	0.8			▲		●					▲	●			●								●		●	●	●	●		●							
	CPMH090304-MV	0.4			▲		●					▲	●			●								●		●	●	●	●		●							E006
	CPMH090308-MV	0.8			▲		●					▲	●			●								●		●	●	●	●		●							
Medium Cutting																																						

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

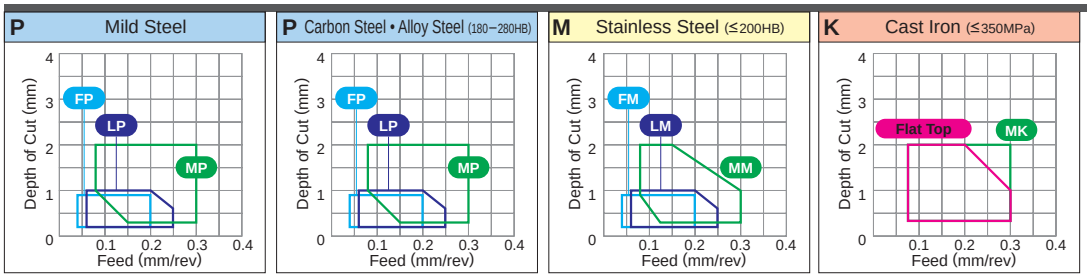
CHIP BREAKERS ➤ A068

55° DC TYPE INSERTS WITH HOLE

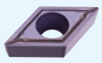
DCMT 07 02 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					
	P	Steel	●	◐	✠	◐	✠	✠	●														✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠									◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐			◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																															◐		●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠									◐	◐	●
Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
FP Finish Cutting	DCMT070202-FP	0.2		●		●	●																			●		●										C023 D009 D026 E008 E009 E029 E031
	DCMT070204-FP	0.4		●		●	●																			●		●										
	DCMT11T302-FP	0.2		●		●	●																			●		●										
	DCMT11T304-FP	0.4		●		●	●																			●		●										
	DCMT11T308-FP	0.8		●		●	●																			●		●										
FM  Finish Cutting	DCMT070202-FM	0.2																						●														C023 D009 D026 E008 E009 E029 E031
	DCMT070204-FM	0.4																						●														
	DCMT11T302-FM	0.2																						●														
	DCMT11T304-FM	0.4																						●														
	DCMT11T308-FM	0.8																						●														
FS NEW Finish Cutting	DCGT070201M-FS	0.08																		●	●																	C023 D009 D026 E008 E009 E029 E031
	DCGT070202M-FS	0.18																		●	●																	
	DCGT11T301M-FS	0.08																		●	●																	
	DCGT11T302M-FS	0.18																		●	●																	
FS-P NEW Finish Cutting	DCGT070201M-FS-P	0.08																																	●			C023 D009 D026 E008 E009 E029 E031
	DCGT070202M-FS-P	0.18																																	●			
	DCGT11T301M-FS-P	0.08																																	●			
	DCGT11T302M-FS-P	0.18																																	●			
FV Finish Cutting	DCMT070202-FV	0.2		●	▲																			●		●	●		●									C023 D009 D026 E008 E009 E029 E031
	DCMT070204-FV	0.4		●	▲																			●		●	●		●									
	DCMT070208-FV	0.8			▲																			●		●	●											
	DCMT11T302-FV	0.2			▲																			●		●	●											
	DCMT11T304-FV	0.4		●	▲																			●		●	●		●									
	DCMT11T308-FV	0.8		●	▲																			●		●	●		●									
AZ Medium Cutting – Finish Cutting	DCGT070202-AZ	0.2																															●					C023 D009 D026 E008 E009 E029 E031
	DCGT070204-AZ	0.4																															●					
	DCGT11T302-AZ	0.2																															●					
	DCGT11T304-AZ	0.4																															●					
	DCGT11T308-AZ	0.8																															●					

● = NEW

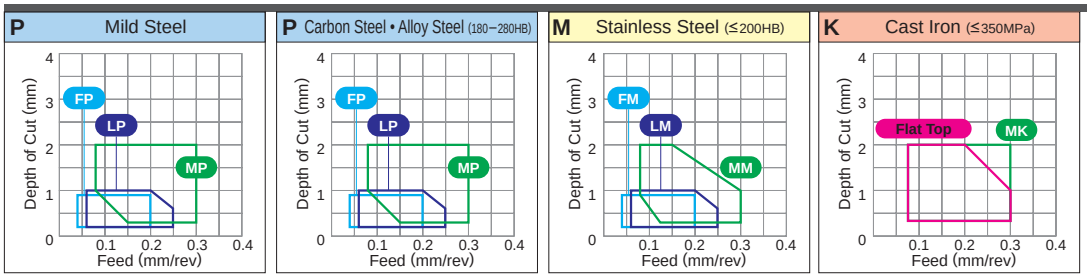
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

55° DC TYPE INSERTS WITH HOLE

DCGT 07 02 02 R-F
Size Thickness Corner Radius R/L Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

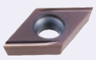
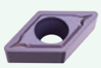
Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●
	M	Stainless Steel								◐	✣	○	✣										◐	✣	✣	○			○	○		✣					
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●
	N	Non-ferrous Metal																																◐		●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
R/L-F Finish Cutting	**DCGT070202R-F**	0.2																						●		●							●					C023 D009 D026 E008 E009 E029 E031
	DCGT070202L-F	0.2																						●		●			●				●					
	DCGT070204R-F	0.4																						●		●							●					
	DCGT070204L-F	0.4																						●		●			●				●					
	DCGT11T302R-F	0.2																						●		●							●					
	DCGT11T302L-F	0.2																						●		●			●				●					
	DCGT11T304R-F	0.4																						●		●							●					
	DCGT11T304L-F	0.4																						●		●			●				●					
LP Light Cutting	**DCMT070204-LP**	0.4		●		●	●																			●		●										C023 D009 D026 E008 E009 E029 E031
	DCMT070208-LP	0.8		●		●	●																			●		●										
	DCMT11T304-LP	0.4		●		●	●																			●		●										
	DCMT11T308-LP	0.8		●		●	●																			●		●										
LM Light Cutting	**DCMT070204-LM**	0.4								●	●													●														C023 D009 D026 E008 E009 E029 E031
	DCMT070208-LM	0.8								●	●													●														
	DCMT11T304-LM	0.4								●	●													●														
	DCMT11T308-LM	0.8								●	●													●														
LS NEW Light Cutting	**DCMT070202-LS**	0.2																		●	●															●		C023 D009 D026 E008 E009 E029 E031
	DCMT070204-LS	0.4																		●	●															●		
	DCMT11T302-LS	0.2																		●	●															●		
	DCMT11T304-LS	0.4																		●	●															●		
	DCMT11T308-LS	0.8																		●	●															●		
LS NEW Light Cutting	**DCGT070201M-LS**	0.08																		●	●																	C023 D009 D026 E008 E009 E029 E031
	DCGT070202M-LS	0.18																		●	●																	
	DCGT070204M-LS	0.38																		●	●																	
	DCGT11T301M-LS	0.08																		●	●																	
	DCGT11T302M-LS	0.18																		●	●																	
	DCGT11T304M-LS	0.38																		●	●																	
LS-P NEW Light Cutting	**DCGT070201M-LS-P**	0.08							●																											●		C023 D009 D026 E008 E009 E029 E031
	DCGT070202M-LS-P	0.18							●																											●		
	DCGT070204M-LS-P	0.38							●																											●		
	DCGT11T301M-LS-P	0.08							●																											●		
	DCGT11T302M-LS-P	0.18							●																											●		
	DCGT11T304M-LS-P	0.38							●																											●		

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
Work Material	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
	M	Stainless Steel								◐	✣	●	✣										◐	✣	✣	●			●	●		✣						
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
	N	Non-ferrous Metal																																◐			●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●		
			Coated																							Cermet		Coated Cermet				Carbide						
SV	DCMT070202-SV	0.2			▲							▲	●											●		●	●				●							C023 D009 D026 E008 E009 E029 E031
	DCMT070204-SV	0.4		●	▲							▲	●											●		●	●				●							
	DCMT070208-SV	0.8		●	▲							▲	●											●		●	●				●							
	DCMT11T302-SV	0.2		●	▲							▲	●											●		●	●				●							
	DCMT11T304-SV	0.4		●	▲							▲	●											●		●	●				●							
Light Cutting	DCMT11T308-SV	0.8		●	▲							▲	●											●		●	●				●							
R/L-SS	DCGT0702V3R-SS	0.03																						●														C023 D009 D026 E008 E009 E029 E031
	DCGT0702V3L-SS	0.03																						●														
	DCGT070201R-SS	0.1																						●														
	DCGT070201L-SS	0.1																						●														
	DCGT070202R-SS	0.2																						●														
	DCGT070202L-SS	0.2																						●														
	DCGT11T3V3R-SS	0.03																						●														
	DCGT11T301R-SS	0.1																						●														
	DCGT11T302R-SS	0.2																						●														
	DCGT070201MR-SS	0.08							●																													C023 D009 D026 E008 E009 E029 E031
	NEW DCGT070201ML-SS	0.08							●																													
	DCGT070202MR-SS	0.18							●																													
	NEW DCGT070202ML-SS	0.18							●																													
	DCGT11T301MR-SS	0.08							●																													
	NEW DCGT11T301ML-SS	0.08							●																													
	DCGT11T302MR-SS	0.18							●																													
	NEW DCGT11T302ML-SS	0.18							●																													
	DCGT11T304MR-SS	0.38							●																													
Light Cutting	NEW DCGT11T304ML-SS	0.38							●																													
MP	DCMT070204-MP	0.4		●		●	●																			●		●										C023 D009 D026 E008 E009 E029 E031
	DCMT070208-MP	0.8		●		●	●																			●		●										
	DCMT11T304-MP	0.4		●		●	●																			●		●										
	DCMT11T308-MP	0.8		●		●	●																			●		●										
	DCMT150404-MP	0.4		●		●	●																			●		●										
Medium Cutting	DCMT150408-MP	0.8		●		●	●																			●		●										
MM	DCMT070204-MM	0.4								●	●													●														C023 D009 D026 E008 E009 E029 E031
	DCMT070208-MM	0.8								●	●													●														
	DCMT11T304-MM	0.4								●	●													●														
	DCMT11T308-MM	0.8								●	●													●														
	DCMT150404-MM	0.4								●	●													●														
Medium Cutting	DCMT150408-MM	0.8								●	●													●														
MK	DCMT070204-MK	0.4													●	●																						C023 D009 D026 E008 E009 E029 E031
	DCMT070208-MK	0.8													●	●																						
	DCMT11T304-MK	0.4													●	●																						
	DCMT11T308-MK	0.8													●	●																						
	DCMT150404-MK	0.4													●	●																						
Medium Cutting	DCMT150408-MK	0.8													●	●																						

● (highlighted) = NEW

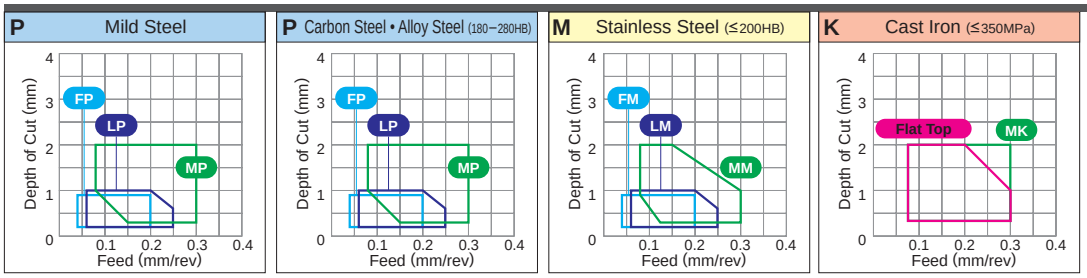
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

55° DC TYPE INSERTS WITH HOLE

DCMT 07 02 04- MS
Size / Thickness / Corner Radius / Chip Breaker
★ Please refer to page A002.

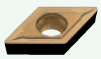
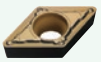
CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
MS NEW Medium Cutting	**DCMT070204-MS**	0.4																		●	●															●		C023 D009 D026 E008 E009 E029 E031
	DCMT070208-MS	0.8																		●	●															●		
	DCMT11T304-MS	0.4																		●	●															●		
	DCMT11T308-MS	0.8																		●	●															●		
	DCMT11T312-MS	1.2																		●	●															●		
Standard  Medium Cutting	**DCMT070202**	0.2		●	▲								●													●	●	●	●			●						C023 D009 D026 E008 E009 E029 E031
	DCMT070204	0.4	●	●	▲								●					●							●	●	●	●	●			●						
	DCMT070208	0.8		●									●					●								●	●	●	●									
	DCMT11T302	0.2		●	▲								●													●	●	●	●			●						
	DCMT11T304	0.4	●	●	▲								●					●							●	●	●	●	●			●						
	DCMT11T308	0.8	●	●	▲								●					●							●	●	●	●	●			●						
	DCMT11T312	1.2		●																																		
	DCMT150404	0.4		●	▲								●					●								●	●	●	●			●						
	DCMT150408	0.8		●	▲								●					●								●	●	●				●						
	DCMT150412	1.2		●																																		
MV  Medium Cutting	**DCMT070202-MV**	0.2		●	▲		●					▲	●											●		●	●	●	●		●							C023 D009 D026 E008 E009 E029 E031
	DCMT070204-MV	0.4		●	▲		●					▲	●			●								●		●	●	●	●		●							
	DCMT070208-MV	0.8		●	▲		●					▲	●			●								●		●	●	●	●		●							
	DCMT11T302-MV	0.2		●	▲		●					▲	●											●		●	●	●	●		●							
	DCMT11T304-MV	0.4		●	▲		●					▲	●			●								●		●	●	●	●		●							
	DCMT11T308-MV	0.8		●	▲		●					▲	●			●								●		●	●	●	●		●							
R/L-SR Medium Cutting	**DCET0702V3R-SR**	0.03																						●		●							●					C023 D009 D026 E008 E009 E029 E031
	DCET0702V3L-SR	0.03																						●		●							●					
	DCET070201R-SR	0.1																						●		●							●					
	DCET070201L-SR	0.1																						●		●							●					
	DCET070202R-SR	0.2																						●		●							●					
	DCET070202L-SR	0.2																						●		●							●					
	DCET070204R-SR	0.4																						●		●							●					
	DCET070204L-SR	0.4																						●		●							●					
	DCET11T3V3R-SR	0.03																						●		●							●					
	DCET11T3V3L-SR	0.03																						●		●							●					

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
R/L-SR	DCET11T301R-SR	0.1																						●		●							●					C023 D009 D026 E008 E009 E029 E031
	DCET11T301L-SR	0.1																						●		●							●					
	DCET11T302R-SR	0.2																						●		●							●					
	DCET11T302L-SR	0.2																						●		●							●					
	DCET11T304R-SR	0.4																						●		●							●					
Medium Cutting	DCET11T304L-SR	0.4																						●		●							●					
R/L-SN	DCGT0702V3R-SN	0.03																						●														C023 D009 D026 E008 E009 E029 E031
	DCGT070201R-SN	0.1																						●														
	DCGT070202R-SN	0.2																						●														
	DCGT070202L-SN	0.2																						●														
	DCGT11T3V3R-SN	0.03																						●														
	DCGT11T3V3L-SN	0.03																						●														
	DCGT11T301R-SN	0.1																						●														
	DCGT11T301L-SN	0.1																						●														
	DCGT11T302R-SN	0.2																						●														
	DCGT11T302L-SN	0.2																						●														
	DCGT11T304R-SN	0.4																						●														
	DCGT11T304L-SN	0.4																						●														
	DCGT070201MR-SN	0.08							●																													C023 D009 D026 E008 E009 E029 E031
	NEW DCGT070201ML-SN	0.08							●																													
	DCGT070202MR-SN	0.18							●																													
	NEW DCGT070202ML-SN	0.18							●																													
	DCGT11T301MR-SN	0.08							●																													
	NEW DCGT11T301ML-SN	0.08							●																													
	DCGT11T302MR-SN	0.18							●																													
	NEW DCGT11T302ML-SN	0.18							●																													
	DCGT11T304MR-SN	0.38							●																													
Medium Cutting	NEW DCGT11T304ML-SN	0.38							●																													
R/L-SN	DCET0702V3R-SN	0.03																						●		●							●					C023 D009 D026 E008 E009 E029 E031
	DCET0702V3L-SN	0.03																						●		●							●					
	DCET070200R-SN	0																						●		●							●					
	DCET070200L-SN	0																						●		●							●					
	DCET070201R-SN	0.1																						●		●							●					
	DCET070201L-SN	0.1																						●		●							●					
	DCET070202R-SN	0.2																						●		●							●					
	DCET070202L-SN	0.2																						●		●							●					
	DCET070204R-SN	0.4																						●		●							●					
	DCET070204L-SN	0.4																						●		●							●					
	DCET11T3V3R-SN	0.03																						●		●							●					
	DCET11T3V3L-SN	0.03																						●		●							●					
	DCET11T300R-SN	0																						●		●							●					
	DCET11T300L-SN	0																						●		●							●					
	DCET11T301R-SN	0.1																						●		●							●					
Medium Cutting	DCET11T301L-SN	0.1																						●		●							●					

● = NEW

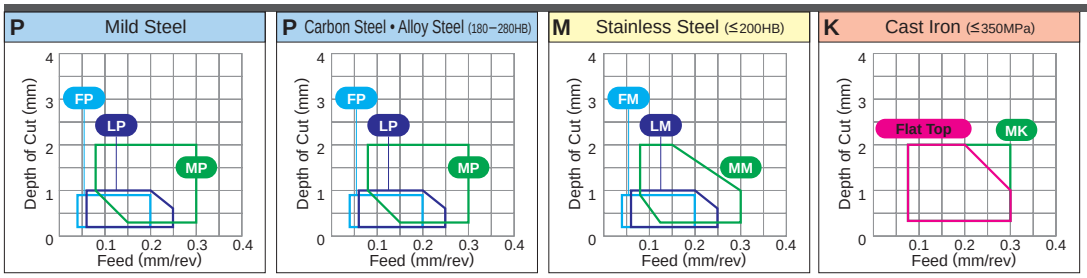
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

55° DC TYPE INSERTS WITH HOLE

DCET 11 T3 02 R-SN
Size / Thickness / Corner Radius / R/L / Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
R/L-SN	DCET11T302R-SN	0.2																						●		●							●					C023 D009 D026 E008 E009 E029 E031
	DCET11T302L-SN	0.2																						●		●							●					
	DCET11T304R-SN	0.4																						●		●							●					
	DCET11T304L-SN	0.4																						●		●							●					
Medium Cutting																																						
R/LW-SN *	DCET0702V3RW-SN	0.03																						●														C023 D009 D026 E008 E009 E029 E031
	DCET0702V3LW-SN	0.03																						●														
	DCET11T3V3RW-SN	0.03																						●														
	DCET11T3V3LW-SN	0.03																						●														
Medium Cutting (Wiper)																																						
SMG	DCGT070201M-SMG	0.08							●																													C023 D009 D026 E008 E009 E029 E031
	DCGT070202M-SMG	0.18							●															●														
	DCGT070204M-SMG	0.38							●															●														
	DCGT11T301M-SMG	0.08							●																													
	DCGT11T302M-SMG	0.18							●															●														
Medium Cutting	DCGT11T304M-SMG	0.38							●															●														
Flat Top	DCMW070204	0.4													●	●	●	●															●					C023 D009 D026 E008 E009 E029 E031
	DCMW11T304	0.4													●	●	●	●														●	●					
	DCMW11T308	0.8													●	●	●	●															●					
	DCMW150404	0.4																															●					
	DCMW150408	0.8																															●					
Flat Top	DCGW070200	0																								●												C023 D009 D026 E008 E009 E029 E031
	DCGW0702V5	0.05																								●												
	DCGW11T300	0																								●												
	DCGW11T3V5	0.05																								●												

* Please refer to A028 before using the R/LW-SN breaker (wiper insert).

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

CHIP BREAKERS ➤ A060

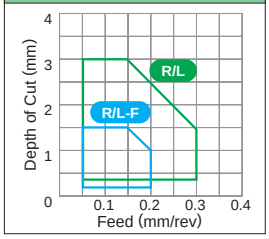
55° DE TYPE INSERTS WITH HOLE

DEGX 15 04 02 R-F
Size Thickness Corner Radius R/L Chip Breaker
★ Please refer to page A002.

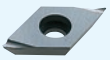
CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Medium Cutting ·····

N Aluminium Alloy



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
P	Steel		●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
M	Stainless Steel									◐	✣	○	✣										◐	✣	✣	○			○	○		✣						
K	Cast Iron														●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
N	Non-ferrous Metal																																	◐			●	
S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	●	◐	✣										◐	◐	●		
Shape	Order Number	RE (mm)																																				
R/L-F  Finish Cutting (For Aluminium Alloy)	DEGX150402R-F	0.2																															●					C032
	DEGX150402L-F	0.2																															●					
	DEGX150404R-F	0.4																															●					
	DEGX150404L-F	0.4																															●					
R/L Medium Cutting (For Aluminium Alloy)	DEGX150402R	0.2																															●					C032
	DEGX150402L	0.2																															●					
	DEGX150404R	0.4																															●					
	DEGX150404L	0.4																															●					

● = NEW

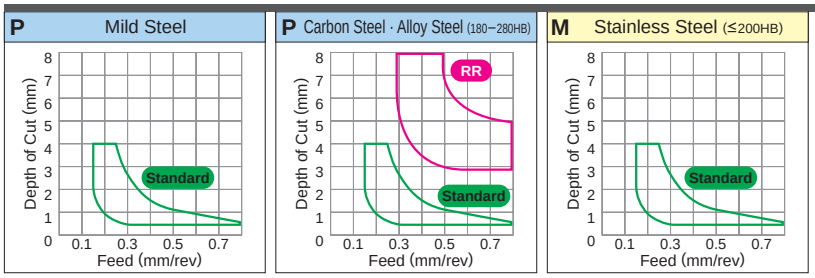
CHIP BREAKERS ➤ A072
GRADES ➤ A030
IDENTIFICATION ➤ A002

RC TYPE INSERTS WITH HOLE

RCGT 08 03 M0- AZ
Size / Thickness / Corner Radius / Chip Breaker
* Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
P	Steel		●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
M	Stainless Steel									◐	✣	○	✣										◐	✣	✣	○			○	○		✣						
K	Cast Iron														●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
N	Non-ferrous Metal																																	◐			●	
S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	●	◐	✣										◐	◐	●		
Shape	Order Number	IC (mm)																																				
AZ Medium Cutting – Finish Cutting	RCGT0803M0-AZ	8.0																																●				C025
	RCGT10T3M0-AZ	10.0																																●				
Standard Medium Cutting	RCMT0602M0	6.0		●																						●	●	●				●						C025
	RCMT0803M0	8.0		●									●													●	●	●				●						
Standard Medium Cutting	RCMX1003M0	10.0		●	▲		●						●									●				●	●	●										C024 H012
	RCMX1204M0	12.0	●	●	▲		●						●	●		●		●				●	●			●	●	●										
	RCMX1606M0	16.0	●	●	▲		●	●					●	●								●	●															
	RCMX2006M0	20.0	●	●	▲		●	●					●																									
	RCMX2507M0	25.0	●	●	▲		●																															
	RCMX3209M0	32.0	●	●	▲																																	
RR Heavy Cutting	RCMX1606M0-RR	16.0		●	▲		●	●					●																									C024
	RCMX2006M0-RR	20.0		●	▲		●	●					●																									
	RCMX2507M0-RR	25.0		●	▲		●	●					●																									
	RCMX3209M0-RR	32.0		●	▲																																	

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

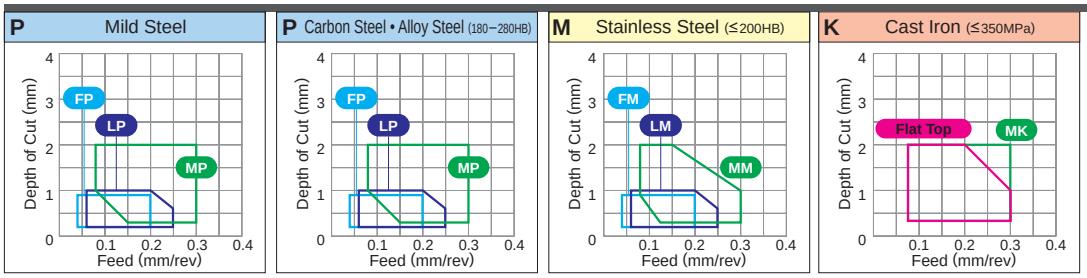
CHIP BREAKERS ➤ A060

90° SC TYPE INSERTS WITH HOLE

SCMT 09 T3 04- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
FP Finish Cutting	**SCMT09T304-FP**	0.4		●		●	●																			●		●										C026 E033
	SCMT09T308-FP	0.8		●		●	●																			●		●										
FM Finish Cutting	**SCMT09T304-FM**	0.4																						●														C026 E033
	SCMT09T308-FM	0.8																						●														
FV Finish Cutting	**SCMT09T304-FV**	0.4			▲																					●	●		●		●							C026 E033
LP Light Cutting	**SCMT09T304-LP**	0.4		●		●	●																			●		●										C026 E033
	SCMT09T308-LP	0.8		●		●	●																			●		●										
LM Light Cutting	**SCMT09T304-LM**	0.4								●	●													●														C026 E033
	SCMT09T308-LM	0.8								●	●													●														
MP Medium Cutting	**SCMT09T304-MP**	0.4		●		●	●																			●		●										C026 E033
	SCMT09T308-MP	0.8		●		●	●																			●		●										
	SCMT120404-MP	0.4		●		●	●																			●		●										
	SCMT120408-MP	0.8		●		●	●																			●		●										
MM Medium Cutting	**SCMT09T304-MM**	0.4								●	●													●														C026 E033
	SCMT09T308-MM	0.8								●	●													●														
	SCMT120404-MM	0.4								●	●													●														
	SCMT120408-MM	0.8								●	●													●														

● = NEW

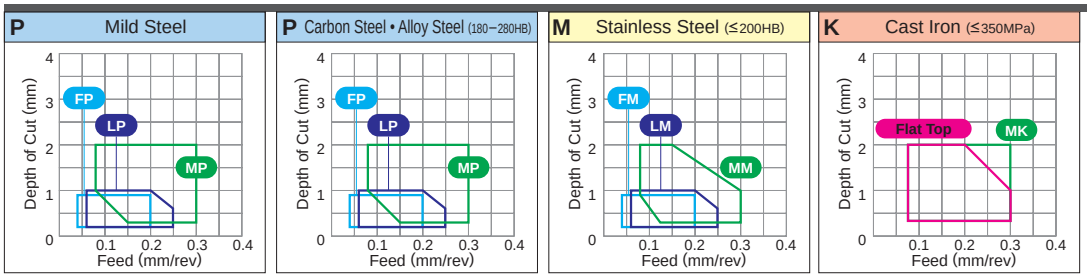
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

90° SC TYPE INSERTS WITH HOLE

SCMT 09 T3 04- MK
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																				Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
MK Medium Cutting	**SCMT09T304-MK**	0.4													●	●																						C026 E033
	SCMT09T308-MK	0.8													●	●																						
	SCMT120404-MK	0.4													●	●																						
	SCMT120408-MK	0.8													●	●																						
MS NEW Medium Cutting	**SCMT09T304-MS**	0.4																		●	●															●		C026 E033
	SCMT09T308-MS	0.8																		●	●															●		
	SCMT120404-MS	0.4																		●	●															●		
	SCMT120408-MS	0.8																		●	●															●		
	SCMT120412-MS	1.2																		●	●															●		
Standard Medium Cutting	**SCMT09T304**	0.4	●	●	▲								●					●								●	●	●	●			●						C026 E033
	SCMT09T308	0.8	●	●	▲								●					●								●	●	●	●			●						
	SCMT120404	0.4	●	●	▲								●					●								●	●	●										
	SCMT120408	0.8	●	●	▲								●					●								●	●	●	●			●						
	SCMT120412	1.2		●																																		
Flat Top	**SCMW09T304**	0.4													●	●		●														●		●				C026 E033
	SCMW09T308	0.8													●	●	●	●																				
	SCMW120408	0.8													●	●	●	●																				

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

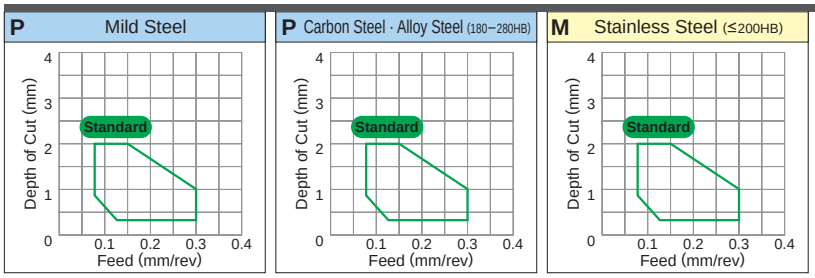
CHIP BREAKERS ➤ A060

90° SP TYPE INSERTS WITH HOLE

SPMT 09 03 04
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
Standard Medium Cutting	**SPMT090304**	0.4																								●												
	SPMT090308	0.8																								●												
	SPMT120308	0.8																								●						●						—
Flat Top	**SPMW090304**	0.4																						●	●	●						●		●				
	SPMW090308	0.8																						●	●	●						●		●				
	SPMW120304	0.4																						●	●	●						●		●				—
	SPMW120308	0.8																						●	●	●						●		●				
Flat Top	**SPGX090304**	0.4																								●								●				
	SPGX090308	0.8																																●				
	SPGX120304	0.4																																●				—
	SPGX120308	0.8																																●				

● = NEW

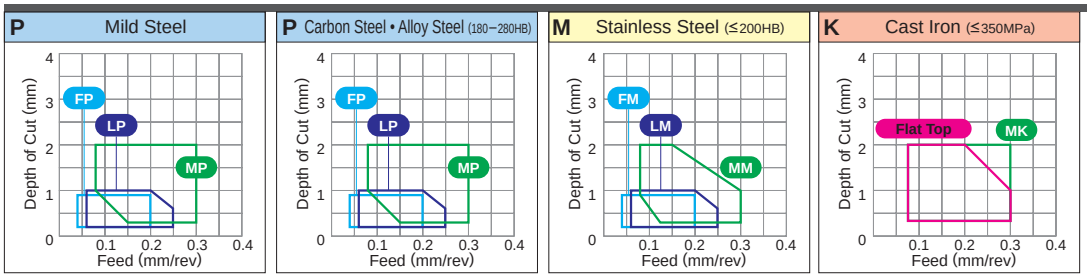
CHIP BREAKERS ➤ A068
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TC TYPE INSERTS WITH HOLE

TCMT 09 02 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
FP Finish Cutting	TCMT090202-FP	0.2		●		●	●																			●		●										C027 E028
	TCMT090204-FP	0.4		●		●	●																			●		●										
	TCMT110202-FP	0.2		●		●	●																			●		●										
	TCMT110204-FP	0.4		●		●	●																			●		●										
	TCMT16T304-FP	0.4		●		●	●																			●		●										
FM Finish Cutting	TCMT090202-FM	0.2																						●														C027 E028
	TCMT090204-FM	0.4																						●														
	TCMT110202-FM	0.2																						●														
	TCMT110204-FM	0.4																						●														
	TCMT16T304-FM	0.4																						●														
FV Finish Cutting	TCMT110204-FV	0.4			▲																					●	●		●		●							C027 E028
	TCMT16T304-FV	0.4			▲																					●	●		●									
AZ Medium Cutting – Finish Cutting	TCGT110202-AZ	0.2																																●				C027 E028
	TCGT110204-AZ	0.4																																●				
	TCGT110208-AZ	0.8																																●				
	TCGT16T302-AZ	0.2																																●				
	TCGT16T304-AZ	0.4																																●				
	TCGT16T308-AZ	0.8																																●				
R/L-F Finish Cutting	TCGT0601V3L-F	0.03																								●												E017
	TCGT060101L-F	0.1																						●		●												
	TCGT060102R-F	0.2																						●		●								●				
	TCGT060102L-F	0.2																						●		●								●				
	TCGT060104R-F	0.4																								●								●				
	TCGT060104L-F	0.4																						●		●								●				
	NEW TCGT060101MR-F	0.08							●																													E017
	NEW TCGT060101ML-F	0.08							●																													
	NEW TCGT060102MR-F	0.18							●																													
	NEW TCGT060102ML-F	0.18							●																													
	NEW TCGT060104MR-F	0.38							●																													
Finish Cutting	NEW TCGT060104ML-F	0.38							●																													

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
P	Steel		●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
M	Stainless Steel									◐	✠	●	✠										◐	✠	✠	●			●	●		✠					
K	Cast Iron														●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
N	Non-ferrous Metal																																	◐			●
S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
LP Light Cutting	TCMT090204-LP	0.4		●		●	●																			●		●										C027 E028
	TCMT090208-LP	0.8		●		●	●																			●		●										
	TCMT110204-LP	0.4		●		●	●																			●		●										
	TCMT110208-LP	0.8		●		●	●																			●		●										
	TCMT16T304-LP	0.4		●		●	●																			●		●										
	TCMT16T308-LP	0.8		●		●	●																			●		●										
LM Light Cutting	TCMT090204-LM	0.4								●	●													●														C027 E028
	TCMT090208-LM	0.8								●	●													●														
	TCMT110204-LM	0.4								●	●													●														
	TCMT110208-LM	0.8								●	●													●														
	TCMT16T304-LM	0.4								●	●													●														
	TCMT16T308-LM	0.8								●	●													●														
LS NEW Light Cutting	TCMT090202-LS	0.2																		●	●															●		C027 E028
	TCMT110202-LS	0.2																		●	●															●		
MP Medium Cutting	TCMT090204-MP	0.4		●		●	●																			●		●										C027 E028
	TCMT090208-MP	0.8		●		●	●																			●		●										
	TCMT110204-MP	0.4		●		●	●																			●		●										
	TCMT110208-MP	0.8		●		●	●																			●		●										
	TCMT130304-MP	0.4		●		●	●																			●		●										
	TCMT16T304-MP	0.4		●		●	●																			●		●										
	TCMT16T308-MP	0.8		●		●	●																			●		●										
	TCMT16T312-MP	1.2		●		●	●																			●		●										
MM Medium Cutting	TCMT090204-MM	0.4								●	●													●														C027 E028
	TCMT090208-MM	0.8								●	●													●														
	TCMT110204-MM	0.4								●	●													●														
	TCMT110208-MM	0.8								●	●													●														
	TCMT130304-MM	0.4								●	●													●														
	TCMT16T304-MM	0.4								●	●													●														
	TCMT16T308-MM	0.8								●	●													●														
	TCMT16T312-MM	1.2								●	●													●														
MK Medium Cutting	TCMT110204-MK	0.4													●	●																						C027 E028
	TCMT110208-MK	0.8													●	●																						
	TCMT16T304-MK	0.4													●	●																						
	TCMT16T308-MK	0.8													●	●																						
	TCMT16T312-MK	1.2													●	●																						
MS NEW Medium Cutting	TCMT090204-MS	0.4																		●	●															●		C027 E028
	TCMT090208-MS	0.8																		●	●															●		
	TCMT110204-MS	0.4																		●	●																	
	TCMT110208-MS	0.8																		●	●																	
	TCMT16T304-MS	0.4																		●	●															●		
	TCMT16T308-MS	0.8																		●	●															●		
	TCMT16T312-MS	1.2																		●	●															●		

● = NEW

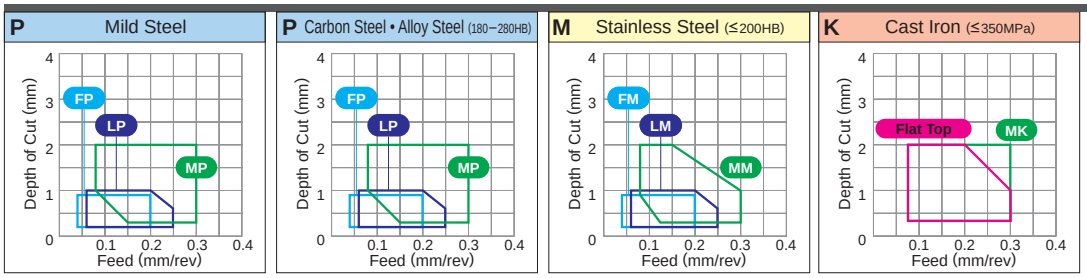
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TC TYPE INSERTS WITH HOLE

TCMT 08 02 04
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting····· Light Cutting····· Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠									◐	✠	✠	○				○	○	✠						
	K	Cast Iron													●	◐	●	◐	◐			◐	✠		●			●	●	✠	●	◐				●
	N	Non-ferrous Metal																															◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠									◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
Standard	**TCMT080204**	0.4																									●	●				●						C027 E028
	TCMT090204	0.4		●	▲								●													●	●	●	●			●						
	TCMT110202	0.2		●	▲								●											●		●	●	●	●									
	TCMT110204	0.4	●	●	▲								●					●						●		●	●	●	●			●						
	TCMT110208	0.8	●	●																				●				●										
	TCMT130302	0.2																										●	●									
	TCMT130304	0.4		●									●														●	●										
	TCMT16T304	0.4	●	●	▲								●					●						●		●	●	●	●			●						
	TCMT16T308	0.8	●	●	▲								●					●						●		●	●	●	●			●						
Medium Cutting	**TCMT16T312**	1.2		●																																		
Flat Top	**TCMW110204**	0.4													●	●	●	●																●				C027 E028
	TCMW130304	0.4																																●				
	TCMW16T304	0.4													●	●	●	●																●				
	TCMW16T308	0.8													●	●	●	●																●				
	TCMW16T312	1.2													●	●																						

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

CHIP BREAKERS ➤ A060

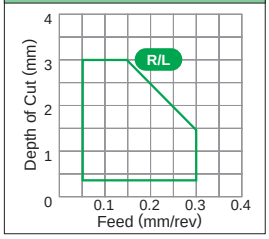
60° TE TYPE INSERTS WITH HOLE

TEGX 16 03 02 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting

N Aluminium Alloy



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																						Cermet		Coated Cermet				Carbide					
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 NEW	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐		●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●

Shape	Order Number	RE (mm)	Applicable Holder Page
R/L Medium Cutting (For Aluminium Alloy)	TEGX160302R	0.2	C033 E043
	TEGX160302L	0.2	
	TEGX160304R	0.4	
	TEGX160304L	0.4	

● = NEW

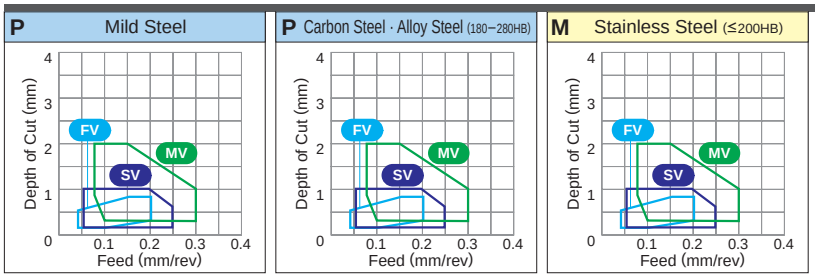
CHIP BREAKERS ➤ A072
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TP TYPE INSERTS WITH HOLE

TPMH 08 02 02- FV
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
FV	TPMH080202-FV	0.2			▲																			●		●	●	●										
	TPMH080204-FV	0.4			▲																			●		●	●	●										
	TPMH090202-FV	0.2			▲																			●		●	●	●										
	TPMH090204-FV	0.4			▲																			●		●	●	●										
	TPMH110302-FV	0.2			▲																			●		●	●	●										E007
	TPMH110304-FV	0.4			▲																			●		●	●	●										
	TPMH110308-FV	0.8			▲																			●		●	●	●										
	TPMH160302-FV	0.2			▲																			●		●	●	●										
	TPMH160304-FV	0.4			▲																			●		●	●	●										
Finish Cutting	TPMH160308-FV	0.8			▲																			●		●	●	●										
R/L-FS	TPGH080202R-FS	0.2																						●		●								●				
	TPGH080202L-FS	0.2																						●		●		●	●					●				
	TPGH080204R-FS	0.4																						●		●								●				
	TPGH080204L-FS	0.4																						●		●		●	●					●				
	TPGH090202R-FS	0.2																						●		●								●				
	TPGH090202L-FS	0.2																						●		●		●	●					●				
	TPGH090204R-FS	0.4																						●		●								●				
	TPGH090204L-FS	0.4																						●		●		●	●					●				E007
	TPGH110302R-FS	0.2																						●		●								●				
	TPGH110302L-FS	0.2																						●		●		●	●					●				
	TPGH110304R-FS	0.4																						●		●								●				
	TPGH110304L-FS	0.4																						●		●		●	●					●				
	TPGH160304R-FS	0.4																						●		●								●				
	TPGH160304L-FS	0.4																						●		●		●						●				
	TPGH160308R-FS	0.8																						●		●								●				
Finish Cutting	TPGH160308L-FS	0.8																						●		●		●						●				

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	●	✠										◐	✠	✠	●			●	●		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	Applicable Holder Page
R/L	**TPGX080202R**	0.2	E025
	TPGX080202L	0.2	
	TPGX080204R	0.4	
	TPGX080204L	0.4	
	TPGX090202R	0.2	
	TPGX090202L	0.2	
	TPGX090204R	0.4	
	TPGX090204L	0.4	
	TPGX090208R	0.8	
	TPGX090208L	0.8	
	TPGX110302L	0.2	
	TPGX110304R	0.4	
	TPGX110304L	0.4	
	TPGX110308R	0.8	
Finish Cutting	**TPGX110308L**	0.8	
L	**TPMX090204L**	0.4	E025
	TPMX110304L	0.4	
Finish Cutting			
SV	**TPMH080202-SV**	0.2	E007
	TPMH080204-SV	0.4	
	TPMH090202-SV	0.2	
	TPMH090204-SV	0.4	
	TPMH110302-SV	0.2	
	TPMH110304-SV	0.4	
	TPMH110308-SV	0.8	
	TPMH160302-SV	0.2	
	TPMH160304-SV	0.4	
Light Cutting	**TPMH160308-SV**	0.8	
Standard	**TPMX110304**	0.4	E025
	TPMX110308	0.8	
Medium Cutting			
MV	**TPMH080202-MV**	0.2	E007
	TPMH080204-MV	0.4	
	TPMH090202-MV	0.2	
	TPMH090204-MV	0.4	
	TPMH090208-MV	0.8	
	TPMH110302-MV	0.2	
	TPMH110304-MV	0.4	
	TPMH110308-MV	0.8	
	TPMH160304-MV	0.4	
Medium Cutting	**TPMH160308-MV**	0.8	

Order Number	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
TPGX080202R																								●											
TPGX080202L																								●						●		●			
TPGX080204R																								●								●			
TPGX080204L																							●	●						●		●			
TPGX090202R																								●											
TPGX090202L																								●						●		●			
TPGX090204R																								●								●			
TPGX090204L																							●	●						●		●			
TPGX090208R																																●			
TPGX090208L																								●								●			
TPGX110302L																								●						●		●			
TPGX110304R																							●	●								●			
TPGX110304L																							●	●						●		●			
TPGX110308R																								●								●			
TPGX110308L																							●	●						●	●	●			
TPMX090204L																								●											
TPMX110304L																								●											
TPMH080202-SV			▲		●					▲	●											●		●	●	●									
TPMH080204-SV			▲		●					▲	●											●		●	●	●			●						
TPMH090202-SV			▲		●					▲	●											●		●	●	●									
TPMH090204-SV			▲		●					▲	●											●		●	●	●			●						
TPMH110302-SV			▲		●					▲	●											●		●	●	●			●						
TPMH110304-SV			▲		●					▲	●											●		●	●	●			●						
TPMH110308-SV			▲		●					▲	●											●		●	●	●			●						
TPMH160302-SV			▲		●					▲	●											●		●	●	●			●						
TPMH160304-SV			▲		●					▲	●											●		●	●	●			●						
TPMH160308-SV			▲		●					▲	●											●		●	●	●			●						
TPMX110304																								●	●	●									
TPMX110308																								●	●	●									
TPMH080202-MV			▲		●					▲	●											●		●	●	●									
TPMH080204-MV			▲		●					▲	●			●								●		●	●	●	●		●						
TPMH090202-MV			▲		●					▲	●											●		●	●	●									
TPMH090204-MV			▲		●					▲	●			●								●		●	●	●	●		●						
TPMH090208-MV			▲		●									●								●			●	●									
TPMH110302-MV			▲		●					▲	●											●		●	●	●	●		●						
TPMH110304-MV			▲		●					▲	●			●								●		●	●	●	●		●						
TPMH110308-MV			▲		●					▲	●			●								●		●	●	●	●		●						
TPMH160304-MV			▲		●					▲	●			●								●		●	●	●	●		●						
TPMH160308-MV			▲		●					▲	●			●								●		●	●	●	●		●						

● = NEW

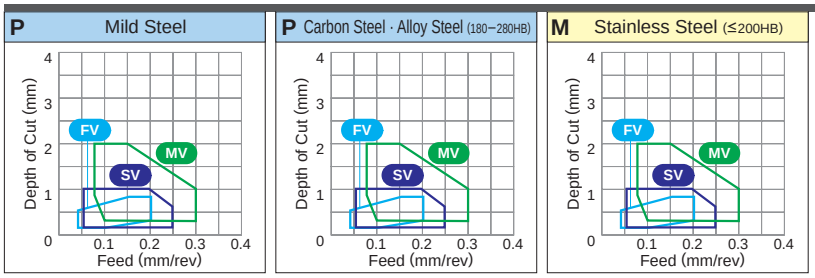
CHIP BREAKERS ➤ A068
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TP TYPE INSERTS WITH HOLE

TPGX 08 02 02
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
						Coated																						Cermet		Coated Cermet				Carbide							
Work Material	P	Steel				●	◐	✣	◐	✣	✣	●														✣	✣	●	◐	◐	●	●	◐	✣					●		
	M	Stainless Steel											◐	✣	○	✣									◐	✣	✣	○				○	○	✣								
	K	Cast Iron																●	◐	●	◐	◐			◐	✣		●			●	●	✣	●	◐				●		
	N	Non-ferrous Metal																																		◐			●		
	S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	●	◐	✣									◐	◐	●			
			Flat Top	TPGX080202	0.2																															●					
				TPGX080204	0.4																					●	●	●						●		●						
				TPGX080208	0.8																							●						●		●						
				TPGX090202	0.2																															●					
				TPGX090204	0.4																						●	●						●		●						
				TPGX090208	0.8																						●	●						●		●						E025
				TPGX110302	0.2																															●					
				TPGX110304	0.4																					●	●	●						●	●	●						
				TPGX110308	0.8																						●	●						●	●	●						
				TPGX160304	0.4																							●						●		●						
				TPGX160308	0.8																													●		●						

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

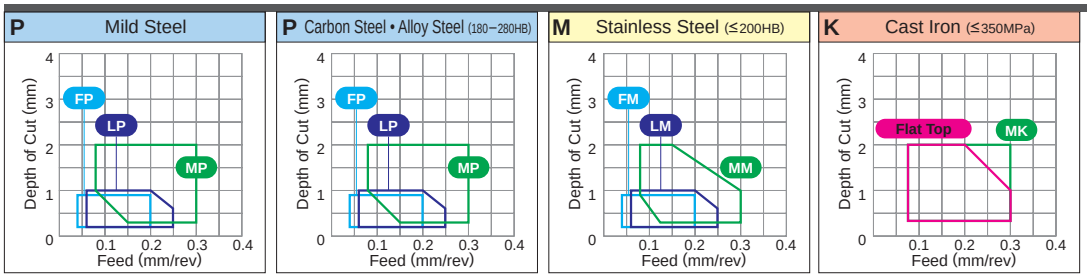
CHIP BREAKERS ➤ A068

35° VB TYPE INSERTS WITH HOLE

VBMT 11 03 02- FP
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
FP	**VBMT110302-FP**	0.2		●		●	●																			●		●										D010
	VBMT110304-FP	0.4		●		●	●																			●		●										D011
	VBMT110308-FP	0.8		●		●	●																			●		●										E011
	VBMT160404-FP	0.4		●		●	●																			●		●										E012
Finish Cutting	**VBMT160408-FP**	0.8		●		●	●																			●		●										H013
FM	**VBMT110302-FM**	0.2																						●														D010
	VBMT110304-FM	0.4																						●														D011
	VBMT110308-FM	0.8																						●														E011
	VBMT160404-FM	0.4																						●														E012
Finish Cutting	**VBMT160408-FM**	0.8																						●														H013
FV	**VBMT110304-FV**	0.4			▲																			●		●	●											D010
	VBMT110308-FV	0.8			▲																			●		●	●											D011
	VBMT160404-FV	0.4			▲																			●		●	●											E011
	VBMT160408-FV	0.8			▲																			●		●	●											E012
Finish Cutting																																						H013
R/L-F	**VBGT110302R-F**	0.2																						●		●		●	●					●				
	VBGT110302L-F	0.2																						●		●		●	●					●				
	VBGT110304R-F	0.4																						●		●			●					●				D010
	VBGT110304L-F	0.4																						●		●			●					●				D011
	VBGT160402R-F	0.2																						●		●			●					●				E011
	VBGT160402L-F	0.2																						●		●			●					●				E012
	VBGT160404R-F	0.4																						●		●			●					●				H013
Finish Cutting	**VBGT160404L-F**	0.4																						●		●			●					●				
LP	**VBMT110304-LP**	0.4		●		●	●																			●		●										D010
	VBMT110308-LP	0.8		●		●	●																			●		●										D011
	VBMT160404-LP	0.4		●		●	●																			●		●										E011
	VBMT160408-LP	0.8		●		●	●																			●		●										E012
Light Cutting																																						H013
LM	**VBMT110304-LM**	0.4								●	●													●														D010
	VBMT110308-LM	0.8								●	●													●														D011
	VBMT160404-LM	0.4								●	●													●														E011
	VBMT160408-LM	0.8								●	●													●														E012
Light Cutting																																						H013

● = NEW

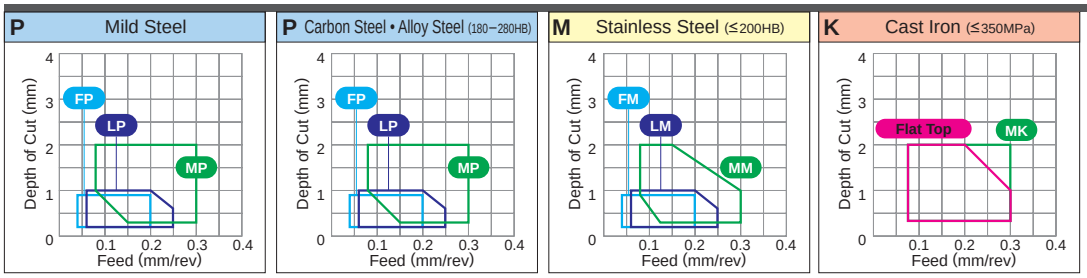
CHIP BREAKERS ➤ A054
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VB TYPE INSERTS WITH HOLE

VBMT 11 03 02- LS
Size / Thickness / Corner Radius / Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																				Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
LS NEW Light Cutting	**VBMT110302-LS**	0.2																		●	●															●		D010
	VBMT110304-LS	0.4																		●	●															●		D011
	VBMT110308-LS	0.8																		●	●															●		E011
	VBMT160404-LS	0.4																		●	●															●		E012
	VBMT160408-LS	0.8																		●	●															●		H013
SV Light Cutting	**VBMT110304-SV**	0.4			▲																			●			●											D010
	VBMT110308-SV	0.8			▲																			●			●											D011
	VBMT160404-SV	0.4			▲																			●			●											E011
	VBMT160408-SV	0.8			▲																			●			●											E012
																																						H013
MP Medium Cutting	**VBMT160404-MP**	0.4		●		●	●																			●		●										
	VBMT160408-MP	0.8		●		●	●																			●		●										
																																						E011 H013
MM Medium Cutting	**VBMT160404-MM**	0.4								●	●													●														
	VBMT160408-MM	0.8								●	●													●														
																																						E011 H013
MK Medium Cutting	**VBMT160404-MK**	0.4													●	●																						
	VBMT160408-MK	0.8													●	●																						
																																						E011 H013
MS NEW Medium Cutting	**VBMT160402-MS**	0.2																		●	●															●		
	VBMT160404-MS	0.4																		●	●															●		
	VBMT160408-MS	0.8																		●	●															●		E011
	VBMT160412-MS	1.2																		●	●															●		H013
Standard Medium Cutting	**VBMT160404**	0.4		●																																		
	VBMT160408	0.8		●																																		
																																						E011 H013

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
MV Medium Cutting	**VBMT110304-MV**	0.4			▲		●					▲	●			●								●		●	●	●	●		●							D010 D011 E011 E012 H013
	VBMT110308-MV	0.8			▲		●					▲	●			●								●		●	●	●	●		●							
	VBMT160404-MV	0.4			▲		●					▲	●			●								●		●	●	●	●		●							
	VBMT160408-MV	0.8			▲		●					▲	●			●								●		●	●	●	●		●							
R/L-SR Medium Cutting	**VBET1103V3R-SR**	0.03																						●		●								●				D010 D011 E011 E012
	VBET1103V3L-SR	0.03																						●		●								●				
	VBET110301R-SR	0.1																						●		●								●				
	VBET110301L-SR	0.1																						●		●								●				
	VBET110302R-SR	0.2																						●		●								●				
	VBET110302L-SR	0.2																						●		●								●				
	VBET110304R-SR	0.4																						●		●								●				
	VBET110304L-SR	0.4																						●		●								●				
R/L-SN Medium Cutting	**VBET1103V3R-SN**	0.03																						●		●								●				D010 D011 E011 E012
	VBET1103V3L-SN	0.03																						●		●								●				
	VBET110300R-SN	0																						●		●								●				
	VBET110300L-SN	0																						●		●								●				
	VBET110301R-SN	0.1																						●		●								●				
	VBET110301L-SN	0.1																						●		●								●				
	VBET110302R-SN	0.2																						●		●								●				
	VBET110302L-SN	0.2																						●		●								●				
	VBET110304R-SN	0.4																						●		●								●				
	VBET110304L-SN	0.4																						●		●								●				
R/LW-SN * Medium Cutting (Wiper)	**VBET1103V3RW-SN**	0.03																						●														D010 D011 E011 E012
	VBET1103V3LW-SN	0.03																						●														
Flat Top	**VBMW160408**	0.8													●	●																						E011 H013

* Please refer to A028 before using the R/LW-SN breaker (wiper insert).

● = NEW

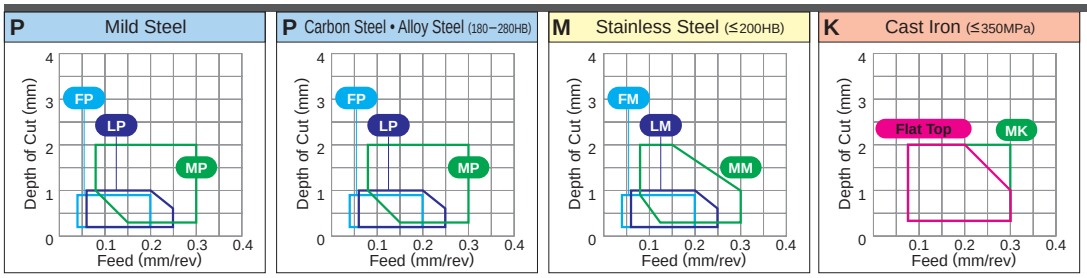
CHIP BREAKERS ➤ A054
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VC TYPE INSERTS WITH HOLE

VCMT 11 03 02- FP
Size / Thickness / Corner Radius / Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
FP	**VCMT110302-FP**	0.2		●		●	●																			●		●										C028
	VCMT110304-FP	0.4		●		●	●																			●		●										C029
	VCMT160404-FP	0.4		●		●	●																			●		●										D011
	VCMT160408-FP	0.8		●		●	●																			●		●										E032
Finish Cutting																																						E033
FM	**VCMT110302-FM**	0.2																						●														C028
	VCMT110304-FM	0.4																						●														C029
	VCMT160404-FM	0.4																						●														D011
	VCMT160408-FM	0.8																						●														E032
Finish Cutting																																						E033
FV	**VCMT080202-FV**	0.2			▲		●																	●		●	●	●										C028
	VCMT080204-FV	0.4			▲		●																	●		●	●	●										C029
	VCMT160404-FV	0.4		●	▲																					●	●		●									E011
	VCMT160408-FV	0.8		●	▲																					●	●		●									E012
Finish Cutting																																						E032
																																						E033
AZ	**VCGT160404-AZ**	0.4																															●					
	VCGT160408-AZ	0.8																															●					C028
	VCGT160412-AZ	1.2																															●					C029
Medium Cutting – Finish Cutting																																						E032
																																						E033
R/L-F	**VCGT080202R-F**	0.2																						●		●			●				●					
	VCGT080202L-F	0.2																						●		●			●				●					E011
	VCGT080204R-F	0.4																						●		●			●				●					E012
	VCGT080204L-F	0.4																						●		●			●				●					
Finish Cutting																																						
LP	**VCMT110304-LP**	0.4		●		●	●																			●		●										C028
	VCMT110308-LP	0.8		●		●	●																			●		●										C029
	VCMT160404-LP	0.4		●		●	●																			●		●										D011
	VCMT160408-LP	0.8		●		●	●																			●		●										E032
Light Cutting																																						E033
LM	**VCMT110304-LM**	0.4								●	●													●														C028
	VCMT110308-LM	0.8								●	●													●														C029
	VCMT160404-LM	0.4								●	●													●														D011
	VCMT160408-LM	0.8								●	●													●														E032
Light Cutting																																						E033

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐			●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	Applicable Holder Page
LS NEW Light Cutting	**VCMT110302-LS**	0.2	C028
	VCMT110304-LS	0.4	C029
	VCMT160404-LS	0.4	D011
	VCMT160408-LS	0.8	E032
			E033
LS NEW Light Cutting	**VCGT110301M-LS**	0.08	C028 D011 E032 E033
	VCGT110302M-LS	0.18	
	VCGT110304M-LS	0.38	
	VCGT130301M-LS	0.08	
	VCGT130302M-LS	0.18	
	VCGT130304M-LS	0.38	
LS-P NEW Light Cutting	**VCGT110301M-LS-P**	0.08	C028 D011 E032 E033
	VCGT110302M-LS-P	0.18	
	VCGT110304M-LS-P	0.38	
	VCGT130301M-LS-P	0.08	
	VCGT130302M-LS-P	0.18	
	VCGT130304M-LS-P	0.38	
SV Light Cutting	**VCMT080202-SV**	0.2	E011 E012
	VCMT080204-SV	0.4	
MP Medium Cutting	**VCMT160404-MP**	0.4	C028 C029 E032 E033
	VCMT160408-MP	0.8	
	VCMT160412-MP	1.2	
MM Medium Cutting	**VCMT160404-MM**	0.4	C028 C029 E032 E033
	VCMT160408-MM	0.8	
	VCMT160412-MM	1.2	
MK Medium Cutting	**VCMT160404-MK**	0.4	C028 C029 E032 E033
	VCMT160408-MK	0.8	
MS NEW Medium Cutting	**VCMT110302-MS**	0.2	C028 C029 D011 E032 E033
	VCMT110304-MS	0.4	
	VCMT110308-MS	0.8	
	VCMT160404-MS	0.4	
	VCMT160408-MS	0.8	

● = NEW

POSI 7°
WITH HOLE

C D R S T V W X

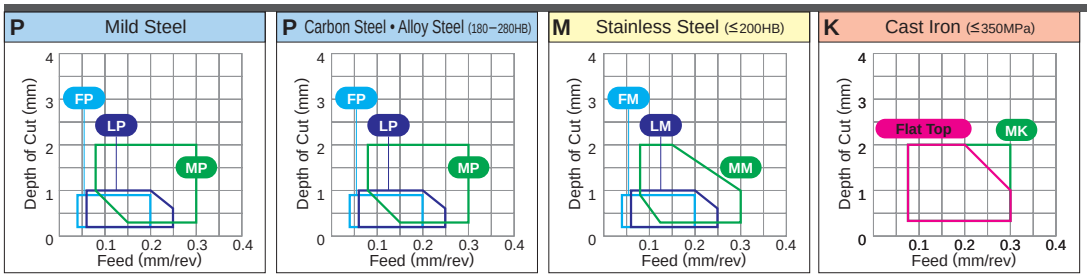
CHIP BREAKERS ➤ A060
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VC TYPE INSERTS WITH HOLE

VCMT 11 03 04
Size Thickness Corner Radius
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15
			Coated																							Cermet		Coated Cermet				Carbide					
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●
	M	Stainless Steel								◐	✣	○	✣									◐	✣	✣	○				○	○		✣					
	K	Cast Iron													●	◐	●	◐	◐			◐	✣		●			●	●		✣	●	◐				●
	N	Non-ferrous Metal																															◐				●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣									◐	◐	●		

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
Standard	**VCMT110304**	0.4		●	▲								●											●		●	●	●	●			●		●				C028
	VCMT160404	0.4	●	●	▲								●					●						●		●	●	●	●			●		●				C029
	VCMT160408	0.8	●	●	▲								●					●						●		●	●	●	●			●						D011
	VCMT160412	1.2		●	▲								●													●	●											E032
Medium Cutting																																						E033
MV	**VCMT080202-MV**	0.2			▲		●					▲	●											●		●	●	●	●		●							
	VCMT080204-MV	0.4			▲		●					▲	●			●								●		●	●	●	●		●							E011
																																						E012
Medium Cutting																																						
Flat Top	**VCMW110304**	0.4																																●				
	VCMW160404	0.4													●	●	●	●																●				C028
	VCMW160408	0.8													●	●	●	●	●															●				C029
																																						E032
																																						E033

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

CHIP BREAKERS ➤ A060

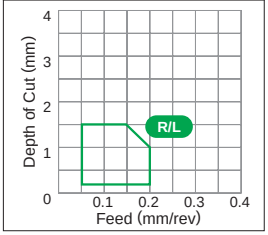
35° VD TYPE INSERTS WITH HOLE

VDGX 16 03 02 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting

N Aluminium Alloy



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●	
	M	Stainless Steel								◐	✠	○	✠										◐	✠	✠	○			○	○		✠						
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●	
	N	Non-ferrous Metal																																◐		●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●		
Shape	Order Number	RE (mm)																																				
R/L Medium Cutting (For Aluminium)	VDGX160302R	0.2																																●				C034
	VDGX160302L	0.2																																●				
	VDGX160304R	0.4																																●				
	VDGX160304L	0.4																																●				

● = NEW

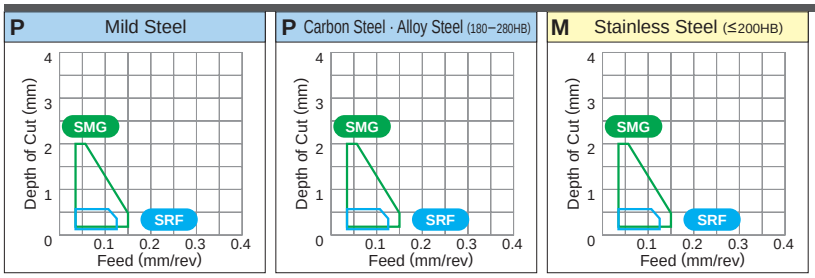
CHIP BREAKERS ➤ A072
GRADES ➤ A030
IDENTIFICATION ➤ A002

35° VP TYPE INSERTS WITH HOLE

VPGT 08 02 01 R-SRF
Size Thickness Corner Radius R/L Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	Applicable Holder Page
						Coated																						Cermet		Coated Cermet				Carbide						
Work Material	P	Steel				●	◐	✣	◐	✣	✣	●														✣	✣	●	◐	◐	●	●	◐	✣				●		
	M	Stainless Steel											◐	✣	○	✣									◐	✣	✣	○			○	○		✣						
	K	Cast Iron																●	◐	●	◐	◐			◐	✣		●			●	●		✣	●	◐			●	
	N	Non-ferrous Metal																																		◐		●	
	S	Heat-resistant Alloy, Titanium Alloy															●						●	◐	●	◐	✣									◐	◐	●		
R/L-SRF				VPET080201R-SRF	0.1																						●													
				VPET080201L-SRF	0.1																						●													
				VPET080202R-SRF	0.2																						●													
				VPET080202L-SRF	0.2																						●													
				VPET1103V3R-SRF	0.03																						●													D010 D011
				VPET1103V3L-SRF	0.03																						●													
				VPET110301R-SRF	0.1																						●													
				VPET110301L-SRF	0.1																						●													
				VPET110302R-SRF	0.2																						●													
		Finish Cutting		VPET110302L-SRF	0.2																						●													
SMG				VPGT080201M-SMG	0.1																						●													
				VPGT080202M-SMG	0.2																						●													
				VPGT110301M-SMG	0.1																						●													D010 D011
				VPGT110302M-SMG	0.2																						●													
		Medium Cutting																																						

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

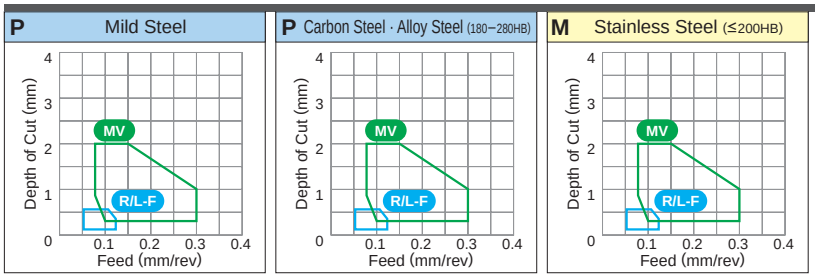
CHIP BREAKERS ➤ A068

80° WB TYPE INSERTS WITH HOLE

WBGT 02 01 V3 L-F
Size Thickness Corner Radius R/L Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●	
	M	Stainless Steel								◐	✠	○	✠									◐	✠	✠	✠	○			○	○		✠						
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●	
	N	Non-ferrous Metal																																◐			●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●		
Shape	Order Number	RE (mm)																																				
R/L-F	WBGT0201V3L-F	0.03																						●		●												
	WBGT020101L-F	0.1																						●		●												
	WBGT020102L-F	0.2																						●		●		●										
	WBGT020104L-F	0.4																						●		●		●										
	WBGTL302V3L-F	0.03																						●		●												E010
	WBGTL30201L-F	0.1																						●		●												E016
	WBGTL30202R-F	0.2																						●		●												
	WBGTL30202L-F	0.2																						●		●		●										
	WBGTL30204R-F	0.4																						●		●												
Finish Cutting	WBGTL30204L-F	0.4																						●		●		●										
R/L-MV	WBMTL30202R-MV	0.2			▲		●					▲												●		●	●	●			●							
	WBMTL30202L-MV	0.2			▲		●					▲												●		●	●	●			●							
	WBMTL30204R-MV	0.4			▲		●					▲												●		●	●	●			●							E010
	WBMTL30204L-MV	0.4			▲		●					▲												●		●	●	●			●							E016
Medium Cutting																																						

● = NEW

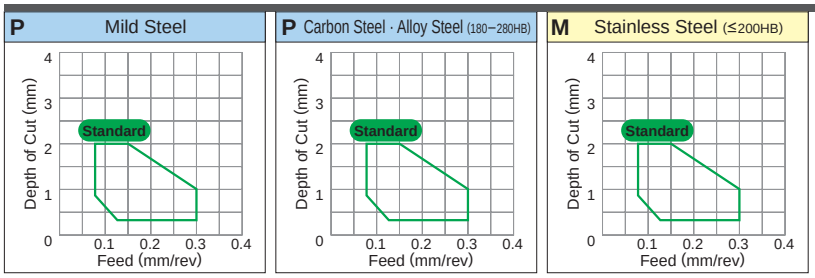
CHIP BREAKERS ➤ A054
GRADES ➤ A030
IDENTIFICATION ➤ A002

80° WC TYPE INSERTS WITH HOLE

WCGT 02 01 02 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
P	Steel		●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
M	Stainless Steel									◐	✣	○	✣										◐	✣	✣	○			○	○		✣						
K	Cast Iron														●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
N	Non-ferrous Metal																																	◐			●	
S	Heat-resistant Alloy, Titanium Alloy													●						●	◐	●	◐	✣										◐	◐	●		
Shape	Order Number	RE (mm)																																				
R/L Finish Cutting	WCGT020102R	0.2																								●												E027
	WCGTL020102L	0.2																								●							●					
	WCGT020104R	0.4																								●												
	WCGT020104L	0.4																								●							●					
	WCGTL30202L	0.2																								●												
	WCGTL30204L	0.4																								●												
Standard Medium Cutting	WCMT020102	0.2		●	▲								●													●	●	●	●			●						E027
	WCMT020104	0.4		●	▲								●													●	●	●	●			●						
	WCMTL30202	0.2		●									●													●	●	●	●			●						
	WCMTL30204	0.4		●									●													●	●	●	●			●						
	WCMT040202	0.2		●	▲								●													●	●	●	●			●						
	WCMT040204	0.4		●	▲								●													●	●	●	●			●						
	WCMT040208	0.8			▲																																	
	WCMT06T304	0.4		●	▲								●													●	●	●	●			●						
	WCMT06T308	0.8		●	▲								●													●	●	●	●			●						

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

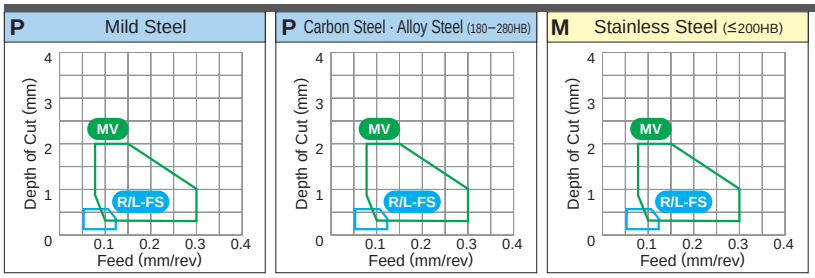
CHIP BREAKERS ➤ A060

80° WP TYPE INSERTS WITH HOLE

WPMT 04 02 04 R-FS
Size Thickness Corner Radius R/L Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																							Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
	M	Stainless Steel								◐	✣	○	✣										◐	✣	✣	○			○	○		✣						
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
	N	Non-ferrous Metal																																◐			●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●		
Shape	Order Number	RE (mm)																																				
R/L-FS Finish Cutting	WPGT040204R-FS	0.4																						●		●												E010
	WPGT040204L-FS	0.4																						●		●												
	WPGT060304R-FS	0.4																						●		●												
	WPGT060304L-FS	0.4																						●		●												
MV Medium Cutting	WPMT040202-MV	0.2			▲		●					▲	●											●		●	●	●										E010
	WPMT040204-MV	0.4			▲		●					▲	●			●								●		●	●	●			●							
	WPMT060304-MV	0.4			▲		●					▲	●			●								●		●	●	●										
	WPMT060308-MV	0.8			▲		●					▲	●			●								●		●	●	●			●							

● = NEW

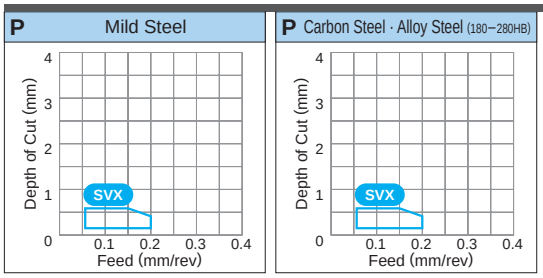
CHIP BREAKERS	➤ A068
GRADES	➤ A030
IDENTIFICATION	➤ A002

25° XC TYPE INSERTS WITH HOLE

XCMT 15 03 02- SVX
Size Thickness Corner Radius Chip Breaker
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material			Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	
	P	Steel	●	◐	✣	◐	✣	✣	●															✣	✣	●	◐	◐	●	●	◐	✣					●	
	M	Stainless Steel								◐	✣	○	✣										◐	✣	✣	○			○	○		✣						
	K	Cast Iron													●	◐	●	◐	◐				◐	✣		●			●	●		✣	●	◐			●	
	N	Non-ferrous Metal																																◐		●	
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✣										◐	◐	●		
Shape	Order Number	RE (mm)																																				
SVX Finish Cutting	XCMT150302-SVX	0.2																						●														C030
	XCMT150304-SVX	0.4			▲																			●														
	XCMT150308-SVX	0.8			▲																			●														

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

CHIP BREAKERS ➤ A060

RTG TYPE INSERTS WITHOUT HOLE

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
			Coated																							Cermet		Coated Cermet				Carbide					
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	●	✠										◐	✠	✠	●			●	●		✠					
	K	Cast Iron													●	◐	●	◐	◐				◐	✠		●			●	●		✠	●	◐			●
	N	Non-ferrous Metal																																◐		●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠										◐	◐	●	

Shape	Order Number	RE (mm)	Applicable Holder Page
For Special Use (For TL Holder)	**RTG05A**	–	C035
	RTG06A	–	
	RTG07A	–	
	RTG08A	–	
	RTG10A	–	

● = NEW

A
TURNING INSERTS
POSI 6°
WITHOUT HOLE
C
D
R
S
T
V
W
X

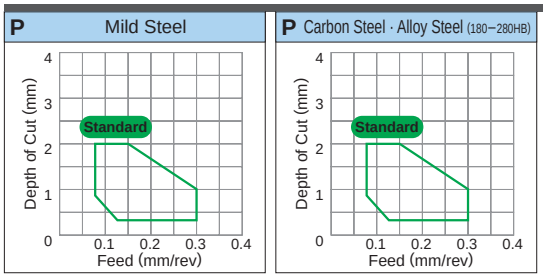
GRADES ➤ A030
IDENTIFICATION ➤ A002

90° SP TYPE INSERTS WITHOUT HOLE

SPGR 09 03 04 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Medium Cutting·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
R Finish Cutting	**SPGR090304R**	0.4																														●						—
Standard Medium Cutting	**SPMR090304**	0.4		●	▲																					●	●	●										—
	SPMR090308	0.8		●	▲																					●	●	●										
	SPMR120304	0.4		●	▲																					●	●	●										
	SPMR120308	0.8		●	▲																					●	●	●										
Flat Top	**SPMN090304**	0.4																								●						●		●				—
	SPMN090308	0.8		●																						●						●		●				
	SPMN120304	0.4		●																				●								●		●				
	SPMN120304T	0.4																								●												
	SPMN120308	0.8		●																				●	●							●		●				
	SPMN120312	1.2		●	▲																			●								●		●				
	SPMN120408	0.8																														●		●				
	SPMN120412	1.2																														●						
	SPMN150408	0.8																														●						
	SPMN150412	1.2																														●						
	SPMN190404	0.4																														●						
	SPMN190408	0.8																														●						
	SPMN190412	1.2																														●						
Flat Top	**SPGN090304**	0.4																								●						●		●				—
	SPGN090308	0.8																																●				
	SPGN120304	0.4																								●						●		●				
	SPGN120308	0.8																							●	●						●		●				
	SPGN120312	1.2																																●				
	SPGN120404	0.4																																●				
	SPGN120408	0.8																														●		●				
	SPGN150404	0.4																														●						
	SPGN150408	0.8																																●				

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

CHIP BREAKERS ➤ A074

60° TC TYPE INSERTS WITHOUT HOLE

TCGN 06 01 04
Size Thickness Corner Radius
★ Please refer to page A002.

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Work Material			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15
	P	Steel	●	◐	✠	◐	✠	✠	●															✠	✠	●	◐	◐	●	●	◐	✠					●
	M	Stainless Steel								◐	✠	●	✠									◐	✠	✠	●				●	●		✠					
	K	Cast Iron													●	◐	●	◐	◐			◐	✠		●			●	●		✠	●	◐				●
	N	Non-ferrous Metal																															◐				●
	S	Heat-resistant Alloy, Titanium Alloy												●						●	◐	●	◐	✠									◐	●	●		

Shape	Order Number	RE (mm)	UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	MH515 (NEW)	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HTi10	RT9010	MT9005	TF15	Applicable Holder Page
			Coated																							Cermet		Coated Cermet				Carbide						
Flat Top	**TCGN060104**	0.4																															●					—
	TCGN090204	0.4																															●					

● = NEW

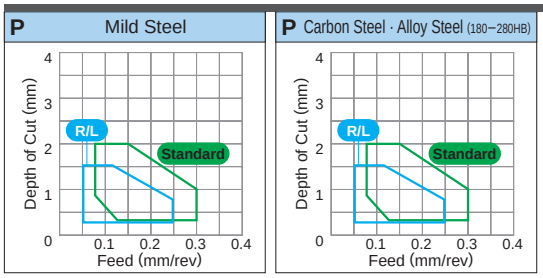
CHIP BREAKERS ➤ A074
GRADES ➤ A030
IDENTIFICATION ➤ A002

60° TP TYPE INSERTS WITHOUT HOLE

TPGR 11 03 04 R
Size Thickness Corner Radius R/L
★ Please refer to page A002.

CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Medium Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Order Number	RE (mm)	Coated																					Cermet		Coated Cermet				Carbide					Applicable Holder Page
			UE6105	UE6110	UE6020	MC6015	MC6025	UH6400	MS6015	MC7025	MP7035	US7020	US735	US905	MC5005	MC5015	UC5105	UC5115	NEW MH515	MP9005	MP9015	VP05RT	VP10RT	VP15TF	UP20M	NX2525	NX3035	MP3025	AP25N	VP25N	VP45N	UTi20T	HTi05T	HT10	RT9010	MT9005	TF15	
R/L	**TPGR110304R**	0.4																								●								●				
	TPGR110304L	0.4																								●						●		●				
	TPGR160304R	0.4																								●						●		●				E026
	TPGR160304L	0.4																								●						●		●				
	TPGR160308R	0.8																								●												
Finish Cutting	**TPGR160308L**	0.8																								●						●		●				
Standard	**TPMR090202**	0.2																									●	●										
	TPMR090204	0.4																								●	●	●										
	TPMR090208	0.8																										●										
	TPMR110302	0.2																								●	●	●										
	TPMR110304	0.4		●	●																					●	●	●										E026
	TPMR110308	0.8		●	●																					●	●	●										
	TPMR160304	0.4		●	●																					●	●	●										
	TPMR160308	0.8		●	●																					●	●	●										
Medium Cutting	**TPMR160312**	1.2		●																							●	●										
Flat Top	**TPMN110304**	0.4		●											●	●	●	●							●	●						●		●				
	TPMN110308	0.8		●											●	●	●	●								●						●		●				
	TPMN160304	0.4		●											●	●	●	●						●	●	●						●		●				
	TPMN160308	0.8		●											●	●	●	●						●	●	●						●	●	●				
	TPMN160312	1.2		●											●	●	●	●							●									●				E026
	TPMN160320	2.0																														●						
	TPMN220404	0.4		●																												●						
	TPMN220408	0.8		●	●																			●	●							●		●				
	TPMN220412	1.2		●																				●								●		●				
Flat Top	**TPGN110302**	0.2																																●				
	TPGN110304	0.4																								●						●	●	●				
	TPGN110308	0.8																							●									●				
	TPGN160302	0.2																																●				
	TPGN160304	0.4																							●	●						●	●	●				
	TPGN160308	0.8																							●	●						●	●	●				E026
	TPGN160312	1.2																																●				
	TPGN160316	1.6																																●				
	TPGN160408	0.8																														●						
	TPGN220404	0.4																							●									●				
	TPGN220408	0.8																							●									●				

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

CHIP BREAKERS ➤ A074
GRADES ➤ A030
IDENTIFICATION ➤ A002

Memo

HOW TO READ THE STANDARD OF CBN & PCD TURNING INSERTS

●How this section page is organised

①Organised according to turning insert shape.
(Refer to the index on the next page.)

②Inserts are arranged in order of :

- Negative inserts (with hole→without hole)
- Positive inserts (with hole→without hole)

GRADE APPLICATION RECOMMENDED FOR EACH WORK MATERIAL
cutting conditions suitable for each type of work material is shown as a general guide to select the grade.
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

FIGURE SHOWING THE INSERT GEOMETRY
IC : Diameter of Inscribed Circle S : Thickness RE : Corner Radius
LE : Cutting edge effective length D1 : Diameter of Hole
Dimensions are detailed in the "Dimensions" column.

STOCK STATUS

INSERT NUMBER

INSERT GRADES

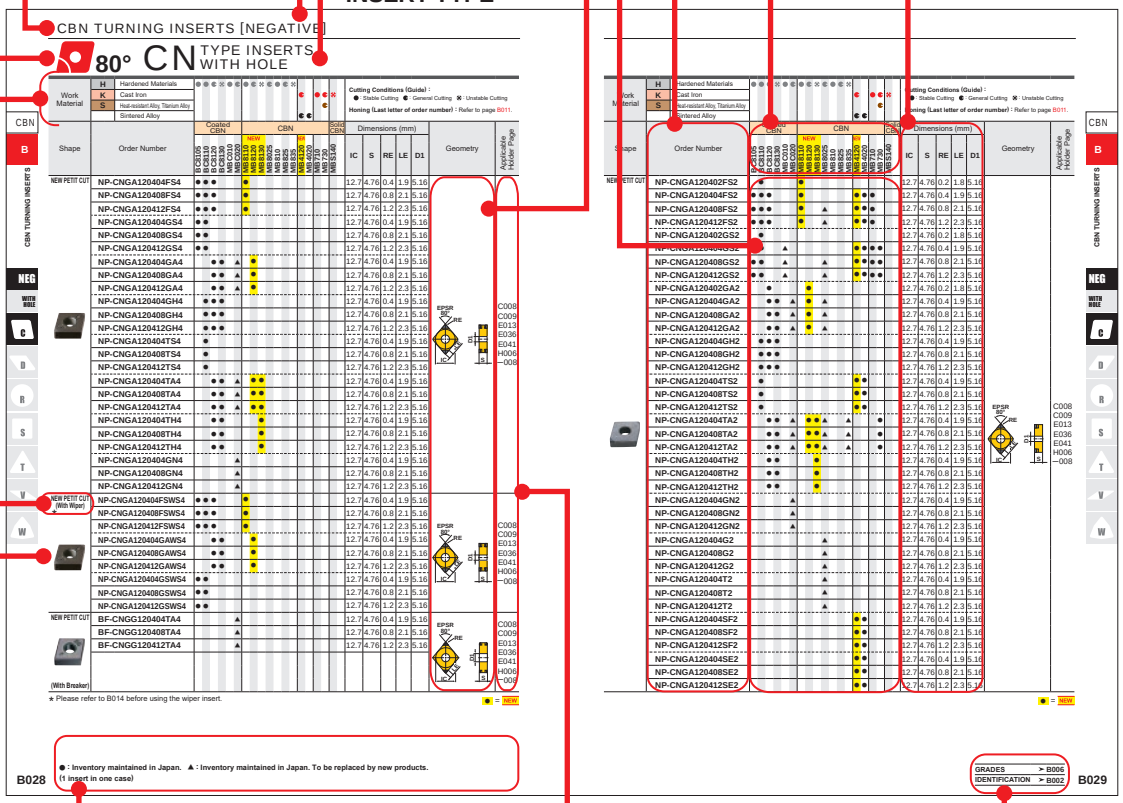
INSERT DIMENSIONS

SHAPE & ANGLE MARK

INDICATION OF NEGATIVE/POSITIVE TYPE

TITLE OF PRODUCT ACCORDING TO THE INSERT TYPE

PRODUCT SECTION



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

PHOTO OF INSERT

PRODUCT NAME

PAGE REFERENCE
·GRADES
·TECHNICAL DATA
indicates reference pages, on the right hand page of each double-page spread.

APPLICABLE HOLDER PAGE
indicates reference pages for details of applicable holders.

●To Order : Please specify
①insert number and ②grade.

TURNING TOOLS

CBN & PCD INSERT STANDARDS
CBN & PCD INSERT GRADES

IDENTIFICATION B002
CLASSIFICATION OF CBN & PCD GRADES B004
CBN (CUBIC BORON NITRIDE) B006
PCD (SINTERED DIAMOND) B021
CLASSIFICATION OF CBN & PCD INSERTS B022

STANDARD OF CBN TURNING INSERTS

NEGATIVE INSERTS WITH HOLE
CN○○TYPE···RHOMBIC 80° B028
DN○○TYPE···RHOMBIC 55° B032
SN○○TYPE···SQUARE 90° B037
TN○○TYPE···TRIANGULAR 60° B039
VN○○TYPE···RHOMBIC 35° B042
WN○○TYPE···TRIGON 80° B044

NEGATIVE INSERTS WITHOUT HOLE
CN○○TYPE···RHOMBIC 80° B045
DN○○TYPE···RHOMBIC 55° B045
RN○○TYPE···ROUND B046
SN○○TYPE···SQUARE 90° B047
TN○○TYPE···TRIANGULAR 60° B048

POSITIVE INSERTS WITH HOLE
CC○○TYPE···RHOMBIC 80° B049
CP○○TYPE···RHOMBIC 80° B053
DC○○TYPE···RHOMBIC 55° B054
TC○○TYPE···TRIANGULAR 60° B057
TP○○TYPE···TRIANGULAR 60° B058
VB○○TYPE···RHOMBIC 35° B061
VC○○TYPE···RHOMBIC 35° B062
WC○○TYPE···TRIGON 80° B063

POSITIVE INSERTS WITHOUT HOLE
SP○○TYPE···SQUARE 90° B064
TB○○TYPE···TRIANGULAR 60° B065
TP○○TYPE···TRIANGULAR 60° B065
RTG TYPE B063
GY TYPE B066
MGTR TYPE B067

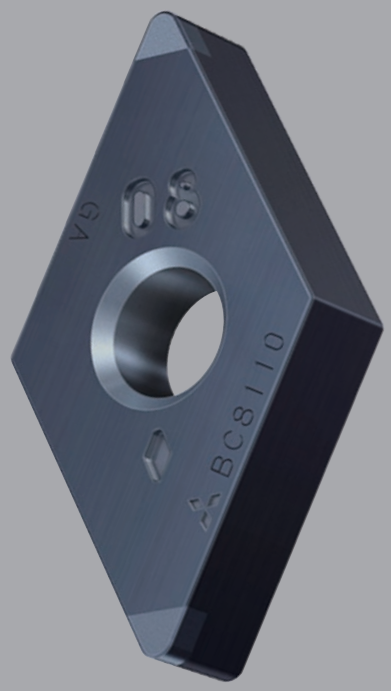
STANDARD OF PCD TURNING INSERTS

NEGATIVE INSERTS WITH HOLE
CN○○TYPE···RHOMBIC 80° B068
DN○○TYPE···RHOMBIC 55° B068
SN○○TYPE···SQUARE 90° B069
TN○○TYPE···TRIANGULAR 60° B069
VN○○TYPE···RHOMBIC 35° B070

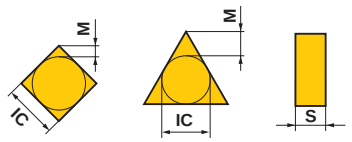
NEGATIVE INSERTS WITHOUT HOLE
SN○○TYPE···SQUARE 90° B071

POSITIVE INSERTS WITH HOLE
CC○○TYPE···RHOMBIC 80° B072
CP○○TYPE···RHOMBIC 80° B072
DC○○TYPE···RHOMBIC 55° B073
SP○○TYPE···SQUARE 90° B073
TC○○TYPE···TRIANGULAR 60° B074
TP○○TYPE···TRIANGULAR 60° B075
VB○○TYPE···RHOMBIC 35° B077
VC○○TYPE···RHOMBIC 35° B077
WC○○TYPE···TRIGON 80° B078
WP○○TYPE···TRIGON 80° B078
DE○○TYPE···RHOMBIC 55° B079
TE○○TYPE···TRIANGULAR 60° B079
VD○○TYPE···RHOMBIC 35° B080

POSITIVE INSERTS WITHOUT HOLE
SP○○TYPE···SQUARE 90° B081
TP○○TYPE···TRIANGULAR 60° B081



IDENTIFICATION



Symbol	Tolerance of Nose Height **M** (mm)	Tolerance of Inscribed Circle **IC** (mm)	Tolerance of Thickness **S** (mm)
G	±0.025	±0.025	±0.13
M*	±0.08–±0.18	±0.05–±0.15	±0.13

The surface of insert with * mark is sintered.

Detail of M Class Insert Tolerance

● Tolerance of Nose Height **M** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.08	±0.08	±0.08	±0.11	±0.16	–
9.525	±0.08	±0.08	±0.08	±0.11	±0.16	–
12.70	±0.13	±0.13	±0.13	±0.15	–	–

● Tolerance of Inscribed Circle **IC** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.05	±0.05	±0.05	±0.05	±0.05	–
9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
12.70	±0.08	±0.08	±0.08	±0.08	–	±0.08

⑤ Tolerance Class

T	10-inserts Package
No mark	1-insert Package

① Insert Case

BM	With Breaker
BF	With Breaker
NP	New Petit Cut
No mark	Standard Type

② Insert Geometry

①	②		③	④	⑤	⑥
T	**NP**	**-**	**C**	**N**	**G**	**A**

③ Insert Shape

Symbol	Insert Shape
S	Square
T	Triangular
C	Rhombic 80°
D	Rhombic 55°
V	Rhombic 35°
W	Trigon
R	Round

④ Normal Clearance

Symbol	Normal Clearance
B	5°
C	7°
D	15°
E	20°
N	0°
P	11°

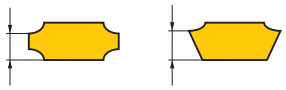
⑥ Fixing and/or for Chip Breaker

Metric

Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole + One Countersink (40–60°)	No	
T	With Hole		One Sided	
B	With Hole	Cylindrical Hole + One Countersink (70–90°)	No	
H	With Hole		One Sided	
A	With Hole	Cylindrical Hole	No	
M	With Hole	Cylindrical Hole	One Sided	
N	Without Hole	–	No	
X	–	–	–	Special Design

Diameter of Inscribed Circle (mm)	Symbol						
	R	W	V	D	C	S	T
3.97		02		04	03	03	06
4.76		L3	08	05	04	04	08
5.56		03	09	06	05	05	09
6.35		04	11	07	06	06	11
7.94		05	13	09	08	07	13
9.525	09	06	16	11	09	09	16
12.70	12	08	22	15	12	12	22

⑦ Insert Size



*Thickness is from the bottom of the insert to the top of the cutting edge.

Symbol	Thickness (mm)
S1	1.39
01	1.59
T0	1.79
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76

⑧ Insert Thickness

Symbol	Corner Radius (mm)
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6

⑨ Insert Corner Configuration

⑦	⑧	⑨					
12	04	04	G	WS	2	J	R
			⑩	⑪	⑫	⑬	⑭

⑩ Application (Honing)

Symbol	Honing
GS GA GB GH GN G	General Cutting
FS FA FB F	Continuous Cutting
TS TA TH T	Interrupted Cutting
SF SE	Cutting Sintered Alloys

Refer to the Honing on page B016 for details.

⑪ Wiper

WS	For High Rigidity Workpiece Material
WL	For Deflection and Vibration Prevention
No mark	Without Wiper

⑫ Number of Teeth

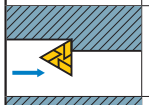
2	2
3	3
4	4
6	6
No mark	1

⑬ Cutting Edge Angle

F	91°
J	93°
No mark	Non Restriction

Please pay special attention when using an indexable insert.

⑭ Cutting Direction

Figure	Hand	Symbol
	Right	R
	Left	L
	Neutral	N

CLASSIFICATION OF CBN & PCD GRADES

FEATURES

NON-COATED CBN MATERIALS

CBN sintered materials base cutting tools are produced by binding CBN (cubic Boron Nitride) and ceramic having hardness next to diamond and sintering under ultra-high pressure and high temperature.
CBN has lower affinity to iron than diamond. The low affinity and high hardness properties means that sintered CBN delivers a superior cutting performance especially during high speed machining of materials such hardened steel, cast iron and sintered alloys etc.

COATED CBN MATERIALS

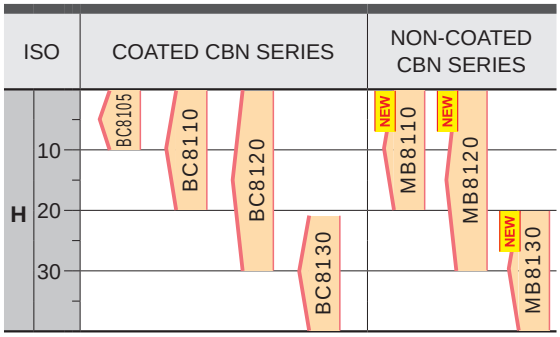
To achieve longer tool life, Mitsubishi uses a unique "Particle-activated Sintering Method", combined with increased cutting edge strength. With high crater wear resistance CBN grades and a wear resistant ceramic coatings, longer tool life and improved machine efficiency are obtained.

PCD MATERIALS (Sintered Diamond)

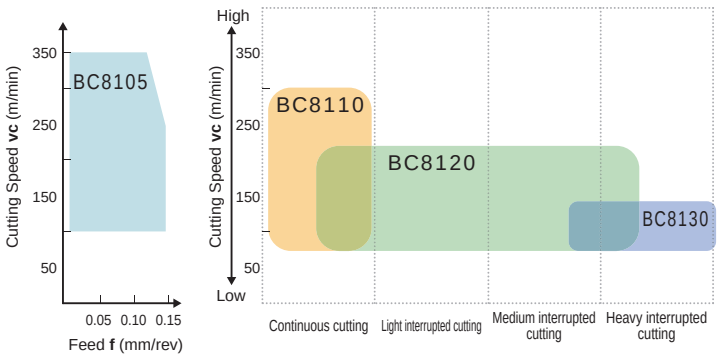
Suitable for cutting materials such as nonferrous metals and fiber reinforced plastics (FRP) including aluminium alloys.
It supports ultra high speed finish cutting.

■ Work materials for turning grades/application area

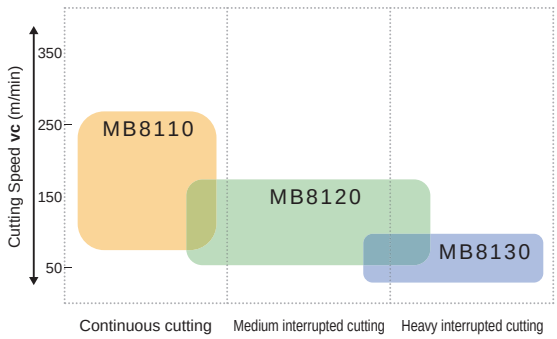
●Hardened Steel



COATED CBN MATERIALS



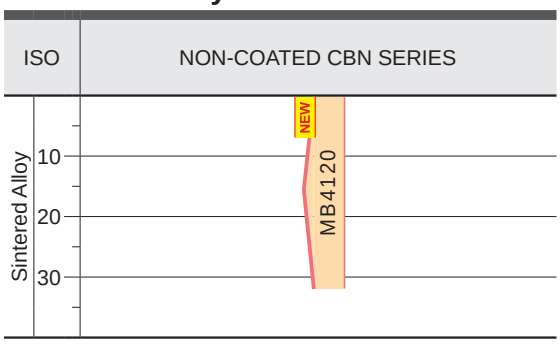
NON-COATED CBN MATERIALS

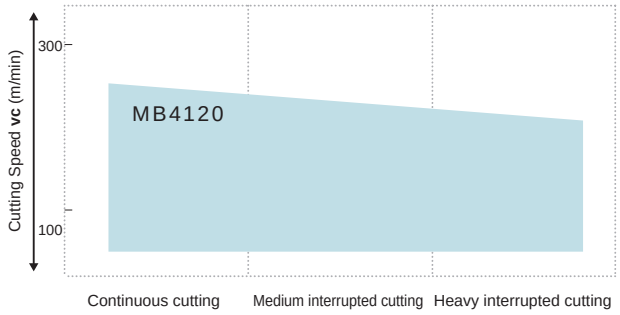


Suitable for finishing with surface roughness Ra 0.6 μm or Rz 2.4 μm or less.

Coated CBN Grade BC8100 and Non-coated CBN Grade MB8100 for high-hardness steel processing are available in a wide range of areas from finishing to continuous cutting of hardened steels and strongly interrupted machining.

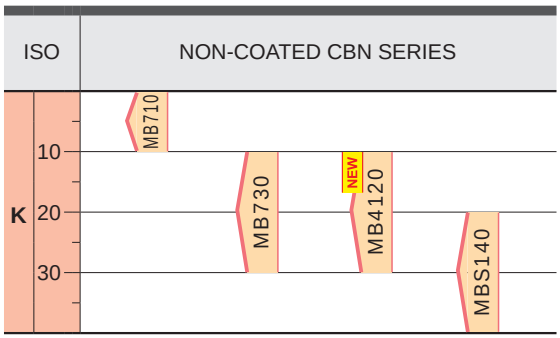
●Sintered Alloy

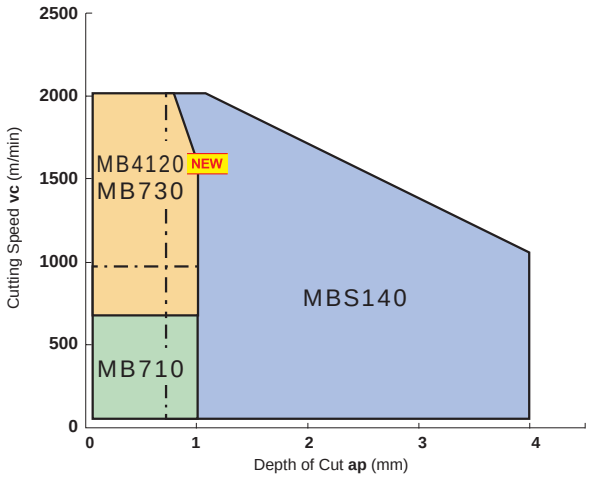




The CBN grade “MB4120” for sintered alloy and cast iron cutting can be used widely from continuous cutting to interrupted cutting in the processing of cast irons such as sintered alloys for valve mechanism parts and oil pump parts.

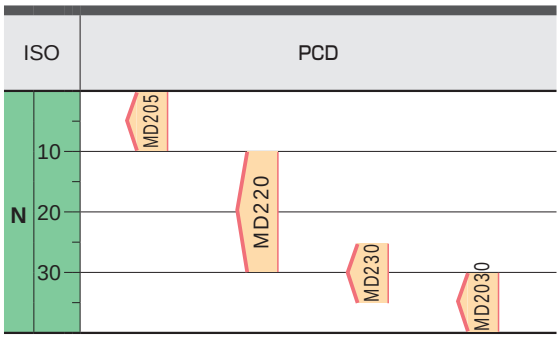
●Cast Iron

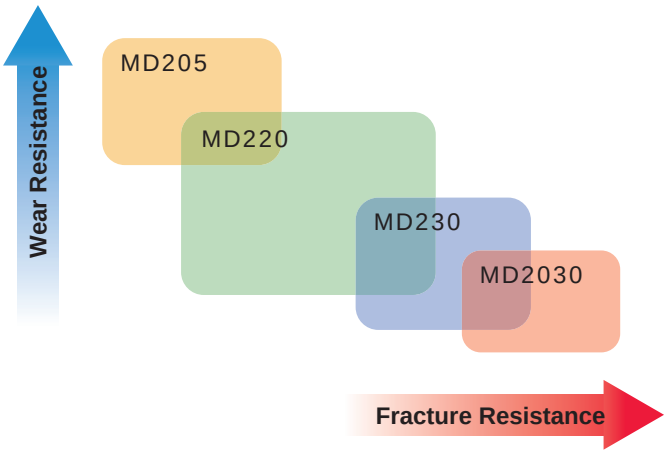




Lineup of grades available from general cutting to deep depth cutting for high efficiency machining.

●Aluminium Alloy





Suitable for cutting materials such as nonferrous metals and fiber reinforced plastics (FRP) including aluminium alloys.
It supports ultra high speed finish cutting.

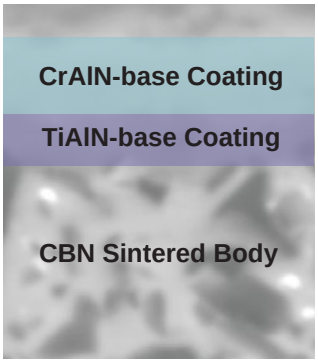
COATED CBN
BC8100 series for machining of hardened steel

FEATURES

The coated CBN grade BC8100 series and non-coated CBN grade MB8100 series for cutting of hardened steel uses new developed optimized substrate technology CBN base material. The new ultra-micro-binder prevents sudden fracturing and longer tool life. The BC8100 series coating exhibit excellent fracture resistance and wear resistance by using a special PVD coating suitable for each cutting mode.

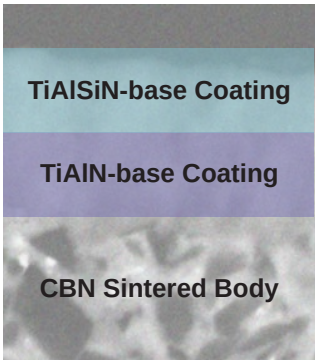
■ Newly Developed Special PVD Coating

BC8105



Offers excellent surface finishes.
Peeling resistance and adhesion strength are improved by having both lubricity and wear resistance.

BC8110

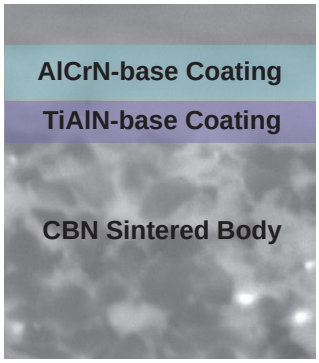


Chipping caused by built up edge is prevented with improved welding resistance.
Improved wear and adhesion strength to the CBN surface.

BC8120

Chipping caused by built up edge is prevented with improved welding resistance.
Improved adhesion to the coating to the CBN surface enhances peeling resistance.
The CBN is also improved in toughness by adopting new binder and sintering method.

BC8130

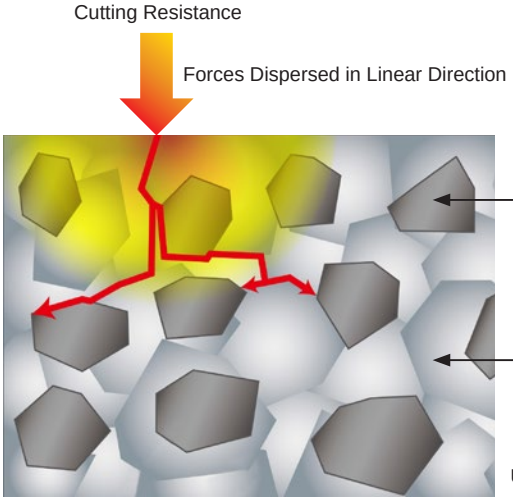


Peeling caused by severe impact and chipping are prevented with high fracture resistances.
Improved adhesion strength to the CBN surface.

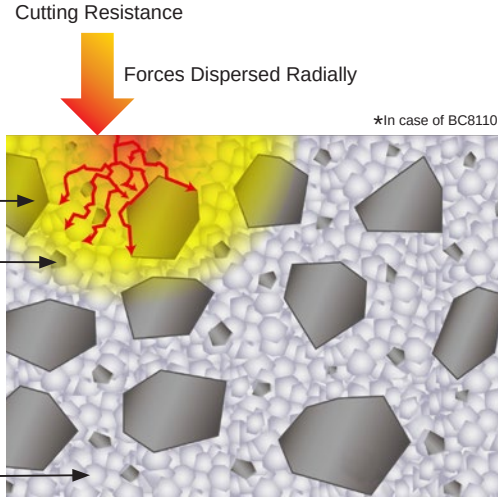
*Graphical representation.

■ The newly developed Ultra Micro-particle Binder prevents sudden fracture

●Conventional



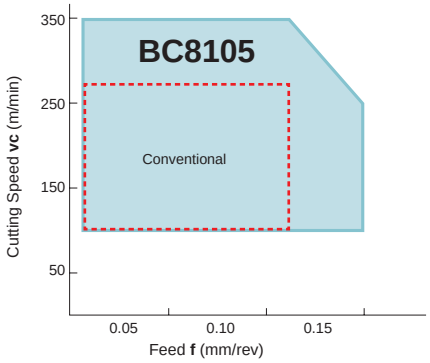
●BC8100 Series



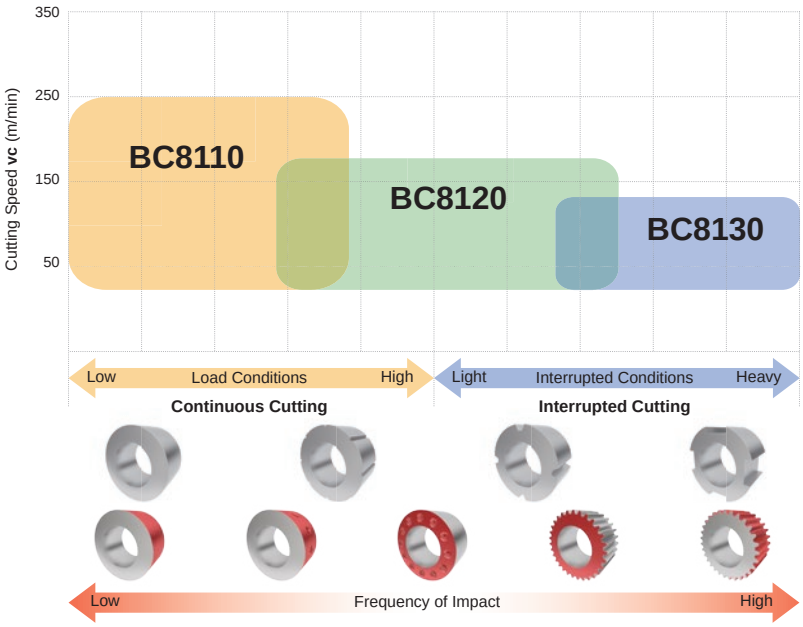
Medium Grain CBN
Micro Grain CBN
Binder Macroparticles
Ultra Micro-particle Binder

Dispersal of the newly developed Ultra Micro-particle Binder for sintered CBN and Micro Grain CBN suppresses cracking to prevent sudden fracturing.

Application range



*BC8110 is recommended to improve wear resistance.



Recommended cutting conditions

Grade		Cutting mode	Cutting Speed vc (m/min) (50 – 150 – 250 – 350)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
BC8100 Series	BC8105	Continuous		≤0.15	≤0.2	Dry, Wet
	BC8110	Continuous		≤0.20	≤0.35	Dry, Wet
	BC8120	Continuous		≤0.3	≤0.5	Dry, Wet
		Interrupted		≤0.2	≤0.3	Dry, Wet
	BC8130	Interrupted		≤0.20	≤0.30	Dry, Wet

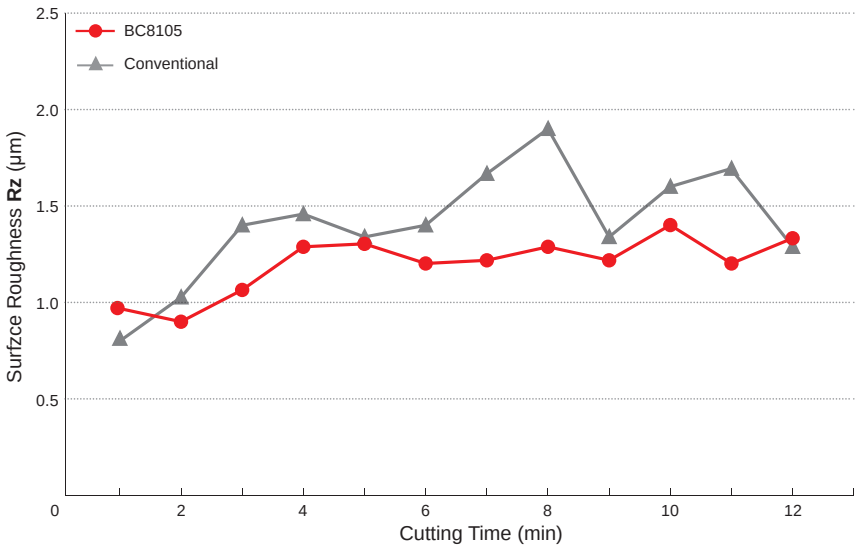
COATED CBN
BC8100 series for machining of hardened steel

■ Cutting example and application example

BC8105 Highest Accuracy

Use of a CBN substrate with excellent wear resistance and chipping resistance, together with a high-lubricity coating film, controls the occurrence of boundary wear and exhibits outstanding surface roughness.

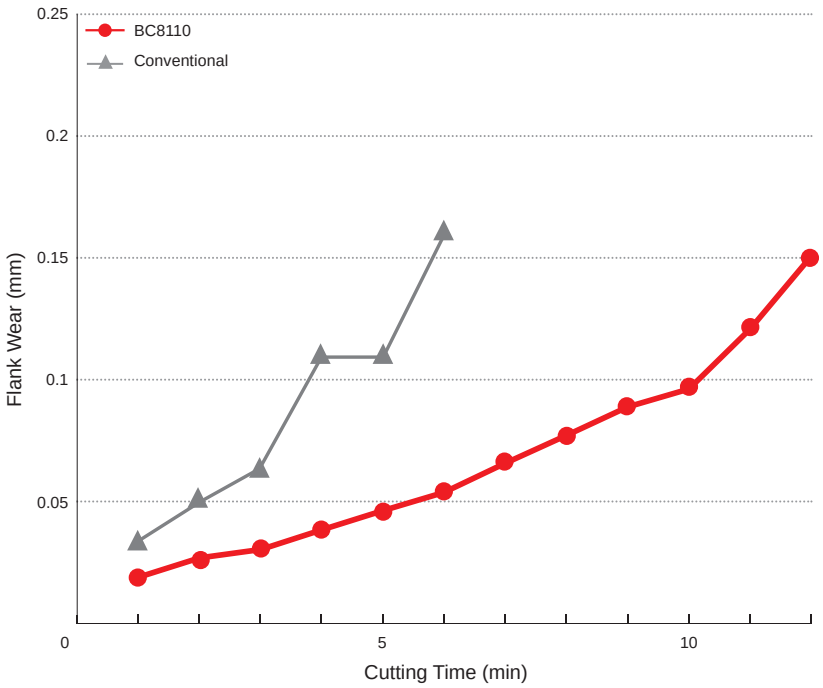
Suitable for finishing with surface roughness Ra 0.6 μm or Rz 2.4 μm or less.



Insert	NP-CNGA120408GS2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Continuous Cutting
Cutting Speed vc (m/min)	200
Feed f (mm/rev)	0.05
Depth of Cut ap (mm)	0.05
Cutting Mode	Dry Cutting

BC8110 High Speed Turning

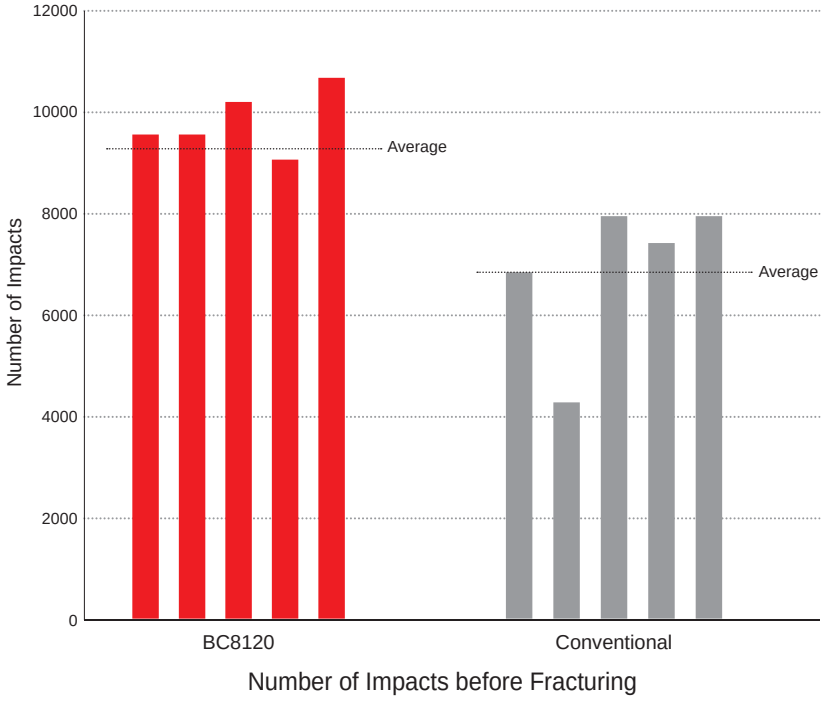
Use of a CBN substrate with excellent wear resistance and chipping resistance, together with an extremely hard coating film, provides the highest flank wear resistance of the entire BC8100 series.



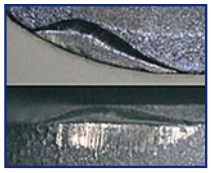
Insert	NP-CNGA120408GS2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Continuous Cutting
Cutting Speed vc (m/min)	250
Feed f (mm/rev)	0.10
Depth of Cut ap (mm)	0.2
Cutting Mode	Dry Cutting

BC8120 General Application

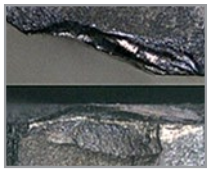
Use of a CBN substrate with excellent fracture resistance and crater wear resistance, together with a coating film having superior wear resistance, combines both fracture resistance and wear resistance while exhibiting outstanding crater wear resistance.



Cutting Edge Condition after 8000 Impacts



BC8120

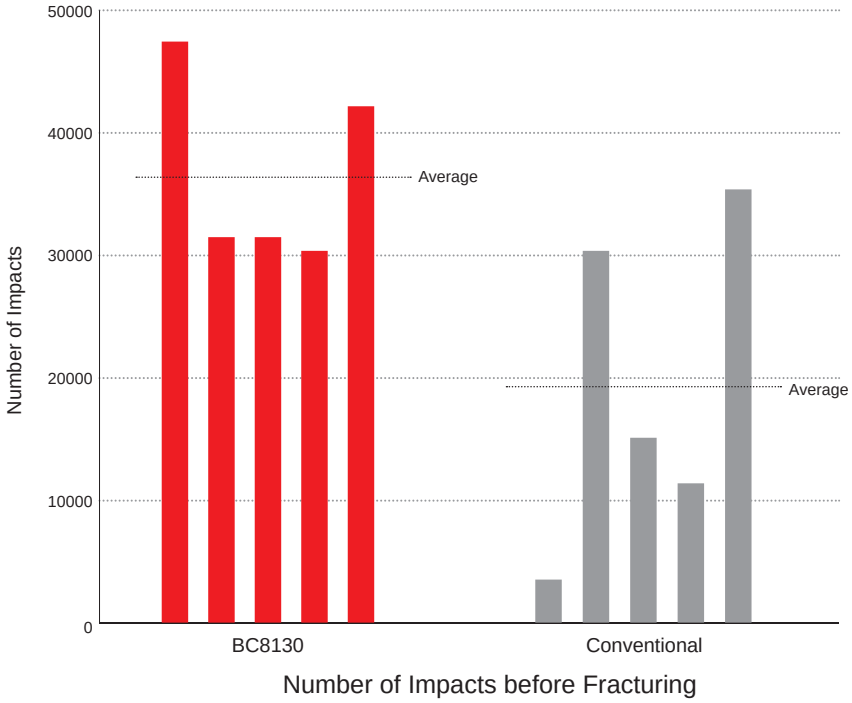


Conventional

Insert	NP-CNGA120408GA2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Interrupted Cutting
Cutting Speed vc (m/min)	250
Feed f (mm/rev)	0.15
Depth of Cut ap (mm)	0.1
Cutting Mode	Dry Cutting

BC8130 Tough Machining

Use of a CBN substrate with excellent cutting edge strength, together with a coating film that combines hardness with impact resistance, allows it to exhibit outstanding cutting edge strength and fracture resistance.



Insert	NP-CNGA120408GA2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Heavy Interrupted Cutting
Cutting Speed vc (m/min)	250
Feed f (mm/rev)	0.05
Depth of Cut ap (mm)	0.1
Cutting Mode	Wet Cutting

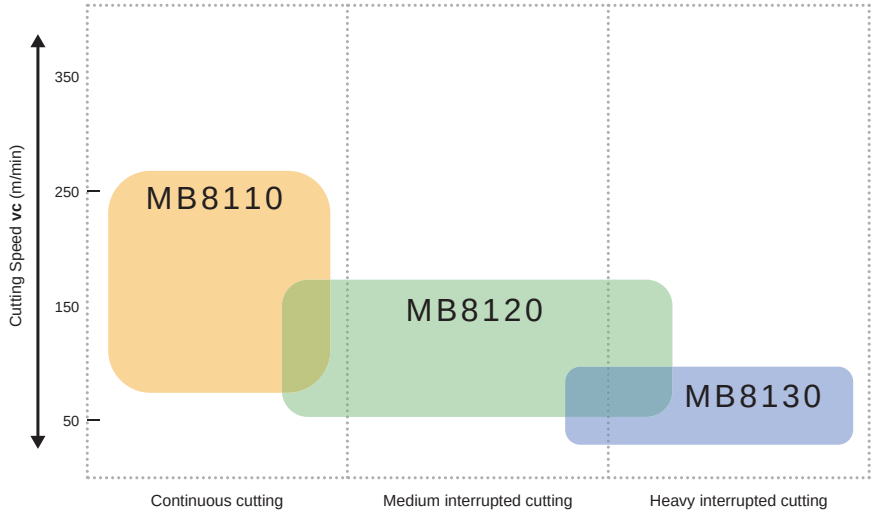
NON-COATED CBN

BC8100 series for machining of hardened steel

FEATURES

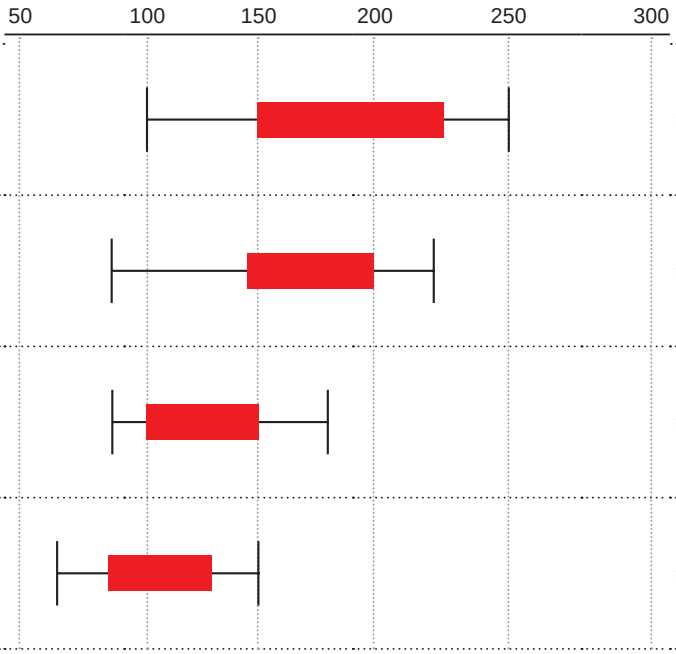
The MB8100 series CBN base material uses the optimized substrate technology (see B006) applied to the BC8100 series to prevent sudden defects during cutting and achieve long life.
The MB8100 series has a lineup of MB8110 for continuous cutting, MB8120 for general cutting, and MB8130 for interrupted cutting, and can be used in a wide range of cutting applications.

■ Application range



■ Recommended cutting conditions

Grade		Cutting mode	Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
MB8100 Series	MB8110	Continuous		≤0.2	≤0.3	Dry, Wet
	MB8120	Continuous		≤0.2	≤0.5	Dry, Wet
		Interrupted		≤0.2	≤0.3	Dry, Wet
	MB8130	Interrupted		≤0.2	≤0.3	Dry, Wet

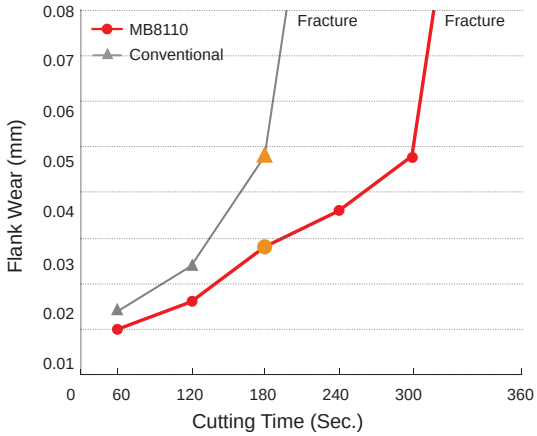


■ Application example

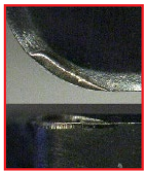
MB8110 Continuous cutting

Tool Life (Flank Wear)

Insert	NP-CNGA120408GA2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Continuous Cutting
Cutting Speed **vc** (m/min)	250
Feed **f** (mm/rev)	0.1
Depth of Cut **ap** (mm)	0.2
Cutting Mode	Dry Cutting



Cutting Edge after 180 sec.


MB8110

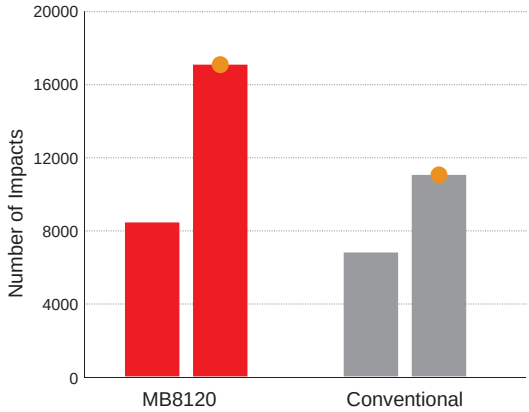
Large Wear

Conventional

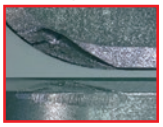
MB8120 General Application

Test of Interrupted Cutting

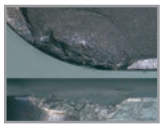
Insert	NP-CNGA120408GA2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Interrupted Cutting
Cutting Speed **vc** (m/min)	250
Feed **f** (mm/rev)	0.15
Depth of Cut **ap** (mm)	0.1
Cutting Mode	Dry Cutting



17000 Impacts


MB8120

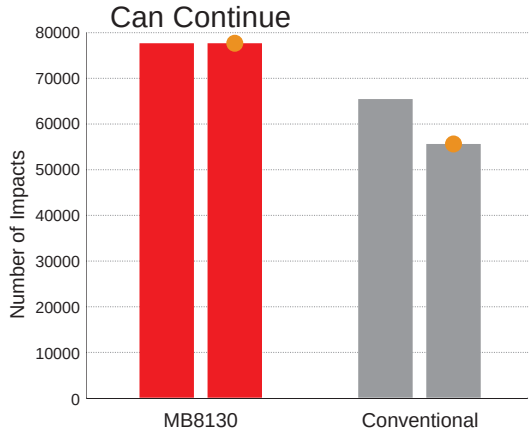
11000 Impacts


Conventional

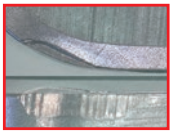
MB8130 Interrupted cutting

Test of Interrupted Cutting

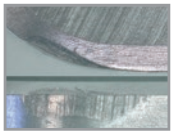
Insert	NP-CNGA120408GA2
Workpiece Material	AISI 5120 (60 HRC)
Machining Methods	External Heavy Interrupted Cutting
Cutting Speed **vc** (m/min)	150
Feed **f** (mm/rev)	0.05
Depth of Cut **ap** (mm)	0.1
Cutting Mode	Wet Cutting



77000 Impacts


MB8130

54000 Impacts


Conventional

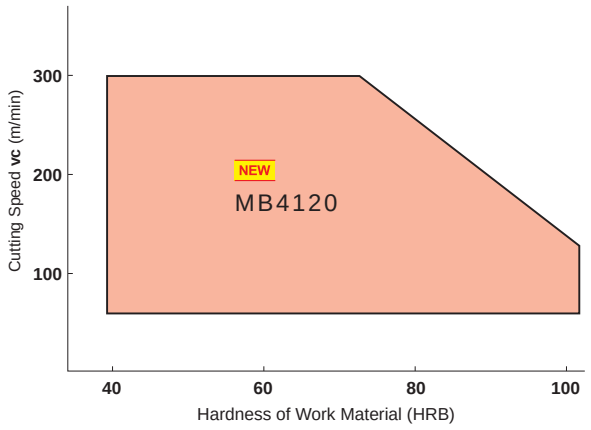
NON-COATED CBN

Sintered Alloy Machining • Cast Iron Machining

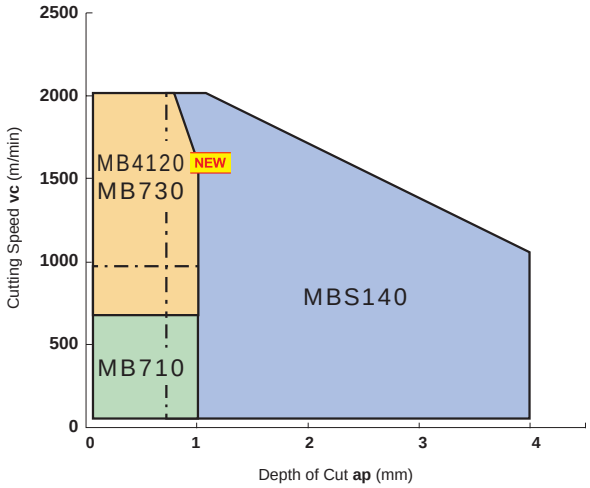
MB4120/MB710/MB730/MBS140

■ Application Range

●Sintered Alloy Machining



●Cast Iron Machining



■ Recommended Cutting Conditions

●Sintered Alloy Machining

Work Material	Application range	Grade	Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
			100 150 200 250 300			
General Sintered Alloy	General Cutting	**MB4120** NEW		≤0.2	≤0.3	Dry, Wet
High Density Sintered Alloy	General Cutting	**MB4120** NEW		≤0.2	≤0.3	Dry, Wet
Sintered Alloy	General Cutting	**MB4120** NEW		≤0.2	≤0.3	Dry, Wet

●Cast Iron Machining

Work Material	Application range	Grade	Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
			250 500 750 1000 1250 1500			
Gray Cast Iron JIS FC250, JIS FC300	General Cutting	**MB4120** NEW		≤0.4	≤0.5	Dry, Wet
	General Cutting	**MB730**		≤0.5	≤1.0	Dry, Wet
	General Cutting	**MB710**		≤0.5	≤1.0	Dry, Wet
	Heavy Cutting	**MBS140**		≤0.5	≤5	Dry, Wet

MB4120

●The first recommendation that can be widely used for continuous to interrupted cutting of sintered alloy and cast iron.

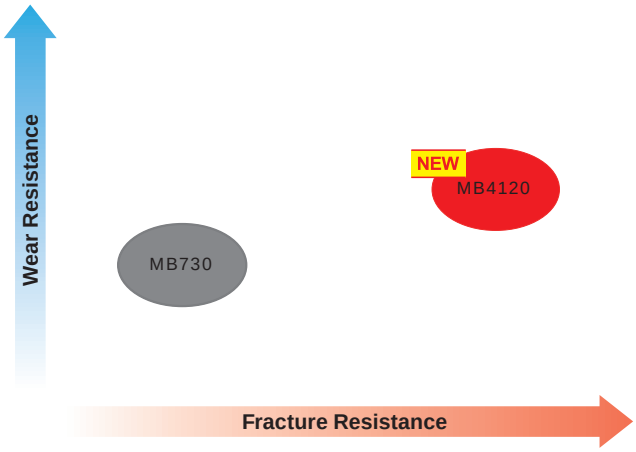
FEATURES

High Fracture Resistance

Fine CBN particles increase cutting edge toughness. The high fracture resistance allows stable performance even during interrupted machining.

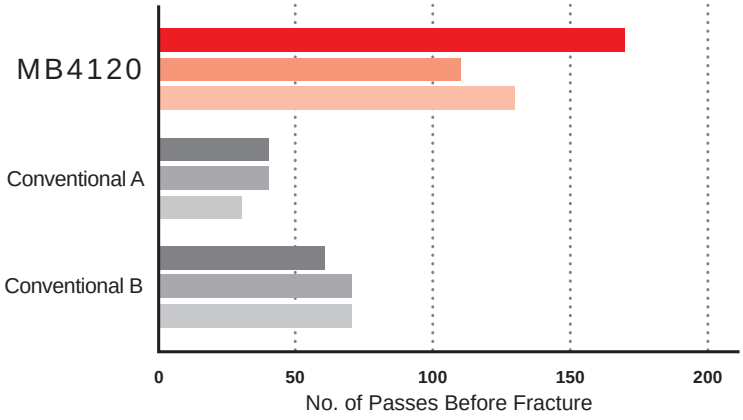
High Adhesion Strength of Fine CBN Particles

Optimization of the sintering conditions strengthens adhesion between fine CBN particles. This increases both fracture resistance and wear resistance.



■ Application Example

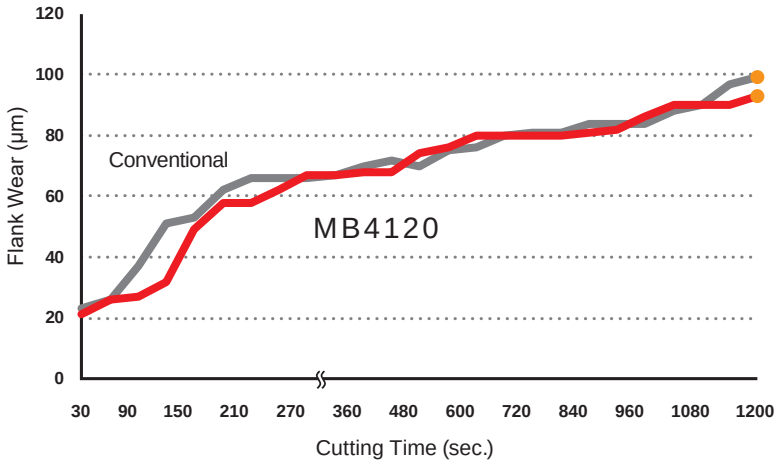
Fracture Resistance Comparison During Interrupted Facing of High Strength Sintered Alloy

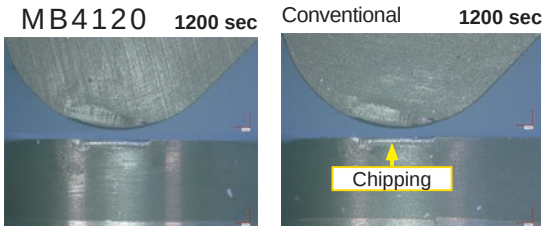


<Cutting Conditions>
Work Material : High Strength Sintered Alloy
Insert : NP-TNGA160408SE3
Cutting Speed : vc=150m/min
Feed : f=0.15mm/rev
Depth of Cut : ap=0.1mm
Cutting Mode : Wet Cutting

Excellent chipping resistance in interrupted face cutting of gear.

Comparison in Continuous Machining of AISI No 35 B





<Cutting Conditions>
Work Material : AISI No 35 B (Perlite)
Insert : NP-TNGA160408SF3
Cutting Speed : vc=800m/min
Feed : f=0.1mm/rev
Depth of Cut : ap=0.2mm
Cutting Mode : Dry Cutting

It has excellent fracture resistance as compared to conventional products.

SOLID CBN

Cast Iron Machining MBS140

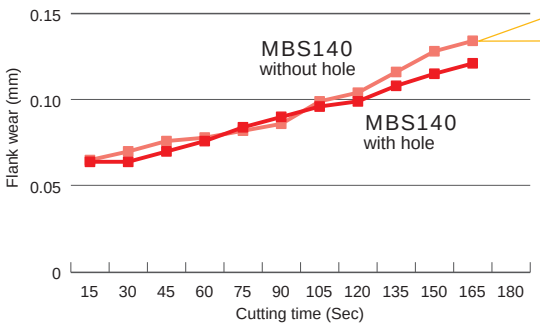
FEATURES

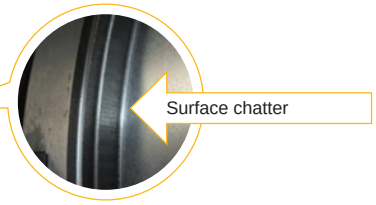
Supports high-efficiency machining with large depths of cut.

Since all inserts are CBN sintered bodies, there are no limits to the depths of cut as with CBN brazing tools, allowing machining with large depths of cut.
For rough machining of cast iron, high-speed, high-efficiency machining, which is a characteristic of CBN tools, can be achieved.

Combines wear resistance and fracture resistance

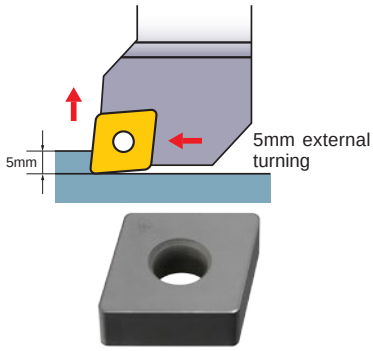
Use of micro-grain CBN with a newly-developed special binder provides high wear resistance.
Use of Mitsubishi's original high-efficiency sintering technology provides high fracture resistance and supports machining with large depths of cut.





<Cutting Conditions>
Workpiece : FC250 (DIN GG25)
Insert : CNGA120408/CNGN120408
Holder : Double Clamp Holder
Cutting Speed : vc=400 m/min
Feed : f=0.05 mm/rev
Depth of Cut : ap=5.0 mm
Cutting Mode : Wet Cutting

Addition of insert series equipped with holes
Comparison of depth of cut
5mm face turning



CBN

FOR CYLINDER LINER MB5015

✱Produce to order only.

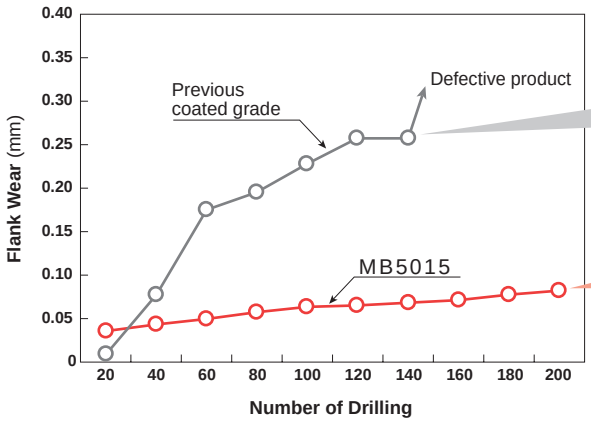
FEATURES

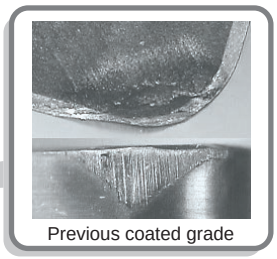
MB5015 is exclusive grade for boring of Centrifugal casting Cylinder liners in semi finishing or finishing applications with high with high wear resistance.

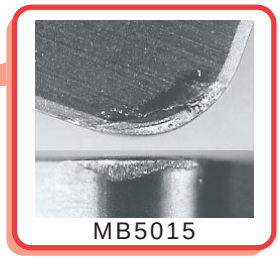
■ Recommended Cutting Conditions

Work Material		Cutting Mode	Cutting Speed vc (m/min) 100 500 1000 1500	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
Centrifugal casting	Cast Iron	Continuous cutting		–0.3(Finishing) –0.8(Semi-finishing)	–0.05(Finishing) –0.2(Semi-finishing)	Wet Cutting

■ Cutting Performance




Previous coated grade


MB5015

<Cutting Conditions>
Workpiece : FC200 (Centrifugal casting) ϕ63.0
Cutting Speed : vc=800m/min Feed : f=0.35mm/rev Depth of Cut : ap=0.03mm
Work : Centrifugal casting Cylinder liner Hole Depth : 100mm

CBN

- Suitable for high speed finishing of heat treated steel, sintered ferrous alloy and cast iron.
- Low affinity to iron, thus good surface finishes are possible.
- Grinding can be replaced by machining.

●Heat Treated Steel

Work Material		Type	Cutting Mode	Recommended Grade	Recommended Cutting Conditions			
					Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
Structural Steel Esp. Carburized Steel (SC, SCM, SCr) High Alloy Steel (SKD, SKH)	35−65 HRC	Coated	High speed finishing cutting	**BC8105**	250 (100−350)	≤0.15	≤0.2	Dry,Wet
			Continuous cutting for general purpose	**BC8110**	200 (100−300)	≤0.2	≤0.35	Dry,Wet
				BC8120	200 (100−230)	≤0.3	≤0.8	Dry,Wet
			Medium interrupted cutting	**BC8120**	150 (60−200)	≤0.2	≤0.3	Dry,Wet
			Interrupted cutting	**BC8130**	120 (60−150)	≤0.2	≤0.3	Dry,Wet
		Non-coated	Continuous cutting for general purpose	NEW **MB8110**	200 (100−250)	≤0.2	≤0.3	Dry,Wet
				NEW **MB8120**	150 (80−220)	≤0.2	≤0.5	Dry,Wet
			Medium interrupted cutting	NEW **MB8120**	130 (85−180)	≤0.2	≤0.3	Dry,Wet
			Interrupted cutting	NEW **MB8130**	100 (60−150)	≤0.2	≤0.3	Dry,Wet

●Cast Iron

Work Material		Workpiece Structure	Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)	Cutting Mode
Gray Cast Iron	JIS FC250	Ferritic + Pearlitic	MBS140	−0.5	−1.0 MBS140 −5.0	Dry,Wet
	JIS FC300	Pearlitic	MB710, MB730, MB4120 NEW			
Alloy Cast Iron		Pearlitic		−0.4	−0.5	Dry,Wet
Ductile Cast Iron	JIS FCD400	Ferritic	MB710, MB730	−0.4	−0.5	Dry,Wet
	JIS FCD700	Ferritic + Pearlitic Pearlitic				

Cutting Speed vc (m/min): 250 500 750 1000 1250

●Sintered Alloy

Work Material	Recommended Grade	Recommended Cutting Conditions		
		Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)
General Sintered Alloy	NEW **MB4120**	180 (80−300)	−0.2	−0.3
High Density Sintered Alloy	NEW **MB4120**	150 (80−230)	−0.2	−0.3
Sintered Alloy	NEW **MB4120**	130 (80−180)	−0.2	−0.3

●Valve Seat

Amount of Hard Particles	**None or Small** ← → **Large**			
Hardness of Workpiece (HV)	150	250	300	350
Plunge Cut	NEW MB4120, MB4020	MB825	MB835	
Traverse Cut	NEW MB4120, MB4020	MB710	MB825	

●Roll

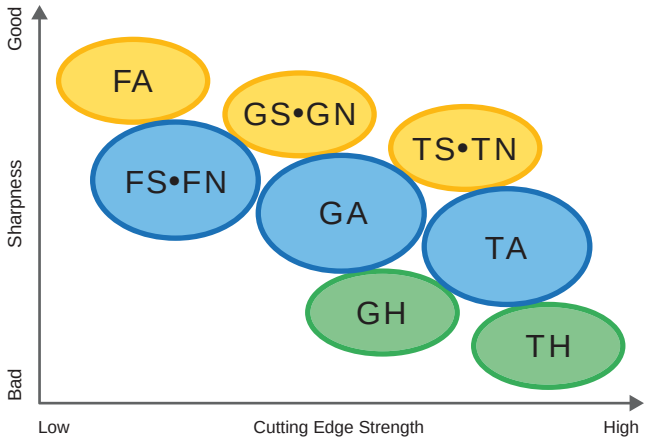
Work Material	Grade	Recommended Cutting Conditions		
		Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)
Cast Steel Adamite Cast Steel	**MB8025**	80 (30−130)	0.3 (0.1−0.5)	0.2−3.0
Ductile Cast Iron Granular Cast Iron Chilled Cast Iron	**MB710**	80 (30−130)	0.3 (0.1−0.5)	0.2−3.0
High Chromium Steel High Alloy Steel	**MB8025**	80 (30−130)	0.3 (0.1−0.5)	0.2−3.0
High Speed Steel	**MB730**	50 (20−70)	0.25 (0.1−0.4)	0.1−3.0
Cemented Carbide	**MB730, MBS140**	20 (10−30)	−0.2	−0.2

●Heat Resistant Alloy

Work Material	Grade	Recommended Cutting Conditions		
		Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)
Ni Base Heat Resistant Alloy (e.g. Inconel)	**MB730, MB8025**	120 (100−150)	−0.2	−0.5
Co Base Heat Resistant Alloy (e.g. Stellite)	**MB730, MB8025**	70 (50−100)	−0.2	−0.5

HONING

Honing for Machining Hardened Steel



● General cutting

GA Honing : General machining
GS Honing : Vibration and burr control
GN Honing : If the crater wear is large.
GH Honing : For depths of cut of 0.15 or greater

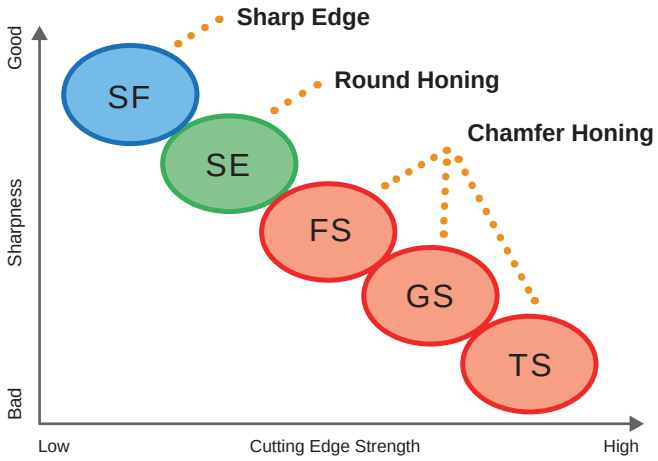
● Continuous cutting, Stable cutting

FS Honing : General machining
FA Honing : For improved biting compared to **FS**
FN Honing : if the crater wear is large.

● Medium and heavy interrupted cutting, Unstable cutting

TA Honing : General machining
TS Honing : Vibration and burr control
TN Honing : If the crater wear is large.
TH Honing : For depths of cut of 0.15 or greater

Honing for Machining Sintered Alloys



● Continuous cutting, Stable cutting

FS Honing : Continuous cutting, General machining

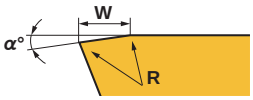
● Medium and heavy interrupted cutting, Unstable cutting

GS,TS Honing : If fracturing occurs at the blade edge during interrupted cutting

● Focus on high-precision cutting, dimensional precision, and surface roughness

SF Honing : Focus on finished surface roughness
SE Honing : If chipping occurs

NP-CNGA120408-G A 2



Main Application — **Edge Honing Type**

(mm)

	A General			S Vibration and burr control			N Crater wear control			H High efficiency			F Focus on dimensional precision			E Chipping control		
	α	W	R	α	W	R	α	W	R	α	W	R	α	W	R	α	W	R
F Continuous cutting	15°	0.1	0	15°	0.1	0.01	15°	0.05	0.01	—	—	—	—	—	—	—	—	—
G General cutting	25°	0.13	0.03	25°	0.13	0.01	25°	0.05	0.01	25°	0.27	0.03	—	—	—	—	—	—
T Interrupted cutting	35°	0.13	0.03	35°	0.13	0.01	35°	0.05	0.01	35°	0.27	0.03	—	—	—	—	—	—
S High-precision cutting	—	—	—	—	—	—	—	—	—	—	—	—	0°	0	0	0°	0	0.01

Conventional honing shapes
F honing : 0.1mm×15°+R0
G honing : 0.13mm×25°+R0.03
T honing : 0.13mm×35°+R0.03

CBN BREAKER INSERT

FEATURES

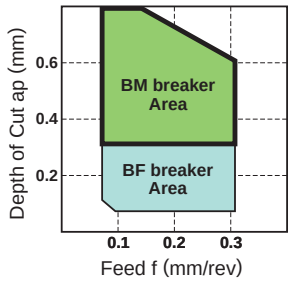
Chip Breaker Geometry Designed for Excellent Chip Control

Radial chip breaker ensures optimization of the cutting point and the chip breaker position. Enables effective chip discharge even when copy machining and prevents the chips from wrapping around the holder under finish cutting conditions.

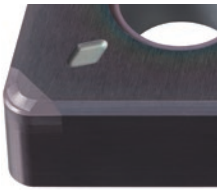
Long Life Coated CBN Grade

Combination of Coating grade & Breaker, high efficiency and long tool life in wide variety of applications.

■ Application Area



■ BM Breaker (Deep shoulder Turning)

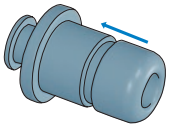


Good for deep depth cutting of carburized layer.

Recommend and under ap=0.6mm

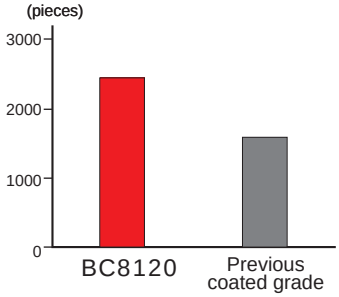
Available in BC8120 grade.

●Cutting Performance



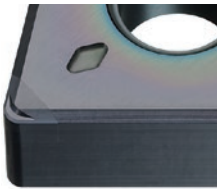
<Cutting Conditions>

Workpiece	: AISI 4142 (56-59HRC)
Component	: Counter shaft (External interrupted cutting)
Insert	: BM-DNGM150608TA2
Cutting Speed	: vc=170m/min
Feed	: f=0.15mm/rev
Depth of Cut	: ap=0.07 — 0.10mm
Cutting Mode	: Wet Cutting



BC8120 achieved 1.5X longer tool life.

■ BF Breaker (Light cutting depth)

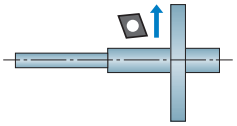


Good for chip removal under light depth and feed cutting.

Recommend and under ap=0.3mm

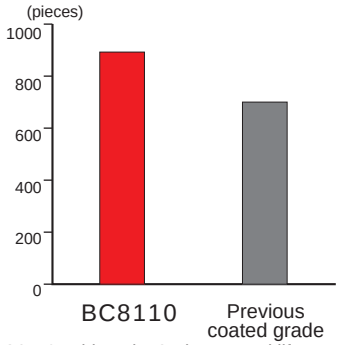
Available in BC8110 grade.

●Cutting Performance



<Cutting Conditions>

Workpiece	: SCr420H (61-65HRC)
Component	: Clutch shaft (Continuous facing)
Cutting Speed	: vc=150m/min
Feed	: f=0.12mm/rev
Depth of Cut	: ap=0.15mm
Wet Cutting	



BC8110 achieved 1.3X longer tool life.

MULTI-CORNER TYPE INSERTS

●A single sided, multi-corner type insert has no cutting edges on the underside.

Double Sided, multi-corner type insert, ex.

NP-CNGA120408GA4

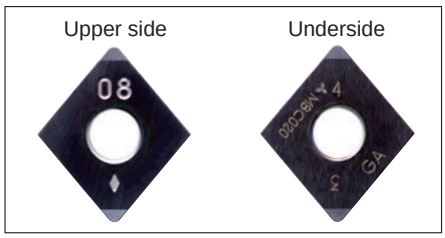
No. of Cutting Edge Corners

Single Sided, multi-corner type insert, ex.

NP-CNGA120408GA2

No. of Cutting Edge Corners

Double sided, Multi-corner type insert



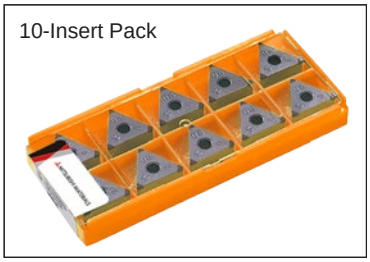
10-INSERTS PACKS

Two types of packs for MB8025 Multi-corner type inserts, are available, a single insert pack and a ten insert pack. For easy storage.

TNP-CNGA120404G2

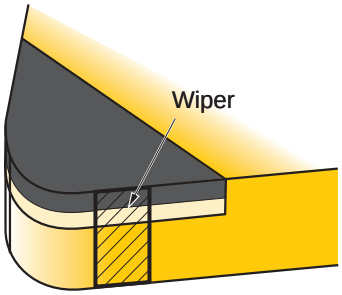
10-Insert Pack Symbol

10-Insert Pack



WIPER INSERT

FEATURES



Improving Surface Finish

Under the same machining conditions as conventional breakers, but with the feed rate increased, the surface finish of the workpiece can be improved.

Improving Efficiency

High feed rates not only shorten machining times but also make it possible to combine roughing and finishing operations.

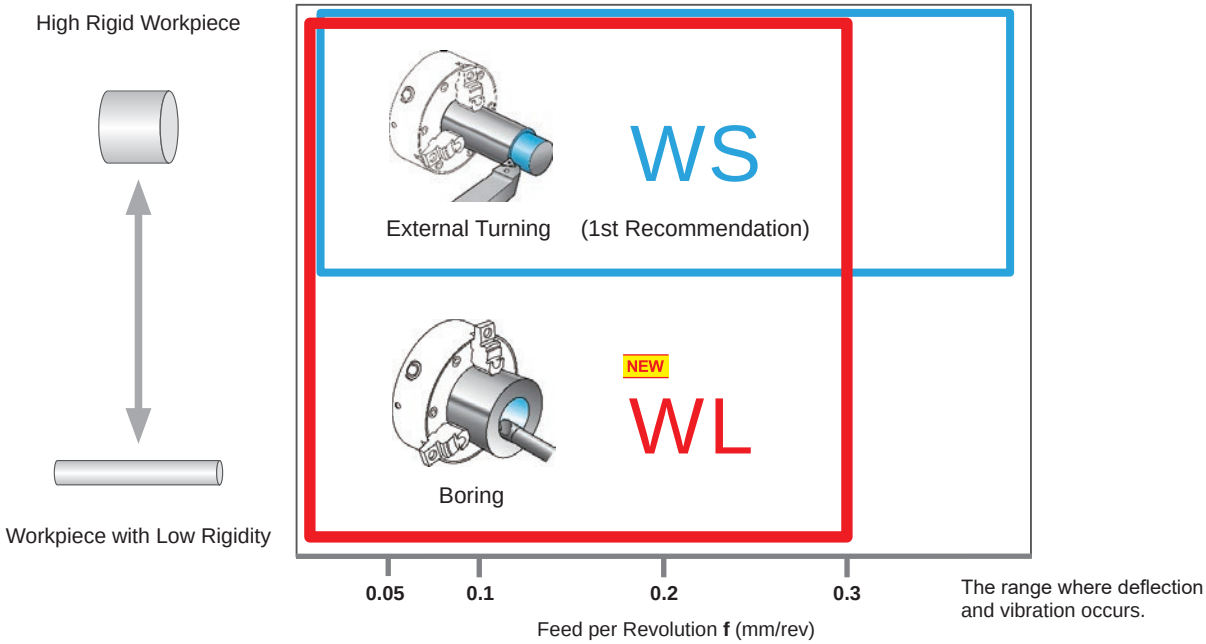
Increased Tool Life

When a change to high feed conditions, the time required to cut one component is decreased, thus more parts can be machined with each insert. In addition, the high feed rate prevents rubbing, therefore, delaying the progression of wear and increasing the tool life of the insert.

Improving Chip Control

Under high feed conditions, the chips generated become thicker and are more easily broken, thus, chip control is improved.

■ Application of Wiper Inserts



NEW

■ WL Wiper Insert

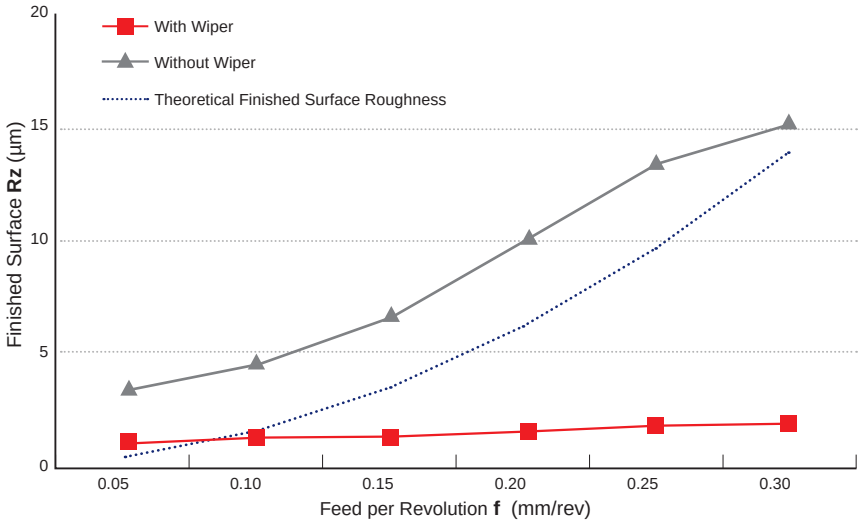
Preventing the cutting edge from vibration during boring and turning of small diameter workpieces as well as providing excellent finish surface roughness.

The Optimum Wiper Width

Applying slight slope on the wiper cutting edge reduces cutting resistance.

■ Cutting Performance

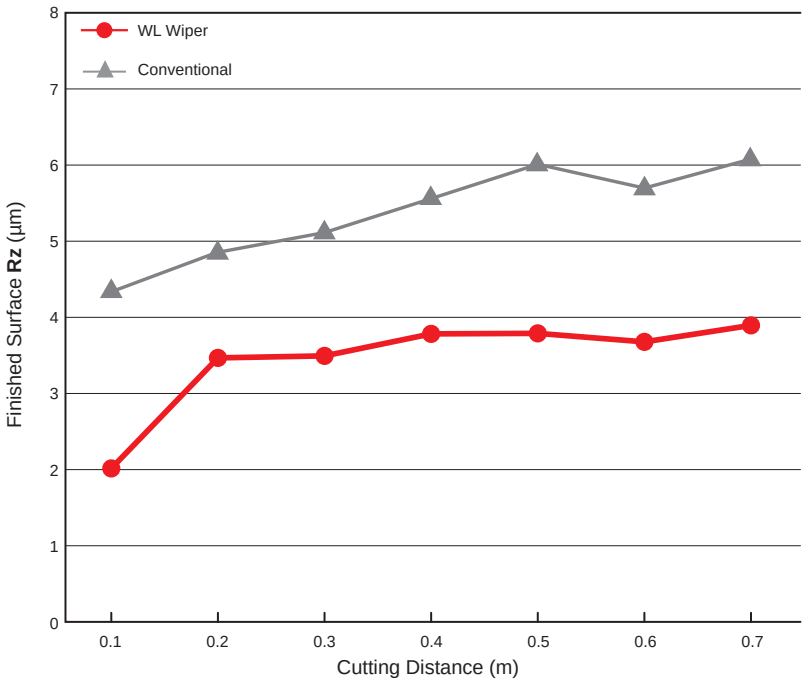
WL Wiper (External Turning)



<Cutting Conditions>
Workpiece Material : Hardened Steel (60HRC)
Insert : NP-CNGA120408
Machining Methods : Continuous
Cutting Speed : vc=120m/min
Depth of Cut : ap=0.1mm
Cutting Mode : Dry Cutting

NEW

WL Wiper (Boring)



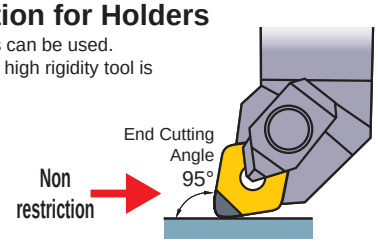
<Cutting Conditions>
Workpiece Material : SCr415 (60HRC)
Insert : NP-CNGA120408FBWL2
Machining Methods : Continuous
Cutting Speed : vc=160m/min
Feed : f=0.3mm/rev
Depth of Cut : ap=0.1mm
Cutting Mode : Dry Cutting

Stable surface finish is maintained even in unstable cutting.

■ Notes for Use

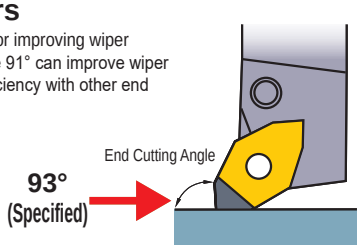
No Restriction for Holders

A standard holders can be used.
(★A double clamp, high rigidity tool is recommended.)



Restriction for Holders

Use a holder with end cutting angle 93° for improving wiper efficiency. A holder with end cutting angle 91° can improve wiper efficiency, however, there is no wiper efficiency with other end cutting angles (60°, 90°,107°etc.).



CBN GROOVING SERIES
(GY/MG)

FEATURES

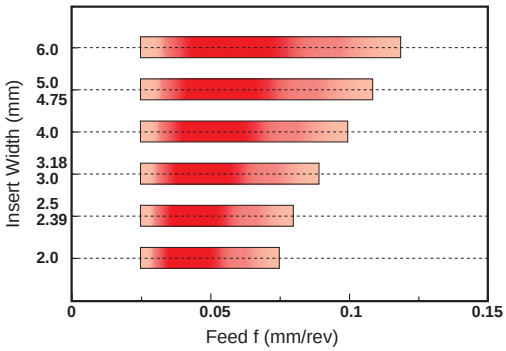
A combination with a high rigidity holder ensures high accuracy and long tool life.

Holder rigidity is essential when grooving hardened steel. The GY series Tri Lock system offers high rigidity equivalent to a 1-piece type despite being a 2-piece type. MG has a wide insert location face for high gripping force. A combination with these holders allows it to deliver excellent performance when grooving hardened steel.

BC8110 coated materials for continuous machining of hardened steel have been added to GY inserts.

BC8110 materials with excellent wear resistance have been added. Compared to conventional materials, they display excellent wear resistance to achieve long tool life. A blade width of 6.0 has also been added to the lineup of BC8110.

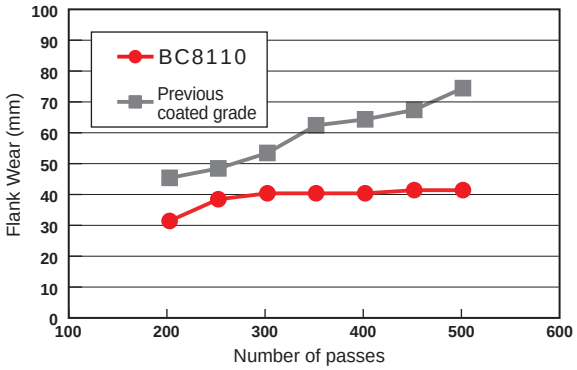
■ Recommended Cutting Conditions



Work Material		Hardness	Grade	Cutting Speed vc (m/min)	Cutting Mode
H	Hardened Steel	35−65HRC	**BC8110** **MB8025**	100 (60−120)	Dry,Wet

■ Cutting Performance

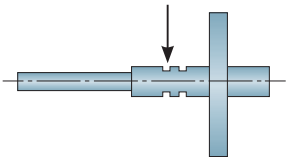
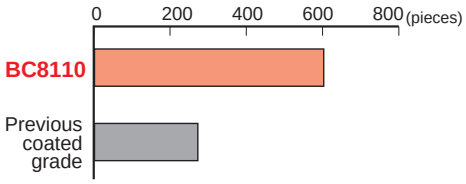
Tool life evaluation for the GY holder



<Cutting Conditions>

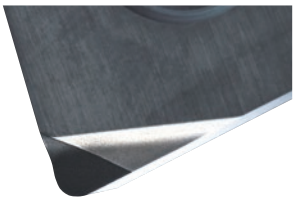
Insert	: GY1G0200D020N-GFGS
Workpiece	: SCr420 (60HRC)
Cutting Speed	: vc=120 m/min
Feed	: f=0.1 mm/rev
Depth of Cut	: ap=0.3 mm
Cutting Mode	: Dry Cutting

■ Application Example

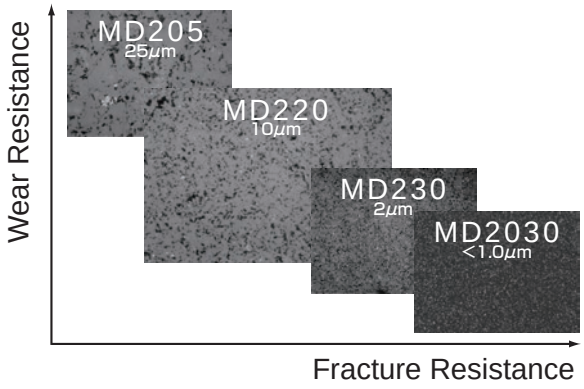
Insert		**GY1G0300F020N-GFGS** (Grade : **BC8110**)
Workpiece		 SNCM230H (58–62HRC)
Component		Input shaft
Cutting Conditions	Cutting Speed vc (m/min)	130
	Feed f (mm/rev)	0.1
Result		 Tool life over twice as long as conventional products

PCD (SINTERED DIAMOND)

- Suitable for materials such as aluminium alloy, non-ferrous metals, and fibre strengthened plastic.
- Suitable for extremely high speed finishing.



FEATURES



Grade	Features
MD205	**For Continuous Cutting** Coarse grain diamond particles are sintered and wear resistance is excellent. Use when wear resistance with MD220 is insufficient.
MD220	**Materials for General Machining** Sintered medium grain diamond particles. Wear resistance and fracture resistance are superbly balanced. Applicable to general finishing of non-ferrous metals, non-metal cutting, and similar machining.
MD230	**For Interrupted Cutting** Fine grain diamond particles are used. Fracture resistance and cutting edge sharpness are excellent. Use when fracture and a high quality finished surface is demanded with MD220.
MD2030	**For Heavy Interrupted Cutting** Strong sintering of ultra micro-grain PCD particles provides exceptional fracture resistance. Chipping during high-speed finish turning can be controlled.

■ SELECTION STANDARD

TURNING

Work Material	Recommended Grade			Recommended Cutting Conditions		
	MD205	MD220	MD2030	Cutting Speed vc (m/min)	Feed f (mm/rev)	Depth of Cut ap (mm)
Aluminium Alloy (Si ≤ 12%)		◎	○	800 (200−1200)	−0.2	−1.0
Aluminium Alloy (Si ≥13%)	◎	○		600 (200−1000)	−0.2	−1.0
Copper Alloy		◎		700 (200−1200)	−0.2	−1.0
Strengthened Plastic		◎		600 (100−1000)	−0.4	−1.0
Glass Fibre Reinforced Plastic		◎		500 (100−800)	−0.25	−1.0
Carbon	○	◎		400 (100−600)	−0.3	−1.0
Ceramics		○		50 (30−80)	−0.1	−1.0
Hard Rubber		◎		600 (300−800)	−0.15	−1.0
Wood Inorganic Board		◎		1300 (300−4000)	−0.4	−
Cemented Carbide	◎	○		15 (5−20)	−0.2	−0.5

Note1) ◎ : 1st recommendation. ○ : 2nd recommendation
Note2) Not suitable for steel.

■ NEW PETIT CUT INSERT SERIES

- **Economical** Low cost is achieved by reducing the area of the diamond sintered body. In addition, tool management is economical because regrinding is unnecessary.
- **With Breaker** Chip breaker formed directly on the PCD portion delivers superior chip control.
- Corner R0.05mm inserts are available, making it suitable for the machining of small work corner radii.

CLASSIFICATION

NEGATIVE INSERTS WITH HOLE

Product Name	Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°
NEW PETIT CUT	Multi-corner Type Double Sided	G	Flat Top	NP-CNGA_○4 B028	NP-DNGA_○4 B032	NP-SNGA_○4 B037	NP-TNGA_○6 B039	NP-VNGA_○4 B042	NP-WNGA_○6 B044
	Multi-corner Type Double Sided With Wiper		Flat Top	NP-CNGA_○WS4 B028					
	Multi-corner Type Double Sided With Breaker		BF	BF-CNGG_○4 B028	BF-DNGG_○4 B033				
	Multi-corner Type Double Sided With Breaker		Flat Top	NP-CNGA_○2 * B029	NP-DNGA_○2 * B033	NP-SNGA_○2 * B037	NP-TNGA_○3 * B039	NP-VNGA_○2 * B042	NP-WNGA_○3 B044
	Multi-corner Type Single Sided With Wiper		Flat Top	NP-CNGA_○W○2 B030	NP-DNGA_○WS2J_R/L B035				NP-WNGA_○WS3 B044
	Multi-corner Type Single Sided With Breaker		BF	BF-CNGM_○2 B030	BF-DNGM_○2 B035				
	Multi-corner Type Single Sided With Breaker		BM	BM-CNGM_○2 B030	BM-DNGM_○2 B035		BM-TNGM_○3 B040		
	One-corner Type Single Sided	M	Flat Top	NP-CNMA_○ B031	NP-DNMA_○ B036	NP-SNMA_○ B038	NP-TNMA_○ B040	NP-VNMA_○ B043	
	One-corner Type Single Sided With Breaker		R/L-F	NP-CNMM_R/L-F B068	NP-DNMM_R/L-F B068	NP-SNMM_R/L-F B069	NP-TNMM_R/L-F B069	NP-VNMM_R/L-F B070	

Note1) Two types of packs for * type inserts, pack of single insert and pack of ten inserts, are available. (The single pack is standard.)
Please refer to the "Standard of inserts".

NEGATIVE INSERTS WITH HOLE

Product Name	Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°
STANDARD	Multi-corner Type Double Sided (Solid CBN)	G	Flat Top	CNGA B031		SNGA B038	TNGA B041		
STANDARD	One-corner Type Single Sided	M	Flat Top	CNMA B031, B068					
STANDARD	One-corner Type Single Sided	G	Flat Top		DNGA B036, B068	SNGA B038, B069	TNGA B041, B069	VNGA B043, B070	

5° POSITIVE INSERTS WITH HOLE

Product Name	Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°
NEW PETIT CUT	Multi-corner Type Single Sided	G	Flat Top					NP-VBGW_○2 B061	
NEW PETIT CUT	One-corner Type Single Sided	G	Flat Top					NP-VBGW_○ B062	
NEW PETIT CUT	One-corner Type Single Sided With Breaker	G	R-F					NP-VBGT_R-F B077	

CLASSIFICATION

7° POSITIVE INSERTS WITH HOLE

Product Name	Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°
NEW PETIT CUT	Multi-corner Type Single Sided	G	Flat Top	NP-CCGW/B_○2 * B049	NP-DCGW_○2 * B054		NP-TCGW_○3 B057	NP-VCGW_○2 B062	
	Multi-corner Type Single Sided With Wiper	G	Flat Top	NP-CCGW_○W○2 B050					
	Multi-corner Type Single Sided With Breaker	G	BF	BF-CCGT_○2 B051	BF-DCGT_○2 B055				
	Multi-corner Type Single Sided With Breaker	G	BM	BM-CCGT_○2 B051	BM-DCGT_○2 B055				
	One-corner Type Single Sided	M	Flat Top	NP-CCMB_○ B051					
	One-corner Type Single Sided With Breaker	M	Standard	NP-CCMH B072					
	One-corner Type Single Sided	G	Flat Top	NP-CCGW_○ B051	NP-DCGW_○ B056				
	One-corner Type Single Sided	M	Flat Top	NP-CCMW_○ B052	NP-DCMW_○ B056				NP-WCMW_○ B063
	One-corner Type Single Sided	M	Flat Top	NP-CCMW B072					
	One-corner Type Single Sided With Breaker	M	R/L-F		NP-DCMT_R/L-F B073				
	One-corner Type Single Sided With Breaker	G	R-F					NP-VCGT_R-F B077	
STANDARD	Multi-corner Type Single Sided	G	Flat Top	CCGW B052	DCGW B056		TCGW B057		
	One-corner Type Single Sided	M G	Flat Top	CCMW B052, B072	DCMW B056, B073		TCMW TCGW B057, B074		WCMW B078

Note1) Two types of packs for * type inserts, pack of single insert and pack of ten inserts, are available. (The single pack is standard.)
Please refer to the "Standard of inserts".

11° POSITIVE INSERTS WITH HOLE

Product Name	Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Rhombic 35°	Trigon 80°
NEW PETIT CUT	Multi-corner Type Single Sided	G	Flat Top	NP-CPGB_○2 B053			NP-TPGB_○3 B058		
NEW PETIT CUT	Multi-corner Type Single Sided	G	Flat Top				NP-TPGX_○3 B059		
NEW PETIT CUT	One-corner Type Single Sided	M	Flat Top	NP-CPMB_○ B053			NP-TPMB_○ B059		
NEW PETIT CUT	One-corner Type Single Sided With Breaker	M	Standard	NP-CPMH B072					
NEW PETIT CUT	One-corner Type Single Sided	G	Flat Top				NP-TPGX_○ B059		
NEW PETIT CUT	One-corner Type Single Sided With Breaker	M	R/L-F				NP-TPMX_R/L-F B075		
NEW PETIT CUT	One-corner Type Single Sided With Breaker	M	R/L-F				NP-TPMH_R/L-F B075		
STANDARD	One-corner Type Single Sided With Breaker	G	Standard	CPGT B072					WPGT B078
STANDARD	One-corner Type Single Sided	G	Flat Top			SPGX B073	TPGX B060, B076		
STANDARD	One-corner Type Single Sided With Breaker	G	R/L-F				TPGT/V_R/L-F B075, B076		

CLASSIFICATION

15° POSITIVE INSERTS WITH HOLE

Type	Tolerance	Breaker Name and Cross Section	Rhombic 35°	
One-corner Type Single Sided (For Aluminium With Breaker)	G	**R/L**	**VDGX_R/L-F** B080	

20° POSITIVE INSERTS WITH HOLE

Type	Tolerance	Breaker Name and Cross Section	Rhombic 55°	Triangular 60°
One-corner Type Single Sided (For Aluminium With Breaker)	G	**R/L**		**TEGX_R/L** B079
One-corner Type Single Sided (For Aluminium With Breaker)		**R/L-F**	**DEGX_R/L-F** B079	
One-corner Type Single Sided (For Aluminium)		**Flat Top**		**TEGX** B079

NEGATIVE INSERTS WITHOUT HOLE

Type	Tolerance	Breaker Name and Cross Section	Rhombic 80°	Rhombic 55°	Square 90°	Triangular 60°	Round
One-corner Type Single Sided	G	Flat Top			SNGN B047, B071	TNGN B048	
Multi-corner Type Double Sided (Solid CBN)		Flat Top	CNGN B045	DNGN B045	SNGN B047	TNGN B048	RNGN B046

5° POSITIVE INSERTS WITHOUT HOLE

Type	Tolerance	Breaker Name and Cross Section	Triangular 60°	
Multi-corner Type Single Sided	G	Flat Top	TBGN B065	

11° POSITIVE INSERTS WITHOUT HOLE

Type	Tolerance	Breaker Name and Cross Section	Square 90°	Triangular 60°
One-corner Type Single Sided	G	Flat Top	SPGN B064, B081	TPGN B065, B081

SPECIAL PURPOSE INSERTS

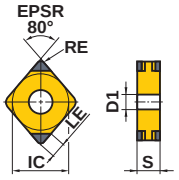
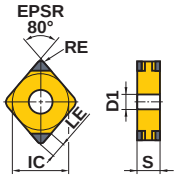
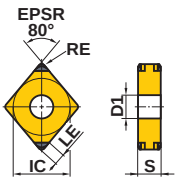
Tool Holder Type	Tolerance	Inserts
GY Type	G	GY_GFGS B066
MG Type		MGTR B067
TL Type		RTG-A B063

80° CN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CNGA120404FS4	●	●	●				●												12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 –008
	NP-CNGA120408FS4	●	●	●				●												12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412FS4	●	●	●				●												12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GS4	●	●																	12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GS4	●	●																	12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GS4	●	●																	12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GA4			●	●		▲		●											12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GA4			●	●		▲		●											12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GA4			●	●		▲		●											12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GH4		●	●	●															12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GH4		●	●	●															12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GH4		●	●	●															12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404TS4		●																	12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TS4		●																	12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TS4		●																	12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404TA4			●	●		▲		●	●										12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TA4			●	●		▲		●	●										12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TA4			●	●		▲		●	●										12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404TH4			●	●					●										12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TH4			●	●					●										12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TH4			●	●					●										12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GN4						▲													12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GN4						▲													12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GN4						▲													12.7	4.76	1.2	2.3	5.16		
NEW PETIT CUT (With Wiper) *	NP-CNGA120404FSWS4	●	●	●				●												12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 –008
	NP-CNGA120408FSWS4	●	●	●				●												12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412FSWS4	●	●	●				●												12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GAWS4			●	●				●											12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GAWS4			●	●				●											12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GAWS4			●	●				●											12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GSWS4	●	●																	12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GSWS4	●	●																	12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GSWS4	●	●																	12.7	4.76	1.2	2.3	5.16		
NEW PETIT CUT (With Breaker)	BF-CNGG120404TA4						▲													12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 –008
	BF-CNGG120408TA4						▲													12.7	4.76	0.8	2.1	5.16		
	BF-CNGG120412TA4						▲													12.7	4.76	1.2	2.3	5.16		

* Please refer to B018 before using the wiper insert.

● = NEW

● : Inventory maintained in Japan.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CNGA120402FS2		●					●												12.7	4.76	0.2	1.8	5.16		
	NP-CNGA120404FS2	●	●	●				●							●	●	●			12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408FS2	●	●	●				●			▲				●	●	●			12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412FS2	●	●	●				●			▲				●	●	●			12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120402GS2		●																	12.7	4.76	0.2	1.8	5.16		
	NP-CNGA120404GS2	●	●			▲									●	●	●	●		12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GS2	●	●			▲					▲				●	●	●	●		12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GS2	●	●			▲					▲				●	●	●	●		12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120402GA2			●					●											12.7	4.76	0.2	1.8	5.16		
	NP-CNGA120404GA2			●	●		▲		●		▲									12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GA2			●	●		▲		●		▲									12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GA2			●	●		▲		●		▲									12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GH2		●	●	●															12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GH2		●	●	●															12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GH2		●	●	●															12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404TS2		●												●	●				12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TS2		●												●	●				12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TS2		●												●	●				12.7	4.76	1.2	2.3	5.16	EPSR 80° RE LE IC D1 S	C008 C009 E013 E036 E041 H006 —008
	NP-CNGA120404TA2			●	●		▲		●	●	▲			▲				●		12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TA2			●	●		▲		●	●	▲			▲				●		12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TA2			●	●		▲		●	●	▲			▲				●		12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404TH2			●	●					●										12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408TH2			●	●					●										12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412TH2			●	●					●										12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GN2						▲													12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GN2						▲													12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GN2						▲													12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404G2										▲									12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408G2										▲									12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412G2										▲									12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404T2										▲									12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408T2										▲									12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412T2										▲									12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404SF2														●	●				12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408SF2														●	●				12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412SF2														●	●				12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404SE2														●	●				12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408SE2														●	●				12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412SE2														●	●				12.7	4.76	1.2	2.3	5.16		

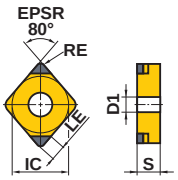
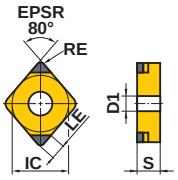
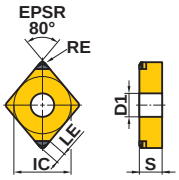
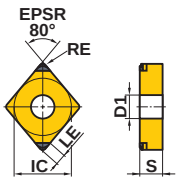
● = NEW

80° CN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✱	●	◐	●	◐	✱	◐	●	◐	✱					
	K	Cast Iron														◐		●	◐	✱
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT ✱2	TNP-CNGA120404G2										▲									12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 —008
	TNP-CNGA120408G2										▲									12.7	4.76	0.8	2.1	5.16		
	TNP-CNGA120412G2										▲									12.7	4.76	1.2	2.3	5.16		
	TNP-CNGA120404T2										▲									12.7	4.76	0.4	1.9	5.16		
	TNP-CNGA120408T2										▲									12.7	4.76	0.8	2.1	5.16		
	TNP-CNGA120412T2										▲									12.7	4.76	1.2	2.3	5.16		
NEW PETIT CUT (With Wiper) ✱1	NP-CNGA120404FSWS2	●	●	●				●												12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 —008
	NP-CNGA120408FSWS2	●	●	●				●												12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412FSWS2	●	●	●				●												12.7	4.76	1.2	2.3	5.16		
	NEW NP-CNGA120404FBWL2	●	●	●				●												12.7	4.76	0.4	1.9	5.16		
	NEW NP-CNGA120408FBWL2	●	●	●				●												12.7	4.76	0.8	2.1	5.16		
	NEW NP-CNGA120412FBWL2	●	●	●				●												12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GAWS2			●	●		▲		●		▲									12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GAWS2			●	●		▲		●		▲									12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GAWS2			●	●		▲		●		▲									12.7	4.76	1.2	2.3	5.16		
	NP-CNGA120404GSWS2	●	●			▲														12.7	4.76	0.4	1.9	5.16		
	NP-CNGA120408GSWS2	●	●			▲														12.7	4.76	0.8	2.1	5.16		
	NP-CNGA120412GSWS2	●	●			▲														12.7	4.76	1.2	2.3	5.16		
	NEW NP-CNGA120404GBWL2	●	●	●					●											12.7	4.76	0.4	1.9	5.16		
	NEW NP-CNGA120408GBWL2	●	●	●					●											12.7	4.76	0.8	2.1	5.16		
	NEW NP-CNGA120412GBWL2	●	●	●					●											12.7	4.76	1.2	2.3	5.16		
NEW PETIT CUT (With Breaker)	BF-CNGM120404TS2		●																	12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 —008
	BF-CNGM120408TS2		●																	12.7	4.76	0.8	2.1	5.16		
	BF-CNGM120412TS2		●																	12.7	4.76	1.2	2.3	5.16		
	BF-CNGM120404TA2						▲													12.7	4.76	0.4	1.9	5.16		
	BF-CNGM120408TA2						▲													12.7	4.76	0.8	2.1	5.16		
	BF-CNGM120412TA2						▲													12.7	4.76	1.2	2.3	5.16		
NEW PETIT CUT (With Breaker)	BM-CNGM120404TA2			●																12.7	4.76	0.4	1.9	5.16		C008 C009 E013 E036 E041 H006 —008
	BM-CNGM120408TA2			●																12.7	4.76	0.8	2.1	5.16		
	BM-CNGM120412TA2			●																12.7	4.76	1.2	2.3	5.16		

✱1 Please refer to B018 before using the wiper insert.
✱2 The order number is for a 10-insert pack. Please specify order number, grade and quantity.

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.
(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CNMA120404GS																●	●		12.7	4.76	0.4	1.9	5.16	EPSR 80° LE RE D1 IC S	C008 C009 E013 E036 E041 H006 –008
	NP-CNMA120408GS																●	●		12.7	4.76	0.8	2.1	5.16		
	NP-CNMA120412GS																●	●		12.7	4.76	1.2	2.3	5.16		
	NP-CNMA120404F										□	▲					●			12.7	4.76	0.4	1.9	5.16		
	NP-CNMA120408F										□	▲					●			12.7	4.76	0.8	2.1	5.16		
	NP-CNMA120412F										□	▲					●			12.7	4.76	1.2	2.3	5.16		
	NP-CNMA120404G										▲		▲							12.7	4.76	0.4	1.9	5.16		
	NP-CNMA120408G										▲		▲							12.7	4.76	0.8	2.1	5.16		
	NP-CNMA120412G										▲		▲							12.7	4.76	1.2	2.3	5.16		
	NP-CNMA120404T										□		▲	▲				●		12.7	4.76	0.4	1.9	5.16		
	NP-CNMA120408T										□		▲	▲				●		12.7	4.76	0.8	2.1	5.16		
	NP-CNMA120412T										□		▲	▲				●		12.7	4.76	1.2	2.3	5.16		
	CNMA120404											▲					●	●		12.7	4.76	0.4	3.7	5.16	EPSR 80° LE RE D1 IC S	C008 C009 E013 E036 E041 H006 –008
	CNMA120408											▲					●	●		12.7	4.76	0.8	3.6	5.16		
	CNMA120412																●	●		12.7	4.76	1.2	3.6	5.16		
	CNGA120408																		●	12.7	4.76	0.8	–	5.16	EPSR 80° RE D1 IC S	C008 C009 E013 E036 E041 H006 –008
	CNGA120412																		●	12.7	4.76	1.2	–	5.16		

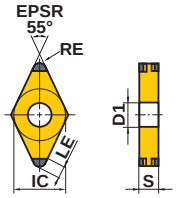
● = NEW

55° DN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-DNGA150404FS4	●	●	●				●												12.7	4.76	0.4	2.1	5.16		C010 C011 E013 E036 —041 H009 —011
	NP-DNGA150408FS4	●	●	●				●												12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412FS4	●	●	●				●												12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604FS4	●	●					●												12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608FS4	●	●					●												12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612FS4	●	●					●												12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GS4	●	●																	12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GS4	●	●																	12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GS4	●	●																	12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604GS4	●	●																	12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GS4	●	●																	12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GS4	●	●																	12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GA4			●	●		▲		●											12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GA4			●	●		▲		●											12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GA4			●	●		▲		●											12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604GA4			●	●				●											12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GA4			●	●				●											12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GA4			●	●				●											12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GH4		●	●	●															12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GH4		●	●	●															12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GH4		●	●	●															12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604GH4		●	●	●															12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GH4		●	●	●															12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GH4		●	●	●															12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404TS4		●																	12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408TS4		●																	12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412TS4		●																	12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604TS4		●																	12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608TS4		●																	12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TS4		●																	12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404TA4			●	●		▲		●	●										12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408TA4			●	●		▲		●	●										12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412TA4			●	●		▲		●	●										12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604TA4			●	●				●											12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608TA4			●	●				●											12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TA4			●	●				●											12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404TH4			●	●					●										12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408TH4			●	●					●										12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412TH4			●	●					●										12.7	4.76	1.2	1.9	5.16		

● = NEW

● : Inventory maintained in Japan.

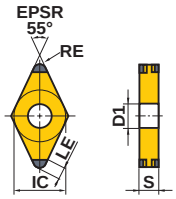
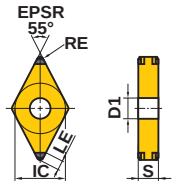
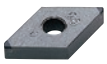
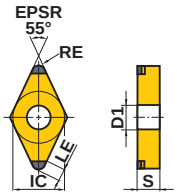
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
								NEW							NEW					IC	S	RE	LE	D1		
NEW PETIT CUT	NP-DNGA150604TH4			●	●														12.7	6.35	0.4	2.1	5.16		C010 C011 E013 E036 −041 H009 −011
	NP-DNGA150608TH4			●	●														12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TH4			●	●														12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GN4						▲												12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GN4						▲												12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GN4						▲												12.7	4.76	1.2	1.9	5.16		
NEW PETIT CUT (With Breaker)	BF-DNGG150404TA4						▲												12.7	4.76	0.4	2.1	5.16		C010 C011 E013 E036 −041 H009 −011
	BF-DNGG150408TA4						▲												12.7	4.76	0.8	2.0	5.16		
	BF-DNGG150412TA4						▲												12.7	4.76	1.2	1.9	5.16		
NEW PETIT CUT 	NP-DNGA150402FS2		●					●											12.7	4.76	0.2	2.3	5.16		C010 C011 E013 E036 −041 H009 −011
	NP-DNGA150404FS2	●	●	●				●								●	●			12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408FS2	●	●	●				●								●	●			12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412FS2	●	●	●				●								●	●			12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604FS2	●	●	●				●								●				12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608FS2	●	●	●				●								●				12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612FS2	●	●	●				●								●				12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150402GS2		●																	12.7	4.76	0.2	2.3	5.16		
	NP-DNGA150404GS2	●	●			▲										●				12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150404GS2																	●	●	12.7	4.76	0.4	1.5	5.16		
	NP-DNGA150408GS2	●	●			▲										●				12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150408GS2																	●	●	12.7	4.76	0.8	1.7	5.16		
	NP-DNGA150412GS2	●	●			▲										●		●	●	12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604GS2	●	●													●				12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GS2	●	●													●				12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GS2	●	●													●				12.7	6.35	1.2	1.9	5.16		
	NP-DNGA110408GA2			●	●				●											9.525	4.76	0.8	2.0	3.81		
	NP-DNGA150402GA2			●																12.7	4.76	0.2	2.3	5.16		
	NP-DNGA150404GA2			●	●		▲		●		▲									12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GA2			●	●		▲		●		▲									12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GA2			●	●		▲		●		▲									12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150602GA2			●																12.7	6.35	0.2	2.3	5.16		
	NP-DNGA150604GA2			●	●				●											12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GA2			●	●				●											12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GA2			●	●				●											12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GH2		●	●	●															12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GH2		●	●	●															12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GH2		●	●	●															12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604GH2		●	●	●															12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608GH2		●	●	●															12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612GH2		●	●	●															12.7	6.35	1.2	1.9	5.16		

● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

55° DN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-DNGA150404TS2		●												●	●				12.7	4.76	0.4	2.1	5.16	EPSR 55° RE IC LE D1 S	C010 C011 E013 E036 −041 H009 −011
	NP-DNGA150408TS2		●												●	●				12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412TS2		●												●	●				12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604TS2		●												●					12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608TS2		●												●					12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TS2		●												●					12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404TA2			●	●		▲		●	●										12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150404TA2													▲						12.7	4.76	0.4	1.5	5.16		
	NP-DNGA150408TA2			●	●		▲		●	●										12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150408TA2													▲						12.7	4.76	0.8	1.7	5.16		
	NP-DNGA150412TA2			●	●		▲		●	●										12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604TA2			●	●				●											12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608TA2			●	●				●											12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TA2			●	●				●											12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404TH2			●	●						●									12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408TH2			●	●						●									12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412TH2			●	●						●									12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150604TH2			●	●															12.7	6.35	0.4	2.1	5.16		
	NP-DNGA150608TH2			●	●															12.7	6.35	0.8	2.0	5.16		
	NP-DNGA150612TH2			●	●															12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404GN2						▲													12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408GN2						▲													12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412GN2						▲													12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150404G2										▲									12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408G2										▲									12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412G2										▲									12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150404T2										▲									12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408T2										▲									12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412T2										▲									12.7	4.76	1.2	1.9	5.16		
	NP-DNGA150404SF2														●	●				12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408SF2														●	●				12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412SF2														●	●				12.7	4.76	1.2	1.9	5.16		
	NEW NP-DNGA150604SF2														●					12.7	6.35	0.4	2.1	5.16		
	NEW NP-DNGA150608SF2														●					12.7	6.35	0.8	2.0	5.16		
	NEW NP-DNGA150612SF2														●					12.7	6.35	1.2	1.9	5.16		
	NP-DNGA150404SE2														●	●				12.7	4.76	0.4	2.1	5.16		
	NP-DNGA150408SE2														●	●				12.7	4.76	0.8	2.0	5.16		
	NP-DNGA150412SE2														●	●				12.7	4.76	1.2	1.9	5.16		
	NEW NP-DNGA150604SE2														●					12.7	6.35	0.4	2.1	5.16		
	NEW NP-DNGA150608SE2														●					12.7	6.35	0.8	2.0	5.16		
	NEW NP-DNGA150612SE2														●					12.7	6.35	1.2	1.9	5.16		

● = NEW

● : **Inventory maintained in Japan.**

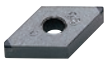
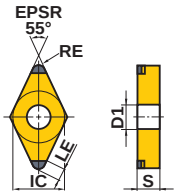
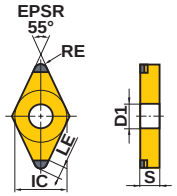
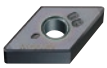
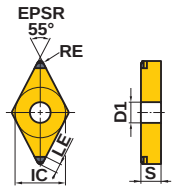
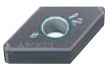
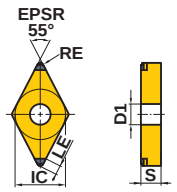
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT *2 	TNP-DNGA150404G2										▲									12.7	4.76	0.4	2.1	5.16		C010 C011 E013 E036 −041 H009 −011
	TNP-DNGA150408G2										▲									12.7	4.76	0.8	2.0	5.16		
	TNP-DNGA150412G2										▲									12.7	4.76	1.2	1.9	5.16		
	TNP-DNGA150404T2										▲									12.7	4.76	0.4	2.1	5.16		
	TNP-DNGA150408T2										▲									12.7	4.76	0.8	2.0	5.16		
	TNP-DNGA150412T2										▲									12.7	4.76	1.2	1.9	5.16		
NEW PETIT CUT (With Wiper) *1	NP-DNGA150404GAWS2JR			●			▲		●		▲									12.7	4.76	0.4	1.9	5.16		C010 C011 E013 E036 −041 H009 −011
	NP-DNGA150404GAWS2JL			●			▲		●		▲									12.7	4.76	0.4	1.9	5.16		
	NP-DNGA150408GAWS2JR			●			▲		●		▲									12.7	4.76	0.8	1.7	5.16		
	NP-DNGA150408GAWS2JL			●			▲		●		▲									12.7	4.76	0.8	1.7	5.16		
	NP-DNGA150604GAWS2JR			●					●											12.7	6.35	0.4	1.9	5.16		
	NP-DNGA150604GAWS2JL			●					●											12.7	6.35	0.4	1.9	5.16		
	NP-DNGA150608GAWS2JR			●					●											12.7	6.35	0.8	1.7	5.16		
	NP-DNGA150608GAWS2JL			●					●											12.7	6.35	0.8	1.7	5.16		
	NP-DNGA150404GSWS2JR					▲														12.7	4.76	0.4	1.9	5.16		
	NP-DNGA150404GSWS2JL					▲														12.7	4.76	0.4	1.9	5.16		
	NP-DNGA150408GSWS2JR					▲														12.7	4.76	0.8	1.7	5.16		
	NP-DNGA150408GSWS2JL					▲														12.7	4.76	0.8	1.7	5.16	Right hand insert shown.	
NEW PETIT CUT 	BF-DNGM150404TS2		●																	12.7	4.76	0.4	2.1	5.16		C010 C011 E013 E036 −041 H009 −011
	BF-DNGM150408TS2		●																	12.7	4.76	0.8	2.0	5.16		
	BF-DNGM150412TS2		●																	12.7	4.76	1.2	1.9	5.16		
	BF-DNGM150404TA2						▲													12.7	4.76	0.4	2.1	5.16		
	BF-DNGM150408TA2						▲													12.7	4.76	0.8	2.0	5.16		
(With Breaker)	BF-DNGM150412TA2						▲													12.7	4.76	1.2	1.9	5.16		
NEW PETIT CUT 	BM-DNGM150404TA2			●																12.7	4.76	0.4	2.1	5.16		C010 C011 E013 E036 −041 H009 −011
	BM-DNGM150408TA2			●																12.7	4.76	0.8	2.0	5.16		
	BM-DNGM150412TA2			●																12.7	4.76	1.2	1.9	5.16		
	BM-DNGM150604TA2			●																12.7	6.35	0.4	2.1	5.16		
	BM-DNGM150608TA2			●																12.7	6.35	0.8	2.0	5.16		
(With Breaker)	BM-DNGM150612TA2			●																12.7	6.35	1.2	1.9	5.16		

*1 Please refer to B018 before using the wiper insert.
*2 The order number is for a 10-insert pack. Please specify order number, grade and quantity.

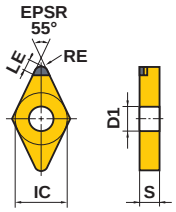
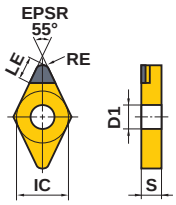
● = NEW

55° DN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-DNMA150404GS																●	●		12.7	4.76	0.4	1.5	5.16		C010 C011 E013 E036 −041 H009 −011
	NP-DNMA150408GS																●	●		12.7	4.76	0.8	1.7	5.16		
	NP-DNMA150404F										□									12.7	4.76	0.4	2.1	5.16		
	NP-DNMA150404F											▲					●			12.7	4.76	0.4	1.5	5.16		
	NP-DNMA150408F										□									12.7	4.76	0.8	2.0	5.16		
	NP-DNMA150408F											▲					●			12.7	4.76	0.8	1.7	5.16		
	NP-DNMA150412F										□									12.7	4.76	1.2	1.9	5.16		
	NP-DNMA150404G										▲									12.7	4.76	0.4	2.1	5.16		
	NP-DNMA150404G												▲							12.7	4.76	0.4	1.5	5.16		
	NP-DNMA150408G										▲									12.7	4.76	0.8	2.0	5.16		
	NP-DNMA150408G												▲							12.7	4.76	0.8	1.7	5.16		
	NP-DNMA150412G										▲									12.7	4.76	1.2	1.9	5.16		
	NP-DNMA150404T										□									12.7	4.76	0.4	2.1	5.16		
	NP-DNMA150404T												▲	▲				●		12.7	4.76	0.4	1.5	5.16		
	NP-DNMA150408T										□									12.7	4.76	0.8	2.0	5.16		
	NP-DNMA150408T												▲	▲				●		12.7	4.76	0.8	1.7	5.16		
	NP-DNMA150412T										□									12.7	4.76	1.2	1.9	5.16		
	DNGA150404																□	□		12.7	4.76	0.4	3.6	5.16		C010 C011 E013 E036 −041 H009 −011
	DNGA150408																□	□		12.7	4.76	0.8	3.2	5.16		
	DNGA150412																□	□		12.7	4.76	1.2	2.8	5.16		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

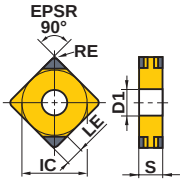
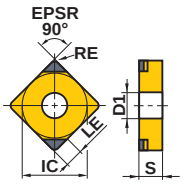
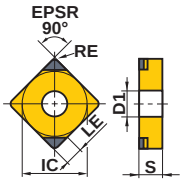
(1 insert in one case)

90° SN TYPE INSERTS WITH HOLE

Work Material		
	H	Hardened Materials
	K	Cast Iron
	S	Heat-resistant Alloy, Titanium Alloy
		Sintered Alloy

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN										Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-SNGA120404GA4						▲													12.7	4.76	0.4	2.1	5.16		C012 −015 E014 E035
	NP-SNGA120408GA4						▲													12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412GA4						▲													12.7	4.76	1.2	2.5	5.16		
NEW PETIT CUT	NP-SNGA120404FS2														●	●				12.7	4.76	0.4	2.1	5.16		C012 −015 E014 E035
	NP-SNGA120408FS2														●	●				12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412FS2														●	●				12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404GS2					▲									●					12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408GS2					▲									●		●	●		12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412GS2					▲									●		●	●		12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120408GA2			●	●				●											12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412GA2			●	●				●											12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404TS2														●	●				12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408TS2														●	●				12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412TS2														●	●				12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404G2										▲									12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408G2										▲									12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412G2										▲									12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404T2										▲									12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408T2										▲									12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412T2										▲									12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404SF2														●	●				12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408SF2														●	●				12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412SF2														●	●				12.7	4.76	1.2	2.5	5.16		
	NP-SNGA120404SE2														●	●				12.7	4.76	0.4	2.1	5.16		
	NP-SNGA120408SE2														●	●				12.7	4.76	0.8	2.3	5.16		
	NP-SNGA120412SE2														●	●				12.7	4.76	1.2	2.5	5.16		
NEW PETIT CUT *	TNP-SNGA120404G2										▲									12.7	4.76	0.4	2.1	5.16		C012 −015 E014 E035
	TNP-SNGA120408G2										▲									12.7	4.76	0.8	2.3	5.16		
	TNP-SNGA120412G2										▲									12.7	4.76	1.2	2.5	5.16		
	TNP-SNGA120404T2										▲									12.7	4.76	0.4	2.1	5.16		
	TNP-SNGA120408T2										▲									12.7	4.76	0.8	2.3	5.16		
	TNP-SNGA120412T2										▲									12.7	4.76	1.2	2.5	5.16		

* The order number is for a 10-insert pack. Please specify order number, grade and quantity.

● = NEW

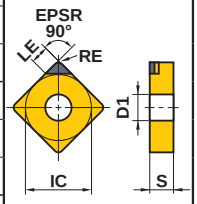
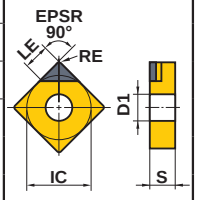
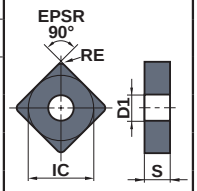
GRADES ➤ B006
IDENTIFICATION ➤ B002

90° SN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-SNMA120404GS																●	●		12.7	4.76	0.4	2.1	5.16		C012 −015 E014 E035
	NP-SNMA120408GS																●	●		12.7	4.76	0.8	2.3	5.16		
	NP-SNMA120404F										□	▲					●			12.7	4.76	0.4	2.1	5.16		
	NP-SNMA120408F										□	▲					●			12.7	4.76	0.8	2.3	5.16		
	NP-SNMA120412F										□	▲					●			12.7	4.76	1.2	2.5	5.16		
	NP-SNMA120404G										▲		▲							12.7	4.76	0.4	2.1	5.16		
	NP-SNMA120408G										▲		▲							12.7	4.76	0.8	2.3	5.16		
	NP-SNMA120412G										▲									12.7	4.76	1.2	2.5	5.16		
	NP-SNMA120404T										□		▲	▲				●		12.7	4.76	0.4	2.1	5.16		
	NP-SNMA120408T										□		▲	▲				●		12.7	4.76	0.8	2.3	5.16		
	NP-SNMA120412T										□		▲	▲				●		12.7	4.76	1.2	2.5	5.16		
	SNGA120404																□	□		12.7	4.76	0.4	4.0	5.16		C012 −015 E014 E035
	SNGA120408																●	●		12.7	4.76	0.8	4.1	5.16		
	SNGA120412																●	●		12.7	4.76	1.2	4.1	5.16		
	SNGA120408																		●	12.7	4.76	0.8	—	5.16		C012 −015 E014 E035
	SNGA120412																		●	12.7	4.76	1.2	—	5.16		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

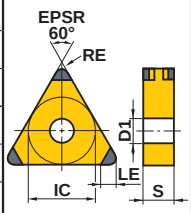
60° TN TYPE INSERTS WITH HOLE

Work Material		
	H	Hardened Materials
	K	Cast Iron
	S	Heat-resistant Alloy, Titanium Alloy
		Sintered Alloy

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN										Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	NEW MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-TNGA160404FS6	●	●	●				●												9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408FS6	●	●	●				●												9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412FS6	●	●	●				●												9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404GS6	●	●																	9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GS6	●	●																	9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GS6	●	●																	9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404GA6			●	●		▲		●											9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GA6			●	●		▲		●											9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GA6			●	●		▲		●											9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404GH6		●	●	●															9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GH6		●	●	●															9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GH6		●	●	●															9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404TS6		●																	9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TS6		●																	9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TS6		●																	9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404TA6			●	●		▲		●	●										9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TA6			●	●		▲		●	●										9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TA6			●	●		▲		●	●										9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404TH6			●	●					●										9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TH6			●	●					●										9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TH6			●	●					●										9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404GN6						▲													9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GN6						▲													9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GN6						▲													9.525	4.76	1.2	1.9	3.81		
NEW PETIT CUT	NP-TNGA160402FS3		●					●												9.525	4.76	0.2	1.5	3.81		
	NP-TNGA160404FS3	●	●	●				●							●	●				9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408FS3	●	●	●				●							●	●				9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412FS3	●	●	●				●							●	●				9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160402GS3		●																	9.525	4.76	0.2	1.5	3.81		
	NP-TNGA160404GS3	●	●			▲									●					9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GS3	●	●			▲									●		●	●		9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GS3	●	●			▲									●		●	●		9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160402GA3			●			▲		●											9.525	4.76	0.2	1.5	3.81		
	NP-TNGA160404GA3			●	●		▲		●		▲									9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GA3			●	●		▲		●		▲									9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GA3			●	●		▲		●		▲									9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404GH3		●	●	●															9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GH3		●	●	●															9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GH3		●	●	●															9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404TS3		●												●	●				9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TS3		●												●	●				9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TS3		●												●	●				9.525	4.76	1.2	1.9	3.81		



C016
C017
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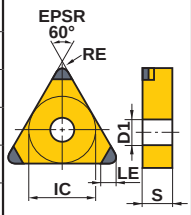

C016
C017
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E040

● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

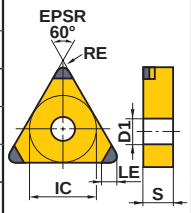
60° TN TYPE INSERTS WITH HOLE

Work Material		
	H	Hardened Materials
	K	Cast Iron
	S	Heat-resistant Alloy, Titanium Alloy
		Sintered Alloy

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	CBN MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	Solid CBN MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-TNGA160404TA3			●	●		▲		●	●										9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TA3			●	●		▲		●	●	▲			▲						9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TA3			●	●		▲		●	●	▲									9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404TH3			●	●					●										9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408TH3			●	●					●										9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412TH3			●	●					●										9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160402GN3						▲													9.525	4.76	0.2	1.5	3.81		
	NP-TNGA160404GN3						▲													9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408GN3						▲													9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412GN3						▲													9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404G3										▲									9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408G3										▲									9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412G3										▲									9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404T3										▲									9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408T3										▲									9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412T3										▲									9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404SF3														●	●				9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408SF3														●	●				9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412SF3														●	●				9.525	4.76	1.2	1.9	3.81		
	NP-TNGA160404SE3														●	●				9.525	4.76	0.4	1.6	3.81		
	NP-TNGA160408SE3														●	●				9.525	4.76	0.8	1.8	3.81		
	NP-TNGA160412SE3														●	●				9.525	4.76	1.2	1.9	3.81		
NEW PETIT CUT *	TNP-TNGA160404G3										▲									9.525	4.76	0.4	1.6	3.81		
	TNP-TNGA160408G3										▲									9.525	4.76	0.8	1.8	3.81		
	TNP-TNGA160412G3										▲									9.525	4.76	1.2	1.9	3.81		
	TNP-TNGA160404T3										▲									9.525	4.76	0.4	1.6	3.81		
	TNP-TNGA160408T3										▲									9.525	4.76	0.8	1.8	3.81		
	TNP-TNGA160412T3										▲									9.525	4.76	1.2	1.9	3.81		
NEW PETIT CUT (With Breaker)	BM-TNGM160408TA3			●																9.525	4.76	0.8	1.8	3.81		
	BM-TNGM160412TA3			●																9.525	4.76	1.2	1.9	3.81		
NEW PETIT CUT	NP-TNMA160404GS																●	●		9.525	4.76	0.4	1.6	3.81		
	NP-TNMA160408GS																●	●		9.525	4.76	0.8	1.8	3.81		
	NP-TNMA160412GS																●	●		9.525	4.76	1.2	1.9	3.81		
	NP-TNMA160404F										□	▲					●			9.525	4.76	0.4	1.6	3.81		
	NP-TNMA160408F										□	▲					●			9.525	4.76	0.8	1.8	3.81		
	NP-TNMA160412F										□	▲					□			9.525	4.76	1.2	1.9	3.81		



C016
C017
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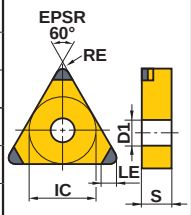

C016
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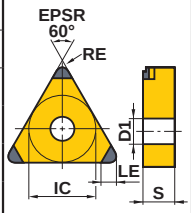

C016
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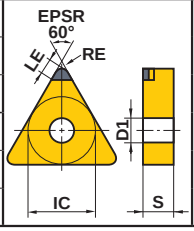


C016
C017
E014
E035
E040

* The order number is for a 10-insert pack. Please specify order number, grade and quantity.

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

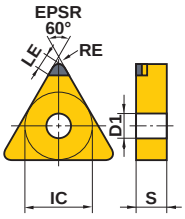
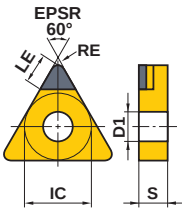
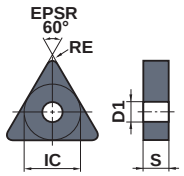
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-TNMA160404G										▲		▲							9.525	4.76	0.4	1.6	3.81		C016 C017 E014 E035 E040
	NP-TNMA160408G										▲		▲							9.525	4.76	0.8	1.8	3.81		
	NP-TNMA160412G										▲		▲							9.525	4.76	1.2	1.9	3.81		
	NP-TNMA160404T										□		▲	▲				●		9.525	4.76	0.4	1.6	3.81		
	NP-TNMA160408T										□		▲	▲				●		9.525	4.76	0.8	1.8	3.81		
	NP-TNMA160412T										□		▲	▲				□		9.525	4.76	1.2	1.9	3.81		
	TNGA160404											▲					●	●		9.525	4.76	0.4	3.7	3.81		C016 C017 E014 E035 E040
	TNGA160408											▲					●	●		9.525	4.76	0.8	3.4	3.81		
	TNGA220404																●	□		12.7	4.76	0.4	3.7	5.16		
	TNGA220408																●	□		12.7	4.76	0.8	3.4	5.16		
	TNGA220412																●	□		12.7	4.76	1.2	3.1	5.16		
	TNGA160408																		●	9.525	4.76	0.8	—	3.81		C016 C017 E014 E035 E040
	TNGA160412																		●	9.525	4.76	1.2	—	3.81		

● = NEW

35° VN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
								NEW							NEW					IC	S	RE	LE	D1		
NEW PETIT CUT	NP-VNGA160404FS4	●	●	●				●											9.525	4.76	0.4	2.5	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	NP-VNGA160408FS4	●	●	●				●											9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412FS4			●															9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404GS4	●	●																9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GS4	●	●																9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GS4		●																9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404GA4			●	●		▲		●										9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GA4			●	●		▲		●										9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GA4			●	●				●										9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404GH4		●	●	●														9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GH4		●	●	●														9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GH4		●	●	●														9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404TS4		●																9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408TS4		●																9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160404TA4			●	●				●										9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408TA4			●	●				●										9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412TA4			●	●				●										9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404TH4			●	●														9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408TH4			●	●														9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412TH4			●	●														9.525	4.76	1.2	1.6	3.81		
NEW PETIT CUT	NP-VNGA160402FS2		●						●										9.525	4.76	0.2	2.5	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	NP-VNGA160404FS2	●	●	●					●							●	●		9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408FS2	●	●	●					●							●	●		9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412FS2			●															9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160402GS2		●																9.525	4.76	0.2	2.5	3.81		
	NP-VNGA160404GS2	●	●			▲										●	●		9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GS2	●	●			▲										●	●		9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GS2		●																9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160402GA2			●			▲		●										9.525	4.76	0.2	2.5	3.81		
	NP-VNGA160404GA2			●	●		▲		●		▲								9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GA2			●	●		▲		●		▲								9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GA2			●	●				●										9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404GH2		●	●	●														9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408GH2		●	●	●														9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412GH2		●	●	●														9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160404TS2		●													●	●		9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408TS2		●													●	●		9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160404TA2			●	●				●										9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408TA2			●	●				●										9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412TA2			●	●				●										9.525	4.76	1.2	1.6	3.81		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✣	●	◐	●	◐	✣	◐	●	◐	✣					
	K	Cast Iron														◐		●	◐	✣
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-VNGA160404TH2			●	●															9.525	4.76	0.4	2.5	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	NP-VNGA160408TH2			●	●															9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160412TH2			●	●															9.525	4.76	1.2	1.6	3.81		
	NP-VNGA160402GN2						▲													9.525	4.76	0.2	2.5	3.81		
	NP-VNGA160404G2										▲									9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408G2										▲									9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160404T2										▲									9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408T2										▲									9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160404SF2														●	●				9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408SF2														●	●				9.525	4.76	0.8	2.0	3.81		
	NP-VNGA160404SE2														●	●				9.525	4.76	0.4	2.5	3.81		
	NP-VNGA160408SE2														●	●				9.525	4.76	0.8	2.0	3.81		
NEW PETIT CUT *	TNP-VNGA160404G2										▲									9.525	4.76	0.4	2.5	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	TNP-VNGA160408G2										▲									9.525	4.76	0.8	2.0	3.81		
	TNP-VNGA160404T2										▲									9.525	4.76	0.4	2.5	3.81		
	TNP-VNGA160408T2										▲									9.525	4.76	0.8	2.0	3.81		
NEW PETIT CUT	NP-VNMA160404GS																●	●		9.525	4.76	0.4	1.4	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	NP-VNMA160408GS																●	●		9.525	4.76	0.8	1.5	3.81		
	NP-VNMA160404F										□									9.525	4.76	0.4	2.5	3.81		
	NP-VNMA160404F											▲					●			9.525	4.76	0.4	1.4	3.81		
	NP-VNMA160408F										□									9.525	4.76	0.8	2.0	3.81		
	NP-VNMA160408F											▲					●			9.525	4.76	0.8	1.5	3.81		
	NP-VNMA160404G										▲									9.525	4.76	0.4	2.5	3.81		
	NP-VNMA160404G												▲							9.525	4.76	0.4	1.4	3.81		
	NP-VNMA160408G										▲									9.525	4.76	0.8	2.0	3.81		
	NP-VNMA160408G												▲							9.525	4.76	0.8	1.5	3.81		
	NP-VNMA160404T										□									9.525	4.76	0.4	2.5	3.81		
	NP-VNMA160404T												▲	▲				●		9.525	4.76	0.4	1.4	3.81		
	NP-VNMA160408T										□									9.525	4.76	0.8	2.0	3.81		
	NP-VNMA160408T												▲	▲				●		9.525	4.76	0.8	1.5	3.81		
	VNGA160404																□	□		9.525	4.76	0.4	2.8	3.81	EPSR 35° RE LE IC D1 S	C018 –020 E015 E042
	VNGA160408																□	□		9.525	4.76	0.8	1.9	3.81		

* The order number is for a 10-insert pack. Please specify order number, grade and quantity.

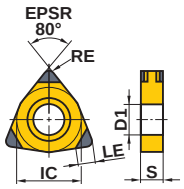
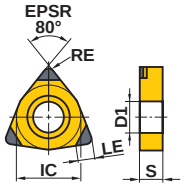
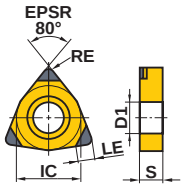
● = NEW

80° WN TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-WNGA080408FS6	●	●																	12.7	4.76	0.8	2.1	5.16		C021 E015 E039
	NP-WNGA080408GS6	●	●																	12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408GA6						▲													12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408TS6		●																	12.7	4.76	0.8	2.1	5.16		
NEW PETIT CUT	NP-WNGA080408FS3	●	●	●											●	●				12.7	4.76	0.8	2.1	5.16		C021 E015 E039
	NP-WNGA080408GS3	●	●												●					12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408GA3			●	●		▲													12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408GH3		●	●	●															12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408TS3		●												●	●				12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408TA3			●	●															12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408TH3			●	●															12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408SF3														●	●				12.7	4.76	0.8	2.1	5.16		
	NP-WNGA080408SE3														●	●				12.7	4.76	0.8	2.1	5.16		
NEW PETIT CUT (With Wiper) *	NP-WNGA080408GAWS3						▲				▲									12.7	4.76	0.8	2.1	5.16		C021 E015 E039
	NP-WNGA080408GSWS3		●			▲														12.7	4.76	0.8	2.1	5.16		

* Please refer to B018 before using the wiper insert.

● = NEW

● : **Inventory maintained in Japan.**

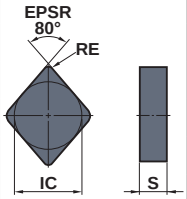
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

80° CN TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

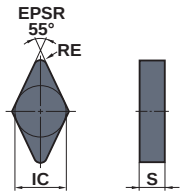
Shape	Order Number	IC	S	RE	Geometry	Applicable Holder Page
	CNGN120404	12.7	4.76	0.4		—
	CNGN120408	12.7	4.76	0.8		
	CNGN120412	12.7	4.76	1.2		

● = NEW

55° DN TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			
			Coated CBN						CBN											Solid CBN
									NEW							NEW				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

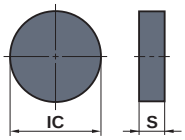
Shape	Order Number	IC	S	RE	Geometry	Applicable Holder Page
	DNGN110308	9.525	3.18	0.8		—
	DNGN110312	9.525	3.18	1.2		

● = NEW

RN TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	MBS140
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Coated CBN						CBN											Solid CBN	Dimensions (mm) IC	S	RE	Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140					
	RNGN090300																		●	9.525	3.18	—		—
	RNGN120300																		●	12.7	3.18	—		
	RNGN120400																		●	12.7	4.76	—		

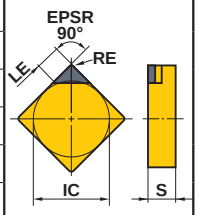
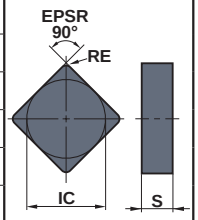
● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

90° SN TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
			Coated CBN						CBN											Solid CBN
									NEW							NEW				
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	Geometry	Applicable Holder Page
	SNGN090304																□	□		9.525	3.18	0.4	4.0		—
	SNGN090308																□	□		9.525	3.18	0.8	4.1		
	SNGN120404																□	□		12.7	4.76	0.4	4.0		
	SNGN120408																●	□		12.7	4.76	0.8	4.1		
	SNGN120412																●	□		12.7	4.76	1.2	4.1		
	SNGN090308																		●	9.525	3.18	0.8	—		—
	SNGN090312																		●	9.525	3.18	1.2	—		
	SNGN090316																		●	9.525	3.18	1.6	—		
	SNGN090408																		●	9.525	4.76	0.8	—		
	SNGN090412																		●	9.525	4.76	1.2	—		
	SNGN120408																		●	12.7	4.76	0.8	—		
	SNGN120412																		●	12.7	4.76	1.2	—		
	SNGN120416																		●	12.7	4.76	1.6	—		

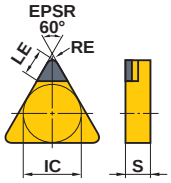
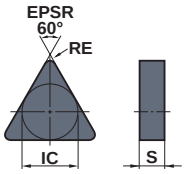
● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

60° TN TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140
			Coated CBN						CBN											Solid CBN
									NEW							NEW				
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠					
	K	Cast Iron														◐		●	◐	✠
	S	Heat-resistant Alloy, Titanium Alloy																	◐	
		Sintered Alloy														◐	◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	MBS140	IC	S	RE	LE	Geometry	Applicable Holder Page
	TNGN160404																●	□		9.525	4.76	0.4	3.7		—
	TNGN160408																●	□		9.525	4.76	0.8	3.4		
	TNGN160408																		●	9.525	4.76	0.8	—		—
	TNGN160412																		●	9.525	4.76	1.2	—		
	TNGN160416																		●	9.525	4.76	1.6	—		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

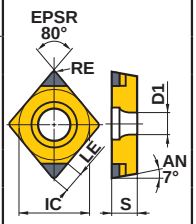
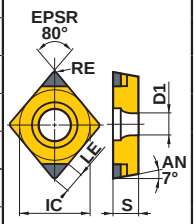
(1 insert in one case)

80° CC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CCGB060204GA2						▲				●								6.35	2.38	0.4	1.9	2.8		C022 D008 E006 E030 E034
NEW PETIT CUT	NP-CCGW060202FS2		●					●							●	●			6.35	2.38	0.2	1.8	2.8		C022 D008 E006 E030 E034
	NP-CCGW060204FS2		●					●							●	●			6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208FS2		●					●							●	●			6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302FS2	●	●					●							●	●			9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304FS2	●	●	●				●							●	●			9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308FS2	●	●	●				●							●	●			9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202GS2	●	●												●		●	●	6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204GS2	●	●			▲									●		●	●	6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208GS2	●	●												●		●	●	6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302GS2	●	●												●				9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304GS2	●	●			▲									●		●	●	9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GS2	●	●			▲									●		●	●	9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202GA2			●			▲		●		▲								6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204GA2			●	●		▲		●		▲								6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208GA2			●	●		▲		●		▲								6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302GA2			●			▲		●		▲								9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304GA2			●	●		▲		●		▲								9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GA2			●	●		▲		●		▲								9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T304GH2		●	●	●														9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GH2		●	●	●														9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202TS2															●			6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204TS2															●			6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208TS2														●	●			6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302TS2															●			9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304TS2															●			9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308TS2														●	●			9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202TA2													▲					6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204TA2				●					●				▲					6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208TA2				●					●									6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T304TA2			●	●				●	●				▲					9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308TA2			●	●				●	●				▲					9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T304TH2			●	●					●									9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308TH2			●	●					●									9.525	3.97	0.8	2.1	4.4		

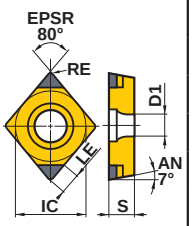
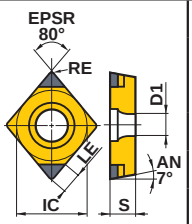
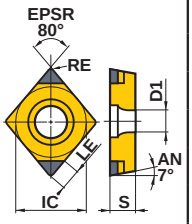
● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

80° CC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠			●	◐
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN										Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CCGW060202FA2																●	●	6.35	2.38	0.2	1.8	2.8		C022 D008 E006 E030 E034
	NP-CCGW060204FA2																●	●	6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208FA2																●	●	6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T304FA2																●	●	9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308FA2																●	●	9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T302GN2						▲												9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304GN2						▲												9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GN2						▲												9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T304G2										▲								9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308G2										▲								9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202SF2														●	●			6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204SF2														●	●			6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208SF2														●	●			6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302SF2														●	●			9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304SF2														●	●			9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308SF2														●	●			9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202SE2														●	●			6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204SE2														●	●			6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208SE2														●	●			6.35	2.38	0.8	2.1	2.8		
	NP-CCGW09T302SE2														●	●			9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304SE2														●	●			9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308SE2														●	●			9.525	3.97	0.8	2.1	4.4		
NEW PETIT CUT *2	TNP-CCGW09T304G2										▲								9.525	3.97	0.4	1.9	4.4		C022 D008 E030 E034
	TNP-CCGW09T308G2										▲								9.525	3.97	0.8	2.1	4.4		
NEW PETIT CUT (With Wiper) *1	NP-CCGW09T304FSWS2	●	●	●				●											9.525	3.97	0.4	1.9	4.4		C022 D008 E030 E034
	NP-CCGW09T308FSWS2	●	●	●				●											9.525	3.97	0.8	2.1	4.4		
	NEW NP-CCGW09T304FBWL2	●	●	●				●											9.525	3.97	0.4	1.9	4.4		
	NEW NP-CCGW09T308FBWL2	●	●	●				●											9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T304GAWS2			●	●				●										9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GAWS2			●	●		▲		●		▲								9.525	3.97	0.8	2.1	4.4		
	NP-CCGW09T304GSWS2	●	●																9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308GSWS2	●	●			▲													9.525	3.97	0.8	2.1	4.4		
	NEW NP-CCGW09T304GBWL2	●	●	●					●										9.525	3.97	0.4	1.9	4.4		
	NEW NP-CCGW09T308GBWL2	●	●	●					●										9.525	3.97	0.8	2.1	4.4		

*1 Please refer to B018 before using the wiper insert.
*2 The order number is for a 10-insert pack. Please specify order number, grade and quantity.

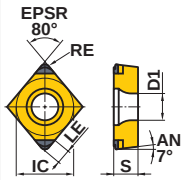
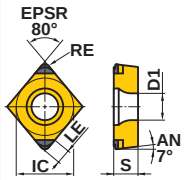
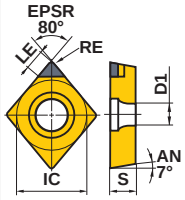
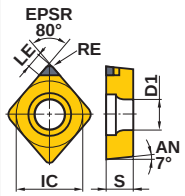
● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.
(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	●
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT (With Breaker)	BF-CCGT09T304TS2		●																9.525	3.97	0.4	1.9	4.4		C022 D008 E030 E034
	BF-CCGT09T308TS2		●																9.525	3.97	0.8	2.1	4.4		
	BF-CCGT09T304TA2						▲												9.525	3.97	0.4	1.8	4.4		
	BF-CCGT09T308TA2						▲												9.525	3.97	0.8	2.0	4.4		
NEW PETIT CUT (With Breaker)	BM-CCGT09T304TA2			●															9.525	3.97	0.4	1.9	4.4		C022 D008 E030 E034
	BM-CCGT09T308TA2			●															9.525	3.97	0.8	2.1	4.4		
NEW PETIT CUT	NP-CCMB060204G												▲						6.35	2.38	0.4	1.9	2.8		C022 D008 E006 E030 E034
NEW PETIT CUT	⁎ NP-CCGW03S102FS		●					●											3.57	1.39	0.2	1.1	2.0		C022 D008 E006 E016 E030 E034
	⁎ NP-CCGW03S104FS		●					●			▲								3.57	1.39	0.4	1.1	2.0		
	⁎ NP-CCGW04T002FS		●					●											4.37	1.79	0.2	1.5	2.4		
	⁎ NP-CCGW04T004FS		●					●			▲								4.37	1.79	0.4	1.5	2.4		
	⁎ NP-CCGW03S102GS	●																	3.57	1.39	0.2	1.1	2.0		
	⁎ NP-CCGW03S104GS	●																	3.57	1.39	0.4	1.1	2.0		
	⁎ NP-CCGW04T002GS	●																	4.37	1.79	0.2	1.5	2.4		
	⁎ NP-CCGW04T004GS	●																	4.37	1.79	0.4	1.5	2.4		
	NP-CCGW09T302GS																●	●	9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304GS																●	●	9.525	3.97	0.4	1.9	4.4		
	⁎ NP-CCGW03S102FA										▲								3.57	1.39	0.2	1.1	2.0		
	⁎ NP-CCGW04T002FA										▲								4.37	1.79	0.2	1.5	2.4		
	NP-CCGW060202F											▲							6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204F											▲							6.35	2.38	0.4	1.9	2.8		
	NP-CCGW09T302F											▲							9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304F										□	▲							9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308F										□								9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202G										▲		▲						6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204G										▲		▲						6.35	2.38	0.4	1.9	2.8		
	NP-CCGW060208G										▲								6.35	2.38	0.8	2.1	2.8		

⁎ Diameter of inscribed circle is special. (For SCLC type)

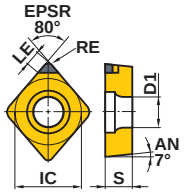
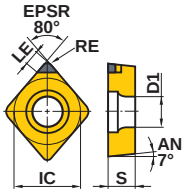
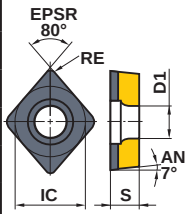
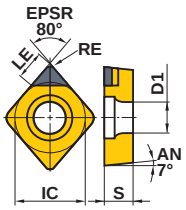
● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

80° CC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
			Coated CBN						CBN										
									NEW							NEW			
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-CCGW09T302G										▲		▲						9.525	3.97	0.2	1.8	4.4		C022 D008 E006 E030 E034
	NP-CCGW09T304G										▲		▲						9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308G										▲								9.525	3.97	0.8	2.1	4.4		
	NP-CCGW060202T													▲					6.35	2.38	0.2	1.8	2.8		
	NP-CCGW060204T													▲					6.35	2.38	0.4	1.9	2.8		
	NP-CCGW09T302T													▲					9.525	3.97	0.2	1.8	4.4		
	NP-CCGW09T304T										□			▲					9.525	3.97	0.4	1.9	4.4		
	NP-CCGW09T308T										□								9.525	3.97	0.8	2.1	4.4		
NEW PETIT CUT	* NP-CCMW03S102F											▲							3.57	1.39	0.2	1.1	2.0		E016
	* NP-CCMW03S104F											▲							3.57	1.39	0.4	1.1	2.0		
	* NP-CCMW04T002F											▲							4.37	1.79	0.2	1.5	2.4		
	* NP-CCMW04T004F											▲							4.37	1.79	0.4	1.5	2.4		
	CCGW060202FS															●			6.35	2.38	0.2	—	2.8		C022 D008 E006 E030 E034
	CCGW060204FS															●			6.35	2.38	0.4	—	2.8		
	CCGW060208FS															●			6.35	2.38	0.8	—	2.8		
	CCGW09T304FS															●			9.525	3.97	0.4	—	4.4		
	CCGW09T308FS															●			9.525	3.97	0.8	—	4.4		
	CCMW060202																□	□	6.35	2.38	0.2	2.8	2.8		C022 D008 E006 E030 E034
	CCMW060204																□	□	6.35	2.38	0.4	2.8	2.8		
	CCMW09T302																□	□	9.525	3.97	0.2	3.7	4.4		
	CCMW09T304																□	□	9.525	3.97	0.4	3.7	4.4		
	CCMW09T308																□	□	9.525	3.97	0.8	3.6	4.4		
	CCMW120404																□	□	12.7	4.76	0.4	3.7	5.5		
	CCMW120408																□	□	12.7	4.76	0.8	3.6	5.5		
	CCMW120412																□	□	12.7	4.76	1.2	3.6	5.5		

* Diameter of inscribed circle is special. (For SCLC type)

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

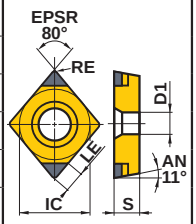
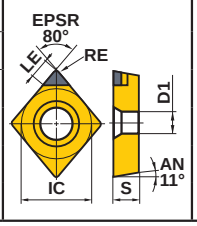
(1 insert in one case)

80° CP TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	●
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

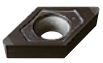
Shape	Order Number	Coated CBN						CBN												Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-CPGB080202FS2														●	●			7.94	2.38	0.2	1.8	3.5		E006
	NP-CPGB080204FS2		●												●	●			7.94	2.38	0.4	1.9	3.5		
	NP-CPGB080208FS2		●																7.94	2.38	0.8	2.1	3.5		
	NP-CPGB090302FS2	●	●												●	●			9.525	3.18	0.2	1.8	4.5		
	NP-CPGB090304FS2	●		●											●	●			9.525	3.18	0.4	1.9	4.5		
	NP-CPGB090308FS2	●		●											●	●			9.525	3.18	0.8	2.1	4.5		
	NP-CPGB090312FS2			●															9.525	3.18	1.2	2.3	4.5		
	NP-CPGB080204GS2	●	●																7.94	2.38	0.4	1.9	3.5		
	NP-CPGB080208GS2	●	●																7.94	2.38	0.8	2.1	3.5		
	NP-CPGB090302GS2	●	●																9.525	3.18	0.2	1.8	4.5		
	NP-CPGB090304GS2	●	●																9.525	3.18	0.4	1.9	4.5		
	NP-CPGB090308GS2	●	●																9.525	3.18	0.8	2.1	4.5		
	NP-CPGB080204GA2			●	●		▲												7.94	2.38	0.4	1.9	3.5		
	NP-CPGB080208GA2			●	●		▲												7.94	2.38	0.8	2.1	3.5		
	NP-CPGB080212GA2			●	●														7.94	2.38	1.2	2.3	3.5		
	NP-CPGB090302GA2			●															9.525	3.18	0.2	1.8	4.5		
	NP-CPGB090304GA2			●	●		▲				▲								9.525	3.18	0.4	1.9	4.5		
	NP-CPGB090308GA2			●	●		▲												9.525	3.18	0.8	2.1	4.5		
	NP-CPGB090312GA2			●	●														9.525	3.18	1.2	2.3	4.5		
	NP-CPGB080204TA2				●														7.94	2.38	0.4	1.9	3.5		
	NP-CPGB080208TA2				●														7.94	2.38	0.8	2.1	3.5		
	NP-CPGB080212TA2				●														7.94	2.38	1.2	2.3	3.5		
	NP-CPGB090304TA2			●	●														9.525	3.18	0.4	1.9	4.5		
	NP-CPGB090308TA2			●	●														9.525	3.18	0.8	2.1	4.5		
	NP-CPGB090312TA2			●	●														9.525	3.18	1.2	2.3	4.5		
	NP-CPGB080202SE2														●	●			7.94	2.38	0.2	1.8	3.5		
	NP-CPGB080204SE2														●	●			7.94	2.38	0.4	1.9	3.5		
	NP-CPGB090302SE2														●	●			9.525	3.18	0.2	1.8	4.5		
	NP-CPGB090304SE2														●	●			9.525	3.18	0.4	1.9	4.5		
	NP-CPGB090308SE2														●	●			9.525	3.18	0.8	2.1	4.5		
NEW PETIT CUT	NP-CPMB080204G												▲						7.94	2.38	0.4	1.9	3.5		E006
	NP-CPMB090304G												▲						9.525	3.18	0.4	1.9	4.5		

● = NEW

55° DC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

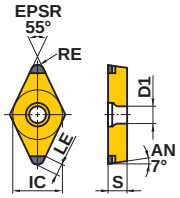
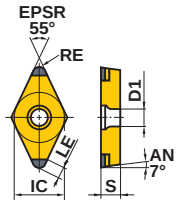
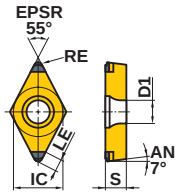
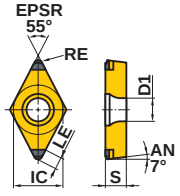
Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-DCGW070202GA2			●			▲		●		▲								6.35	2.38	0.2	2.3	2.8		
	NP-DCGW070204GA2			●	●		▲		●		▲								6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208GA2				●		▲				▲								6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302GA2			●			▲		●		▲								9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T304GA2			●	●		▲		●		▲								9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308GA2			●	●		▲		●		▲								9.525	3.97	0.8	2.0	4.4		
	NP-DCGW070202GS2	●	●																6.35	2.38	0.2	2.3	2.8		
	NP-DCGW070204GS2	●	●			▲									●				6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208GS2	●	●												●				6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302GS2	●	●			▲									●				9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T304GS2	●	●			▲					▲				●				9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T304GS2																●	●	9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308GS2	●	●			▲					▲				●				9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T308GS2																●	●	9.525	3.97	0.8	1.7	4.4		
	NP-DCGW070202GN2						▲												6.35	2.38	0.2	2.3	2.8		
	NP-DCGW070204GN2						▲												6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208GN2						▲												6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302GN2						▲												9.525	3.97	0.2	2.3	4.4	EPSR 55° RE LE IC D1 AN 7° S	C023 D009 D026 E008 E009 E029 E031
	NP-DCGW11T304GN2						▲												9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308GN2						▲												9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T304GH2		●	●	●														9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308GH2		●	●	●														9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T304G2										▲								9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308G2										▲								9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T304FA2																●	●	9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308FA2																●	●	9.525	3.97	0.8	1.7	4.4		
	NP-DCGW070202FS2		●					●											6.35	2.38	0.2	2.3	2.8		
	NP-DCGW070204FS2		●	●				●							●	●			6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208FS2		●					●							●	●			6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302FS2	●	●					●							●	●			9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T304FS2	●	●	●				●							●	●			9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308FS2	●	●	●				●							●	●			9.525	3.97	0.8	2.0	4.4		
	NP-DCGW070204TA2			●	●				●	●									6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070204TA2													▲					6.35	2.38	0.4	1.5	2.8		
	NP-DCGW070208TA2				●					●									6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302TA2													▲					9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T304TA2			●	●				●	●									9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T304TA2													▲					9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308TA2			●	●				●	●									9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T308TA2													▲					9.525	3.97	0.8	1.7	4.4		

● = NEW

● : **Inventory maintained in Japan.**
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.
(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-DCGW070204TS2															●			6.35	2.38	0.4	2.1	2.8		C023 D009 D026 E008 E009 E029 E031
	NP-DCGW070208TS2															●			6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302TS2															●			9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T304TS2															●			9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308TS2															●			9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T304TH2			●	●					●									9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308TH2			●	●					●									9.525	3.97	0.8	2.0	4.4		
	NP-DCGW070204SF2														●	●			6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208SF2														●	●			6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302SF2														●	●			9.525	3.97	0.2	1.5	4.4		
	NP-DCGW11T304SF2														●	●			9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308SF2														●	●			9.525	3.97	0.8	2.0	4.4		
	NP-DCGW070204SE2														●	●			6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208SE2														●	●			6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302SE2														●	●			9.525	3.97	0.2	1.5	4.4		
	NP-DCGW11T304SE2														●	●			9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T308SE2														●	●			9.525	3.97	0.8	2.0	4.4		
NEW PETIT CUT *	TNP-DCGW11T304G2										▲								9.525	3.97	0.4	2.1	4.4		C023 D009 D026 E008 E009 E029 E031
	TNP-DCGW11T308G2										▲								9.525	3.97	0.8	2.1	4.4		
NEW PETIT CUT (With Breaker)	BF-DCGT11T304TA2						▲												9.525	3.97	0.4	2.1	4.4		C023 D009 D026 E008 E009 E029 E031
	BF-DCGT11T308TA2						▲												9.525	3.97	0.8	2.0	4.4		
	BF-DCGT11T304TS2		●																9.525	3.97	0.4	2.1	4.4		
	BF-DCGT11T308TS2		●																9.525	3.97	0.8	2.0	4.4		
NEW PETIT CUT (With Breaker)	BM-DCGT11T304TA2			●															9.525	3.97	0.4	2.1	4.4		C023 D009 D026 E008 E009 E029 E031
	BM-DCGT11T308TA2			●															9.525	3.97	0.8	2.0	4.4		

* The order number is for a 10-insert pack. Please specify order number, grade and quantity.

● = NEW

55° DC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	● ◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-DCGW11T302GS																●	●	9.525	3.97	0.2	1.5	4.4	EPSR 55° LE RE D1 AN 7° IC S	C023 D009 D026 E008 E009 E029 E031
	NP-DCGW11T304GS																●	●	9.525	3.97	0.4	1.5	4.4		
	NP-DCGW070202G										▲								6.35	2.38	0.2	2.3	2.8		
	NP-DCGW070204G										▲								6.35	2.38	0.4	2.1	2.8		
	NP-DCGW070208G										▲								6.35	2.38	0.8	2.0	2.8		
	NP-DCGW11T302G										▲								9.525	3.97	0.2	2.3	4.4		
	NP-DCGW11T302G												▲						9.525	3.97	0.2	1.5	4.4		
	NP-DCGW11T304G										▲								9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T304G												▲						9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308G										▲								9.525	3.97	0.8	2.0	4.4		
	NP-DCGW070202F											▲							6.35	2.38	0.2	1.5	2.8		
	NP-DCGW070204F											▲							6.35	2.38	0.4	1.5	2.8		
	NP-DCGW11T302F											▲							9.525	3.97	0.2	1.5	4.4		
	NP-DCGW11T304F										□								9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T304F											▲							9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308F										□								9.525	3.97	0.8	2.0	4.4		
NEW PETIT CUT	NP-DCGW070202T													▲					6.35	2.38	0.2	1.5	2.8	EPSR 55° LE RE D1 AN 7° IC S	C023 D009 D026 E008 E009 E029 E031
	NP-DCGW070204T													▲					6.35	2.38	0.4	1.5	2.8		
	NP-DCGW11T302T													▲					9.525	3.97	0.2	1.5	4.4		
	NP-DCGW11T304T										□								9.525	3.97	0.4	2.1	4.4		
	NP-DCGW11T304T													▲					9.525	3.97	0.4	1.5	4.4		
	NP-DCGW11T308T										□								9.525	3.97	0.8	2.0	4.4		
	NP-DCGW11T308T													▲					9.525	3.97	0.8	1.7	4.4		
NEW PETIT CUT	NP-DCMW070204G												▲						6.35	2.38	0.4	1.5	2.8	EPSR 55° LE RE D1 AN 7° IC S	C023 D009 D026 E008 E009 E029 E031
	NP-DCMW11T304G												▲						9.525	3.97	0.4	1.5	4.4		
	DCGW070204FS															●			6.35	2.38	0.4	—	2.8	EPSR 55° RE D1 AN 7° IC S	C023 D009 D026 E008 E009 E029 E031
	DCGW070208FS															●			6.35	2.38	0.8	—	2.8		
	DCMW070202																□	□	6.35	2.38	0.2	3.7	2.8	EPSR 55° LE RE D1 AN 7° IC S	C023 D009 D026 E008 E009 E029 E031
	DCMW070204																□	□	6.35	2.38	0.4	3.5	2.8		
	DCMW11T302																□	□	9.525	3.97	0.2	3.7	4.4		
	DCMW11T304																□	□	9.525	3.97	0.4	3.5	4.4		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

60° TC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm) IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-TCGW090202GA3						▲											5.56	2.38	0.2	1.5	2.5	EPSR 60° RE IC LE S D1 AN 7°	C027 E028
	NP-TCGW090204GA3						▲											5.56	2.38	0.4	1.6	2.5		
	NP-TCGW090208GA3						▲											5.56	2.38	0.8	1.8	2.5		
	NP-TCGW110202GA3						▲											6.35	2.38	0.2	1.5	2.8		
	NP-TCGW110204GA3						▲											6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208GA3						▲											6.35	2.38	0.8	1.8	2.8		
	NP-TCGW130304GA3						▲											7.94	3.18	0.4	1.6	3.4		
	NP-TCGW130308GA3						▲											7.94	3.18	0.8	1.8	3.4		
	NP-TCGW16T304GA3						▲											9.525	3.97	0.4	1.6	4.4		
	NP-TCGW16T308GA3						▲											9.525	3.97	0.8	1.8	4.4		
	NP-TCGW090204GS3		●															5.56	2.38	0.4	1.6	2.5		
	NP-TCGW090208GS3		●															5.56	2.38	0.8	1.8	2.5		
	NP-TCGW110202GS3		●															6.35	2.38	0.2	1.5	2.8		
	NP-TCGW110204GS3		●													●		6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208GS3		●													●		6.35	2.38	0.8	1.8	2.8		
	NP-TCGW130304GS3		●															7.94	3.18	0.4	1.6	3.4		
	NP-TCGW130308GS3		●															7.94	3.18	0.8	1.8	3.4		
	NP-TCGW16T304GS3		●															9.525	3.97	0.4	1.6	4.4		
	NP-TCGW16T308GS3		●															9.525	3.97	0.8	1.8	4.4		
	NP-TCGW110204FA3																●	6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208FA3																●	6.35	2.38	0.8	1.8	2.8		
	NP-TCGW110204FS3															●	●	6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208FS3															●	●	6.35	2.38	0.8	1.8	2.8		
	NP-TCGW110204TS3																●	6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208TS3																●	6.35	2.38	0.8	1.8	2.8		
	NP-TCGW110204SF3															●	●	6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208SF3															●	●	6.35	2.38	0.8	1.8	2.8		
	NP-TCGW110204SE3															●	●	6.35	2.38	0.4	1.6	2.8		
	NP-TCGW110208SE3															●	●	6.35	2.38	0.8	1.8	2.8		
	TCGW090204FS																●	5.56	2.38	0.4	—	2.5	EPSR 60° RE IC S D1 AN 7°	C027 E028
	TCGW090208FS																●	5.56	2.38	0.8	—	2.5		
	TCGW110204FS																●	6.35	2.38	0.4	—	2.8		
	TCGW110208FS																●	6.35	2.38	0.8	—	2.8		
	TCMW110202																□	6.35	2.38	0.2	2.8	2.8	EPSR 60° LE RE IC S D1 AN 7°	C027 E028
	TCMW110204																□	6.35	2.38	0.4	2.6	2.8		

● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

60° TP TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

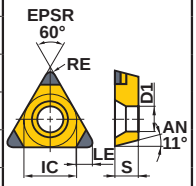
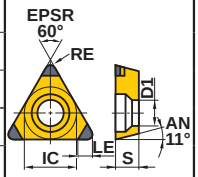
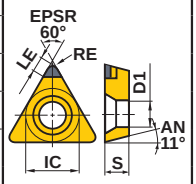
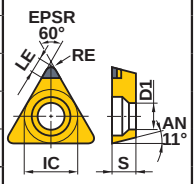
Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
NEW PETIT CUT	NP-TPGB080204GA3				●		▲				▲								4.76	2.38	0.4	1.6	2.4		
	NP-TPGB080208GA3				●		▲												4.76	2.38	0.8	1.8	2.4		
	NP-TPGB090204GA3			●	●		▲		●		▲								5.56	2.38	0.4	1.6	2.9		
	NP-TPGB090208GA3			●	●		▲		●										5.56	2.38	0.8	1.8	2.9		
	NP-TPGB110302GA3			●					●										6.35	3.18	0.2	1.5	3.4		
	NP-TPGB110304GA3			●	●		▲		●										6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308GA3			●	●		▲		●										6.35	3.18	0.8	1.8	3.4		
	NP-TPGB160304GA3			●	●		▲		●		▲								9.525	3.18	0.4	1.6	4.4		
	NP-TPGB160308GA3			●	●		▲		●										9.525	3.18	0.8	1.8	4.4		
	NP-TPGB080204GS3	●	●																4.76	2.38	0.4	1.6	2.4		
	NP-TPGB080208GS3	●	●																4.76	2.38	0.8	1.8	2.4		
	NEW NP-TPGB090202GS3														●				5.56	2.38	0.2	1.5	2.9		
	NP-TPGB090204GS3	●	●												●				5.56	2.38	0.4	1.6	2.9		
	NP-TPGB090208GS3	●	●																5.56	2.38	0.8	1.8	2.9		
	NP-TPGB110302GS3	●	●												●				6.35	3.18	0.2	1.5	3.4		
	NP-TPGB110304GS3	●	●												●				6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308GS3	●	●												●				6.35	3.18	0.8	1.8	3.4		
	NP-TPGB160304GS3	●	●																9.525	3.18	0.4	1.6	4.4		
	NP-TPGB160308GS3	●	●																9.525	3.18	0.8	1.8	4.4		
	NP-TPGB160304GH3		●	●	●														9.525	3.18	0.4	1.6	4.4	EPSR 60° RE IC LE S D1 AN 11°	
	NP-TPGB160308GH3		●	●	●														9.525	3.18	0.8	1.8	4.4		
	NP-TPGB090202FS3														●	●			5.56	2.38	0.2	1.5	2.9		E007
	NP-TPGB090204FS3														●	●			5.56	2.38	0.4	1.6	2.9		
	NP-TPGB110302FS3	●	●						●						●	●			6.35	3.18	0.2	1.5	3.4		
	NP-TPGB110304FS3	●	●	●					●						●	●			6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308FS3	●	●	●					●						●	●			6.35	3.18	0.8	1.8	3.4		
	NP-TPGB160304FS3			●															9.525	3.18	0.4	1.6	4.4		
	NP-TPGB160308FS3			●															9.525	3.18	0.8	1.8	4.4		
	NP-TPGB080204TA3				●					●									4.76	2.38	0.4	1.6	2.4		
	NP-TPGB080208TA3				●					●									4.76	2.38	0.8	1.8	2.4		
	NP-TPGB090204TA3				●					●									5.56	2.38	0.4	1.6	2.9		
	NP-TPGB090208TA3				●					●									5.56	2.38	0.8	1.8	2.9		
	NP-TPGB110304TA3			●	●				●	●									6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308TA3			●	●				●	●									6.35	3.18	0.8	1.8	3.4		
	NP-TPGB160304TA3			●	●				●	●									9.525	3.18	0.4	1.6	4.4		
	NP-TPGB160308TA3			●	●				●	●									9.525	3.18	0.8	1.8	4.4		
	NP-TPGB160304TH3			●	●					●									9.525	3.18	0.4	1.6	4.4		
	NP-TPGB160308TH3			●	●					●									9.525	3.18	0.8	1.8	4.4		
	NP-TPGB090202SF3														●	●			5.56	2.38	0.2	1.5	2.9		
	NP-TPGB090204SF3														●	●			5.56	2.38	0.4	1.6	2.9		
	NP-TPGB110302SF3														●	●			6.35	3.18	0.2	1.5	3.4		
	NP-TPGB110304SF3														●	●			6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308SF3														●	●			6.35	3.18	0.8	1.8	3.4		

● : Inventory maintained in Japan. □ : Non stock, produced to order only. ● = NEW

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.
(1 insert in one case)

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
								NEW							NEW				IC	S	RE	LE	D1		
NEW PETIT CUT	NP-TPGB090202SE3														●	●		5.56	2.38	0.2	1.5	2.9		E007
	NP-TPGB090204SE3														●	●		5.56	2.38	0.4	1.6	2.9		
	NP-TPGB110302SE3														●	●		6.35	3.18	0.2	1.5	3.4		
	NP-TPGB110304SE3														●	●		6.35	3.18	0.4	1.6	3.4		
	NP-TPGB110308SE3														●	●		6.35	3.18	0.8	1.8	3.4		
NEW PETIT CUT	NP-TPGX080202GA3						□											4.76	2.38	0.2	1.5	2.5		E025
	NP-TPGX080204GA3						□											4.76	2.38	0.4	1.6	2.5		
	NP-TPGX080208GA3						□											4.76	2.38	0.8	1.8	2.5		
	NP-TPGX090204GA3						□											5.56	2.38	0.4	1.6	3.0		
	NP-TPGX090208GA3						□											5.56	2.38	0.8	1.8	3.0		
	NP-TPGX110304GA3						□											6.35	3.18	0.4	1.6	3.5		
	NP-TPGX110308GA3						□											6.35	3.18	0.8	1.8	3.5		
	NP-TPGX080202GS3					▲												4.76	2.38	0.2	1.5	2.5		
	NP-TPGX080204GS3					▲												4.76	2.38	0.4	1.6	2.5		
	NP-TPGX090202GS3					▲												5.56	2.38	0.2	1.5	3.0		
	NP-TPGX090204GS3					▲												5.56	2.38	0.4	1.6	3.0		
	NP-TPGX110304GS3					▲												6.35	3.18	0.4	1.6	3.5		
	NP-TPGX110308GS3					▲												6.35	3.18	0.8	1.8	3.5		
NEW PETIT CUT	NP-TPMB080204G											▲						4.76	2.38	0.4	1.6	2.4		E007
	NP-TPMB090204G											▲						5.56	2.38	0.4	1.6	2.9		
	NP-TPMB110304G											▲						6.35	3.18	0.4	1.6	3.4		
	NP-TPMB160304G											▲						9.525	3.18	0.4	1.6	4.4		
NEW PETIT CUT	NP-TPGX090204G										▲							5.56	2.38	0.4	1.6	3.0		E025
	NP-TPGX090208G										▲							5.56	2.38	0.8	1.8	3.0		
	NP-TPGX110304G										▲							6.35	3.18	0.4	1.6	3.5		
	NP-TPGX110308G										▲							6.35	3.18	0.8	1.8	3.5		
	NP-TPGX080202F											▲						4.76	2.38	0.2	1.5	2.5		
	NP-TPGX080204F											▲						4.76	2.38	0.4	1.6	2.5		
	NP-TPGX090202F											▲						5.56	2.38	0.2	1.5	3.0		
	NP-TPGX090204F											▲						5.56	2.38	0.4	1.6	3.0		
	NP-TPGX110304F											▲					●	6.35	3.18	0.4	1.6	3.5		
	NP-TPGX110308F											▲					●	6.35	3.18	0.8	1.8	3.5		
	NP-TPGX080202T													▲				4.76	2.38	0.2	1.5	2.5		
	NP-TPGX080204T													▲				4.76	2.38	0.4	1.6	2.5		
	NP-TPGX090202T													▲				5.56	2.38	0.2	1.5	3.0		
	NP-TPGX090204T													▲				5.56	2.38	0.4	1.6	3.0		
	NP-TPGX110304T												▲	▲			●	6.35	3.18	0.4	1.6	3.5		
	NP-TPGX110308T												▲	▲			●	6.35	3.18	0.8	1.8	3.5		

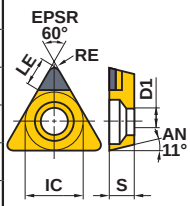
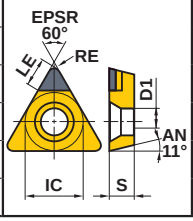
● = NEW

60° TP TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730	IC	S	RE	LE	D1		
	TPGX080202																●	●	4.76	2.38	0.2	1.9	2.5		E025
	TPGX080204											▲					●	●	4.76	2.38	0.4	1.7	2.5		
	TPGX080208																□	□	4.76	2.38	0.8	1.4	2.5		
	TPGX090202																●	●	5.56	2.38	0.2	2.8	3.0		
	TPGX090204											▲					●	●	5.56	2.38	0.4	2.6	3.0		
	TPGX090208																□	□	5.56	2.38	0.8	2.3	3.0		
	TPGX110302																□	□	6.35	3.18	0.2	2.8	3.5	TPGX16○○○○ 	
	TPGX110304											▲					●	●	6.35	3.18	0.4	2.6	3.5		
	TPGX110308											▲					●	●	6.35	3.18	0.8	2.3	3.5		
	TPGX160304																●	□	9.525	3.18	0.4	3.7	4.8		
	TPGX160308																●	□	9.525	3.18	0.8	3.4	4.8		
	TPGX160404																□	□	9.525	4.76	0.4	3.7	4.8		
	TPGX160408																□	□	9.525	4.76	0.8	3.4	4.8		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

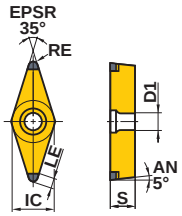
(1 insert in one case)

35° VB TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120 (NEW)	MB8130	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-VBGW110302GA2			●					●										6.35	3.18	0.2	2.5	2.85		
	NP-VBGW110304GA2			●	●				●										6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308GA2			●	●				●										6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160402GA2			●					●										9.525	4.76	0.2	2.5	4.43		
	NP-VBGW160404GA2			●	●		▲		●		▲								9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408GA2			●	●		▲		●		▲								9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110302GS2	●	●																6.35	3.18	0.2	2.5	2.85		
	NP-VBGW110304GS2	●	●												●				6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110304GS2																	●	6.35	3.18	0.4	1.4	2.85		
	NP-VBGW110308GS2	●	●												●				6.35	3.18	0.8	2.0	2.85		
	NP-VBGW110308GS2																	●	6.35	3.18	0.8	1.5	2.85		
	NP-VBGW160402GS2	●	●																9.525	4.76	0.2	2.5	4.43		
	NP-VBGW160404GS2	●	●												●				9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160404GS2																●	●	9.525	4.76	0.4	1.4	4.43		
	NP-VBGW160408GS2	●	●												●				9.525	4.76	0.8	2.0	4.43		
	NP-VBGW160408GS2																●	●	9.525	4.76	0.8	1.5	4.43		
	NP-VBGW160404GH2		●	●	●														9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408GH2		●	●	●														9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110302FS2		●					●											6.35	3.18	0.2	2.5	2.85		D010 D011 E011 E012 H013
	NP-VBGW110304FS2		●					●							●	●			6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308FS2		●					●							●	●			6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160402FS2		●					●											9.525	4.76	0.2	2.5	4.43		
	NP-VBGW160404FS2			●											●	●			9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408FS2			●											●	●			9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110304TA2				●														6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308TA2				●														6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160404TA2			●	●				●										9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408TA2			●	●				●										9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110304TS2															●			6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308TS2															●			6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160404TS2															●			9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408TS2															●			9.525	4.76	0.8	2.0	4.43		
	NP-VBGW160404TH2			●	●														9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408TH2			●	●														9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110304SF2														●	●			6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308SF2														●	●			6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160404SF2														●	●			9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408SF2														●	●			9.525	4.76	0.8	2.0	4.43		
	NP-VBGW110304SE2														●	●			6.35	3.18	0.4	2.5	2.85		
	NP-VBGW110308SE2														●	●			6.35	3.18	0.8	2.0	2.85		
	NP-VBGW160404SE2														●	●			9.525	4.76	0.4	2.5	4.43		
	NP-VBGW160408SE2														●	●			9.525	4.76	0.8	2.0	4.43		

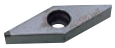
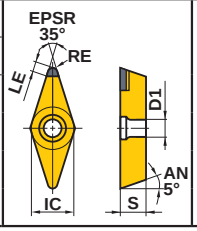
● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

35° VB TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	● ◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

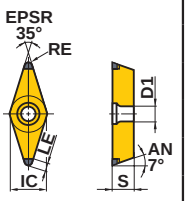
Shape	Order Number	Dimensions (mm) IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT 	NP-VBGW160404G	9.525	4.76	0.4	2.5	4.43		E011 H013
	NP-VBGW160408G	9.525	4.76	0.8	2.0	4.43		

Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
NP-VBGW160404G										▲							
NP-VBGW160408G										▲							

35° VC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110 (NEW)	MB8120 (NEW)	MB8130 (NEW)	MB8025	MB810	MB825	MB835	MB4120 (NEW)	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	● ◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing (Last letter of order number) : Refer to page B016.

Shape	Order Number	Dimensions (mm) IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-VCGW160404GA2	9.525	4.76	0.4	2.5	4.4		C028 C029 E032 E033
	NP-VCGW160408GA2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404GS2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408GS2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404GH2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408GH2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404FS2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408FS2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404TA2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408TA2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404TS2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408TS2	9.525	4.76	0.8	2.0	4.4		
	NP-VCGW160404TH2	9.525	4.76	0.4	2.5	4.4		
	NP-VCGW160408TH2	9.525	4.76	0.8	2.0	4.4		

Order Number	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
NP-VCGW160404GA2			●	●		▲				▲							
NP-VCGW160408GA2			●	●		▲				▲							
NP-VCGW160404GS2	●	●															
NP-VCGW160408GS2	●	●															
NP-VCGW160404GH2		●	●	●													
NP-VCGW160408GH2		●	●	●													
NP-VCGW160404FS2		●	●				●										
NP-VCGW160408FS2		●	●				●										
NP-VCGW160404TA2			●	●													
NP-VCGW160408TA2			●	●													
NP-VCGW160404TS2		●															
NP-VCGW160408TS2		●															
NP-VCGW160404TH2			●	●													
NP-VCGW160408TH2			●	●													

● = NEW

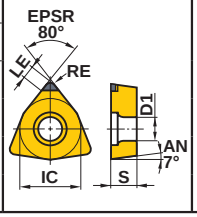
● : Inventory maintained in Japan.
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.
(1 insert in one case)

80° WC TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing (Last letter of order number) : Refer to page B016.

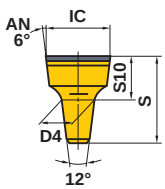
Shape	Order Number	Coated CBN						CBN												Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	IC	S	RE	LE	D1		
	NP-WCMWL30204FA																	●	4.76	2.38	0.4	1.9	2.3		E027
	NP-WCMWL30208FA																	●	4.76	2.38	0.8	2.1	2.3		

● = NEW

RTG TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

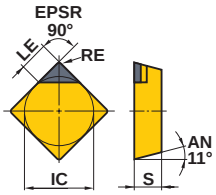
Shape	Order Number	Coated CBN						CBN												Dimensions (mm)				Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	IC	S	S10	D4		
	RTG05A												▲						5	7.5	3.5	2.5		C035
	RTG06A												▲						6	7.5	3.5	3.5		
	RTG07A												▲						7	11	5.0	3.5		
	RTG08A												▲						8	11	5.0	4.5		
	RTG10A												▲						10	14	6.5	5.5		

● = NEW

90° SP TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)				Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	IC	S	RE	LE		
	SPGN090302																□	□	9.525	3.18	0.2	4.1		—
	SPGN090304																●	□	9.525	3.18	0.4	4.0		
	SPGN090308																●	□	9.525	3.18	0.8	4.1		
	SPGN090312																□	□	9.525	3.18	1.2	4.1		
	SPGN120304																●	●	12.7	3.18	0.4	4.0		
	SPGN120308																●	●	12.7	3.18	0.8	4.1		
	SPGN120312																□	□	12.7	3.18	1.2	4.1		
	SPGN120408																□	□	12.7	4.76	0.8	4.1		
	SPGN120412																□	□	12.7	4.76	1.2	4.1		

● = NEW

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

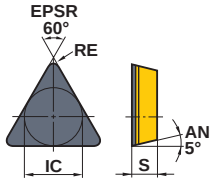
▲ : Inventory maintained in Japan. To be replaced by new products. However, the order for MB810, MB825, MB835 and MBC010 will be discontinued by the end of March 2020. The alternative grade for MB810, MB825 and MB835 is the MB8100 series, and the alternative grade for MBC010 is BC8105.

(1 insert in one case)

60° TB TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
			Coated CBN						CBN										
									NEW							NEW			
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	IC	S	RE	LE	Geometry	Applicable Holder Page
	TBGN060104	3.97	1.59	0.4	5.9		–
	TBGN060108	3.97	1.59	0.8	4.9		

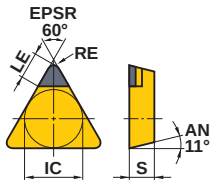
	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
TBGN060104											▲					●	□
TBGN060108											▲					●	□

● = NEW

60° TP TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
			Coated CBN						CBN										
									NEW							NEW			
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	IC	S	RE	LE	Geometry	Applicable Holder Page
	TPGN090204	5.56	2.38	0.4	2.6		E026
	TPGN110302	6.35	3.18	0.2	2.8		
	TPGN110304	6.35	3.18	0.4	2.6		
	TPGN110308	6.35	3.18	0.8	2.3		
	TPGN160304	9.525	3.18	0.4	3.7		
	TPGN160308	9.525	3.18	0.8	3.4		
	TPGN160312	9.525	3.18	1.2	3.1		
	TPGN160408	9.525	4.76	0.8	3.4		
	TPGN220408	12.7	4.76	0.8	3.4		

	BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
TPGN090204																□	□
TPGN110302																□	□
TPGN110304																●	●
TPGN110308																□	□
TPGN160304																●	●
TPGN160308																●	●
TPGN160312																□	□
TPGN160408																□	□
TPGN220408																□	□

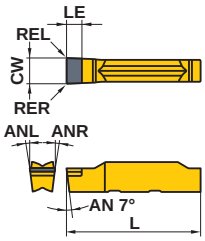
● = NEW

GRADES ➤ B006
IDENTIFICATION ➤ B002

GY TYPE INSERTS WITHOUT HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Coated CBN						CBN											Dimensions (mm)					Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	CW	RER REL	L	LE	ANR ANL		
	GY1G0200D020N-GFGS		●								●								2.00	0.2	20.70	2.7	3°		F016 –027 F030 –035 F038 –087
	GY1G0239E020N-GFGS		●								●								2.39	0.2	20.70	2.7	7°		
	GY1G0250E020N-GFGS		●								●								2.50	0.2	20.70	2.7	7°		
	GY1G0300F020N-GFGS		●								●								3.00	0.2	20.70	2.7	7°		
	GY1G0318F020N-GFGS		●								●								3.18	0.2	20.70	2.7	7°		
	GY1G0400G020N-GFGS		●								●								4.00	0.2	25.65	2.7	7°		
	GY1G0475H020N-GFGS		●								●								4.75	0.2	25.65	2.7	7°		
	GY1G0500H020N-GFGS		●								●								5.00	0.2	25.65	2.7	7°		
	GY1G0600J020N-GFGS		●																6.00	0.2	25.65	2.7	7°		

● = NEW

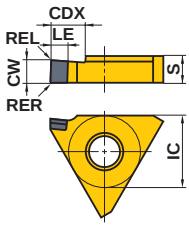
● : Inventory maintained in Japan. (1 insert in one case)

GRADES ➤ B006
IDENTIFICATION ➤ B002

MGTR TYPE INSERTS WITH HOLE

Work Material			BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	MB4120	MB4020	MB710	MB730
	H	Hardened Materials	●	●	◐	✠	●	◐	●	◐	✠	◐	●	◐	✠				
	K	Cast Iron														◐		●	◐
	S	Heat-resistant Alloy, Titanium Alloy																	◐
		Sintered Alloy														◐	◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

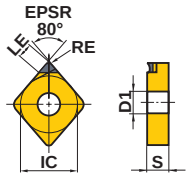
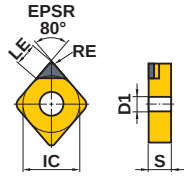
Shape	Order Number	Coated CBN						CBN											Dimensions (mm)						Geometry	Applicable Holder Page
		BC8105	BC8110	BC8120	BC8130	MBC010	MBC020	NEW MB8110	MB8120	MB8130	MB8025	MB810	MB825	MB835	NEW MB4120	MB4020	MB710	MB730	CW	LE	CDX	IC	S	RER REL		
	MGTR43125										●								1.25	2.7	1.2	12.7	4.76	0.2		F116 H014
	MGTR43150										●								1.50	2.7	3.0	12.7	4.76	0.2		
	MGTR43200										●								2.00	2.7	3.0	12.7	4.76	0.2		
	MGTR43250										●								2.50	2.7	4.5	12.7	4.76	0.3		
	MGTR43300										●								3.00	2.7	4.5	12.7	4.76	0.3		
	MGTR43350										●								3.50	2.7	4.5	12.7	4.76	0.3		
	MGTR43400										●								4.00	2.7	4.5	12.7	4.76	0.3		
																									Right hand insert only.	

● = NEW

80° CN TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

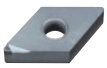
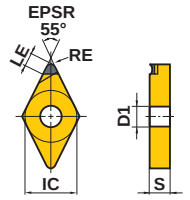
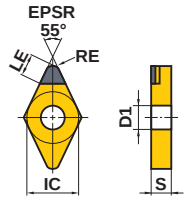
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	NP-CNMM120402R-F	●	12.7	4.76	0.2	1.8	5.16	 Right hand insert shown.	C008 C009 E013 E036 E041 H006 −008
	NP-CNMM120402L-F	□	12.7	4.76	0.2	1.8	5.16		
	NP-CNMM120404R-F	●	12.7	4.76	0.4	1.9	5.16		
	NP-CNMM120404L-F	□	12.7	4.76	0.4	1.9	5.16		
	NP-CNMM120408R-F	●	12.7	4.76	0.8	2.1	5.16		
	NP-CNMM120408L-F	□	12.7	4.76	0.8	2.1	5.16		
	CNMA120404	●	12.7	4.76	0.4	3.7	5.16		C008 C009 E013 E036 E041 H006 −008
	CNMA120408	●	12.7	4.76	0.8	3.6	5.16		

55° DN TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

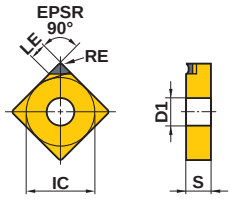
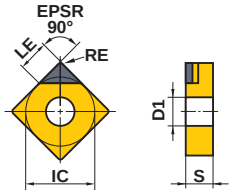
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT  (With Breaker)	NP-DNMM150402R-F	●	12.7	4.76	0.2	1.5	5.16	 Right hand insert shown.	C010 C011 E013 E036 −041 H009 −011
	NP-DNMM150402L-F	□	12.7	4.76	0.2	1.5	5.16		
	NP-DNMM150404R-F	●	12.7	4.76	0.4	1.5	5.16		
	NP-DNMM150404L-F	□	12.7	4.76	0.4	1.5	5.16		
	NP-DNMM150408R-F	●	12.7	4.76	0.8	1.7	5.16		
	NP-DNMM150408L-F	□	12.7	4.76	0.8	1.7	5.16		
	DNGA150404	●	12.7	4.76	0.4	2.9	5.16		C010 C011 E013 E036 −041 H009 −011
	DNGA150408	●	12.7	4.76	0.8	2.5	5.16		

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

90° SN TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

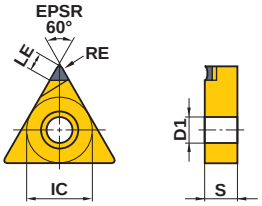
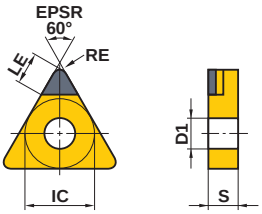
Cutting Conditions (Guide) :
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	NP-SNMM120404R-F	●	12.7	4.76	0.4	2.1	5.16	 Right hand insert shown.	C012 –015 E014 E035
	NP-SNMM120404L-F	□	12.7	4.76	0.4	2.1	5.16		
	NP-SNMM120408R-F	●	12.7	4.76	0.8	2.3	5.16		
	NP-SNMM120408L-F	□	12.7	4.76	0.8	2.3	5.16		
	SNGA120404	□	12.7	4.76	0.4	3.8	5.16		C012 –015 E014 E035
	SNGA120408	●	12.7	4.76	0.8	3.8	5.16		

60° TN TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	NP-TNMM160402R-F	●	9.525	4.76	0.2	1.5	3.81	 Right hand insert shown.	C016 C017 E014 E035 E040
	NP-TNMM160402L-F	□	9.525	4.76	0.2	1.5	3.81		
	NP-TNMM160404R-F	●	9.525	4.76	0.4	1.6	3.81		
	NP-TNMM160404L-F	□	9.525	4.76	0.4	1.6	3.81		
	NP-TNMM160408R-F	●	9.525	4.76	0.8	1.8	3.81		
	NP-TNMM160408L-F	□	9.525	4.76	0.8	1.8	3.81		
	TNGA160402	●	9.525	4.76	0.2	3.1	3.81		C016 C017 E014 E035 E040
	TNGA160404	●	9.525	4.76	0.4	3.0	3.81		
	TNGA160408	●	9.525	4.76	0.8	2.8	3.81		

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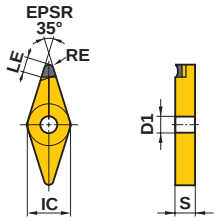
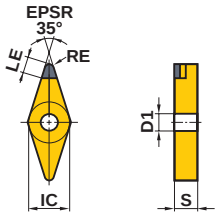
IDENTIFICATION ➤ B002

35° VN TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

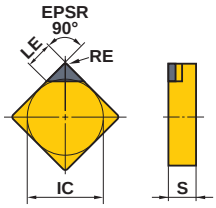
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	**NP-VNMM160402R-F**	●	9.525	4.76	0.2	1.3	3.81	 Right hand insert shown.	C018 –020 E015 E042
	NP-VNMM160402L-F	□	9.525	4.76	0.2	1.3	3.81		
	NP-VNMM160404R-F	●	9.525	4.76	0.4	1.4	3.81		
	NP-VNMM160404L-F	□	9.525	4.76	0.4	1.4	3.81		
	NP-VNMM160408R-F	●	9.525	4.76	0.8	1.5	3.81		
	NP-VNMM160408L-F	□	9.525	4.76	0.8	1.5	3.81		
	VNGA160404	●	9.525	4.76	0.4	2.6	3.81		C018 –020 E015 E042
	VNGA160408	●	9.525	4.76	0.8	1.8	3.81		

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

90° SN TYPE INSERTS WITHOUT HOLE

Work Material	N	Non-ferrous Metal	●

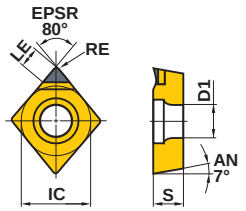
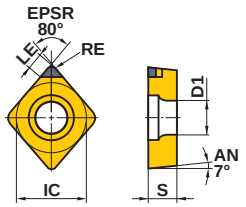
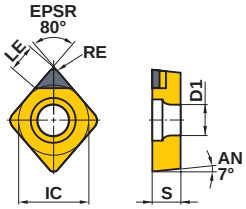
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	Geometry	Applicable Holder Page
	SNGN120404	□	12.7	4.76	0.4	3.8		—
	SNGN120408	●	12.7	4.76	0.8	3.8		

80° CC TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

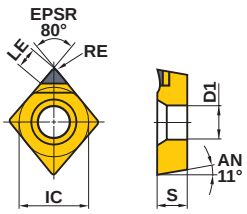
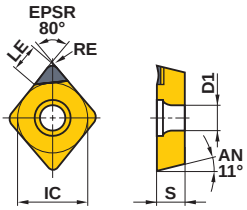
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	NP-CCMH060202	●	6.35	2.38	0.2	1.8	2.8		C022 D008 E006 E030 E034
	NP-CCMH060204	●	6.35	2.38	0.4	1.9	2.8		
NEW PETIT CUT	* NP-CCMW03S102	●	3.57	1.39	0.2	1.8	2.0		E016
	* NP-CCMW03S104	●	3.57	1.39	0.4	1.9	2.0		
	* NP-CCMW04T002	●	4.37	1.79	0.2	1.8	2.4		
	* NP-CCMW04T004	●	4.37	1.79	0.4	1.9	2.4		
	CCMW060202	●	6.35	2.38	0.2	2.9	2.8		C022 D008 E006 E030 E034
	CCMW060204	●	6.35	2.38	0.4	2.9	2.8		
	CCMW09T302	●	9.525	3.97	0.2	3.3	4.4		
	CCMW09T304	●	9.525	3.97	0.4	3.3	4.4		

* Diameter of inscribed circle is special. (For SCLC type)

80° CP TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

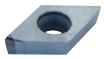
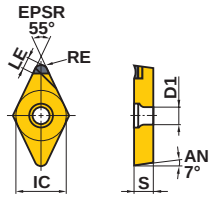
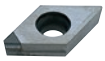
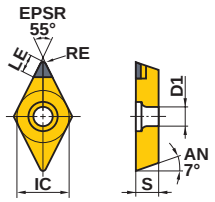
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT (With Breaker)	NP-CPMH080202	●	7.94	2.38	0.2	1.8	3.5		E006
	NP-CPMH080204	●	7.94	2.38	0.4	1.9	3.5		
	NP-CPMH090302	●	9.525	3.18	0.2	1.8	4.5		
	NP-CPMH090304	●	9.525	3.18	0.4	1.9	4.5		
(With Breaker)	CPGT080202	●	7.94	2.38	0.2	3.7	3.4		–
	CPGT080204	●	7.94	2.38	0.4	3.7	3.4		
	CPGT090302	●	9.525	3.18	0.2	3.3	4.4		
	CPGT090304	●	9.525	3.18	0.4	3.3	4.4		

● : Inventory maintained in Japan. (1 insert in one case)

55° DC TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

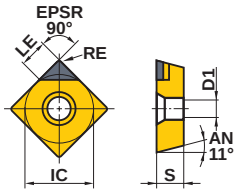
Cutting Conditions (Guide) :
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT  (With Breaker)	NP-DCMT070202R-F	●	6.35	2.38	0.2	1.5	2.8	 Left hand insert shown.	C023 D009 D026 E008 E009 E029 E031
	NP-DCMT070202L-F	●	6.35	2.38	0.2	1.5	2.8		
	NP-DCMT070204R-F	●	6.35	2.38	0.4	1.5	2.8		
	NP-DCMT070204L-F	●	6.35	2.38	0.4	1.5	2.8		
	NP-DCMT11T302R-F	●	9.525	3.97	0.2	1.5	4.4		
	NP-DCMT11T302L-F	●	9.525	3.97	0.2	1.5	4.4		
	NP-DCMT11T304R-F	●	9.525	3.97	0.4	1.5	4.4		
	NP-DCMT11T304L-F	●	9.525	3.97	0.4	1.5	4.4		
	DCMW070202	●	6.35	2.38	0.2	2.7	2.8		C023 D009 D026 E008 E009 E029 E031
	DCMW070204	●	6.35	2.38	0.4	2.6	2.8		
	DCMW11T302	●	9.525	3.97	0.2	3.0	4.4		
	DCMW11T304	●	9.525	3.97	0.4	2.9	4.4		

90° SP TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

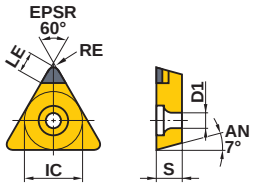
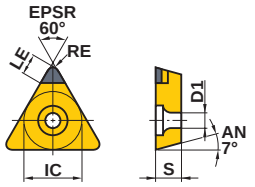
Cutting Conditions (Guide) :
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
	SPGX090304	●	9.525	3.18	0.4	3.8	4.8		–
	SPGX090308	●	9.525	3.18	0.8	3.8	4.8		

60° TC TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
	TCMW110202	●	6.35	2.38	0.2	2.8	2.8		C027 E028
	TCMW110204	●	6.35	2.38	0.4	2.6	2.8		
	TCGW060102	●	3.97	1.59	0.2	1.5	2.3		–
	TCGW060104	●	3.97	1.59	0.4	1.6	2.3		
	TCGW060108	●	3.97	1.59	0.8	1.4	2.3		

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

60° TP TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

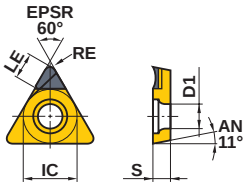
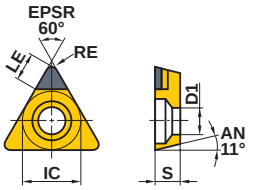
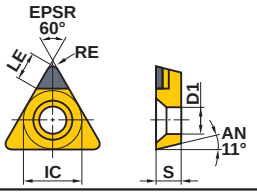
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
NEW PETIT CUT	NP-TPMX090202R-F	●	5.56	2.38	0.2	1.5	3.0		
	NP-TPMX090202L-F	●	5.56	2.38	0.2	1.5	3.0		
	NP-TPMX090204R-F	□	5.56	2.38	0.4	1.6	3.0		
	NP-TPMX090204L-F	●	5.56	2.38	0.4	1.6	3.0		
	NP-TPMX090208R-F	□	5.56	2.38	0.8	1.8	3.0		
	NP-TPMX090208L-F	●	5.56	2.38	0.8	1.8	3.0		
	NP-TPMX110302R-F	□	6.35	3.18	0.2	1.5	3.5		
	NP-TPMX110302L-F	●	6.35	3.18	0.2	1.5	3.5		
	NP-TPMX110304R-F	□	6.35	3.18	0.4	1.6	3.5		
	NP-TPMX110304L-F	●	6.35	3.18	0.4	1.6	3.5		E025
	NP-TPMX110308R-F	□	6.35	3.18	0.8	1.8	3.5	NP-TPMX16○○○○R/L-F	
	NP-TPMX110308L-F	●	6.35	3.18	0.8	1.8	3.5		
	NP-TPMX160302R-F	□	9.525	3.18	0.2	1.5	4.8		
	NP-TPMX160302L-F	●	9.525	3.18	0.2	1.5	4.8		
	NP-TPMX160304R-F	□	9.525	3.18	0.4	1.6	4.8		
	NP-TPMX160304L-F	●	9.525	3.18	0.4	1.6	4.8		
	NP-TPMX160308R-F	□	9.525	3.18	0.8	1.8	4.8		
(With Breaker)	NP-TPMX160308L-F	●	9.525	3.18	0.8	1.8	4.8	Right hand insert shown.	
NEW PETIT CUT	NP-TPMH080202R-F	●	4.76	2.38	0.2	1.5	2.4		
	NP-TPMH080202L-F	●	4.76	2.38	0.2	1.5	2.4		
	NP-TPMH080204R-F	●	4.76	2.38	0.4	1.6	2.4		
	NP-TPMH080204L-F	●	4.76	2.38	0.4	1.6	2.4		
	NP-TPMH090202R-F	●	5.56	2.38	0.2	1.5	2.9		
	NP-TPMH090202L-F	●	5.56	2.38	0.2	1.5	2.9		
	NP-TPMH090204R-F	●	5.56	2.38	0.4	1.6	2.9		
	NP-TPMH090204L-F	●	5.56	2.38	0.4	1.6	2.9		E007
	NP-TPMH110302R-F	●	6.35	3.18	0.2	1.5	3.4		
	NP-TPMH110302L-F	●	6.35	3.18	0.2	1.5	3.4		
	NP-TPMH110304R-F	●	6.35	3.18	0.4	1.6	3.4		
	NP-TPMH110304L-F	●	6.35	3.18	0.4	1.6	3.4		
	NP-TPMH160302R-F	●	9.525	3.18	0.2	1.5	4.4		
	NP-TPMH160302L-F	●	9.525	3.18	0.2	1.5	4.4		
	NP-TPMH160304R-F	●	9.525	3.18	0.4	1.6	4.4		
(With Breaker)	NP-TPMH160304L-F	●	9.525	3.18	0.4	1.6	4.4	Left hand insert shown.	
	TPGT160302R-F	●	9.525	3.18	0.2	3.1	4.4		
	TPGT160302L-F	●	9.525	3.18	0.2	3.1	4.4		
	TPGT160304R-F	●	9.525	3.18	0.4	3.0	4.4		–
	TPGT160304L-F	●	9.525	3.18	0.4	3.0	4.4		
(With Breaker)								Right hand insert shown.	

GRADES ➤ B021
IDENTIFICATION ➤ B002

60° TP TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

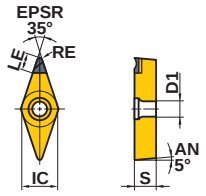
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**TPGV090202R-F**	●	5.56	2.38	0.2	2.8	2.8	 Right hand insert shown.	–
	TPGV090202L-F	●	5.56	2.38	0.2	2.8	2.8		
	TPGV090204R-F	●	5.56	2.38	0.4	2.6	2.8		
	TPGV090204L-F	●	5.56	2.38	0.4	2.6	2.8		
	TPGV110302R-F	●	6.35	3.18	0.2	2.8	3.4		
	TPGV110302L-F	●	6.35	3.18	0.2	2.8	3.4		
	TPGV110304R-F	●	6.35	3.18	0.4	2.6	3.4		
	TPGV110304L-F	●	6.35	3.18	0.4	2.6	3.4		
	TPGX080202	●	4.76	2.38	0.2	1.9	2.5	 TPGX16○○○○ 	E025
	TPGX080204	●	4.76	2.38	0.4	1.7	2.5		
	TPGX080208	●	4.76	2.38	0.8	1.4	2.5		
	TPGX090202	●	5.56	2.38	0.2	2.8	3.0		
	TPGX090204	●	5.56	2.38	0.4	2.6	3.0		
	TPGX090208	●	5.56	2.38	0.8	2.3	3.0		
	TPGX110302	●	6.35	3.18	0.2	2.8	3.5		
	TPGX110304	●	6.35	3.18	0.4	2.6	3.5		
	TPGX110308	●	6.35	3.18	0.8	2.3	3.5		
	TPGX160304	●	9.525	3.18	0.4	3	4.8		
	TPGX160308	●	9.525	3.18	0.8	2.7	4.8		

● : Inventory maintained in Japan. (1 insert in one case)

35° VB TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

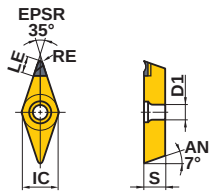
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**NP-VBGT110301R-F**	●	6.35	3.18	0.1	2.6	2.85		D010 D011 E011 E012
	NP-VBGT110302R-F	●	6.35	3.18	0.2	2.6	2.85		
	NP-VBGT110304R-F	●	6.35	3.18	0.4	2.5	2.85		
	NP-VBGT1103V5R-F	●	6.35	3.18	0.05	2.5	2.85		

35° VC TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

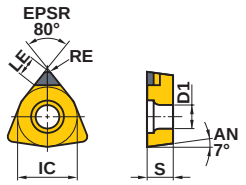
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**NP-VCGT080201R-F**	●	4.76	2.38	0.1	2.6	2.4		C028 D011 E011 E012 E032
	NP-VCGT080202R-F	●	4.76	2.38	0.2	2.6	2.4		
	NP-VCGT080204R-F	●	4.76	2.38	0.4	2.5	2.4		
	NP-VCGT0802V5R-F	●	4.76	2.38	0.05	2.5	2.4		
	NP-VCGT110301R-F	●	6.35	3.18	0.1	2.6	2.8		
	NP-VCGT110302R-F	●	6.35	3.18	0.2	2.6	2.8		
	NP-VCGT110304R-F	●	6.35	3.18	0.4	2.5	2.8		
	NP-VCGT1103V5R-F	●	6.35	3.18	0.05	2.5	2.8		

GRADES ➤ B021
IDENTIFICATION ➤ B002

80° WC TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

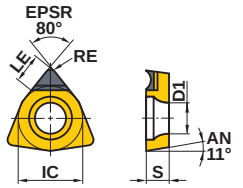
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	Dimensions (mm) IC	S	RE	LE	D1	Geometry	Applicable Holder Page
	WCMWL30202	●	4.76	2.38	0.2	1.6	2.3		E027
	WCMWL30204	□	4.76	2.38	0.4	1.7	2.3		
	WCMW040202	●	6.35	2.38	0.2	2.9	2.8		
	WCMW040204	□	6.35	2.38	0.4	3.0	2.8		
	WCMW06T304	●	9.525	3.97	0.4	3.0	4.4		
	WCMW06T308	□	9.525	3.97	0.8	3.3	4.4		

80° WP TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

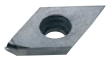
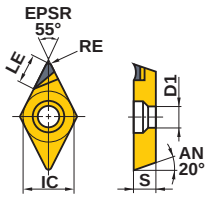
Shape	Order Number	PCD MD220	Dimensions (mm) IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**WPGT040202**	●	6.35	2.38	0.2	2.9	2.8		E010
	WPGT040204	●	6.35	2.38	0.4	2.9	2.8		
	WPGT060302	●	9.525	3.18	0.2	3.3	4.4		
	WPGT060304	●	9.525	3.18	0.4	3.3	4.4		

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

55° DE TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

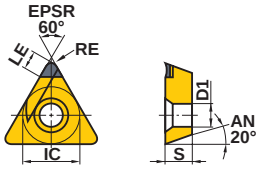
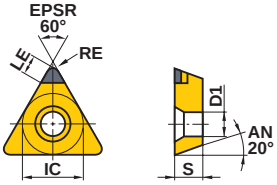
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
 (With Breaker)	**DEGX150402R-F**	●	12.7	4.76	0.2	3.0	5.1	 Right hand insert shown.	C032
	DEGX150402L-F	●	12.7	4.76	0.2	3.0	5.1		
	DEGX150404R-F	●	12.7	4.76	0.4	2.9	5.1		
	DEGX150404L-F	●	12.7	4.76	0.4	2.9	5.1		

60° TE TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

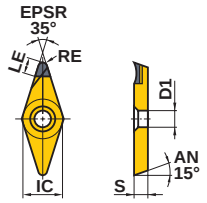
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**TEGX160302R**	●	9.525	3.18	0.2	3.8	4.4	 Right hand insert shown.	C033 E043
	TEGX160302L	●	9.525	3.18	0.2	3.8	4.4		
	TEGX160304R	●	9.525	3.18	0.4	3.7	4.4		
	TEGX160304L	●	9.525	3.18	0.4	3.7	4.4		
	TEGX160302	●	9.525	3.18	0.2	3.1	4.4		C033 E043
	TEGX160304	●	9.525	3.18	0.4	3.0	4.4		

GRADES ➤ B021
IDENTIFICATION ➤ B002

35° VD TYPE INSERTS WITH HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

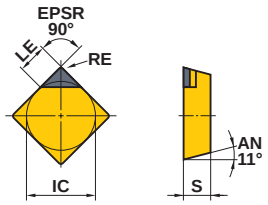
Shape	Order Number	PCD MD220	IC	S	RE	LE	D1	Geometry	Applicable Holder Page
(With Breaker)	**VDGX160302R-F**	●	9.525	3.18	0.2	3.1	4.5	 Right hand insert shown.	C034
	VDGX160302L-F	●	9.525	3.18	0.2	3.1	4.5		
	VDGX160304R-F	●	9.525	3.18	0.4	2.7	4.5		
	VDGX160304L-F	●	9.525	3.18	0.4	2.7	4.5		

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

90° SP TYPE INSERTS WITHOUT HOLE

Work Material	N	Non-ferrous Metal	●

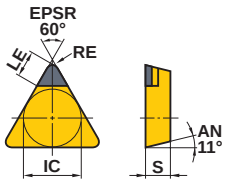
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	Geometry	Applicable Holder Page
	SPGN090302	●	9.525	3.18	0.2	3.8		–
	SPGN090304	●	9.525	3.18	0.4	3.8		
	SPGN090308	●	9.525	3.18	0.8	3.8		
	SPGN090312	□	9.525	3.18	1.2	3.8		
	SPGN120304	●	12.7	3.18	0.4	3.8		
	SPGN120308	●	12.7	3.18	0.8	3.8		
	SPGN120312	●	12.7	3.18	1.2	3.8		

60° TP TYPE INSERTS WITHOUT HOLE

Work Material	N	Non-ferrous Metal	●

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	PCD MD220	IC	S	RE	LE	Geometry	Applicable Holder Page
	TPGN110302	●	6.35	3.18	0.2	2.8		E026
	TPGN110304	●	6.35	3.18	0.4	2.6		
	TPGN110308	●	6.35	3.18	0.8	2.3		
	TPGN160302	●	9.525	3.18	0.2	3.1		
	TPGN160304	●	9.525	3.18	0.4	3.0		
	TPGN160308	●	9.525	3.18	0.8	2.7		
	TPGN160312	□	9.525	3.18	1.2	2.4		

GRADES ➤ B021
IDENTIFICATION ➤ B002

HOW TO READ THE STANDARD OF EXTERNAL TURNING TOOLS

●How this section page is organised

①Organised according to turning insert shape.
(Refer to the index on the next page.)

TYPE OF TOOL HOLDER
indicates the first four letters of the order number, as well as cutting applications.

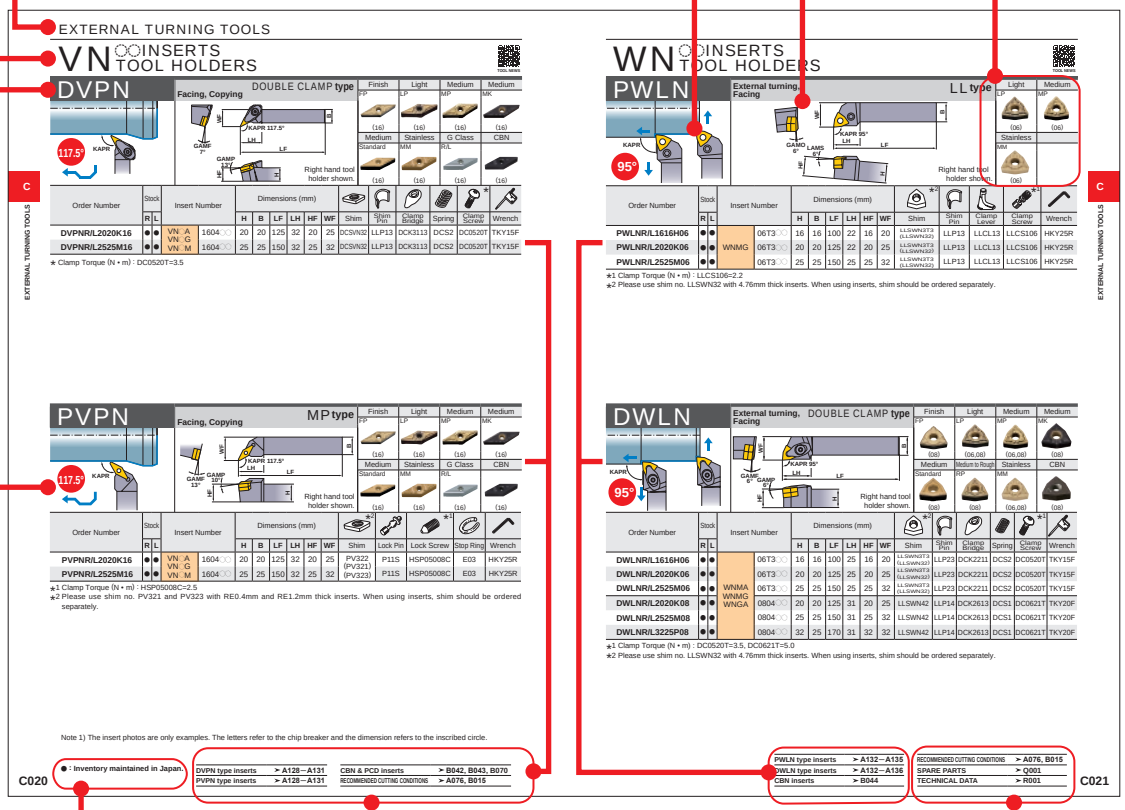
TITLE OF PRODUCT BY INSERT TYPE

PRODUCT SECTION

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict the available machining applications such as external turning, copying, facing, and chamfering together with cutting edge lead angles.

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

REFERENCE PAGE FOR APPLICABLE INSERTS
indicates reference pages giving details of inserts that are applicable to the product.

PAGE REFERENCE
・SPARE PARTS
・TECHNICAL DATA
indicates reference pages, including the above, on the right hand page of each double-page spread.

PRODUCT STANDARDS
indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

●To Order : Please specify
①order number and hand of tool (right/left).

TURNING TOOLS

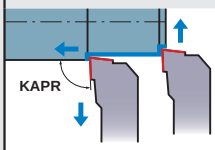
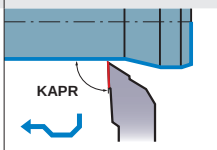
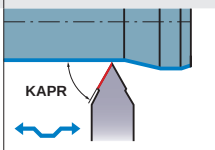
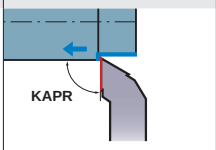
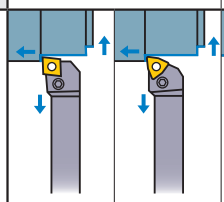
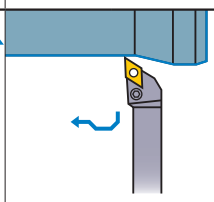
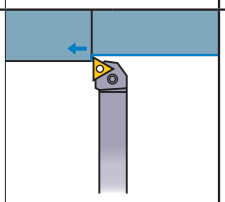
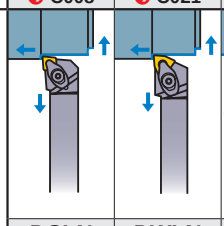
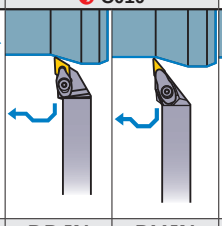
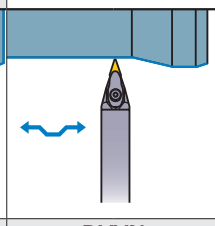
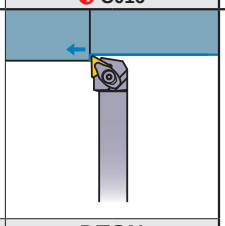
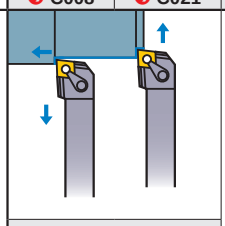
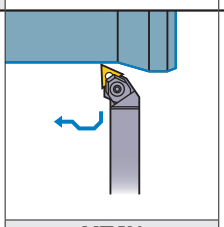
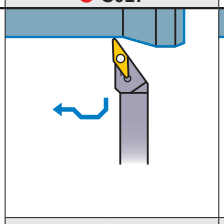
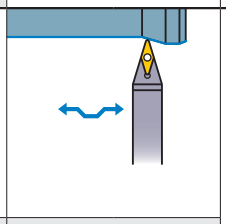
EXTERNAL TURNING TOOLS

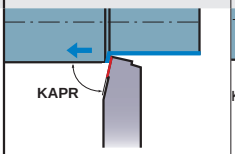
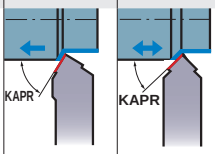
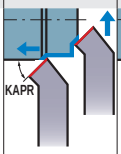
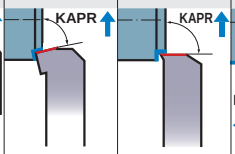
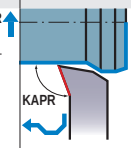
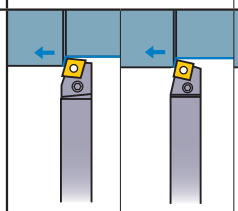
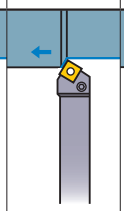
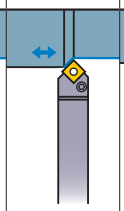
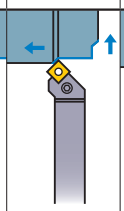
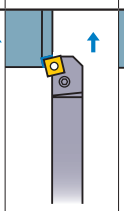
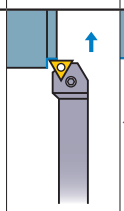
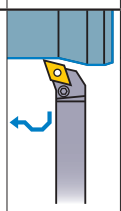
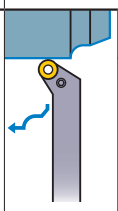
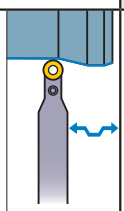
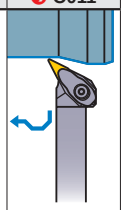
CLASSIFICATION ····· C002
IDENTIFICATION ····· C006
METHOD OF HOLDING ····· C007
STANDARD HOLDERS
CN◯◯ INSERTS TOOL HOLDERS ····· C008
DN◯◯ INSERTS TOOL HOLDERS ····· C010
SN◯◯ INSERTS TOOL HOLDERS ····· C012
TN◯◯ INSERTS TOOL HOLDERS ····· C016
VN◯◯ INSERTS TOOL HOLDERS ····· C018
WN◯◯ INSERTS TOOL HOLDERS ····· C021
CC◯◯ INSERTS TOOL HOLDERS ····· C022
DC◯◯ INSERTS TOOL HOLDERS ····· C023
RC◯◯ INSERTS TOOL HOLDERS ····· C024
SC◯◯ INSERTS TOOL HOLDERS ····· C026
TC◯◯ INSERTS TOOL HOLDERS ····· C027
VC◯◯ INSERTS TOOL HOLDERS ····· C028
XC◯◯ INSERTS TOOL HOLDERS ····· C030
TL HOLDER ····· C035
●AL HOLDER (FOR ALUMINIUM TURNING)
DE◯◯ INSERTS TOOL HOLDERS ····· C032
TE◯◯ INSERTS TOOL HOLDERS ····· C033
VD◯◯ INSERTS TOOL HOLDERS ····· C034

*Arranged by Alphabetical order

C008 **DCLN**
C010 **DDJN**
C016 **DTGN**
C018 **DVJN**
C020 **DVPN**
C019 **DVVN**
C021 **DWLN**
C009 **MCLN**
C012 **MSBN**
C014 **MSSN**
C017 **MTJN**
C009 **PCBN**
C008 **PCLN**
C011 **PDHN**
C010 **PDJN**
C024 **PRDC**
C024 **PRGC**
C012 **PSBN**
C014 **PSDN**
C015 **PSKN**
C013 **PSSN**
C013 **PSTN**
C017 **PTFN**
C016 **PTGN**
C018 **PVJN**
C020 **PVPN**
C019 **PVVN**
C021 **PWLN**
C022 **SCLC**
C023 **SDJC**
C032 **SDJE**
C023 **SDNC**
C032 **SDNE**
C025 **SRDC**
C025 **SRGC**
C026 **SSSC**
C033 **STFE**
C027 **STGC**
C033 **STGE**
C028 **SVJC**
C034 **SVJD**
C029 **SVPC**
C028 **SVVC**
C030 **SXZC**
C035 **TLHR**

CLASSIFICATION(Negative insert)

Tool Holder	Features Shank Size (H x W x L)	External Turning Facing KAPR=95°	External Turning Copying KAPR=93°	External Turning Copying KAPR=72.5°	External Turning KAPR=91°
					
LL Holder 	● Lever lock type. ● ISO standard. ● Various holder shapes. ● Suitable for light to heavy cutting. ● Economical negative insert. 10 x 10 x 70 / 25 x 25 x 150 12 x 12 x 80 / 32 x 25 x 170 16 x 16 x 100 / 32 x 32 x 170 20 x 20 x 125	 **PCLN** ➲ C008 **PWLN** ➲ C021	 **PDJN** ➲ C010		 **PTGN** ➲ C016
DOUBLE CLAMP Holder 	● New double clamp type. ● Holds inserts securely. ● Excellent cutting edge tolerance. ● Economical negative insert. ● Small insert series. 16 x 16 x 100 / 25 x 25 x 150 20 x 20 x 125 / 32 x 25 x 170	 **DCLN** ➲ C008 **DWLN** ➲ C021	 **DDJN** ➲ C010 **DVJN** ➲ C018	 **DVVN** ➲ C019	 **DTGN** ➲ C016
DOUBLE CLAMP Holder (For heavy cutting) 	● Double clamp holder type. ● Holds inserts securely. ● Suitable for heavy cutting. ● Negative insert. 32 x 32 x 170 40 x 40 x 200	 **MCLN** ➲ C009			
WP Holder 	● Double clamp holder type. ● Simple insert exchange. ● Economical negative insert. 20 x 20 x 125 25 x 25 x 150		 **MTJN** ➲ C017		
MP Holder 	● Pin lock type. ● 35°rhombic shape insert. ● Suitable for recessing. 20 x 20 x 125 25 x 25 x 150		 **PVJN** ➲ C018	 **PVVN** ➲ C019	

External Turning		External Turning, Chamfering		External Turning, Facing, Chamfering	Facing		Facing, Copying	External Turning, Copying		Selection Standard				
KAPR=75°		KAPR=60°	KAPR=45°	KAPR=45°	KAPR=75°	KAPR=91°	KAPR=107.5° 117.5°	Special Design (Positive inserts)		Economical	Low Cutting Resistance (Sharpness)	Clamp Rigidity	Operation Efficiency	Specialised
														
										◎		○	◎	
PCBN ➲ C009	PSBN ➲ C012	PSTN ➲ C013	PSDN ➲ C014	PSSN ➲ C013	PSKN ➲ C015	PTFN ➲ C017	PDHN ➲ C011	PRGC ➲ C024	PRDC ➲ C024					
										◎		◎	◎	
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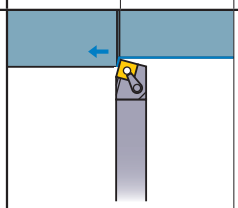
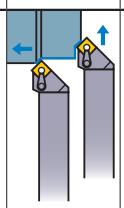
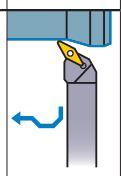
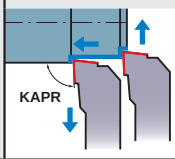
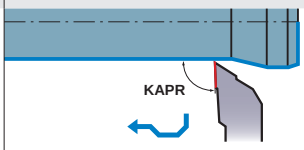
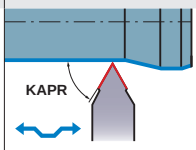
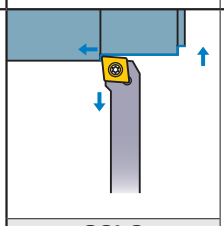
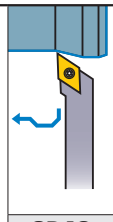
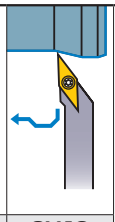
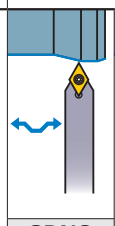
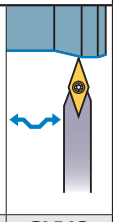
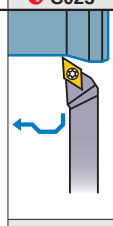
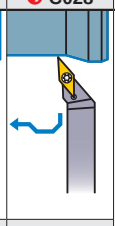
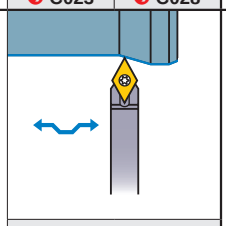
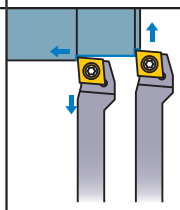
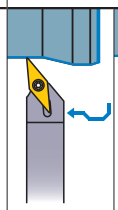
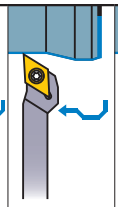
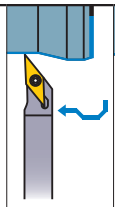
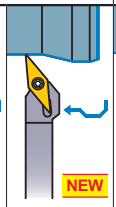
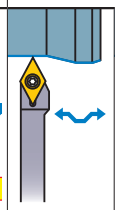
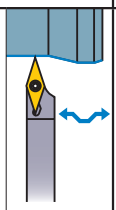
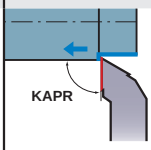
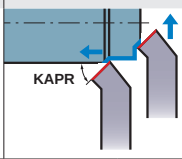
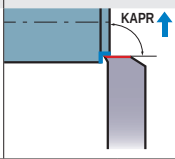
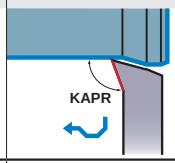
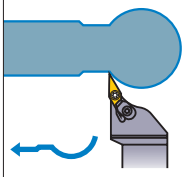
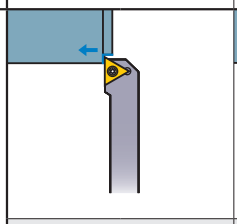
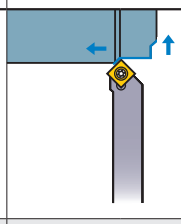
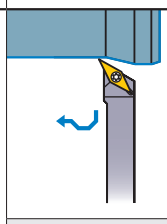
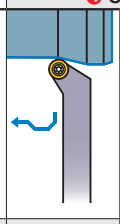
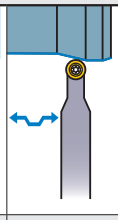
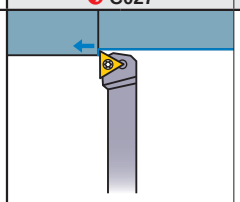
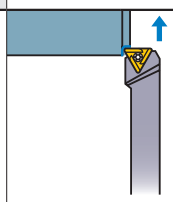
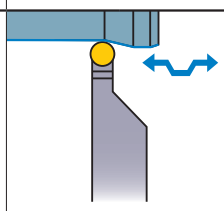
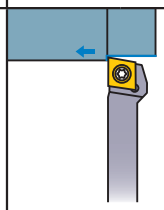
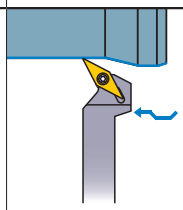
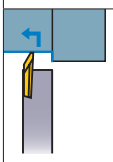
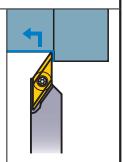
												◎		
MSBN ➲ C012				MSSN ➲ C014										
										◎		◎	◎	
										◎			◎	
							PVPN ➲ C020							

Note 1) ◎ : 1st recommendation. ○ : 2nd recommendation.

CLASSIFICATION(Positive insert)

Tool Holder	Features Shank Size (H x W x L)	External Turning, Facing KAPR=95°	External Turning, Copying KAPR=93° 95°				External Turning, Copying KAPR=62.5° 72.5°	
								
Profile Holder 	● Double clamp holder type. ● 25° rhombic shape insert. ● Possible to machine a face relief with up to 60º inclination. 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150							
SP Holder 	● Screw-on type. ● Miniature holder with 7°positive insert. 8 x 8 x 60 10 x 10 x 70 12 x 12 x 80 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150	 SCLC ➲ C022		 SDJC ➲ C023	 SVJC ➲ C028		 SDNC ➲ C023	 SVVC ➲ C028
AL Holder (For Aluminium turning) 	● Screw-on type. ● 20°positive insert. (35°rhombic shape insert is 15°) ● High rake and good sharpness. 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150			 SDJE ➲ C032	 SVJD ➲ C034		 SDNE ➲ C032	
TL Holder 	● Taper lock type ● Excellent finished surface with round shape insert. 20 x 20 x 125 25 x 25 x 150 32 x 25 x 170							
SMALL TOOLS (Tools for front turning) 	● Screw-on type. ● Tools to be equipped on gang type tool posts. ● Miniature holder with 7°positive insert. 8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	 SCLC-SM ➲ D008	 SVLP-SM ➲ D010	 SDJC-SM ➲ D009	 SVJB-SM ➲ D010	 SVJC-SM ➲ D011	 SDNC-SM ➲ D009	 SVVB-SM ➲ D011
SMALL TOOLS (Tools for back turning) 	● Screw-on type. ● Tools to be equipped on gang type tool posts. ● High rigidity due to designing of vertical insert. (BTA/CTB type) ● Back machining. (BTA/CTB type) 8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120							

	External Turning	External Turning, Facing, Chamfering	Facing	Facing, Copying	External Turning, Copying	Selection Standard				
	KAPR=90° 91°	KAPR=45°	KAPR=91°	KAPR=117.5°	Special Design	Economical	Low Cutting Resistance (Sharpness)	Clamp Rigidity	Operation Efficiency	Specialised
										
					 SXZC ➲ C030		◎	◎		
	 STGC ➲ C027	 SSSC ➲ C026		 SVPC ➲ C029	 SRGC ➲ C025  SRDC ➲ C025		○			
	 STGE ➲ C033		 STFE ➲ C033				◎			◎
					 TLHR ➲ C035		○			◎
	 SCAC-SM ➲ D008			 SVPP-SM ➲ D011			○			
					Special Design  BTAH/CTBH ➲ D012  BTVH ➲ D014		○			

Note 1) ◎ : 1st recommendation. ○ : 2nd recommendation.

IDENTIFICATION

■ LL Holder / Double Clamp Holder / SP Holder / Profile Holder / AL Holder

P	C	L	N	R	25	25	M	12
①	②	③	④	⑤	⑥	⑥	⑦	⑧

①Clamp Structure	
D	Double Clamp Type
M	Wedge Lock Type Multiple Clamp Type
P	Lever Lock Type
S	Screw-on Type

②Insert Shape	
C	Rhombic 80°
D	Rhombic 55°
R	Round
S	Square
T	Triangular
V	Rhombic 35°
W	Trigon
X	Special Design

③Cutting Angle KAPR	
A	90°Without Offset
B	75°
D	45°Neutral
E	60°
F	90°
G	90°With Offset
H	107.5°
J	93°
K	75°
L	95°
N	62.5°
P	117.5°
Q	105°
S	45°
T	60°
V	72.5°
Z	Special

④Insert Clearance	
C	7°Positive
N	Negative
E	20°Positive

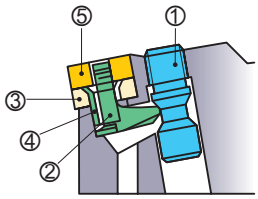
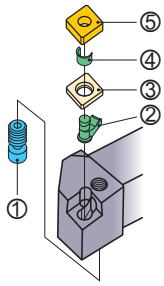
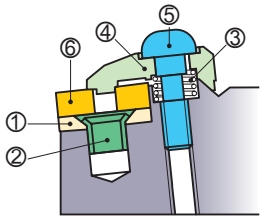
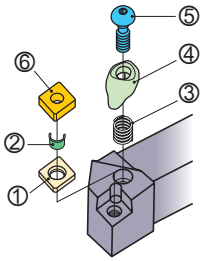
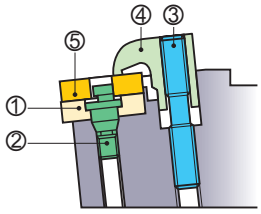
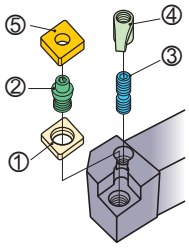
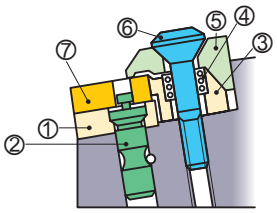
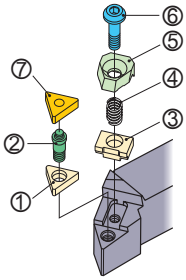
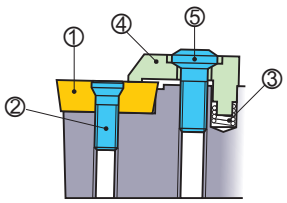
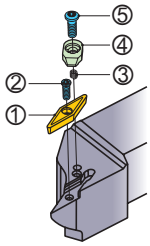
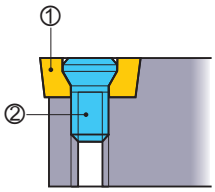
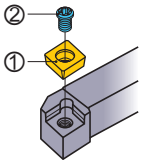
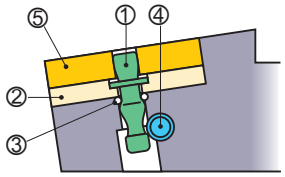
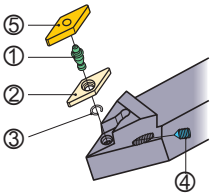
⑤Hand of Tool	
R	Right Hand
L	Left Hand
N	Neutral

⑥Tool Size H/B (mm) (Height and Width)	
8	08
10	10
12	12
16	16
20	20
25	25
32	32

⑦Tool Length LF (mm)	
D	60
E	70
F	80
H	100
K	125
M	150
P	170
Q	180
R	200

⑧Cutting Edge Length (mm)						
Inscribed Circle	Insert Shape					
	Square	Triangular	Round	Rhombic 80°	Rhombic 55°	Rhombic 35°
6.00	–	–	06	–	–	–
6.35	–	11	–	06	07	11
7.94	–	13	–	–	–	–
8.00	–	–	08	–	–	–
9.525	09	16	–	09	11	16
10.00	–	–	10	–	–	–
12.00	–	–	12	–	–	–
12.70	12	22	–	12	15	–
15.875	15	27	–	16	–	–
16.00	–	–	16	–	–	–
19.05	19	–	–	19	–	–
20.00	–	–	20	–	–	–
25.00	–	–	25	–	–	–
25.40	25	–	–	–	–	–
32.00	–	–	32	–	–	–

METHOD OF HOLDING

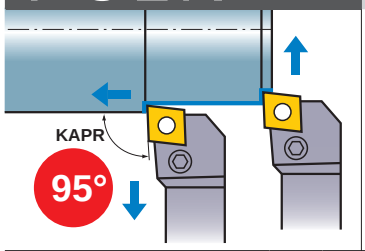
Type (Holder)	Structure		
Lever Lock (LL HOLDER)		①Clamp Screw ②Lever ③Shim ④Shim Pin ⑤Insert	
Double Clamp (DOUBLE CLAMP HOLDER)		①Shim ②Shim Pin ③Spring ④Clamp Bridge ⑤Clamp Screw ⑥Insert	
Multiple Clamp (DOUBLE CLAMP HOLDER) (For heavy cutting)		①Shim ②Shim Pin ③Clamp Screw ④Clamp Bridge ⑤Insert	
Wedge Lock (WP HOLDER)		①Shim ②Shim Pin ③Plate ④Spring ⑤Clamp Bridge ⑥Clamp Screw ⑦Insert	
Two Action Double Clamp (PROFILE HOLDER)		①Insert ②Clamp Screw (1) ③Spring ④Clamp Bridge ⑤Clamp Screw (2)	
Screw-on (SP HOLDER AL HOLDER)		①Insert ②Clamp Screw	
Pin Lock (MP HOLDER)		①Lock Pin ②Shim ③Stop Ring ④Lock Screw ⑤Insert	

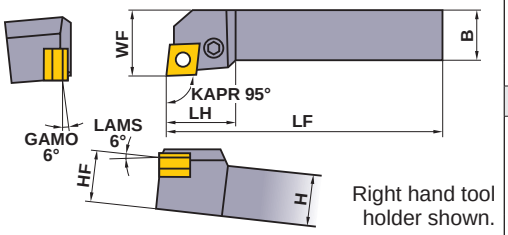
CN INSERTS TOOL HOLDERS

TOOL NEWS

PCLN

External turning, Facing — **LL type**





Right hand tool holder shown.

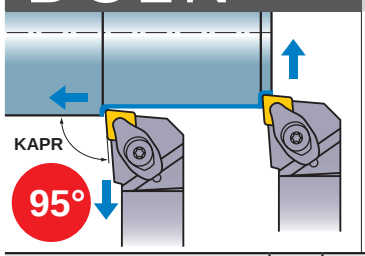
Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12,16)	(12,16,19)
Medium	**Medium to Rough**	**Stainless**	**CBN**
Standard	RP	MM	
(09,12,16,19)	(12,16,19)	(12,16,19)	(12)

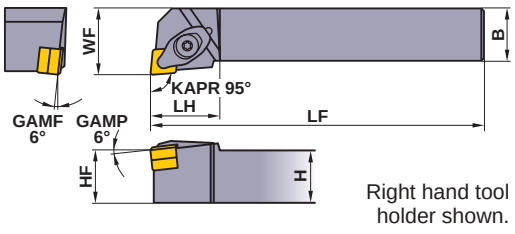
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PCLNR/L1616H09	●	●	CNMG	09T3○○	16	16	100	22	16	20	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
PCLNR/L2020K09	●	●		09T3○○	20	20	125	22	20	25	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
PCLNR/L2525M09	●	●		09T3○○	25	25	150	22	25	32	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
PCLNR/L2020K12	●	●	CNMA CNMG CNMM CNGA CNGG CNGM	1204○○	20	20	125	28	20	25	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
PCLNR/L2525M12	●	●		1204○○	25	25	150	28	25	32	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
PCLNR/L3225P12	●	●		1204○○	32	25	170	28	32	32	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
PCLNR/L3232P16	●	●		1606○○	32	32	170	32	32	40	LLSCN53	LLP15	LLCL25	LLCS508	HKY30R
PCLNR/L3232P19	●	●		1906○○	32	32	170	40	32	40	LLSCN63	LLP16	LLCL16	LLCS310	HKY40R

* Clamp Torque (N • m) : LLCS106=2.2, LLCS108=3.3, LLCS508=3.3, LLCS310=7.0

DCLN

External turning, Facing — **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12)
Medium	**Medium to Rough**	**Stainless**	**CBN**
Standard	RP	MM	
(09,12)	(12)	(12)	(12)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim *2	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench
DCLNR/L1616H09	●	●	CNMG	09T3○○	16	16	100	25	16	20	LLSCN3T3 (LLSCN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DCLNR/L2020K09	●	●		09T3○○	20	20	125	25	20	25	LLSCN3T3 (LLSCN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DCLNR/L2525M09	●	●		09T3○○	25	25	150	25	25	32	LLSCN3T3 (LLSCN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DCLNR/L2020K12	●	●	CNMA CNMG CNMM CNGA CNGG CNGM	1204○○	20	20	125	29	20	25	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DCLNR/L2525M12	●	●		1204○○	25	25	150	29	25	32	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DCLNR/L3225P12	●	●		1204○○	32	25	170	29	32	32	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0520T=3.5, DC0621T=5.0
*2 Please use shim no. LLSCN33 with 3.18mm thick inserts. When using 3.18mm thick inserts, shim should be ordered separately.

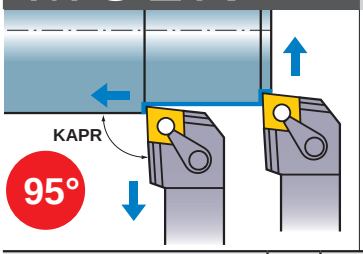
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

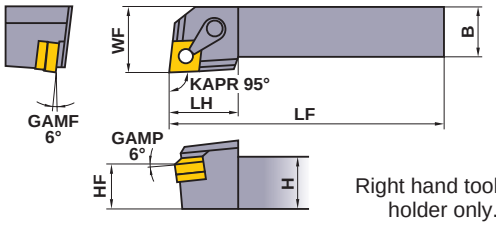
● : Inventory maintained in Japan.

PCLN type inserts	➤ A100—A106
DCLN type inserts	➤ A100—A106
CBN & PCD inserts	➤ B028—B031, B068
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

MCLN

External turning, Facing — DOUBLE CLAMP **type** — For heavy cutting





Right hand tool holder only.

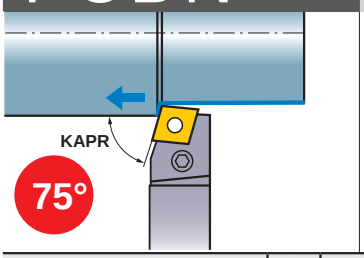
Medium	Medium	Medium	Medium to Rough
MH	Standard	MS	RP
(19)	(19)	(19)	(19)
Heavy	**Heavy**	**Heavy**	**M Class**
HZ	HX	HL	Flat Top
(19)	(19)	(19)	(19)

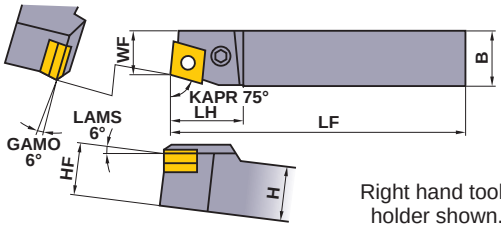
Order Number	Stock	Insert Number		Dimensions (mm)						Shim	Shim Pin	Clamp Bridge	Clamp Screw *	Wrench
	R			H	B	LF	LH	HF	WF					
MCLNR3232P19	●	CNMG CNMM CNMA	1906○○	32	32	170	36	32	40	MSCN63	MP6	CKW6	LS25	HKY40R
MCLNR4040R19	●		1906○○	40	40	200	36	40	50	MSCN63	MP6	CKW6	LS25	HKY40R

* Clamp Torque (N • m) : LS25=8.2

PCBN

External turning — **LL type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12)
Medium	**Medium to Rough**	**Stainless**	
Standard	RP	MM	
(12)	(12)	(12)	

Order Number	Stock		Insert Number		Dimensions (mm)						Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
	R	L			H	B	LF	LH	HF	WF					
PCBNR/L2020K12	●	●	CN○A CN○G CN○M	1204○○	20	20	125	28	20	17	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
PCBNR/L2525M12	●	●		1204○○	25	25	150	25	25	22	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

MCLN type inserts	➤ A100—A106
PCBN type inserts	➤ A100—A106
CBN & PCD inserts	➤ B028—B031, B068

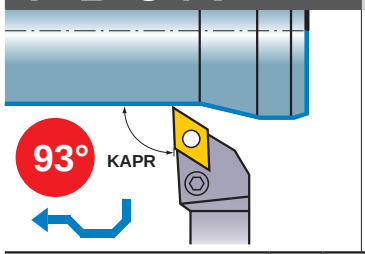
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

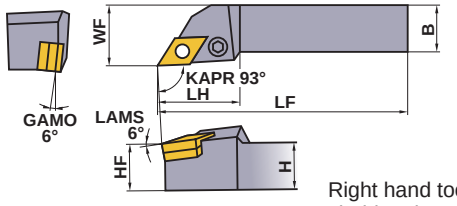
DN INSERTS TOOL HOLDERS

TOOL NEWS

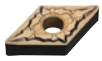
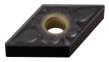
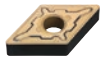
PDJN

External turning, Copying — **LL type**





Right hand tool holder shown.

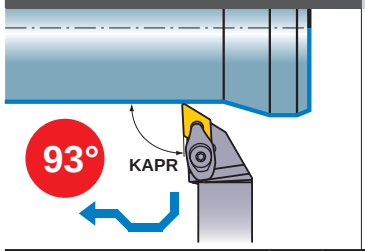
Finish	Light	Medium	Medium
FP	LP	MP	MK
(15)	 (15)	(15)	 (15)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
 (15)	(15)	(15)	(15)

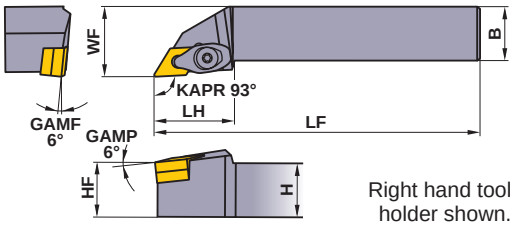
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	⋆2 Shim	Shim Pin	Clamp Lever	⋆1 Clamp Screw	Wrench
PDJNR/L2020K15	●	●	DNMA DNMG DNMM DNMX DNGA DNGG DNGM	1504○○	20	20	125	35	20	25	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R
PDJNR/L2525M15	●	●		1504○○	25	25	150	35	25	32	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R
PDJNR/L3225P15	●	●		1504○○	32	25	170	35	32	32	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

⋆1 Clamp Torque (N • m) : LLCS108=3.3
⋆2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, shim should be ordered separately.

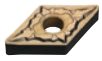
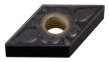
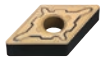
DDJN

External turning, Copying — **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(15)	 (11,15)	(15)	 (11,15)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
 (15)	(15)	(15)	(15)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	⋆2 Shim	Shim Pin	Clamp Bridge	Spring	⋆1 Clamp Screw	Wrench
DDJNR/L1616H11	●	●	DNMG DNGA	1104○○	16	16	100	28	16	20	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DDJNR/L2020K11	●	●		1104○○	20	20	125	28	20	25	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DDJNR/L2525M11	●	●		1104○○	25	25	150	28	25	32	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DDJNR/L3225P11	●	●		1104○○	32	25	170	28	32	32	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DDJNR/L2020K15	●	●	DNMA DNMG DNMM DNMX DNGA DNGG DNGM	1504○○	20	20	125	37	20	25	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
DDJNR/L2525M15	●	●		1504○○	25	25	150	37	25	32	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
DDJNR/L3225P15	●	●		1504○○	32	25	170	37	32	32	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

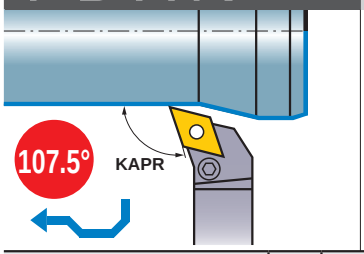
⋆1 Clamp Torque (N • m) : DC0520T=3.5, DC0621T=5.0
⋆2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, shim should be ordered separately.

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

● : Inventory maintained in Japan.

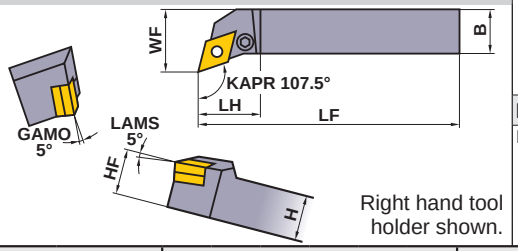
PDJN type inserts	➤ A107—A113
DDJN type inserts	➤ A107—A113
CBN & PCD inserts	➤ B032—B036, B068
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

PDHN

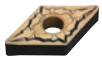
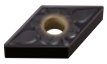
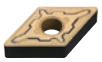


Facing, Copying

L L type



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(15)	(15)	(15)	(15)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
			
(15)	(15)	(15)	(15)

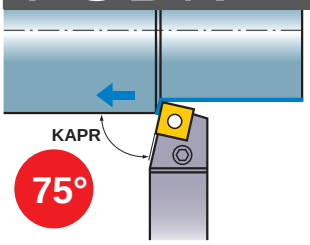
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	⋆2 Shim	Shim Pin	Clamp Lever	⋆1 Clamp Screw	Wrench
PDHNR/L2020K15	●	●	DNMA DNMG	1504○○	20	20	125	34	20	25	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R
PDHNR/L2525M15	●	●	DNMM DNGA	1504○○	25	25	150	34	25	32	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R
PDHNR/L3225P15	●	●	DNGG DNGM	1504○○	32	25	170	34	32	32	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

⋆1 Clamp Torque (N • m) : LLCS108=3.3
⋆2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, shim should be ordered separately.

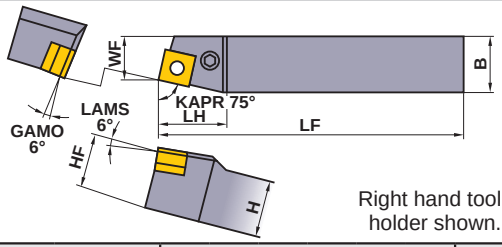
PDHN type inserts ➤ A107—A113
CBN & PCD inserts ➤ B032—B036, B068
RECOMMENDED CUTTING CONDITIONS ➤ A076, B015
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

SN ○○ INSERTS TOOL HOLDERS

PSBN



External turning — **LL type**



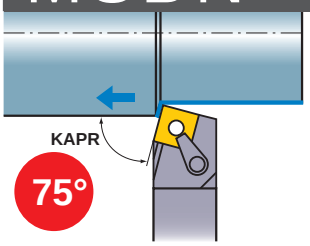
Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12,15,19)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(12,15,19)	(12,15,19)	(09,12)	(12)

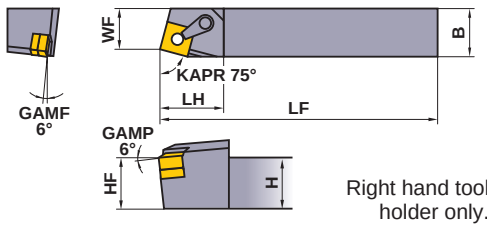
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Lever Spring	Clamp Lever	Clamp Screw *	Wrench
PSBNR/L1212F09	●	●	SNMA SNMG SNMM SNGA SNGG	0903○○	12	12	80	20	12	13	—	—	HLS2	LLCL13S	LLCS105	HKY20R
PSBNR/L1616H09	●	●		0903○○	16	16	100	22	16	13	LLSSN33	LLP23	—	LLCL13	LLCS106	HKY25R
PSBNR/L2020K12	●	●		1204○○	20	20	125	28	20	17	LLSSN42	LLP14	—	LLCL14	LLCS108	HKY30R
PSBNR/L2525M12	●	●		1204○○	25	25	150	25	25	22	LLSSN42	LLP14	—	LLCL14	LLCS108	HKY30R
PSBNR/L2525M15	●	●		1506○○	25	25	150	33	25	22	LLSSN53	LLP15	—	LLCL25	LLCS508	HKY30R
PSBNR/L3232P19	●	●		1906○○	32	32	170	40	32	27	LLSSN63	LLP16	—	LLCL16	LLCS310	HKY40R

* Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS108=3.3, LLCS508=3.3, LLCS310=7.0

MSBN



External turning — **DOUBLE CLAMP type** For heavy cutting



Right hand tool holder only.

Medium	Medium	Medium	Medium to Rough
MH	Standard	MS	RP
(19)	(19)	(19)	(19)
Heavy	**Heavy**	**Heavy**	**M Class**
HZ	HX	HL	Flat Top
(19)	(19)	(19)	(19)

Order Number	Stock R	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Bridge	Clamp Screw *	Wrench
MSBNR3232P19	●	SNMG SNMM SNMA	1906○○	32	32	170	41	32	27	MSSN63	MP6	CKW6	LS25	HKY40R
MSBNR4040R19	●		1906○○	40	40	200	41	40	35	MSSN63	MP6	CKW6	LS25	HKY40R

* Clamp Torque (N • m) : LS25=8.2

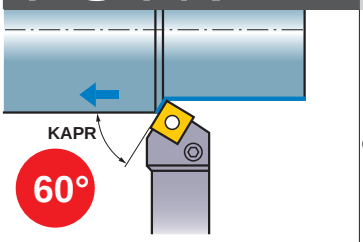
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

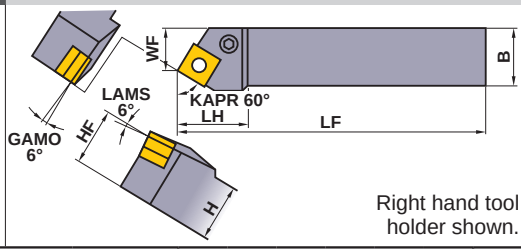
● : Inventory maintained in Japan.

PSBN type inserts	➤ A115—A120
MSBN type inserts	➤ A116—A120
CBN & PCD inserts	➤ B037, B038, B069
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

PSTN

External turning, Chamfering — **LL type**





Right hand tool holder shown.

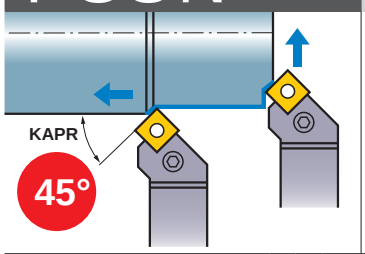
Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(12)	(12)	(09,12)	(12)

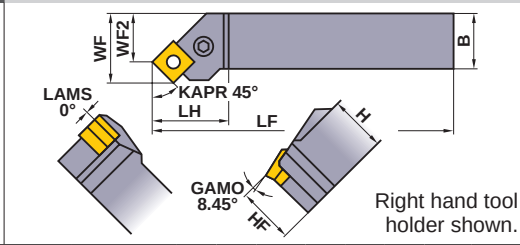
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PSTNR/L1616H09	●	●	SNMA SNMG SNMM SNGA SNGG	0903○○	16	16	100	20	16	13	LLSSN33	LLP23	LLCL13	LLCS106	HKY25R
PSTNR/L2020K12	●	●		1204○○	20	20	125	25	20	17	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R
PSTNR/L2525M12	●	●		1204○○	25	25	150	25	25	22	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R

* Clamp Torque (N • m) : LLCS106=2.2, LLCS108=3.3

PSSN

External turning, Facing, Chamfering — **LL type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12,15,19)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(12,15,19)	(12,15,19)	(09,12)	(12)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	WF2	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PSSNR/L1616H09	●	●	SNMA SNMG SNMM SNGA SNGG	0903○○	16	16	100	22	16	20	14	LLSSN33	LLP23	LLCL13	LLCS106	HKY25R
PSSNR/L2020K12	●	●		1204○○	20	20	125	31	20	25	17	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R
PSSNR/L2525M12	●	●		1204○○	25	25	150	31	25	32	24	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R
PSSNR/L3232P15	●	●		1506○○	32	32	170	34	32	40	29	LLSSN53	LLP15	LLCL25	LLCS508	HKY30R
PSSNR/L3232P19	●	●		1906○○	32	32	170	40	32	40	27	LLSSN63	LLP16	LLCL16	LLCS310	HKY40R

Note 1) When facing or chamfering only and using insert with right or left hand breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

* Clamp Torque (N • m) : LLCS106=2.2, LLCS108=3.3, LLCS508=3.3, LLCS310=7.0

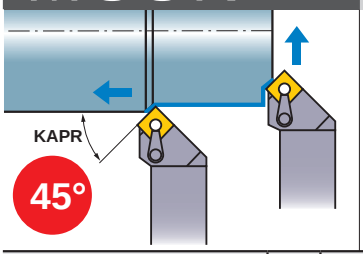
PSTN type inserts	**➤ A115—A120**
PSSN type inserts	**➤ A115—A120**
CBN & PCD inserts	**➤ B037, B038, B069**

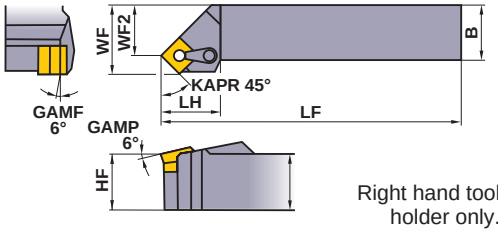
RECOMMENDED CUTTING CONDITIONS	**➤ A076, B015**
SPARE PARTS	**➤ Q001**
TECHNICAL DATA	**➤ R001**

SN ○○ INSERTS TOOL HOLDERS

MSSN

External turning, Facing, Chamfering — DOUBLE CLAMP **type** — For heavy cutting





Right hand tool holder only.

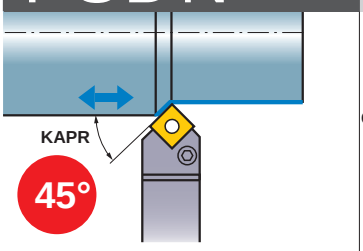
Medium	Medium	Medium	Rough
MH	Standard	MS	RP
(19)	(19)	(19)	(19)
Heavy	**Heavy**	**Heavy**	**M Class**
HZ	HX	HL	Flat Top
(19)	(19)	(19)	(19)

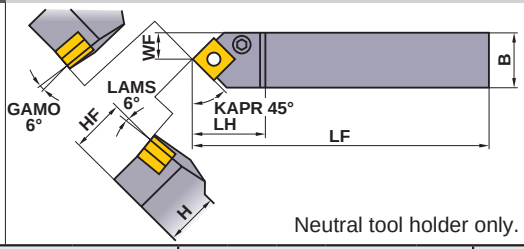
Order Number	Stock	Insert Number		Dimensions (mm)							Shim	Shim Pin	Clamp Bridge	Clamp Screw *	Wrench
	R			H	B	LF	LH	HF	WF	WF2					
MSSNR3232P19	●	SNMG SNMM SNMA	1906○○	32	32	170	44	32	40	27	MSSN63	MP6	CKW6	LS25	HKY40R
MSSNR4040R19	●		1906○○	40	40	200	44	40	50	37	MSSN63	MP6	CKW6	LS25	HKY40R

* Clamp Torque (N • m) : LS25=8.2

PSDN

External turning, Chamfering — **LL type**





Neutral tool holder only.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(12)	(12)	(09,12)	(12)

Order Number	Stock	Insert Number		Dimensions (mm)						Shim	Shim Pin	Lever Spring	Clamp Lever	Clamp Screw *	Wrench
	N			H	B	LF	LH	HF	WF						
PSDNN1212F09	●	SNMA SNMG SNMM SNGA SNGG	0903○○	12	12	80	20	12	6.0	–	–	HLS2	LLCL13S	LLCS105	HKY20R
PSDNN1616H09	●		0903○○	16	16	100	22	16	8.0	LLSSN33	LLP23	–	LLCL13	LLCS106	HKY25R
PSDNN2020K12	●		1204○○	20	20	125	28	20	10.0	LLSSN42	LLP14	–	LLCL14	LLCS108	HKY30R
PSDNN2525M12	●		1204○○	25	25	150	28	25	12.5	LLSSN42	LLP14	–	LLCL14	LLCS108	HKY30R
PSDNN3225P12	●		1204○○	32	25	170	28	32	12.5	LLSSN42	LLP14	–	LLCL14	LLCS108	HKY30R

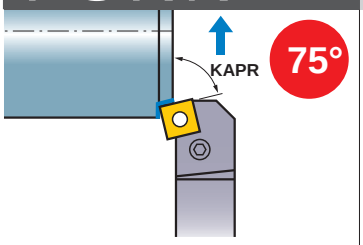
* Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS108=3.3

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

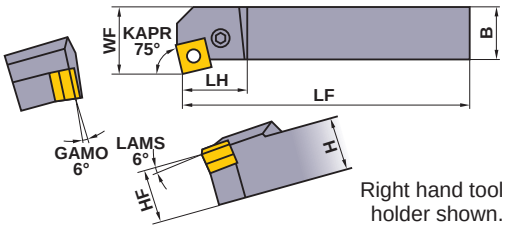
● : Inventory maintained in Japan.

MSSN type inserts	**➤ A116—A120**
PSDN type inserts	**➤ A115—A120**
CBN & PCD inserts	**➤ B037, B038, B069**
RECOMMENDED CUTTING CONDITIONS	**➤ A076, B015**

PSKN



Facing — **L L type**



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(12)	(12)	(12)	(12)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(12)	(12)	(09,12)	(12)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PSKNR/L1616H09	●	●	SNMA SNMG SNMM SNGA SNGG	0903○○	16	16	100	20	16	20	LLSSN33	LLP23	LLCL13	LLCS106	HKY25R
PSKNR/L2020K12	●	●		1204○○	20	20	125	25	20	25	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R
PSKNR/L2525M12	●	●		1204○○	25	25	150	25	25	32	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R

Note 1) When using insert with right or left hand breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

* Clamp Torque (N • m) : LLCS106=2.2, LLCS108=3.3

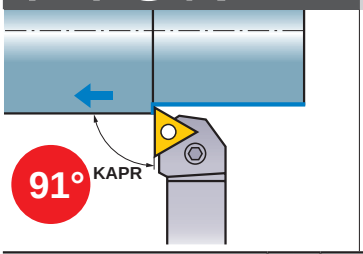
PSKN type inserts	➤ A115—A120
CBN & PCD inserts	➤ B037, B038, B069
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

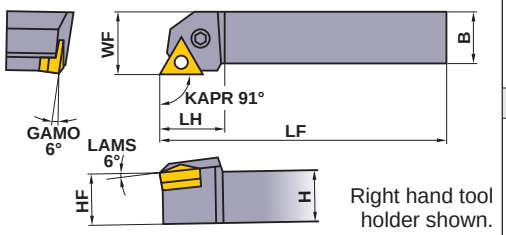
TN ○○ INSERTS TOOL HOLDERS

TOOL NEWS

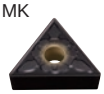
PTGN



External turning — **LL type**



Right hand tool holder shown.

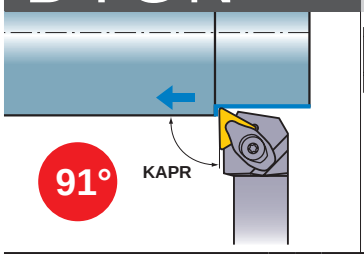
Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16,22)	(16,22)	 (16,22)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(16,22,27)	(16,22)	(11,16,22)	(16)

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF	Shim *2	Shim Pin *2	Lever Spring	Clamp Lever	Clamp Screw *1	Wrench
PTGNR/L1010E11	●	●	TNMA TNMG TNMM TNGA TNGG TNGM	1103○○	10	10	70	17	10	12	–	–	HLS1	LLCL12S	LLCS105	HKY20F
PTGNR/L1212F11	●	●		1103○○	12	12	80	17	12	16	–	–	HLS1	LLCL12S	LLCS105	HKY20F
PTGNR/L1616H16	●	●		1604○○	16	16	100	22	16	20	LLSTN32 (LLSTN33)	LLP13 (LLP23)	–	LLCL13	LLCS106	HKY25R
PTGNR/L2020K16	●	●		1604○○	20	20	125	22	20	25	LLSTN32 (LLSTN33)	LLP13 (LLP23)	–	LLCL13	LLCS106	HKY25R
PTGNR/L2525M16	●	●		1604○○	25	25	150	22	25	32	LLSTN32 (LLSTN33)	LLP13 (LLP23)	–	LLCL13	LLCS206	HKY25R
PTGNR/L2525M22	●	●		2204○○	25	25	150	28	25	32	LLSTN42	LLP14	–	LLCL14	LLCS108	HKY30R
PTGNR/L3225P22	●	●		2204○○	32	25	170	28	32	32	LLSTN42	LLP14	–	LLCL14	LLCS108	HKY30R
PTGNR/L3232P27	●	●		2706○○	32	32	170	35	32	40	LLSTN53	LLP15	–	LLCL25	LLCS508	HKY30R

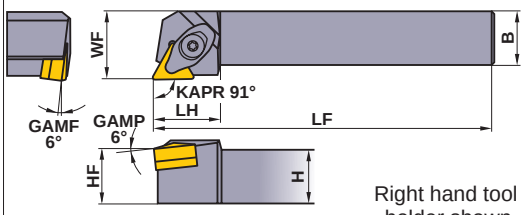
*1 Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS206=2.2, LLCS108=3.3, LLCS508=3.3
PTGNR/L1010E11 • PTGNR/L1212F11 Clamp Torque (N • m) : LLCS105=1.0

*2 Please use shim no. LLSTN33 and shim pin no. LLP23 with 3.18mm thick inserts. When using 3.18mm thick inserts, shim and shim pin should be ordered separately.

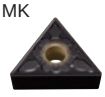
DTGN



External turning — **DOUBLE CLAMP type**



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	 (16)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF	Shim *2	Shim Pin *2	Clamp Bridge	Spring	Clamp Screw *1	Wrench
DTGNR/L1616H16	●	●	TNMA TNMG TNMM TNGA TNGG TNGM	1604○○	16	16	100	25	16	20	LLSTN32 (LLSTN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DTGNR/L2020K16	●	●		1604○○	20	20	125	25	20	25	LLSTN32 (LLSTN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DTGNR/L2525M16	●	●		1604○○	25	25	150	25	25	32	LLSTN32 (LLSTN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F

*1 Clamp Torque (N • m) : DC0520T=3.5

*2 Please use shim no. LLSTN33 with 3.18mm thick inserts. When using 3.18mm thick inserts, shim should be ordered separately.

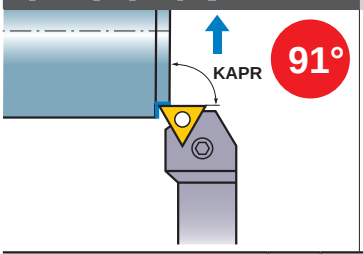
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

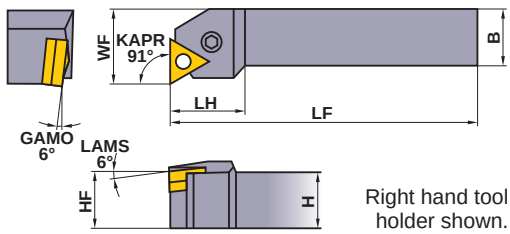
● : Inventory maintained in Japan.

PTGN type inserts	➤ A121–A127
DTGN type inserts	➤ A121–A127
CBN & PCD inserts	➤ B039–B041, B069
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

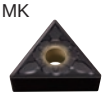
PTFN

Facing — **LL type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(16)	(16,22)	(16,22)	(16,22)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(16,22)	(16,22)	(16,22)	(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim ⋆2	Shim Pin ⋆2	Clamp Lever	Clamp Screw ⋆1	Wrench
PTFNR/L1616H16	●	●	TNMA TNMG TNMM TNGA TNGG TNGM	1604◌◌	16	16	100	22	16	20	LLSTN32 (LLSTN33)	LLP13 (LLP23)	LLCL13	LLCS106	HKY25R
PTFNR/L2020K16	●	●		1604◌◌	20	20	125	22	20	25	LLSTN32 (LLSTN33)	LLP13 (LLP23)	LLCL13	LLCS106	HKY25R
PTFNR/L2525M16	●	●		1604◌◌	25	25	150	22	25	32	LLSTN32 (LLSTN33)	LLP13 (LLP23)	LLCL13	LLCS206	HKY25R
PTFNR/L2525M22	●	●		2204◌◌	25	25	150	28	25	32	LLSTN42	LLP14	LLCL14	LLCS108	HKY30R

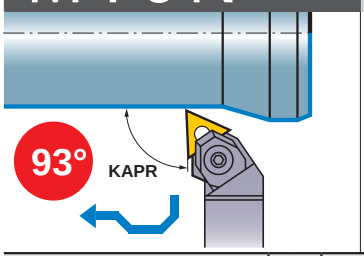
Note 1) When using insert with right or left hand breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

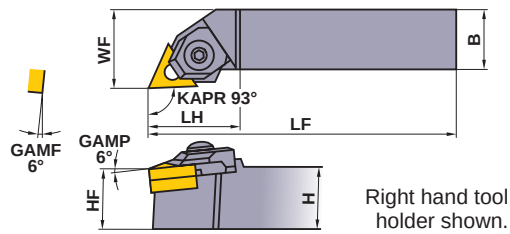
⋆1 Clamp Torque (N • m) : LLCS106=2.2, LLCS206=2.2, LLCS108=3.3

⋆2 Please use shim no. LLSTN33 and shim pin no. LLP23 with 3.18mm thick inserts. When using 3.18mm thick inserts, shim should be ordered separately.

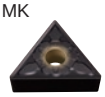
MTJN

External turning, Copying — **WP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(16)	(16,22)	(16,22)	(16,22)
Medium to Rough	**Stainless**	**G Class**	**CBN**
RP	MM	R/L	
(16,22)	(16,22)	(16,22)	(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Bridge	Side Lock Plate	Spring	Clamp Screw ⋆1	Wrench ⋆2
MTJNR/L2020K16N	●	●	TN◌A TN◌G TN◌M TNMX	1604◌◌	20	20	125	31	20	25	WPSTN33	CCP33	CCK13	CPT13	MES2	SLCS105	HKY25R HKY40R
MTJNR/L2525M16N	●	●		1604◌◌	25	25	150	31	25	32	WPSTN33	CCP33	CCK13	CPT13	MES2	SLCS105	HKY25R HKY40R
MTJNR/L2525M22N	●	●		2204◌◌	25	25	150	38	25	32	WPSTN43	CCP34	CCK14	CPT14	MES3	SLCS106	HKY30R HKY40R

⋆1 Clamp Torque (N • m) : SLCS105=7.0, SLCS106=7.0

⋆2 HKY25R, HKY30R Wrench for Shim Pin, HKY40R Wrench for Clamp Screw.

PTFN type inserts	➤ A121—A127
MTJN type inserts	➤ A121—A127
CBN & PCD inserts	➤ B039—B041, B069
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

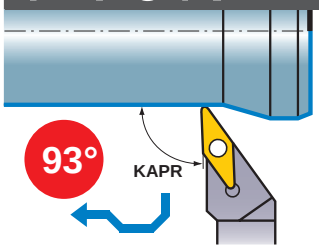
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

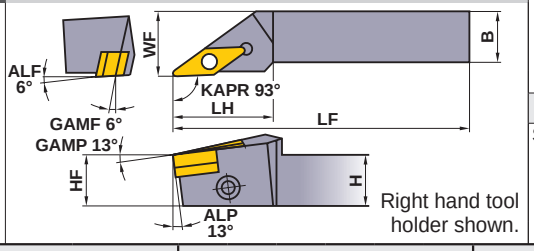
VN INSERTS TOOL HOLDERS

TOOL NEWS

PVJN

External turning, Copying — **MP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

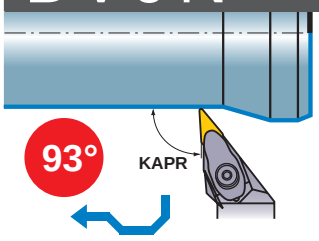
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim *2	Lock Pin	Lock Screw *1	Stop Ring	Wrench
PVJNR/L2020K16	●	●	VN◯A VN◯G VN◯M	1604◯◯	20	20	125	32	20	25	PV322 (PV321) (PV323)	P11S	HSP05008C	E03	HKY25R
PVJNR/L2525M16	●	●		1604◯◯	25	25	150	38	25	32		P11S	HSP05008C	E03	HKY25R

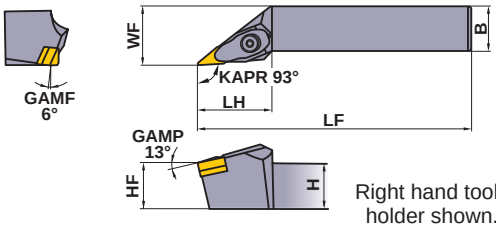
*1 Clamp Torque (N • m) : HSP05008C=2.5

*2 Please use shim no. PV321 and PV323 with RE0.4mm and RE1.2mm thick inserts. When using inserts, shim should be ordered separately.

DVJN

External turning, Copying — **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
DVJNR/L2020K16	●	●	VN◯A VN◯G VN◯M	1604◯◯	20	20	125	41	20	25	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F
DVJNR/L2525M16	●	●		1604◯◯	25	25	150	41	25	32	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F

* Clamp Torque (N • m) : DC0520T=3.5

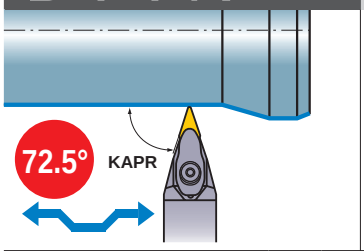
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

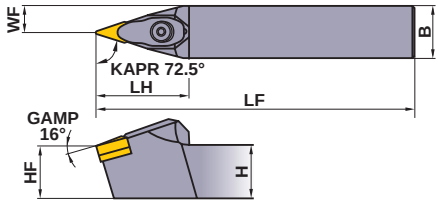
● : Inventory maintained in Japan.

PVJN type inserts	➤ A128—A131
DVJN type inserts	➤ A128—A131
CBN & PCD inserts	➤ B042, B043, B070
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015

DVVN

External turning, Copying DOUBLE CLAMP **type**





Neutral tool holder only.

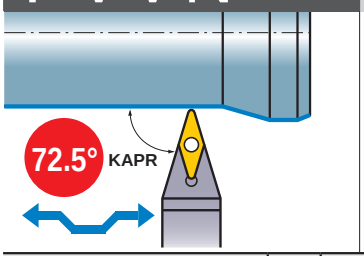
Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

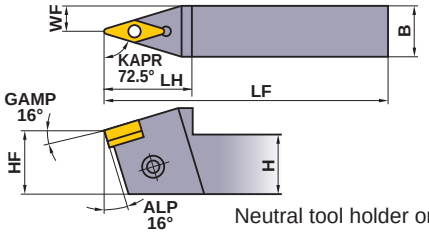
Order Number	Stock	Insert Number		Dimensions (mm)										*	
	N			H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
DVVNN2020K16	●	VN◯A VN◯G VN◯M	1604◯◯	20	20	125	44	20	10	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F
DVVNN2525M16	●		1604◯◯	25	25	150	44	25	12.5	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F

* Clamp Torque (N • m) : DC0520T=3.5

PVVN

External turning, Copying MP **type**





Neutral tool holder only.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock	Insert Number		Dimensions (mm)						*2		*1		
	N			H	B	LF	LH	HF	WF	Shim	Lock Pin	Lock Screw	Stop Ring	Wrench
PVVNN2020K16	●	VN◯A VN◯G VN◯M	1604◯◯	20	20	125	38	20	10	PV322 (PV321) (PV323)	P11S	HSP05008C	E03	HKY25R
PVVNN2525M16	●		1604◯◯	25	25	150	38	25	12.5		P11S	HSP05008C	E03	HKY25R

*1 Clamp Torque (N • m) : HSP05008C=2.5
*2 Please use shim no. PV321 and PV323 with RE0.4mm and RE1.2mm thick inserts. When using inserts, shim should be ordered separately.

DVVN type inserts	➤ A128–A131
PVVN type inserts	➤ A128–A131
CBN & PCD inserts	➤ B042, B043, B070

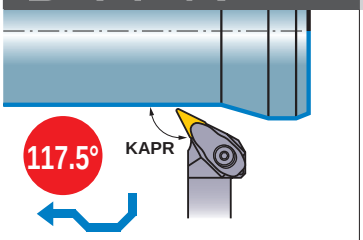
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

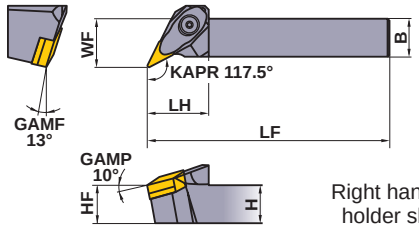
VN ○○ INSERTS TOOL HOLDERS

TOOL NEWS

DVPN

Facing, Copying — DOUBLE CLAMP **type**





Right hand tool holder shown.

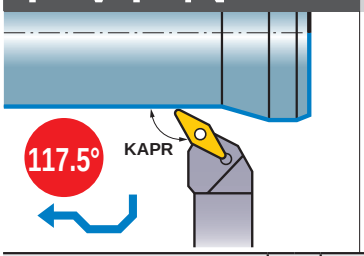
Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

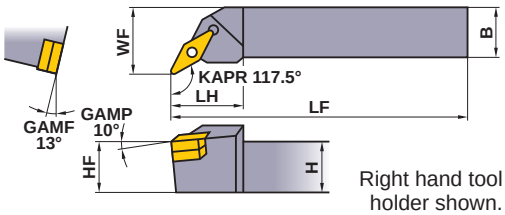
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
DVPNR/L2020K16	●	●	VN○A VN○G VN○M	1604○○	20	20	125	32	20	25	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F
DVPNR/L2525M16	●	●		1604○○	25	25	150	32	25	32	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F

* Clamp Torque (N • m) : DC0520T=3.5

PVPN

Facing, Copying — MP **type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G Class**	**CBN**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim *2	Lock Pin	Lock Screw *1	Stop Ring	Wrench
PVPNR/L2020K16	●	●	VN○A VN○G VN○M	1604○○	20	20	125	32	20	25	PV322 (PV321) (PV323)	P11S	HSP05008C	E03	HKY25R
PVPNR/L2525M16	●	●		1604○○	25	25	150	32	25	32		P11S	HSP05008C	E03	HKY25R

*1 Clamp Torque (N • m) : HSP05008C=2.5
*2 Please use shim no. PV321 and PV323 with RE0.4mm and RE1.2mm thick inserts. When using inserts, shim should be ordered separately.

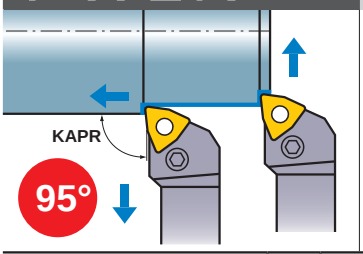
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

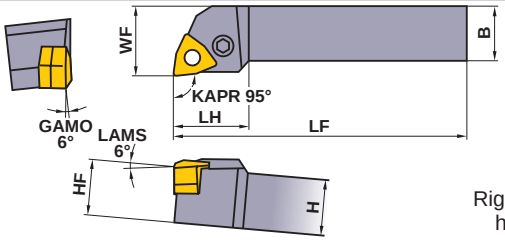
● : **Inventory maintained in Japan.**

DVPN type inserts	➤ **A128—A131**
PVPN type inserts	➤ **A128—A131**
CBN & PCD inserts	➤ **B042, B043, B070**
RECOMMENDED CUTTING CONDITIONS	➤ **A076, B015**

PWLN

External turning, Facing — **LL type**





Right hand tool holder shown.

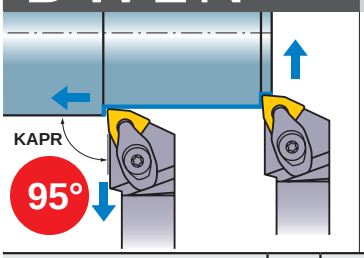
Light	Medium
LP (06)	MP (06)
Stainless	
MM (06)	

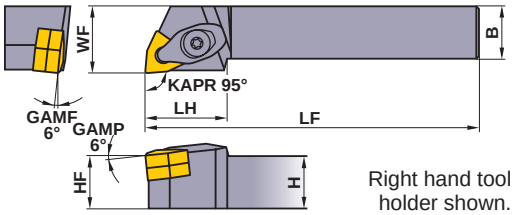
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim *2	Shim Pin	Clamp Lever	Clamp Screw *1	Wrench
PWLNR/L1616H06	●	●	WNMG	06T3○○	16	16	100	22	16	20	LLSWN3T3 (LLSWN32)	LLP13	LLCL13	LLCS106	HKY25R
PWLNR/L2020K06	●	●		06T3○○	20	20	125	22	20	25	LLSWN3T3 (LLSWN32)	LLP13	LLCL13	LLCS106	HKY25R
PWLNR/L2525M06	●	●		06T3○○	25	25	150	25	25	32	LLSWN3T3 (LLSWN32)	LLP13	LLCL13	LLCS106	HKY25R

*1 Clamp Torque (N • m) : LLCS106=2.2
*2 Please use shim no. LLSWN32 with 4.76mm thick inserts. When using inserts, shim should be ordered separately.

DWLN

External turning, Facing — **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP (08)	LP (06,08)	MP (06,08)	MK (08)
Medium	**Medium to Rough**	**Stainless**	**CBN**
Standard (08)	RP (08)	MM (06,08)	(08)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim *2	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench
DWLNR/L1616H06	●	●	WNMA WNMG WNGA	06T3○○	16	16	100	25	16	20	LLSWN3T3 (LLSWN32)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DWLNR/L2020K06	●	●		06T3○○	20	20	125	25	20	25	LLSWN3T3 (LLSWN32)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DWLNR/L2525M06	●	●		06T3○○	25	25	150	25	25	32	LLSWN3T3 (LLSWN32)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DWLNR/L2020K08	●	●		0804○○	20	20	125	31	20	25	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DWLNR/L2525M08	●	●		0804○○	25	25	150	31	25	32	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DWLNR/L3225P08	●	●		0804○○	32	25	170	31	32	32	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

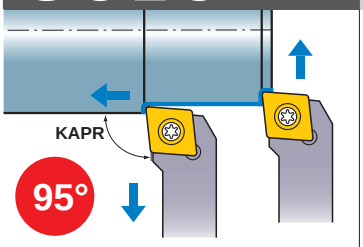
*1 Clamp Torque (N • m) : DC0520T=3.5, DC0621T=5.0
*2 Please use shim no. LLSWN32 with 4.76mm thick inserts. When using inserts, shim should be ordered separately.

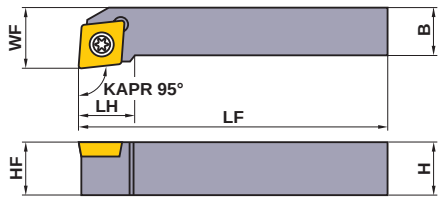
PWLN type inserts	➤ A132—A135
DWLN type inserts	➤ A132—A136
CBN inserts	➤ B044
RECOMMENDED CUTTING CONDITIONS	➤ A076, B015
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

CC ○○ INSERTS TOOL HOLDERS

SCLC

External turning, Facing SP type





Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(06,09)	(06,09)	(06,09,12)	(06,09)
Stainless	**Stainless**	**Flat top**	**PCD/CBN**
LM	MM		
(06,09)	(06,09,12)	(06,09,12)	(06,09,12)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	⋆1 Clamp Screw	Wrench
SCLCR/L0808D06	●	●	CC○B CC○H ⋆2 CC○T CC○W	0602○○	8	8	60	8.9	8	10	TS25	TKY08F
SCLCR/L1010E06	●	●		0602○○	10	10	70	8.9	10	12	TS25	TKY08F
SCLCR/L1212F09	●	●		09T3○○	12	12	80	13.6	12	16	TS43	TKY15F
SCLCR/L1616H12	●	●		1204○○	16	16	100	16.7	16	20	TS5	TKY25F

⋆1 Clamp Torque (N • m) : TS25=1.0, TS43=3.5, TS5=7.5
⋆2 When using CCGH and CCMH, it is recommended to use TS253 clamp screw.

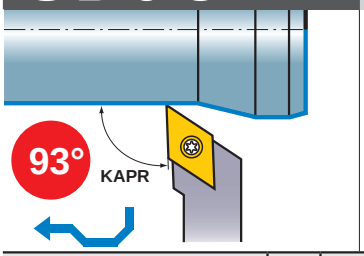
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

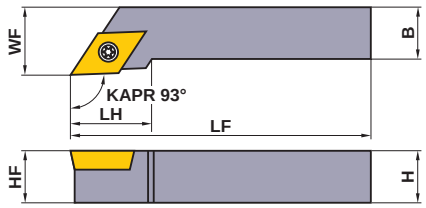
● : **Inventory maintained in Japan.**

SCLC type inserts	**➤ A140—A147**
CBN & PCD inserts	**➤ B049—B052, B072**
RECOMMENDED CUTTING CONDITIONS	**➤ A090, B015**

SDJC

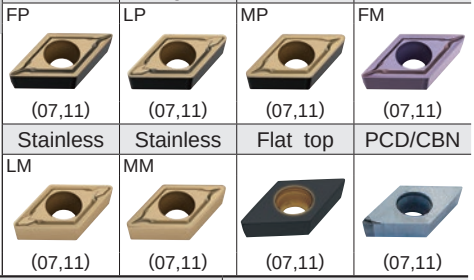
External turning, Copying — **SP type**





Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(07,11)	(07,11)	(07,11)	(07,11)
Stainless	Stainless	Flat top	PCD/CBN
LM	MM		
(07,11)	(07,11)	(07,11)	(07,11)

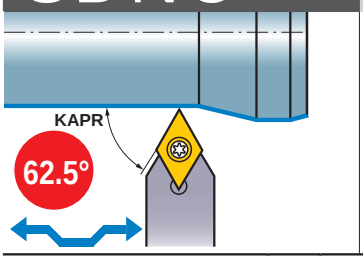


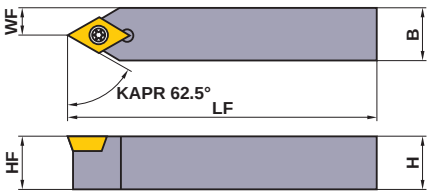
Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SDJCR/L1010E07	●	●	DCET DCGT DCMW DCMT DCGW	0702○○	10	10	70	12	10	12	TS25	TKY08F
SDJCR/L1212F11	●	●		11T3○○	12	12	80	18	12	16	TS43	TKY15F
SDJCR/L1616H11	●	●		11T3○○	16	16	100	18	16	20	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

SDNC

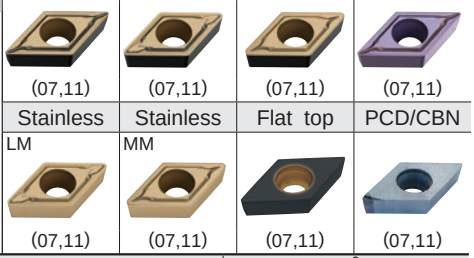
External turning, Copying — **SP type**





Neutral tool holder only.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(07,11)	(07,11)	(07,11)	(07,11)
Stainless	Stainless	Flat top	PCD/CBN
LM	MM		
(07,11)	(07,11)	(07,11)	(07,11)



Order Number	Stock N	Insert Number		H	B	LF	HF	WF	* Clamp Screw	Wrench
SDNCN0808D07	●	DCET DCGT DCMW DCMT DCGW	0702○○	8	8	60	8	4	TS25	TKY08F
SDNCN1010E07	●		0702○○	10	10	70	10	5	TS25	TKY08F
SDNCN1212F11	●		11T3○○	12	12	80	12	6	TS43	TKY15F
SDNCN1616H11	●		11T3○○	16	16	100	16	8	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

SDJC type inserts	➤ A149—A154
SDNC type inserts	➤ A149—A154
CBN & PCD inserts	➤ B054—B056, B073

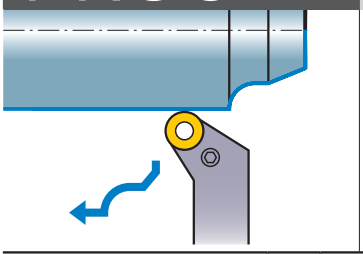
RECOMMENDED CUTTING CONDITIONS	➤ A090, B015
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

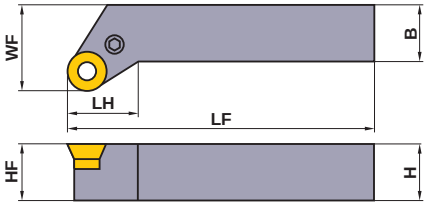
RC INSERTS TOOL HOLDERS

PRGC

External turning, Facing, Copying

L L type





Right hand tool holder shown.

Medium

(10,12,16,20)

Heavy Cutting

RR

(16,20)

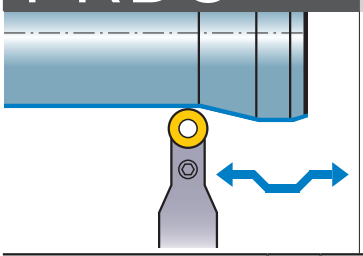
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PRGCR/L2525M10	●	●	RCMX	1003M0	25	25	150	16.7	25	32	LLSRN103	LLP13	LLCL110	LLCS205	HKY20R
PRGCR/L2525M12	●	●		1204M0	25	25	150	17.5	25	32	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R
PRGCR/L2525M16	●	●		1606M0	25	25	150	19.9	25	32	LLSRN164	LLP24	LLCL116	LLCS306	HKY25R
PRGCR/L3232P20	●	●		2006M0	32	32	170	23.8	32	40	LLSRN204	LLP15	LLCL120	LLCS508	HKY30R

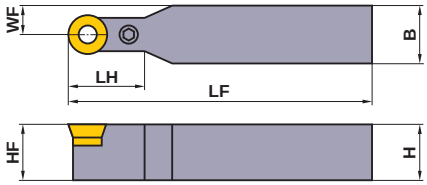
* Clamp Torque (N • m) : LLCS205=1.5, LLCS106=2.2, LLCS306=2.2, LLCS508=3.3

PRDC

External turning, Copying

L L type





Neutral tool holder only.

Medium

(10,12,16,20)

Heavy Cutting

RR

(16,20)

Order Number	Stock N	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
PRDCN2020K10	●	RCMX	1003M0	20	20	125	23	20	10.0	LLSRN103	LLP13	LLCL110	LLCS205	HKY20R
PRDCN2525M12	●		1204M0	25	25	150	24	25	12.5	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R
PRDCN3225P12	●		1204M0	32	25	170	24	32	12.5	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R
PRDCN3225P16	●		1606M0	32	25	170	28	32	12.5	LLSRN164	LLP24	LLCL116	LLCS306	HKY25R
PRDCN3232P20	●		2006M0	32	32	170	33	32	16.0	LLSRN204	LLP15	LLCL120	LLCS508	HKY30R

* Clamp Torque (N • m) : LLCS205=1.5, LLCS106=2.2, LLCS306=2.2, LLCS508=3.3

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

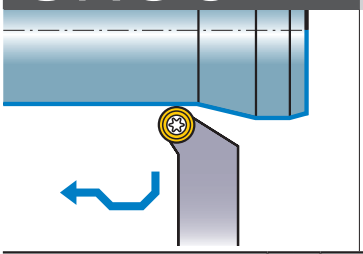
● : Inventory maintained in Japan.

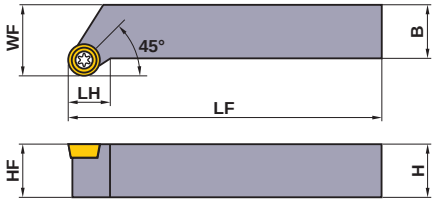
PRGC type inserts	**➤ A156**
PRDC type inserts	**➤ A156**
RECOMMENDED CUTTING CONDITIONS	**➤ A090**

SRGC

External turning, Facing, Copying

SP type

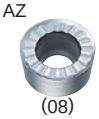




Right hand tool holder shown.

Medium – Finish Cutting

AZ



(08)

Medium

Standard

(06,08)

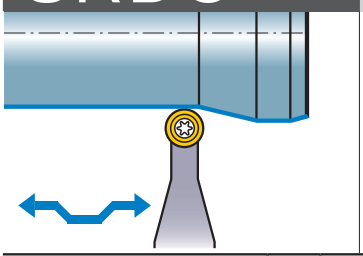
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SRGCR/L1616H06	●	●	RCMT	0602○○	16	16	100	10	16	20	TS25	TKY08F
SRGCR/L1616H08	●	●	RCGT	0803○○	16	16	100	14.5	16	22	TS3	TKY08F

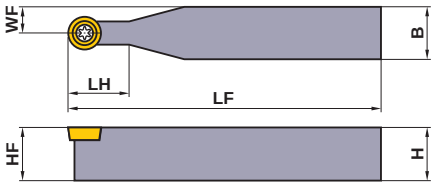
* Clamp Torque (N • m) : TS25=1.0, TS3=1.0

SRDC

External turning, Copying

SP type

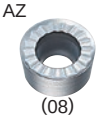




Neutral tool holder only.

Medium – Finish Cutting

AZ



(08)

Medium

Standard

(06,08)

Order Number	Stock N	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SRDCN1616H06	●	RCMT	0602○○	16	16	100	12	16	8	TS25	TKY08F
SRDCN1616H08	●	RCGT	0803○○	16	16	100	16	16	8	TS3	TKY08F

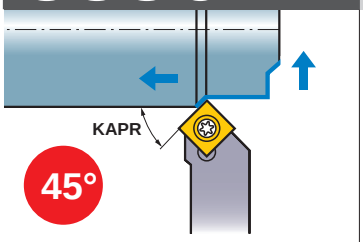
* Clamp Torque (N • m) : TS25=1.0, TS3=1.0

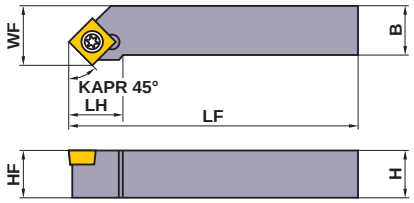
SRGC type inserts	➤ A156
SRDC type inserts	➤ A156
RECOMMENDED CUTTING CONDITIONS	➤ A090
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

SC ○○INSERTS TOOL HOLDERS

SSSC

External turning, Facing, Chamfering — **SP type**





Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(09)	(09)	(09)	(09)
Stainless	**Stainless**	**Medium**	**Flat top**
LM	MM	Standard	
(09)	(09)	(09)	(09)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SSSCR/L1212F09	●	●	SCMW SCMT	09T3○○	12	12	80	15.2	12	13	TS43	TKY15F
SSSCR/L1616H09	●	●		09T3○○	16	16	100	15.2	16	17	TS43	TKY15F

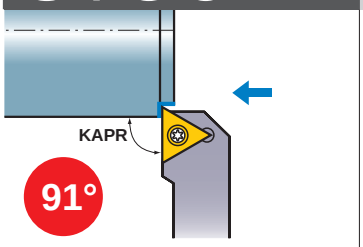
* Clamp Torque (N • m) : TS43=3.5

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

● : Inventory maintained in Japan.

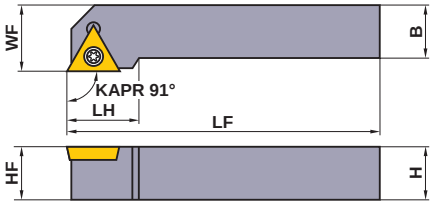
SSSC type inserts ➤ **A157, A158**
RECOMMENDED CUTTING CONDITIONS ➤ **A090**

STGC



External turning

SP type



Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(11,16)	(11,16)	(11,13,16)	(11,16)
Stainless	**Stainless**	**Flat top**	**PCD/CBN**
LM	MM		
(11,16)	(11,13,16)	(11,13,16)	(11,13,16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
STGCR/L1010E11	●	●	TCGT TCMT TCGW TCMW	1102○○	10	10	70	13.5	10	12	TS25	TKY08F
STGCR/L1212F13	●	●		1303○○	12	12	80	17.6	12	16	TS3	TKY08F
STGCR/L1616H16	●	●		16T3○○	16	16	100	20.7	16	20	TS43	TKY15F

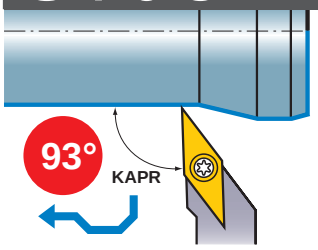
* Clamp Torque (N • m) : TS25=1.0, TS3=1.0, TS43=3.5

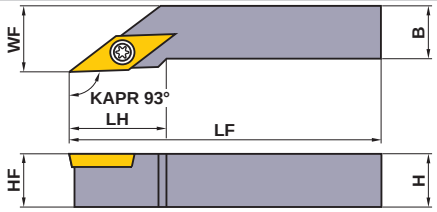
STGC type inserts ➤ A160—A162
CBN & PCD inserts ➤ B057, B074
RECOMMENDED CUTTING CONDITIONS ➤ A090, B015
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

VC ○○ INSERTS TOOL HOLDERS

SVJC

External turning, Copying — **SP type**





Right hand tool holder shown.

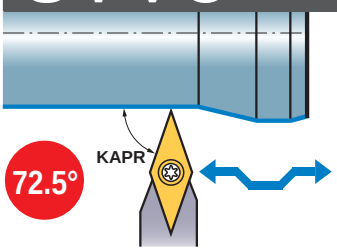
Finish	Light	Medium	Stainless
FP	LP	MP	FM
(11,16)	(11,16)	(16)	(11,16)
Stainless	**Stainless**	**Medium**	**Flat top**
LM	MM	Standard	
(11,16)	(16)	(11,16)	(11,16)

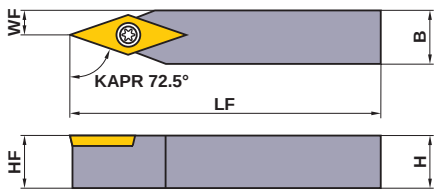
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Screw *	Wrench ① ②
SVJCR/L1010E11	●	●	VCGT VCGW VCMT VCMW	1103○○	10	10	70	17	10	12	–	–	TS25	①TKY08F
SVJCR/L1616H16	●	●		1604○○	16	16	100	25	16	20	–	–	TS43	①TKY15F
SVJCR/L2020K16	●	●		1604○○	20	20	125	40	20	25	SPSVN32	BCP141	TS44	②TKY15R
SVJCR/L2525M16	●	●		1604○○	25	25	150	40	25	32	SPSVN32	BCP141	TS44	②TKY15R

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5, TS44=3.5

SVVC

External turning, Copying — **SP type**





Neutral tool holder only.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(16)	(16)	(16)	(16)
Stainless	**Stainless**	**Medium**	**Flat top**
LM	MM	Standard	
(16)	(16)	(16)	(16)

Order Number	Stock N	Insert Number		Dimensions (mm) H	B	LF	HF	WF	Shim	Shim Pin	Clamp Screw *	Wrench ① ②
SVVCN1616H16	●	VCGT VCGW VCMT VCMW	1604○○	16	16	100	16	8	–	–	TS43	①TKY15F
SVVCN2020K16	●		1604○○	20	20	125	20	10	SPSVN32	BCP141	TS44	②TKY15R
SVVCN2525M16	●		1604○○	25	25	150	25	12.5	SPSVN32	BCP141	TS44	②TKY15R

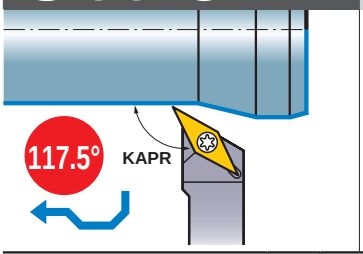
* Clamp Torque (N • m) : TS43=3.5, TS44=3.5

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

● : Inventory maintained in Japan.

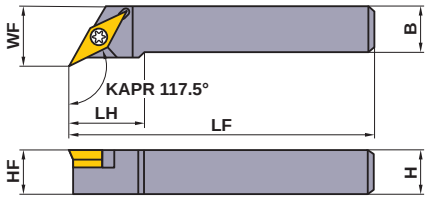
SVJC type inserts	**➤ A170—A172**
SVVC type inserts	**➤ A170—A172**
CBN & PCD inserts	**➤ B062, B077**
RECOMMENDED CUTTING CONDITIONS	**➤ A090, B015**

SVPC

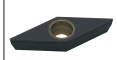


Facing, Copying

SP type



Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP	LP	MP	FM
(16)	(16)	(16)	(16)
Stainless	**Stainless**	**Medium**	**Flat top**
LM	MM	Standard	
			
(16)	(16)	(16)	(16)

Order Number	Stock		Insert Number		Dimensions (mm)								*	
	R	L			H	B	LF	LH	HF	WF	Shim	Shim Pin	Clamp Screw	Wrench
SVPCR/L2020K16	●	●	VCGT VCGW	1604○○	20	20	125	30	20	25	SPSVN32	BCP141	TS44	TKY15R
SVPCR/L2525M16	●	●	VCMT VCMW	1604○○	25	25	150	30	25	32	SPSVN32	BCP141	TS44	TKY15R

* Clamp Torque (N • m) : TS44=3.5

SVPC type inserts	➢ A170—A172
CBN inserts	➢ B062, B077
RECOMMENDED CUTTING CONDITIONS	➢ A090, B015

SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

XC ○○INSERTS TOOL HOLDERS

TOOL NEWS

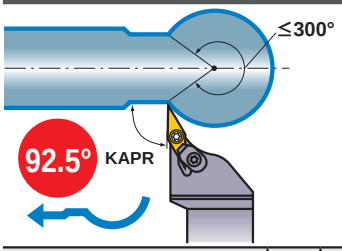
SXZC

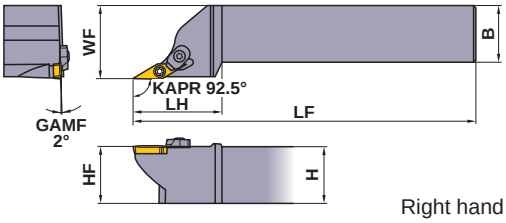
External turning, Copying

Profile Holder

Finish
SVX

(15)



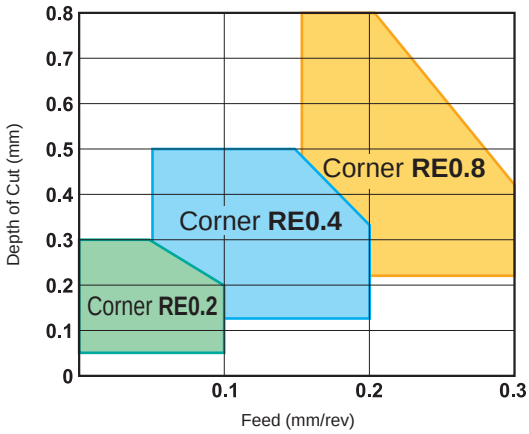


Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF	Clamp Screw *	Clamp Bridge	Clamp Bridge Screw *	Spring	Insert Wrench	Wrench for clamp bridge
SXZCR/L1616H15	●	●	XCMT	1503○○-SVX	16	16	100	35	16	20	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
SXZCR/L2020K15	●	●	XCMT	1503○○-SVX	20	20	125	35	20	25	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
SXZCR/L2525M15	●	●	XCMT	1503○○-SVX	25	25	150	40	25	32	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F

* Clamp Torque (N • m) : TS255=1.0, AJS3010T10=2.5

■ Applicable range



RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UE6020**	250 (150−350)
	Carbon Steel, Alloy Steel	**150HB−250HB**	**UE6020**	175 (100−250)
M	Stainless Steel	≤200HB	**VP15TF**	100 (70−120)

The above cutting conditions are general guidelines.
Adjustments maybe necessary depending on machine rigidity, workpiece geometry and clamping.

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

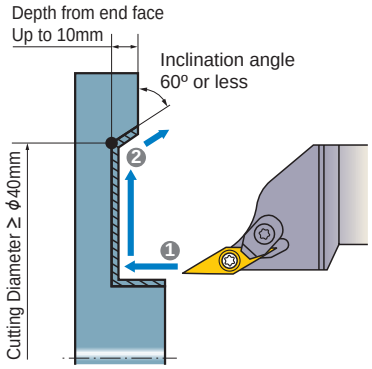
● : Inventory maintained in Japan.

SXZC type inserts ➤ A178

NOTE

Notes when end face copying

Pay special attention to the following when face copying.



Machining of an outer diameter (Step ①)

- To prevent burr formation, the depth of cut should be below half the nose radius.

Machining of an inclination (Step ②)

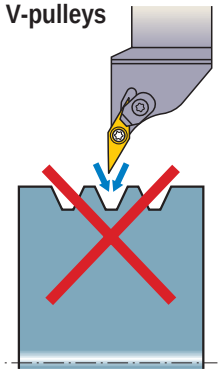
- To reduce the contact length of chips, the depth of cut should be below half the nose radius.
- To prevent interference between the tool and the workpiece, the cutting diameter should be 40mm or larger, inclination angle 60° or less and depth from the end face up to 10mm.

When changing inserts

- When indexing the inserts, it is recommended to preset the cutting edge position to maintain machining accuracy.

Not possible

●Machining of V-pulleys

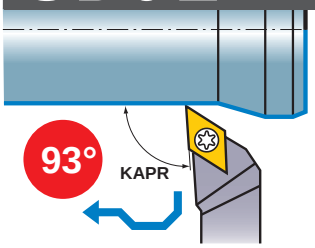


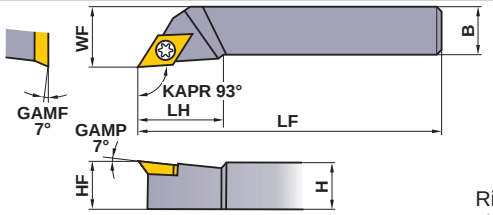
When machining V-pulleys, use a VNMG insert.

DE INSERTS TOOL HOLDERS

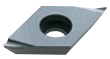
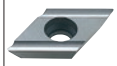
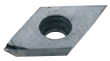
SDJE

External turning, Copying — **AL type**





Right hand tool holder shown.

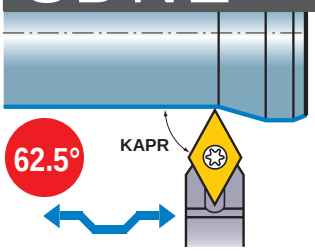
Finish	Medium
R/L-F  (15)	R/L  (15)
PCD	
R/L-F  (15)	

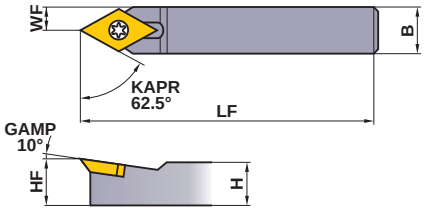
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SDJER/L1616H15	●	●	DEGX	1504○○	16	16	100	27	16	20	CS451190T	TKY20F
SDJER/L2020K15	●	●		1504○○	20	20	125	35	20	25	CS451190T	TKY20F
SDJER/L2525M15	●	●		1504○○	25	25	150	35	25	32	CS451190T	TKY20F

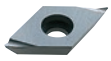
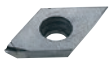
* Clamp Torque (N • m) : CS451190T=5.0

SDNE

External turning, Copying — **AL type**





Finish	Medium
R/L-F  (15)	R/L (15)
PCD	
R/L-F  (15)	

Order Number	Stock	Insert Number		Dimensions (mm) H	B	LF	HF	WF	* Clamp Screw	Wrench
SDNEN1616H15	●	DEGX	1504○○	16	16	100	16	8	CS451190T	TKY20F
SDNEN2020K15	●		1504○○	20	20	125	20	10	CS451190T	TKY20F
SDNEN2525M15	●		1504○○	25	25	150	25	12.5	CS451190T	TKY20F

* Clamp Torque (N • m) : CS451190T=5.0

RECOMMENDED CUTTING CONDITIONS

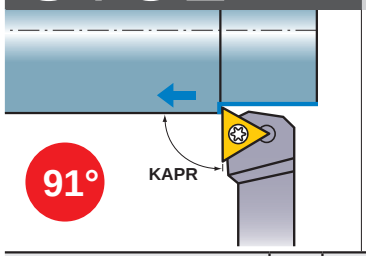
	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
N	Aluminium Alloy	**HTi10**	400	0.05−0.3	0.2−3.0
		MD220	800	0.05−0.3	0.2−0.5

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

● : Inventory maintained in Japan.

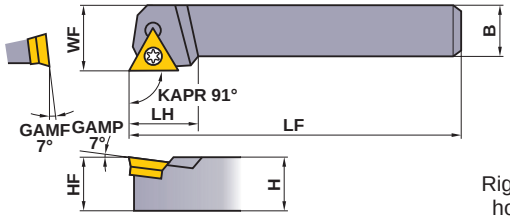
SDJE type inserts ➤ A155
SDNE type inserts ➤ A155
PCD inserts ➤ B079

STGE



External turning

AL type



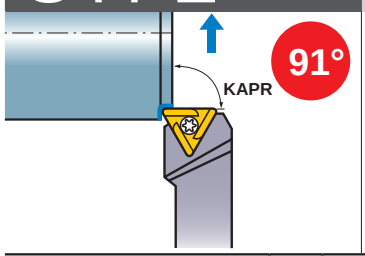
Right hand tool holder shown.

Medium	PCD
R/L (16)	R/L (16)
PCD (16)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
STGER/L1616H16	●	●	TEGX	1603○○	16	16	100	22	16	20	FC400890T	TKY10F
STGER/L2020K16	●	●		1603○○	20	20	125	22	20	25	FC400890T	TKY10F
STGER/L2525M16	●	●		1603○○	25	25	150	22	25	32	FC400890T	TKY10F

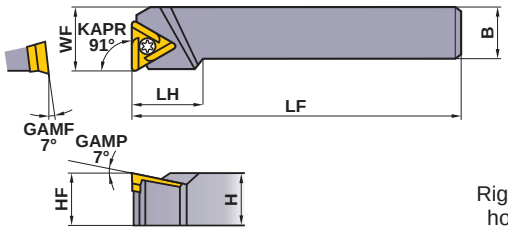
* Clamp Torque (N • m) : FC400890T=2.5

STFE



Facing

AL type



Right hand tool holder shown.

Medium	PCD
R/L (16)	R/L (16)
PCD (16)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
STFER/L1616H16	●	●	TEGX	1603○○	16	16	100	22	16	20	FC400890T	TKY10F
STFER/L2020K16	●	●		1603○○	20	20	125	22	20	25	FC400890T	TKY10F
STFER/L2525M16	●	●		1603○○	25	25	150	22	25	32	FC400890T	TKY10F

Note 1) When using insert with right or left hand breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

* Clamp Torque (N • m) : FC400890T=2.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
N	Aluminium Alloy	**HTi10**	400	0.05−0.3	0.2−3.0
		MD220	800	0.05−0.3	0.2−0.5

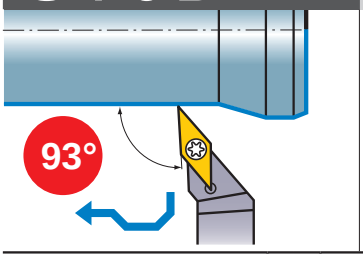
STGE type inserts ➤ **A163**
STFE type inserts ➤ **A163**
PCD inserts ➤ **B079**
SPARE PARTS ➤ **Q001**
TECHNICAL DATA ➤ **R001**

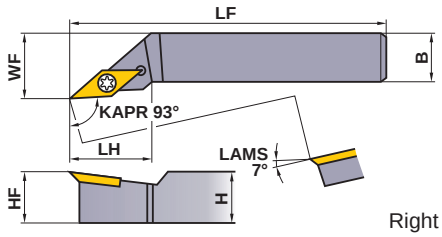
VD○○ INSERTS TOOL HOLDERS

SVJD

External turning, Copying

AL type





Right hand tool holder shown.

Finish

R/L

(16)

PCD

R/L-F

(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HF	WF	* Clamp Screw	Wrench
SVJDR/L1616H16	●	●	VDGX	1603○○	16	16	100	30	16	20	FC400890T	TKY10F
SVJDR/L2020K16	●	●		1603○○	20	20	125	30	20	25	FC400890T	TKY10F
SVJDR/L2525M16	●	●		1603○○	25	25	150	30	25	32	FC400890T	TKY10F

* Clamp Torque (N • m) : FC400890T=2.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
N	Aluminium Alloy	**HTi10**	400	0.05−0.3	0.2−3.0
		MD220	800	0.05−0.3	0.2−0.5

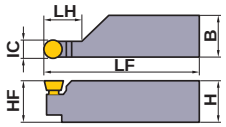
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

● : Inventory maintained in Japan.
▲ : Inventory maintained in Japan. To be replaced by new products.

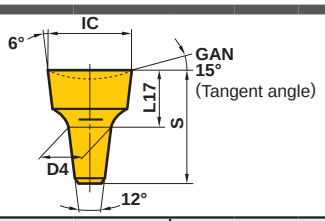
SVJD type inserts ➢ A173
PCD inserts ➢ B080

TL HOLDER

HOLDER

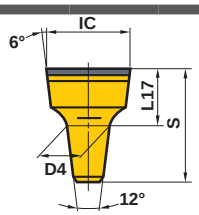
Geometry	Revised order number	Conventional order number	Stock	Insert Number	Dimensions (mm)					
					IC	H	B	HF	LF	LH
TLHR (External turning, Copying) 	**TLHR2020K5**	TLHR2020K5	●	RTG05A	5	20	20	20	125	16
	TLHR2020K6	TLHR2020K6	●	RTG06A	6	20	20	20	125	16
	TLHR2525M7	TLHR2525M7	●	RTG07A	7	25	25	25	150	20
	TLHR3225P10	TLHR54P10	●	RTG10A	10	32	25	32	170	25

INSERTS



Order Number	Stock Carbide		Dimensions (mm)			
	UTi20T	HTi10	IC	S	D4	L17
RTG05A	●	●	5	7.5	2.5	3.5
RTG06A	●	●	6	7.5	3.5	3.5
RTG07A	●		7	11	3.5	5
RTG08A	●	●	8	11	4.5	5
RTG10A	●	●	10	14	5.5	6.5

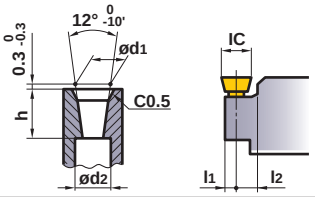
INSERTS (CBN)



Order Number	Stock CBN	Dimensions (mm)			
	MB825	IC	S	D4	L17
RTG05A	▲	5	7.5	2.5	3.5
RTG06A	▲	6	7.5	3.5	3.5
RTG07A	▲	7	11	3.5	5
RTG08A	▲	8	11	4.5	5
RTG10A	▲	10	14	5.5	6.5

INSERT SEAT LOCATION

When manufacturing a special tool holder, please machine insert seat in accordance to the drawing.

Insert Seat Dimensions	Insert Diameter **IC**	Dimensions (mm)					Taper Diameter
		h	d_1	d_2	l_1	l_2	
	5	4	2.5	1.9	1.85	3.2	1.5
	6	4	3.5	2.9	2.35	3.7	2.5
	7	6	3.5	2.5	2.75	4.3	2.1
	8	6	4.5	3.5	3.25	4.8	3.1
	10	7.5	5.5	4.2	4.15	5.9	3.8
	12	7.5	7.5	6.2	5.15	6.9	5.8

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

HOW TO READ THE STANDARD OF SMALL TOOLS

●How this section page is organised

①Organised according to the cutting mode of small tools.
(Refer to the inside title on the next page.)
②Shown as Turning → External Grooving → External Cutting Off → Threading → Boring.

TYPE OF TOOL HOLDER
indicates the first four letters of the order number, as well as cutting applications.

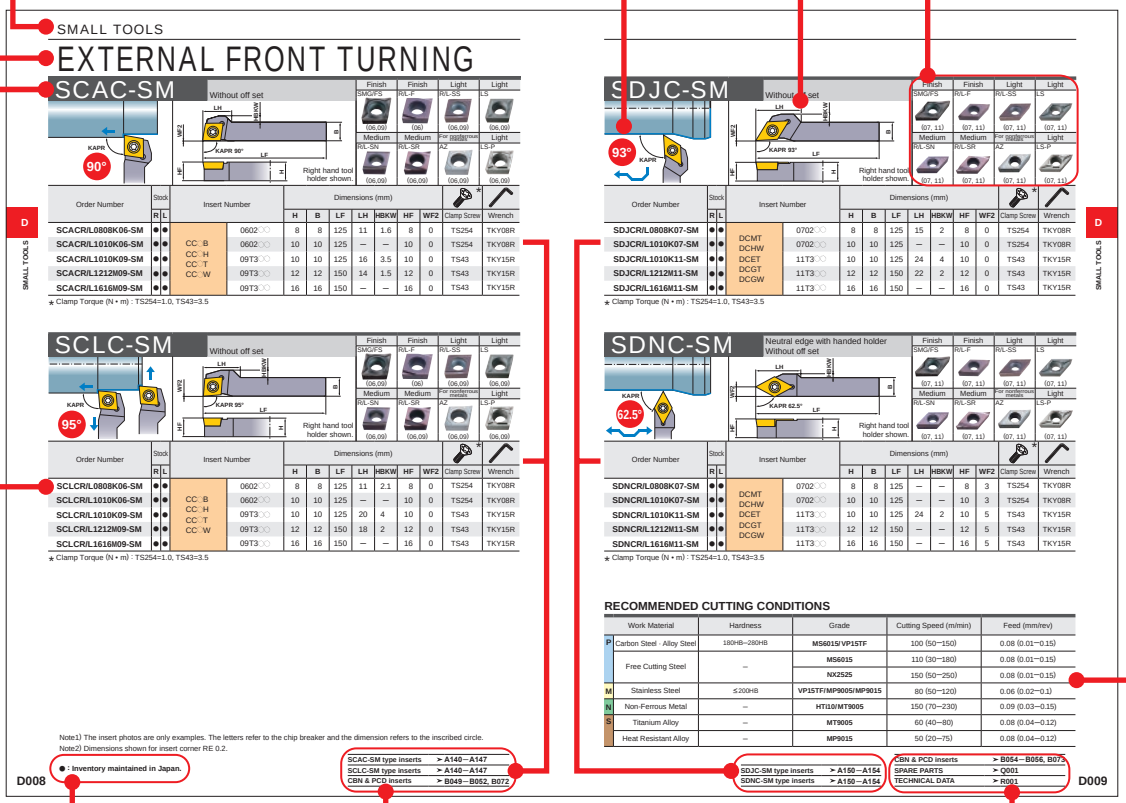
APPLICATION

PRODUCT SECTION

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict the available machining applications such as external turning, copying, facing, chamfering, threading, and grooving together with cutting edge lead angles.

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

REFERENCE PAGE FOR APPLICABLE INSERTS
indicates reference pages giving details of inserts that are applicable to the product.

PAGE REFERENCE
・SPARE PARTS
・TECHNICAL DATA
indicates reference pages, including the above, on the right hand page of each double-page spread.

PRODUCT STANDARDS
indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

RECOMMENDED CUTTING CONDITIONS
for each work material classification, indicates recommended cutting conditions according to the ISO categories for cutting grades, P, M and N.

●To Order : Please specify
①order number and hand of tool (right/left).

TURNING TOOLS

SMALL TOOLS

OUTLINE OF SMALL TOOLS ····· D002
CLASSIFICATION ····· D004

STANDARD OF SMALL TOOLS

EXTERNAL FRONT TURNING
SCAC-SM ····· D008
SCLC-SM ····· D008
SDJC-SM ····· D009
SDNC-SM ····· D009
SVLP-SM ····· D010
SVJB-SM ····· D010
SVJC-SM ····· D011
SVVB-SM ····· D011
SVPP-SM ····· D011

EXTERNAL BACK TURNING
BTAH ····· D012
CTBH ····· D013
BTVH ····· D014

EXTERNAL GROOVING
GTAH ····· D016
GTBH ····· D016
GTCH ····· D016

EXTERNAL CUTTING OFF
CTAH ····· D018
CTAH-S ····· D018
CTBH ····· D020
CTCH ····· D021
CTDH ····· D022
CTEH ····· D023

EXTERNAL THREADING
TTAH ····· D024

EXTERNAL FRONT TURNING, COPYING, FACING
SH ····· D026

CAM TYPE TOOL POSTS
CSVH ····· D027

BORING
SBAH ····· D030

*Arranged by Alphabetical order

D012 **BTAH**
D012 **BTAT INSERTS**
D013 **BTBT INSERTS**
D014 **BTVH**
D014 **BTVT INSERTS**
D027 **CSVH**
D028 **CSVTBXL INSERTS**
D028 **CSVTB INSERTS**
D028 **CSVTC INSERTS**
D027 **CSVTF INSERTS**
D027 **CSVTFXL INSERTS**
D029 **CSVTG INSERTS**
D029 **CSVTT INSERTS**
D018 **CTAH**
D018 **CTAH-S**
D019 **CTAT INSERTS**
D013 **CTBH**
D020 **CTBH**
D020 **CTBT INSERTS**
D021 **CTCH**
D021 **CTCT INSERTS**
D022 **CTDH**
D022 **CTDT INSERTS**
D023 **CTEH**
D023 **CTET INSERTS**
D016 **GTAH**
D016 **GTAT INSERTS**
D016 **GTBH**
D016 **GTBT INSERTS**
D016 **GTCH**
D016 **GTCT INSERTS**
D030 **SBAH**
D030 **SBAT INSERTS**
D008 **SCAC-SM**
D008 **SCLC-SM**
D009 **SDJC-SM**
D009 **SDNC-SM**
D026 **SH**
D010 **SVJB-SM**
D011 **SVJC-SM**
D010 **SVLP-SM**
D011 **SVPP-SM**
D011 **SVVB-SM**
D024 **TTAH**
D024 **TTAT INSERTS**

OUTLINE OF SMALL TOOLS

TOOLS FOR GANG TYPE AUTOMATIC LATHES (FOR EXTERNAL TURNING AND BORING)

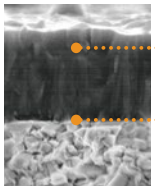
PVD Coated Cemented Carbide Grade for Carbon Steel

MS6015 NEW

Skilled at pure iron, carbon steel and free cutting steel turning and achieving implemented stable finished surfaces and excellent dimensional accuracy.

	MS6015	Conventional
Coating	TiCN multilayer	TiAlN
Hardness (HV)	3,000	2,800
Wear Coefficient (Carbon Steel)	Low	High
Base Material Hardness (HRA)	92.0	92.0
T.R.S (GPa)	2.0	2.0

Ti-C-N Multilayer Coating



Superior wear and welding resistance and demonstrating the best possible results for carbon steel.

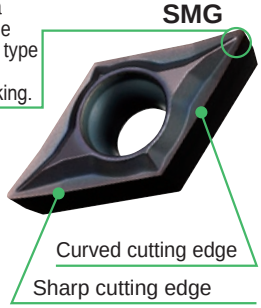
Minute multilayers remarkably improve welding.

●Moulded breaker insert

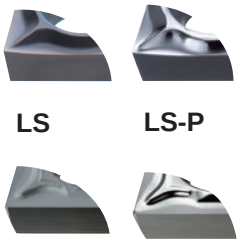
Nose radii designed with minus tolerance

- Suitable for small parts applications that often require minus tolerance dimensions.
- The order number is shown with the letter "M" that indicates minus tolerance. ex) DCGT11T301M-FS
- The radius value is printed on the side of the insert label for easy recognition.

A combination of a curved cutting edge and the protrusion type breaker promotes efficient chip breaking.



SMG FS FS-P LS LS-P



●Tolerance Corner R

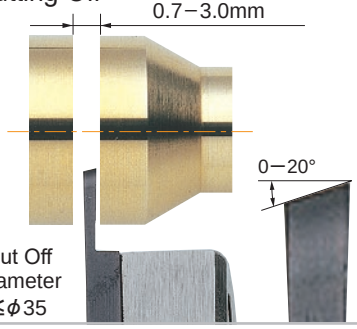
E class
RE $^{0}_{-0.02}$ mm

The letter "M" insert
RE $^{0}_{-0.05}$ mm

(Conventional G-class insert
RE ±0.10 mm)

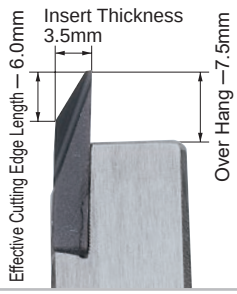
●Cutting Off

Cutting Edge Width 0.7–3.0mm



Cut Off Diameter ≤φ35

●Back Turning

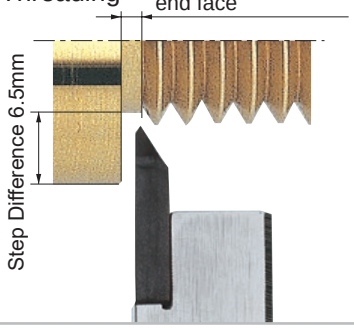


Inserts for Moulded Back Turning

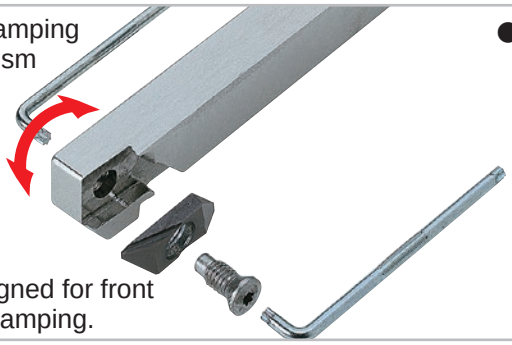
SMB Breaker NEW

●Threading

Can machine to the end face



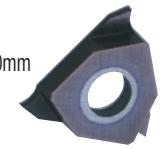
●Back Clamping Mechanism

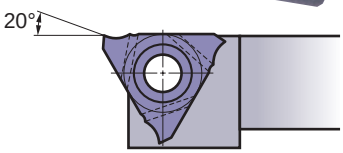


Screw designed for front and back clamping.

●Grooving

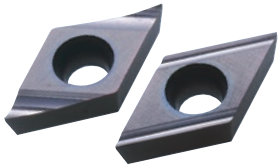
- 3-cornered
- Groove width 0.3–3.0mm
- Traversing possible





●Front Turning

- ISO E class accuracy inserts
- A wide variety of small corner R inserts
- Rake angle 30°



Tools for a very wide range of small parts machining

External Turning	Tools for front turning, back turning, grooving, threading, and cutting off
Internal Turning	Tools for boring, internal grooving and internal threading
Drilling	Drills
End Milling	End Mills

Tools for CNC automatic and small lathes

Types of Tool Posts	Gang type, turret type, cam type (radial pattern type)
Tool Sizes	Square shank: 8–16 mm Round shank : less than ϕ25.4

Indexable inserts developed under the concept of "high quality, high efficiency and long tool life."

High Quality	E class tolerance, sharp cutting edge, high accuracy small corner R, smooth surface finish
Long Tool Life	PVD coating MS6015/VP15TF/MP9005/MP9015
High Efficiency	Regrinding not necessary due to the employment of indexable inserts. A wide variety of top cutting edge geometries

INTERNAL TURNING TOOLS

Solid type MICRO-MINI TWIN Boring Bars

Minimum cutting diameter ϕ2.2–

Boring
Grooving
Threading

Round Shank

Square Shank

MICRO-DEX Boring Bars

Minimum cutting diameter ϕ5.0–

Minimum cutting diameter ϕ10.0–

DIMPLE BAR

TOOLS FOR CAM TYPE AUTOMATIC LATHES

- The most suitable for the use with cam type automatic lathes (radial pattern tool posts)
- The most suitable for machining of small parts with work diameter 5mm or smaller
- Single holder for front turning, back turning, grooving, threading and cutting off operations

Front Turning | Back Turning | Grooving | Threading | Cutting Off

DRILLING TOOLS

Violet Coated Precision Drills

VAPDS/VAPDM **(General)**
VAPDSSUS/VAPDMSUS
(For stainless steel)
VAPDSCB
(For counter boring)

Solid Carbide Drill

MVS/MVE

Solid Carbide Flat Bottom Drills

MFE NEW

Solid Carbide Drills for Centreing and Chamfering

DLE NEW

Micro Solid Carbide Drills

MSE **Drills**
MSE/MSP **(Centre Drills)**

Solid Gun Drill

Micro Solid Carbide Gun Drill with through coolant holes

MGS

END MILLING TOOLS

Solid Carbide End Mill

MSTAR **End Mill Series**

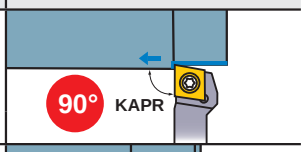
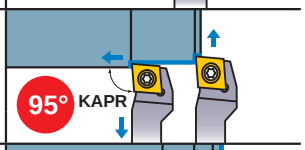
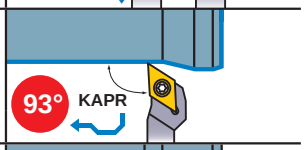
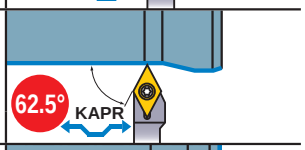
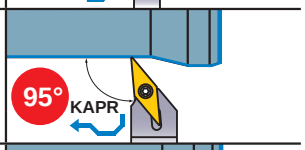
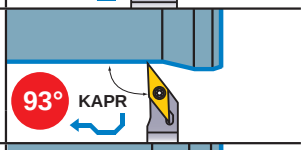
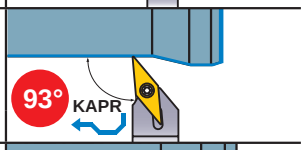
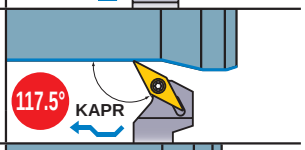
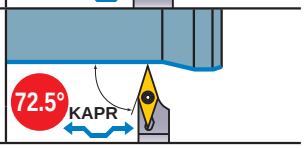
Vibration Control End Mills for Machining Difficult-to-Cut Materials

SMART MIRACLE **End Mill Series**

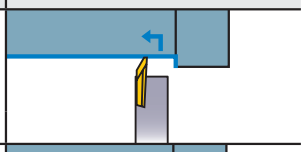
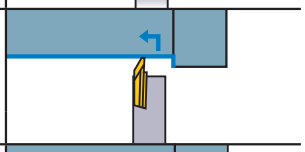
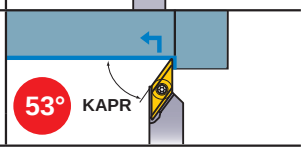
CLASSIFICATION OF EXTERNAL TURNING TOOLS

GANG TYPE TOOL POSTS

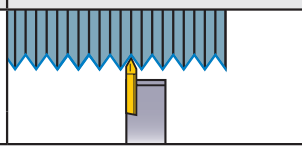
● FRONT TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
SCAC-SM ➲ D008	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SCLC-SM ➲ D008	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SDJC-SM ➲ D009	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SDNC-SM ➲ D009	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SVLP-SM ➲ D010	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SVJB-SM ➲ D010	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SVJC-SM NEW ➲ D011	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
SVPP-SM ➲ D011	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	
SVVB-SM ➲ D011	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	

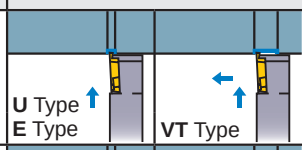
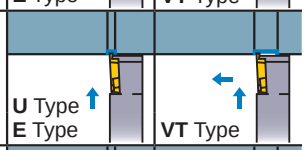
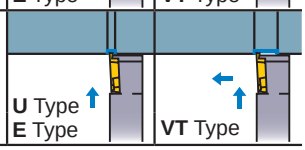
● BACK TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
BTAH (Insert Size 2.8, 3.5, 5.0mm) ➲ D012	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTBH (Insert Size 4.5, 6.0mm) ➲ D013	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
BTVH (Insert Size 7.5mm) ➲ D014	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	

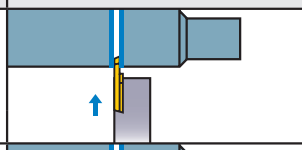
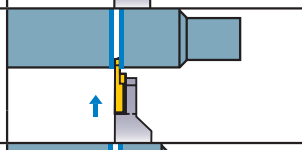
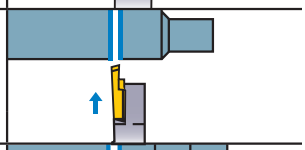
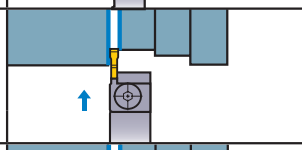
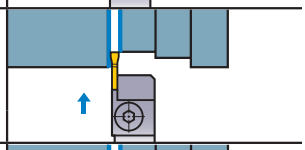
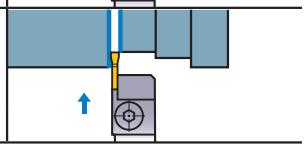
● THREADING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
TTAH ➲ D024	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	

● GROOVING

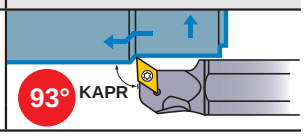
Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
GTAH (Groove Width 0.3—3.0mm) ➲ D016	8 x 8 x 80 8 x 8 x 120 10 x 10 x 80 10 x 10 x 120 12 x 12 x 80 12 x 12 x 120 16 x 16 x 120	
GTBH (Groove Width 1.45—3.0mm) ➲ D016	10 x 10 x 80 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
GTCH (Groove Width 2.5—3.0mm) ➲ D016	10 x 10 x 80 10 x 10 x 120	

● CUTTING OFF

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
CTAH (Max. Cut Off Diameter 12mm) ➲ D018	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTAH-S (Max. Cut Off Diameter 12mm) ➲ D018	10 x 10 x 80	
CTBH (Max. Cut Off Diameter 16mm) ➲ D020	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTCH (Max. Cut Off Diameter 20mm) ➲ D021	10 x 10 x 120 12 x 12 x 120	
CTDH (Max. Cut Off Diameter 23—35mm) ➲ D022	16 x 16 x 120 16 x 16 x 125	
CTEH (Max. Cut Off Diameter 23—35mm) ➲ D023	16 x 16 x 120 16 x 16 x 125	

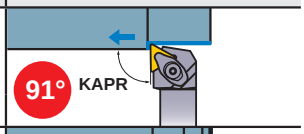
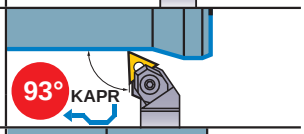
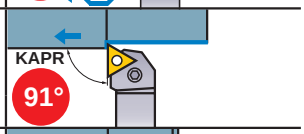
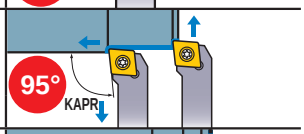
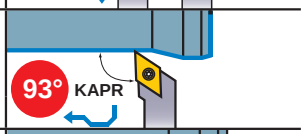
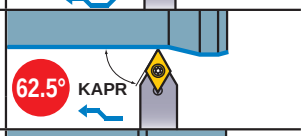
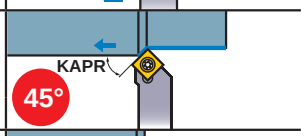
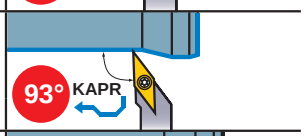
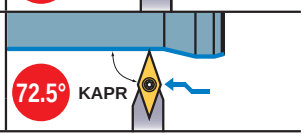
OPPOSITE TOOL POSTS

● DIMPLE SLEEVE HOLDER

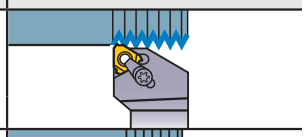
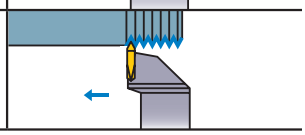
Name of Tool Holder	Shank Size (mm) (Shank Dia. x L)	Geometry
SH (Front Turning, Copying, Facing) ➲ D026	ϕ15.875 x 100 ϕ19.05 x 125 ϕ20 x 125 ϕ22 x 125 ϕ25.4 x 150	

TURRET TYPE TOOL POSTS

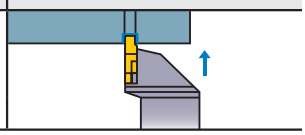
● FRONT TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
DTGN ➲ C016	16 x 16 x 100 20 x 20 x 125 25 x 25 x 150	
MTJN ➲ C017	20 x 20 x 125 25 x 25 x 150	
PTGN ➲ C016	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150	
SCLC ➲ C022	8 x 8 x 60 10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
SDJC ➲ C023	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
SDNC ➲ C023	8 x 8 x 60 10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
SSSC ➲ C026	12 x 12 x 80 16 x 16 x 100	
STGC ➲ C027	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
SVJC ➲ C028	10 x 10 x 70 16 x 16 x 100	
SVVC ➲ C028	16 x 16 x 100	

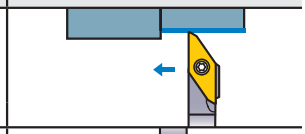
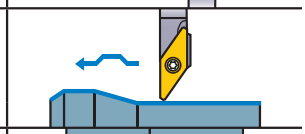
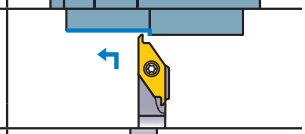
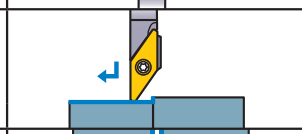
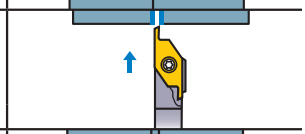
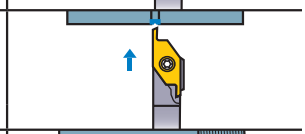
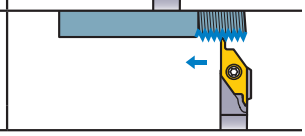
● THREADING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
MMT ➲ G019	12 x 12 x 100 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150 32 x 32 x 170	
SMGH ➲ G026	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	

● GROOVING

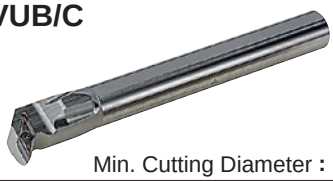
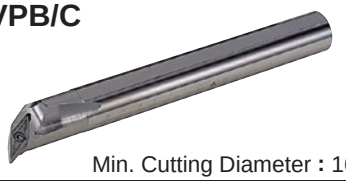
Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
SMGH ➲ F118	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	

CAM TYPE TOOL POSTS

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
CSVH (Front Turning) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Front Turning Copying) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Back Turning) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Back Turning Copying) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Cutting Off) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Grooving) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	
CSVH (Threading) ➲ D027	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x10 x 140 12 x12 x 140	

CLASSIFICATION OF INTERNAL TURNING TOOLS (FOR GENERAL USE)

Product Name	Holder
For Gang Type Tool Posts ➲ D030	SBAH Min. Cutting Diameter : 3mm
MICRO-MINI TWIN Boring Bars (Solid Carbide) ➲ E019	CB CR Min. Cutting Diameter : 2.2mm
MICRO-MINI Boring Bars (Solid Carbide) ➲ E022	C○○FR-BLS Min. Cutting Diameter : 3.2mm
MICRO-DEX Boring Bars (Carbide Shank) ➲ E016	SCLC Min. Cutting Diameter : 5mm
MICRO-DEX Boring Bars (Carbide Shank) ➲ E017	STUC Min. Cutting Diameter : 8mm
MICRO-DEX Boring Bars (Carbide Shank) ➲ E016	SWUB Min. Cutting Diameter : 6mm
F type Bars (Steel Shank) ➲ E027	FSWL1 Min. Cutting Diameter : 5.8mm
F type Bars (Carbide Shank) ➲ E027	FSWL2 Min. Cutting Diameter : 5.8mm
DIMPLE BAR (Steel Shank Carbide Shank) ➲ E006	FSCLC/P FSCLC/P-E Min. Cutting Diameter : 10mm

Product Name	Holder
DIMPLE BAR (Steel Shank Carbide Shank) ➲ E008	FSDUC FSDUC-E Min. Cutting Diameter : 14mm
DIMPLE BAR (Steel Shank Carbide Shank) ➲ E009	FSDQC FSDQC-E Min. Cutting Diameter : 13mm
DIMPLE BAR (Steel Shank Carbide Shank) ➲ E007	FSTUP FSTUP-E Min. Cutting Diameter : 10mm
DIMPLE BAR (Steel Shank) ➲ E011	FSVUB/C  Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank) ➲ E011	FSVPB/C  Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank) ➲ E012	FSVJB/C Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank Carbide Shank) ➲ E010	FSWUB/P FSWUB/P-E Min. Cutting Diameter : 10mm

CLASSIFICATION OF INTERNAL TURNING TOOLS (GROOVING/THREADING END MILLING/DRILLING)

FOR GROOVING AND THREADING

Product Name	Holder
MICRO-MINI TWIN Boring Bars (Solid Type) ➲ F120	**CG TYPE(Grooving)** Min. Cutting Diameter : 3mm
MICRO-MINI TWIN Boring Bars (Solid Type) ➲ G033	**CT TYPE(Threading)** Min. Cutting Diameter : 3mm
F type Bars (Steel Shank / Carbide Shank) (Grooving) (Threading) ➲ F124	**FSL51 FSL52** Min. Cutting Diameter : 10mm

END MILLS

Solid Carbide End Mill series	➲ J024
HSS End Mill series	➲ J044

DRILLS

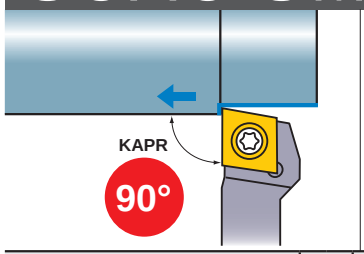
Product Name	Series Title
NEW **Leading Drills** ➲ P012	**DLE series**
NEW **Flat Bottom Drills** ➲ P015	**MFE series**

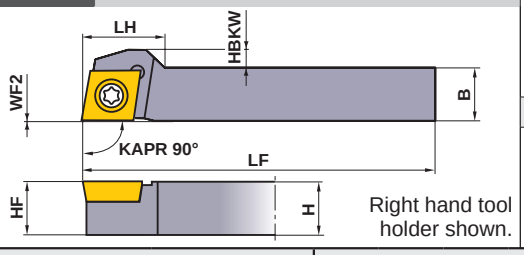
DLE series	➲ P012
MFE series	➲ P015
MVX/TAF Drill (Indexable type)	➲ P230
Solid Carbide Drill series	➲ P004
Solid Gun Drill series	➲ P130
HSS Drill series	➲ P008

EXTERNAL FRONT TURNING

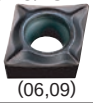
SCAC-SM

Without off set





Right hand tool holder shown.

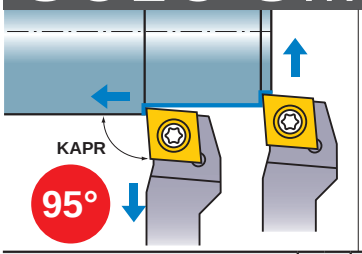
Finish	Finish	Light	Light
SMG/FS	R/L-F	R/L-SS	LS
			
(06,09)	(06)	(06,09)	(06,09)
Medium	Medium	For nonferrous metals	Light
R/L-SN	R/L-SR	AZ	LS-P
(06,09)	(06,09)	(06,09)	(06,09)

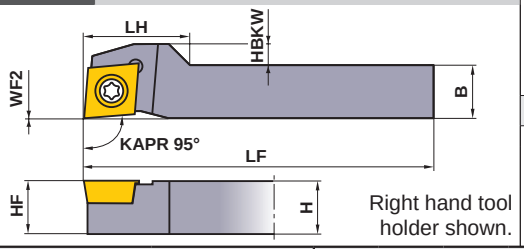
Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HBKW	HF	WF2	Clamp Screw *	Wrench
SCACR/L0808K06-SM	●	●	CC◌B CC◌H CC◌T CC◌W	0602◌◌	8	8	125	11	1.6	8	0	TS254	TKY08R
SCACR/L1010K06-SM	●	●		0602◌◌	10	10	125	—	—	10	0	TS254	TKY08R
SCACR/L1010K09-SM	●	●		09T3◌◌	10	10	125	16	3.5	10	0	TS43	TKY15R
SCACR/L1212M09-SM	●	●		09T3◌◌	12	12	150	14	1.5	12	0	TS43	TKY15R
SCACR/L1616M09-SM	●	●		09T3◌◌	16	16	150	—	—	16	0	TS43	TKY15R

* Clamp Torque (N • m) : TS254=1.0, TS43=3.5

SCLC-SM

Without off set





Right hand tool holder shown.

Finish	Finish	Light	Light
SMG/FS	R/L-F	R/L-SS	LS
(06,09)	(06)	(06,09)	(06,09)
Medium	Medium	For nonferrous metals	Light
R/L-SN	R/L-SR	AZ	LS-P
(06,09)	(06,09)	(06,09)	(06,09)

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HBKW	HF	WF2	Clamp Screw *	Wrench
SCLCR/L0808K06-SM	●	●	CC◌B CC◌H CC◌T CC◌W	0602◌◌	8	8	125	11	2.1	8	0	TS254	TKY08R
SCLCR/L1010K06-SM	●	●		0602◌◌	10	10	125	—	—	10	0	TS254	TKY08R
SCLCR/L1010K09-SM	●	●		09T3◌◌	10	10	125	20	4	10	0	TS43	TKY15R
SCLCR/L1212M09-SM	●	●		09T3◌◌	12	12	150	18	2	12	0	TS43	TKY15R
SCLCR/L1616M09-SM	●	●		09T3◌◌	16	16	150	—	—	16	0	TS43	TKY15R

* Clamp Torque (N • m) : TS254=1.0, TS43=3.5

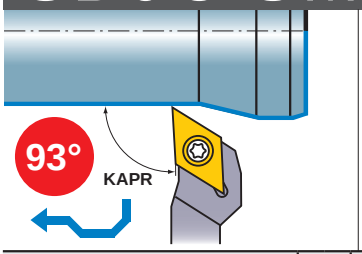
Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note2) Dimensions shown for insert corner RE 0.2.

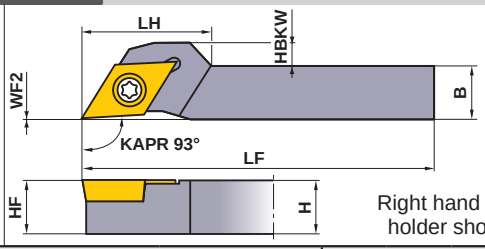
● : Inventory maintained in Japan.

SCAC-SM type inserts	➤ A140—A147
SCLC-SM type inserts	➤ A140—A147
CBN & PCD inserts	➤ B049—B052, B072

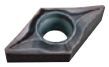
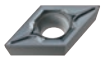
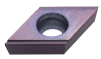
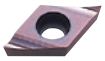
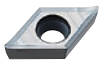
SDJC-SM

Without off set





Right hand tool holder shown.

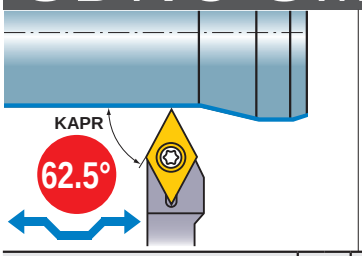
Finish	Finish	Light	Light
SMG/FS	R/L-F	R/L-SS	LS
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)
Medium	Medium	For nonferrous metals	Light
R/L-SN	R/L-SR	AZ	LS-P
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)

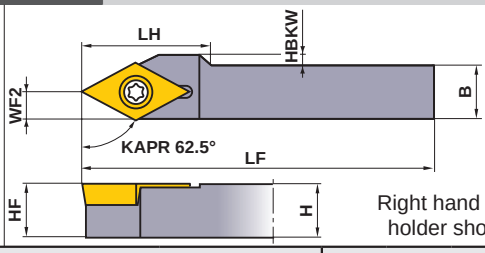
Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HBKW	HF	WF2	Clamp Screw *	Wrench
SDJCR/L0808K07-SM	●	●	DCMT DCMW DCET DCGT DCGW	0702□□	8	8	125	15	2	8	0	TS254	TKY08R
SDJCR/L1010K07-SM	●	●		0702□□	10	10	125	–	–	10	0	TS254	TKY08R
SDJCR/L1010K11-SM	●	●		11T3□□	10	10	125	24	4	10	0	TS43	TKY15R
SDJCR/L1212M11-SM	●	●		11T3□□	12	12	150	22	2	12	0	TS43	TKY15R
SDJCR/L1616M11-SM	●	●		11T3□□	16	16	150	–	–	16	0	TS43	TKY15R

* Clamp Torque (N • m) : TS254=1.0, TS43=3.5

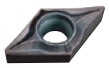
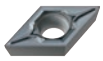
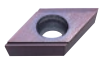
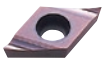
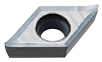
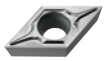
SDNC-SM

Neutral edge with handed holder
Without off set





Right hand tool holder shown.

Finish	Finish	Light	Light
SMG/FS	R/L-F	R/L-SS	LS
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)
Medium	Medium	For nonferrous metals	Light
R/L-SN	R/L-SR	AZ	LS-P
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HBKW	HF	WF2	Clamp Screw *	Wrench
SDNCR/L0808K07-SM	●	●	DCMT DCMW DCET DCGT DCGW	0702□□	8	8	125	–	–	8	3	TS254	TKY08R
SDNCR/L1010K07-SM	●	●		0702□□	10	10	125	–	–	10	3	TS254	TKY08R
SDNCR/L1010K11-SM	●	●		11T3□□	10	10	125	24	2	10	5	TS43	TKY15R
SDNCR/L1212M11-SM	●	●		11T3□□	12	12	150	–	–	12	5	TS43	TKY15R
SDNCR/L1616M11-SM	●	●		11T3□□	16	16	150	–	–	16	5	TS43	TKY15R

* Clamp Torque (N • m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

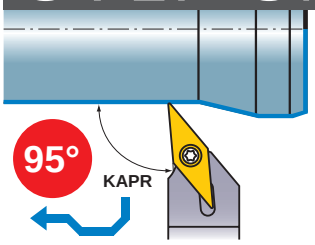
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**MS6015/VP15TF**	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	–	**MS6015**	110 (30–180)	0.08 (0.01–0.15)
			NX2525	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	**VP15TF/MP9005/MP9015**	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	**HTi10/MT9005**	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	**MT9005**	60 (40–80)	0.08 (0.04–0.12)
	Heat Resistant Alloy	–	**MP9015**	50 (20–75)	0.08 (0.04–0.12)

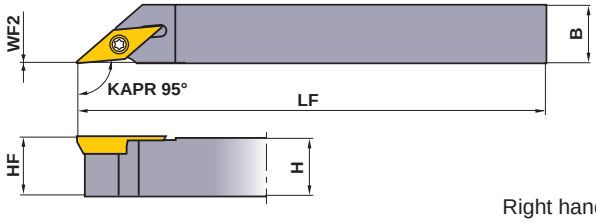
SDJC-SM type inserts	➤ A149–A154
SDNC-SM type inserts	➤ A149–A154
CBN & PCD inserts	➤ B054–B056, B073
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

EXTERNAL FRONT TURNING

SVLP-SM

Without off set





Right hand tool holder shown.

Finish R/L-SRF

(08,11)

Finish SMG

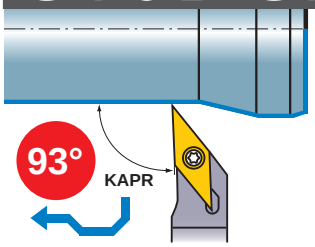
(08,11)

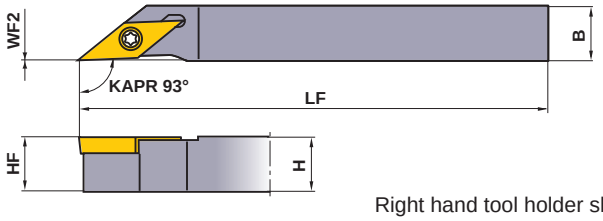
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	HF	WF2	* Clamp Screw	Wrench
SVLPR/L1010K08-SM	●	●	VPET VPGT	0802□□	10	10	125	10	0	TS202	TKY06R
SVLPR/L1212M08-SM	●	●		0802□□	12	12	150	12	0	TS202	TKY06R
SVLPR/L1010K11-SM	●	●		1103□□	10	10	125	10	0	TS255	TKY08R
SVLPR/L1212M11-SM	●	●		1103□□	12	12	150	12	0	TS255	TKY08R
SVLPR/L1616M11-SM	●	●		1103□□	16	16	150	16	0	TS255	TKY08R

* Clamp Torque (N • m) : TS202=0.6, TS255=1.0

SVJB-SM

Without off set





Right hand tool holder shown.

Finish R/L-F

(11)

Medium R/L-SN

(11)

Medium R/L-SR

(11)

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	HF	WF2	* Clamp Screw	Wrench
SVJBR/L1010K11-SM	●	●	VBMT VBET VBGT VBGW	1103□□	10	10	125	10	0	TS255	TKY08R
SVJBR/L1212M11-SM	●	●		1103□□	12	12	150	12	0	TS255	TKY08R
SVJBR/L1616M11-SM	●	●		1103□□	16	16	150	16	0	TS255	TKY08R

* Clamp Torque (N • m) : TS255=1.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**MS6015/VP15TF**	100 (50–150)	0.08 (0.01–0.15)
P	Free Cutting Steel	–	**MS6015**	110 (30–180)	0.08 (0.01–0.15)
P			**NX2525**	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	**VP15TF/MP9005/MP9015**	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	**HTi10/MT9005**	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	**MT9005**	60 (40–80)	0.08 (0.04–0.12)
S	Heat Resistant Alloy	–	**MP9015**	50 (20–75)	0.08 (0.04–0.12)

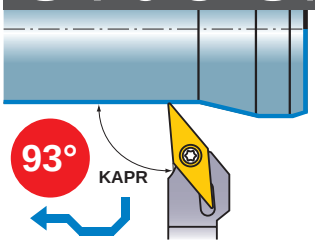
Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note2) Dimensions shown for insert corner RE 0.2.

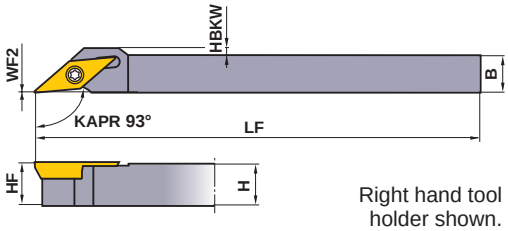
● : Inventory maintained in Japan.

SVLP-SM type inserts	**➤ A174**
SVJB-SM type inserts	**➤ A167–A169**
CBN & PCD inserts	**➤ B061, B077**

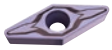
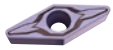
SVJC-SM NEW

Without off set





Right hand tool holder shown.

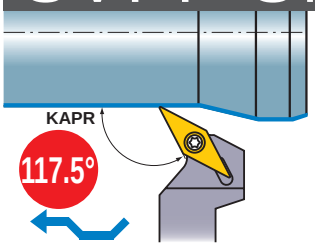
Finish	Finish	Light	Light
FP	FM	LS	LS-P
(11)	(11)	(11,13)	(11,13)
Light	Light	Light	
LP	LM	LS	
			
(11)	(11)	(11)	

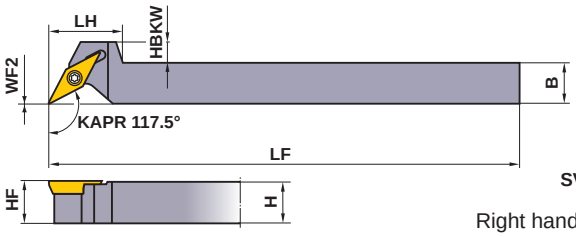
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	HBKW	HF	WF2	Clamp Screw *	Wrench
SVJCR/L1010JX11-SM	●	●	VCMW VCMT VCGT	1103○○	10	10	120	—	10	0	TS255	TKY08R
SVJCR/L1212JX11-SM	●	●		1103○○	12	12	120	—	12	0	TS255	TKY08R
SVJCR/L1616JX11-SM	●	●		1103○○	16	16	120	—	16	0	TS255	TKY08R
SVJCR/L1010JX13-SM	●	●		1303○○	10	10	120	2	10	0	TS32	TKY08R
SVJCR/L1212JX13-SM	●	●		1303○○	12	12	120	—	12	0	TS32	TKY08R
SVJCR/L1616JX13-SM	●	●		1303○○	16	16	120	—	16	0	TS32	TKY08R

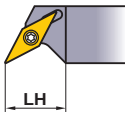
* Clamp Torque (N • m) : TS255=1.0, TS32=1.0

● = NEW

SVPP-SM







SVPPR/L1616M11-SM

Right hand tool holder shown.

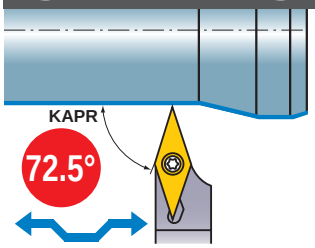
Finish
R/L-SRF
(11)
Finish
SMG
(11)

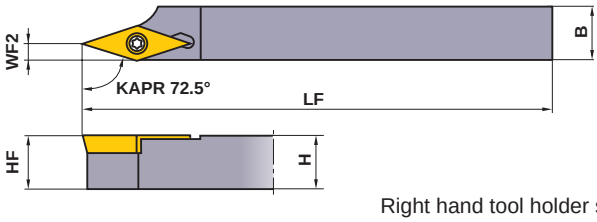
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	LH	HBKW	HF	WF2	Clamp Screw *	Wrench
SVPPR/L1010K11-SM	●	●	VPET VPGT	1103○○	10	10	125	20	8	10	0	TS255	TKY08R
SVPPR/L1212M11-SM	●	●		1103○○	12	12	150	20	6	12	0	TS255	TKY08R
SVPPR/L1616M11-SM	●	●		1103○○	16	16	150	17	—	16	0	TS255	TKY08R

* Clamp Torque (N • m) : TS255=1.0

SVVB-SM

Neutral edge with handed holder





Right hand tool holder shown.

Finish	Medium
R/L-F	R/L-SN
(11)	(11)
Medium	
R/L-SR	
(11)	

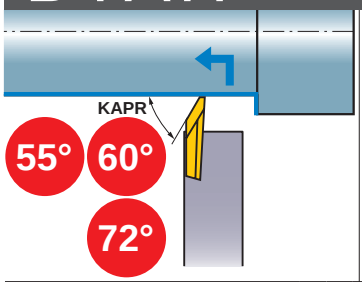
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	LF	HF	WF2	Clamp Screw *	Wrench
SVVBR/L1010K11-SM	●	●	VBET VBGT VBMT VBGW	1103○○	10	10	125	10	3	TS255	TKY08R
SVVBR/L1212M11-SM	●	●		1103○○	12	12	150	12	3	TS255	TKY08R
SVVBR/L1616M11-SM	●	●		1103○○	16	16	150	16	3	TS255	TKY08R

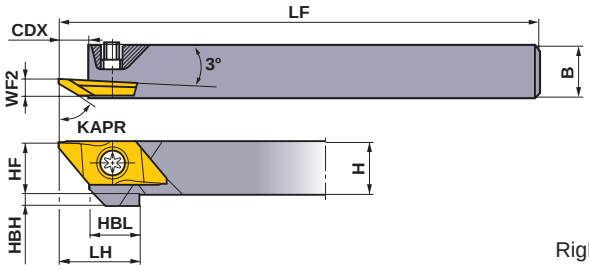
* Clamp Torque (N • m) : TS255=1.0

SVJC-SM type inserts	➤ A170—A172	CBN & PCD inserts	➤ B061, B077
SVPP-SM type inserts	➤ A174	SPARE PARTS	➤ Q001
SVVB-SM type inserts	➤ A167—A169	TECHNICAL DATA	➤ R001

EXTERNAL BACK TURNING

BTAH





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF2	HBH	HBL	CDX	Clamp Screw *	Wrench
BTAHR/L0810-50	●	●	BTAT	5528○○R/L-B	8	10	120	15	8	3.5	4	9.5	5.5	NS402W	NKY15S
BTAHR/L1010-50	●	●		6035○○R/L-B	10	10	120	15	10	3.5	2	9.5	5.5	NS402W	NKY15S
BTAHR/L1212-50	●	●		605000RX	12	12	120	15	12	3.5	—	9.5	5.5	NS403W	NKY15S
BTAHR/L1616-50	●			7235○○R-SMB	16	16	120	15	16	3.5	—	9.5	5.5	NS403W	NKY15S

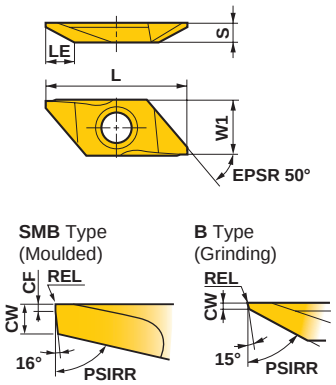
Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.
Note 2) Set the maximum depth of cut at under 60% of the effective cutting edge length (LE).
* Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

INSERTS

Order Number	Hand	Coated VP15TF	Coated NEW MS6015	PSIRR/L *	RER/L	CF	L	W1	CW	S	LE * (mm)
NEW BTAT7235V5R-SMB	R	●		72°	0.05	0.3	20	8	1.4	2.5	3.5
NEW BTAT723501MR-SMB	R	●		72°	0.08	0.3	20	8	1.4	2.5	3.5
NEW BTAT723502MR-SMB	R	●		72°	0.18	0.3	20	8	1.4	2.5	3.5
BTAT552800R-B	R	●	●	55°	0	0	20	8	0.5	2.5	2.8
BTAT552800L-B	L	●		55°	0	0	20	8	0.5	2.5	2.8
BTAT552801R-B	R	●	●	55°	0.1	0	20	8	0.5	2.5	2.8
BTAT552801L-B	L	●		55°	0.1	0	20	8	0.5	2.5	2.8
BTAT603500R-B	R	●	●	60°	0	0	20	8	0.5	2.5	3.5
BTAT603500L-B	L	●		60°	0	0	20	8	0.5	2.5	3.5
NEW BTAT603501MR-B	R		●	60°	0.08	0	20	8	0.5	2.5	3.5
BTAT603501R-B	R	●	●	60°	0.1	0	20	8	0.5	2.5	3.5
BTAT603501L-B	L	●		60°	0.1	0	20	8	0.5	2.5	3.5
BTAT605000RX	R	●		60°	0	0	20	8	1.25	2.5	5.0

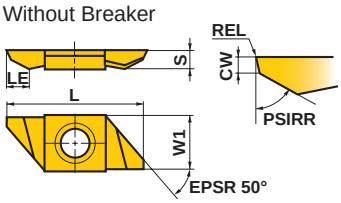
Geometry

With Breaker



Right hand insert shown.

Without Breaker



Note 1) REL, PSIRR dimensions for Right Hand Tool and RER, PSIRL dimensions for Left Hand Tool.
* Numeric value set insert on holder.

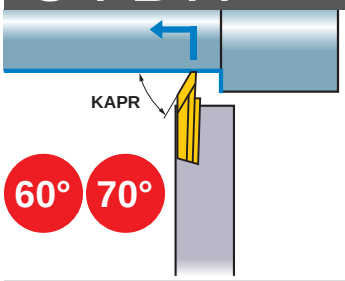
● = NEW

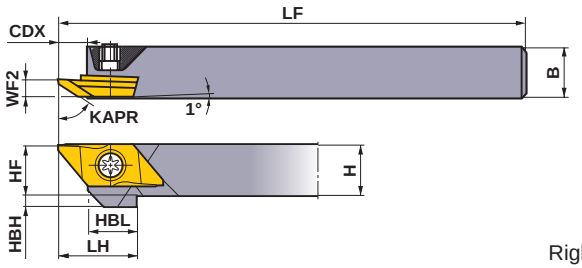
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB—280HB	**MS6015/ VP15TF**	100 (50—150)	0.08 (0.01—0.15)
	Free Cutting Steel	—	**MS6015**	110 (30—180)	0.08 (0.01—0.15)
M	Stainless Steel	≤200HB	**VP15TF**	80 (50—120)	0.06 (0.02—0.1)
N	Non-Ferrous Metal	—	**MS6015**	150 (70—230)	0.09 (0.03—0.15)

● : Inventory maintained in Japan. (5 inserts in one case)

CTBH





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	LF	LH	HF	WF2	HBH	HBL	CDX	Clamp Screw *	Wrench
CTBHR/L1010-160	●	●	BTBT	60450◌R/L-B	10	10	120	19.5	10	3.4	2	12	7.5	NS402W	NKY15S
CTBHR/L1212-160	●	●	BTBT	606000R/L	12	12	120	19.5	12	3.4	—	12	7.5	NS403W	NKY15S
CTBHR/L1616-160	●	●	BTBT	7055◌◌R-SMB	16	16	120	19.5	16	3.4	—	12	7.5	NS403W	NKY15S

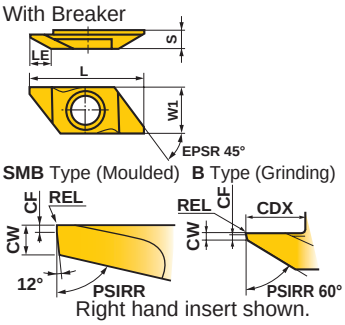
Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.
Note 2) Set the maximum depth of cut at under 60% of the effective cutting edge length (LE).
* Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

INSERTS

Order Number	Hand	Coated VP15TF	Coated NEW MS6015	PSIRR/L*	RER/L	CF	L	W1	CW	S	CDX	LE* (mm)
NEW BTBT7055V5R-SMB	R	●		70°	0.05	0.3	25	9.4	1.35	3.5	6.5	5.5
NEW BTBT705501MR-SMB	R	●		70°	0.08	0.3	25	9.4	1.35	3.5	6.5	5.5
NEW BTBT705502MR-SMB	R	●		70°	0.18	0.3	25	9.4	1.35	3.5	6.5	5.5
BTBT604500R-B	R	●	●	60°	0	0.2	25	9.4	0.7	3.5	5.5	4.5
BTBT604500L-B	L	●		60°	0	0.2	25	9.4	0.7	3.5	5.5	4.5
NEW BTBT604501MR-B	R		●	60°	0.08	0.3	25	9.4	0.7	3.5	5.5	4.5
BTBT604501R-B	R	●	●	60°	0.1	0.3	25	9.4	0.7	3.5	5.5	4.5
BTBT604501L-B	L	●		60°	0.1	0.3	25	9.4	0.7	3.5	5.5	4.5
BTBT606000R	R	●		60°	0	0.2	25	9.4	0.7	3.5	7	6.0
BTBT606000L	L	●		60°	0	0.2	25	9.4	0.7	3.5	7	6.0

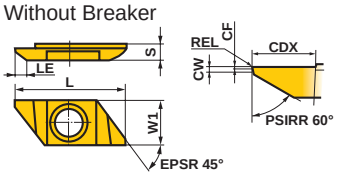
Geometry

With Breaker



Right hand insert shown.

Without Breaker



Right hand insert shown.

Note 1) REL, PSIRR dimensions for Right Hand Tool and RER, PSIRL dimensions for Left Hand Tool.
* Numeric value set insert on holder.

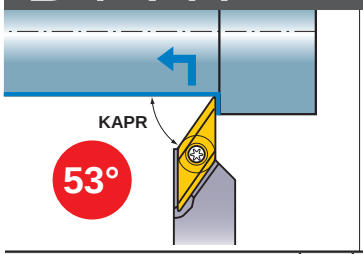
● = NEW

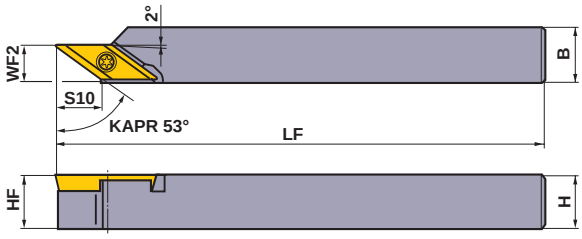
● : Inventory maintained in Japan. (5 inserts in one case)

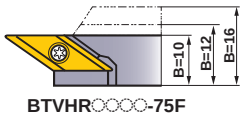
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

EXTERNAL BACK TURNING

BTVH







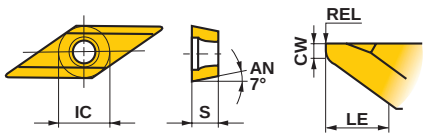
Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)						*	
	R			H	B	LF	HF	WF2	S10	Clamp Screw	Wrench
BTVHR1010-75	●	BTVT	5375○○R-B	10	10	120	10	7.5	8.5	NS251	NKY15S
BTVHR1212-75	●			12	12	120	12	7.5	8.5	NS251	NKY15S
BTVHR1616-75	●			16	16	120	16	7.5	8.5	NS251	NKY15S
BTVHR1010-75F	●			10	10	120	10	10.0	8.5	NS251	NKY15S
BTVHR1212-75F	●			12	12	120	12	10.0	8.5	NS251	NKY15S
BTVHR1616-75F	●			16	16	120	16	10.0	8.5	NS251	NKY15S

Note 1) Set the maximum depth of cut at under 30% of the effective cutting edge length (LE).
Note 2) For high load machining, F type is recommended.
* Clamp Torque (N • m) : NS251=1.0

INSERTS

Order Number	Hand	Coated	Dimensions (mm)				LE * (mm)	Geometry
		VP15TF	IC	S	REL	CW		
BTVT5375V5R-B	R	●	6.35	3.18	0.05	0.5	7.5	With Breaker
BTVT537501R-B	R	●	6.35	3.18	0.1	0.5	7.5	



* Numeric value set insert on holder.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**VP15TF**	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	–	**VP15TF**	110 (30–180)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	**VP15TF**	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	**VP15TF**	150 (70–230)	0.09 (0.03–0.15)

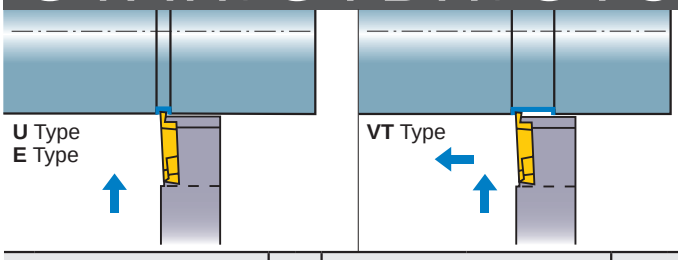
● : Inventory maintained in Japan. (5 inserts in one case)

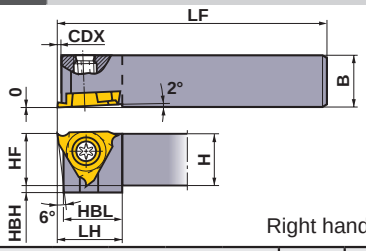
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Memo

EXTERNAL GROOVING

GTAH, GTBH, GTCH





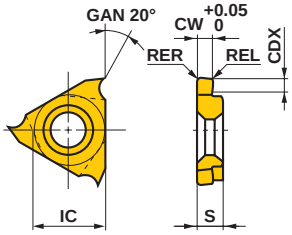
Right hand tool holder shown.

	Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	HF	LF	CDX*1	LH	HBH	HBL	Cutting Width (mm)	*2 Clamp Screw	Wrench
Standard Shank	GTAHR/L0808-20S	●	●	GTAT GTBT *1 GTCT *1	○○○○	8	8	8	80	2	15	5	12.9	0.3－3.0	NS404W	NKY15S
	GTAHR/L1010-20S	●	●		○○○○	10	10	10	80	2	15	3	12.9	0.3－3.0	NS404W	NKY15S
	GTAHR/L1212-20S	●	●		○○○○	12	12	12	80	2	15	1	12.9	0.3－3.0	NS404W	NKY15S
	GTBHR/L1010-30S	●	●	GTBT. GTCT	○○○○	10	10	10	80	3	15	3	13.4	1.45－3.0	NS404W	NKY15S
	GTCHR/L1010-30S	●	●	GTCT	○○○○	10	10	10	80	3	15	3	13.4	2.5－3.0	NS404W	NKY15S
Long Shank	GTAHR/L0808-20	●	●	GTAT GTBT *1 GTCT *1	○○○○	8	8	8	120	2	15	5	12.9	0.3－3.0	NS404W	NKY15S
	GTAHR/L1010-20	●	●		○○○○	10	10	10	120	2	15	3	12.9	0.3－3.0	NS404W	NKY15S
	GTAHR/L1212-20	●	●		○○○○	12	12	12	120	2	15	1	12.9	0.3－3.0	NS404W	NKY15S
	GTAHR/L1616-20	●	●		○○○○	16	16	16	120	2	15	—	12.9	0.3－3.0	NS404W	NKY15S
	GTBHR/L1010-30	●	●	GTBT. GTCT	○○○○	10	10	10	120	3	15	3	13.4	1.45－3.0	NS404W	NKY15S
	GTBHR/L1212-30	●	●		○○○○	12	12	12	120	3	15	1	13.4	1.45－3.0	NS404W	NKY15S
	GTBHR/L1616-30	●	●		○○○○	16	16	16	120	3	15	—	13.4	1.45－3.0	NS404W	NKY15S
	GTCHR/L1010-30	●	●	GTCT	○○○○	10	10	10	120	3	15	3	13.4	2.5－3.0	NS404W	NKY15S

Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.
*1 It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth).
*2 Clamp Torque (N • m) : NS404W=1.0

INSERTS

Order Number	Hand	Coated VP15TF	Dimensions (mm) CW	CDX*1	RER/L	IC	S	Geometry
GTAT 03006V3R-U	R	●	0.3	0.6	0.03	9.525	3.18	**U** Type Breaker (General purpose Grooving)
GTAT 03006V3L-U	L	●	0.3	0.6	0.03	9.525	3.18	
GTAT 05012V5R-U	R	●	0.5	1.2	0.05	9.525	3.18	
GTAT 05012V5L-U	L	●	0.5	1.2	0.05	9.525	3.18	
GTAT 07520V5R-U	R	●	0.75	2.0	0.05	9.525	3.18	
GTAT 07520V5L-U	L	●	0.75	2.0	0.05	9.525	3.18	
GTAT 09520V5R-U	R	●	0.95	2.0	0.05	9.525	3.18	
GTAT 09520V5L-U	L	●	0.95	2.0	0.05	9.525	3.18	
GTAT 10020V5R-U	R	●	1.0	2.0	0.05	9.525	3.18	
GTAT 10020V5L-U	L	●	1.0	2.0	0.05	9.525	3.18	
GTAT 10320V5R-U	R	●	1.03	2.0	0.05	9.525	3.18	
GTAT 12520V5R-U	R	●	1.25	2.0	0.05	9.525	3.18	
GTAT 12520V5L-U	L	●	1.25	2.0	0.05	9.525	3.18	
GTBT14530V5R-U	R	●	1.45	3.0	0.05	9.525	3.18	
GTBT14530V5L-U	L	●	1.45	3.0	0.05	9.525	3.18	
GTBT15030V5R-U	R	●	1.5	3.0	0.05	9.525	3.18	
GTBT15030V5L-U	L	●	1.5	3.0	0.05	9.525	3.18	
GTBT17530V5R-U	R	●	1.75	3.0	0.05	9.525	3.18	
GTBT17530V5L-U	L	●	1.75	3.0	0.05	9.525	3.18	
GTBT20030V5R-U	R	●	2.0	3.0	0.05	9.525	3.18	
GTBT20030V5L-U	L	●	2.0	3.0	0.05	9.525	3.18	
GTCT25030V5R-U	R	●	2.5	3.0	0.05	9.525	3.18	
GTCT25030V5L-U	L	●	2.5	3.0	0.05	9.525	3.18	



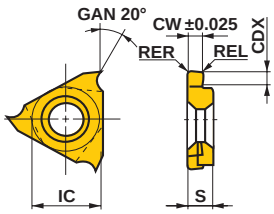
Right hand insert shown.

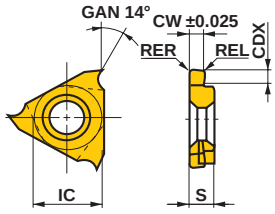
*1 It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth).

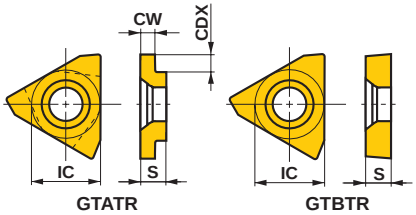
● : Inventory maintained in Japan. (5 inserts in one case)

INSERTS

Order Number	Hand	Coated VP15TF	Coated VP15KZ	Carbide TF15	Dimensions (mm) CW	CDX	RER/L	IC	S	Max. Cutting Depth (mm)	Geometry
GTAT 03306V3R-E	R	●			0.33	0.6	0.03	9.525	3.18		**E** Type Breaker (Ring processing Grooving)
GTAT 03306V3L-E	L	●			0.33	0.6	0.03	9.525	3.18		
GTAT 04312V3R-E	R	●			0.43	1.2	0.03	9.525	3.18		
GTAT 04312V3L-E	L	●			0.43	1.2	0.03	9.525	3.18		
GTAT 05312V5R-E	R	●			0.53	1.2	0.05	9.525	3.18		
GTAT 05312V5L-E	L	●			0.53	1.2	0.05	9.525	3.18		
GTAT 07520V5R-E	R	●			0.75	2.0	0.05	9.525	3.18		
GTAT 07520V5L-E	L	●			0.75	2.0	0.05	9.525	3.18		
GTAT 09520V5R-E	R	●			0.95	2.0	0.05	9.525	3.18		
GTAT 09520V5L-E	L	●			0.95	2.0	0.05	9.525	3.18		
GTAT 10020V5R-E	R	●			1.0	2.0	0.05	9.525	3.18		
GTAT 10020V5L-E	L	●			1.0	2.0	0.05	9.525	3.18		
GTAT 1002001R-E	R	●			1.0	2.0	0.1	9.525	3.18		
GTAT 1002001L-E	L	●			1.0	2.0	0.1	9.525	3.18		
GTAT 12020V5R-E	R	●			1.2	2.0	0.05	9.525	3.18		
GTAT 12020V5L-E	L	●			1.2	2.0	0.05	9.525	3.18		
GTAT 1202001R-E	R	●			1.2	2.0	0.1	9.525	3.18		
GTAT 1202001L-E	L	●			1.2	2.0	0.1	9.525	3.18		
GTAT 14020V5R-E	R	●			1.4	2.0	0.05	9.525	3.18		
GTAT 14020V5L-E	L	●			1.4	2.0	0.05	9.525	3.18		
GTBT15030V5R-E	R	●			1.5	3.0	0.05	9.525	3.18		
GTBT15030V5L-E	L	●			1.5	3.0	0.05	9.525	3.18		
GTBT1503001R-E	R	●			1.5	3.0	0.1	9.525	3.18		
GTBT1503001L-E	L	●			1.5	3.0	0.1	9.525	3.18		
GTBT18030V5R-E	R	●			1.8	3.0	0.05	9.525	3.18		
GTBT18030V5L-E	L	●			1.8	3.0	0.05	9.525	3.18		
GTBT20030V5R-E	R	●			2.0	3.0	0.05	9.525	3.18		
GTBT20030V5L-E	L	●			2.0	3.0	0.05	9.525	3.18		
GTBT2003001R-E	R	●			2.0	3.0	0.1	9.525	3.18		
GTBT2003001L-E	L	●			2.0	3.0	0.1	9.525	3.18		
GTBT22530V5R-E	R	●			2.25	3.0	0.05	9.525	3.18		
GTBT22530V5L-E	L	●			2.25	3.0	0.05	9.525	3.18		
GTCT25030V5R-E	R	●			2.5	3.0	0.05	9.525	3.18		
GTCT25030V5L-E	L	●			2.5	3.0	0.05	9.525	3.18		
GTCT27530V5R-E	R	●			2.75	3.0	0.05	9.525	3.18		
GTCT27530V5L-E	L	●			2.75	3.0	0.05	9.525	3.18		
GTCT30030V5R-E	R	●			3.0	3.0	0.05	9.525	3.18		
GTCT30030V5L-E	L	●			3.0	3.0	0.05	9.525	3.18		Right hand insert shown.
GTAT 0330600R-VT	R		●		0.33	0.6	0	9.525	3.18	0.25	**VT** Type Breaker (Grooving, Side Turning)
GTAT 0431200R-VT	R		●		0.43	1.2	0	9.525	3.18	0.9	
GTAT 0532000R-VT	R		●		0.53	2.0	0	9.525	3.18	1.6	
GTAT 0652000R-VT	R		●		0.65	2.0	0	9.525	3.18	1.6	
GTAT 0752000R-VT	R		●		0.75	2.0	0	9.525	3.18	1.6	
GTAT 0802000R-VT	R		●		0.8	2.0	0	9.525	3.18	1.6	
GTAT 0852000R-VT	R		●		0.85	2.0	0	9.525	3.18	1.6	
GTAT 0952000R-VT	R		●		0.95	2.0	0	9.525	3.18	1.6	
GTAT 1002000R-VT	R		●		1.0	2.0	0	9.525	3.18	1.6	
GTAT 1102000R-VT	R		●		1.1	2.0	0	9.525	3.18	1.6	
GTAT 1202000R-VT	R		●		1.2	2.0	0	9.525	3.18	1.6	
GTAT 1302000R-VT	R		●		1.3	2.0	0	9.525	3.18	1.6	
GTAT 1402000R-VT	R		●		1.4	2.0	0	9.525	3.18	1.6	
GTBT1503000R-VT	R		●		1.5	3.0	0	9.525	3.18	2.7	
GTBT2003000R-VT	R		●		2.0	3.0	0	9.525	3.18	2.7	
GTATR	R			⁎●	1.76	3.0	—	9.525	3.18		Blank
GTATL	L			⁎●	1.76	3.0	—	9.525	3.18		
GTBTR	R			⁎●	—	0	—	9.525	3.18		
GTBTL	L			⁎●	—	0	—	9.525	3.18		







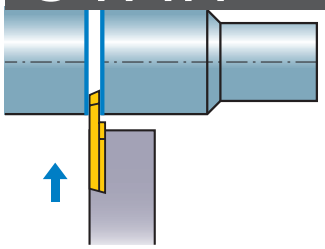
Right hand insert shown.

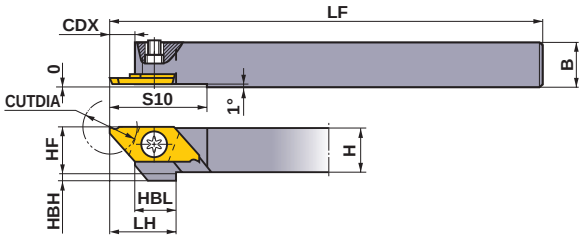
⁎ 10 inserts in one case.

CUTTING CONDITIONS ➤ D018
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

EXTERNAL CUTTING OFF

CTAH



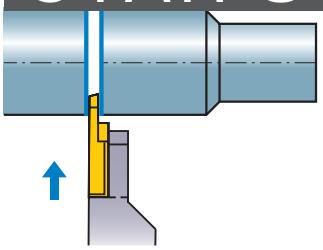


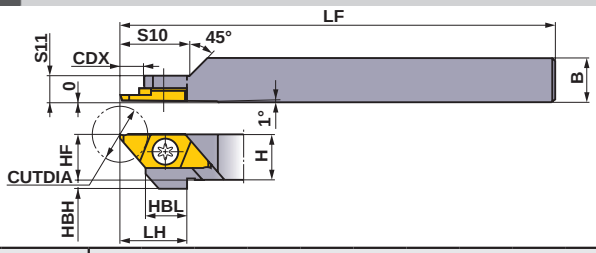
Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	HF	LF	LH	CDX	HBH	HBL	S10	CUTDIA (mm)	Clamp Screw ⋆2	Wrench
CTAHR/L0810-120	●	●	CTAT	○○○○	8	10	8	120	15	5.5	4	9.5	22	12 (8)⋆1	NS402W	NKY15S
CTAHR/L1010-120	●	●		○○○○	10	10	10	120	15	5.5	2	9.5	22		NS402W	NKY15S
CTAHR/L1212-120	●	●		○○○○	12	12	12	120	15	5.5	—	9.5	22		NS403W	NKY15S
CTAHR/L1616-120	●	●		○○○○	16	16	16	120	15	5.5	—	9.5	22		NS403W	NKY15S

⋆1 When the width of cutting off (CW) is 0.7mm.
⋆2 Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

CTAH-S





Right hand tool holder only.

Order Number	Stock R	Insert Number		H	B	HF	LF	LH	CDX	HBH	HBL	S10	S11	CUTDIA (mm)	Clamp Screw ⋆2	Wrench
CTAHR1010-120S	●	CTAT	○○○○	10	10	10	80	15	16	2	9.5	16	5.5	12 (8)⋆1	NS401	NKY25R

⋆1 When the width of cutting off (CW) is 0.7mm.
⋆2 Clamp Torque (N • m) : NS401=3.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB—280HB	**MS6015/ VP15TF**	100 (50—150)	0.05 (0.02—0.09)
	Free Cutting Steel	–	**MS6015**	110 (30—180)	0.05 (0.01—0.09)
M	Stainless Steel	≤200HB	**VP15TF**	80 (50—120)	0.03 (0.02—0.05)
N	Non-Ferrous Metal	–	**MS6015**	150 (70—230)	0.07 (0.03—0.11)

● : Inventory maintained in Japan. (5 inserts in one case)

INSERTS

Holder	Setting Geometry	Breaker	Geometry	Insert Geometry	Order Number	Hand	Coated VP15TF	Coated NEW MS6015	CW	CDX	RER/L	L	W1	S	LBB	CUTDIA (mm)
Right Hand (R)	16°	With Breaker		REL CDX LBB CW ±0.05 RER	CTAT07080V5RR-B	R	●		0.7	4.5	0.05	20	8	2.5	1.5	8
					CTAT10120V5RR-B	R	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12
					CTAT15120V5RR-B	R	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12
					CTAT20120V5RR-B	R	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12
	16°			REL CDX LBB CW ±0.05 RER Strong Edge Type	CTAT15120V5RR-BX	R	●		1.5	6.7	0.05	20	8	2.5	1.5	12
					CTAT20120V5RR-BX	R	●		2.0	6.7	0.05	20	8	2.5	1.5	12
	0°			REL CDX LBB CW ±0.05 RER	CTAT10120V5RN-B	N	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12
					CTAT15120V5RN-B	N	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12
					CTAT20120V5RN-B	N	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12
	0°			REL CDX LBB CW ±0.05 RER Strong Edge Type	CTAT15120V5RN-BX	N	●		1.5	6.7	0.05	20	8	2.5	1.5	12
					CTAT20120V5RN-BX	N	●		2.0	6.7	0.05	20	8	2.5	1.5	12
	16°		S L W1 EPSR 50°	REL CDX CW ±0.05 RER LBB	CTAT10110V5RL-B	L	●		1.0	6.7	0.05	20	8	2.5	1.5	11
					CTAT15110V5RL-B	L	●		1.5	6.7	0.05	20	8	2.5	1.5	11
					CTAT20110V5RL-B	L	●		2.0	6.7	0.05	20	8	2.5	1.5	11
	20°	Without Breaker		REL CDX LBB CW ±0.05 RER	CTAT1012000RR	R	●	●	1.0	6.7	0	20	8	2.5	3.5	12
					CTAT1512000RR	R	●	●	1.5	6.7	0	20	8	2.5	3.5	12
					CTAT2012000RR	R	●	●	2.0	6.7	0	20	8	2.5	3.5	12
Left Hand (L)	16°	With Breaker		REL CW ±0.05 RER LBB CDX	CTAT07080V5LL-B	L	●		0.7	4.5	0.05	20	8	2.5	1.5	8
					CTAT10120V5LL-B	L	●		1.0	6.7	0	20	8	2.5	1.5	12
					CTAT15120V5LL-B	L	●		1.5	6.7	0	20	8	2.5	1.5	12
					CTAT20120V5LL-B	L	●		2.0	6.7	0	20	8	2.5	1.5	12
	0°			REL CW ±0.05 RER LBB CDX	CTAT10120V5LN-B	N	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12
					CTAT15120V5LN-B	N	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12
					CTAT20120V5LN-B	N	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12
	16°			REL LBB CW ±0.05 RER CDX	CTAT10110V5LR-B	R	●	●	1.0	6.7	0.05	20	8	2.5	1.5	11
					CTAT15110V5LR-B	R	●	●	1.5	6.7	0.05	20	8	2.5	1.5	11
					CTAT20110V5LR-B	R	●	●	2.0	6.7	0.05	20	8	2.5	1.5	11
	20°	Without Breaker	Right hand insert shown.	REL CW ±0.05 RER LBB CDX	CTAT1012000LL	L	●		1.0	6.7	0	20	8	2.5	3.5	12
					CTAT1512000LL	L	●		1.5	6.7	0	20	8	2.5	3.5	12
					CTAT2012000LL	L	●		2.0	6.7	0	20	8	2.5	3.5	12

● = NEW

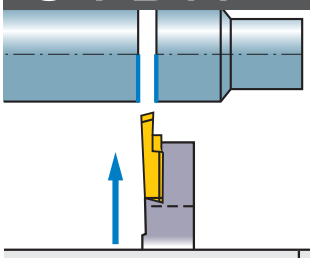
D

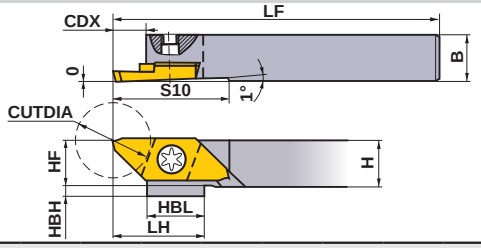
SMALL TOOLS

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

EXTERNAL CUTTING OFF

CTBH





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	HF	LF	LH	CDX	HBH	HBL	S10	CUTDIA (mm)	Clamp Screw *	Wrench
CTBHR/L1010-160	●	●	CTBT	○○○○	10	10	10	120	19.5	7.5	2	9.5	25	16	NS402W	NKY15S
CTBHR/L1212-160	●	●		○○○○	12	12	12	120	19.5	7.5	—	9.5	25	16	NS403W	NKY15S
CTBHR/L1616-160	●	●		○○○○	16	16	16	120	19.5	7.5	—	9.5	25	16	NS403W	NKY15S

* Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

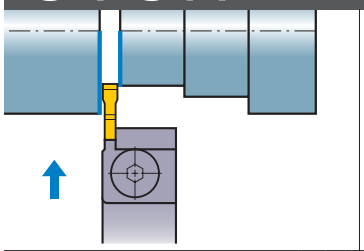
INSERTS

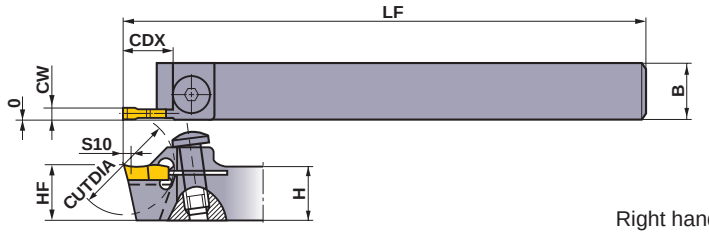
Holder	Setting Geometry	Breaker	Geometry	Insert Geometry	Order Number	Hand	Coated VP15TF	Coated NEW MS6015	CW	CDX	RER/L	L	W1	S	CUTDIA (mm)
Right Hand (R)	16°	With Breaker	EPSR 45°	REL, CDX, CW ±0.05, RER	CTBT15160V5RR-B	R	●	●	1.5	9.2	0.05	25	9.4	3.5	16
					CTBT20160V5RR-B	R	●	●	2.0	9.2	0.05	25	9.4	3.5	16
	0°			REL, CDX, CW ±0.05, RER	CTBT20160V5RN-B	N	●	●	2.0	9.2	0.05	25	9.4	3.5	16
Left Hand (L)	16°			REL, CW ±0.05, RER, CDX	CTBT20160V5LL-B	L	●		2.0	9.2	0.05	25	9.4	3.5	16
	0°			REL, CW ±0.05, RER, CDX	CTBT20160V5LN-B	N	●	●	2.0	9.2	0.05	25	9.4	3.5	16
	16°		Right hand insert shown.	REL, CW ±0.05, RER, CDX	CTBT20145V5LR-B	R	●	●	2.0	9.2	0.05	25	9.4	3.5	14.5

● = NEW

● : Inventory maintained in Japan. (5 inserts in one case)

CTCH





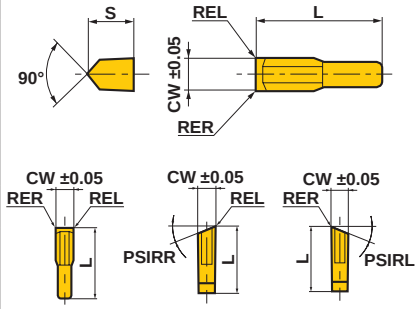
Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	HF	LF	CDX	S10	CUTDIA (mm)	Clamp Screw *	Wrench
CTCHR/L1010-200	●	●	CTCT	2○○○	10	10	10	120	11	0.5	20	NS501W	HKY25RS
CTCHR/L1212-200	●	●	CTCT	2○○○	12	12	12	120	11	0.5	20	NS501W	HKY25RS

* Clamp Torque (N • m) : NS501W=2.2

INSERTS

Breaker	Order Number	Hand	Coated VP15TF	Dimensions (mm) CW	PSIRR/L	RER/L	L	S	CUTDIA (mm)	Geometry
With Breaker	**CTCT22200V5N-B**	N	*●	2.2	0°	0.05	10	4.0	20	
	CTCT2220001N-B	N	*●	2.2	0°	0.1	10	4.0	20	
	CTCT25200V5N-B	N	*●	2.5	0°	0.05	10	4.0	20	
	CTCT2520001N-B	N	*●	2.5	0°	0.1	10	4.0	20	
	CTCT22200V5R-B	R	*●	2.2	17°	0.05	10	4.0	20	
	CTCT2220001R-B	R	*●	2.2	17°	0.1	10	4.0	20	
	CTCT25200V5R-B	R	*●	2.5	17°	0.05	10	4.0	20	
	CTCT2520001R-B	R	*●	2.5	17°	0.1	10	4.0	20	
	CTCT22200V5L-B	L	*●	2.2	17°	0.05	10	4.0	20	
	CTCT2220001L-B	L	*●	2.2	17°	0.1	10	4.0	20	
	CTCT25200V5L-B	L	*●	2.5	17°	0.05	10	4.0	20	
	CTCT2520001L-B	L	*●	2.5	17°	0.1	10	4.0	20	



Neutral (N) Right Hand (R) Left Hand (L)

* 10 inserts in one case.

RECOMMENDED CUTTING CONDITIONS

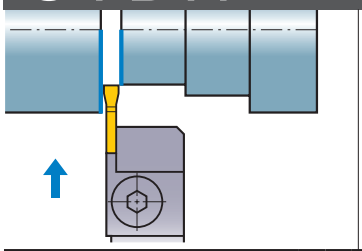
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**MS6015/VP15TF**	100 (50–150)	0.05 (0.02–0.09)
	Free Cutting Steel	–	**MS6015**	110 (30–180)	0.05 (0.01–0.09)
M	Stainless Steel	≤200HB	**VP15TF**	80 (50–120)	0.03 (0.02–0.05)
N	Non-Ferrous Metal	–	**MS6015**	150 (70–230)	0.07 (0.03–0.11)

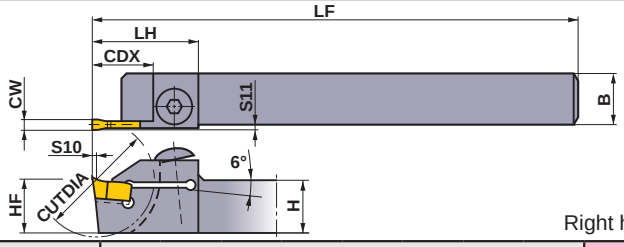
● : Inventory maintained in Japan. (10 inserts in one case)

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

EXTERNAL CUTTING OFF

CTDH





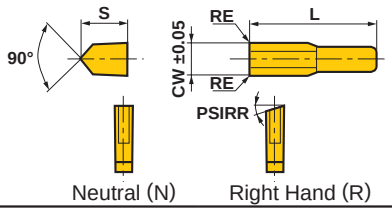
Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	HF	LF	LH	CDX	S10	S11	CUTDIA (mm)	* Clamp Screw	Wrench
CTDHR/L1616-230	●		CTDT	2535○○	16	16	16	125	24	12.2	0.5	0.5	23	HBH06020	HKY40R
CTDHR/L1616-280	●		CTDT	2535○○	16	16	16	120	25	15	0.5	0.5	28	NS502W	HKY25R
CTDHR/L1616-350	●	●	CTDT	2535○○	16	16	16	125	32	18.5	0.5	0.5	35	HBH06020	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0, NS502W=2.2

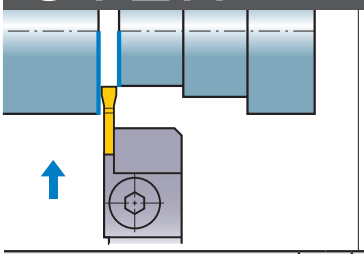
INSERTS

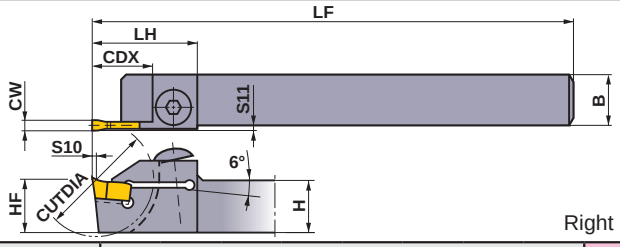
Breaker	Order Number	Hand	Coated VP15TF	Dimensions (mm) CW	PSIRR	RE	L	S	CUTDIA (mm)	Geometry
With Breaker	**CTDT2535002N-B**	N	●	2.5	0°	0.2	12	6.39	23–35	
With Breaker	**CTDT25350V5R-B**	R	●	2.5	8°	≤0.05	12	6.39	23–35	
With Breaker	**CTDT25350V5R-BS**	R	●	2.5	17°	≤0.05	12	6.39	23–35	
With Breaker	**CTDT2535002R-B**	R	●	2.5	8°	0.2	12	6.39	23–35	



● : Inventory maintained in Japan. (10 inserts in one case)

CTEH





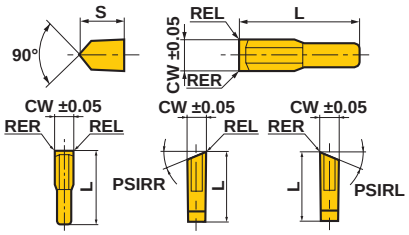
Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	HF	LF	LH	CDX	S10	S11	CUTDIA (mm)	* Clamp Screw	Wrench
CTEHR/L1616-230	●		CTET	3035○○	16	16	16	125	24	12.2	0.5	0.5	23	HBH06020	HKY40R
CTEHR/L1616-280	●			3035○○	16	16	16	120	25	15	0.5	0.5	28	NS502W	HKY25R
CTEHR/L1616-350	●	●		3035○○	16	16	16	125	32	18.5	0.5	0.5	35	HBH06020	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0, NS502W=2.2

INSERTS

Breaker	Order Number	Hand	Coated VP15TF	Dimensions (mm) CW	PSIRR/L	RER/L	L	S	CUTDIA (mm)	Geometry
With Breaker	**CTET30350V5R-B**	R	●	3	8°	≤0.05	12	6.39	23－35	
	CTET30350V5R-BS	R	●	3	17°	≤0.05	12	6.39	23－35	
	CTET3035002N-B	N	●	3	0°	0.2	12	6.39	23－35	
	CTET3035002R-B	R	●	3	8°	0.2	12	6.39	23－35	
	CTET3035002L-B	L	●	3	8°	0.2	12	6.39	23－35	



RECOMMENDED CUTTING CONDITIONS

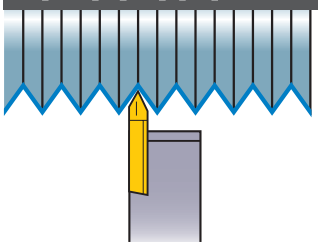
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**VP15TF**	100 (50–150)	0.05 (0.02–0.09)
	Free Cutting Steel	–	**VP15TF**	110 (30–180)	0.05 (0.01–0.09)
M	Stainless Steel	≤200HB	**VP15TF**	80 (50–120)	0.03 (0.02–0.05)
N	Non-Ferrous Metal	–	**VP15TF**	150 (70–230)	0.07 (0.03–0.11)

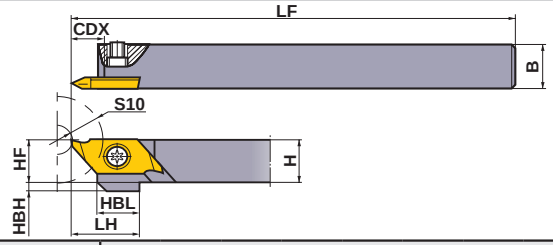
● : Inventory maintained in Japan. (10 inserts in one case)

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

EXTERNAL THREADING

TTAH





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		H	B	HF	LF	LH	HBH	HBL	CDX	S10	Clamp Screw *	Wrench
TTAHR/L0810	●	●	TTAT	○○○○	8	10	8	120	15	4	9.5	7	6.5	NS402W	NKY15S
TTAHR/L1010	●	●		○○○○	10	10	10	120	15	2	9.5	7	6.5	NS402W	NKY15S
TTAHR/L1212	●	●		○○○○	12	12	12	120	15	—	9.5	7	6.5	NS403W	NKY15S
TTAHR/L1616	●	●		○○○○	16	16	16	120	15	—	9.5	7	6.5	NS403W	NKY15S

* Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

INSERTS

Holder	Setting Geometry	Breaker	Geometry	Insert Geometry	Order Number	Hand	Coated VP15TF	Dimensions (mm) PXD	RE	L	W1	S	Pitch of Screw mm (thread/inch)
Right Hand (R)		With Breaker	General Purpose Partial Profile (60°)		TTAT60075F5RR-B	R	●	0.4	0.05 Flat	20.0	8.0	2.5	0.2—0.75 (80—36)
					TTAT60125V5RR-B	R	●	0.8	0.05	20.0	8.0	2.5	0.5—1.25 (40—16)
					TTAT60075F5RL-B	L	●	0.4	0.05 Flat	20.0	8.0	2.5	0.2—0.75 (80—36)
					TTAT60125V5RL-B	L	●	0.8	0.05	20.0	8.0	2.5	0.5—1.25 (40—16)
					TTAT6015001RN-B	N	●	1.25	0.1	20.0	8.0	2.5	1.0—1.5 (24—18)
Left Hand (L)					TTAT60075F5LR-B	R	●	0.4	0.05 Flat	20.0	8.0	2.5	0.2—0.75 (80—36)
					TTAT60125V5LR-B	R	●	0.8	0.05	20.0	8.0	2.5	0.5—1.25 (40—16)
					TTAT60075F5LL-B	L	●	0.4	0.05 Flat	20.0	8.0	2.5	0.2—0.75 (80—36)
					TTAT60125V5LL-B	L	●	0.8	0.05	20.0	8.0	2.5	0.5—1.25 (40—16)
			Right hand insert shown.		TTAT6015001LN-B	N	●	1.25	0.1	20.0	8.0	2.5	1.0—1.5 (24—18)
Right Hand (R)			General Purpose Partial Profile (55°)		TTAT55158V5RR-B	R	●	0.8	0.05	20.0	8.0	2.5	(40—16)
					TTAT55158V5RL-B	L	●	0.8	0.05	20.0	8.0	2.5	(40—16)
Left Hand (L)					TTAT55158V5LR-B	R	●	0.8	0.05	20.0	8.0	2.5	(40—16)
			Right hand insert shown.		TTAT55158V5LL-B	L	●	0.8	0.05	20.0	8.0	2.5	(40—16)

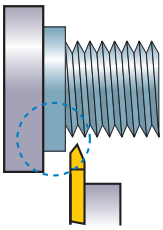
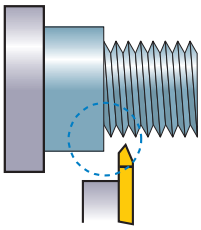
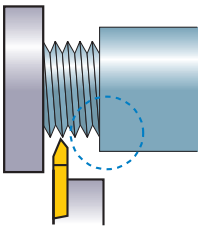
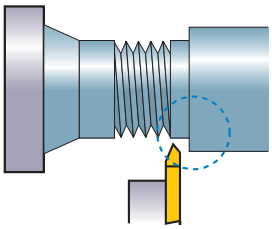
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Speed (m/min)
P	Carbon Steel · Alloy Steel	180HB—280HB	100 (50—150)
	Free Cutting Steel	—	110 (30—180)

	Work Material	Hardness	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	80 (50—120)
N	Non-Ferrous Metal	—	150 (70—230)

● : Inventory maintained in Japan. (5 inserts in one case)

HOLDER APPLICATION

	Right Hand Holder	Left Hand Holder
Right Hand Insert		
Left Hand Insert		

*The above combinations enable to machine the side of ◌.

THREAD RANGE

Application range

Pitch (mm)	Pitch Diameter of Thread (mm)										Number of Passes
	≥ϕ1.0	≥ϕ1.2	≥ϕ1.6	≥ϕ2.0	≥ϕ2.5	≥ϕ3.0	≥ϕ4.0	≥ϕ5.0	≥ϕ6.0	≥ϕ7.0	
0.2											2－4
0.25											
0.3											3－5
0.35											
0.4											4－6
0.45											
0.5											5－7
0.6											
0.7											
0.75											
0.8		Threading impossible									
1											
1.25											6－8
1.5											

*Metric Thread (60°)

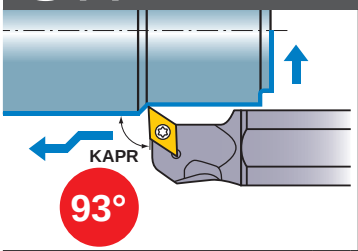
Pitch(thread/inch)	Pitch Diameter of Thread									Number of Passes
Inch	≥ϕ0.060	≥ϕ0.073	≥ϕ0.086	≥ϕ0.099	≥ϕ0.112	≥ϕ0.164	≥ϕ0.190	≥ϕ0.250	≥ϕ0.313	
mm	≥ϕ1.524	≥ϕ1.854	≥ϕ2.184	≥ϕ2.515	≥ϕ2.845	≥ϕ4.166	≥ϕ4.826	≥ϕ6.350	≥ϕ7.938	
80										3－5
72										
64										4－6
56										
48										5－7
44										
40										
32										
28										
26										
24		Threading impossible								
20										6－8
18										
16										

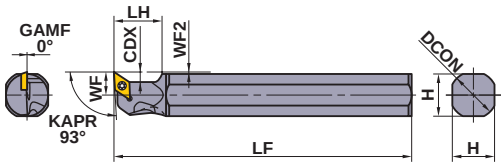
*American UN, Whitworth

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

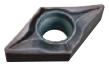
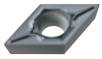
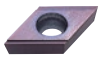
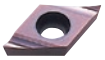
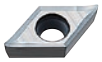
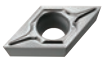
EXTERNAL FRONT TURNING, COPYING, FACING (FOR OPPOSITE TOOL POSTS)

SH





Left hand tool holder shown.

Finish	Finish	Light	Light
SMG/FS	R-F	R-SS	LS
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)
Medium	**Medium**	**For nonferrous metals**	**Light**
R-SN	R-SR	AZ	LS-P
			
(07, 11)	(07, 11)	(07, 11)	(07, 11)

Order Number	Stock L	Insert Number		Dimensions (mm) DCON	LF	LH	H	WF	WF2	CDX	* Clamp Screw	Wrench
SH16H-FSDUCL07	●	DCMT DCMW DCET DCGT DCGW	0702□□	15.875	100	20	14	7.75	0.75	4.2	TS254	TKY08R
SH19K-FSDUCL07	●			19.05	125	20	17	9.25	0.75	4.2	TS254	TKY08R
SH20K-FSDUCL07	●			20	125	20	18	9.75	0.75	4.2	TS254	TKY08R
SH22K-FSDUCL07	●			22	125	20	20	10.75	0.75	4.2	TS254	TKY08R
SH25M-FSDUCL07	●			25.4	150	20	23	12.25	0.75	4.2	TS254	TKY08R
SH16H-FSDUCL11	●	DCMT DCMW DCET DCGT DCGW	11T3□□	15.875	100	20	15	7.75	0.75	6.4	TS43	TKY15R
SH19K-FSDUCL11	●			19.05	125	20	17	9.25	0.75	6.4	TS43	TKY15R
SH20K-FSDUCL11	●			20	125	20	18	9.75	0.75	6.4	TS43	TKY15R
SH22K-FSDUCL11	●			22	125	20	20	10.75	0.75	6.4	TS43	TKY15R
SH25M-FSDUCL11	●			25.4	150	20	23	12.25	0.75	6.4	TS43	TKY15R

Note 1) When using insert with right and left hand chip breaker, please use right hand insert.
Note 2) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
* Clamp Torque (N • m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

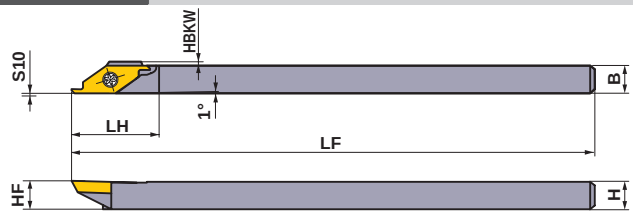
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	**MS6015/VP15TF**	100 (50–150)	0.08 (0.01–0.15)
P	Free Cutting Steel	–	**MS6015**	110 (30–180)	0.08 (0.01–0.15)
P	Free Cutting Steel	–	**NX2525**	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	**VP15TF/MP9005/MP9015**	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	**HTi10/MT9005**	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	**MT9005**	60 (40–80)	0.08 (0.04–0.12)
S	Heat Resistant Alloy	–	**MP9015**	50 (20–75)	0.08 (0.04–0.12)

● : Inventory maintained in Japan.

SH□□□ type inserts ➤ A149–A154
CBN & PCD inserts ➤ B054–B056, B073

CAM TYPE TOOL POSTS

CSVH



Right hand tool holder shown.

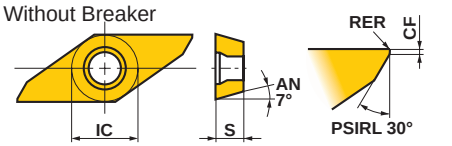
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H	B	HF	LF	HBKW	LH	S10	*1 APMX (mm)	*2 Clamp Screw	Wrench
CSVHR/L0707	●	●	CSVT	○○○○	7	7	7	140	0.5	20	0.1	3.0	NS251	NKY15S
CSVHR/L0808	●	●		○○○○	8	8	8	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L0909	●			○○○○	9.5	9.5	9.5	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L1010	●	●		○○○○	10	10	10	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L1212	●			○○○○	12	12	12	140	0	20	0.1	3.0	NS251	NKY15S

Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.
Note 2) Max. Cutting Depth (APMX) varies depending on the type of insert used.
*1 APMX : Max. Cutting Depth
*2 Clamp Torque (N • m) : NS251=1.0

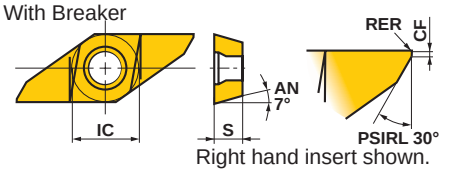
INSERTS

CSVTF — Front turning

Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	RER/L	CF	APMX * (mm)	Geometry
CSVTF30AR	R	●	6.35	2.38	0	0.3	3.0	Without Breaker
CSVTF30AL	L	●	6.35	2.38	0	0.3	3.0	
CSVTF30BR	R	●	6.35	2.38	0	0.3	3.0	
CSVTF30CR	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30DR	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30AR-B	R	●	6.35	2.38	0	0.3	3.0	With Breaker
CSVTF30AL-B	L	●	6.35	2.38	0	0.3	3.0	
CSVTF30BR-B	R	●	6.35	2.38	0	0.3	3.0	
CSVTF30CR-B	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30DR-B	R	●	6.35	2.38	0	0.15	3.0	



Right hand insert shown.

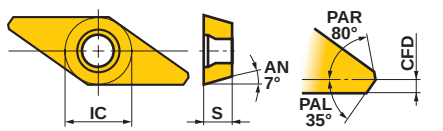


Right hand insert shown.

* APMX : Max. Cutting Depth

CSVTFXL — Front turning, Copying

Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	CFD	APMX * (mm)	Geometry
CSVTFXL	L	●	6.35	2.38	0.7	3.0	Without Breaker



* APMX : Max. Cutting Depth

● : **Inventory maintained in Japan. (5 inserts in one case)**

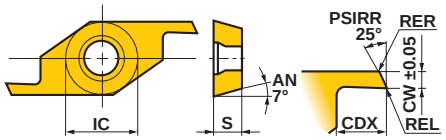
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

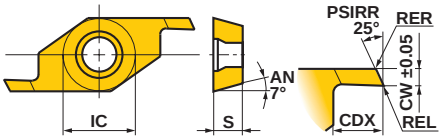
CAM TYPE TOOL POSTS

INSERTS

CSVTC — Cutting off

Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	RER/L	CDX	CW	APMX* (mm)	Geometry
CSVTC0640R	R	●	6.35	2.38	0	2.0	0.6	1.5	Without Breaker
CSVTC0750R	R	●	6.35	2.38	0	2.5	0.7	2.0	
CSVTC0750L	L	●	6.35	2.38	0	2.5	0.7	2.0	
CSVTC0850R	R	●	6.35	2.38	0	2.5	0.8	2.0	
CSVTC0850L	L	●	6.35	2.38	0	2.5	0.8	2.0	
CSVTC0950R	R	●	6.35	2.38	0	2.5	0.9	2.0	
CSVTC1060R	R	●	6.35	2.38	0	3.0	1.0	2.5	
CSVTC1060L	L	●	6.35	2.38	0	3.0	1.0	2.5	
CSVTC1360R	R	●	6.35	2.38	0	3.0	1.3	2.5	
CSVTC1360L	L	●	6.35	2.38	0	3.0	1.3	2.5	
CSVTC1560R	R	●	6.35	2.38	0	3.0	1.5	2.5	
CSVTC1560L	L	●	6.35	2.38	0	3.0	1.5	2.5	Right hand insert shown.
CSVTC0640R-B	R	●	6.35	2.38	0	2.0	0.6	1.5	With Breaker
CSVTC0750R-B	R	●	6.35	2.38	0	2.5	0.7	2.0	
CSVTC0850R-B	R	●	6.35	2.38	0	2.5	0.8	2.0	
CSVTC0950R-B	R	●	6.35	2.38	0	2.5	0.9	2.0	
CSVTC1060R-B	R	●	6.35	2.38	0	3.0	1.0	2.5	
CSVTC1360R-B	R	●	6.35	2.38	0	3.0	1.3	2.5	
CSVTC1560R-B	R	●	6.35	2.38	0	3.0	1.5	2.5	Right hand insert shown.

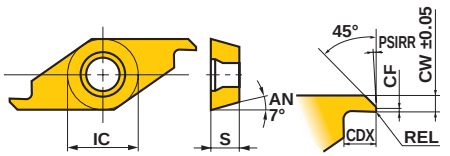


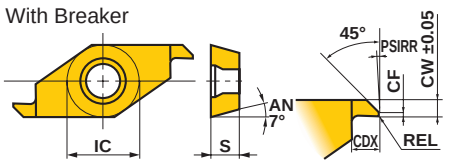


* APMX : Max. Cutting Depth

CSVTB — Back turning

Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	RER/L	CDX	CW	CF	PSIRR/L	APMX* (mm)	Geometry
CSVTB10AR	R	●	6.35	2.38	0	2.5	1	0.3	5°	2.0	Without Breaker
CSVTB10AL	L	●	6.35	2.38	0	2.5	1	0.3	5°	2.0	
CSVTB10BR	R	●	6.35	2.38	0	2.5	1	0.3	2°	2.0	
CSVTB10CR	R	●	6.35	2.38	0	2.5	1	0.15	2°	2.0	
CSVTB10DR	R	●	6.35	2.38	0	2.5	1	0.15	5°	2.0	
CSVTB12AR	R	●	6.35	2.38	0	2.5	1.2	0.3	5°	2.0	
CSVTB14AR	R	●	6.35	2.38	0	2.5	1.4	0.3	5°	2.0	Right hand insert shown.
CSVTB10AR-B	R	●	6.35	2.38	0	2.5	1	0.3	5°	2.0	With Breaker
CSVTB10BR-B	R	●	6.35	2.38	0	2.5	1	0.3	2°	2.0	
CSVTB10CR-B	R	●	6.35	2.38	0	2.5	1	0.15	2°	2.0	
CSVTB10DR-B	R	●	6.35	2.38	0	2.5	1	0.15	5°	2.0	
CSVTB12AR-B	R	●	6.35	2.38	0	2.5	1.2	0.3	5°	2.0	
CSVTB14AR-B	R	●	6.35	2.38	0	2.5	1.4	0.3	5°	2.0	Right hand insert shown.

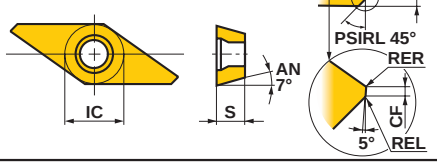




* APMX : Max. Cutting Depth

CSVTBXL — Back turning, Copying

Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	RER/L	CW	CF	APMX* (mm)	Geometry
CSVTBXL	L	●	6.35	2.38	0	0.7	0.035	3.0	Without Breaker



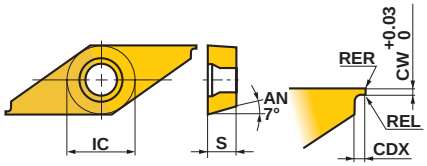
* APMX : Max. Cutting Depth

● : **Inventory maintained in Japan. (5 inserts in one case)**

INSERTS

CSVTG Grooving

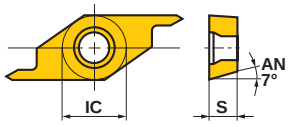
Order Number	Hand	Coated VP15KZ	Dimensions (mm) IC	S	RER/L	CDX	CW	APMX* (mm)	Geometry
CSVTG02505R	R	●	6.35	2.38	0	0.5	0.25	0.15	Without Breaker
CSVTG03005R	R	●	6.35	2.38	0	0.5	0.3	0.15	
CSVTG03505R	R	●	6.35	2.38	0	0.5	0.35	0.15	
CSVTG04005R	R	●	6.35	2.38	0	0.5	0.4	0.15	
CSVTG04510R	R	●	6.35	2.38	0	1.0	0.45	0.45	
CSVTG05010R	R	●	6.35	2.38	0	1.0	0.5	0.45	
CSVTG05510R	R	●	6.35	2.38	0	1.0	0.55	0.45	
CSVTG06010R	R	●	6.35	2.38	0	1.0	0.6	0.45	
CSVTG06510R	R	●	6.35	2.38	0	1.0	0.65	0.45	
CSVTG07010R	R	●	6.35	2.38	0	1.0	0.7	0.45	
CSVTG07520R	R	●	6.35	2.38	0	2.0	0.75	1.4	
CSVTG07520L	L	●	6.35	2.38	0	2.0	0.75	1.4	
CSVTG08020R	R	●	6.35	2.38	0	2.0	0.8	1.4	
CSVTG08520R	R	●	6.35	2.38	0	2.0	0.85	1.4	
CSVTG09020R	R	●	6.35	2.38	0	2.0	0.9	1.4	
CSVTG09520R	R	●	6.35	2.38	0	2.0	0.95	1.4	
CSVTG09520L	L	●	6.35	2.38	0	2.0	0.95	1.4	
CSVTG10020R	R	●	6.35	2.38	0	2.0	1.0	1.4	
CSVTG11030R	R	●	6.35	2.38	0	3.0	1.1	2.6	
CSVTG12030R	R	●	6.35	2.38	0	3.0	1.2	2.6	
CSVTG12030L	L	●	6.35	2.38	0	3.0	1.2	2.6	
CSVTG13030R	R	●	6.35	2.38	0	3.0	1.3	2.6	
CSVTG14030R	R	●	6.35	2.38	0	3.0	1.4	2.6	
CSVTG15030R	R	●	6.35	2.38	0	3.0	1.5	2.6	Right hand insert shown.

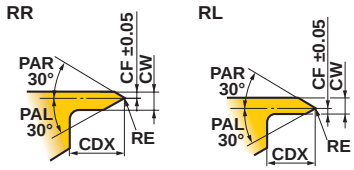


* APMX : Max. Cutting Depth

CSVTT Threading

Order Number	Hand	Coated VP15KZ	Pitch (mm)	Dimensions (mm) IC	S	RE	CDX	CW	CF	Geometry
CSVTT60050RR	R	●	0.2－0.5	6.35	2.38	0.03	3.0	1.0	0.35	Without Breaker General Purpose Partial Profile (60°)
CSVTT60050RL	L	●	0.2－0.5	6.35	2.38	0.03	3.0	1.0	0.35	



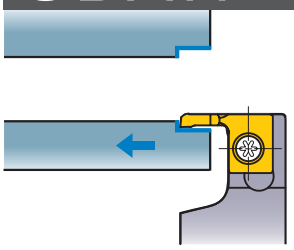


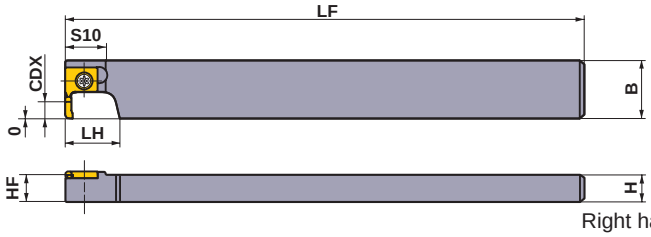
Right hand insert shown.

BORING

SBAH

Without off set





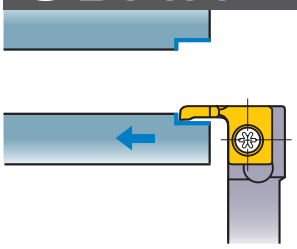
Right hand tool holder only.

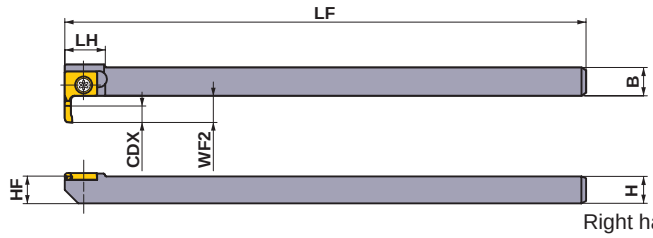
Order Number	Stock	Insert Number		Dimensions (mm)						CDX (mm)	*1 DMIN (mm)	*2 Clamp Screw	Wrench
	R			H	B	LF	HF	LH	S10				
SBAHR1022	●	SBAT	3080○○L/L-B	10	21.5	120	10	17.5	15	8	3	NS402W	NKY15S
SBAHR1222	●		3080○○L/L-B	12	21.5	120	12	17.5	15	8	3	NS403W	NKY15S

*1 DMIN : Min. Cutting Diameter
*2 Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

SBAH

With off set



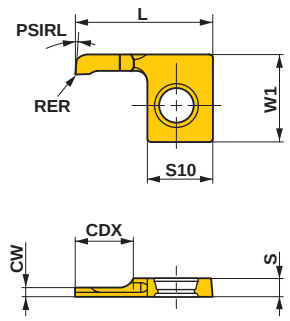


Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)						CDX (mm)	*1 DMIN (mm)	*2 Clamp Screw	Wrench
	R			H	B	LF	HF	WF2	LH				
SBAHR1010	●	SBAT	3080○○L/L-B	10	10	120	10	10	15	8	3	NS402W	NKY15S

*1 DMIN : Min. Cutting Diameter
*2 Clamp Torque (N • m) : NS402W=1.0

INSERTS

Breaker	Order Number	Coated	Dimensions (mm)								DMIN* (mm)	Geometry
		VP15KZ	PSIRL	RER	CDX	L	W1	S	CW	S10		
Without Breaker	**SBAT308000L**	●	5°	0	8.0	18.5	12.0	2.50	1.25	9.0	3	
	SBAT3080V5L	●	5°	0.05	8.0	18.5	12.0	2.50	1.25	9.0	3	
With Breaker	**SBAT308000L-B**	●	5°	0	8.0	18.5	12.0	2.50	1.25	9.0	3	
	SBAT3080V5L-B	●	5°	0.05	8.0	18.5	12.0	2.50	1.25	9.0	3	

* DMIN : Min. Cutting Diameter

● : Inventory maintained in Japan. (5 inserts in one case)

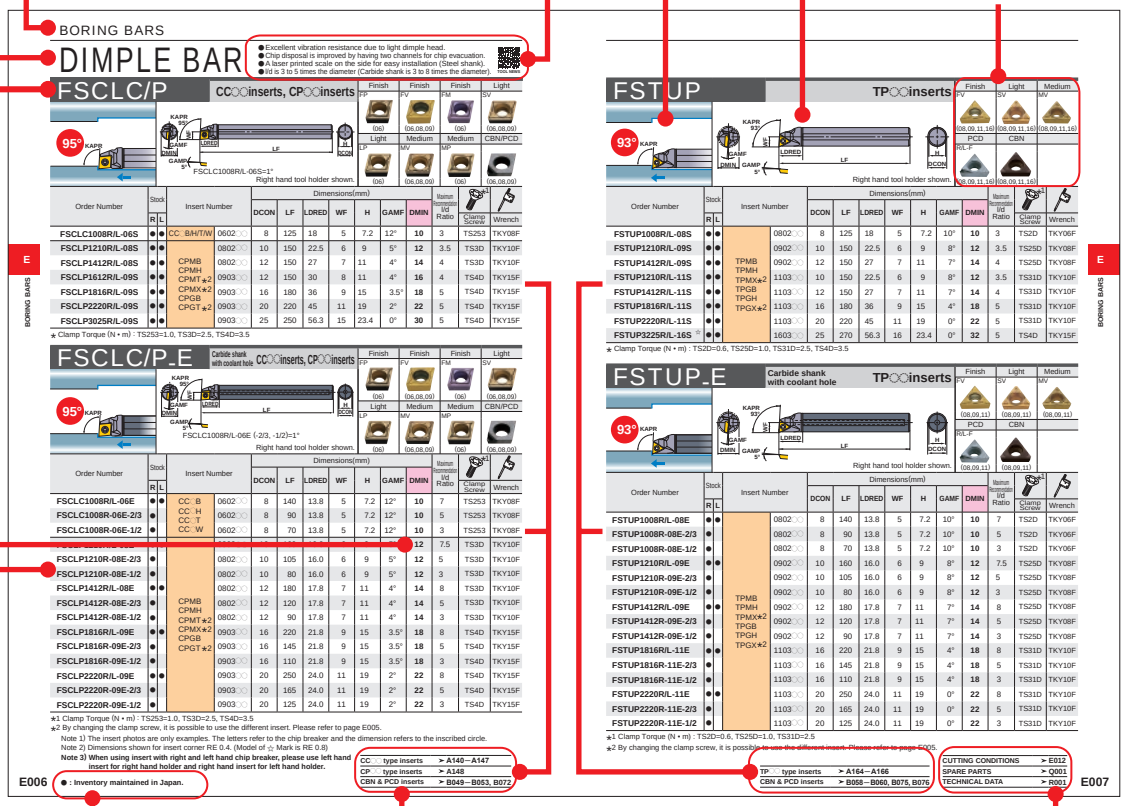
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Memo

HOW TO READ THE STANDARD OF BORING BARS

●How this section page is organised

①Organised by product series.
(Refer to the index on the next page.)



TYPE OF BORING BAR
indicates the initial letters for the order number, as well as applicable insert types.

TITLE OF PRODUCT SERIES

PRODUCT SECTION

PRODUCT FEATURES

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict available machining applications along with cutting edge lead angles.

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION

LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

REFERENCE PAGE FOR APPLICABLE INSERTS
indicates reference pages for details of inserts that are applicable to the title product.

PAGE REFERENCE
·SPARE PARTS
·TECHNICAL DATA
indicates reference pages, including the above, on the right hand page of each double-page spread.

PRODUCT STANDARDS
indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, minimum cutting diameters, standard corner radius, recommended l/d ratios, and spare parts.

MIN. CUTTING DIAMETER
is colour-coded to let you find, at a glance, the maximum / minimum cutting diameters for internal machining.

●To Order : Please specify
①order number and hand of tool (right/left).

TURNING TOOLS

BORING BARS

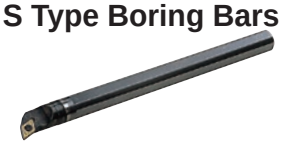
CLASSIFICATION OF BORING TOOLS ····· E002
IDENTIFICATION ····· E004

STANDARD OF BORING BARS
- FEATURES OF DIMPLE BAR ····· E005
- DIMPLE BAR ····· E006
- DOUBLE CLAMP DIMPLE BAR ····· E013
- MICRO-DEX BORING BARS ····· E016
- MICRO-MINI TWIN BORING BARS ····· E019
- MICRO-MINI BORING BARS ····· E022
- F TYPE BORING BARS ····· E025
- S TYPE BORING BARS ····· E028
- P TYPE BORING BARS ····· E035
- M TYPE BORING BARS ····· E039
- D TYPE BORING HEAD ····· E040
- AL TYPE BORING BARS ····· E043

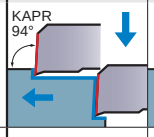
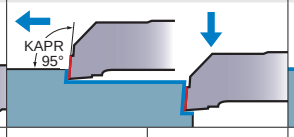
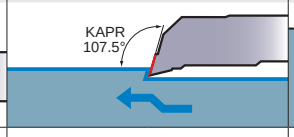
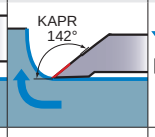
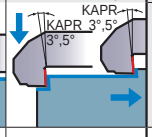
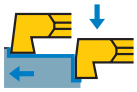
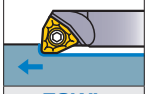
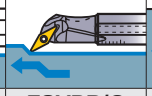
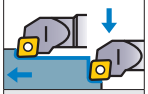
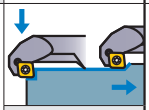
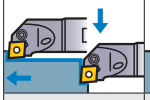
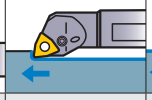
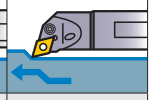
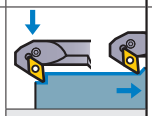
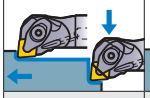
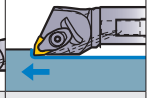
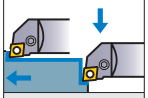
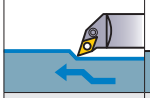
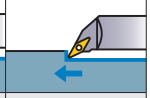
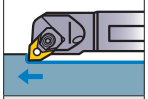
*Arranged by Alphabetical order

E013 **A□□□-DCLN**
E013 **A□□□-DDUN**
E014 **A□□□-DSKN**
E014 **A□□□-DTFN**
E015 **A□□□-DVUN**
E015 **A□□□-DWLN**
E039 **A□□□MWLN**
E036 **A□□□PCLN**
E037 **A□□□PDQN**
E036 **A□□□PDUN**
E038 **A□□□PDZN**
E035 **A□□□PSKN**
E035 **A□□□PTFN**
E037 **A□□□PWLN**
E042 **B1□□□□**
E022 **C□□□□-BLS**
E016 **C□□□SCLC**
E030 **C□□□SCLC**
E031 **C□□□SDQC**
E029 **C□□□SDUC**
E028 **C□□□STFC**
E017 **C□□□STUC**
E032 **C□□□SVQC**
E016 **C□□□SWUB**
E019 **CB**
E020 **CR**
E041 **DPCL**
E041 **DPDH**
E040 **DPDU**
E040 **DPTF**
E042 **DPVP**
E026 **FCTU1**
E026 **FCTU2**
E006 **FSCLC/P**
E009 **FSDQC**
E008 **FSDUC**
E025 **FSTU1**
E025 **FSTU2**
E007 **FSTUP**
E012 **FSVJB/C**
E011 **FSVPB/C**
E011 **FSVUB/C**
E027 **FSWL1**
E027 **FSWL2**
E010 **FSWUB/P**
E018 **RBH**
E023 **RBH**
E030 **S□□□SCLC**
E034 **S□□□SCZC**
E031 **S□□□SDQC**
E029 **S□□□SDUC**
E033 **S□□□SSKC**
E028 **S□□□STFC**
E043 **S□□□STFE**
E032 **S□□□SVQC**
E033 **S□□□SVUC**
E024 **SBH**

CLASSIFICATION

Name of Tool Holder	DMIN Minimum Cutting Diameter	Features	KAPR=75°	KAPR=91°	KAPR=93°	
			KAPR 75°	KAPR 91°	KAPR 93°	
MICRO-MINI TWIN Boring Bars	ϕ2.2 – ϕ8.2	● Solid carbide type with two cutting edges. ● Continuous cutting from boring to facing. ● With or without a chip breaker.				
MICRO-MINI Boring Bars	ϕ3.2 – ϕ5.2	● Solid carbide type (Single cutting edges). ● l/d is 5 times the diameter. ● Cutting edge can be shaped according to the application. Thus, it covers a wide cutting range (threading,grooving,copying, etc.).				
MICRO-DEX Boring Bars (Carbide Shank)	ϕ5 – ϕ8	● 7°positive insert. ● Carbide shank type. ● Easy-to-use tool geometries. ● Suitable for small workpieces. ● l/d is 5 times the diameter.			SWUB E016 STUC E017	
F Type Boring Bars	ϕ5.8 – ϕ40	● 11°positive insert. ● Screw-on type and Clamp-on type. ● l/d is 3 to 5 times the diameter. ● FSWL type is 7°positive insert.			FSTU E025 FCTU E026	
DIMPLE BAR	ϕ10 – ϕ40	● 5°, 7°, 11° positive insert. ● Excellent vibration resistance due to a light dimple head. ● l/d is 3 to 5 times the diameter (Carbide shank is 3 to 8 times the diameter).			FSTUP E007 FSDUC E008 FSVUB/C E011 FSWUB/P E010	
S Type Boring Bars 	ϕ11 – ϕ50	● ISO standard. ● 7°positive insert. ● Screw-on type. ● l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).	SSKC E033	STFC E028	SDUC E029 SVUC E033	
AL Type Boring Bars (For Aluminium Alloy)	ϕ20 – ϕ32	● Suitable for non-ferrous metal. ● 20°positive insert. ● Screw-on type. ● l/d is 6 times the diameter. ● Excellent vibration resistance.		STFE E043		
P Type Boring Bars	ϕ20 – ϕ70	● ISO standard. ● Economical negative insert. ● Lever lock type, and pin lock type. ● l/d is 3 times the diameter.	PSKN E035	PTFN E035	PDUN E036	
DOUBLE CLAMP DIMPLE BAR	ϕ32 – ϕ50	● Economical negative insert. ● Single action type. ● Excellent vibration resistance due to a light dimple head. (With coolant hole.) ● l/d is 3 to 4 times the diameter.	DSKN E014	DTFN E014	DDUN E013 DVUN E015	
D Type Boring Head	ϕ40 – ϕ60	● Economical negative insert. ● Lever lock type. ● Exchangeable head type.		DPTF E040	DPDU E040	
M Type Boring Bars	ϕ63	● Negative trigon shape insert. ● Double clamp type. ● l/d is 3 times the diameter.				

Note 1) Holders with blue colour symbol have an anti-vibration carbide shank. (For Micro-dex boring bars, carbide shank only.)
Note 2) l/d represents the ratio of the projection length L to the cutting edge and the shank diameter d.

KAPR=94°	KAPR=95°	KAPR=107.5°－117.5°	KAPR=142°	KAPR=3°,5°	Selection Standard							
					Economical	Low Cutting Resistance (Sharpness)	Clamp Rigidity	Vibration Resisiance	Operation Efficiency	Coolant Hole	Specialized	Small Diameter Cutting
	CB○○RS(-B) E019		CR E020			◎		◎*				◎
 C○○FR-BLS E022						◎						◎
	SCLC E016							◎*				◎
	 FSWL E027					○		○*				○
	FSCLC/P E006	FSDQC E009	 FSVPB/C E011	FSVJB/C E012		◎		◎*	◎	◎*		
	 SCLC E030	SDQC E031	SVQC E032		 SCZC E034		○		○*				
						◎		○			◎	
	 PCLN E036	 PWLN E037	 PDQN E037		 PDZN E038	◎		○		◎	◎		
	 DCLN E013	 DWLN E015				◎		◎		◎	◎		
	 DPCL E041		 DPDH E041	 DPVP E042		◎		○		◎			
	 MWLN E039					◎		◎		○	◎		

Note 3) ◎ : 1st recommendation. ○: 2nd recommendation.
Note 4) *Indicates that the shank material is carbide.

IDENTIFICATION

■ DIMPLE BAR

①Function	
F	Fixed type

②Clamp Structure	
S	Screw-on

③Insert Shape	
C	RHOMBIC 80°
D	RHOMBIC 55°
T	TRIANGULAR 60°
V	RHOMBIC 35°
W	TRIGON

④Cutting Angle KAPR	
U	93°
L	95°
Q	107.5°
P	117.5°
J	142°

⑤Insert Clearance	
B	5°
C	7°
P	11°

⑥Min.Cutting Diameter DMIN (mm)			
10	10	22	22
12	12	25	25
13	13	30	30
14	14	32	32
16	16	34	34
18	18	40	40
20	20		

⑦Shank Diameter DCON (mm)	
08	8
10	10
12	12
16	16
20	20
25	25
32	32

①	②	③	④	⑤	⑥	⑦	⑧		⑨	⑩		⑪
F	S	C	L	C	10	08	R	-	06	E	-	2/3

⑧Hand of Tool	
R	Right Hand
L	Left Hand

⑨Cutting Edge Length (mm)					
Inscribed circle of insert	4.76	5.56	6.35	7.94	9.525
RHOMBIC 80°	–	–	**06**	**0.8**	**09**
RHOMBIC 55°	–	–	**07**	–	**11**
TRIANGULAR 60°	**08**	**09**	**11**	–	**16**
RHOMBIC 35°	**08**	–	**11**	–	**16**
TRIGON	**L3**	–	**04**	–	**06**

⑩Shank Material	
E	Carbide Shank
S	Steel Shank

⑪ Tool Length (Carbide shank only) (mm)					
Shank Dia.	8	10	12	16	20
No symbol	140	160	180	220	250
2/3	90	105	120	145	165
1/2	70	80	90	110	125

■ ISO TYPE BORING TOOLS
[For Aluminium Alloy, P-type and S-type]

①	②	③	④	⑤	⑥	⑦	⑧	⑨
S	16	M	S	C	L	C	R	09

①Shank Material	
A	Steel Shank with Coolant Hole
C	Carbide Shank
E	Carbide Shank with Coolant Hole
S	Steel Shank

②Shank Diameter DCON (mm)	
08	8
10	10
12	12
16	16
20	20
25	25
32	32
40	40

③Tool Length LF (mm)	
F	80
H	100
K	125
M	150
Q	180
R	200
S	250
T	300
U	350
V	400

④Clamp Structure	
P	Lever Lock
S	Screw-on

⑤Insert Shape	
C	RHOMBIC 80°
D	RHOMBIC 55°
S	SQUARE 90°
T	TRIANGULAR 60°
V	RHOMBIC 35°
W	TRIGON

⑥Cutting Angle KAPR	
F	91°
K	75°
L	95°
Q	107.5°
U	93°

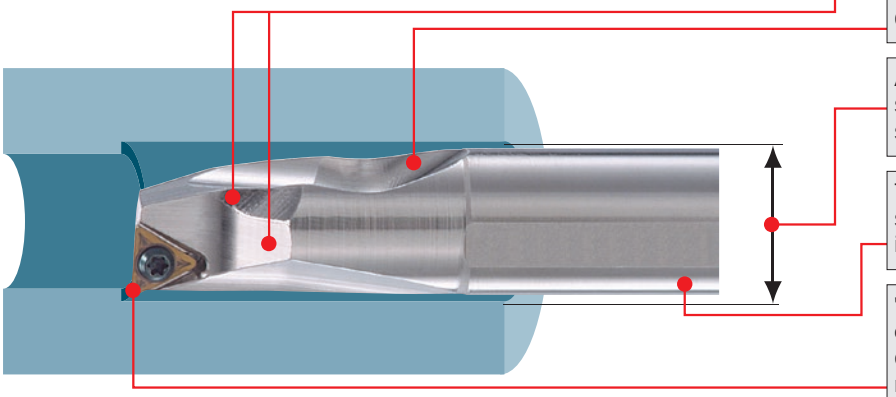
⑦Insert Clearance	
C	7°Positive
E	20°Positive
N	0°
P	11°Positive

⑧Hand of Tool	
R	Right Hand
L	Left Hand

⑨Cutting Edge Length (mm)					
Inscribed circle of insert	6.35	7.94	9.525	12.70	19.05
RHOMBIC 80°	**06**	**08**	**09**	**12**	**19**
RHOMBIC 55°	**07**	–	**11**	**15**	–
SQUARE 90°	–	–	**09**	**12**	**19**
TRIANGULAR 60°	**11**	–	**16**	**22**	–
RHOMBIC 35°	**11**	–	**16**	–	–

FEATURES OF DIMPLE BAR

Highly rigid steel shank and a lightweight head configuration designed by computer simulation analysis reduces chatter and improves the vibration damping properties.



- Chip disposal is improved by having two channels for chip evacuation.
- The lightweight head with its large dimple reduces chatter.
- Available in sizes smaller than the ISO standard. Therefore the boring of small diameter holes is possible.
- The boring bar has a laser printed scale on the shank to facilitate easy installation.
- "F and FS" breakers improves the quality of the surface finish, "MV" breaker offers excellent chip disposal. High wear resistant CBN inserts are also available for the machining of hardened materials.

■ VIBRATION RESISTANCE

●DIMPLE BAR

Weight of the Head	Damping Time
49.7g	15.8ms

By reducing the weight of the head, the damping properties are increased.

●Conventional Product

Weight of the Head	Damping Time
70.1g	20ms

* The simulation data stated above was conducted with a FSCLP1816R-09S holder, under the following conditions; l/d=5, depth of cut=0.5mm, and feed=0.05mm/rev.

■ Direction for the use of CCG/MT • CPG/MT • CPMX • TPG/MX type inserts

By changing the clamp screw, it is possible to use the inserts listed in the table below.

Holder : FSCLC/P • FSCLC/P...E

Insert Number	Clamp Screw
CCG/MT0602○○ (ϕ6.35)	Can be used as it is.
CPG/MT0802○○ (ϕ7.94)	Change to **TS3**
CPG/MT0903○○ (ϕ9.525)	Change to **TS4**
CPMX0802○○ (ϕ7.94)	Can be used as it is.
CPMX0903○○ (ϕ9.525)	Can be used as it is.

Holder : FSTUP • FSTUP...E

Insert Number	Clamp Screw
TPG/MX0802○○ (ϕ4.76)	Change to **CS200T**
TPG/MX0902○○ (ϕ5.56)	Change to **CS250T**
TPG/MX1103○○ (ϕ9.525)	Change to **CS300890T**

* If the screw is too long the please shorten as necessary.

Note 1) TPMT/W09, W11 types cannot be used due to a different clamp screw size.

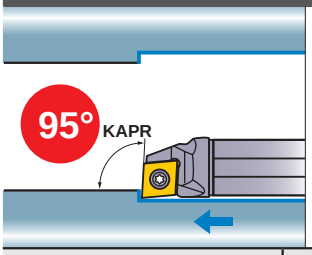
DIMPLE BAR

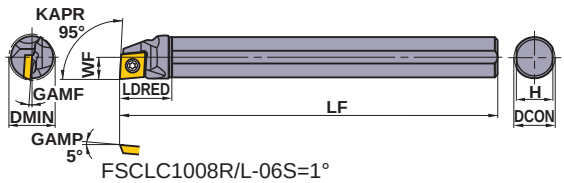
- Excellent vibration resistance due to light dimple head.
- Chip disposal is improved by having two channels for chip evacuation.
- A laser printed scale on the side for easy installation (Steel shank).
- l/d is 3 to 5 times the diameter (Carbide shank is 3 to 8 times the diameter).

TOOL NEWS

FSCLC/P

CC○○inserts, CP○○inserts





FSCLC1008R/L-06S=1°
Right hand tool holder shown.

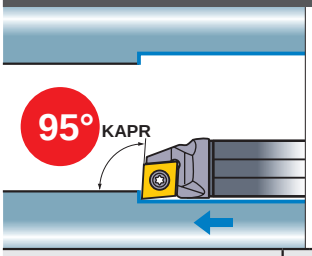
Finish	Finish	Finish	Light
FP	FV	FM	SV
(06)	(06,08,09)	(06)	(06,08,09)
Light	**Medium**	**Medium**	**CBN/PCD**
LP	MV	MP	
(06)	(06,08,09)	(06)	(06,08,09)

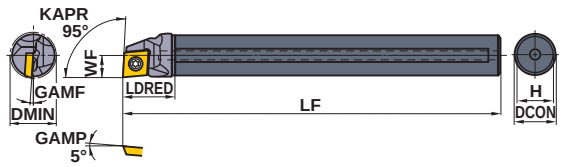
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw ⋆1	Wrench
FSCLC1008R/L-06S	●	●	CC○B/H/T/W	0602○○	8	125	18	5	7.2	12°	**10**	3	TS253	TKY08F
FSCLP1210R/L-08S	●	●	CPMB CPMH CPMT⋆2 CPMX⋆2 CPGB CPGT⋆2	0802○○	10	150	22.5	6	9	5°	**12**	3.5	TS3D	TKY10F
FSCLP1412R/L-08S	●	●		0802○○	12	150	27	7	11	4°	**14**	4	TS3D	TKY10F
FSCLP1612R/L-09S	●	●		0903○○	12	150	30	8	11	4°	**16**	4	TS4D	TKY15F
FSCLP1816R/L-09S	●	●		0903○○	16	180	36	9	15	3.5°	**18**	5	TS4D	TKY15F
FSCLP2220R/L-09S	●	●		0903○○	20	220	45	11	19	2°	**22**	5	TS4D	TKY15F
FSCLP3025R/L-09S	●	●		0903○○	25	250	56.3	15	23.4	0°	**30**	5	TS4D	TKY15F

⋆ Clamp Torque (N • m) : TS253=1.0, TS3D=2.5, TS4D=3.5

FSCLC/P_E

Carbide shank with coolant hole CC○○inserts, CP○○inserts





FSCLC1008R/L-06E (-2/3, -1/2)=1°
Right hand tool holder shown.

Finish	Finish	Finish	Light
FP	FV	FM	SV
(06)	(06,08,09)	(06)	(06,08,09)
Light	**Medium**	**Medium**	**CBN/PCD**
LP	MV	MP	
(06)	(06,08,09)	(06)	(06,08,09)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw ⋆1	Wrench
FSCLC1008R/L-06E	●	●	CC○B CC○H CC○T CC○W	0602○○	8	140	13.8	5	7.2	12°	**10**	7	TS253	TKY08F
FSCLC1008R-06E-2/3	●			0602○○	8	90	13.8	5	7.2	12°	**10**	5	TS253	TKY08F
FSCLC1008R-06E-1/2	●			0602○○	8	70	13.8	5	7.2	12°	**10**	3	TS253	TKY08F
FSCLP1210R/L-08E	●	●	CPMB CPMH CPMT⋆2 CPMX⋆2 CPGB CPGT⋆2	0802○○	10	160	16.0	6	9	5°	**12**	7.5	TS3D	TKY10F
FSCLP1210R-08E-2/3	●			0802○○	10	105	16.0	6	9	5°	**12**	5	TS3D	TKY10F
FSCLP1210R-08E-1/2	●			0802○○	10	80	16.0	6	9	5°	**12**	3	TS3D	TKY10F
FSCLP1412R/L-08E	●	●		0802○○	12	180	17.8	7	11	4°	**14**	8	TS3D	TKY10F
FSCLP1412R-08E-2/3	●			0802○○	12	120	17.8	7	11	4°	**14**	5	TS3D	TKY10F
FSCLP1412R-08E-1/2	●			0802○○	12	90	17.8	7	11	4°	**14**	3	TS3D	TKY10F
FSCLP1816R/L-09E	●	●		0903○○	16	220	21.8	9	15	3.5°	**18**	8	TS4D	TKY15F
FSCLP1816R-09E-2/3	●			0903○○	16	145	21.8	9	15	3.5°	**18**	5	TS4D	TKY15F
FSCLP1816R-09E-1/2	●			0903○○	16	110	21.8	9	15	3.5°	**18**	3	TS4D	TKY15F
FSCLP2220R/L-09E	●	●		0903○○	20	250	24.0	11	19	2°	**22**	8	TS4D	TKY15F
FSCLP2220R-09E-2/3	●			0903○○	20	165	24.0	11	19	2°	**22**	5	TS4D	TKY15F
FSCLP2220R-09E-1/2	●			0903○○	20	125	24.0	11	19	2°	**22**	3	TS4D	TKY15F

⋆1 Clamp Torque (N • m) : TS253=1.0, TS3D=2.5, TS4D=3.5
⋆2 By changing the clamp screw, it is possible to use the different insert. Please refer to page E005.

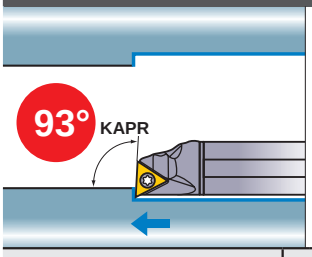
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4. (Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

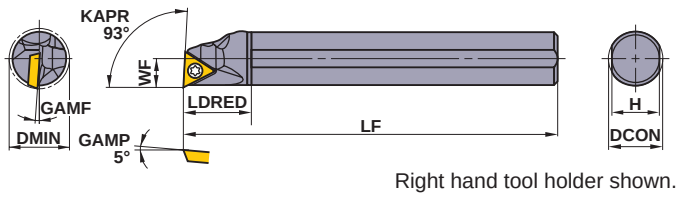
CC○○ type inserts	**➤ A140—A147**
CP○○ type inserts	**➤ A148**
CBN & PCD inserts	**➤ B049—B053, B072**

● : **Inventory maintained in Japan.**

FSTUP

TP○○inserts





Right hand tool holder shown.

Finish	Light	Medium
FV	SV	MV
(08,09,11,16)	(08,09,11,16)	(08,09,11,16)
PCD	CBN	
R/L-F		
(08,09,11,16)	(08,09,11,16)	

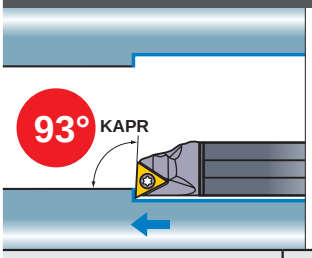
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	⋆1 Clamp Screw	Wrench
FSTUP1008R/L-08S	●	●	TPMB TPMH TPMX⋆2 TPGB TPGH TPGX⋆2	0802○○	8	125	18	5	7.2	10°	**10**	3	TS2D	TKY06F
FSTUP1210R/L-09S	●	●		0902○○	10	150	22.5	6	9	8°	**12**	3.5	TS25D	TKY08F
FSTUP1412R/L-09S	●	●		0902○○	12	150	27	7	11	7°	**14**	4	TS25D	TKY08F
FSTUP1210R/L-11S	●	●		1103○○	10	150	22.5	6	9	8°	**12**	3.5	TS31D	TKY10F
FSTUP1412R/L-11S	●	●		1103○○	12	150	27	7	11	7°	**14**	4	TS31D	TKY10F
FSTUP1816R/L-11S	●	●		1103○○	16	180	36	9	15	4°	**18**	5	TS31D	TKY10F
FSTUP2220R/L-11S	●	●		1103○○	20	220	45	11	19	0°	**22**	5	TS31D	TKY10F
FSTUP3225R/L-16S ☆	●	●		1603○○	25	270	56.3	16	23.4	0°	**32**	5	TS4D	TKY15F

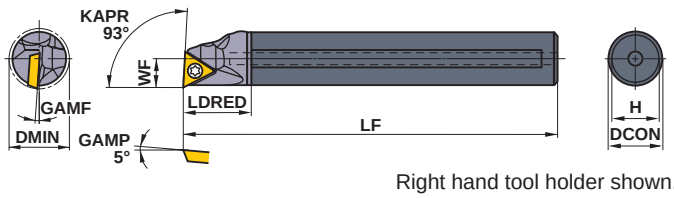
⋆ Clamp Torque (N • m) : TS2D=0.6, TS25D=1.0, TS31D=2.5, TS4D=3.5

FSTUP_E

Carbide shank with coolant hole

TP○○inserts





Right hand tool holder shown.

Finish	Light	Medium
FV	SV	MV
(08,09,11)	(08,09,11)	(08,09,11)
PCD	CBN	
R/L-F		
(08,09,11)	(08,09,11)	

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	⋆1 Clamp Screw	Wrench
FSTUP1008R/L-08E	●	●	TPMB TPMH TPMX⋆2 TPGB TPGH TPGX⋆2	0802○○	8	140	13.8	5	7.2	10°	**10**	7	TS2D	TKY06F
FSTUP1008R-08E-2/3	●			0802○○	8	90	13.8	5	7.2	10°	**10**	5	TS2D	TKY06F
FSTUP1008R-08E-1/2	●			0802○○	8	70	13.8	5	7.2	10°	**10**	3	TS2D	TKY06F
FSTUP1210R/L-09E	●	●		0902○○	10	160	16.0	6	9	8°	**12**	7.5	TS25D	TKY08F
FSTUP1210R-09E-2/3	●			0902○○	10	105	16.0	6	9	8°	**12**	5	TS25D	TKY08F
FSTUP1210R-09E-1/2	●			0902○○	10	80	16.0	6	9	8°	**12**	3	TS25D	TKY08F
FSTUP1412R/L-09E	●	●		0902○○	12	180	17.8	7	11	7°	**14**	8	TS25D	TKY08F
FSTUP1412R-09E-2/3	●			0902○○	12	120	17.8	7	11	7°	**14**	5	TS25D	TKY08F
FSTUP1412R-09E-1/2	●			0902○○	12	90	17.8	7	11	7°	**14**	3	TS25D	TKY08F
FSTUP1816R/L-11E	●	●		1103○○	16	220	21.8	9	15	4°	**18**	8	TS31D	TKY10F
FSTUP1816R-11E-2/3	●			1103○○	16	145	21.8	9	15	4°	**18**	5	TS31D	TKY10F
FSTUP1816R-11E-1/2	●			1103○○	16	110	21.8	9	15	4°	**18**	3	TS31D	TKY10F
FSTUP2220R/L-11E	●	●		1103○○	20	250	24.0	11	19	0°	**22**	8	TS31D	TKY10F
FSTUP2220R-11E-2/3	●			1103○○	20	165	24.0	11	19	0°	**22**	5	TS31D	TKY10F
FSTUP2220R-11E-1/2	●			1103○○	20	125	24.0	11	19	0°	**22**	3	TS31D	TKY10F

⋆1 Clamp Torque (N • m) : TS2D=0.6, TS25D=1.0, TS31D=2.5

⋆2 By changing the clamp screw, it is possible to use the different insert. Please refer to page E005.

TP○○ type inserts	➤ A164—A166
CBN & PCD inserts	➤ B058—B060, B075, B076

CUTTING CONDITIONS	➤ E012
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

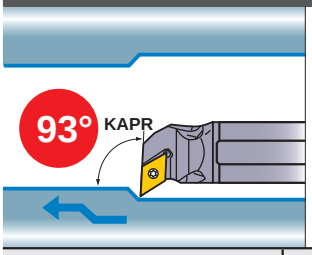
DIMPLE BAR

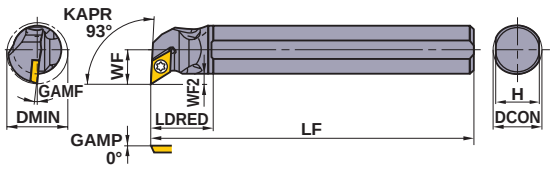
- Excellent vibration resistance due to light dimple head.
- Chip disposal is improved by having two channels for chip evacuation.
- A laser printed scale on the side for easy installation (Steel shank).
- l/d is 3 to 5 times the diameter (Carbide shank is 3 to 8 times the diameter).

TOOL NEWS

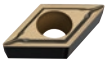
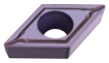
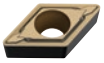
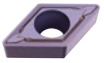
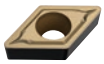
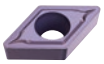
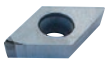
FSDUC

DC○○inserts





Right hand tool holder shown.

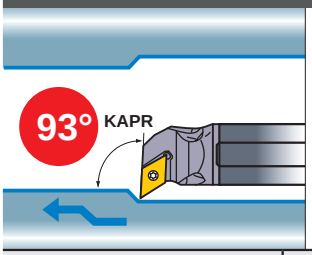
Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	**Medium**	**PCD**	**CBN**
MP	MM	R/L-F	
			
(07,11)	(07,11)	(07,11)	(07,11)

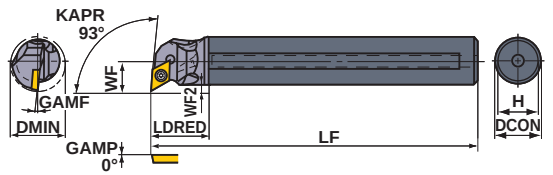
Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
					Dimensions(mm)										
FSDUC1410R/L-07S	●	●	DCMT DCMW DCGT DCGW	0702○○	10	150	18	8.3	3.3	9	7.5°	**14**	3.5	TS25	TKY08F
FSDUC1612R/L-07S	●	●		0702○○	12	150	20	9.3	3.3	11	6°	**16**	4	TS25	TKY08F
FSDUC2016R/L-07S	●	●		0702○○	16	180	20	11.3	3.3	15	5°	**20**	5	TS25	TKY08F
FSDUC3220R/L-11S☆	●	●		11T3○○	20	180	22.5	16.1	6.1	19	5°	**32**	5	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

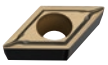
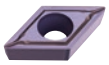
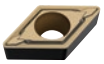
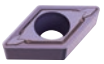
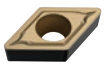
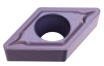
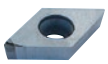
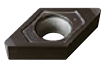
FSDUC_E

Carbide shank with coolant hole **DC○○inserts**





Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	**Medium**	**PCD**	**CBN**
MP	MM	R/L-F	
			
(07,11)	(07,11)	(07,11)	(07,11)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
					Dimensions(mm)										
FSDUC1410R/L-07E	●	●	DCMT DCMW DCGT DCGW	0702○○	10	160	16.0	8.3	3.3	9	7.5°	**14**	7.5	TS25	TKY08F
FSDUC1612R/L-07E	●	●		0702○○	12	180	17.8	9.3	3.3	11	6.0°	**16**	8	TS25	TKY08F
FSDUC2016R/L-07E	●	●		0702○○	16	220	21.8	11.3	3.3	15	5.0°	**20**	8	TS25	TKY08F
FSDUC3220R/L-11E☆	●	●		11T3○○	20	250	24.0	16.1	6.1	19	5.0°	**32**	8	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

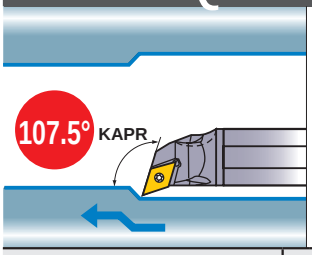
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4. (Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

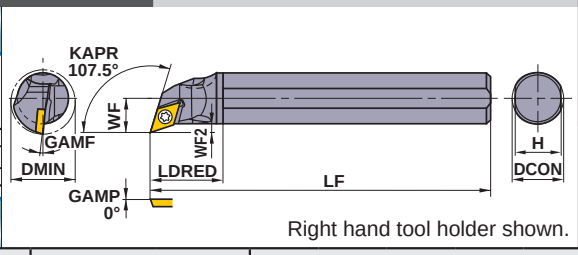
● : Inventory maintained in Japan.

DC○○ type inserts	**➤ A149—A154**
CBN & PCD inserts	**➤ B054—B056, B073**

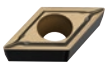
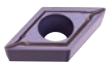
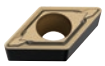
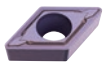
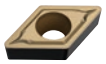
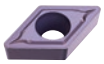
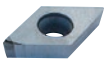
FSDQC

DC○○inserts





Right hand tool holder shown.

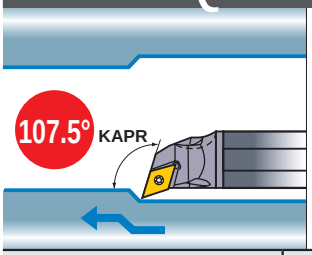
Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	PCD	CBN
MP	MM	R/L-F	
			
(07,11)	(07,11)	(07,11)	(07,11)

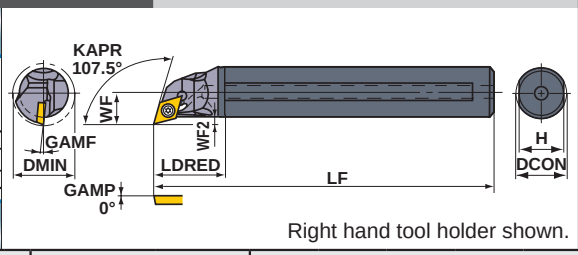
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
FSDQC1310R/L-07S	●	●	DCMT DCMW DCGT DCGW	0702○○	10	150	20.5	7.6	2.6	9	8°	**13**	3.5	TS25	TKY08F
FSDQC1612R/L-07S	●	●		0702○○	12	150	22.5	8.6	2.6	11	6°	**16**	4	TS25	TKY08F
FSDQC2016R/L-07S	●	●		0702○○	16	180	22.5	10.6	2.6	15	5°	**20**	5	TS25	TKY08F
FSDQC2520R/L-11S☆	●	●		11T3○○	20	180	26	13.7	3.7	19	7°	**25**	5	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

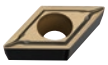
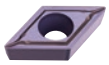
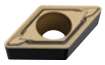
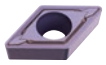
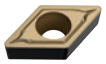
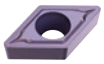
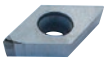
FSDQC_E

Carbide shank with coolant hole DC○○inserts





Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	PCD	CBN
MP	MM	R/L-F	
			
(07,11)	(07,11)	(07,11)	(07,11)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
FSDQC1310R/L-07E	●	●	DCMT DCMW DCGT DCGW	0702○○	10	162	18.4	7.6	2.6	9	8°	**13**	7.5	TS25	TKY08F
FSDQC1612R/L-07E	●	●		0702○○	12	182	20.2	8.6	2.6	11	6°	**16**	8	TS25	TKY08F
FSDQC2016R/L-07E	●	●		0702○○	16	222	24.2	10.6	2.6	15	5°	**20**	8	TS25	TKY08F
FSDQC2520R/L-11E☆	●	●		11T3○○	20	254	28.0	13.7	3.7	19	7°	**25**	8	TS43	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS43=3.5

DC○○ type inserts	➤ A149—A154
CBN & PCD inserts	➤ B054—B056, B073

CUTTING CONDITIONS	➤ E012
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

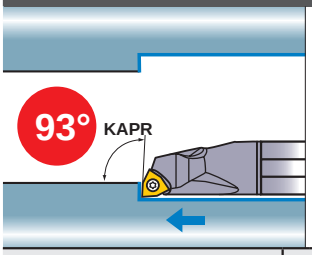
DIMPLE BAR

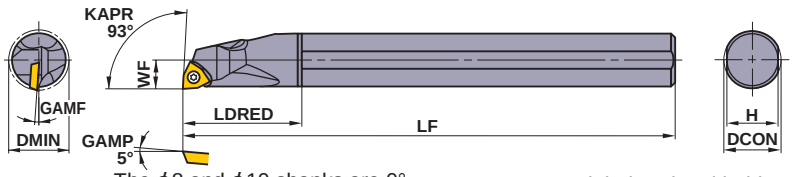
- Excellent vibration resistance due to light dimple head.
- Chip disposal is improved by having two channels for chip evacuation.
- A laser printed scale on the side for easy installation (Steel shank).
- l/d is 3 to 5 times the diameter (Carbide shank is 3 to 8 times the diameter).

TOOL NEWS

FSWUB/P

WB○○inserts, WP○○inserts





The ϕ8 and ϕ10 shanks are 0°

Right hand tool holder shown.

Finish
R/L-F·FS

(L3,04,06)
Medium
MV

(L3,04,06)

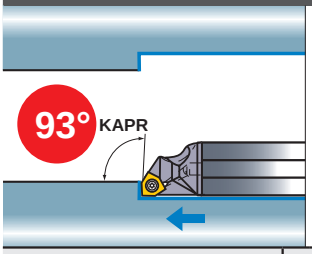
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
FSWUB1008R/L-L3S ☆1	●	●	WBMT WBGT	L302○○	8	125	18	5	7.2	14°	**10**	3	TS2	TKY06F
FSWUB1210R/L-L3S ☆1	●	●		L302○○	10	150	22.5	6	9	11°	**12**	3.5	TS2	TKY06F
FSWUP1412R/L-04S	●	●	WPMT WPGT	0402○○	12	150	27	7	11	4°	**14**	4	TS253	TKY08F
FSWUP1816R/L-04S	●	●		0402○○	16	180	36	9	15	1°	**18**	5	TS253	TKY08F
FSWUP2220R/L-06S ☆2	●	●		0603○○	20	220	45	11	19	2°	**22**	5	TS4	TKY15F
FSWUP3025R/L-06S ☆2	●	●		0603○○	25	250	56.3	15	23.4	0°	**30**	5	TS4	TKY15F

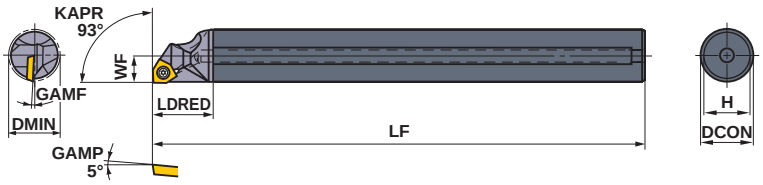
* Clamp Torque (N • m) : TS2=0.6, TS253=1.0, TS4=3.5

FSWUB/P_E

Carbide shank with coolant hole

WB○○inserts, WP○○inserts





The ϕ8 and ϕ10 shanks are 0°

Right hand tool holder shown.

Finish
R/L-F·FS

(L3,04,06)
Medium
MV

(L3,04,06)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
FSWUB1008R/L-L3E ☆1	●	●	WBMT WBGT	L302○○	8	140	13.8	5	7.2	14°	**10**	7	TS2	TKY06F
FSWUB1008R-L3E-2/3 ☆1	●			L302○○	8	90	13.8	5	7.2	14°	**10**	5	TS2	TKY06F
FSWUB1008R-L3E-1/2 ☆1	●			L302○○	8	70	13.8	5	7.2	14°	**10**	3	TS2	TKY06F
FSWUB1210R/L-L3E ☆1	●	●		L302○○	10	160	16.0	6	9	11°	**12**	7.5	TS2	TKY06F
FSWUB1210R-L3E-2/3 ☆1	●			L302○○	10	105	16.0	6	9	11°	**12**	5	TS2	TKY06F
FSWUB1210R-L3E-1/2 ☆1	●			L302○○	10	80	16.0	6	9	11°	**12**	3	TS2	TKY06F
FSWUP1412R/L-04E	●	●	WPMT WPGT	0402○○	12	180	17.8	7	11	4°	**14**	8	TS253	TKY08F
FSWUP1412R-04E-2/3	●			0402○○	12	120	17.8	7	11	4°	**14**	5	TS253	TKY08F
FSWUP1412R-04E-1/2	●			0402○○	12	90	17.8	7	11	4°	**14**	3	TS253	TKY08F
FSWUP1816R/L-04E	●	●		0402○○	16	220	21.8	9	15	1°	**18**	8	TS253	TKY08F
FSWUP1816R-04E-2/3	●			0402○○	16	145	21.8	9	15	1°	**18**	5	TS253	TKY08F
FSWUP1816R-04E-1/2	●			0402○○	16	110	21.8	9	15	1°	**18**	3	TS253	TKY08F
FSWUP2220R/L-06E ☆2	●	●		0603○○	20	250	24.0	11	19	2°	**22**	8	TS4	TKY15F
FSWUP 2220R-06E-2/3 ☆2	●			0603○○	20	165	24.0	11	19	2°	**22**	5	TS4	TKY15F
FSWUP 2220R-06E-1/2 ☆2	●			0603○○	20	125	24.0	11	19	2°	**22**	3	TS4	TKY15F

* Clamp Torque (N • m) : TS2=0.6, TS253=1.0, TS4=3.5

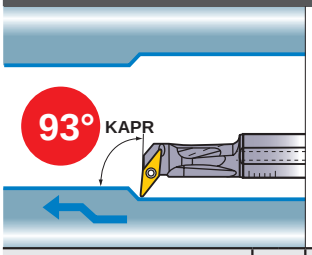
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4. (Model of ☆1 Mark is RE 0.2 , Model of ☆2 Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

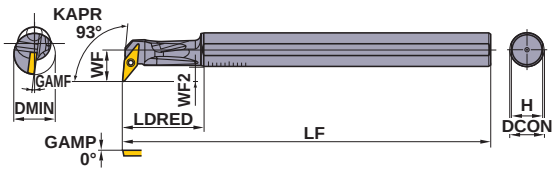
● : Inventory maintained in Japan.

WB○○ type inserts	**➤ A175**
WP○○ type inserts	**➤ A177**
PCD inserts	**➤ B078**

FSVUB/C

VC○○inserts, VB○○inserts





Right hand tool holder shown.

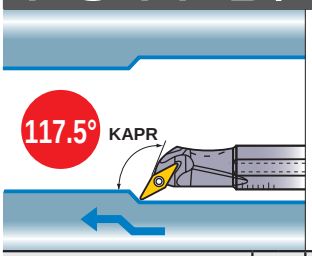
Finish	Finish	Light	Light
FP	FM	LP	LM
(11,16)	(11,16)	(11,16)	(11,16)
Medium	Medium	Medium	CBN
MP	MM	Standard	
(16)	(16)	(16)	(11,16)

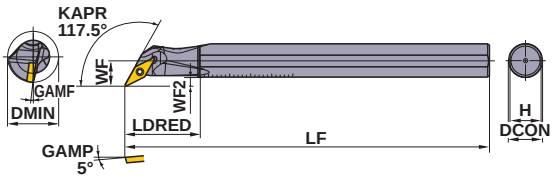
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Shim	Shim Pin	Clamp Screw *	Wrench
FSVUC1612R/L-08S	●	●	VCGT VCMT	0802○○	12	150	25	11	5.5	11	8°	**16**	4	–	–	TS202	TKY06F
FSVUB2016R/L-11S	●	●	VBMT VBMW VBET VBGW	1103○○	16	180	32.5	15.5	8	15	8°	**20**	5	–	–	TS255	TKY08F
FSVUB2520R/L-11S	●	●		1103○○	20	200	40.5	17.5	8	19	7°	**25**	5	–	–	TS255	TKY08F
FSVUB3425R/L-16S☆2	●	●		1604○○	25	220	50	20.5	8.5	23.4	13°	**34**	5	SPSVN32	BCP141	TS35D	TKY15F
FSVUB4032R/L-16S☆2	●	●		1604○○	32	250	84.0	27.5	12	30.4	9°	**40**	5	SPSVN32	BCP141	TS35D	TKY15F

* Clamp Torque (N • m) : TS202=0.6, TS255=1.0, TS35D=3.5

FSVPB/C

VC○○inserts, VB○○inserts





Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
(11,16)	(11,16)	(11,16)	(11,16)
Medium	Medium	Medium	CBN
MP	MM	Standard	
(16)	(16)	(16)	(11,16)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Shim	Shim Pin	Clamp Screw *	Wrench
FSVPC1610R/L-08S	●	●	VCGT VCMT	0802○○	10	150	25	8	3	9	8°	**16**	3.5	–	–	TS202	TKY06F
FSVPB2012R/L-11S	●	●	VBMT VBMW VBET VBGW	1103○○	12	150	28	10	4.5	11	8°	**20**	4	–	–	TS255	TKY08F
FSVPB2516R/L-11S	●	●		1103○○	16	180	35	12.5	5	15	5°	**25**	5	–	–	TS255	TKY08F
FSVPB3020R/L-11S	●	●		1103○○	20	200	40	15	5	19	5°	**30**	5	–	–	TS255	TKY08F
FSVPB3425R/L-16S☆2	●	●		1604○○	25	220	50	17	5	23.4	13°	**34**	5	SPSVN32	BCP141	TS35D	TKY15F
FSVPB4032R/L-16S☆2	●	●		1604○○	32	250	55	22	6.5	30.4	9°	**40**	5	SPSVN32	BCP141	TS35D	TKY15F

* Clamp Torque (N • m) : TS202=0.6, TS255=1.0, TS35D=3.5

VB○○ type inserts	➤ A167—A169
VC○○ type inserts	➤ A170—A172
CBN & PCD inserts	➤ B061, B077

CUTTING CONDITIONS	➤ E012
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

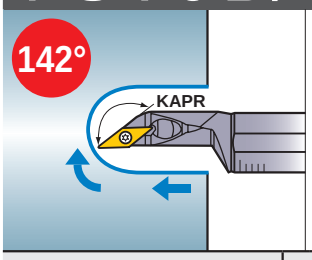
DIMPLE BAR

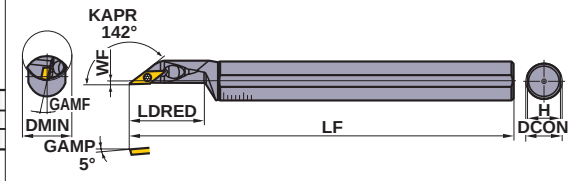
- Excellent vibration resistance due to light dimple head.
- Chip disposal is improved by having two channels for chip evacuation.
- A laser printed scale on the side for easy installation (Steel shank).
- l/d is 3 to 5 times the diameter.

TOOL NEWS

FSVJB/C

VC○○inserts, VB○○inserts





Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
(11)	(11)	(11)	(11)
Medium			
MV			
(08,11)			

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Maximum Recommendation l/d Ratio	Clamp Screw *	Wrench
					Dimensions(mm)									
FSVJC1612R/L-08S ☆	●	●	VCGT VCMT	0802○○	12	150	26	2	11	5°	**16**	4	TS202	TKY06F
FSVJC2016R/L-08S ☆	●	●		0802○○	16	180	36	2	15	5°	**20**	5	TS202	TKY06F
FSVJB2520R/L-11S ☆	●	●	VBMT VBMW VBET VBGW	1103○○	20	200	37.5	2	19	5°	**25**	5	TS255	TKY08F
FSVJB3025R/L-11S ☆	●	●		1103○○	25	250	45	3.5	23.4	5°	**30**	5	TS255	TKY08F

* Clamp Torque (N • m) : TS202=0.6, TS255=1.0

E

BORING BARS

RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Mode	Breaker	Recom-mendation	Grade	Cutting Speed (m/min)	l/d ≤ 3 (Steel shank) l/d ≤ 6 (Carbide shank) Feed (mm/rev)	Depth of Cut (mm)	l/d = 4–5 (Steel shank) l/d = 7–8 (Carbide shank) Feed (mm/rev)	Depth of Cut (mm)
P	Mild Steel ≤180HB	Finish	**FP**	①	**NX2525**	170 (120–220)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	**LP**	①	**MP3025**	150 (100–200)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	**NX2525**	160 (110–210)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	**MP**	①	**MP3025**	140 (90–190)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
				②	**NX2525**	150 (100–200)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
	Carbon Steel Alloy Steel 180–350HB	Finish	**FP**	①	**MC6015**	140 (90–190)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
				②	**NX2525**	130 (80–180)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	**LP**	①	**MC6025**	140 (90–190)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	**MP3025**	110 (60–160)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	**MP**	①	**MC6025**	130 (80–180)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
				②	**MP3025**	100 (60–150)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
M	Stainless Steel ≤200HB	Finish	**FM**	①	**VP15TF**	150 (110–190)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	**LM**	①	**MC7025**	125 (85–165)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	**VP15TF**	130 (90–170)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	**MM**	①	**MC7025**	105 (70–135)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.0
				②	**VP15TF**	120 (80–160)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.0
K	Gray Cast Iron Tensile Strength ≤350MPa	Finish	**F, FS**	①	**HTi10**	130 (90–160)	0.15 (0.10–0.20)	–0.5	0.15 (0.10–0.20)	–0.5
		Medium	**MK**	①	**MC5015**	90 (60–120)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.5
N	Aluminium Alloy	Finish	**F, FS**	①	**HTi10**	300 (200–400)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
			Flat Top	①	**MD220**	200 (150–250)	0.10 (0.05–0.15)	–2.0	0.10 (0.05–0.15)	–1.0
H	Hardened Steel 35–65HRC	Finish	**Flat Top**	①	**MB8120**	100 (80–200)	0.10 (0.05–0.15)	–0.15	0.10 (0.05–0.15)	–0.1

When vibrations occur, reduce cutting speed by 30%.
The depth of cut needs to be less than the corner diameter when using the FSVJ type.

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.(Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

● : Inventory maintained in Japan.

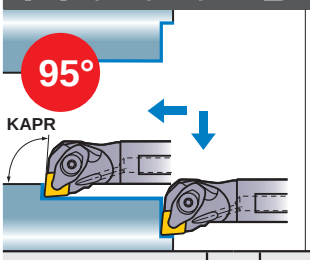
VB○○ type inserts	**➤ A167–A169**
VC○○ type inserts	**➤ A170–A172**
CBN & PCD inserts	**➤ B061, B062, B077**

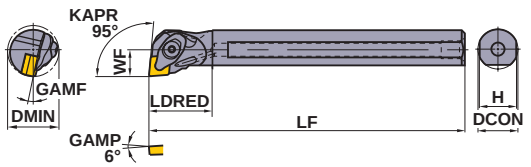
DOUBLE CLAMP DIMPLE BAR

- Economical negative insert.
- Single action type.
- Excellent vibration resistance due to a light dimple head. (With coolant hole.)
- l/d is 3 to 4 times the diameter.

A○○○-DCLN

With coolant hole **CN○○inserts**





Right hand tool holder shown.

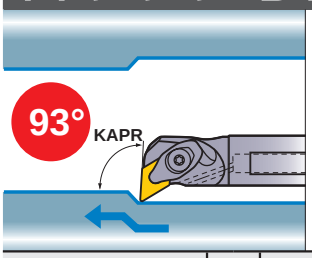
Finish	Light	Light	Light
FP	SA	LP	LM
(12)	(12)	(12)	(12)
Medium	**Medium**	**Stainless**	**CBN/PCD**
MP	Standard	MM	
(12)	(12)	(12)	(12)

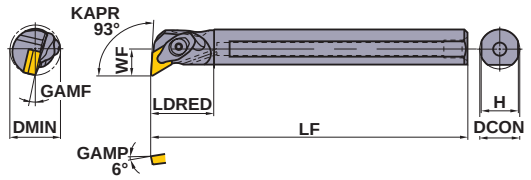
Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
					Dimensions(mm)												
A25R-DCLNR/L12	●	●	CN○A	1204○○	25	200	40	17	23	13°	32	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A32S-DCLNR/L12	●	●	CN○G	1204○○	32	250	50	22	30	13°	40	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A40T-DCLNR/L12	●	●	CN○M	1204○○	40	300	63	27	37	10°	50	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

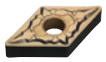
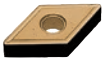
A○○○-DDUN

With coolant hole **DN○○inserts**





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MH
			
(15)	(15)	(15)	(15)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
			
(15)	(15)	(15)	(15)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
					Dimensions(mm)												
A25R-DDUNR/L15	●	●	DN○A	1504○○	25	200	40	17	23	13°	35	LLSDP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A32S-DDUNR/L15	●	●	DN○G	1504○○	32	250	50	22	30	13°	40	LLSDN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A40T-DDUNR/L15	●	●	DN○M	1504○○	40	300	63	27	37	10°	50	LLSDN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3–4 Cutting Speed (m/min)	l/d=3–4 Feed (mm/rev)	l/d=3–4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Medium	110 (80–140)	0.25 (0.1–0.4)	–5.0	110 (80–140)	0.2 (0.1–0.3)	–4.0
M	Stainless Steel	≤200HB	Medium	80 (60–100)	0.2 (0.1–0.3)	–4.0	70 (50–100)	0.15 (0.1–0.25)	–3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium	80 (60–100)	0.25 (0.1–0.4)	–5.0	80 (60–100)	0.2 (0.1–0.3)	–4.0

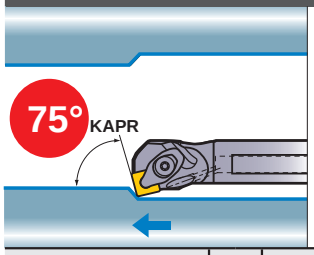
CN○○ type inserts	➤ A100–A106
DN○○ type inserts	➤ A107–A113
CBN & PCD inserts	➤ B028–B031, B068

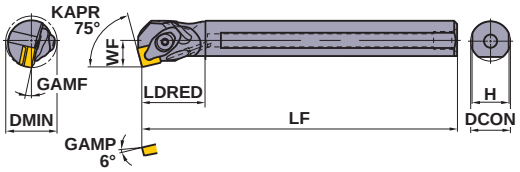
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

DOUBLE CLAMP DIMPLE BAR

- Economical negative insert.
- Single action type.
- Excellent vibration resistance due to a light dimple head. (With coolant hole.)
- l/d is 3 to 4 times the diameter.

A○○○-DSKN With coolant hole SN○○inserts





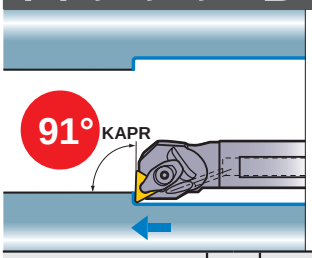
Right hand tool holder shown.

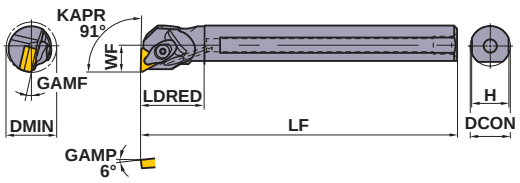
Finish	Light	Medium	Medium
FP	LP	MP	MH
(12)	(12)	(12)	(12)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(12)	(12)	(12)	(12)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
A25R-DSKNR/L12	●	●	SNMA SNMG SNMM SNGA SNGG	1204○○	25	200	40	17	23	13°	32	LLSSP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A32S-DSKNR/L12	●	●		1204○○	32	250	50	22	30	13°	40	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

A○○○-DTFN With coolant hole TN○○inserts





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MH
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
A25R-DTFNR/L16	●	●	TN○A TN○G TN○M	1604○○	25	200	40	17	23	13°	32	LLSTP32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
A32S-DTFNR/L16	●	●		1604○○	32	250	50	22	30	13°	40	LLSTN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F

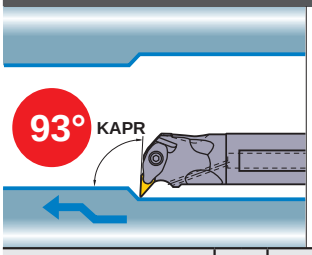
* Clamp Torque (N • m) : DC0520T=3.5

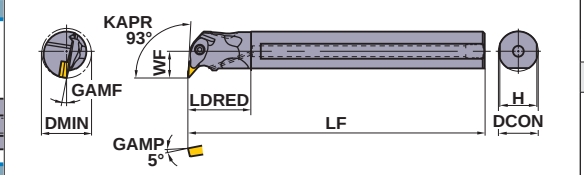
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.8.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

● : Inventory maintained in Japan.

SN○○ type inserts	**➤ A115—A120**
TN○○ type inserts	**➤ A121—A127**
CBN & PCD inserts	**➤ B037—B041, B069**

A○○○-DVUN With coolant hole VN○○inserts





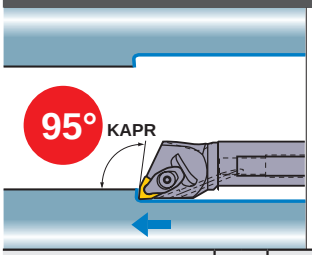
Right hand tool holder shown.

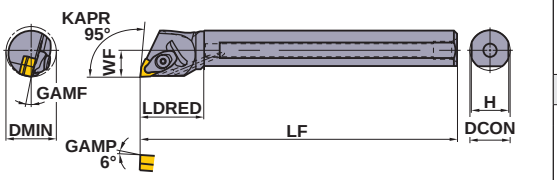
Finish	Light	Medium	Medium
FP	LP	MP	MH
(16)	(16)	(16)	(16)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock R	Stock L	Insert Number	DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
				Dimensions(mm)												
A40T-DVUNR/L16	●	●	VN○A VN○G VN○M 1604○○	40	300	63	27	37	9°	50	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F

* Clamp Torque (N • m) : DC0520T=3.5

A○○○-DWLN With coolant hole WN○○inserts





Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
(08)	(06, 08)	(06,08)	(08)
Medium	**Medium — Rough**	**Stainless**	
Standard	RP	MM	
(08)	(08)	(06,08)	

Order Number	Stock R	Stock L	Insert Number	DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
				Dimensions(mm)												
A25R-DWLNR/L06	●	●	WNMA WNMG 0604○○	25	200	40	17	23	13°	35	LLSWP32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
A25R-DWLNR/L08	●	●	WNMA 0804○○	25	200	40	17	23	13°	35	LLSWP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A32S-DWLNR/L08	●	●	WNMG 0804○○	32	250	50	22	30	13°	40	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A40T-DWLNR/L08	●	●	WNGA 0804○○	40	300	63	27	37	10°	50	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0520T=3.5, DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3—4 Cutting Speed (m/min)	l/d=3—4 Feed (mm/rev)	l/d=3—4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M	Stainless Steel	≤200HB	Medium	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

VN○○ type inserts	➤ A128—A131
WN○○ type inserts	➤ A132—A136
CBN & PCD inserts	➤ B042—B044, B070

SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

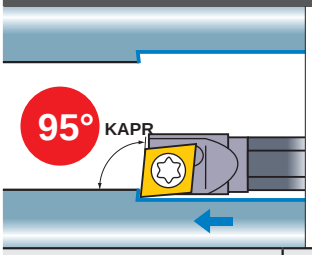
MICRO-DEX BORING BARS

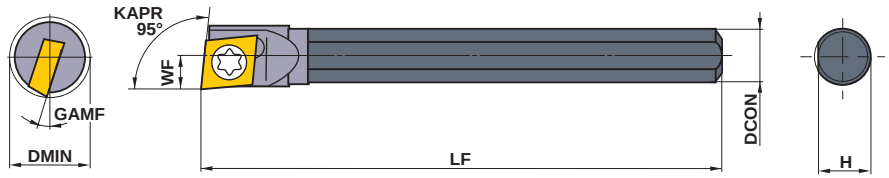
- The minimum cutting diameter is from ϕ5.
- 7° positive insert, carbide shank type.
- Easy-to-use tool geometries.
- Suitable for small workpieces.
- l/d is 5 times the diameter.

TOOL NEWS

C○○○SCLC

Carbide shank — **CC○○inserts**





Right hand tool holder shown.

Finish: L-F

(03,04)

CBN/PCD

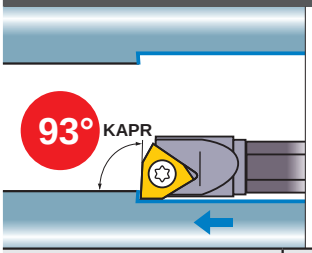
(03,04)

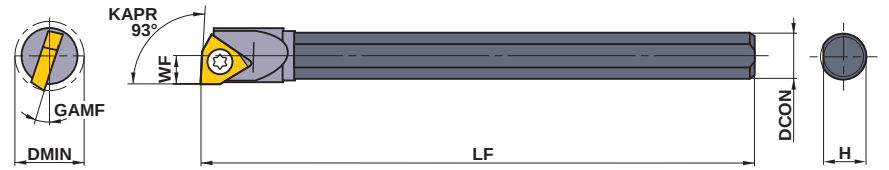
Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	H	GAMF	DMIN	*2 Clamp Screw	Wrench
C04GSCLCR03	●	*1 CCGT CCGW CCMW	03S1○○	4	90	2.5	3.7	15°	**5**	TS16	TKY06F
C05HSCLCR03	●		03S1○○	5	100	3.0	4.7	13°	**6**	TS16	TKY06F
C06JSCLCR04	●		04T0○○	6	110	3.5	5.7	13°	**7**	TS21	TKY06F
C07KSCLCR04	●		04T0○○	7	125	4.0	6.7	11°	**8**	TS21	TKY06F

*1 Diameter of inscribed circle is special. (For SCLC type)
*2 Clamp Torque (N • m) : TS16=0.6, TS21=0.6

C○○○SWUB

Carbide shank — **WB○○ inserts**





Right hand tool holder shown.

Finish: L-F

(02,L3)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	H	GAMF	DMIN	* Clamp Screw	Wrench
C05HSWUBR02	●	WBGT WBMT	0201○○L-F	5	100	3.0	4.7	15°	**6**	TS21	TKY06F
C06JSWUBR02	●		0201○○L-F	6	110	3.5	5.7	13°	**7**	TS2C	TKY06F
C07KSWUBRL3	●		L302○○L-F	7	125	4.0	6.7	15°	**8**	TS2	TKY06F

* Clamp Torque (N • m) : TS21=0.6, TS2C=0.6, TS2=0.6

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.2.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

● : Inventory maintained in Japan.

CCGT type inserts	**➤ A141**
WBGT type inserts	**➤ A175**
CBN inserts	**➤ B051, B052**

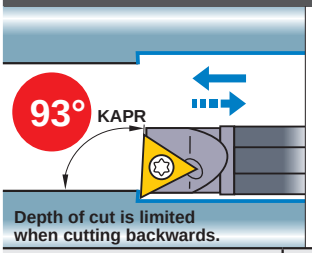
COOOSTUC

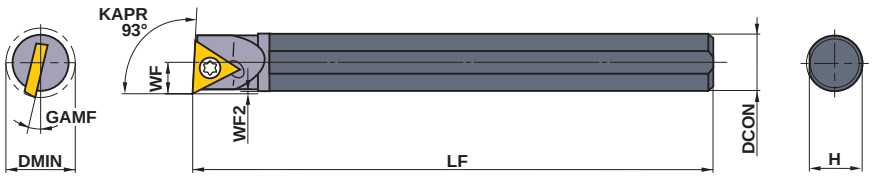
Carbide shank

TCGT inserts

Finish R/L-F

(06)





Right hand tool holder only.

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	WF2	H	GAMF	DMIN	* Clamp Screw	Wrench
C07KSTUCR06	●	TCGT	0601○○	7	125	4.0	0.35	6.7	12°	**8**	TS2C	TKY06F

* Clamp Torque (N • m) : TS2C=0.6

E

BORING BARS

RECOMMENDED CUTTING CONDITIONS

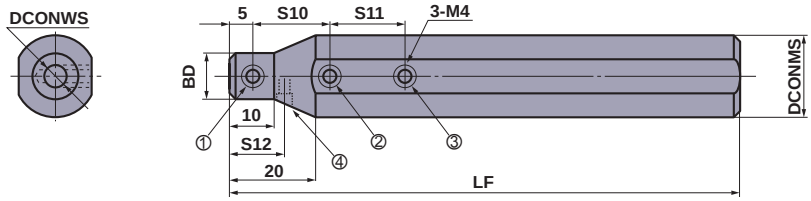
	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d
P	Carbon Steel, Alloy Steel 180–350HB	**NX2525**	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
M	Stainless Steel ≤200HB	**VP15TF**	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
K	Gray Cast Iron ≤350MPa	**VP15TF**	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
N	Non-Ferrous Meterial	**VP15TF**	120 (80–160)	0.05 (0.01–0.08)	0.4 (0.1–0.6)	3–5
		MD220	120 (80–160)	0.05 (0.01–0.08)	0.4 (0.1–0.6)	3–5
H	Hardened Steel 35–65HRC	**MB8110**	80 (40–120)	0.03 (0.01–0.05)	0.1 (0.03–0.2)	3–5

TCGT type inserts ➢ **A160**
SPARE PARTS ➢ **Q001**
TECHNICAL DATA ➢ **R001**

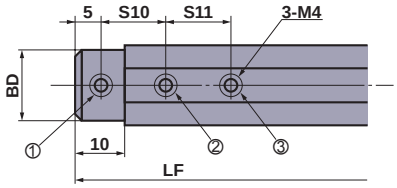
MICRO-DEX BORING BARS

TOOL NEWS

STANDARD HOLDER



RBH22○○N has a temporary set screw for different machine specifications.
(Represented by number 4)



RBH158○○N, RBH16○○N,
RBH190○○N

Order Number	Stock	Dimensions(mm)							MICRO-DEX	⋆Clamp Screw				Wrench	Torque (N • m)
		DCONMS	DCONWS	BD	LF	S10	S11	S12		①	②	③	④		
RBH15840N	●	15.875	4	15	100	15	15	—	C04GS○○○R○○	A	A	A	—	HKY20F	2.0
RBH15850N	●	15.875	5	15	100	15	15	—	C05HS○○○R○○	A	A	A	—	HKY20F	2.0
RBH15860N	●	15.875	6	15	100	15	15	—	C06JS○○○R○○	A	A	A	—	HKY20F	2.0
RBH15870N	●	15.875	7	15	100	20	20	—	C07KS○○○R○○	A	A	A	—	HKY20F	2.0
RBH1640N	●	16	4	15	100	15	15	—	C04GS○○○R○○	A	A	A	—	HKY20F	2.0
RBH1650N	●	16	5	15	100	15	15	—	C05HS○○○R○○	A	A	A	—	HKY20F	2.0
RBH1660N	●	16	6	15	100	15	15	—	C06JS○○○R○○	A	A	A	—	HKY20F	2.0
RBH1670N	●	16	7	15	100	20	20	—	C07KS○○○R○○	A	A	A	—	HKY20F	2.0
⋆2 RBH19040N	●	19.05	4	18	125	15	15	—	C04GS○○○R○○	B	B	B	—	HKY20F	2.0
⋆2 RBH19050N	●	19.05	5	18	125	15	15	—	C05HS○○○R○○	B	B	B	—	HKY20F	2.0
⋆2 RBH19060N	●	19.05	6	18	125	15	15	—	C06JS○○○R○○	B	B	B	—	HKY20F	2.0
⋆2 RBH19070N	●	19.05	7	18	125	20	20	—	C07KS○○○R○○	B	B	B	—	HKY20F	2.0
RBH2040N	●	20	4	13	125	15	15	—	C04GS○○○R○○	A	B	B	—	HKY20F	2.0
RBH2050N	●	20	5	14	125	15	15	—	C05HS○○○R○○	A	B	B	—	HKY20F	2.0
RBH2060N	●	20	6	15	125	15	15	—	C06JS○○○R○○	A	B	B	—	HKY20F	2.0
RBH2070N	●	20	7	16	125	20	20	—	C07KS○○○R○○	A	B	B	—	HKY20F	2.0
RBH2240N	●	22	4	13	125	15	15	12.5	C04GS○○○R○○	A	B	B	A	HKY20F	2.0
RBH2250N	●	22	5	14	125	15	15	12.5	C05HS○○○R○○	A	B	B	A	HKY20F	2.0
RBH2260N	●	22	6	15	125	15	15	15	C06JS○○○R○○	A	B	B	A	HKY20F	2.0
RBH2270N	●	22	7	16	125	20	20	15	C07KS○○○R○○	A	B	B	A	HKY20F	2.0
RBH2540N	●	25	4	13	150	15	15	—	C04GS○○○R○○	A	C	C	—	HKY20F	2.0
RBH2550N	●	25	5	14	150	15	15	—	C05HS○○○R○○	A	C	C	—	HKY20F	2.0
RBH2560N	●	25	6	15	150	15	15	—	C06JS○○○R○○	A	C	C	—	HKY20F	2.0
RBH2570N	●	25	7	16	150	20	20	—	C07KS○○○R○○	A	C	C	—	HKY20F	2.0
RBH25440N	●	25.4	4	13	150	15	15	—	C04GS○○○R○○	A	C	C	—	HKY20F	2.0
RBH25450N	●	25.4	5	14	150	15	15	—	C05HS○○○R○○	A	C	C	—	HKY20F	2.0
RBH25460N	●	25.4	6	15	150	15	15	—	C06JS○○○R○○	A	C	C	—	HKY20F	2.0
RBH25470N	●	25.4	7	16	150	20	20	—	C07KS○○○R○○	A	C	C	—	HKY20F	2.0

⋆1 Order number of clamp screw A=HSS04004, B=HSS04006, C=HSS04008
⋆2 Revised order number.

Conventional Order Number	Revised Order Number
RBH1940N	RBH19040N
RBH1950N	RBH19050N
RBH1960N	RBH19060N
RBH1970N	RBH19070N

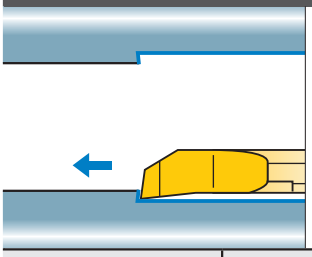
● : Inventory maintained in Japan. (MICRO-MINI TWIN is available in 1 piece in one pack.)

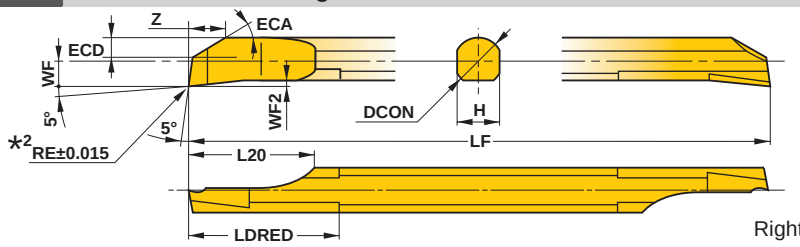
MICRO-MINI TWIN

TOOL NEWS

CB

For internal machining





Right hand tool only.

Order Number	Stock: Micro Grain TF15	Stock: Coated VP15TF	Breaker	DMIN*1 l/d ≤ 3	DMIN*1 l/d>3	RE	DCON	LF	L20	LDRED	WF	WF2	H	Z
CB02RS	●	●	without	2.2	3.6	0.05	2	50	5	6	1	0.25	1.8	1.4
CB02RS-B	●	●	with	2.2	3.9	0.05	2	50	5	6	1	0.25	1.8	1.4
CB02RS-01	●	●	without	2.2	3.6	0.1	2	50	5	6	1	0.25	1.8	1.4
CB02RS-01B	●	●	with	2.2	4.2	0.1	2	50	5	6	1	0.25	1.8	1.4
CB02RS-02	●	●	without	2.2	3.6	0.2	2	50	5	6	1	0.25	1.8	1.4
CB02RS-02B	●	●	with	2.2	4.9	0.2	2	50	5	6	1	0.25	1.8	1.4
CB03RS	●	●	without	3.2	4.2	0.05	3	50	7.5	9	1.5	0.35	2.7	2.3
CB03RS-B	●	●	with	3.2	4.4	0.05	3	50	7.5	9	1.5	0.35	2.7	2.3
CB03RS-01	●	●	without	3.2	4.2	0.1	3	50	7.5	9	1.5	0.35	2.7	2.3
CB03RS-01B	●	●	with	3.2	4.5	0.1	3	50	7.5	9	1.5	0.35	2.7	2.3
CB03RS-02	●	●	without	3.2	4.2	0.2	3	50	7.5	9	1.5	0.35	2.7	2.3
CB03RS-02B	●	●	with	3.2	4.8	0.2	3	50	7.5	9	1.5	0.35	2.7	2.3
CB04RS	●	●	without	4.2	5.1	0.05	4	60	10	12	2	0.45	3.6	3.1
CB04RS-B	●	●	with	4.2	5.2	0.05	4	60	10	12	2	0.45	3.6	3.1
CB04RS-01	●	●	without	4.2	5.1	0.1	4	60	10	12	2	0.45	3.6	3.1
CB04RS-01B	●	●	with	4.2	5.3	0.1	4	60	10	12	2	0.45	3.6	3.1
CB04RS-02	●	●	without	4.2	5.1	0.2	4	60	10	12	2	0.45	3.6	3.1
CB04RS-02B	●	●	with	4.2	5.5	0.2	4	60	10	12	2	0.45	3.6	3.1
CB05RS	●	●	without	5.2	6.0	0.05	5	70	12.5	15	2.5	0.55	4.5	3.9
CB05RS-B	●	●	with	5.2	6.1	0.05	5	70	12.5	15	2.5	0.55	4.5	3.9
CB05RS-02	●	●	without	5.2	6.0	0.2	5	70	12.5	15	2.5	0.55	4.5	3.9
CB05RS-02B	●	●	with	5.2	6.4	0.2	5	70	12.5	15	2.5	0.55	4.5	3.9
CB06RS	●	●	without	6.2	7.2	0.05	6	75	12.5	18	3	0.65	5.4	4.7
CB06RS-B	●	●	with	6.2	7.3	0.05	6	75	12.5	18	3	0.65	5.4	4.7
CB06RS-02	●	●	without	6.2	7.2	0.2	6	75	12.5	18	3	0.65	5.4	4.7
CB06RS-02B	●	●	with	6.2	7.8	0.2	6	75	12.5	18	3	0.65	5.4	4.7
CB07RS	●	●	without	7.2	8.6	0.05	7	85	12.5	21	3.5	0.75	6.3	5.5
CB07RS-B	●	●	with	7.2	8.8	0.05	7	85	12.5	21	3.5	0.75	6.3	5.5
CB07RS-02	●	●	without	7.2	8.6	0.2	7	85	12.5	21	3.5	0.75	6.3	5.5
CB07RS-02B	●	●	with	7.2	9.2	0.2	7	85	12.5	21	3.5	0.75	6.3	5.5
CB08RS	●	●	without	8.2	9.5	0.05	8	95	15	24	4	0.85	7.2	6.3
CB08RS-B	●	●	with	8.2	9.6	0.05	8	95	15	24	4	0.85	7.2	6.3
CB08RS-02	●	●	without	8.2	9.5	0.2	8	95	15	24	4	0.85	7.2	6.3
CB08RS-02B	●	●	with	8.2	9.8	0.2	8	95	15	24	4	0.85	7.2	6.3

*1 DMIN : Min. Cutting Diameter
*2 The RE dimension represents the size before grinding a chip breaker.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Micro-Mini Twin **CB**: Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d	Micro-Mini Twin **CR**: Cutting Speed (m/min)	Feed(mm/rev) 03RS/04RS	Feed(mm/rev) 05RS
P	Carbon Steel Alloy Steel 180–350HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
M	Stainless Steel ≤200HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
K	Gray Cast Iron ≤350MPa	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.03 (0.01–0.05)	0.03 (0.01–0.05)
N	Non-Ferrous Meterial	120 (80–160)	0.05 (0.01–0.08)	0.3 (0.1–0.5)	3–5	120 (80–160)	0.03 (0.01–0.05)	0.05 (0.01–0.08)

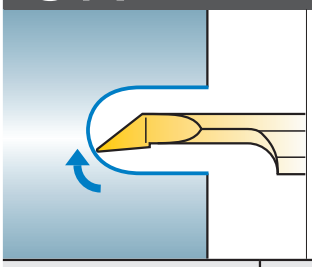
Note 1) Recommend wet machining.

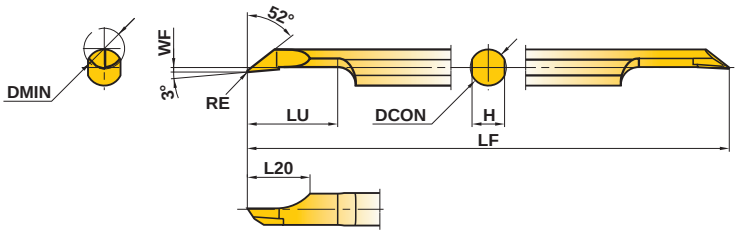
MICRO-MINI TWIN

TOOL NEWS

CR

For internal copying





Right hand tool only.

Order Number	Stock		Breaker	Dimensions(mm)							
	Micro Grain	Coated		DMIN	RE	DCON	LF	LU	L20	WF	H
	TF15	VP15TF									
CR03RS-01	●	●	without	**3.5**	0.1	3	50	8	6	0.15	2.7
CR03RS-01B	●	●	with	**3.5**	0.1	3	50	8	6	0.15	2.7
CR04RS-01	●	●	without	**4.5**	0.1	4	60	10	7	0.15	3.6
CR04RS-01B	●	●	with	**4.5**	0.1	4	60	10	7	0.15	3.6
CR05RS-01	●	●	without	**5.5**	0.1	5	70	12	8	0.15	4.5
CR05RS-01B	●	●	with	**5.5**	0.1	5	70	12	8	0.15	4.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Micro-Mini Twin **CB**				Micro-Mini Twin **CR**		
		Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d	Cutting Speed (m/min)	Feed(mm/rev) 03RS/04RS	Feed(mm/rev) 05RS
P	Carbon Steel Alloy Steel 180–350HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
M	Stainless Steel ≤200HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
K	Gray Cast Iron ≤350MPa	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.03 (0.01–0.05)	0.03 (0.01–0.05)
N	Non-Ferrous Meterial	120 (80–160)	0.05 (0.01–0.08)	0.3 (0.1–0.5)	3–5	120 (80–160)	0.03 (0.01–0.05)	0.05 (0.01–0.08)

Note 1) Recommend wet machining.
Note 2) The recommended tool overhang of CR type is LU+2mm.

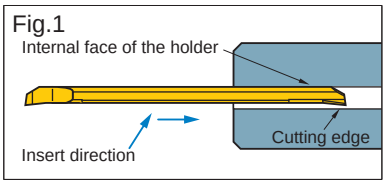
● : Inventory maintained in Japan. (MICRO-MINI TWIN is available in 1 piece in one pack.)

■PRECAUTIONS WHEN USING THE MICRO-MINI TWIN

●When using a holder for general purpose / small automatic lathe:

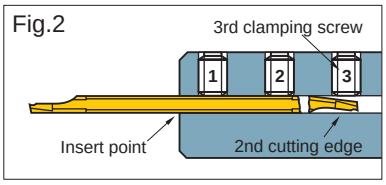
1 To avoid chipping of the 2nd cutting edge take care when inserting the boring bar into the holder. Refer to fig.1. If the 2nd edge contacts the internal face of the holder there is a possibility that it may chip.

Fig.1



2 When using this type of holder, there is a possibility that damage to the shank and the 2nd cutting edge can occur. Make sure that the clamping screws are tightened to the set torque value. Additionally make sure that there is no clamping screw near the 2nd cutting edge as this can break the boring bar.

Fig.2



◎When using Mitsubishi holders

When using holders with a tool overhang of recommended quantity, ensure that the 3rd clamping screw is removed prior to machining. (RBH1620N, RBH19020N, RBH2020N and RBH2520N do not have the 3rd screw.) The set torque value for clamping screw is 2.0 N•m.

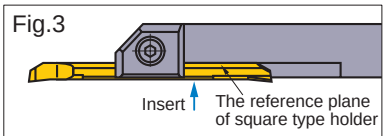
●When using a square type holder:

1 When installing the boring bar into the holder, tighten the clamp screws after ensuring the flats on the tool holder are parallel to the reference flats on the micro-mini bar. Refer to fig.3.

2 Make sure that the clamping screws are tightened to the recommended values.

3 Do not tighten the clamp screw without a bar in place, otherwise the bridge will be deformed.

Fig.3



Tighten the clamping screw ensuring making the micro-mini twin boring bars is in contact with the reference plane of square type holder.

E

BORING BARS

MACHINING METHODS OF THE CR TYPE

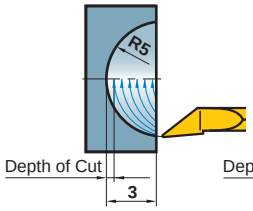
●Profile turning

By drilling a pre-prepared hole, the machining time will be shortened and chip control will be improved.

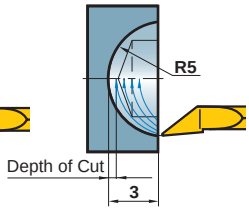
<Cutting Conditions>

Workpiece	: JIS S20C
Holder	: CR05RS-01B
Cutting Speed	: 80m/min
Feed	: 0.05mm/rev
Depth of Cut	: 0.05mm
Wet Cutting	

Machining a work piece without a pre-prepared hole



Machining a work piece with a pre-prepared hole



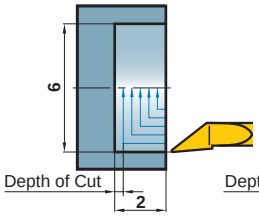
●Inner end facing

By drilling a pre-prepared hole, the machining time will be shortened and chip control will be improved.

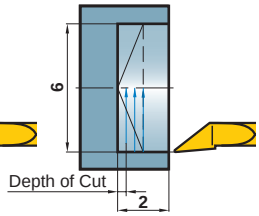
<Cutting Conditions>

Workpiece	: JIS S20C
Holder	: CR05RS-01B
Cutting Speed	: 80m/min
Feed	: 0.05mm/rev
Depth of Cut	: 0.05mm
Wet Cutting	

Machining a work piece without a pre-prepared hole

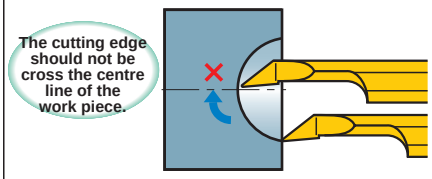


Machining a work piece with a pre-prepared hole



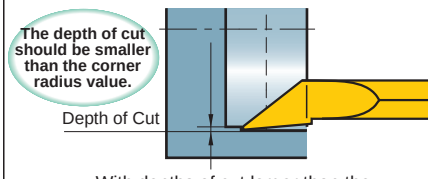
■NOTES FOR USE

Profile turning, Inner end facing



If the cutting edge crosses the centre line of a work piece, the cutting edge can fracture.

Copying



With depths of cut larger than the corner radius value, burrs will be formed.

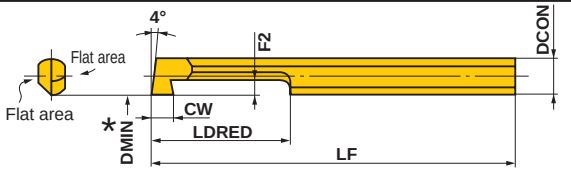
MICRO-MINI BORING BARS

- Solid carbide type with minimum cutting diameter ϕ3.2mm.
- l/d is 5 times the diameter.
- Cutting edge can be shaped according to the application thus, it covers a wide application range (threading, grooving, copying, etc).

94°

TOOL NEWS

STANDARD MICRO-MINI BORING BARS (Solid carbide boring bar)

Order Number	Stock	Dimensions(mm)						Geometry
	TF15	CW	DCON	LF	LDRED	DMIN*	F2	
C03FR-BLS	●	2.0	3	80	15	3.2	1.0	
C04FR-BLS	●	2.5	4	80	20	4.2	1.5	
C05HR-BLS	●	3.0	5	100	25	5.2	2.0	

Right hand tool only.

*DMIN : Min. Cutting Diameter

E

BORING BARS

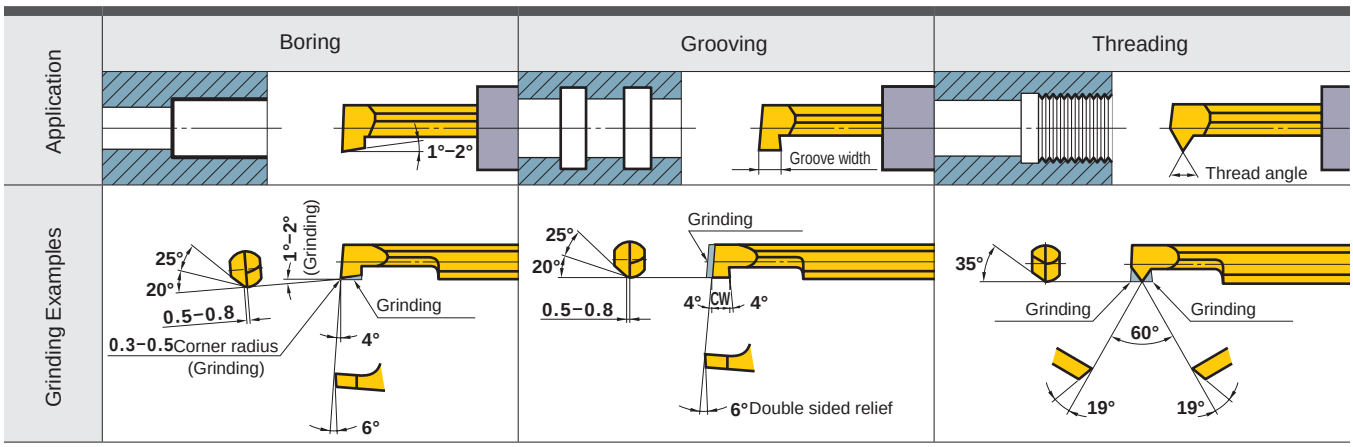
RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d	Edge Condition (mm)	
						*Corner Radius or BCH	*Honing
P	Carbon Steel, Alloy Steel 180–350HB	40 (30–50)	0.05 (–0.1)	0.2 (0.1–0.3)	5	0.1–0.5	0.01–0.05
M	Stainless Steel ≤200HB	40 (30–50)	0.05 (–0.1)	0.2 (0.1–0.3)	5	≤0.4	≤0.03 (Honing not required)
K	Gray Cast Iron ≤350MPa	40 (30–50)	0.05 (–0.05)	0.2 (0.1–0.3)	5	0.1–0.5	0.01–0.05
N	Non-Ferrous Meterial	80 (60–100)	0.05 (–0.1)	0.3 (0.1–0.5)	5	0.1–0.5	≤0.03 (Honing not required)

*Cutting edge is not honed. Please hone according to the workpiece before machining.

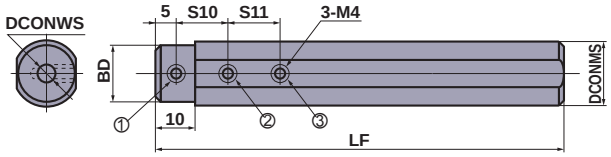
■GRINDING THE CUTTING EDGE OF MICRO-MINI BORING BAR

- MICRO-MINI boring bar can be applied to boring and grooving without any modifications. It can also be reground as shown below.
- For shaping and regrinding, use a diamond whetstone approximately #250–#400.
  Please grind according to the application using the figure below as a reference.

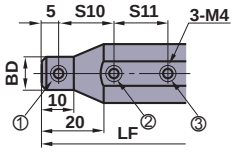


● : Inventory maintained in Japan. (MICRO MINI is available in 1 piece in one pack.)

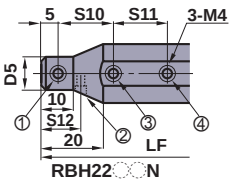
■ROUND TYPE HOLDER



RBH158□□N, RBH16□□N, RBH190□□N



RBH20□□N, RBH25□□N, RBH254□□N



RBH22□□N

Order Number	Stock	Dimensions(mm) DCONMS	DCONWS	BD	LF	S10	S11	S12	Micro-Mini C	Micro-Mini Twin CB	CR	⋆1 Clamp Screw ①	②	③	④	Wrench	Torque (N • m)
RBH15820N	●	15.875	2	15	100	10	—	—	—	02RS(-B) 02RS-0□(B)	—	B	B	—	—	HKY20F	2.0
RBH15830N	●	15.875	3	15	100	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	A	A	—	HKY20F	2.0
RBH15840N	●	15.875	4	15	100	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	A	A	—	HKY20F	2.0
RBH15850N	●	15.875	5	15	100	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	A	A	—	HKY20F	2.0
RBH15860N	●	15.875	6	15	100	15	15	—	—	06RS(-B) 06RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH15870N	●	15.875	7	15	100	20	20	—	—	07RS(-B) 07RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH15880N	●	15.875	8	15	100	20	20	—	—	08RS(-B) 08RS-0□(B)	—	D	D	D	—	HKY20F	2.0
RBH1620N	●	16	2	15	100	10	—	—	—	02RS(-B) 02RS-0□(B)	—	B	B	—	—	HKY20F	2.0
RBH1630N	●	16	3	15	100	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	A	A	—	HKY20F	2.0
RBH1640N	●	16	4	15	100	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	A	A	—	HKY20F	2.0
RBH1650N	●	16	5	15	100	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	A	A	—	HKY20F	2.0
RBH1660N	●	16	6	15	100	15	15	—	—	06RS(-B) 06RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH1670N	●	16	7	15	100	20	20	—	—	07RS(-B) 07RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH1680N	●	16	8	15	100	20	20	—	—	08RS(-B) 08RS-0□(B)	—	D	D	D	—	HKY20F	2.0
⋆2 RBH19020N	●	19.05	2	18	125	10	—	—	—	02RS(-B) 02RS-0□(B)	—	C	C	—	—	HKY20F	2.0
⋆2 RBH19030N	●	19.05	3	18	125	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19040N	●	19.05	4	18	125	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19050N	●	19.05	5	18	125	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19060N	●	19.05	6	18	125	15	15	—	—	06RS(-B) 06RS-0□(B)	—	B	B	B	—	HKY20F	2.0
⋆2 RBH19070N	●	19.05	7	18	125	20	20	—	—	07RS(-B) 07RS-0□(B)	—	B	B	B	—	HKY20F	2.0
RBH19080N	●	19.05	8	18	125	20	20	—	—	08RS(-B) 08RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH2020N	●	20	2	11	125	10	—	—	—	02RS(-B) 02RS-0□(B)	—	A	A	—	—	HKY20F	2.0
RBH2030N	●	20	3	12	125	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	A	B	—	HKY20F	2.0
RBH2040N	●	20	4	13	125	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	B	B	—	HKY20F	2.0
RBH2050N	●	20	5	14	125	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	B	B	—	HKY20F	2.0
RBH2060N	●	20	6	15	125	15	15	—	—	06RS(-B) 06RS-0□(B)	—	A	B	B	—	HKY20F	2.0
RBH2070N	●	20	7	16	125	20	20	—	—	07RS(-B) 07RS-0□(B)	—	A	B	B	—	HKY20F	2.0
RBH2080N	●	20	8	17	125	20	20	—	—	08RS(-B) 08RS-0□(B)	—	A	A	A	—	HKY20F	2.0
RBH2220N	●	22	2	11	125	10	—	10	—	02RS(-B) 02RS-0□(B)	—	A	B	—	A	HKY20F	2.0
RBH2230N	●	22	3	12	125	10	10	10	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	B	C	A	HKY20F	2.0
RBH2240N	●	22	4	13	125	15	15	12.5	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	B	B	A	HKY20F	2.0
RBH2250N	●	22	5	14	125	15	15	12.5	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	B	B	A	HKY20F	2.0
RBH2260N	●	22	6	15	125	15	15	15	—	06RS(-B) 06RS-0□(B)	—	A	B	B	A	HKY20F	2.0
RBH2270N	●	22	7	16	125	20	20	15	—	07RS(-B) 07RS-0□(B)	—	A	B	B	A	HKY20F	2.0
RBH2280N	●	22	8	17	125	20	20	15	—	08RS(-B) 08RS-0□(B)	—	A	B	B	A	HKY20F	2.0
RBH2520N	●	25	2	11	150	10	—	—	—	02RS(-B) 02RS-0□(B)	—	A	B	—	—	HKY20F	2.0
RBH2530N	●	25	3	12	150	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	B	C	—	HKY20F	2.0
RBH2540N	●	25	4	13	150	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	C	C	—	HKY20F	2.0
RBH2550N	●	25	5	14	150	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	C	C	—	HKY20F	2.0
RBH2560N	●	25	6	15	150	15	15	—	—	06RS(-B) 06RS-0□(B)	—	A	C	C	—	HKY20F	2.0
RBH2570N	●	25	7	16	150	20	20	—	—	07RS(-B) 07RS-0□(B)	—	A	C	C	—	HKY20F	2.0
RBH2580N	●	25	8	17	150	20	20	—	—	08RS(-B) 08RS-0□(B)	—	A	B	B	—	HKY20F	2.0
RBH25420N	●	25.4	2	11	150	10	—	—	—	02RS(-B) 02RS-0□(B)	—	A	B	—	—	HKY20F	2.0
RBH25430N	●	25.4	3	12	150	10	10	—	03FR-BLS	03RS(-B) 03RS-0□(B)	03RS-01(B)	A	B	C	—	HKY20F	2.0
RBH25440N	●	25.4	4	13	150	15	15	—	04FR-BLS	04RS(-B) 04RS-0□(B)	04RS-01(B)	A	C	C	—	HKY20F	2.0
RBH25450N	●	25.4	5	14	150	15	15	—	05HR-BLS	05RS(-B) 05RS-0□(B)	05RS-01(B)	A	C	C	—	HKY20F	2.0
RBH25460N	●	25.4	6	15	150	15	15	—	—	06RS(-B) 06RS-0□(B)	—	A	C	C	—	HKY20F	2.0
RBH25470N	●	25.4	7	16	150	20	20	—	—	07RS(-B) 07RS-0□(B)	—	A	C	C	—	HKY20F	2.0
RBH25480N	●	25.4	8	17	150	20	20	—	—	08RS(-B) 08RS-0□(B)	—	A	B	B	—	HKY20F	2.0

⋆1 Order number of clamp screw A=HSS04004, B=HSS04006, C=HSS04008, D=HSS04003 ⋆2 Revised order number.

Conventional Order Number	Revised Order Number
RBH1920N	RBH19020N
RBH1930N	RBH19030N
RBH1940N	RBH19040N

Conventional Order Number	Revised Order Number
RBH1950N	RBH19050N
RBH1960N	RBH19060N
RBH1970N	RBH19070N

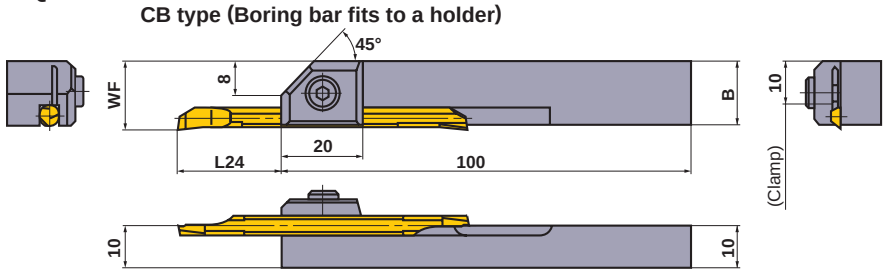
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

MICRO-MINI TWIN

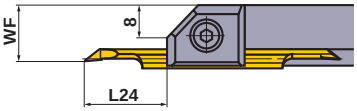
TOOL NEWS

■SQUARE TYPE HOLDER

CB type (Boring bar fits to a holder)



CR type (Boring bar fits to a holder)



Order Number	Stock	Dimensions(mm)						Micro-Mini Twin		Clamp Screw	Wrench	Torque (N • m)
		WF		L24*		B						
		CB	CR	CB	CR	CB	CR	CB	CR			
SBH1020R	●	13	—	6—24 (6—10)	—	12.9		02RS(-B) 02RS-0□(B)	—	HSC04010	HKY30R	4.8
SBH1030R	●	14	12.65	8.5—22 (9—15)	11—19.5 (12)	13.8		03RS(-B) 03RS-0□(B)	03RS-01(B)	HSC05012	HKY40R	9.5
SBH1040R	●	15	13.15	11—29.5 (12—20)	13—27.5 (14)	14.7		04RS(-B) 04RS-0□(B)	04RS-01(B)	HSC05012	HKY40R	9.5
SBH1050R	●	16	13.65	13.5—37 (15—25)	15—35.5 (16)	15.6		05RS(-B) 05RS-0□(B)	05RS-01(B)	HSC05012	HKY40R	9.5
SBH1060R	●	17	—	13.5—42 (18—30)	—	16.5		06RS(-B) 06RS-0□(B)	—	HSC05012	HKY40R	9.5
SBH1070R	●	18	—	13.5—52 (21—35)	—	17.4		07RS(-B) 07RS-0□(B)	—	HSC05012	HKY40R	9.5

Note 1) The MICRO-DEX and the MICRO-MINI cannot be fit to square holders.
*L24 is the length of overhang for sufficient clamping, and ( ) is the recommended length for machining of carbon and alloy steel.

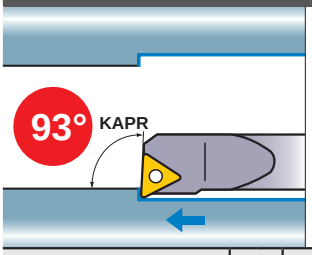
● : **Inventory maintained in Japan.**

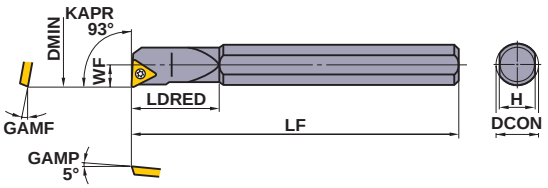
F TYPE BORING BARS

- The minimum cutting diameter is from ϕ10.
- 11°positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

FSTU1

TP○○inserts





Right hand tool holder shown.

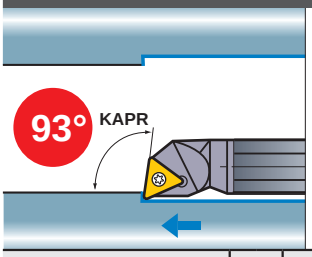
Finish	Flat Top
R/L	(08,09,11)
PCD	CBN/PCD
R/L-F	(09,11) (08,09,11)

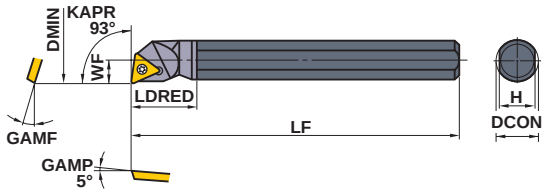
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	* Clamp Screw	Wrench
FSTU108R/L	●	●	TPGX TPMX	0802○○	8	125	18	5	7	15°	**10**	CS200T	TKY06F
FSTU110R/L	●	●		0902○○	10	150	22	6	9	13°	**12**	CS250T	TKY08F
FSTU112R/L	●	●		0902○○	12	180	25	8	11	10°	**16**	CS250T	TKY08F
FSTU116R/L	●	●		1103○○	16	200	30	11	14	7°	**22**	CS300890T	TKY08F

* Clamp Torque (N • m) : CS200T=0.6, CS250T=1.0, CS300890T=1.0

FSTU2

Carbide shank **TP○○inserts**





Right hand tool holder shown.

Finish	Flat Top
R/L	(08,09,11)
PCD	CBN/PCD
R/L-F	(09,11) (08,09,11)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	* Clamp Screw	Wrench
FSTU208R/L	●	●	TPGX TPMX	0802○○	8	125	13	5	7	15°	**10**	CS200T	TKY06F
FSTU210R/L	●	●		0902○○	10	150	16	6	9	13°	**12**	CS250T	TKY08F
FSTU212R/L	●	●		0902○○	12	180	19	8	11	10°	**16**	CS250T	TKY08F
FSTU216R/L	●	●		1103○○	16	200	26	11	14	7°	**22**	CS300890T	TKY08F

* Clamp Torque (N • m) : CS200T=0.6, CS250T=1.0, CS300890T=1.0

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d≤3			l/d=3–4 (Shank Diameter ≥ 25mm)		
Carbide Shank			l/d≤5			l/d=6–7		
Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
		Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
		Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
		Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

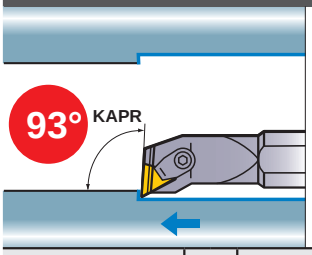
TP○○ type inserts	➤ A165, A166	SPARE PARTS	➤ Q001
CBN & PCD inserts	➤ B059, B060, B075, B076	TECHNICAL DATA	➤ R001

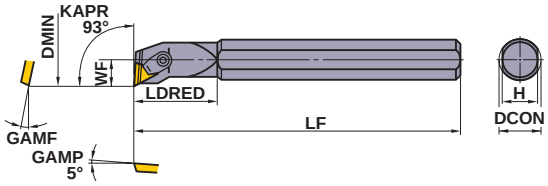
F TYPE BORING BARS

- The minimum cutting diameter is from ϕ22.
- 11°positive insert.
- Clamp-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

FCTU1

TP○○inserts





Right hand tool holder shown.

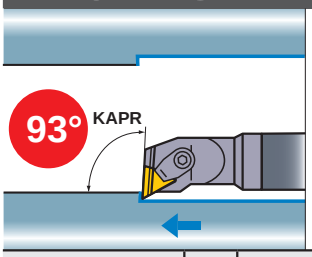
M Class	M Class	G class
Standard		R/L
(11,16)	(11,16)	(11,16)
G class	CBN/PCD	
(11,16)	(11,16)	

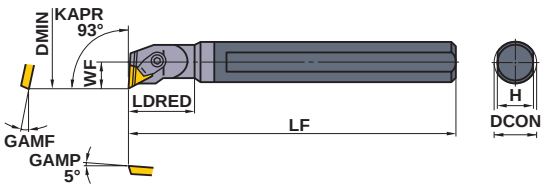
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Set *	Breaker Piece	Wrench
FCTU116R/L	●	●	TPMN TPMR TPGN TPGR	1103○○	16	200	30	11	14	7°	**22**	–	–	C3	CBT2N	HKY25R
FCTU120R/L☆	●	●		1603○○	20	200	37	13	18	5°	**26**	–	–	C4	CBT3F	HKY30R
FCTU125R/L☆ (4 Side Flat Shank)	●	●		1603○○	25	250	40	16	22	5°	**32**	PT32	BCP202	C4	CBT3F	HKY30R
FCTU132R/L☆ (4 Side Flat Shank)	●	●		1603○○	32	300	45	20	29	0°	**40**	PT32	BCP201	C4	CBT3F	HKY30R

* Clamp Torque (N • m) : C3=2.2, C4=3.3

FCTU2

Carbide shank **TP○○inserts**





Right hand tool holder only.

M Class	M Class	G class
Standard		R/L
(11,16)	(11,16)	(11,16)
G class	CBN/PCD	
(11,16)	(11,16)	

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Set *	Breaker Piece	Wrench
FCTU216R	●	TPMN TPMR TPGN TPGR	1103○○	16	200	26	11	14	7°	**22**	–	–	C3	CBT2N	HKY25R
FCTU220R ☆	●		1603○○	20	200	33	13	18	5°	**26**	–	–	C4	CBT3F	HKY30R
FCTU225R ☆	●		1603○○	25	250	37	16	22	5°	**32**	PT32	BCP202	C4	CBT3F	HKY30R

* Clamp Torque (N • m) : C3=2.2, C4=3.3

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.(Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

● : Inventory maintained in Japan.

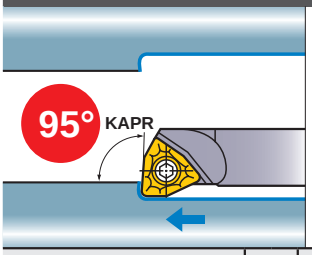
TP○○ type inserts ➤ A182
CBN & PCD inserts ➤ B065, B081

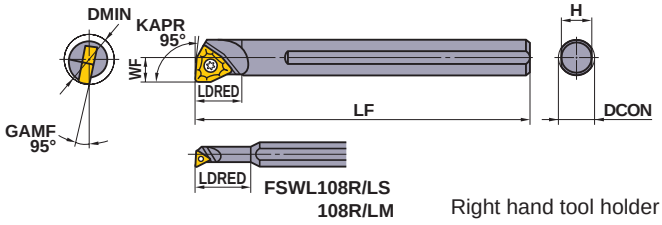
F TYPE BORING BARS

- The minimum cutting diameter is from ϕ5.8.
- 7°positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

FSWL1

WC○○inserts





Right hand tool holder shown.

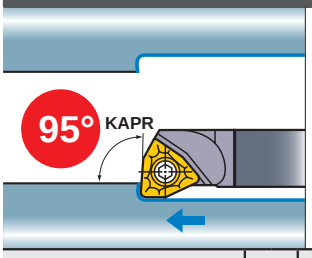
Finish	Light
R/L	Standard
(02,L3)	(02,L3,04,06)
CBN/PCD	
(L3,04,06)	

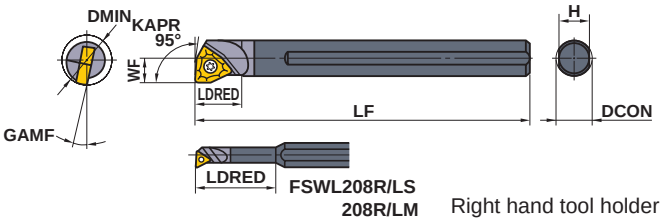
Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
FSWL108R/LS	●	●	WCMT WCGT	0201○○	8	100	19	2.9	7	17°	**5.8**	TS21	TKY06F
FSWL108R/LM	●	●	WCMT WCGT WCMW	L302○○	8	100	25	4	7	15°	**8**	TS2	TKY06F
FSWL108R/L	●	●	WCMT WCMW	0402○○	8	125	10	5	7	15°	**10**	TS25	TKY08F
FSWL110R/L	●	●		0402○○	10	150	12	6	9	13°	**12**	TS25	TKY08F
FSWL112R/L ☆	●	●		06T3○○	12	180	15	8	11	13°	**16**	TS4	TKY15F
FSWL116R/L ☆	●	●		06T3○○	16	200	20	11	14	7°	**22**	TS4	TKY15F

* Clamp Torque (N • m) : TS21=0.6, TS2=0.6, TS25=1.0, TS4=3.5

FSWL2

Carbide shank **WC○○inserts**





Right hand tool holder shown.

Finish	Light
R/L	Standard
(02,L3)	(02,L3,04,06)
CBN/PCD	
(L3,04,06)	

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
FSWL208R/LS	●	●	WCMT WCGT	0201○○	8	122	25	2.9	7	17°	**5.8**	TS21	TKY06F
FSWL208R/LM	●	●	WCMT WCGT WCMW	L302○○	8	125	33	4	7	15°	**8**	TS2	TKY06F
FSWL208R/L	●	●	WCMT WCMW	0402○○	8	125	10	5	7	15°	**10**	TS25	TKY08F
FSWL210R/L	●	●		0402○○	10	150	12	6	9	13°	**12**	TS25	TKY08F
FSWL212R/L ☆	●	●		06T3○○	12	180	15	8	11	13°	**16**	TS4	TKY15F
FSWL216R/L ☆	●	●		06T3○○	16	200	20	11	14	7°	**22**	TS4	TKY15F

* Clamp Torque (N • m) : TS21=0.6, TS2=0.6, TS25=1.0, TS4=3.5

RECOMMENDED CUTTING CONDITIONS

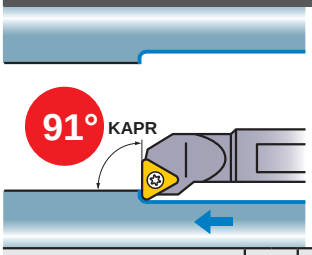
Steel Shank				l/d≤3			l/d=3–4 (Shank Diameter ≥ 25mm)		
Carbide Shank				l/d≤5			l/d=6–7		
	Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
			Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
			Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N	Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
			Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

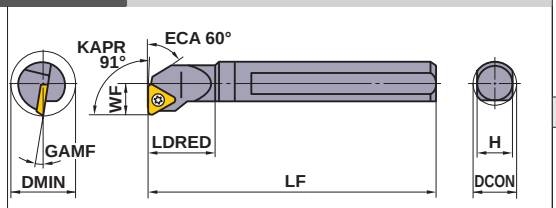
WC○○ type inserts	➤ **A176**
CBN & PCD inserts	➤ **B063, B078**
SPARE PARTS	➤ **Q001**
TECHNICAL DATA	➤ **R001**

S TYPE BORING BARS

- The minimum cutting diameter is from ϕ11.
- ISO standard.
- 7° positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

S○○○STFC — TC○○inserts





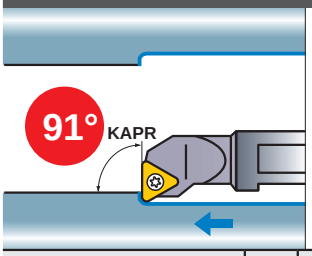
Right hand tool holder shown.

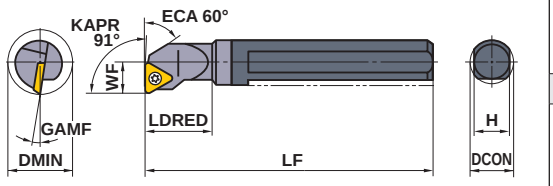
Finish	Finish	Light	Light
FP	FM	LP	LM
(09,11,16)	(09,11,16)	(09,11,16)	(09,11,16)
Medium	Medium	Flat top	CBN/PCD
MP	MM		
(09,11,16)	(09,11,16)	(11,16)	(09,11,16)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
S08FSTFCR/L09	●	●	TCMT TCGW	0902○○	8	80	12	6	7	15°	**11**	TS22	TKY06F
S10HSTFCR/L11	●	●	TCMW TCMT TCGW TCGT	1102○○	10	100	16	7	9	13°	**13**	TS25	TKY08F
S12KSTFCR/L11	●	●		1102○○	12	125	20	9	11	10°	**16**	TS25	TKY08F
S16MSTFCR/L11	●	●		1102○○	16	150	25	11	14	7°	**20**	TS25	TKY08F
S20QSTFCR/L16 ☆	●	●		16T3○○	20	180	32	13	18	7°	**25**	TS4	TKY15F
S25RSTFCR/L16 ☆	●	●		16T3○○	25	200	40	17	23	5°	**32**	TS4	TKY15F
S32SSTFCR/L16 ☆	●	●		16T3○○	32	250	50	22	30	5°	**40**	TS4	TKY15F

* Clamp Torque (N • m) : TS22=0.6, TS25=1.0, TS4=3.5

C○○○STFC — Carbide shank TC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
(09,11,16)	(09,11,16)	(09,11,16)	(09,11,16)
Medium	Medium	Flat top	CBN/PCD
MP	MM		
(09,11,16)	(09,11,16)	(11,16)	(11)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
C08HSTFCR09	●	TCMT TCGW	0902○○	8	100	12	6	7	15°	**11**	TS22	TKY06F
C10KSTFCR11	●	TCMW TCMT TCGW TCGT	1102○○	10	125	16	7	9	13°	**13**	TS25	TKY08F
C12MSTFCR11	●		1102○○	12	150	20	9	11	10°	**16**	TS25	TKY08F
C16RSTFCR11	●		1102○○	16	200	25	11	14	7°	**20**	TS25	TKY08F
C20SSTFCR16 ☆	●		16T3○○	20	250	32	13	18	7°	**25**	TS4	TKY15F
C25TSTFCR16 ☆	●		16T3○○	25	300	40	17	23	5°	**32**	TS4	TKY15F

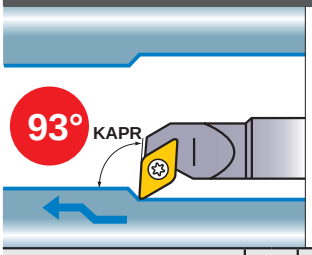
* Clamp Torque (N • m) : TS22=0.6, TS25=1.0, TS4=3.5

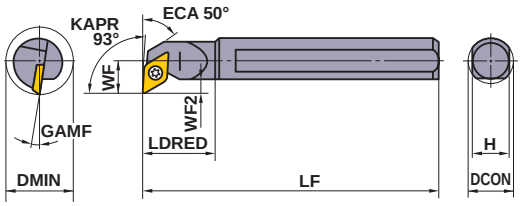
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.(Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

● : Inventory maintained in Japan.

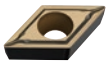
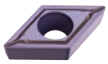
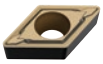
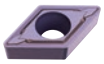
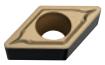
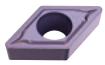
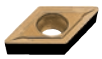
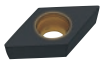
TC○○ type inserts	➤ A160—A162
CBN & PCD inserts	➤ B057, B074

S○○○SDUC — DC○○inserts





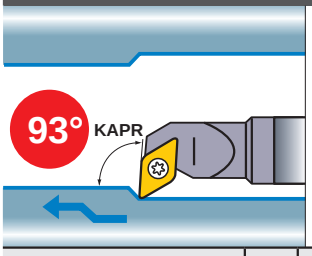
Right hand tool holder shown.

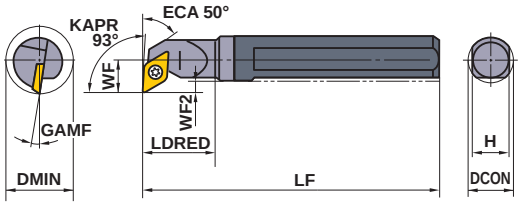
Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	Medium	Flat top
MP	MM	Standard	
			
(07,11,15)	(07,11,15)	(07,11,15)	(07,11,15)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
S10HSDUCR/L07	●	●	DCMT DCET DCGT DCMW DCGW	0702○○	10	100	16	7	2.4	9	13°	**13**	TS25	TKY08F
S12KSDUCR/L07	●	●		0702○○	12	125	20	9	3.4	11	10°	**16**	TS25	TKY08F
S16MSDUCR/L07	●	●		0702○○	16	150	25	11	3.9	14	7°	**20**	TS25	TKY08F
S20QSDUCR/L11☆	●	●		11T3○○	20	180	32	13	4.4	18	7°	**25**	TS4	TKY15F
S25RSDUCR/L15☆	●	●		1504○○	25	200	40	17	6.9	23	5°	**32**	TS5	TKY25F
S32SSDUCR/L15☆	●	●		1504○○	32	250	50	22	8.4	30	5°	**40**	TS5	TKY25F
S40TSDUCR/L15☆	●	●		1504○○	40	300	63	27	9.4	37	5°	**50**	TS5	TKY25F

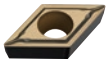
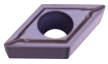
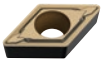
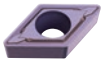
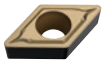
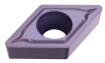
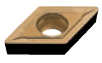
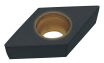
* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

C○○○SDUC — Carbide shank DC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	Medium	Flat top
MP	MM	Standard	
			
(07,11,15)	(07,11,15)	(07,11,15)	(07,11,15)

Order Number	Stock R	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
C10KSDUCR07	●	DCMT DCET DCGT DCMW DCGW	0702○○	10	125	16	7	2.1	9	13°	**13**	TS25	TKY08F
C12MSDUCR07	●		0702○○	12	150	20	9	3.1	11	10°	**16**	TS25	TKY08F
C16RSDUCR07	●		0702○○	16	200	25	11	3.1	14	7°	**20**	TS25	TKY08F
C20SSDUCR11☆	●		11T3○○	20	250	32	13	3.1	18	7°	**25**	TS4	TKY15F
C25TSDUCR15☆	●	DCMW DCMT	1504○○	25	300	40	17	4.9	23	5°	**32**	TS5	TKY25F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

RECOMMENDED CUTTING CONDITIONS

Steel Shank				l/d≤3			l/d=3–4 (Shank Diameter ≥ 25mm)		
Carbide Shank				l/d≤5			l/d=6–7		
	Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
			Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
			Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N	Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
			Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

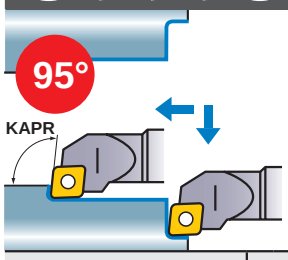
DC○○ type inserts	➤ A149–A154
CBN & PCD inserts	➤ B054–B056, B073
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

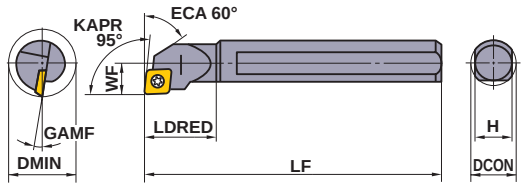
S TYPE BORING BARS

- The minimum cutting diameter is from ϕ11.
- ISO standard.
- 7° positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

S○○○SCLC

CC○○inserts





Right hand tool holder shown.

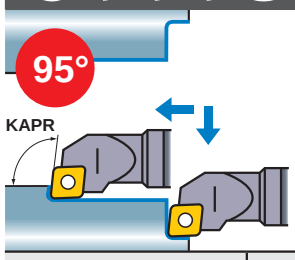
Finish	Finish	Light	Light
FP	FM	LP	LM
(06,09)	(06,09)	(06,09)	(06,09)
Medium	**Medium**	**Flat top**	**CBN/PCD**
MP	MM		
(06,09,12)	(06,09,12)	(06,09,12)	(06,09,12)

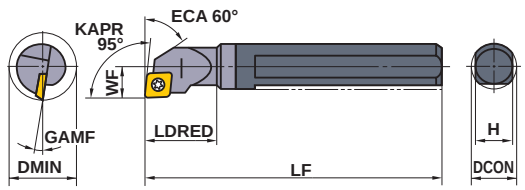
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
S08FSCLCR/L06	●	●	CCMB CCMH CCMT CCMW CCET CCGB CCGH CCGT CCGW	0602○○	8	80	12	6	7	15°	**11**	TS25	TKY08F
S10HSCLCR/L06	●	●		0602○○	10	100	16	7	9	13°	**13**	TS25	TKY08F
S12KSCLCR/L06	●	●		0602○○	12	125	20	9	11	10°	**16**	TS25	TKY08F
S16MSCLCR/L09☆	●	●		09T3○○	16	150	25	11	14	7°	**20**	TS4	TKY15F
S20QSCLCR/L09☆	●	●		09T3○○	20	180	32	13	18	7°	**25**	TS4	TKY15F
S25RSCLCR/L12☆	●	●		1204○○	25	200	40	17	23	5°	**32**	TS5	TKY25F
S32SSCLCR/L12☆	●	●		1204○○	32	250	50	22	30	5°	**40**	TS5	TKY25F
S40TSCLCR/L12☆	●	●		1204○○	40	300	63	27	37	5°	**50**	TS5	TKY25F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

C○○○SCLC

Carbide shank CC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
(06,09)	(06,09)	(06,09)	(06,09)
Medium	**Medium**	**Flat top**	**CBN/PCD**
MP	MM		
(06,09)	(06,09)	(06,09)	(06,09)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
C08HSCLCR06	●	CCMB CCMH CCMT CCMW CCET CCGB CCGH CCGT CCGW	0602○○	8	100	12	6	7	15°	**11**	TS25	TKY08F
C10KSCLCR06	●		0602○○	10	125	16	7	9	13°	**13**	TS25	TKY08F
C12MSCLCR06	●		0602○○	12	150	20	9	11	10°	**16**	TS25	TKY08F
C16RSCLCR09☆	●		09T3○○	16	200	25	11	14	7°	**20**	TS4	TKY15F
C20SSCLCR09☆	●		09T3○○	20	250	32	13	18	7°	**25**	TS4	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

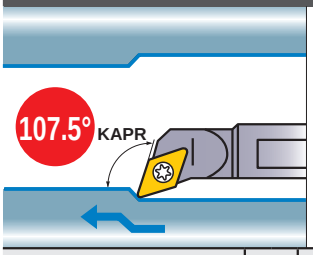
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.(Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

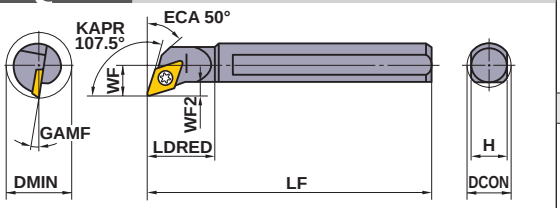
● : Inventory maintained in Japan.

CC○○ type inserts ➤ A140—A147
CBN & PCD inserts ➤ B049—B052, B072

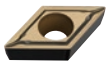
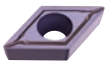
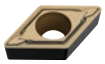
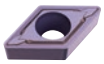
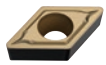
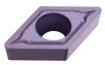
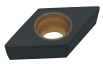
S○○○SDQC

DC○○inserts





Right hand tool holder shown.

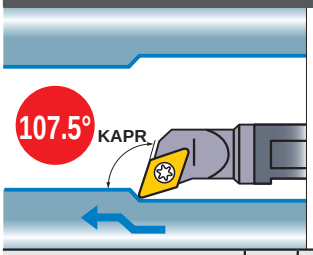
Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	Flat top	CBN/PCD
MP	MM		
			
(07,11,15)	(07,11,15)	(07,11,15)	(07,11)

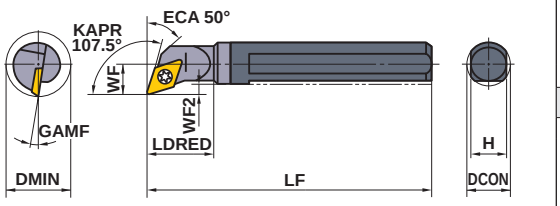
Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
S10HSDQCR/L07	●	●	DCMT DCET DCGT DCMW DCGW	0702○○	10	100	16	7	2.4	9	13°	**13**	TS25	TKY08F
S12KSDQCR/L07	●	●		0702○○	12	125	20	9	3.4	11	10°	**16**	TS25	TKY08F
S16MSDQCR/L07	●	●		0702○○	16	150	25	11	3.9	14	7°	**20**	TS25	TKY08F
S20QSDQCR/L11 ☆	●	●		11T3○○	20	180	32	13	4.4	18	7°	**25**	TS4	TKY15F
S25RSDQCR/L15 ☆	●	●		1504○○	25	200	40	17	6.9	23	5°	**32**	TS5	TKY25F
S32SSDQCR15 ☆	●			1504○○	32	250	50	22	8.4	30	5°	**40**	TS5	TKY25F
S40TSDQCR15 ☆	●			1504○○	40	300	63	27	9.4	37	5°	**50**	TS5	TKY25F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

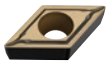
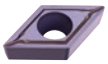
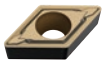
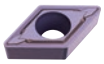
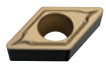
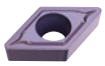
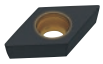
C○○○SDQC

Carbide shank DC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(07,11)	(07,11)	(07,11)	(07,11)
Medium	Medium	Flat top	CBN/PCD
MP	MM		
			
(07,11,15)	(07,11,15)	(07,11,15)	(07,11)

Order Number	Stock R	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
C10KSDQCR07	●	DCMT DCET DCGT DCMW DCGW	0702○○	10	125	16	7	2.1	9	13°	**13**	TS25	TKY08F
C12MSDQCR07	●		0702○○	12	150	20	9	3.1	11	10°	**16**	TS25	TKY08F
C16RSDQCR07	●		0702○○	16	200	25	11	3.1	14	7°	**20**	TS25	TKY08F
C20SSDQCR11 ☆	●		11T3○○	20	250	32	13	3.1	18	7°	**25**	TS4	TKY15F
C25TSDQCR15 ☆	●	DCMW DCMT	1504○○	25	300	40	17	4.9	23	5°	**32**	TS5	TKY25F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

RECOMMENDED CUTTING CONDITIONS

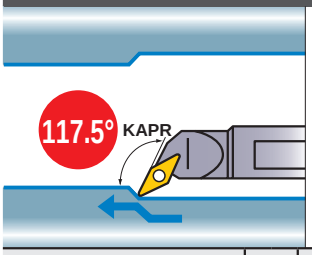
Steel Shank				l/d≤3			l/d=3–4 (Shank Diameter ≥ 25mm)		
Carbide Shank				l/d≤5			l/d=6–7		
	Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
			Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
			Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N	Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
			Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

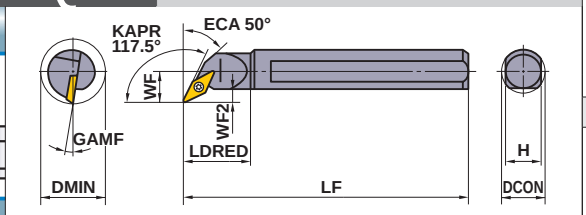
DC○○ type inserts	➤ A149–A154
CBN & PCD inserts	➤ B054–B056, B073
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

S TYPE BORING BARS

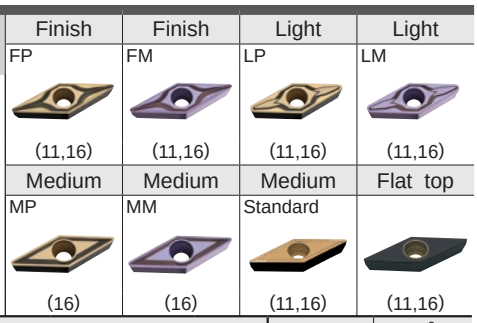
- The minimum cutting diameter is from ϕ20.
- ISO standard.
- 7° positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (Carbide shank is 7 times the diameter).

S○○○SVQC — VC○○inserts





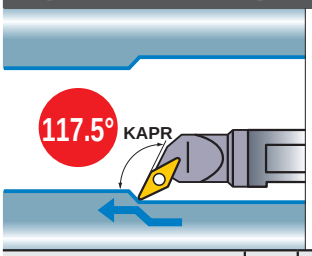
Right hand tool holder shown.

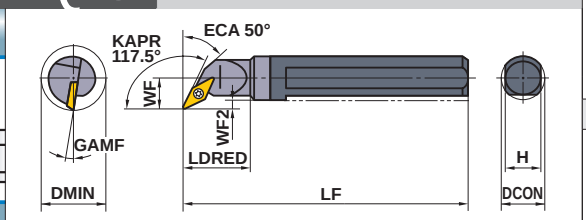


Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
S16MSVQCR/L11	●	●	VCMW VCMT VCGW VCGT	1103○○	16	150	25	11	3.9	14	7°	**20**	TS25	TKY08F
S20QSVQCR/L11	●	●		1103○○	20	180	32	13	4.4	18	7°	**25**	TS25	TKY08F
S25RSVQCR/L16 ☆	●	●		1604○○	25	200	40	17	6.9	23	5°	**32**	TS4	TKY15F
S32SSVQCR/L16 ☆	●	●		1604○○	32	250	50	22	8.4	30	5°	**40**	TS4	TKY15F
S40TSVQCR16 ☆	●			1604○○	40	300	63	27	9.4	37	5°	**50**	TS4	TKY15F

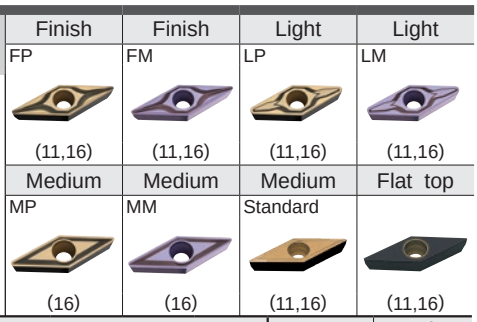
* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

C○○○SVQC Carbide shank — VC○○inserts





Right hand tool holder only.



Order Number	Stock R	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
C16RSVQCR11	●	VCMW VCMT VCGW VCGT	1103○○	16	200	25	11	3.1	14	7°	**20**	TS25	TKY08F
C20SSVQCR11	●		1103○○	20	250	32	13	3.1	18	7°	**25**	TS25	TKY08F
C25TSVQCR16 ☆	●		1604○○	25	300	40	17	4.9	23	5°	**32**	TS4	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

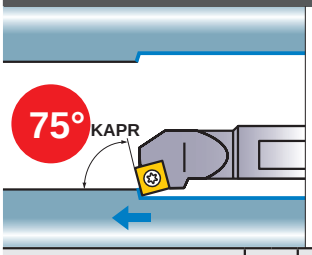
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.(Model of ☆ Mark is RE 0.8)
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

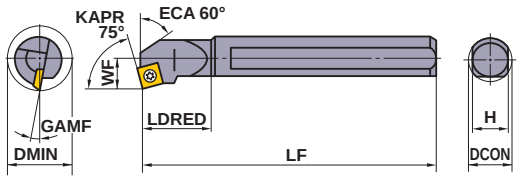
● : Inventory maintained in Japan.

VC○○ type inserts	**➤ A170—A172**
CBN & PCD inserts	**➤ B062, B077**

S○○○SSKC

SC○○inserts





Right hand tool holder shown.

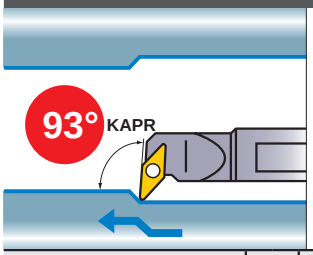
Finish	Finish	Light	Light
FP	FM	LP	LM
(09)	(09)	(09)	(09)
Medium	Medium	Medium	Flat top
MP	MM	Standard	
(09,12)	(09,12)	(09,12)	(09,12)

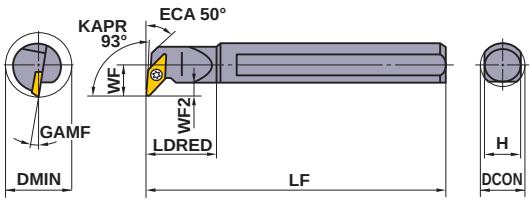
Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Clamp Screw *	Wrench
S16MSSKCR/L09 ☆	●	●	SCMW SCMT	09T3○○	16	150	25	11	14	7°	**20**	TS4	TKY15F
S20QSSKCR/L09 ☆	●	●		09T3○○	20	180	32	13	18	7°	**25**	TS4	TKY15F
S25RSSKCR/L12 ☆	●	●		1204○○	25	200	40	17	23	5°	**32**	TS5	TKY25F

* Clamp Torque (N • m) : TS4=3.5, TS5=7.5

S○○○SVUC

VC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
(11,16)	(11,16)	(11,16)	(11,16)
Medium	Medium	Medium	Flat top
MP	MM	Standard	
(16)	(16)	(11,16)	(11,16)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
S20QSVUCR/L11	●	●	VCMW VCMT VCGW VCGT	1103○○	20	180	32	13	4.4	18	7°	**25**	TS25	TKY08F
S25RSVUCR/L16 ☆	●	●		1604○○	25	200	40	17	6.9	23	5°	**32**	TS4	TKY15F
S32SSVUCR/L16 ☆	●	●		1604○○	32	250	50	22	8.4	30	5°	**40**	TS4	TKY15F
S40TSVUCR/L16 ☆	●	●		1604○○	40	300	63	27	9.4	37	5°	**50**	TS4	TKY15F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d≤3			l/d=3–4 (Shank Diameter ≥ 25mm)		
Carbide Shank			l/d≤5			l/d=6–7		
Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
		Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
		Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
		Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

SC○○ type inserts	➤ A157, A158
VC○○ type inserts	➤ A170–A172
CBN inserts	➤ B062, B077

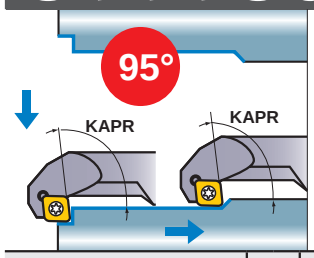
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

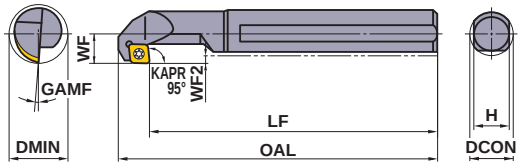
S TYPE BORING BARS

- The minimum cutting diameter is from ϕ20.
- ISO standard.
- 7° positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter

S○○○SCZC

CC○○inserts





Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
(06,09)	(06,09)	(06,09)	(06,09)
Medium	**Medium**	**Flat top**	**CBN/PCD**
MP	MM		
(06,09)	(06,09)	(06,09)	(06,09)

Order Number	Stock R	Stock L	Insert Number		DCON	OAL	LF	WF	WF2	H	GAMF	DMIN	Clamp Screw *	Wrench
S16MSCZCR/L06	●	●	CC○B CC○H CC○T CC○W	0602○○	16	161	150	11	3	14	10°	**20**	TS25	TKY08F
S20QSCZCR/L09	●	●		09T3○○	20	198	180	13	3	18	7°	**25**	TS4	TKY15F

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) When using insert with right and left hand chip breaker, please use right hand insert for right hand holder and left hand insert for left hand holder.
* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

E

BORING BARS

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3–4 (Shank Diameter ≥ 25mm) Cutting Speed (m/min)	l/d=3–4 Feed (mm/rev)	l/d=3–4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
			Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
			Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N	Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
			Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5

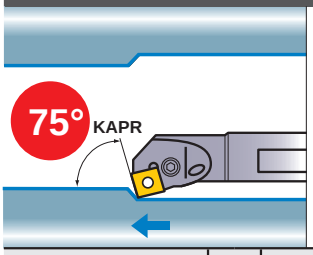
● : Inventory maintained in Japan.

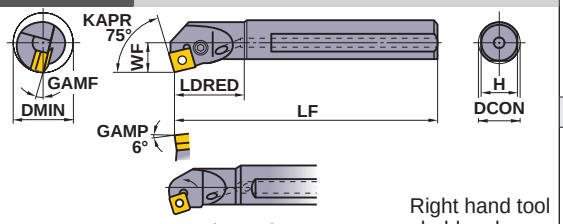
CC○○ type inserts ➤ A140–A147
CBN & PCD inserts ➤ B049–B052, B072

P TYPE BORING BARS

- The minimum cutting diameter is from ϕ25.
- ISO standard.
- Economical negative insert.
- Lever lock type.
- l/d is 3 times the diameter.

A○○○PSKN With coolant hole SN○○inserts





*1 Pin Lock Type

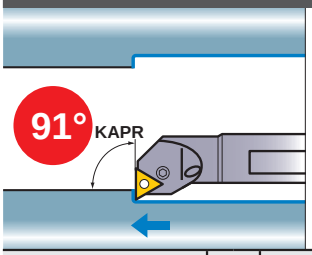
Right hand tool holder shown.

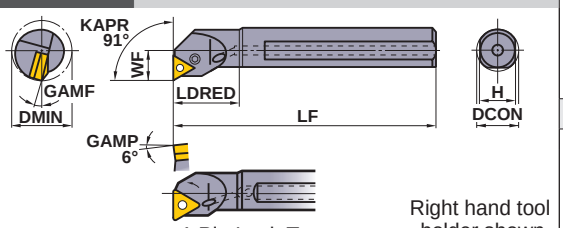
Finish	Light	Medium	Medium
FP	LP	MP	MH
(12)	(12)	(12)	(12)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(09,12)	(12)	(09,12)	(12)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *2	Wrench	Plug	Clamp Pin *2	Pin	Screw
A20QPSKNR/L09	●	●	SNMA SNMG	0903○○	20	180	32	13	18	13°	**25**	—	—	—	—	HKY15R HKY25R	HGM-PT1/8	HP3T	P208AM	HSS03005
A25RPSKNR/L12	●	●	SNMM	1204○○	25	200	40	17	23	13°	**32**	MLSP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPSKNR/L12	●	●	SNGA SNGG	1204○○	32	250	50	22	30	13°	**44**	LLSSN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A20QPSKNR/L09, A25RPSKNR/L12
*2 Clamp Torque (N • m) : LLCS108S=3.3, HP3T=2.2, HP43=3.3

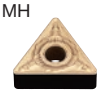
A○○○PTFN With coolant hole TN○○inserts





*1 Pin Lock Type

Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MH
(16)	(16, 22)	(16,22)	 (16,22)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(16,22)	(16,22)	(16,22)	(16,22)

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *2	Wrench	Plug	Clamp Pin *2	Pin	Screw
A20QPTFNR/L16	●	●	TNMA	1604○○	20	180	32	13	18	15°	**25**	—	—	—	—	HKY15R HKY25R	HGM-PT1/8	HP31	P208AM	HSS03005
A25RPTFNR/L16	●	●	TNMG	1604○○	25	200	40	17	23	13°	**32**	MLTP32	—	—	—	HKY15R HKY25R	HGM-PT1/4	HP33	P208AM	HSS03005
A32SPTFNR/L16	●	●	TNMM TNGA	1604○○	32	250	50	22	30	13°	**44**	LLSTN32	LLP13	LLCL13	LLCS106	HKY25R	HGM-PT3/8	—	—	—
A40TPTFNR/L22	●	●	TNGG	2204○○	40	300	63	27	37	10°	**54**	LLSTN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A50UPTFNR/L22	●	●	TNGH	2204○○	50	350	80	35	47	9°	**70**	LLSTN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A20QPTFNR/L16, A25RPTFNR/L16
*2 Clamp Torque (N • m) : LLCS106=2.2, LLCS108S=3.3, HP31=2.2, HP33=2.2

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3—4 Cutting Speed (m/min)	l/d=3—4 Feed (mm/rev)	l/d=3—4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

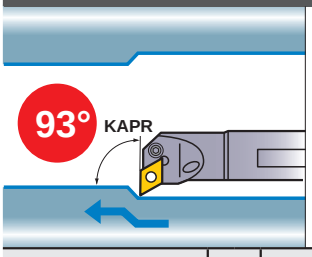
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.8.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

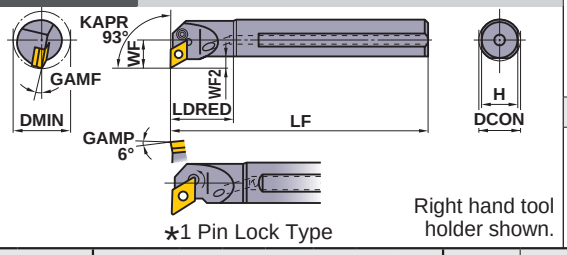
SN○○ type inserts	➤ A115—A120
TN○○ type inserts	➤ A121—A127
CBN & PCD inserts	➤ B037—B041, B069
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

P TYPE BORING BARS

- The minimum cutting diameter is from ϕ20.
- ISO standard.
- Economical negative insert.
- Lever lock type.
- l/d is 3 times the diameter.

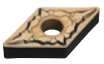
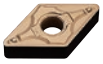
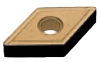
A○○○PDUN With coolant hole DN○○inserts





*1 Pin Lock Type

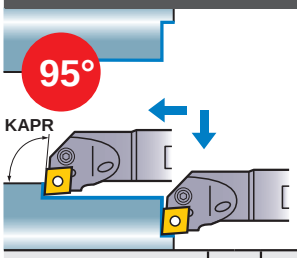
Right hand tool holder shown.

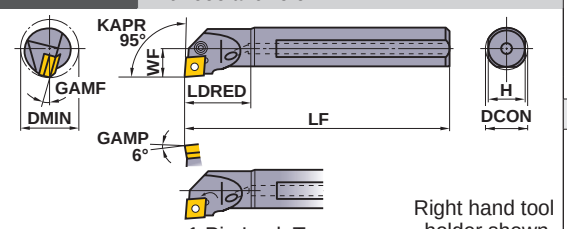
Finish	Light	Medium	Medium
FP	LP	MP	MH
			
(15)	(11, 15)	(15)	(15)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
			
(11,15)	(15)	(15)	(15)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	F2	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *2	Wrench	Plug	Clamp Pin *2	Pin	Screw
A20QPDUNR/L11	●	●	DNMA DNMG DNMX DNMM DNGA DNGG DNGM	1104○○	20	180	32	15	6.4	18	13°	**26**	—	—	LLCL23S	LLCS125	HKY20R	HGM-PT1/8	—	—	—
A25RPDUNR/L11	●	●		1104○○	25	200	40	17	6.9	23	15°	**32**	LLSDN32	LLP13	LLCL23	LLCS106	HKY25R	HGM-PT1/4	—	—	—
A25RPDUNR/L15	●	●		1504○○	25	200	40	17	6.9	23	13°	**32**	MLDP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPDUNR/L11	●	●		1104○○	32	250	50	22	8.4	30	13°	**44**	LLSDN32	LLP13	LLCL23	LLCS106	HKY25R	HGM-PT3/8	—	—	—
A32SPDUNR/L15	●	●		1504○○	32	250	50	22	8.4	30	13°	**44**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A40TPDUNR/L15	●	●		1504○○	40	300	63	27	9.4	37	10°	**54**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A50UPDUNR/L15	●	●		1504○○	50	350	80	35	12.4	47	9°	**70**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A25RPDUNR/L15
*2 Clamp Torque (N • m) : LLCS125=1.5, LLCS106=2.2, LLCS108S=3.3, HP43=3.3

A○○○PCLN With coolant hole CN○○inserts





*1 Pin Lock Type

Right hand tool holder shown.

Finish	Light	Light	Medium
FP	SA	LP	MP
(12)	(12)	(12)	(12)
Medium	**Medium**	**Stainless**	**CBN/PCD**
MH	Standard	MM	
(12)	(09,12)	(12)	(12)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever *3	Clamp Screw *2	Wrench	Plug	Clamp Pin *2	Pin	Screw
A16MPCLNR/L09	●	●	CNMA CNMG CNMM CNGA CNGG CNGM	09T3○○	16	150	25	11	14	15°	**20**	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/8	—	—	—
A20QPCLNR/L09	●	●		09T3○○	20	180	32	13	18	13°	**25**	—	—	—	—	HKY25R HKY15R	HGM-PT1/8	HP3T	P208AM	HSS03005
A20QPCLNR/L09N	●	●		09T3○○	20	180	32	13	18	13°	**25**	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/8	—	—	—
A25RPCLNR/L09	●	●		09T3○○	25	200	40	17	23	13°	**32**	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/4	—	—	—
A25RPCLNR/L12	●	●		1204○○	25	200	40	17	23	13°	**32**	MLCP42	—	—	—	HKY30R HKY15R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPCLNR/L12	●	●		1204○○	32	250	50	22	30	13°	**44**	LLSCN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A40TPCLNR/L12	●	●		1204○○	40	300	63	27	37	10°	**54**	LLSCN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A50UPCLNR12	●			1204○○	50	350	80	35	47	10°	**63**	LLSCP42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A20QPCLNR/L09, A25RPCLNR/L12
*2 Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS108S=3.3, HP3T=2.2, HP43=3.3
*3 When replacing clamp Lever LLCL13S, please consider purchasing lever spring HLS2 as necessary.

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.8.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

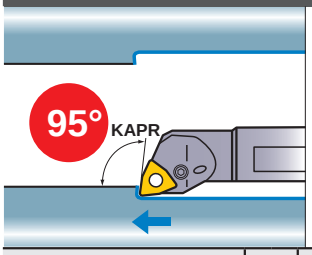
● : Inventory maintained in Japan.

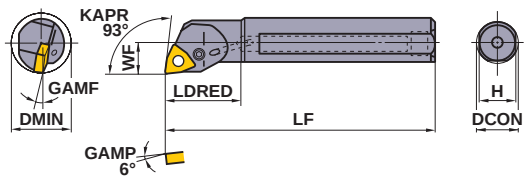
DN○○ type inserts	**➤ A107—A113**
CN○○ type inserts	**➤ A100—A106**
CBN & PCD inserts	**➤ B028—B036, B068**

A○○○PWLN

With coolant hole

WN○○inserts





Right hand tool holder shown.

Light	Medium
LP (06)	MP (06)
Stainless	
MM (06)	

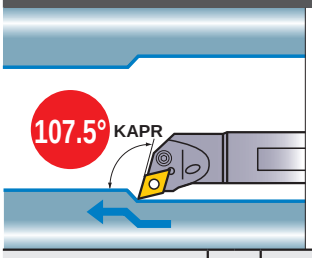
Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	H	GAMF	DMIN	*2 Clamp Lever	*1 Clamp Screw	Wrench	Plug
A16MPWLNR/L06	●	●	WNMG	06T3○○	16	150	25	11	14	15°	**20**	LLCL13S	LLCS105	HKY20R	HGM-PT1/8
A20QPWLNR/L06	●	●		06T3○○	20	180	32	13	18	13°	**25**	LLCL13S	LLCS105	HKY20R	HGM-PT1/8
A25RPWLNR/L06	●	●		06T3○○	25	200	40	17	23	13°	**32**	LLCL13S	LLCS105	HKY20R	HGM-PT1/4

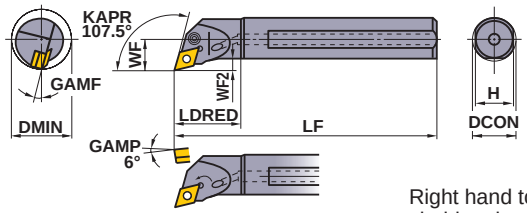
*1 Clamp Torque (N • m) : LLCS105=1.5
*2 When replacing clamp Lever LLCL13S, please consider purchasing lever spring HLS2 as necessary.

A○○○PDQN

With coolant hole

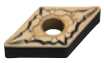
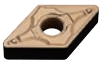
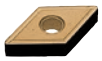
DN○○inserts





*1 Pin Lock Type

Right hand tool holder shown.

Finish	Light	Medium	Medium
FP (15)	LP  (15)	MP (15)	MH  (15)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard  (15)	MM (15)	R/L (15)	(15)

Order Number	Stock R	Stock L	Insert Number		DCON	LF	LDRED	WF	WF2	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	*2 Clamp Screw	Wrench	Plug	*2 Clamp Pin	Pin	Screw
A25RPDQNR/L15	●	●	DNMA DNMG DNMM DNGA DNGG DNGM	1504○○	25	200	40	17	6.9	23	13°	**32**	MLDP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPDQNR/L15	●	●		1504○○	32	250	50	22	8.4	30	13°	**44**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A40TPDQNR/L15	●	●		1504○○	40	300	63	27	9.4	37	10°	**54**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A50UPDQNR15	●			1504○○	50	350	80	35	12.4	47	9°	**70**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A25RPDQNR/L15
*2 Clamp Torque (N • m) : LLCS108S=3.3, HP43=3.3

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3—4 Cutting Speed (m/min)	l/d=3—4 Feed (mm/rev)	l/d=3—4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

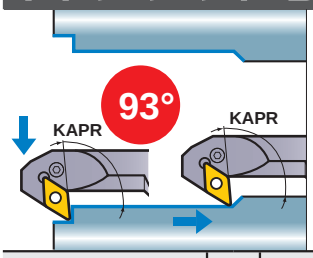
WN○○ type inserts	➤ A132—A136
DN○○ type inserts	➤ A107—A113
CBN & PCD inserts	➤ B032—A036, B068
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

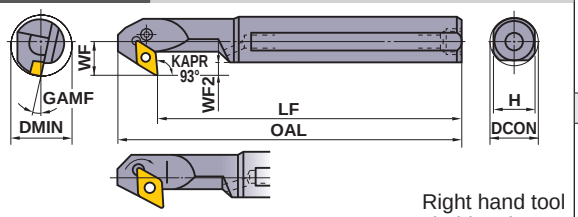
P TYPE BORING BARS

- The minimum cutting diameter is from ϕ32.
- ISO standard.
- Economical negative insert.
- Lever lock type.
- l/d is 3 times the diameter.

A○○○PDZN

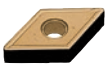
With coolant hole **DN○○inserts**





*1 Pin Lock Type

Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MH
(15)	(15)	(15)	(15)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
			
(15)	(15)	(15)	(15)

Order Number	Stock R	Stock L	Insert Number		DCON	OAL	LF	WF	WF2	H	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *2	Wrench	Plug	Clamp Pin *2	Pin	Screw
A25RPDZNR/L15	●	●	DNMA DNMG	1504○○	25	225	200	17	6.7	23	13°	**32**	MLDP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPDZNR/L15	●	●	DNMX DNMM	1504○○	32	275	250	22	8.2	30	13°	**40**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A40TPDZNR/L15	●	●	DNGA DNGG	1504○○	40	325	300	27	9.2	37	10°	**50**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—
A50UPDZNR/L15	●	●	DNGM	1504○○	50	375	350	35	12.2	47	9°	**63**	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—

*1 Pin Lock Type : A25RPDZNR/L15

*2 Clamp Torque (N • m) : LLCS108S=3.3, HP43=3.3

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

Note 2) Dimensions shown for insert corner RE 0.8.

Note 3) When using insert with right and left hand chip breaker, please use right hand insert for right hand holder and left hand insert for left hand holder.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3—4 Cutting Speed (m/min)	l/d=3—4 Feed (mm/rev)	l/d=3—4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

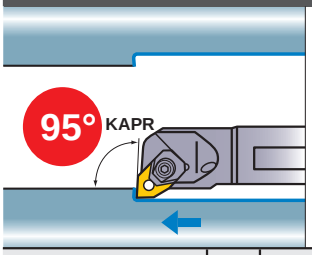
● : Inventory maintained in Japan.

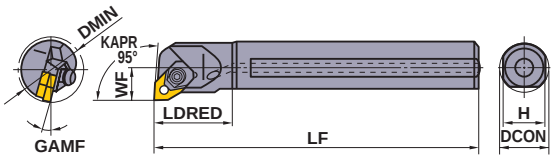
DN○○ type inserts ➤ A107—A113
CBN & PCD inserts ➤ B032—B036, B068

M TYPE BORING BARS

- The minimum cutting is from ϕ63.
- Negative trigon shape insert.
- Double clamp type.
- l/d is 3 times the diameter.

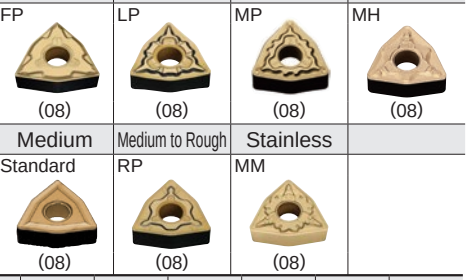
A○○○MWLN With coolant hole WN○○inserts





Right hand tool holder only.

Finish	Light	Medium	Medium
FP (08)	LP (08)	MP (08)	MH (08)
Medium	**Medium to Rough**	**Stainless**	
Standard (08)	RP (08)	MM (08)	



Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	GAMF	DMIN	Shim	Shim Pin	Clamp Bridge	Side Lock Plate	Spring	Clamp Screw *	Wrench	Plug
A50UMWLNR08	●	WNMA WNMG WNGA	0804○○	50	350	80	35	63	9°	**63**	WPS WC43	CCP44	CCK13	CPT24	MES2	SLCS105	HKY25R HKY40R	HGM-PT3/8

*1 Clamp Torque (N • m) : SLCS105=7.0

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.8.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3–4 Cutting Speed (m/min)	l/d=3–4 Feed (mm/rev)	l/d=3–4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180–350HB	Medium Cutting	110 (80–140)	0.25 (0.1–0.4)	–5.0	110 (80–140)	0.2 (0.1–0.3)	–4.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60–100)	0.2 (0.1–0.3)	–4.0	70 (50–100)	0.15 (0.1–0.25)	–3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60–100)	0.25 (0.1–0.4)	–5.0	80 (60–100)	0.2 (0.1–0.3)	–4.0

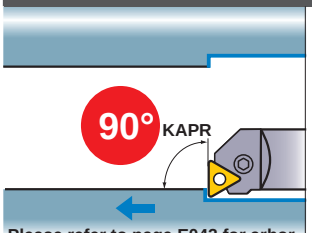
WN○○ type inserts ➤ A132–A136
CBN inserts ➤ B044

D TYPE BORING HEAD

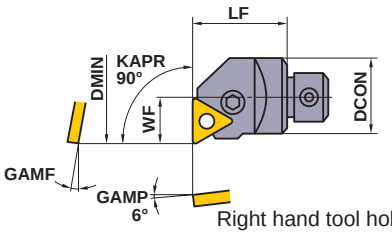
- The minimum cutting diameter is from ϕ40.
- Economical negative insert.
- Lever lock type.
- Exchangeable head type.

DPTF

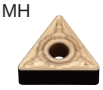
TN○○inserts



Please refer to page E042 for arbor.



Right hand tool holder only.

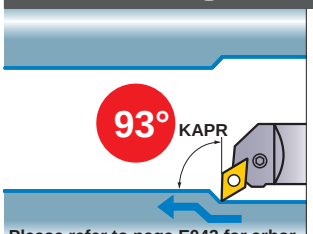
Finish	Light	Medium	Medium
FP	LP	MP	MH
			
(16)	(16,22)	(16,22)	(16,22)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	R/L	
(16,22)	(16,22)	(16,22)	(16)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
DPTF132R	●	TN○A TN○G TN○M	1604○○	32	40	20	12°	**40**	LLSTN32	LLP13	LLCL13	LLCS106	HKY25R
DPTF140R	●		2204○○	40	50	25	10°	**50**	LLSTN42	LLP14	LLCL14	LLCS108	HKY30R

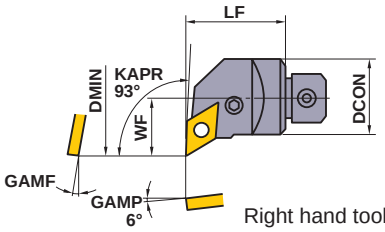
* Clamp Torque (N • m) : LLCS106=2.2, LLCS108=3.3

DPDU

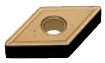
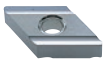
DN○○inserts



Please refer to page E042 for arbor.



Right hand tool holder only.

Finish	Light	Medium	Medium
FP	LP	MP	MH
(15)	(15)	(15)	(15)
Medium	**Stainless**	**G class**	**CBN/PCD**
Standard	MM	L	
			
(15)	(15)	(15)	(15)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
DPDU132R	●	DN○A DN○G DN○M DN○X	1504○○	32	40	25	10°	**50**	LLSDN42	LLP14	LLCL24	LLCS108	HKY30R
DPDU140R	●		1504○○	40	50	30	9°	**60**	LLSDN42	LLP14	LLCL24	LLCS108	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

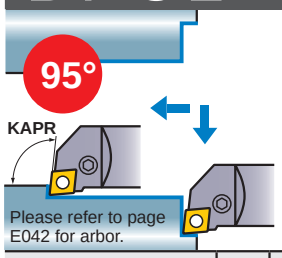
Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.8.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

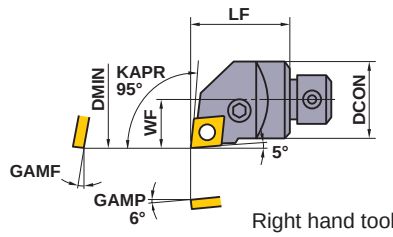
● : Inventory maintained in Japan.

TN○○ type inserts	**➤ A121—A127**
DN○○ type inserts	**➤ A107—A113**
CBN & PCD inserts	**➤ B032—B036, B039—B041, B068, B069**

DPCL

CN○○inserts





Right hand tool holder only.

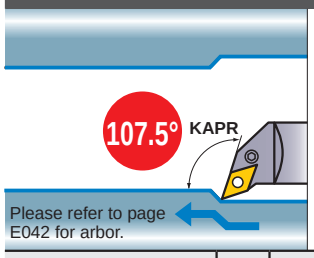
Finish	Light	Light	Light
FP	SA	LP	LM
(12)	(12)	(12)	(12)
Medium	Medium	Stainless	CBN/PCD
MP	Standard	MM	
(12)	(12)	(12)	(12)

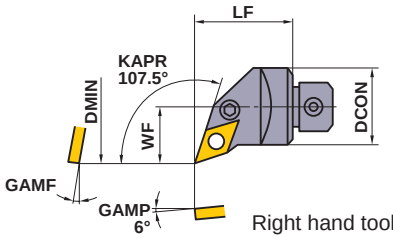
Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
DPCL132R	●	CN○A CN○G CN○M	1204○○	32	40	20	12°	**40**	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
DPCL140R	●		1204○○	40	50	25	10°	**50**	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

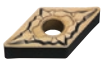
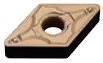
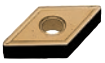
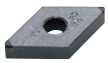
DPDH

DN○○inserts





Right hand tool holder only.

Finish	Light	Medium	Medium
FP	LP	MP	MH
			
(15)	(15)	(15)	(15)
Medium	Stainless	G class	CBN/PCD
Standard	MM	L	
			
(15)	(15)	(15)	(15)

Order Number	Stock R	Insert Number		Dimensions(mm) DCON	LF	WF	GAMF	DMIN	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Wrench
DPDH132R	●	DN○A DN○G DN○M	1504○○	32	40	25	10°	**50**	LLSDN42	LLP14	LLCL24	LLCS108	HKY30R
DPDH140R	●		1504○○	40	50	30	9°	**60**	LLSDN42	LLP14	LLCL24	LLCS108	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	l/d≤3 Cutting Speed (m/min)	l/d≤3 Feed (mm/rev)	l/d≤3 Depth of Cut (mm)	l/d=3—4 Cutting Speed (m/min)	l/d=3—4 Feed (mm/rev)	l/d=3—4 Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

CN○○ type inserts	➤ A100—A106
DN○○ type inserts	➤ A107—A113
CBN & PCD inserts	➤ B028—B036, B068

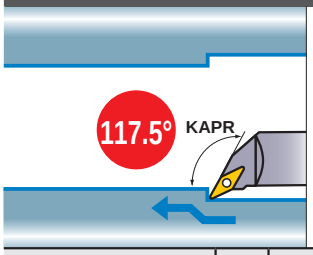
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

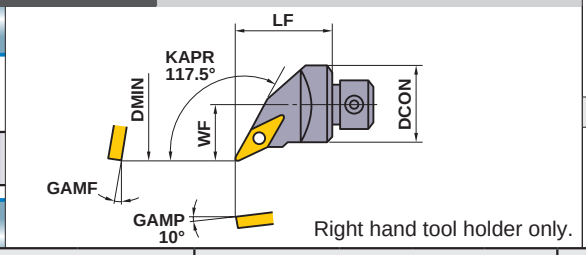
D TYPE BORING HEAD

- The minimum cutting diameter is from ϕ40.
- Economical negative insert.
- Lever lock type.
- Exchangeable head type.

DPVP

VN○○inserts





Right hand tool holder only.

Finish	Light	Medium	Medium
FP	LP	MP	MH
(16)	(16)	(16)	(16)
Stainless	**G class**	**PCD**	**CBN**
MM	L	L-F	
(16)	(16)	(16)	(16)

Order Number	Stock	Insert Number		Dimensions(mm)					Shim	Lock Pin	Lock Screw *	Stop Ring	Wrench
	R			DCON	LF	WF	GAMF	DMIN					
DPVP132R	●	VN○A VN○G VN○M	1604○○	32	40	25	13°	**50**	PV322	P11S	HSP05008C	E03	HKY25R
DPVP140R	●		1604○○	40	50	30	13°	**60**	PV322	P11S	HSP05008C	E03	HKY25R

* Clamp Torque (N • m) : HSP05008C=2.5

Note 1) Dimensions shown for insert corner RE 0.8.

STANDARD ARBOR FOR D TYPE BORING HEAD

① **B** ② **1** ③ **32** ④ **32**

①Designation

②Arbor Length (mm)

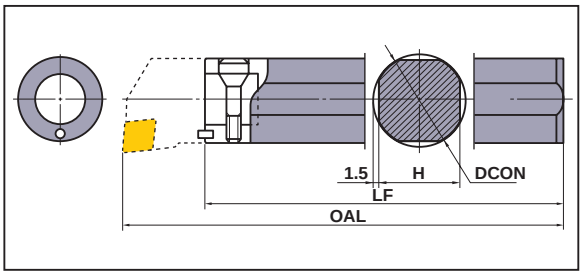
Symbol	DCON	LF	OAL
1	32	260	300
	40	310	360

③Arbor Diameter (mm)

Symbol	Diameter(DCON)
32	32
40	40

④Head Diameter (mm)

Symbol	Diameter(BD)
32	32
40	40



Order Number	Stock	Dimensions (mm)				Set Bolt	Wrench	Head Order Number
		DCON	LF	H	OAL			
B13232	●	32	260	29	300	SD32	HKY60R	DP○○132R
B14040	●	40	310	37	360	SD40	HKY60R	DP○○140R

● : Inventory maintained in Japan.

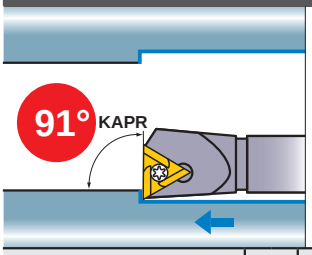
VN○○ type inserts	➤ A128—A131
CBN & PCD inserts	➤ B042, B043, B070

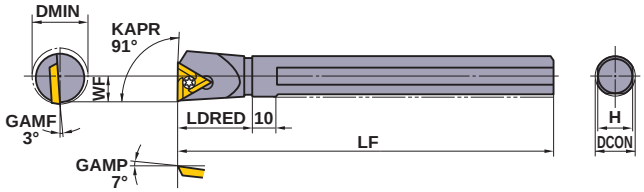
AL TYPE BORING BARS

- Suitable for non-ferrous metal.
- 20° positive insert.
- Screw-on type.
- l/d is 6 times the diameter.
- Excellent vibration resistance.
- The minimum cutting diameter is from ϕ20.

STFE

TE○○inserts





Right hand tool holder shown.

Medium	PCD
R/L (16)	R/L (16)
PCD (16)	

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) DCON	LF	LDRED	WF	H	DMIN	Clamp Screw *	Wrench
S16RSTFER/L16	●	●	TEGX○○○R/L TEGX	1603○○	16	200	30	11	14.6	**20**	FC400890T	TKY10F
S20RSTFER/L16	●	●		1603○○	20	200	37	13	18	**25**	FC400890T	TKY10F
S25SSTFER/L16	●	●		1603○○	25	250	40	17	23	**32**	FC400890T	TKY10F

* Clamp Torque (N • m) : FC400890T=2.5

E

BORING BARS

RECOMMENDED CUTTING CONDITIONS

Work Material		Grade	Cutting Speed (m/min)	l/d=3 Feed (mm/rev)	l/d=3 Depth of Cut (mm)	l/d=4 Feed (mm/rev)	l/d=4 Depth of Cut (mm)	l/d=5 Feed (mm/rev)	l/d=5 Depth of Cut (mm)	l/d=6 Feed (mm/rev)	l/d=6 Depth of Cut (mm)
N	Aluminium Alloy	**HTi10**	400 (200—600)	0.15 (0.05—0.25)	—3.0	0.15 (0.05—0.25)	—3.0	0.1 (0.05—0.2)	—2.5	0.1 (0.05—0.2)	—1.0
		MD220	800 (200—1500)	0.15 (0.05—0.25)	—3.0	0.15 (0.05—0.25)	—3.0	0.1 (0.05—0.2)	—2.5	0.1 (0.05—0.2)	—1.0

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note 2) Dimensions shown for insert corner RE 0.4.
Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.

TE○○ type inserts	**➤ A163**	**SPARE PARTS**	**➤ Q001**
PCD inserts	**➤ B079**	**TECHNICAL DATA**	**➤ R001**

HOW TO READ THE STANDARD OF GROOVING AND CUTTING OFF

●How this section page is organised

①Classified according to external or internal applications.
②Sub-classified according to product series.
(Refer to the index on the next page.)

[For External Grooving / Cutting Off] [For Internal Grooving]

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict available machining applications such as cutting off, grooving, and copying.

INDICATION OF HOLDER TYPE ACCORDING TO APPLICATION
indicates the holder types, such as the standard type or the L type, according to machining application.

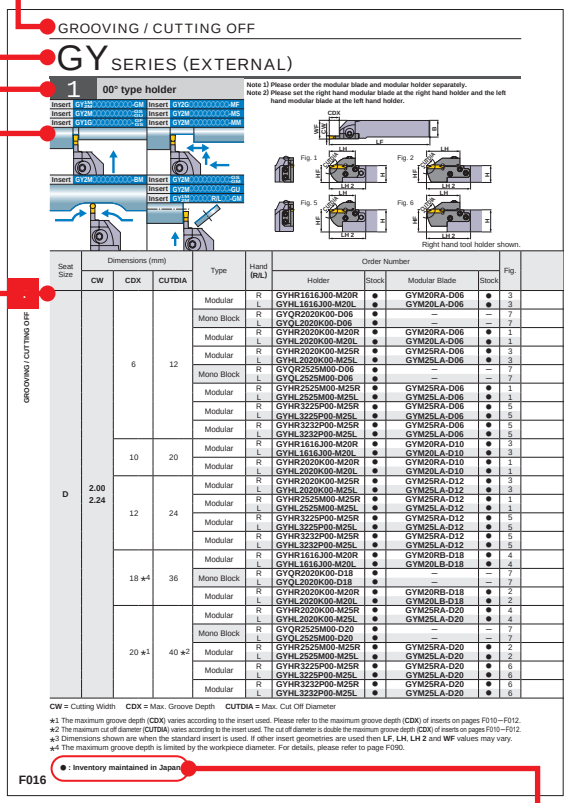
TITLE OF PRODUCT

PRODUCT SECTION

PRODUCT FEATURES

MIN. CUTTING DIAMETER
is colour-coded to let you find, at a glance, the minimum cutting diameters for internal machining.

GEOMETRY


GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1 00° type holder

Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

Right hand tool holder shown.

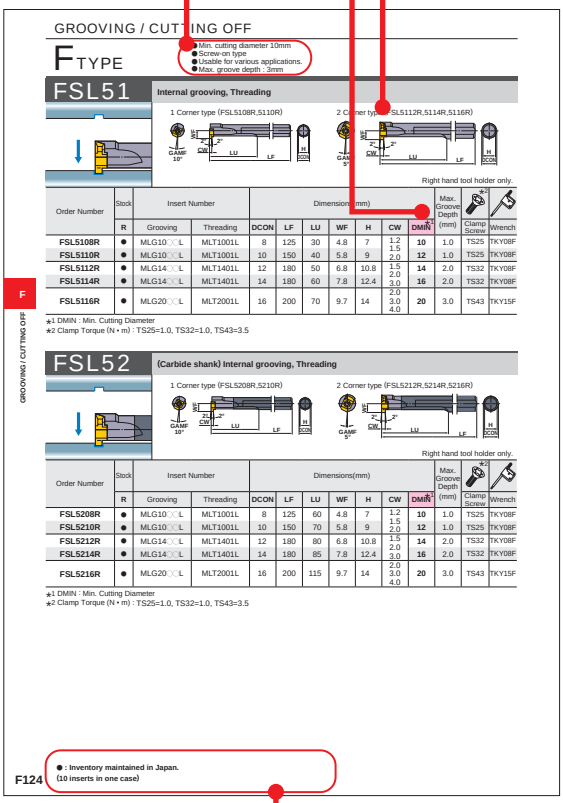
Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
D	2.00 2.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D06	●	3
				Mono Block	R	GYQR2020K00-D06	●	—	–	7
					L	GYQL2020K00-D06	●	—	–	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-D06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D06	●	3
				Mono Block	R	GYQR2525M00-D06	●	—	–	7
					L	GYQL2525M00-D06	●	—	–	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D06	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D06	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-D06	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D06	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-D06	●	5
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D12	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D12	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-D12	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D12	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-D12	●	5
		18 ★4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-D18	●	4
					L	GYHL1616J00-M20L	●	GYM20LB-D18	●	4
				Mono Block	R	GYQR2020K00-D18	●	—	–	7
					L	GYQL2020K00-D18	●	—	–	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-D18	●	2
					L	GYHL2020K00-M20L	●	GYM20LB-D18	●	2
		20 ★1	40 ★2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D20	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-D20	●	4
				Mono Block	R	GYQR2525M00-D20	●	—	–	7
					L	GYQL2525M00-D20	●	—	–	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D20	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-D20	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D20	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-D20	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D20	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-D20	●	6

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

★1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F010~F012.
★2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F010~F012.
★3 Dimensions shown are when the standard insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.
★4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F090.

● : Inventory maintained in Japan

F016


GROOVING / CUTTING OFF

F TYPE

● Min. cutting diameter 10mm
● Screw-on type
● Usable for various applications.
● Max. groove depth : 3mm

FSL51 Internal grooving, Threading

Right hand tool holder only.

Order Number	Stock R	Insert Number Grooving	Insert Number Threading	DCON	LF	LU	WF	H	CW	DMIN ★1	Max. Groove Depth (mm)	Clamp Screw	Wrench
FSL5108R	●	MLG10□□L	MLT1001L	8	125	30	4.8	7	1.2 1.5 2.0	10	1.0	TS25	TKY08F
FSL5110R	●	MLG10□□L	MLT1001L	10	150	40	5.8	9	1.5 2.0	12	1.0	TS25	TKY08F
FSL5112R	●	MLG14□□L	MLT1401L	12	180	50	6.8	10.8	1.5 2.0	14	2.0	TS32	TKY08F
FSL5114R	●	MLG14□□L	MLT1401L	14	180	60	7.8	12.4	2.0 3.0	16	2.0	TS32	TKY08F
FSL5116R	●	MLG20□□L	MLT2001L	16	200	70	9.7	14	2.0 3.0 4.0	20	3.0	TS43	TKY15F

★1 DMIN : Min. Cutting Diameter
★2 Clamp Torque (N・m) : TS25=1.0, TS32=1.0, TS43=3.5

FSL52 (Carbide shank) Internal grooving, Threading

Right hand tool holder only.

Order Number	Stock R	Insert Number Grooving	Insert Number Threading	DCON	LF	LU	WF	H	CW	DMIN ★1	Max. Groove Depth (mm)	Clamp Screw	Wrench
FSL5208R	●	MLG10□□L	MLT1001L	8	125	60	4.8	7	1.2 1.5 2.0	10	1.0	TS25	TKY08F
FSL5210R	●	MLG10□□L	MLT1001L	10	150	70	5.8	9	1.5 2.0	12	1.0	TS25	TKY08F
FSL5212R	●	MLG14□□L	MLT1401L	12	180	80	6.8	10.8	1.5 2.0 3.0	14	2.0	TS32	TKY08F
FSL5214R	●	MLG14□□L	MLT1401L	14	180	85	7.8	12.4	2.0 3.0 4.0	16	2.0	TS32	TKY08F
FSL5216R	●	MLG20□□L	MLT2001L	16	200	115	9.7	14	2.0 3.0 4.0	20	3.0	TS43	TKY15F

★1 DMIN : Min. Cutting Diameter
★2 Clamp Torque (N・m) : TS25=1.0, TS32=1.0, TS43=3.5

● : Inventory maintained in Japan.
(10 inserts in one case)

F124

PRODUCT STANDARDS
indicates order numbers, stock status (per right/left hand), holders, Modular Blade, cutting widths, maximum groove depths, maximum cut-off diameters, dimensions, applicable inserts, and cutting edge shapes.

LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

●To Order : For holder, please specify ①order number and hand of tool (right/left).
For insert, please specify ①insert number and ②grade.

TURNING TOOLS

GROOVING AND CUTTING OFF

CLASSIFICATION (EXTERNAL) ····· F002
CLASSIFICATION (INTERNAL) ····· F003

STANDARD OF GROOVING AND CUTTING OFF TOOLS

EXTERNAL

FEATURES OF THE GY SERIES ····· F004
GY SERIES ORDER NUMBER ····· F008
GY SERIES INSERTS ····· F010
GY SERIES REFERENCE MATERIAL ··· F013
GY SERIES ····· F014
NEW GW SERIES ····· F106
UG HOLDER ····· F114
MG HOLDER ····· F116
SMG HOLDER ····· F118

INTERNAL

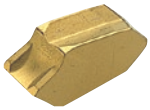
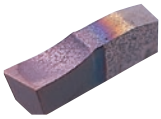
GY SERIES ····· F080
MICRO-MINI BORING BARS ····· F119
MICRO-MINI TWIN BORING BARS ····· F120
F TYPE BORING BARS ····· F124
D TYPE BORING HEAD ····· F126

*Arranged by Alphabetical order

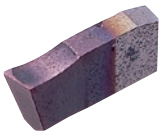
F119 **C○○○R-BLS**
F120 **CG**
F126 **DPT4**
F124 **FSL51**
F124 **FSL52**
F112 **GW1**
F110 **GWB**
F111 **GWTB**
F014 **GY**
F115 **KGBN**
F115 **KGT**
F116 **MGH**
F117 **MGT**
F125 **MLG**
F125 **MLT**
F122 **RBH**
F123 **SBH**
F118 **SMGH**
F118 **SMGT**
F118 **SMTT**
F114 **UGH**
F114 **UGHN**

CLASSIFICATION

EXTERNAL

Name of Tool Holder	Insert Shape	Features	Cutting Width According to Cutting Mode (mm)					
			Shallow Grooving	Deep Grooving	Cutting Off	Copying	Recessing	Face Grooving
GY Series F014		**Modular blade type** ● Clamp-on type. ● The modular blade allows for high rigidity and accuracy. (Tri-Lock System) ● Various insert types. **Mono block type** ● Clamp-on type. ● Maximum cut off diameter : 50mm. TOOL NEWS	1.5 2 2.24 2.39 2.5 2.74 3 3.18 3.24 4 4.24 4.75 5 5.24 6 6.31 6.35 8	1.5 2 2.24 2.39 2.5 2.74 3 3.18 3.24 4 4.24 4.75 5 5.24 6 6.31 6.35 8	1.5 2 2.24 2.39 2.5 2.74 3 3.18 3.24 4 4.24 4.75 5 5.24 6 6.31 6.35 8	2 2.5 3 3.18 4 4.75 5 6 6.35 8	2 2.5 3 3.18 4 4.75 5 6 6.35	2 2.24 2.39 2.5 2.74 3 3.18 3.24 4 4.24 4.75 5 5.24 6 6.31 6.35
GW Series NEW F110		● Spring clamp type. ● Simple insert clamping method. ● The blade is possible to use with both external or through coolant. ● Breaker system offering excellent chip disposal properties. ● Maximum cut off diameter : 120mm. TOOL NEWS	2.0 3.0 4.0 5.0	2.0 3.0 4.0 5.0	2.0 3.0 4.0 5.0			
UG Holder F114		● Spring clamp type. ● Strengthened insert clamping. ● Block and blade type and solid type series. ● Maximum cut off diameter : 120mm.	2.2 3.1 4.1 5.1	2.2 3.1 4.1 5.1	2.2 3.1 4.1 5.1			
MG Holder F116		● Clamp-on type. ● Precision class insert. ● Positive insert suffers from negligible chattering and thus produces a good finished surface.	1.25 I 6					
SMG Holder F118		● Screw-on type. ● Precision class insert. ● Positive insert suffers from negligible chattering and thus produces a good finished surface.	0.5 I 1.3					
SMALL TOOLS **GTAH GTBH GTCH** D016		● For gang type tool posts. ● Small Shank : 8–16mm ● Possible to control the back clamping. ● High rigidity due to design of vertical insert. ● Economical due to the design of three-corner inserts.	0.3 I 3.0					
CTAH D018		● For gang type tool posts. ● Small Shank : 8–16mm ● Due to the design of handed tool holders, able to minimize accumulation of workpieces. ● High rigidity due to design of vertical insert. ● Maximum cut off diameter : 12mm	0.7 1.0 1.5 2.0	0.7 1.0 1.5 2.0	0.7 1.0 1.5 2.0			
CTBH D013		● For gang type tool posts. ● Small Shank : 10–16mm ● Single holder for inserts for back turning and cutting off. ● High rigidity due to design of vertical insert. ● Maximum cut off diameter : 16mm	1.5 2.0	1.5 2.0	1.5 2.0			
CTCH D021		● For gang type tool posts. ● Small Shank : 10mm,12mm ● High cutting edge sharpness and excellent chip discharge. ● Maximum cut off diameter : 20mm	2.2 2.5	2.2 2.5	2.2 2.5			

EXTERNAL

	Name of Tool Holder	Insert Shape	Features	Cutting Width According to Cutting Mode (mm)				
				Shallow Grooving	Deep Grooving	Cutting Off	Copying	Face Grooving
SMALL TOOLS	**CTDH** D022		● For gang type tool posts. ● Small Shank : 16mm ● High cutting edge sharpness and excellent chip discharge. ● Maximum cut off diameter : 23–35mm	2.5	2.5	2.5		
	CTEH D023		● For gang type tool posts. ● Small Shank : 16mm ● High cutting edge sharpness and excellent chip discharge. ● Maximum cut off diameter : 23–35mm	3.0	3.0	3.0		
	CSVH D027		● For cam type tool posts. ● Small Shank : 7–12mm ● Single holder responds to front turning, back turning, grooving, threading and cutting off operations. ● The most suitable for machining of small parts with work diameter 5mm or smaller. ● Maximum groove depth : 0.3–2.5mm ● Maximum cut off diameter : 3–5mm	0.25 I 1.5		0.6 I 1.5		

INTERNAL

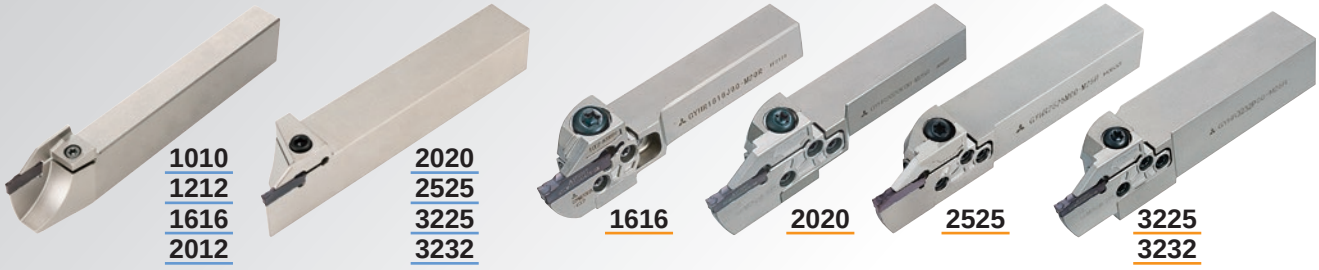
Name of Tool Holder	Insert Shape	Features	Min. Cutting Diameter (mm)	Groove Width (mm)	Max. Groove Depth (mm)
MICRO-MINI TWIN Boring Bars F120	–	● Solid carbide type. ● Economical due to single tool with two cutting edges.	3.0	1.0 I 2.0	1.0 I 2.0
MICRO-MINI Boring Bars F119	–	● Solid carbide type. ● Insert can be ground to suit the application.	3.2	2.0 I 3.0	1.0 I 2.0
GY Series F080		**Modular blade type** ● Clamp-on type. ● The modular blade allows for high rigidity and accuracy. (Tri-Lock System) ● Various insert types. **Mono block type** ● Clamp-on type. TOOL NEWS	25	2 I 6.35	4 I 13
FSL5 F124		● Screw-on type. ● Precision class insert. ● Holder is capable of performing both grooving and threading. ● Maximum groove depth : 3mm.	10	1.2 I 4.0	1.0 I 3.0
DPT4 F126		● Pin lock type. ● Precision class insert. ● Exchangable head type.	40	1.25 I 4.5	1.2 I 4.5

GY SERIES

A wide selection of holders and inserts available for diverse grooving and cutting off applications

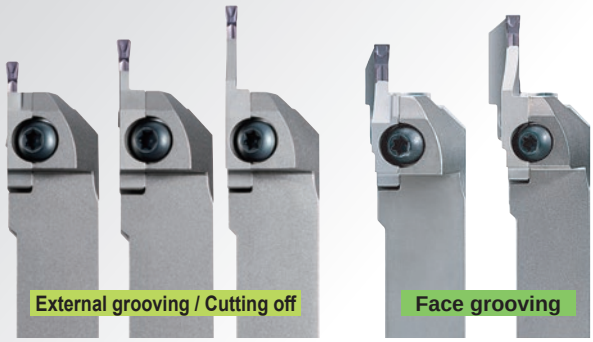
External • Face holders

Corresponding blades to a variety of modular holders with different shank sizes



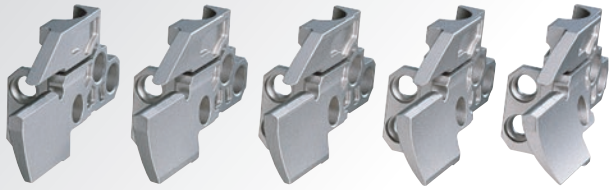
Mono block type | Modular type

A wide selection of holders and inserts available for diverse grooving and cutting off applications



Same holder

Applicable for various diameters of face grooves by the wide array of modular blades with different grooving diameters



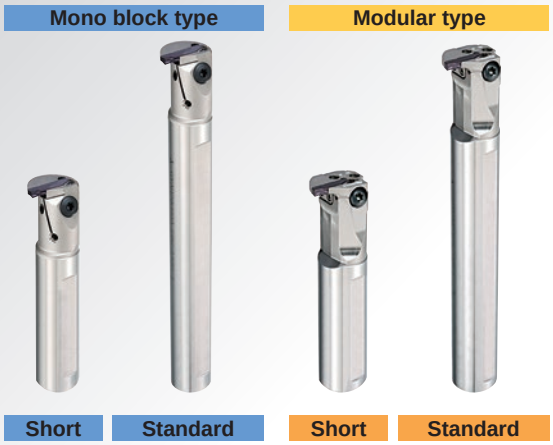
Internal holders

A wide range of holders available from minimum diameter of ø25mm

Mono block type — Min.cutting diameter ϕ25, ϕ32mm

Modular type — Min.cutting diameter ϕ40, ϕ50mm ϕ60, ϕ70mm

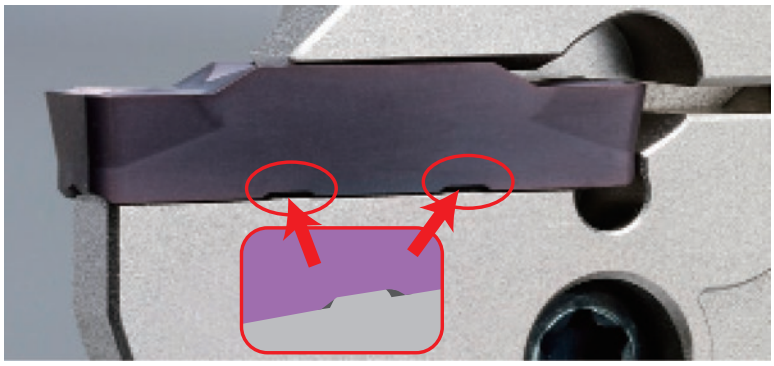
Short shank types are standard stocked



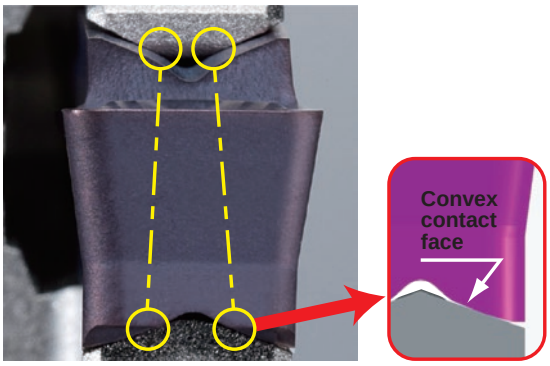
Original insert design leading the way to new grooving and cutting off applications

Highly reliable insert clamping

Safety keys prevent insert movement.



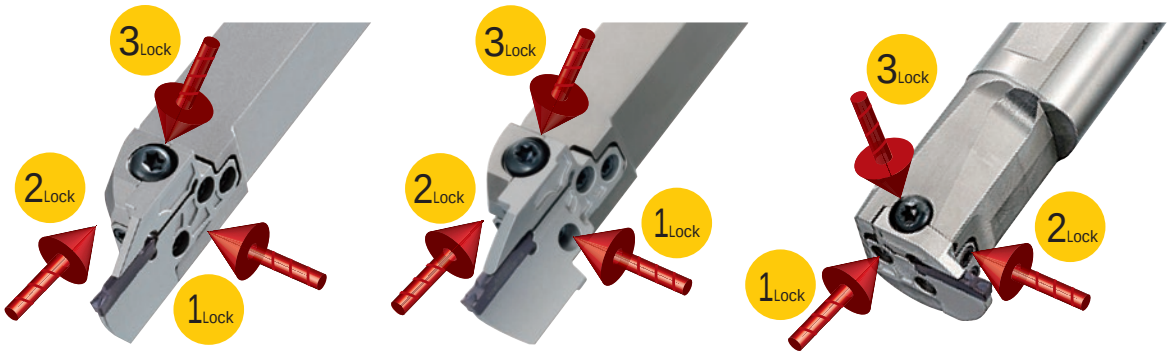
The convex geometry ensures high precision clamping.



New TRI-LOCK System for increased stability and performance!

TRI-LOCK System

The TRI-LOCK system ensures the blade is securely fixed in 3 directions (side, front and top), giving high rigidity for stable grooving and cutting off performance.

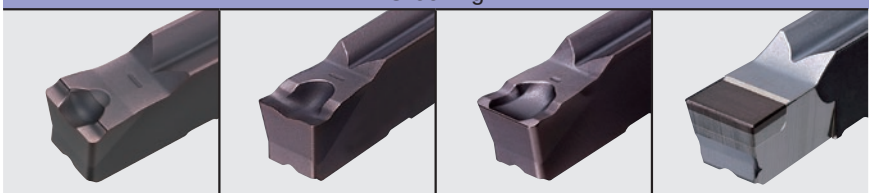


INSERT

A WIDE SELECTION OF INSERTS

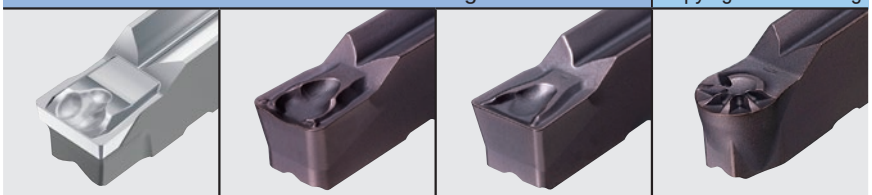
● Breaker system

Grooving



GUBreaker (For Gummy Steel)	GSBreaker (Low feeds)	GMBreaker (Medium feeds)	GFGS (For hardened steel)

For Multifunctional Grooving / Copying/For recessing



MFBreaker (G class)	MSBreaker (Low feeds)	MMBreaker (Medium feeds)	BMBreaker

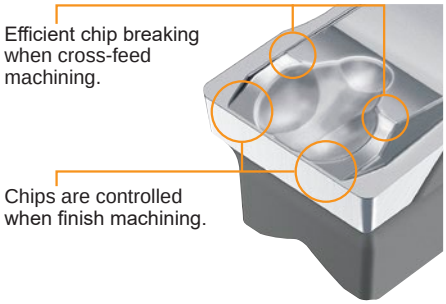
Cutting Off

GUBreaker (For Gummy Steel)	GSBreaker (Low feeds)	GMBreaker (Medium feeds)	R/L05-GMBreaker (Medium feeds)

● Selection of cutting widths

● Different corner radii available

● MF Breaker

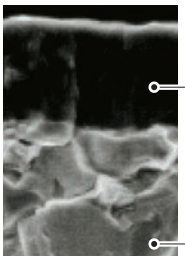


INSERT GRADE

Work Material / Machining Condition	P Steel	M Stainless Steel	K Cast Iron	S Heat Resistant Alloy / Titanium Alloy	H Hardened Steel
Stable ↑	NX2525				BC8110
	MY5015		MY5015	VP10RT	
Machining Condition	VP10RT	VP10RT			
			VP10RT	RT9010	MB8025
↓ Unstable	VP20RT	VP20RT	VP20RT	VP20RT	

Note1) VP20RT is the first recommended grade for materials other than hardened steel.
Note2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

VP20RT (1st Recommendation)

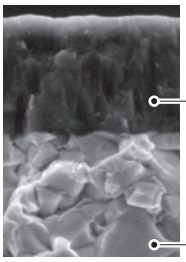


- PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Tough cemented carbide substrate (90.5HRA)

VP10RT (2nd Recommendation)

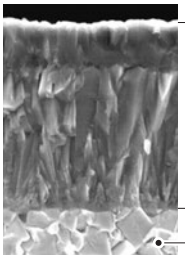


- PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE Coating

Tough cemented carbide substrate (92.0HRA)

MY5015



- MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast irons. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Tough cemented carbide substrate

RT9010

- First recommended grade for Titanium alloys.
  Not recommended for use on non-ferrous alloys.

NX2525

- NX2525, a cermet grade for finish machining of steels and for good surface finishes at lower cutting speeds.

BC8110

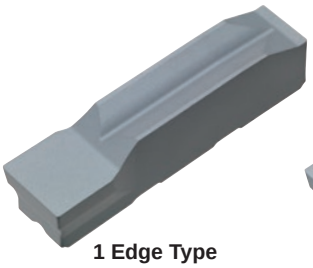
- A CBN coated grade for continuous cutting, which provides longer life when machining hardened steel.

MB8025

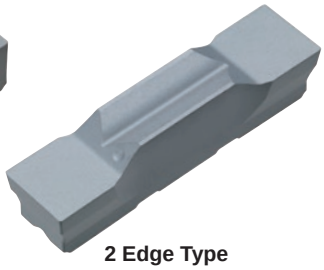
- MB8025 is a sintered CBN grade for hardened steel.

BLANK INSERTS

- Blank inserts for custom grinding



1 Edge Type



2 Edge Type

⁎ Insert blank is not suitable for machining without grinding.

RT9010/RT9020 for insert blank

- First recommendation on insert blank is RT9020 due to the tougher carbide substrate and suitable for a wide range of application.
  RT9010 is a harder substrate than RT9020 and is ideal for long tool life on stable cutting applications.
  Coating is recommended for application on steel, stainless steel and cast iron materials.

GY SERIES ORDER NUMBER

■ INSERT

① GY ② 2 ③ M ④ 0300 ⑤ F ⑥ 030 ⑦ N ⑧ 05 – ⑨ M ⑩ F

①Series Description

②Number of Teeth

1	1 Edge Type
2	2 Edge Type

③Peripheral

G	Ground
M	Sintered
B	Blank

④Cutting Width

0150	1.50mm
0200	2.00mm
⋮	⋮
0800	8.00mm

⑤Seat Size ⋆1

C	1.50mm
D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.35mm
K	8.00mm

⑥Corner Radius

010	0.10mm
015	0.15mm
⋮	⋮
400	4.00mm

⑦Hand

N	Neutral
R	Right
L	Left

⑧Lead angle (R/L type insert)

05	5º

⑨Application 1

G	Grooving/Cutting off
M	Multifunctional
B	Copying (Ball shape)

⑩Application 2

U	For Gummy Steel
F	Finishing
S	Low feeds
M	Medium feeds

■ CBN INSERT

① GY ② 1 ③ G ④ 0300 ⑤ F ⑥ 020 ⑦ N – ⑨ G ⑪ F ⑫ GS

⑪Application 3

F	Flat Top

⑫Honing Type

GS	General Purpose

⋆1 Select a seat size with the same symbol as that of modular blade and mono block holder.

■ MODULAR BLADE

● EXTERNAL/INTERNAL/FOR RECESSING

① GY ② M25 ③ R ④ A – ⑤ F ⑥ 12 ⋆3

①Series Description

②Modular Blade Size

M20
M25

③Hand

R	Right
L	Left

④Modular Blade Type

A	Standard Type
B	Reinforced Type
C	For recessing
D	Face Grooving

⑤Seat Size ⋆1

D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.35mm

⑥Max. Groove Depth CDX ⋆2

005	0.5mm
06	6mm
⋮	⋮
25	25mm

● FACE GROOVING

① GY ② M25 ③ R ④ D – ⑤ F ⑥ 12 – ⑦ 050

⑦Min. Groove Diameter

035	35mm
040	40mm
⋮	⋮
250	250mm

⋆1 Select a seat size with the same symbol as that of the insert.
⋆2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.
For internal grooving, refer to the maximum groove depth on pages F080—F086.
⋆3 GYM20R/LA-◯10, GYM20R/LA-◯12, GYM25R/LA-◯12 and GYM25R/LA-◯14 can be used for both external and internal grooving.

■ EXTERNAL/FACE GROOVING/FOR RECESSING

● MONO BLOCK HOLDER

①	②	③	④	⑤	⑥		⑦	⑧
GY	P	R	2525	M	00	–	K	25

①Series Description

②Holder Type

S	Mono block type for Swiss style lathes
P	With mono block offset
Q	Without mono block offset
H	Modular holder

③Hand of Holder

R	Right
L	Left

④Shank Diameter(H x W)

1010	10x10mm
1212	12x12mm
1616	16x16mm
2012	20x12mm
2020	20x20mm
2525	25x25mm
3225	32x25mm
3232	32x32mm

⑤Holder Length LF

J	110mm
JX	120mm
K	125mm
M	150mm
P	170mm

⑥Angle

00	0°
50	50°
90	90°

⑦Seat Size *1

C	1.50mm
D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.35mm
K	8.00mm

⑧Max. Groove Depth CDX

06	6mm
08	8mm
⋮	⋮
25	25mm

● MODULAR HOLDER

①	②	③	④	⑤	⑥		⑨	⑩
GY	H	R	2525	M	00	–	M25	R

⑨Modular Blade Size

M20
M25

⑩Hand of Modular Blade

R	Right
L	Left

*1 Select a seat size with the same symbol as that of the insert.

■ INTERNAL

● MONO BLOCK HOLDER

①	②	③	④	⑤	⑥	⑦		⑧	⑨
GY	A	R	20	K	90	A	–	F	06

①Series Description

②Holder Type

A	Mono Block
D	Modular holder

③Hand of Holder

R	Right
L	Left

④Shank Diameter DCON

20	20mm
25	25mm
32	32mm
40	40mm
50	50mm

⑤Holder Length LF

K	125mm
L	140mm
M	150mm
P	170mm
Q	180mm
R	200mm
S	250mm
T	300mm

⑥Angle

90	90°

⑦Neck Length

A	30mm
B	40mm
C	50mm
D	60mm
F	80mm

⑧Seat Size *1

D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.24mm

⑨Max. Groove Depth CDX

06	6mm
07	7mm

● MODULAR HOLDER

①	②	③	④	⑤	⑥	⑦		⑩	⑪
GY	D	R	40	M	90	D	–	M25	L

⑩Modular Blade Size

M20
M25

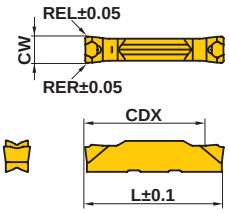
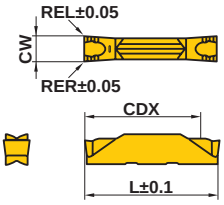
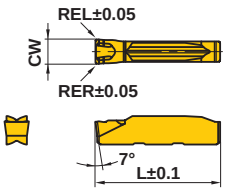
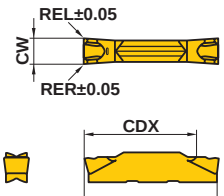
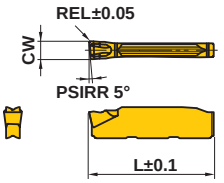
⑪Hand of Modular Blade

R	Right
L	Left

*1 Select a seat size with the same symbol as that of the insert.

GY SERIES INSERTS

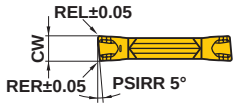
INSERTS

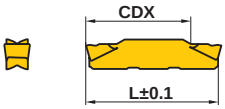
Applications	Geometry	Order Number	Stock: Coated VP10RT	Coated VP20RT	Coated MY5015	Cermet NX2525	Cermet	Carbide RT9010	Carbide RT9020	CBN MB8025	Seat Size	Dimensions (mm) CW Cutting Width	CW Tolerance	RER/L	CDX	*2 L
For Grooving / Cutting Off	**GU Breaker** (For gummy steel) 	GY2M0200D020N-GU	●	●		●					D	2.00	±0.03	0.2	19.7	20.70
		GY2M0239E020N-GU	●	●		●					E	2.39	±0.03	0.2	19.8	20.70
		GY2M0250E020N-GU	●	●		●					E	2.50	±0.03	0.2	19.5	20.70
		GY2M0300F030N-GU	●	●		●					F	3.00	±0.03	0.3	19.3	20.70
		GY2M0318F030N-GU	●	●		●					F	3.18	±0.03	0.3	19.3	20.70
		GY2M0400G030N-GU	●	●		●					G	4.00	±0.04	0.3	24.2	25.65
		GY2M0475H040N-GU	●	●		●					H	4.75	±0.04	0.4	24.2	25.65
		GY2M0500H040N-GU	●	●		●					H	5.00	±0.04	0.4	24.2	25.65
		GY2M0600J040N-GU	●	●		●					J	6.00	±0.04	0.4	24.2	25.65
		GY2M0635J040N-GU	●	●		●					J	6.35	±0.04	0.4	24.2	25.65
	GS Breaker (Low feeds) 	GY2M0150C010N-GS	●	●		●					C	1.50	±0.03	0.1	13.4	14.70
		GY2M0200D020N-GS	●	●		●					D	2.00	±0.03	0.2	18.7	20.70
		GY2M0239E020N-GS	●	●		●					E	2.39	±0.03	0.2	18.5	20.70
		GY2M0250E020N-GS	●	●		●					E	2.50	±0.03	0.2	18.5	20.70
		GY2M0300F020N-GS	●	●		●					F	3.00	±0.03	0.2	18.5	20.70
		GY2M0318F020N-GS	●	●		●					F	3.18	±0.03	0.2	18.5	20.70
		GY2M0400G020N-GS	●	●		●					G	4.00	±0.04	0.2	23.9	25.65
		GY2M0475H030N-GS	●	●		●					H	4.75	±0.04	0.3	23.9	25.65
		GY2M0500H030N-GS	●	●		●					H	5.00	±0.04	0.3	24.0	25.65
		GY2M0600J030N-GS	●	●		●					J	6.00	±0.04	0.3	24.1	25.65
		GY2M0635J030N-GS	●	●		●					J	6.35	±0.04	0.3	24.1	25.65
		GY2M0800K030N-GS	●	●							K	8.00	±0.04	0.3	29.1	30.50
	GM Breaker (Medium feeds) 	GY1M0200D020N-GM	●	●	●						D	2.00	±0.03	0.2	–	20.70
		GY1M0250E020N-GM	●	●	●						E	2.50	±0.03	0.2	–	20.70
		GY1M0300F030N-GM	●	●	●						F	3.00	±0.03	0.3	–	20.70
		GY1M0400G030N-GM	●	●	●						G	4.00	±0.04	0.3	–	25.65
		GY1M0500H040N-GM	●	●	●						H	5.00	±0.04	0.4	–	25.65
	GM Breaker (Medium feeds) 	GY2M0150C020N-GM	●	●		●					C	1.50	±0.03	0.2	13.9	14.70
		GY2M0200D020N-GM	●	●	●	●					D	2.00	±0.03	0.2	19.4	20.70
		GY2M0239E020N-GM	●	●	●	●					E	2.39	±0.03	0.2	19.4	20.70
		GY2M0250E020N-GM	●	●	●	●					E	2.50	±0.03	0.2	19.4	20.70
		GY2M0300F030N-GM	●	●	●	●					F	3.00	±0.03	0.3	19.4	20.70
		GY2M0318F030N-GM	●	●	●	●					F	3.18	±0.03	0.3	19.4	20.70
		GY2M0400G030N-GM	●	●	●	●					G	4.00	±0.04	0.3	24.4	25.65
		GY2M0475H040N-GM	●	●	●	●					H	4.75	±0.04	0.4	24.3	25.65
		GY2M0500H040N-GM	●	●	●	●					H	5.00	±0.04	0.4	24.3	25.65
		GY2M0600J040N-GM	●	●	●	●					J	6.00	±0.04	0.4	24.3	25.65
		GY2M0635J040N-GM	●	●	●	●					J	6.35	±0.04	0.4	24.3	25.65
		GY2M0800K050N-GM	●	●	●						K	8.00	±0.04	0.5	29.3	30.50
For Cutting off	**R/L05-GM Breaker**  Right hand insert shown.	GY1M0200D020R05-GM	●	●							D	2.00	±0.03	0.2	–	20.80
		GY1M0200D020L05-GM	●	●							D	2.00	±0.03	0.2	–	20.80
		GY1M0300F030R05-GM	●	●							F	3.00	±0.03	0.3	–	20.85
		GY1M0300F030L05-GM	●	●							F	3.00	±0.03	0.3	–	20.85

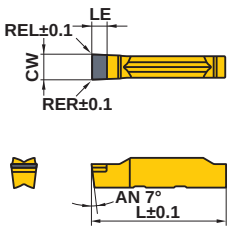
*2 The dimension depends on the breaker. Refer to the F013 “L dimension tolerance conversion table”.

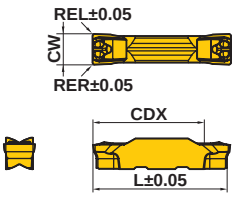
● : Inventory maintained in Japan.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

Applications	Geometry	Order Number	Stock: Coated VP10RT	Coated VP20RT	Coated MY5015	Cermet NX2525	Cermet	Carbide RT9010	Carbide RT9020	CBN BC8110	CBN MB8025	Seat Size	Dimensions (mm) CW Cutting Width	CW Tolerance	RER/L	CDX	⁎2 L	LE
For Cutting Off	**R/L05-GM Breaker**	GY2M0200D020R05-GM	●	●								D	2.00	±0.03	0.2	19.5	20.80	—
		GY2M0200D020L05-GM	●	●								D	2.00	±0.03	0.2	19.5	20.80	—
		GY2M0250E020R05-GM	●	●								E	2.50	±0.03	0.2	19.5	20.825	—
		GY2M0250E020L05-GM	●	●								E	2.50	±0.03	0.2	19.5	20.825	—
		GY2M0300F030R05-GM	●	●								F	3.00	±0.03	0.3	19.5	20.85	—
		GY2M0300F030L05-GM	●	●								F	3.00	±0.03	0.3	19.5	20.85	—
		GY2M0400G030R05-GM	●	●								G	4.00	±0.04	0.3	24.5	25.85	—
		GY2M0400G030L05-GM	●	●								G	4.00	±0.04	0.3	24.5	25.85	—
		GY2M0500H040R05-GM	●	●								H	5.00	±0.04	0.4	24.5	25.95	—
	Right hand insert shown.	GY2M0500H040L05-GM	●	●								H	5.00	±0.04	0.4	24.5	25.95	—
For Grooving	**Flat Top** (For hardened steel)	GY1G0200D020N-GFGS								●	●	D	2.00	±0.03	0.2	—	20.70	2.7
		GY1G0239E020N-GFGS								●	●	E	2.39	±0.03	0.2	—	20.70	2.7
		GY1G0250E020N-GFGS								●	●	E	2.50	±0.03	0.2	—	20.70	2.7
		GY1G0300F020N-GFGS								●	●	F	3.00	±0.03	0.2	—	20.70	2.7
		GY1G0318F020N-GFGS								●	●	F	3.18	±0.03	0.2	—	20.70	2.7
		GY1G0400G020N-GFGS								●	●	G	4.00	±0.03	0.2	—	25.65	2.7
		GY1G0475H020N-GFGS								●	●	H	4.75	±0.03	0.2	—	25.65	2.7
		GY1G0500H020N-GFGS								●	●	H	5.00	±0.03	0.2	—	25.65	2.7
		GY1G0600J020N-GFGS								●		J	6.00	±0.03	0.2	—	25.65	2.7
For Multifunctional Grooving	**MF Breaker** (Finishing)	GY2G0200D020N-MF	●	●		●		●				D	2.00	±0.02	0.2	19.5	21.05	—
		⁎1GY2G0224D015N-MF	●	●		●		●				D	2.24	±0.02	0.15	19.8	21.05	—
		GY2G0239E020N-MF	●	●		●		●				E	2.39	±0.02	0.2	19.2	21.05	—
		GY2G0250E020N-MF	●	●		●		●				E	2.50	±0.02	0.2	19.4	21.05	—
		⁎1GY2G0274E020N-MF	●	●		●		●				E	2.74	±0.02	0.2	19.7	21.05	—
		GY2G0300F020N-MF	●	●		●		●				F	3.00	±0.02	0.2	19.5	21.05	—
		GY2G0300F040N-MF	●	●		●		●				F	3.00	±0.02	0.4	19.3	21.05	—
		GY2G0318F020N-MF	●	●		●		●				F	3.18	±0.02	0.2	19.5	21.05	—
		GY2G0318F040N-MF	●	●		●		●				F	3.18	±0.02	0.4	19.3	21.05	—
		⁎1GY2G0324F020N-MF	●	●		●		●				F	3.24	±0.02	0.2	19.5	21.05	—
		GY2G0400G020N-MF	●	●		●		●				G	4.00	±0.02	0.2	24.9	25.95	—
		GY2G0400G040N-MF	●	●		●		●				G	4.00	±0.02	0.4	24.7	25.95	—
		GY2G0400G080N-MF	●	●		●		●				G	4.00	±0.02	0.8	24.3	25.95	—
		⁎1GY2G0424G020N-MF	●	●		●		●				G	4.24	±0.02	0.2	24.9	25.95	—
		GY2G0475H020N-MF	●	●		●		●				H	4.75	±0.02	0.2	24.4	25.95	—
		GY2G0475H040N-MF	●	●		●		●				H	4.75	±0.02	0.4	24.2	25.95	—
		GY2G0475H080N-MF	●	●		●		●				H	4.75	±0.02	0.8	23.8	25.95	—
		GY2G0500H020N-MF	●	●		●		●				H	5.00	±0.02	0.2	24.4	25.95	—
		GY2G0500H040N-MF	●	●		●		●				H	5.00	±0.02	0.4	24.2	25.95	—
		GY2G0500H080N-MF	●	●		●		●				H	5.00	±0.02	0.8	23.8	25.95	—
		⁎1GY2G0524H020N-MF	●	●		●		●				H	5.24	±0.02	0.2	24.4	25.95	—
		GY2G0600J020N-MF	●	●		●		●				J	6.00	±0.02	0.2	24.4	25.95	—
		GY2G0600J040N-MF	●	●		●		●				J	6.00	±0.02	0.4	24.2	25.95	—
		GY2G0600J080N-MF	●	●		●		●				J	6.00	±0.02	0.8	23.8	25.95	—
		⁎1GY2G0631J020N-MF	●	●		●		●				J	6.31	±0.02	0.2	24.4	25.95	—
		GY2G0635J020N-MF	●	●		●		●				J	6.35	±0.02	0.2	24.4	25.95	—
		GY2G0635J040N-MF	●	●		●		●				J	6.35	±0.02	0.4	24.2	25.95	—
		GY2G0635J080N-MF	●	●		●		●				J	6.35	±0.02	0.8	23.8	25.95	—





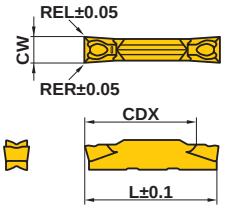
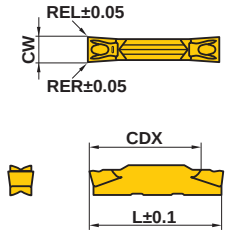
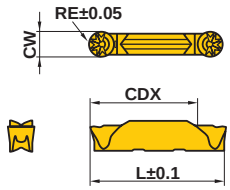
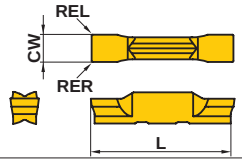
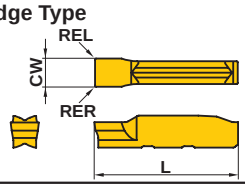




⁎1 Circlip corresponding width of cut

GY SERIES INSERTS

INSERTS

Applications	Geometry	Order Number	Stock: Coated VP10RT	Coated VP20RT	Coated MY5015	Cermet NX2525		Carbide RT9010	Carbide RT9020	CBN MB8025	Seat Size	Dimensions (mm): CW Cutting Width	CW Tolerance	RE RER/L	CDX	*2 L
For Multifunctional Grooving	**MS Breaker** (Low feeds) 	GY2M0200D020N-MS	●	●	●	●					D	2.00	±0.03	0.2	19.1	20.70
		GY2M0250E020N-MS	●	●	●	●					E	2.50	±0.03	0.2	19.1	20.70
		GY2M0300F020N-MS	●	●	●	●					F	3.00	±0.03	0.2	19.2	20.70
		GY2M0300F040N-MS	●	●	●	●					F	3.00	±0.03	0.4	18.9	20.70
		GY2M0400G020N-MS	●	●	●	●					G	4.00	±0.04	0.2	24.2	25.65
		GY2M0400G040N-MS	●	●	●	●					G	4.00	±0.04	0.4	23.9	25.65
		GY2M0500H040N-MS	●	●	●	●					H	5.00	±0.04	0.4	23.9	25.65
		GY2M0500H080N-MS	●	●	●	●					H	5.00	±0.04	0.8	23.5	25.65
		GY2M0600J040N-MS	●	●	●	●					J	6.00	±0.04	0.4	23.9	25.65
		GY2M0600J080N-MS	●	●	●	●					J	6.00	±0.04	0.8	23.5	25.65
		GY2M0800K080N-MS	●	●	●						K	8.00	±0.04	0.8	28.5	30.50
	MM Breaker (Medium feeds) 	GY2M0200D020N-MM	●	●	●	●					D	2.00	±0.03	0.2	19.1	20.70
		GY2M0250E020N-MM	●	●	●	●					E	2.50	±0.03	0.2	19.1	20.70
		GY2M0300F020N-MM	●	●	●	●					F	3.00	±0.03	0.2	19.1	20.70
		GY2M0300F040N-MM	●	●	●	●					F	3.00	±0.03	0.4	18.9	20.70
		GY2M0300F080N-MM	●	●	●	●					F	3.00	±0.03	0.8	18.5	20.70
		GY2M0400G020N-MM	●	●	●	●					G	4.00	±0.04	0.2	24.1	25.65
		GY2M0400G040N-MM	●	●	●	●					G	4.00	±0.04	0.4	23.9	25.65
		GY2M0400G080N-MM	●	●	●	●					G	4.00	±0.04	0.8	23.5	25.65
		GY2M0500H040N-MM	●	●	●	●					H	5.00	±0.04	0.4	23.9	25.65
		GY2M0500H080N-MM	●	●	●	●					H	5.00	±0.04	0.8	23.5	25.65
		GY2M0600J040N-MM	●	●	●	●					J	6.00	±0.04	0.4	23.9	25.65
		GY2M0600J080N-MM	●	●	●	●					J	6.00	±0.04	0.8	23.5	25.65
		GY2M0800K080N-MM	●	●	●						K	8.00	±0.04	0.8	28.5	30.50
		GY2M0800K120N-MM	●	●	●						K	8.00	±0.04	1.2	28.1	30.50
For Copying / For Recessing	**BM Breaker** 	GY2M0200D100N-BM	●	●	●	●					D	2.00	±0.03	1.00	19.5	20.90
		GY2M0250E125N-BM	●	●	●	●					E	2.50	±0.03	1.25	19.3	20.90
		GY2M0300F150N-BM	●	●	●	●					F	3.00	±0.03	1.50	19.0	20.90
		GY2M0318F159N-BM	●	●	●	●					F	3.18	±0.03	1.59	18.9	20.90
		GY2M0400G200N-BM	●	●	●	●					G	4.00	±0.04	2.00	23.4	25.80
		GY2M0475H238N-BM	●	●	●	●					H	4.75	±0.04	2.38	22.9	25.80
		GY2M0500H250N-BM	●	●	●	●					H	5.00	±0.04	2.50	22.8	25.80
		GY2M0600J300N-BM	●	●	●	●					J	6.00	±0.04	3.00	22.5	25.90
		GY2M0635J318N-BM	●	●	●	●					J	6.35	±0.04	3.18	22.3	25.90
		GY2M0800K400N-BM	●	●	●						K	8.00	±0.04	4.00	26.5	30.80
*1 Blank	**2 Edge Type** 	GY2B0220D020N				●		●	●		D	2.20	±0.10	0.2	—	21.05
		GY2B0270E020N				●		●	●		E	2.70	±0.10	0.2	—	21.05
		GY2B0340F020N				●		●	●		F	3.40	±0.10	0.2	—	21.05
		GY2B0420G020N				●		●	●		G	4.20	±0.10	0.2	—	26.00
		GY2B0520H020N				●		●	●		H	5.20	±0.10	0.2	—	26.00
		GY2B0655J020N				●		●	●		J	6.55	±0.10	0.2	—	26.03
	1 Edge Type 	GY1B0220D020N				●		●	●		D	2.20	±0.10	0.2	—	21.07
		GY1B0270E020N				●		●	●		E	2.70	±0.10	0.2	—	21.10
		GY1B0340F020N				●		●	●		F	3.40	±0.10	0.2	—	21.00
		GY1B0420G020N				●		●	●		G	4.20	±0.10	0.2	—	25.86
		GY1B0520H020N				●		●	●		H	5.20	±0.10	0.2	—	25.90
		GY1B0655J020N				●		●	●		J	6.55	±0.10	0.2	—	25.90

*1 **Insert blank is not suitable for machining without grinding.**
*2 The dimension depends on the breaker. Refer to the F013 “L dimension tolerance conversion table”.

● : Inventory maintained in Japan.
(10 inserts in one case)

C-TYPE CIRCLIP STANDARDS LIST

Category	Application		Standard	Width (Tolerance) For shaft						Width (Tolerance) For hole			
C-type stop ring	For shaft	For hole	ANSI B27.7/27.8 (US) BS 3673 (UK) DIN 471/472 (De) NF E 22 163 (Fr) UNI 7435/7438 (It) JIS B 2804 (JP)	0.5 0.7 0.8 0.9 1.1 1.3 1.6 1.85 2.15 2.65	+0.14 0	0.305 0.457	+0.051 0	1.15 1.35 1.75 1.95 2.2 2.7	+0.14 0	9 1.1 1.3 1.6 1.85 2.15 2.65	+0.14 0	0.457	+0.051 0
						0.737 0.991 1.168	+0.076 0					0.737 0.991 1.168	+0.076 0
						1.422 1.727	+0.102 0					1.422 1.727	+0.102 0
C-type concentric stop ring	For shaft	For hole				2.184 2.616 3.048	+0.127 0	3.2 4.2	+0.18 0	3.15 4.15 5.15	+0.18 0	2.184 2.616 3.048	+0.127 0
				3.15 4.15 5.15	+0.18 0	3.531	+0.152 0			6.2	+0.22 0		
				6.2	+0.22 0								
E-type stop ring	For shaft		N1*** American	0.32 0.5	+0.05 0	0.305 0.457 0.584	+0.051 0	0.3 0.4 0.5	+0.05 0				
				0.7 1.0	+0.10 0	0.737 0.991 1.168	+0.076 0	0.7 0.9	+0.10 0				
				1.2 1.4	+0.14 0	1.422 1.727	+0.102 0	1.15 1.75 2.2	+0.14 0				

O-RING STANDARDS

Category	Standard	Width (Tolerance) General				Width (Tolerance) For oil pressure				Width (Tolerance) For air pressure			
For stable	DIN 3770/3771 (De) JIS B 2401 (JP) ISO 3601	2.54 3.18 4.32 6.1 8.0	+0.13 0	2.5 3.2 4.7 7.5 11.1	+0.14 0	1.9 2.3	+0.1 0	2.3 3.1 3.7 6.4 9.0	+0.2 0				
						2.9	+0.15 0						
		3.2 4.0 7.5 11.0	+0.2 0			3.6 4.5	+0.2 0						
For dynamic	SMS 1586/1588 (Se) BS 1806/4518 (UK) SAE AS-568 (US)					5.5 7.0	+0.3 0	2.4 3.6 4.8 7.1 9.5	+0.25 0	2.3 3.1 3.7 6.4 9.0	+0.2 0	2.2 3.4 4.6 6.9 9.3	+0.25 0
		2.39 3.58 4.78 7.14 9.58	+0.25 0			8.6	+0.4 0						
						10.7	+0.5 0						

G-class insert with MF breaker is available for single-step machining.
Conventional GY series insert is available for single-step machining.
Machined in multiple steps or by cross feed machining.

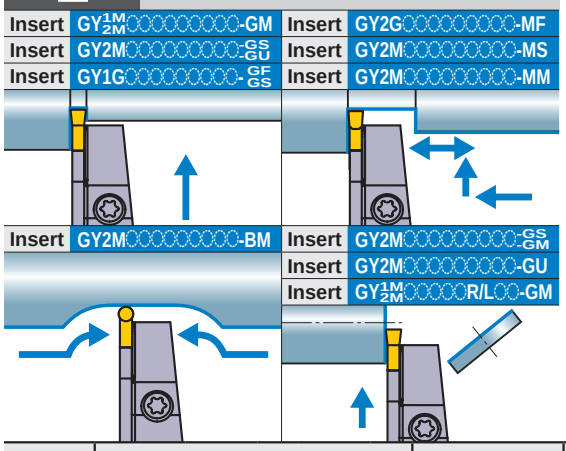
L DIMENSION TOLERANCE CONVERSION TABLE

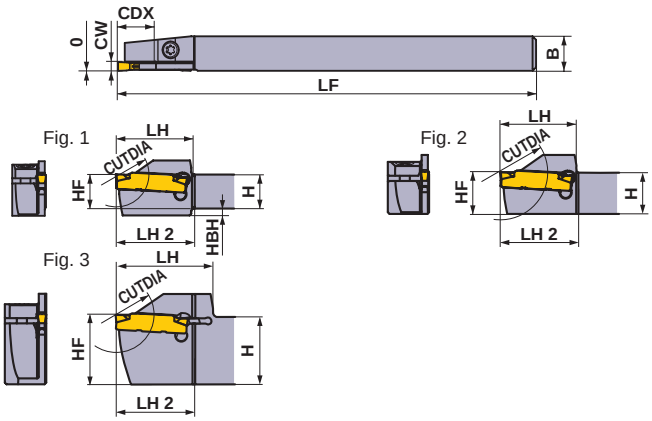
Cutting Width CW (mm)	*1 Dimensions L (mm)	*2 Dimensional tolerance (mm) versus standard dimension (L) of each breaker						
		GU	GS/GM	MS/MM	R/L-GM	Flat Top	MF	BM
1.50	14.70		0					
2.00	20.70	0	0	0	0.10	0	0.35	0.20
2.24	*3 (20.7)						0.35	
2.39	20.70	0	0			0	0.35	
2.50	20.70	0	0	0	0.125	0	0.35	0.20
2.74	*3 (20.7)						0.35	
3.00	20.70	0	0	0	0.15	0	0.35	0.20
3.18	20.70	0	0			0	0.35	0.20
3.24	*3 (20.7)						0.35	
4.00	25.65	0	0	0	0.20	0	0.30	0.15
4.24	*3 (25.65)						0.30	
4.75	25.65	0	0			0	0.30	0.15
5.00	25.65	0	0	0	0.30	0	0.30	0.15
5.24	*3 (25.65)						0.30	
6.00	25.65	0	0	0		0	0.30	0.25
6.31	*3 (25.65)						0.30	
6.35	25.65	0	0				0.30	0.25
8.00	30.50		0	0				0.30

*1 This value is used at the described holder dimension.
*2 ■ when there is no applicable breaker.
*3 The standard dimensions shown here use an approximate insert width.

GY SERIES (External for Swiss style lathes)

1 00° type holder





Right hand tool holder shown.

Seat Size	Dimensions (mm)			Type	Hand (R/L)	Order Number		Fig.
	CW	CDX*4	CUTDIA			Holder	Stock	
C	1.50	11	22	Mono Block	R	GYSR1010JX00-C11	●	1
					L	GYSL1010JX00-C11	●	1
		13	26	Mono Block	R	GYSR1212JX00-C13	●	2
					L	GYSL1212JX00-C13	●	2
		17*1	34*2	Mono Block	R	GYSR1616JX00-C17	●	2
					L	GYSL1616JX00-C17	●	2
		18*1	36*2	Mono Block	R	GYSR2012JX00-C18	●	3
					L	GYSL2012JX00-C18	●	3
D	2.00 2.24	11	22	Mono Block	R	GYSR1010JX00-D11	●	1
					L	GYSL1010JX00-D11	●	1
		13	26	Mono Block	R	GYSR1212JX00-D13	●	2
					L	GYSL1212JX00-D13	●	2
		17	34	Mono Block	R	GYSR1616JX00-D17	●	2
					L	GYSL1616JX00-D17	●	2
		18	36	Mono Block	R	GYSR2012JX00-D18	●	3
					L	GYSL2012JX00-D18	●	3
E	2.39 2.50 2.74	11	22	Mono Block	R	GYSR1010JX00-E11	●	1
					L	GYSL1010JX00-E11	●	1
		13	26	Mono Block	R	GYSR1212JX00-E13	●	2
					L	GYSL1212JX00-E13	●	2
		17	34	Mono Block	R	GYSR1616JX00-E17	●	2
					L	GYSL1616JX00-E17	●	2
		18	36	Mono Block	R	GYSR2012JX00-E18	●	3
					L	GYSL2012JX00-E18	●	3
F	3.00 3.18 3.24	11	22	Mono Block	R	GYSR1010JX00-F11	●	1
					L	GYSL1010JX00-F11	●	1
		13	26	Mono Block	R	GYSR1212JX00-F13	●	2
					L	GYSL1212JX00-F13	●	2
		17	34	Mono Block	R	GYSR1616JX00-F17	●	2
					L	GYSL1616JX00-F17	●	2
		18	36	Mono Block	R	GYSR2012JX00-F18	●	3
					L	GYSL2012JX00-F18	●	3

CW = Cutting Width **CDX** = Max. Groove Depth **CUTDIA** = Max. Cut Off Diameter

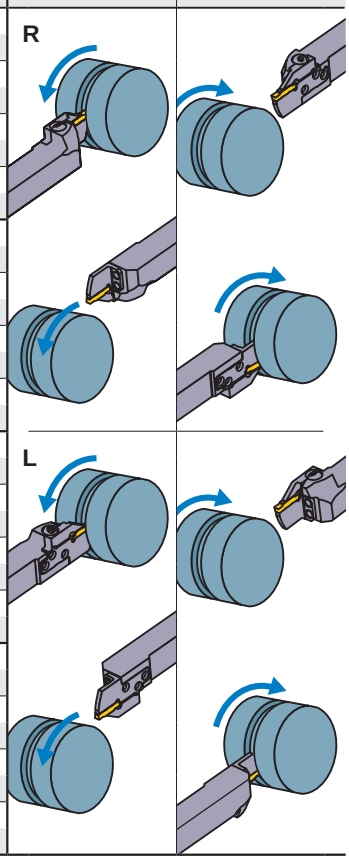
*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

● : **Inventory maintained in Japan.**

SPARE PARTS

Holder	Clamp Screw	Wrench
GYSR/L1010JX00-◌11	CS350990T (Clamp Torque : 2.5N·m)	TKY10R
GYSR/L1212JX00-◌13		
GYSR/L2012JX00-◌18		
GYSR/L1616JX00-◌17	TS4SBL (Clamp Torque : 3.5N·m)	TKY15R

Dimensions (mm) ⋆3							Cutting Mode	
H	B	LF	LH	LH 2	HF	HBH	Clockwise	Anticlockwise
10	10	120	22	16	10	2	R	
10	10	120	22	16	10	2		
12	12	120	22	16	12	—		
12	12	120	22	16	12	—		
16	16	120	27	17	16	—		
16	16	120	27	17	16	—		
20	12	120	28	16	20	—		
20	12	120	28	16	20	—		
10	10	120	22	23	10	2		
10	10	120	22	23	10	2		
12	12	120	22	23	12	—		
12	12	120	22	23	12	—		
16	16	120	27	24	16	—		
16	16	120	27	24	16	—		
20	12	120	28	23	20	—		
20	12	120	28	23	20	—		
10	10	120	22	23	10	2	L	
10	10	120	22	23	10	2		
12	12	120	22	23	12	—		
12	12	120	22	23	12	—		
16	16	120	27	24	16	—		
16	16	120	27	24	16	—		
20	12	120	28	23	20	—		
20	12	120	28	23	20	—		
10	10	120	22	23	10	2		
10	10	120	22	23	10	2		
12	12	120	22	23	12	—		
12	12	120	22	23	12	—		
16	16	120	27	24	16	—		
16	16	120	27	24	16	—		
20	12	120	28	23	20	—		
20	12	120	28	23	20	—		



Insert selection

Seat Size	Geometry name
C	GY◌◌0150C◌◌◌◌◌–Breaker shown below
D	GY◌◌0200/0224D◌◌◌◌◌–Breaker shown below
E	GY◌◌0239/0250/0274E◌◌◌◌◌–Breaker shown below
F	GY◌◌0300/0318/0324F◌◌◌◌◌–Breaker shown below

For grooving/cutting off breaker➢ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
C	1.50mm		●	●		
D	2.00mm	●	●	●	●	●
E	2.39mm	●	●	●		●
	2.50mm	●	●	●	●	●
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●		●

For multifunctional grooving breaker➢ F011, F012

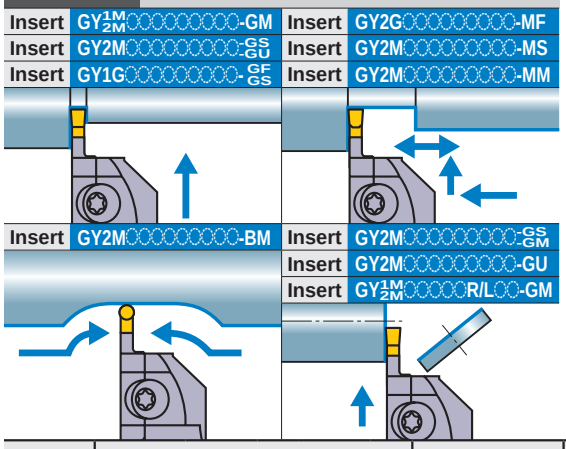
Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

● : Standard insert with dimensions

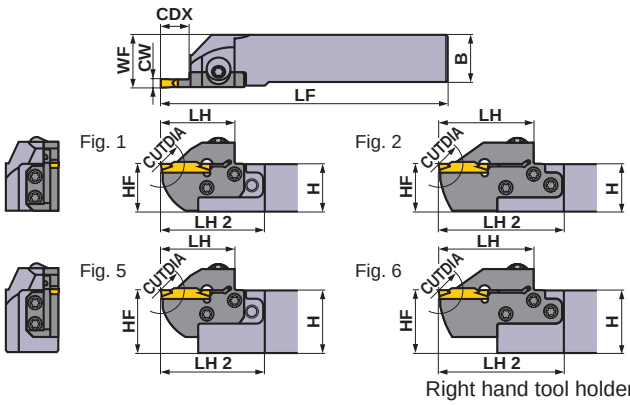
IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

GY SERIES (EXTERNAL)

1 00° type holder



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



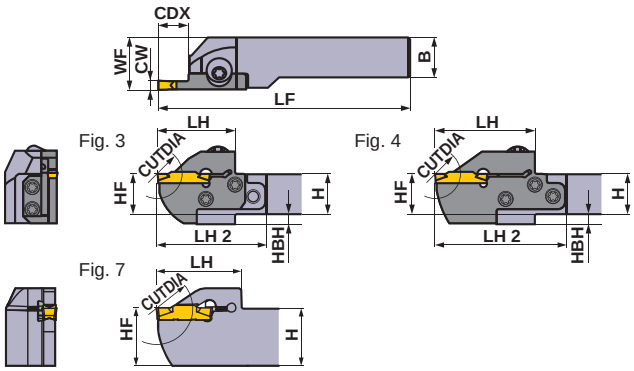
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
D	2.00 2.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D06	●	3
				Mono Block	R	GYQR2020K00-D06	●	—	—	7
					L	GYQL2020K00-D06	●	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-D06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D06	●	3
				Mono Block	R	GYQR2525M00-D06	●	—	—	7
					L	GYQL2525M00-D06	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D06	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D06	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-D06	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D06	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-D06	●	5
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D12	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D12	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-D12	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D12	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-D12	●	5
		18 ⋆4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-D18	●	4
					L	GYHL1616J00-M20L	●	GYM20LB-D18	●	4
				Mono Block	R	GYQR2020K00-D18	●	—	—	7
					L	GYQL2020K00-D18	●	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-D18	●	2
					L	GYHL2020K00-M20L	●	GYM20LB-D18	●	2
		20 ⋆1	40 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D20	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-D20	●	4
				Mono Block	R	GYQR2525M00-D20	●	—	—	7
					L	GYQL2525M00-D20	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D20	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-D20	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-D20	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-D20	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-D20	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-D20	●	6

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

⋆1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.
⋆4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

● : Inventory maintained in Japan.



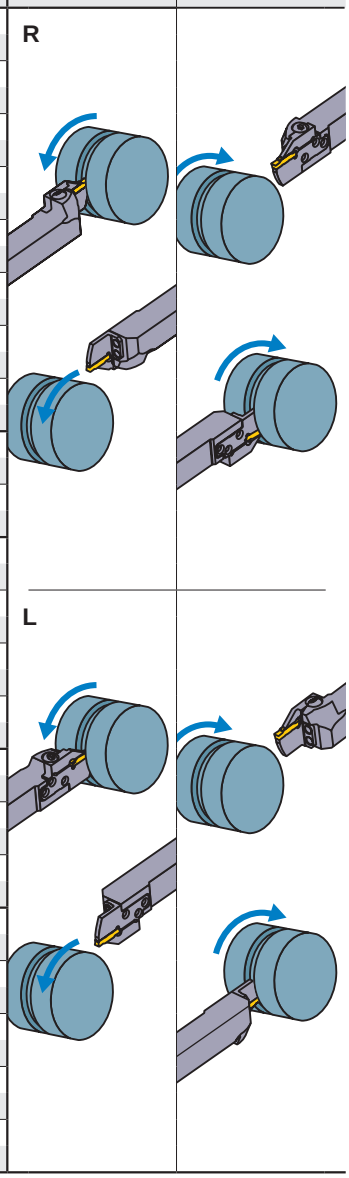
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ★
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	R	
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.15	—		
20	20	125	36	—	20	20.15	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.15	—		
25	25	150	36	—	25	25.15	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.1	—		
20	20	125	39	—	20	20.1	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.1	—		
25	25	150	41	—	25	25.1	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		



Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○-Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
D	2.00mm	●	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			

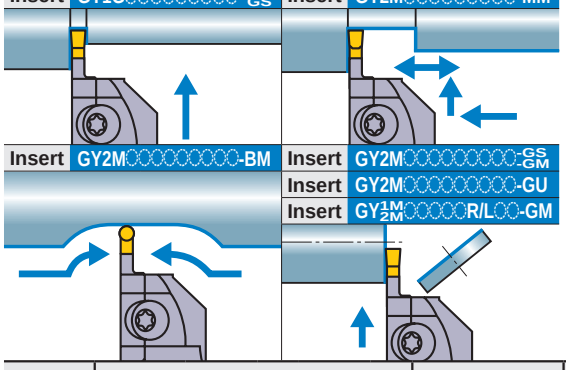
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F088
CAUTION FOR USE ➤ F092

GY SERIES (EXTERNAL)

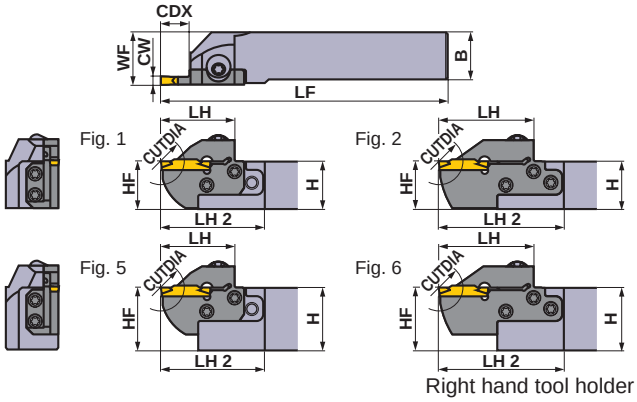
1 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert	GY2M○○○○○○○○○○-BM	Insert	GY2M○○○○○○○○○○-GS/GM
		Insert	GY2M○○○○○○○○○○-GU
		Insert	GY1M/2M○○○○○R/L○○-GM

Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



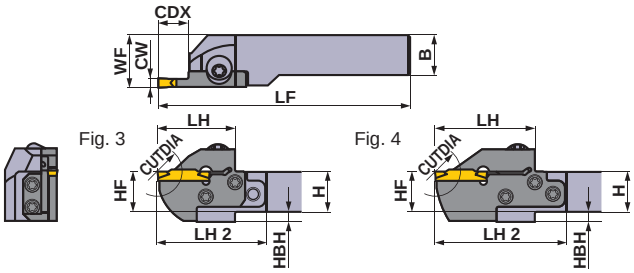
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
E	2.39 2.50 2.74	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-E06	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-E06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-E06	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-E06	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E06	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-E06	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E06	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-E06	●	5
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-E10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-E10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-E12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-E12	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E12	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-E12	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E12	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-E12	●	5
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-E18	●	4
					L	GYHL1616J00-M20L	●	GYM20LB-E18	●	4
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-E18	●	2
					L	GYHL2020K00-M20L	●	GYM20LB-E18	●	2
		20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E20	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-E20	●	4
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E20	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-E20	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E20	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-E20	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E20	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-E20	●	6

CW = Cutting Width **CDX** = Max. Groove Depth **CUTDIA** = Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

● : Inventory maintained in Japan.



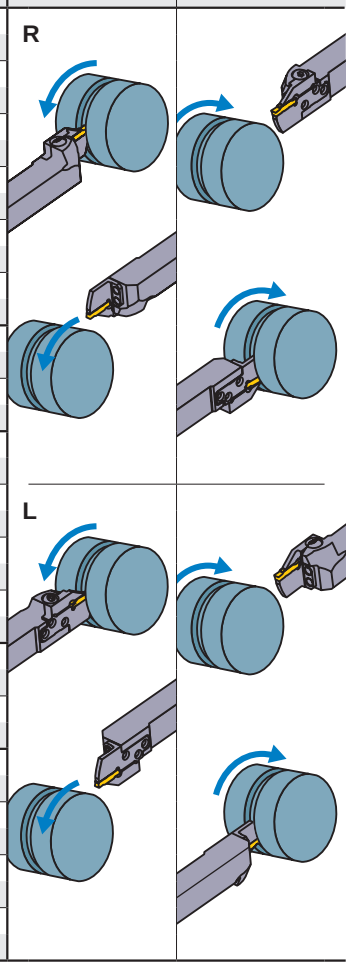
Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) ⁎3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	R	
16	16	104	28	44	16	20	4		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		



Insert selection

Seat Size	Geometry name
E	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
E	2.39mm	●	●	●		●
	2.50mm	●	●	●	●	●

For multifunctional grooving breaker ➢ F011, F012

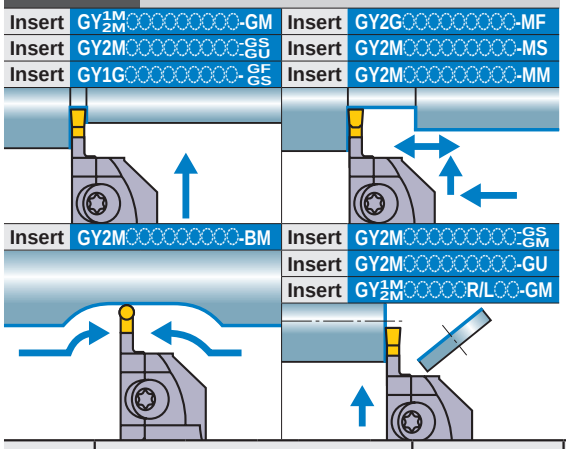
Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Standard insert with dimensions

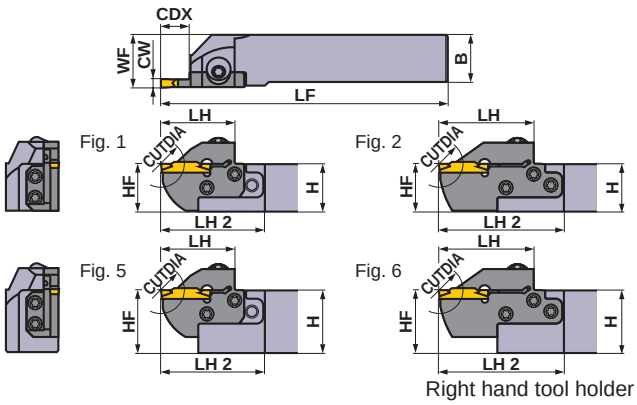
IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

GY SERIES (EXTERNAL)

1 00° type holder



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



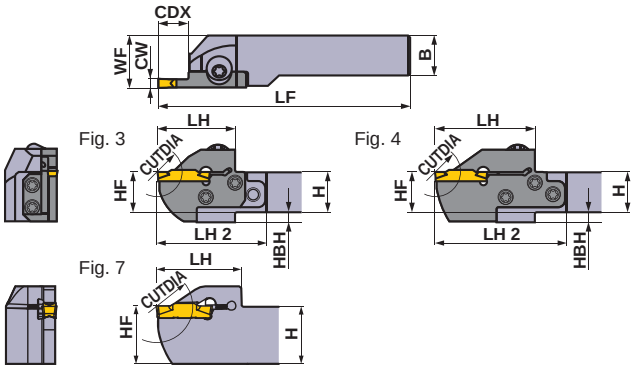
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-F06	●	3
				Mono Block	R	GYQR2020K00-F06	●	—	—	7
					L	GYQL2020K00-F06	●	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-F06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-F06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-F06	●	3
				Mono Block	R	GYQR2525M00-F06	●	—	—	7
					L	GYQL2525M00-F06	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-F06	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F06	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-F06	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F06	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-F06	●	5
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-F10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-F10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-F12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-F12	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F12	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-F12	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F12	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-F12	●	5
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-F18	●	4
					L	GYHL1616J00-M20L	●	GYM20LB-F18	●	4
				Mono Block	R	GYQR2020K00-F18	●	—	—	7
					L	GYQL2020K00-F18	●	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-F18	●	2
					L	GYHL2020K00-M20L	●	GYM20LB-F18	●	2
		20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F20	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-F20	●	4
				Mono Block	R	GYQR2525M00-F20	●	—	—	7
					L	GYQL2525M00-F20	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F20	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-F20	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F20	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-F20	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F20	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-F20	●	6

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

● : Inventory maintained in Japan.



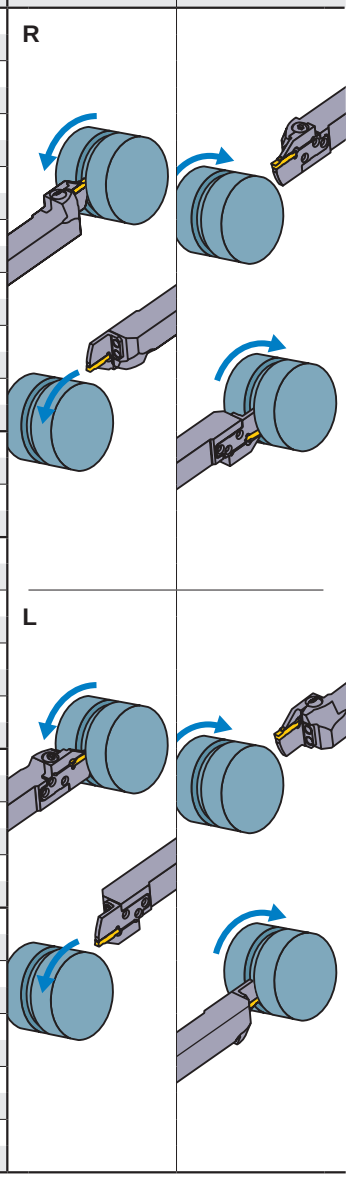
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ★
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	R	
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.3	—		
20	20	125	36	—	20	20.3	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.3	—		
25	25	150	36	—	25	25.3	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.25	—		
20	20	125	39	—	20	20.25	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.25	—		
25	25	150	41	—	25	25.25	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		



Insert selection

Seat Size	Geometry name
F	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●		●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

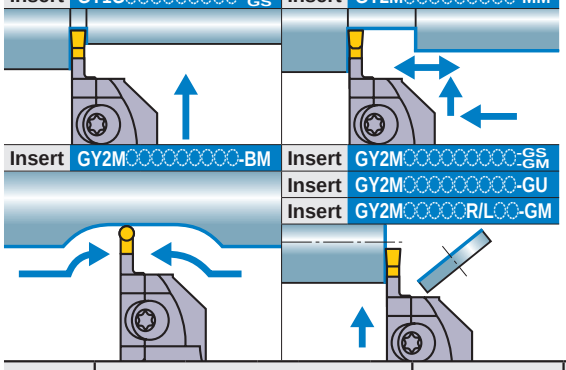
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F088
CAUTION FOR USE ➤ F092

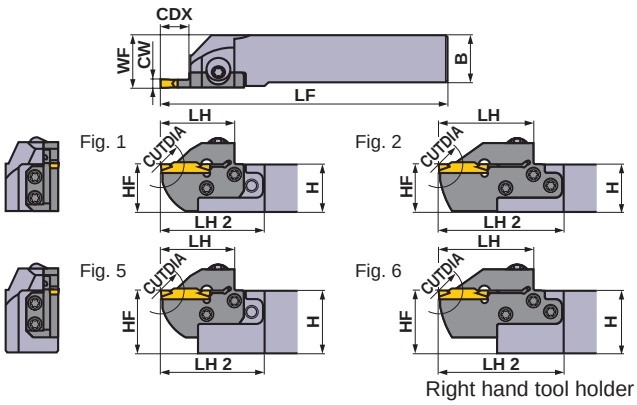
GY SERIES (EXTERNAL)

1 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM
Insert	GY2M○○○○○○○○○○-BM	Insert	GY2M○○○○○○○○○○-GS/GM
		Insert	GY2M○○○○○○○○○○-GU
		Insert	GY2M○○○○○R/L○○-GM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



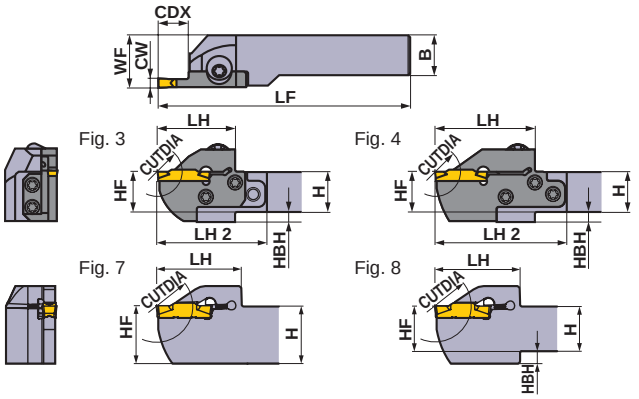
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
G	4.00 4.24	8	16	Mono Block	R	GYQR2020K00-G08	●	—	—	7
					L	GYQL2020K00-G08	●	—	—	7
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G08	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-G08	●	3
				Mono Block	R	GYQR2525M00-G08	●	—	—	7
					L	GYQL2525M00-G08	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G08	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-G08	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G08	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-G08	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G08	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-G08	●	5
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-G12	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-G12	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-G12	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-G12	●	1
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-G14	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-G14	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G14	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-G14	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G14	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-G14	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G14	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-G14	●	5
		25 *1	50 *2	Mono Block	R	GYQR2020K00-G25	●	—	—	8
					L	GYQL2020K00-G25	●	—	—	8
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G25	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-G25	●	4
				Mono Block	R	GYQR2525M00-G25	●	—	—	7
					L	GYQL2525M00-G25	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G25	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-G25	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G25	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-G25	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G25	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-G25	●	6

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : Inventory maintained in Japan.



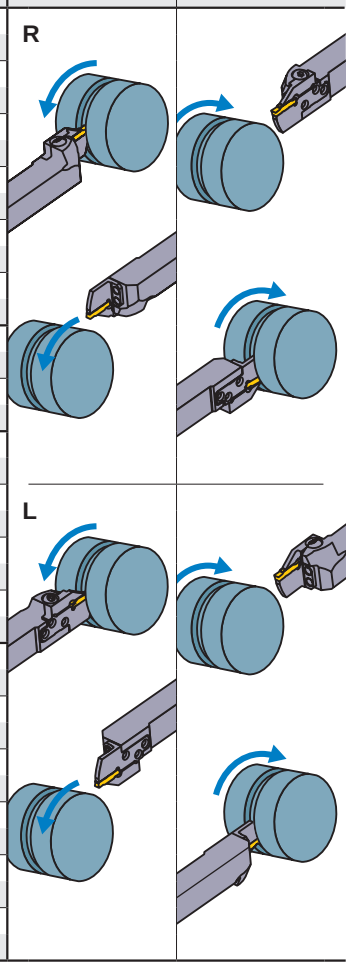
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ★
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		



Insert selection

Seat Size	Geometry name
G	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
G	4.00mm	●	●	●	●	●

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

● : Standard insert with dimensions

F

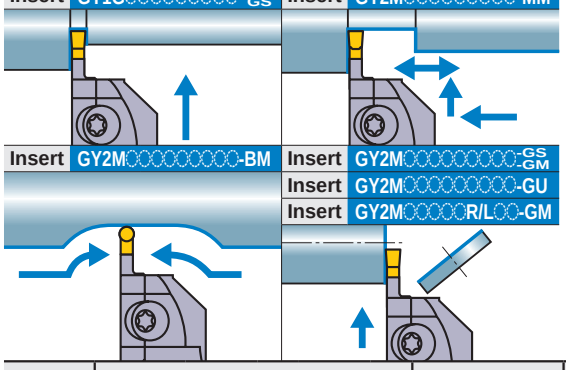
GROOVING / CUTTING OFF

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

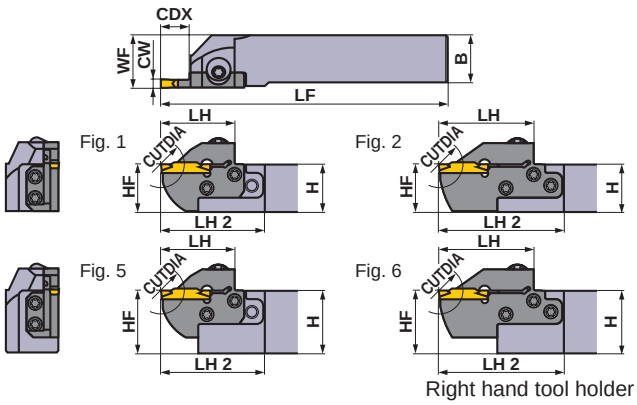
GY SERIES (EXTERNAL)

1 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM
Insert	GY2M○○○○○○○○○○-BM	Insert	GY2M○○○○○○○○○○-GS/GM
		Insert	GY2M○○○○○○○○○○-GU
		Insert	GY2M○○○○○○R/L○○-GM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



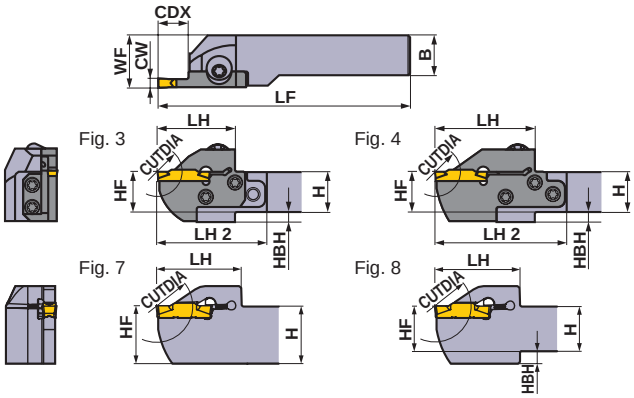
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	8	16	Mono Block	R	GYQR2020K00-H08	●	—	—	7
					L	GYQL2020K00-H08	●	—	—	7
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H08	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-H08	●	3
				Mono Block	R	GYQR2525M00-H08	●	—	—	7
					L	GYQL2525M00-H08	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H08	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-H08	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-H08	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-H08	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-H08	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-H08	●	5
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-H12	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-H12	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-H12	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-H12	●	1
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-H14	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-H14	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H14	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-H14	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-H14	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-H14	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-H14	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-H14	●	5
		25 *1	50 *2	Mono Block	R	GYQR2020K00-H25	●	—	—	8
					L	GYQL2020K00-H25	●	—	—	8
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H25	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-H25	●	4
				Mono Block	R	GYQR2525M00-H25	●	—	—	7
					L	GYQL2525M00-H25	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H25	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-H25	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-H25	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-H25	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-H25	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-H25	●	6

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : Inventory maintained in Japan.



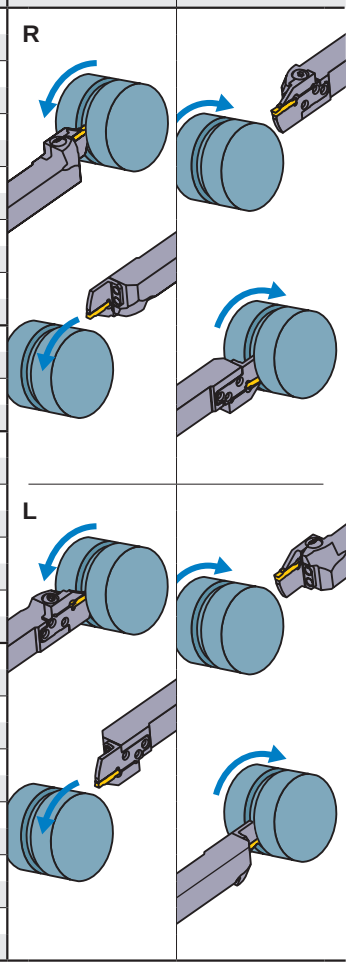
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ★
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		



Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel) Neutral	GS (Low) Neutral	GM (Medium) Neutral	05-GM (Cutting off) With hand	GFGS (Hardened steel) Neutral
H	4.75mm	●	●	●		●
	5.00mm	●	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

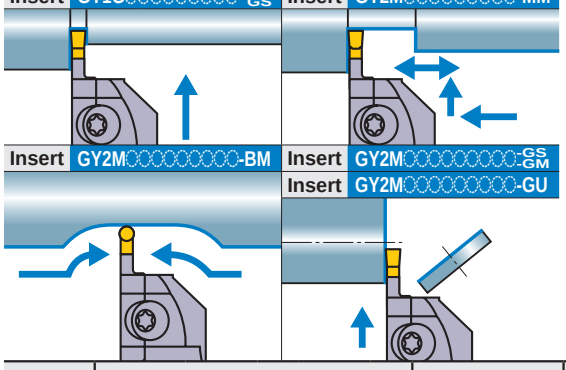
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F088
CAUTION FOR USE ➤ F092

GY SERIES (EXTERNAL)

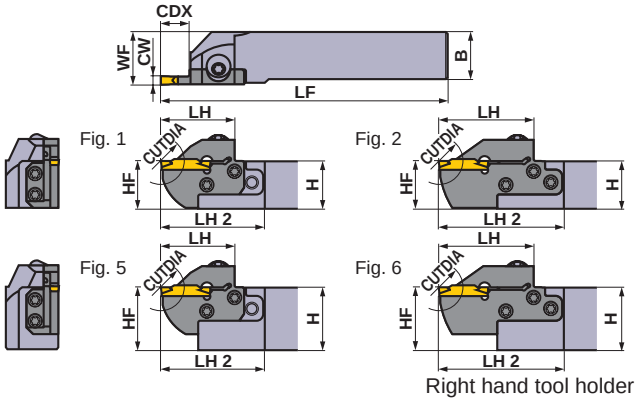
1 00° type holder

Insert GY2M○○○○○○○○○○-GM
Insert GY2M○○○○○○○○○○-GS GU
Insert GY1G○○○○○○○○○○- GF GS
Insert GY2G○○○○○○○○○○-MF
Insert GY2M○○○○○○○○○○-MS
Insert GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM
Insert GY2M○○○○○○○○○○-GS GM
Insert GY2M○○○○○○○○○○-GU

Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



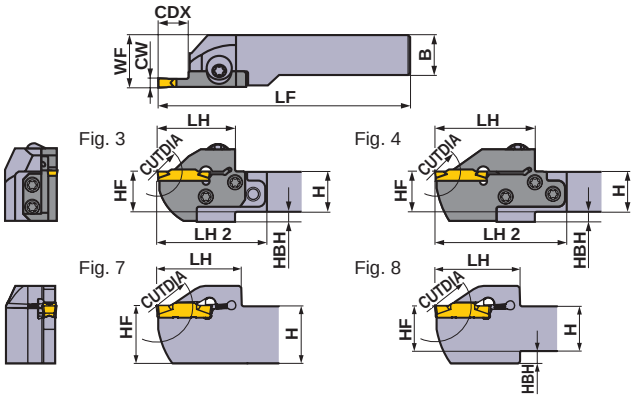
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
J	6.00 6.31 6.35	8	16	Mono Block	R	GYQR2020K00-J08	●	—	—	7
					L	GYQL2020K00-J08	●	—	—	7
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J08	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-J08	●	3
				Mono Block	R	GYQR2525M00-J08	●	—	—	7
					L	GYQL2525M00-J08	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J08	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-J08	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-J08	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-J08	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-J08	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-J08	●	5
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-J14	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-J14	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J14	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-J14	●	1
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-J14	●	5
					L	GYHL3225P00-M25L	●	GYM25LA-J14	●	5
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-J14	●	5
					L	GYHL3232P00-M25L	●	GYM25LA-J14	●	5
		25 ⋆1	50 ⋆2	Mono Block	R	GYQR2020K00-J25	●	—	—	8
					L	GYQL2020K00-J25	●	—	—	8
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J25	●	4
					L	GYHL2020K00-M25L	●	GYM25LA-J25	●	4
				Mono Block	R	GYQR2525M00-J25	●	—	—	7
					L	GYQL2525M00-J25	●	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J25	●	2
					L	GYHL2525M00-M25L	●	GYM25LA-J25	●	2
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-J25	●	6
					L	GYHL3225P00-M25L	●	GYM25LA-J25	●	6
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-J25	●	6
					L	GYHL3232P00-M25L	●	GYM25LA-J25	●	6

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

⋆1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : Inventory maintained in Japan.



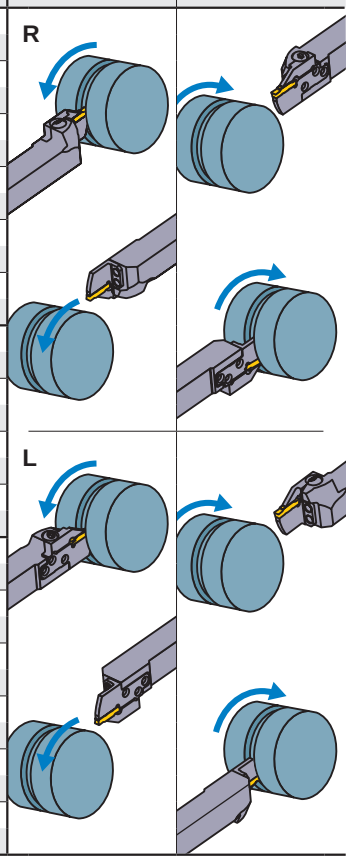
Right hand tool holder shown.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYQR/L○○○○○○○○-○○○	HSC05020 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—		
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		



Insert selection

Seat Size	Geometry name
J	GY○○0600/0631/0635J○○○○-Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
J	6.00mm	●	●	●		●
	6.35mm	●	●	●		

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

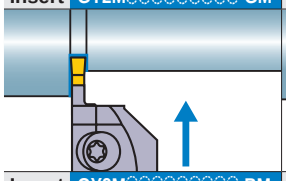
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F088
CAUTION FOR USE ➤ F092

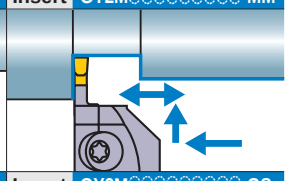
GY SERIES (EXTERNAL)

1 00° type holder

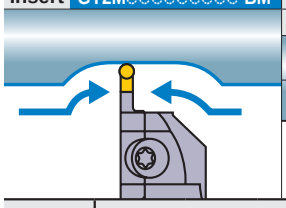
Insert GY2M○○○○○○○○○○-GS
Insert GY2M○○○○○○○○○○-GM



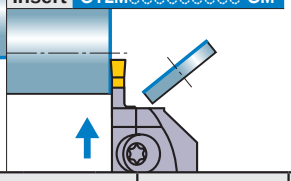
Insert GY2M○○○○○○○○○○-MS
Insert GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Insert GY2M○○○○○○○○○○-GS
Insert GY2M○○○○○○○○○○-GM



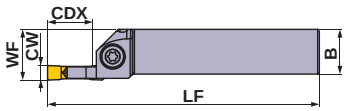


Fig. 1

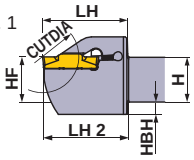
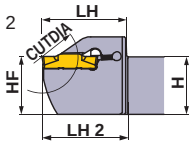


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)			Type	Hand (R/L)	Order Number				Fig.
	CW	CDX	CUTDIA			Holder	Stock	Modular Blade	Stock	
K	8.00	25 ⋆1	50 ⋆2	Mono Block	R	**GYPR2525M00-K25**	●	—	—	1
					L	**GYPL2525M00-K25**	●	—	—	1
				Mono Block	R	**GYPR3225P00-K25**	●	—	—	2
					L	**GYPL3225P00-K25**	●	—	—	2
				Mono Block	R	**GYPR3232P00-K25**	●	—	—	3
					L	**GYPL3232P00-K25**	●	—	—	3

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

⋆1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : **Inventory maintained in Japan.**

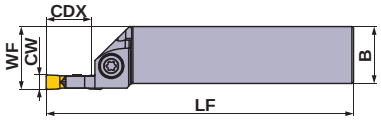
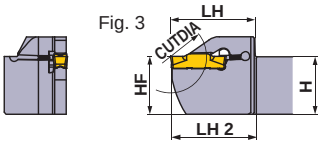


Fig. 3

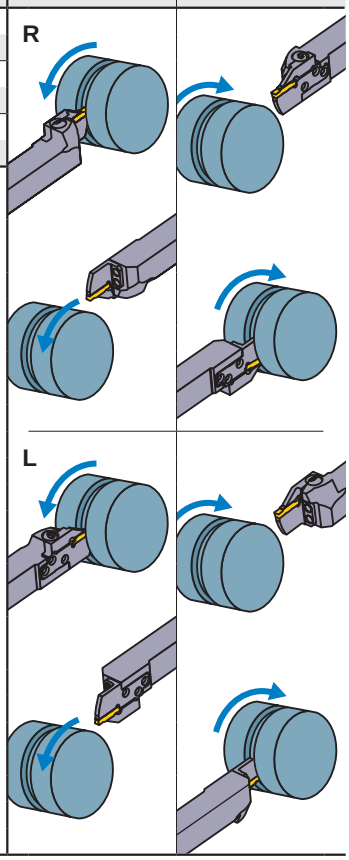


Right hand tool holder shown.

SPARE PARTS

Holder	Clamp Screw	Wrench
GYPR/L○○○○○○00-K25	GY06013M (Clamp Torque : 6.0N·m)	TKY30R

	Dimensions (mm) ⋆3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	25	25	150	47	48	25	28	7		
	25	25	150	47	48	25	28	7		
	32	25	170	47	48	32	28	—		
	32	25	170	47	48	32	28	—		
	32	32	170	47	48	32	35	—		
	32	32	170	47	48	32	35	—		



Insert selection

Seat Size	Geometry name
K	GY○○0800K○○○○−Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
K	8.00mm		●	●		

For multifunctional grooving breaker ➢ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
K	8.00mm				●
	RE 0.8		●	●	
	RE 1.2			●	

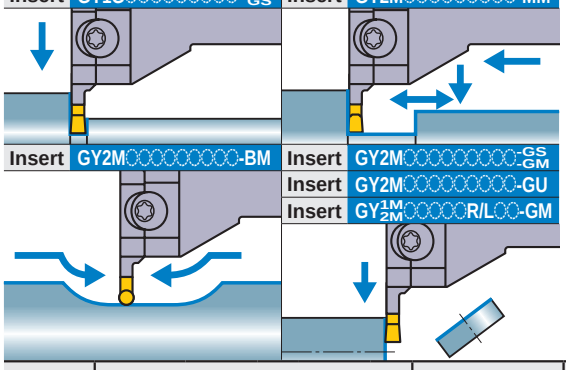
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

GY SERIES (EXTERNAL)

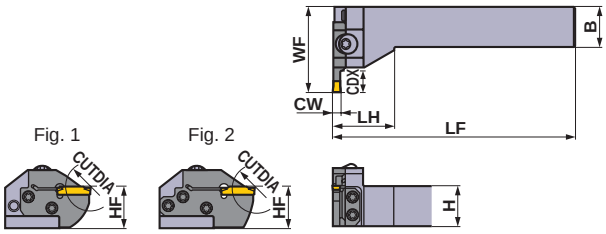
2 90° type holder

Insert GY1M/2M○○○○○○○○○○-GM
Insert GY2M○○○○○○○○○○-GS/GU
Insert GY1G○○○○○○○○○○-GF/GS
Insert GY2G○○○○○○○○○○-MF
Insert GY2M○○○○○○○○○○-MS
Insert GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM
Insert GY2M○○○○○○○○○○-GS/GM
Insert GY2M○○○○○○○○○○-GU
Insert GY1M/2M○○○○○○R/L○○-GM

Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
D	2.00 2.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-D06	●	1
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-D06	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-D06	●	1
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D10	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-D10	●	1
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D12	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-D12	●	1
		18 ⋆4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-D18	●	2
					L	GYHL2020K90-M20R	●	GYM20RB-D18	●	2
		20 ⋆1	40 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D20	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-D20	●	2
E	2.39 2.50 2.74	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-E06	●	1
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-E06	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-E06	●	1
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E10	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-E10	●	1
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E12	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-E12	●	1
		18 ⋆4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-E18	●	2
					L	GYHL2020K90-M20R	●	GYM20RB-E18	●	2
		20 ⋆1	40 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E20	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-E20	●	2

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

⋆1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
⋆4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

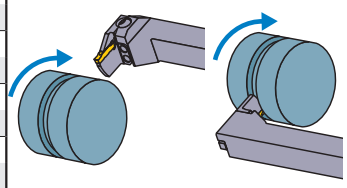
● : Inventory maintained in Japan.

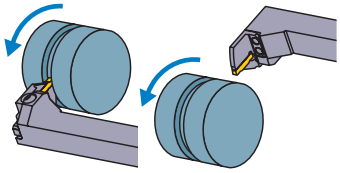
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *3						Cutting Mode
H	B	LF	LH	HF	WF	
20	20	125	35	20	39	R
20	20	125	35	20	39	
25	25	150	38	25	45	
25	25	150	38	25	45	
20	20	125	35	20	45	
20	20	125	35	20	45	
25	25	150	38	25	53	
25	25	150	38	25	53	
20	20	125	35	20	51	
20	20	125	35	20	51	
25	25	150	38	25	59	
25	25	150	38	25	59	
20	20	125	35	20	39	L
20	20	125	35	20	39	
25	25	150	38	25	45	
25	25	150	38	25	45	
20	20	125	35	20	45	
20	20	125	35	20	45	
25	25	150	38	25	53	
25	25	150	38	25	53	
20	20	125	35	20	51	
20	20	125	35	20	51	
25	25	150	38	25	59	
25	25	150	38	25	59	





Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○–Breaker shown below
E	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
D	2.00mm	●	●	●	●	●
E	2.39mm	●	●	●		●
	2.50mm	●	●	●	●	●

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

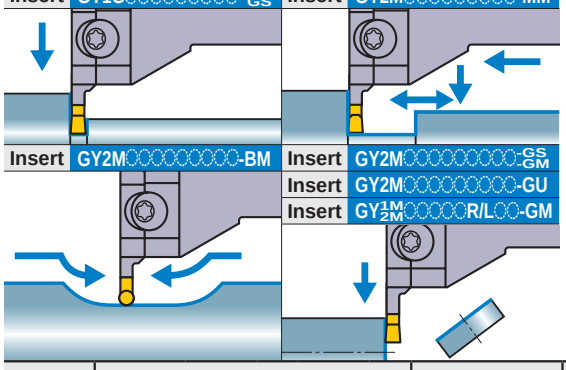
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

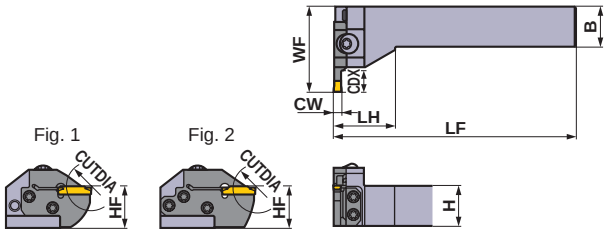
GY SERIES (EXTERNAL)

2 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM
Insert	GY2M○○○○○○○○○○-BM	Insert	GY2M○○○○○○○○○○-GS/GM
		Insert	GY2M○○○○○○○○○○-GU
		Insert	GY1M/2M○○○○○R/L○○-GM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-F06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-F06	●	1
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-F06	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-F06	●	1
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-F10	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-F10	●	1
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-F12	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-F12	●	1
		18*4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-F18	●	2
					L	GYHL2020K90-M20R	●	GYM20RB-F18	●	2
		20*1	40*2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-F20	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-F20	●	2
G	4.00 4.24	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G08	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-G08	●	1
		12	24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-G12	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-G12	●	1
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G14	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-G14	●	1
		25*1	50*2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G25	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-G25	●	2

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
*3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F090.

● : Inventory maintained in Japan.

* Wrench : ① : Clamp Screw, ② : Blade Screw

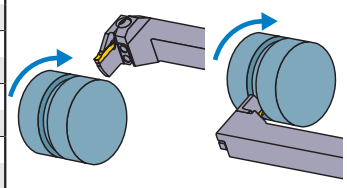
SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

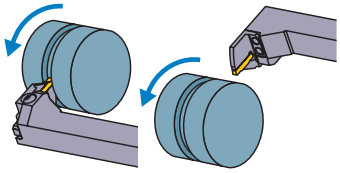
Dimensions (mm) *3						
H	B	LF	LH	HF	WF
20	20	125	35	20	39
20	20	125	35	20	39
25	25	150	38	25	45
25	25	150	38	25	45
20	20	125	35	20	45
20	20	125	35	20	45
25	25	150	38	25	53
25	25	150	38	25	53
20	20	125	35	20	51
20	20	125	35	20	51
25	25	150	38	25	59
25	25	150	38	25	59
25	25	150	38	25	47
25	25	150	38	25	47
20	20	125	35	20	45
20	20	125	35	20	45
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64

Cutting Mode

R



L



Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below
G	GY○○0400/0424G○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	05-GM (Cutting off)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	With hand	Neutral
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●		●
G	4.00mm	●	●	●	●	●

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

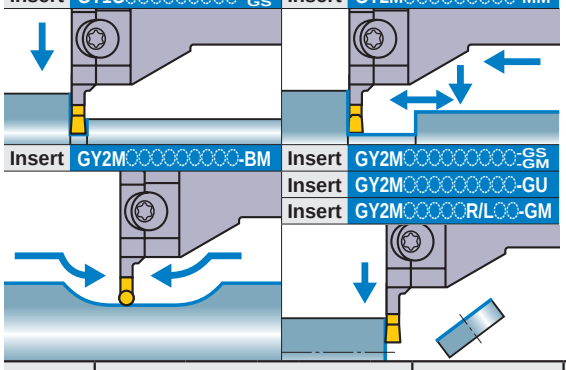
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

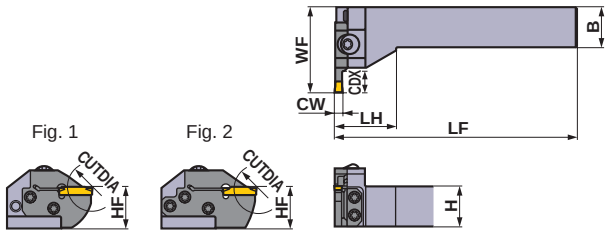
GY SERIES (EXTERNAL)

2 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM
Insert	GY2M○○○○○○○○○○-BM	Insert	GY2M○○○○○○○○○○-GS/GM
		Insert	GY2M○○○○○○○○○○-GU
		Insert	GY2M○○○○○R/L○○-GM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.



Right hand tool holder shown.

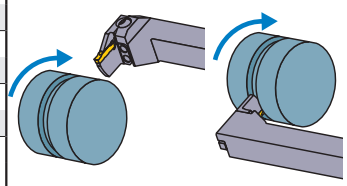
Seat Size	Dimensions (mm) CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H08	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-H08	●	1
		12	24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-H12	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-H12	●	1
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H14	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-H14	●	1
		25 ⋆1	50 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H25	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-H25	●	2
J	6.00 6.31 6.35	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J08	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-J08	●	1
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J14	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-J14	●	1
		25 ⋆1	50 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J25	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-J25	●	2

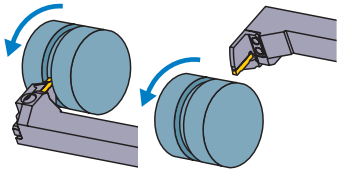
CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cut Off Diameter

⋆1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆2 The maximum cut off diameter (**CUTDIA**) varies according to the insert used. The cut off diameter is double the maximum groove depth (**CDX**) of inserts on pages F010—F012.
⋆3 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.

● : Inventory maintained in Japan.

Dimensions (mm) *3						Cutting Mode
H	B	LF	LH	HF	WF	
25	25	150	38	25	47	R
25	25	150	38	25	47	
20	20	125	35	20	45	
20	20	125	35	20	45	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	64	
25	25	150	38	25	64	
25	25	150	38	25	47	L
25	25	150	38	25	47	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	64	
25	25	150	38	25	64	





*Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below
J	GY○○0600/0631/0635J○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel) Neutral	GS (Low) Neutral	GM (Medium) Neutral	05-GM (Cutting off) With hand	GFGS (Hardened steel) Neutral
H	4.75mm	●	●	●		●
	5.00mm	●	●	●	●	●
J	6.00mm	●	●	●		●
	6.35mm	●	●	●		

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

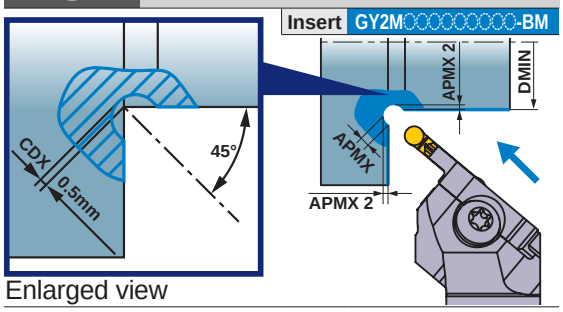
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F088
CAUTION FOR USE ➢ F092

GY SERIES (FOR EXTERNAL RECESSING)

3 For 50° recessing holder

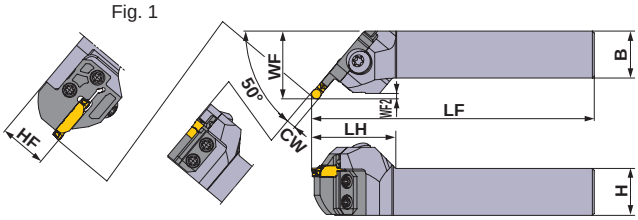
Insert GY2M○○○○○○○○○-BM



Enlarged view

Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

Fig. 1



Right hand tool holder shown.

Seat Size	Dimensions (mm)					Type	Hand (R/L)	Order Number				Fig.
	CW	CDX	DMIN	APMX	APMX 2			Holder	Stock	Modular Blade	Stock	
D	2.00	0.5	30	1.5	0.646	Modular	R	GYHR2020K50-M20L	●	GYM20LC-D005	●	1
							L	GYHL2020K50-M20R	●	GYM20RC-D005	●	1
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-D005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-D005	●	1
E	2.50			1.75	0.72	Modular	R	GYHR2020K50-M20L	●	GYM20LC-E005	●	1
							L	GYHL2020K50-M20R	●	GYM20RC-E005	●	1
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-E005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-E005	●	1
F	3.00 3.18			2	0.793	Modular	R	GYHR2020K50-M20L	●	GYM20LC-F005	●	1
							L	GYHL2020K50-M20R	●	GYM20RC-F005	●	1
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-F005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-F005	●	1
G	4.00		20	2.5	0.939	Modular	R	GYHR2020K50-M20L	●	GYM20LC-G005	●	1
							L	GYHL2020K50-M20R	●	GYM20RC-G005	●	1
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-G005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-G005	●	1
H	4.75 5.00			2.88	1.049	Modular	R	GYHR2020K50-M20L	●	GYM20LC-H005	●	1
							L	GYHL2020K50-M20R	●	GYM20RC-H005	●	1
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-H005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-H005	●	1
J	6.00 6.35			3.5	1.232	Modular	R	GYHR2525M50-M25L	●	GYM25LC-J005	●	1
							L	GYHL2525M50-M25R	●	GYM25RC-J005	●	1

*1 Cannot be used because external and face grooving blade interferes with the work.
*2 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF**, **LH**, **WF** and **WF2** values may vary.

● : **Inventory maintained in Japan.**

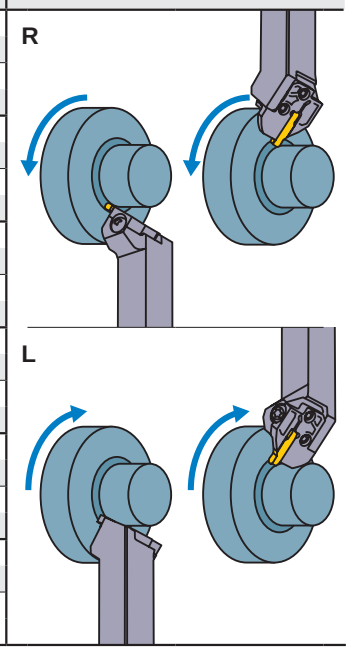
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) *2						
H	B	LF	LH	HF	WF	WF2
20	20	125	40	20	32	1.6
20	20	125	40	20	32	1.6
25	25	150	45	25	35	1.6
25	25	150	45	25	35	1.6
20	20	125	40	20	32	1.8
20	20	125	40	20	32	1.8
25	25	150	45	25	35	1.8
25	25	150	45	25	35	1.8
20	20	125	40	20	32	2.0
20	20	125	40	20	32	2.0
25	25	150	45	25	35	2.0
25	25	150	45	25	35	2.0
20	20	125	40	20	32	2.4
20	20	125	40	20	32	2.4
25	25	150	45	25	35	2.4
25	25	150	45	25	35	2.4
20	20	125	40	20	33	2.8
20	20	125	40	20	33	2.8
25	25	150	45	25	36	2.8
25	25	150	45	25	36	2.8
25	25	150	44	25	36	3.4
25	25	150	44	25	36	3.4

Cutting Mode



Insert selection

Geometry name
GY2M○○○○○○○○○N-BM

For multifunctional grooving breaker ➤ F012		
Seat Size	Breaker / CW	BM (Copying, Recessing) Ball shape
D	2.00mm	●
E	2.50mm	●
F	3.00mm	●
	3.18mm	●
G	4.00mm	●
H	4.75mm	●
	5.00mm	●
J	6.00mm	●
	6.35mm	●

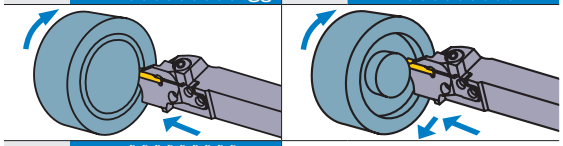
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F091
CAUTION FOR USE ➤ F091

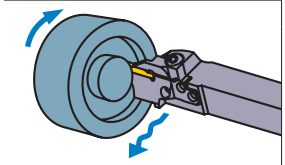
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

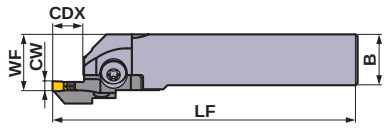


Fig. 1

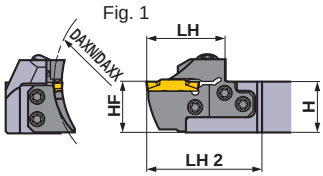
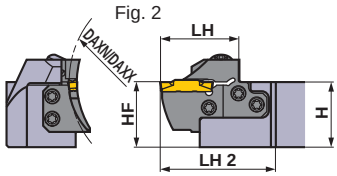


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-040	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-040	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-040	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-040	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-040	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-050	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-050	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-050	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-050	●	2
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-060	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-060	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-060	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-060	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-060	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-060	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-060	●	2
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-075	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-075	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-075	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-075	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-075	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-075	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-075	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.

● : Inventory maintained in Japan.

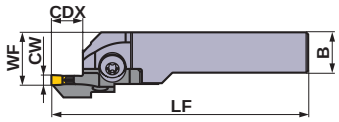
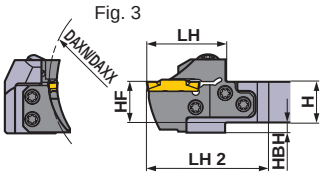


Fig. 3



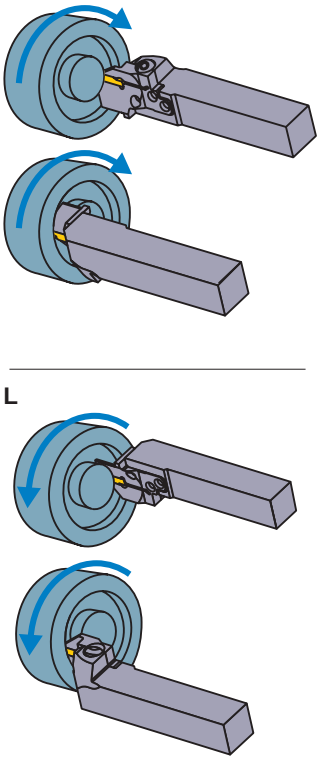
Right hand tool holder shown.

＊Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ＊
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ＊1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	



Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011					
Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	2.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012					
Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			

● : Standard insert with dimensions

F

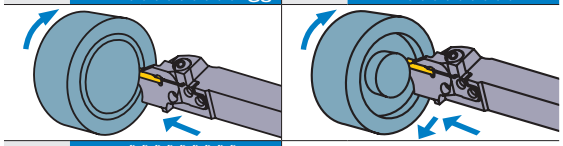
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

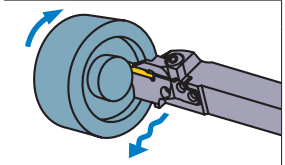
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

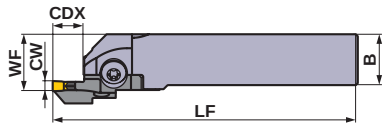


Fig. 1

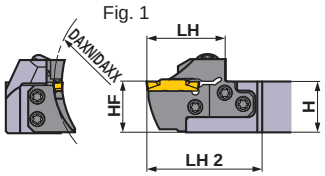
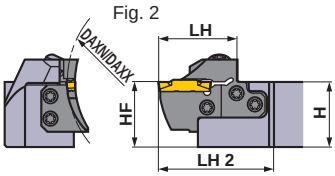


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-100	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-100	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-100	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-100	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-100	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-100	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-100	●	2
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-135	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-135	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-135	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-135	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-135	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-135	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-135	●	2
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-180	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-180	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-180	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-180	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-D12-180	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-180	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-D12-180	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.

● : Inventory maintained in Japan.

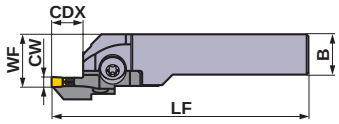
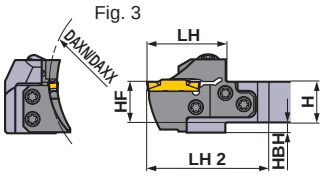


Fig. 3



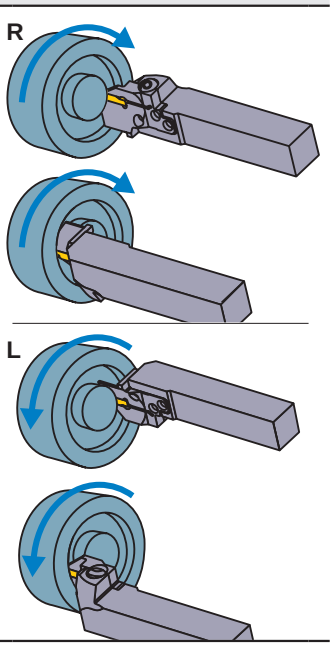
Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	



Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	2.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			

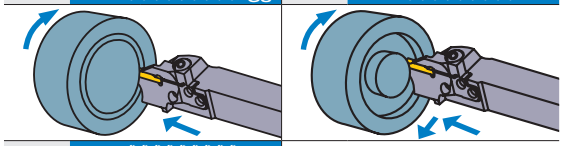
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

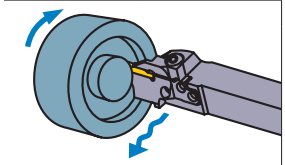
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

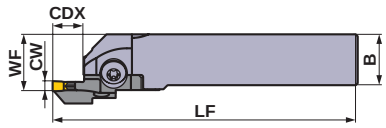


Fig. 1

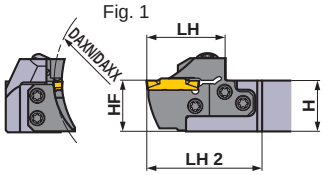
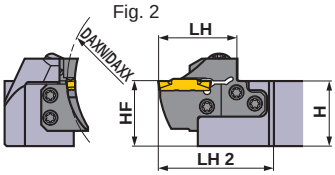


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-040	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-040	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-040	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-040	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-040	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-050	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-050	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-050	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-050	●	2
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-060	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-060	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-060	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-060	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-060	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-060	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-060	●	2
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-075	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-075	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-075	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-075	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-075	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-075	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-075	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.

● : Inventory maintained in Japan.

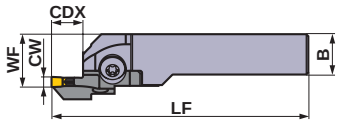
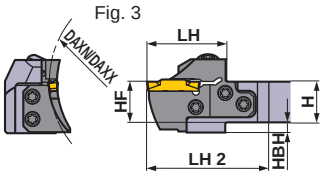


Fig. 3



Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
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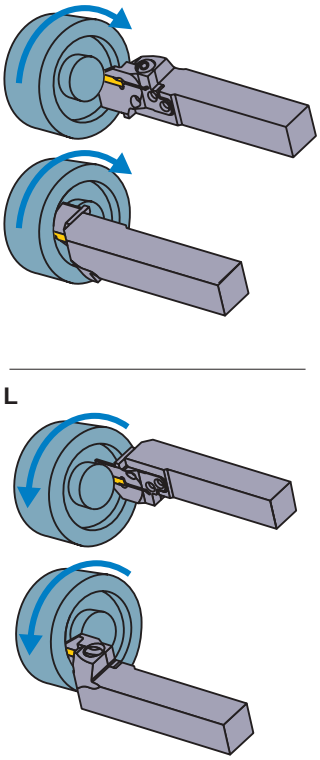
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	



Insert selection

Seat Size	Geometry name
E	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Standard insert with dimensions

F

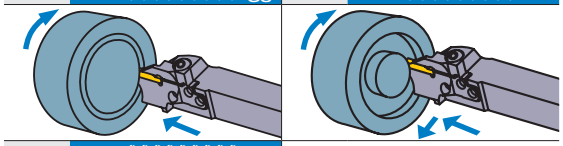
GROOVING / CUTTING OFF

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F096
CAUTION FOR USE ➢ F098

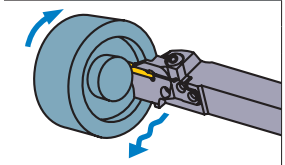
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

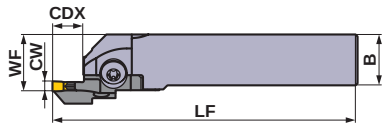


Fig. 1

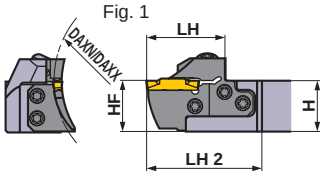
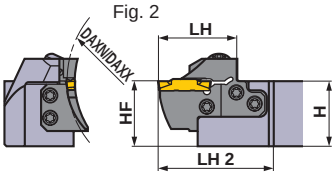


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-100	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-100	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-100	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-100	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-100	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-100	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-100	●	2
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-135	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-135	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-135	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-135	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-135	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-135	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-135	●	2
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-180	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-180	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-180	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-180	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-E12-180	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-180	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-E12-180	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.

● : Inventory maintained in Japan.

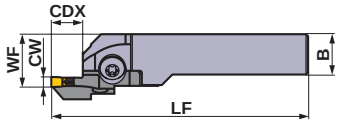
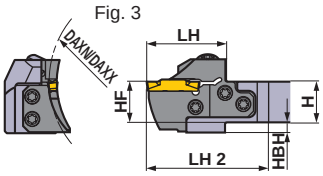


Fig. 3



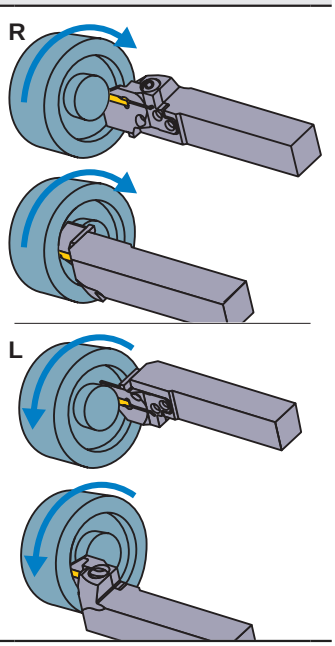
Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ⁎1								Cutting Mode
	H	B	LF	LH	LH 2	HF	WF	HBH	
	20	20	125	39	60	20	26	5	R
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	125	39	60	20	26	5	
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	125	39	60	20	26	5	L
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	



Insert selection

Seat Size	Geometry name
E	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

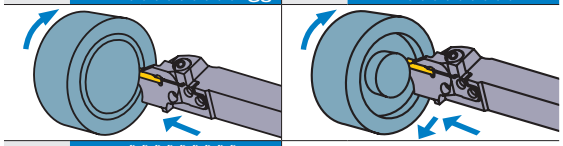
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

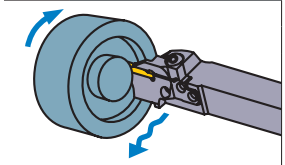
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○-MM



Insert GY2M○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.

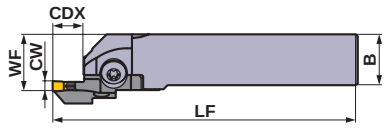


Fig. 1

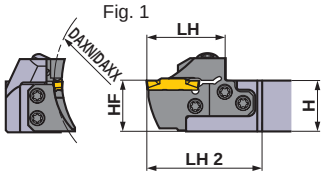
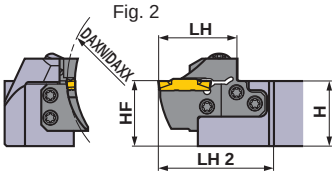


Fig. 2



Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-035	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-035	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-035	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-035	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-035	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-F12-035	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-035	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-F12-035	●	2
		40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-040	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-040	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-040	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-F12-040	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-040	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-F12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-050	●	2
						L	GYHL3225P00-M25L	●	GYM25LD-F12-050	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-050	●	2
						L	GYHL3232P00-M25L	●	GYM25LD-F12-050	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.

● : Inventory maintained in Japan.

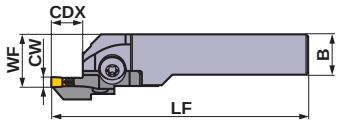
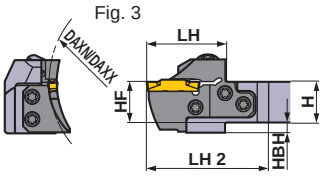


Fig. 3



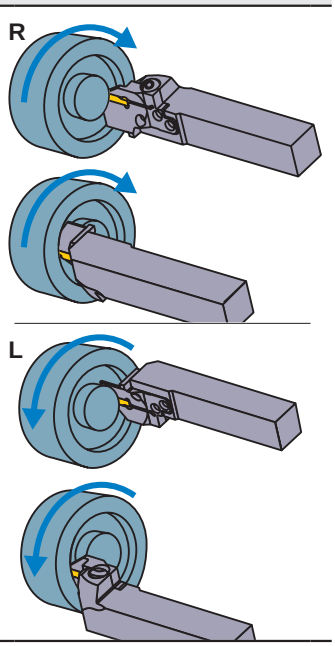
Right hand tool holder shown.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1								Cutting Mode
	H	B	LF	LH	LH 2	HF	WF	HBH	
	20	20	125	39	60	20	26	5	R
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	125	39	60	20	26	5	
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	125	39	60	20	26	5	L
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	



Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

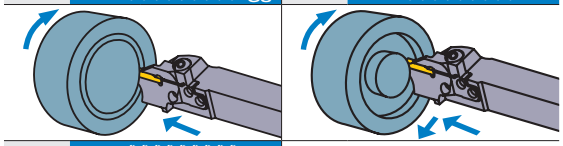
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

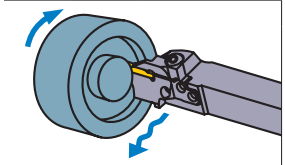
GY SERIES (FACE GROOVING)

4 00° type holder

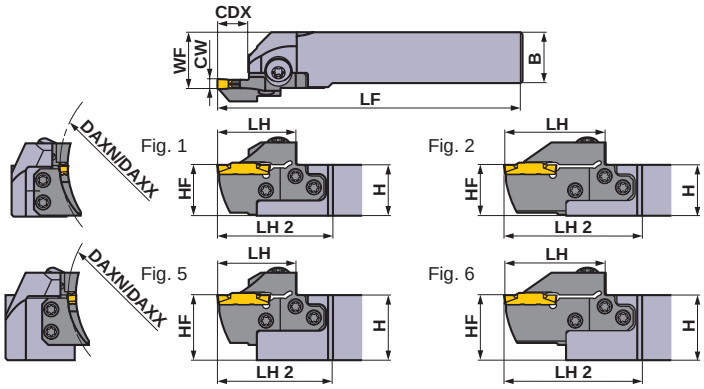
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



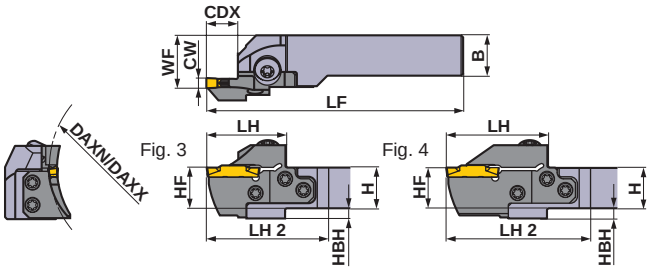
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-060	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-060	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-060	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-060	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-060	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-060	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-060	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-060	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-060	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-060	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-060	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-060	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-060	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-060	●	6
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-075	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-075	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-075	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-075	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-075	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-075	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-075	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-075	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-075	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-075	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-075	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-075	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-075	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-075	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-075	●	6

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



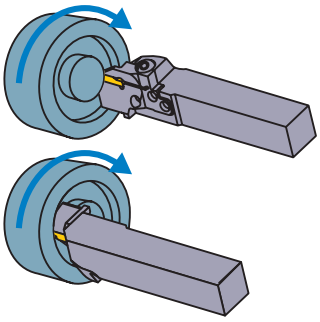
Right hand tool holder shown.

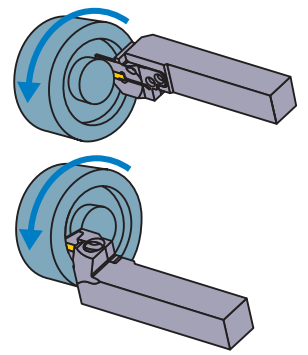
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	131	45	66	20	26	5	
20	20	131	45	66	20	26	5	
25	25	156	45	63	25	28	—	
25	25	156	45	63	25	28	—	
32	25	176	45	63	32	28	—	
32	25	176	45	63	32	28	—	
32	32	176	45	63	32	35	—	
32	32	176	45	63	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	131	45	66	20	26	5	
20	20	131	45	66	20	26	5	
25	25	156	45	63	25	28	—	
25	25	156	45	63	25	28	—	
32	25	176	45	63	32	28	—	
32	25	176	45	63	32	28	—	
32	32	176	45	63	32	35	—	
32	32	176	45	63	32	35	—	





Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

● : Standard insert with dimensions

F

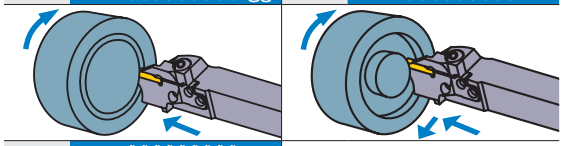
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

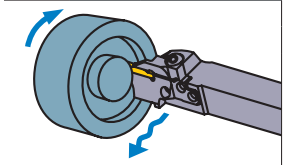
GY SERIES (FACE GROOVING)

4 00° type holder

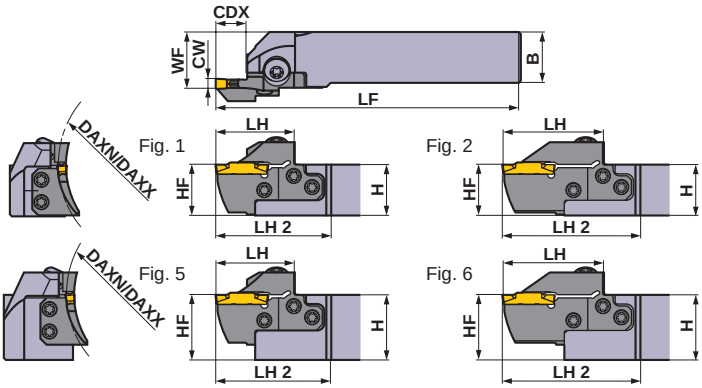
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



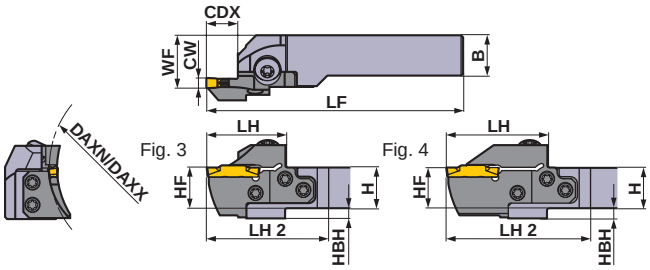
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-100	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-100	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-100	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-100	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-100	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-100	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-100	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-100	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-100	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-100	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-100	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-100	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-100	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-100	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-100	●	6
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-135	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-135	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-135	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-135	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-135	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-135	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-135	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-135	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-135	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-135	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-135	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-135	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-135	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-135	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-135	●	6

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

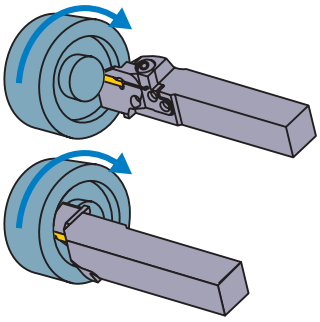
SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

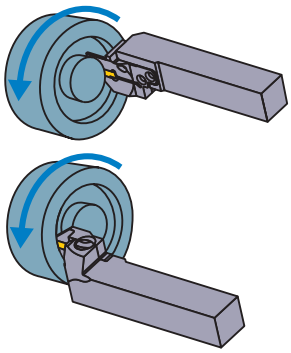
Dimensions (mm) ⁎1							
H	B	LF	LH	LH 2	HF	WF	HBH
20	20	125	39	60	20	26	5
20	20	125	39	60	20	26	5
25	25	150	39	57	25	28	—
25	25	150	39	57	25	28	—
32	25	170	39	57	32	28	—
32	25	170	39	57	32	28	—
32	32	170	39	57	32	35	—
32	32	170	39	57	32	35	—
20	20	131	45	66	20	26	5
20	20	131	45	66	20	26	5
25	25	156	45	63	25	28	—
25	25	156	45	63	25	28	—
32	25	176	45	63	32	28	—
32	25	176	45	63	32	28	—
32	32	176	45	63	32	35	—
32	32	176	45	63	32	35	—
20	20	125	39	60	20	26	5
20	20	125	39	60	20	26	5
25	25	150	39	57	25	28	—
25	25	150	39	57	25	28	—
32	25	170	39	57	32	28	—
32	25	170	39	57	32	28	—
32	32	170	39	57	32	35	—
32	32	170	39	57	32	35	—
20	20	131	45	66	20	26	5
20	20	131	45	66	20	26	5
25	25	156	45	63	25	28	—
25	25	156	45	63	25	28	—
32	25	176	45	63	32	28	—
32	25	176	45	63	32	28	—
32	32	176	45	63	32	35	—
32	32	176	45	63	32	35	—

Cutting Mode

R



L



Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

● : Standard insert with dimensions

F

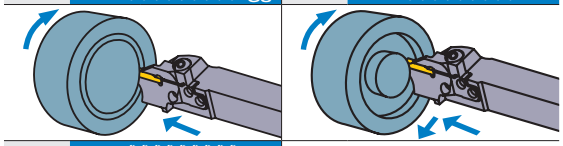
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

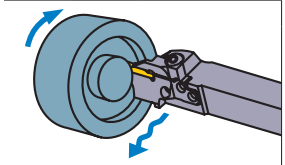
GY SERIES (FACE GROOVING)

4 00° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



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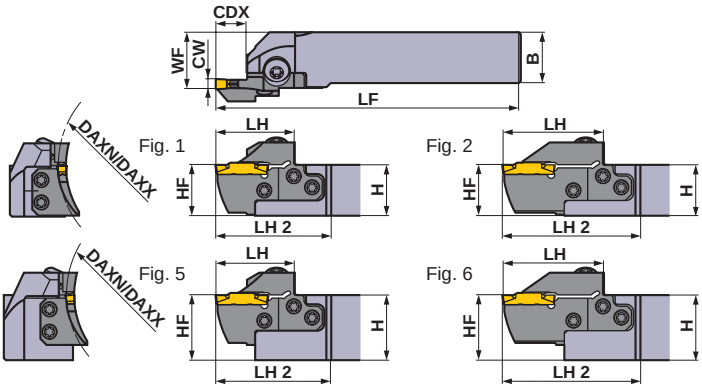
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



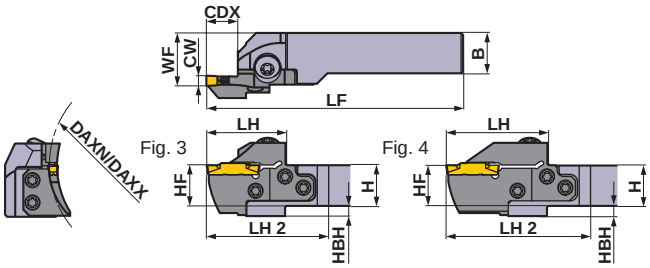
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-180	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-180	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-180	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-180	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-180	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-180	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-180	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-180	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-180	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-180	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-180	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-180	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-180	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-180	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-180	●	6
		225	999	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-225	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-F12-225	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-225	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-F12-225	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-225	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-F12-225	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-225	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-F12-225	●	5
				20 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-225	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-F20-225	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-225	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-F20-225	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-225	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-F20-225	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-225	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-F20-225	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



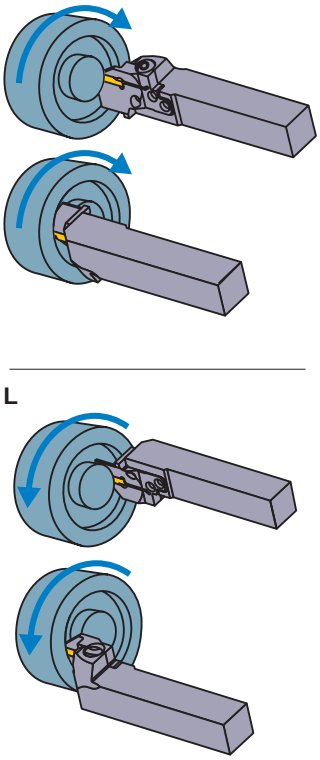
Right hand tool holder shown.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1								Cutting Mode
	H	B	LF	LH	LH 2	HF	WF	HBH	
	20	20	125	39	60	20	26	5	R
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	131	45	66	20	26	5	
	20	20	131	45	66	20	26	5	
	25	25	156	45	63	25	28	—	
	25	25	156	45	63	25	28	—	
	32	25	176	45	63	32	28	—	
	32	25	176	45	63	32	28	—	
	32	32	176	45	63	32	35	—	
	32	32	176	45	63	32	35	—	
	20	20	125	39	60	20	26	5	L
	20	20	125	39	60	20	26	5	
	25	25	150	39	57	25	28	—	
	25	25	150	39	57	25	28	—	
	32	25	170	39	57	32	28	—	
	32	25	170	39	57	32	28	—	
	32	32	170	39	57	32	35	—	
	32	32	170	39	57	32	35	—	
	20	20	131	45	66	20	26	5	
	20	20	131	45	66	20	26	5	
	25	25	156	45	63	25	28	—	
	25	25	156	45	63	25	28	—	
	32	25	176	45	63	32	28	—	
	32	25	176	45	63	32	28	—	
	32	32	176	45	63	32	35	—	
	32	32	176	45	63	32	35	—	



Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

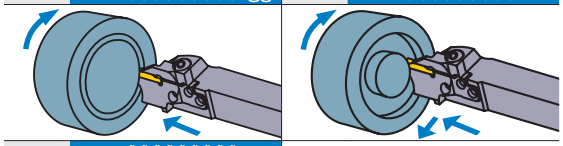
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

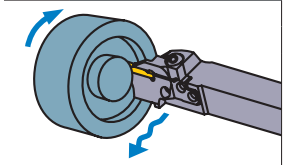
GY SERIES (FACE GROOVING)

4 00° type holder

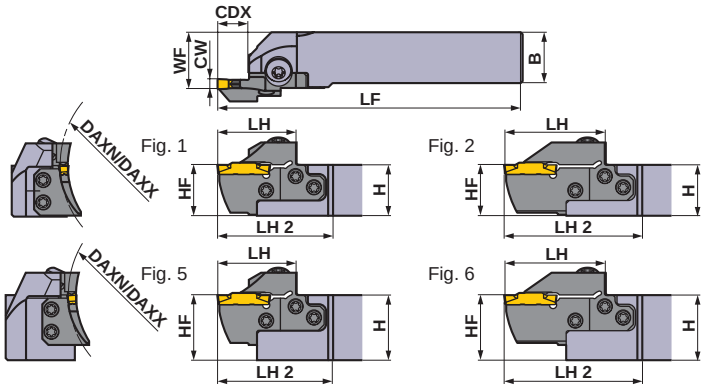
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



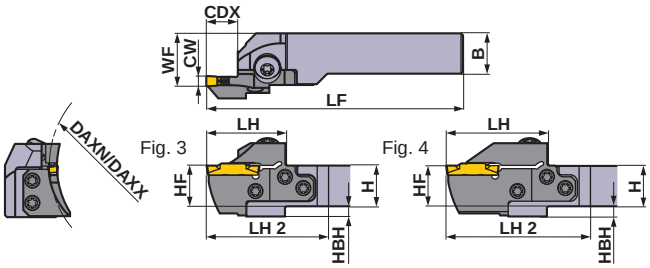
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
G	4.00 4.24	40	50	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-040	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-040	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-040	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-040	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-040	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-040	●	5
		50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-050	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-050	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-050	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-050	●	5
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-060	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-060	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-060	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-060	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-060	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-060	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-060	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-060	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-G25-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-060	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-G25-060	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-060	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-G25-060	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-060	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-G25-060	●	6

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



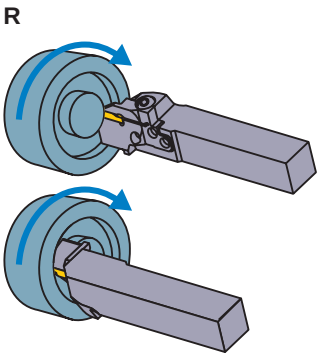
Right hand tool holder shown.

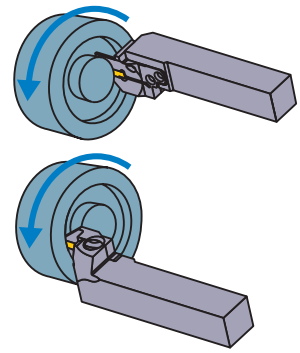
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
G	GY○○0400/0424G○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	4.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

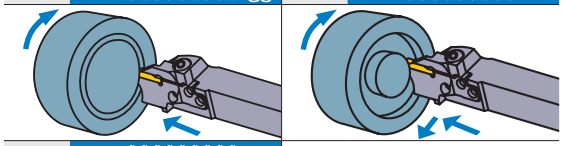
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

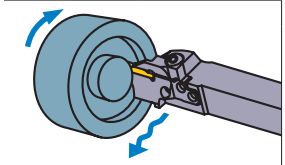
GY SERIES (FACE GROOVING)

4 00° type holder

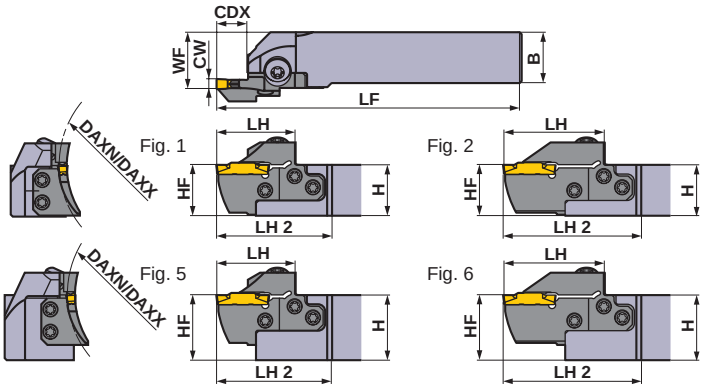
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



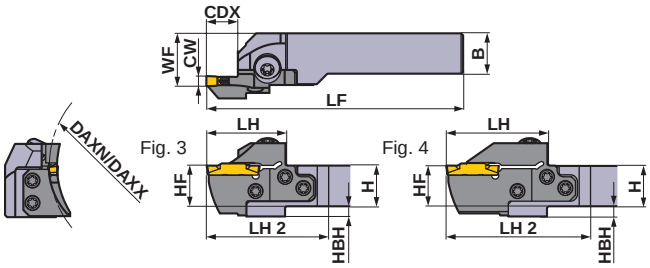
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
G	4.00 4.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-085	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-085	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-085	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-085	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-085	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-G25-085	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-085	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-G25-085	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-085	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-G25-085	●	6
		125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-125	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-125	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-125	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-125	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-125	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-G25-125	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-125	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-G25-125	●	6

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



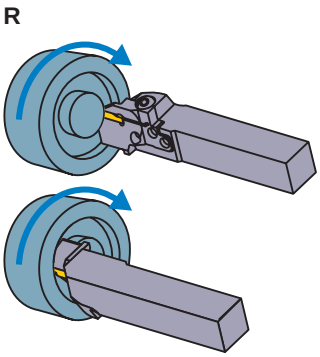
Right hand tool holder shown.

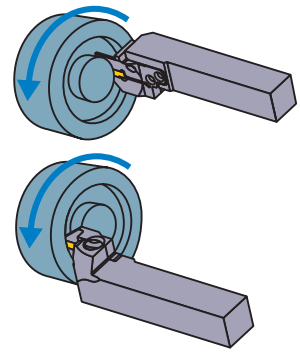
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
G	GY○○0400/0424G○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	4.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

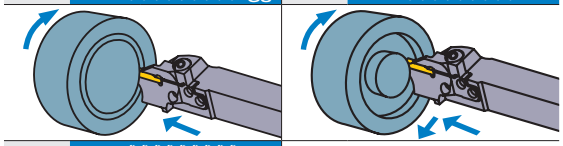
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

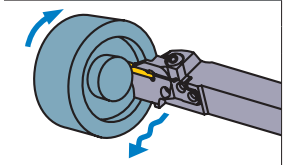
GY SERIES (FACE GROOVING)

4 00° type holder

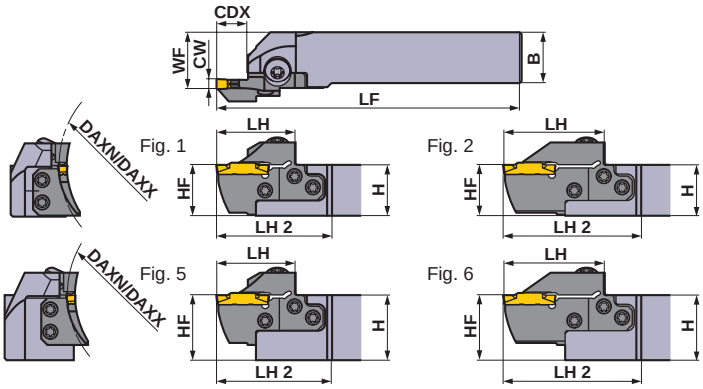
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



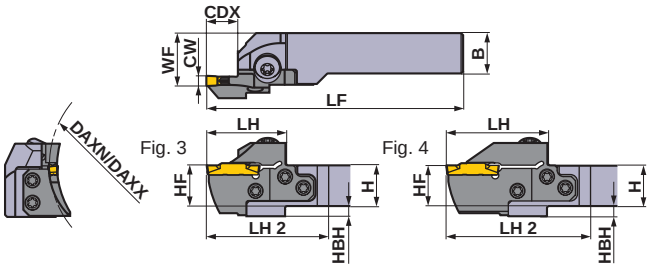
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
G	4.00 4.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-180	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-180	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-180	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-180	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-180	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-G25-180	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-180	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-G25-180	●	6
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-250	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-G14-250	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-250	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-G14-250	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-250	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-G25-250	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-250	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-G25-250	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-250	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-G25-250	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : Inventory maintained in Japan.



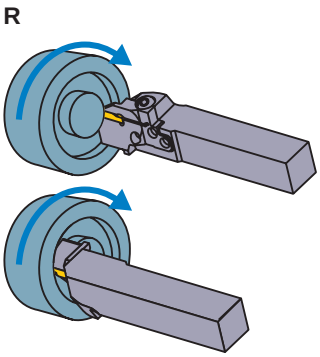
Right hand tool holder shown.

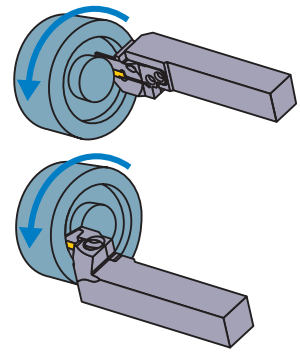
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
G	GY○○0400/0424G○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	4.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

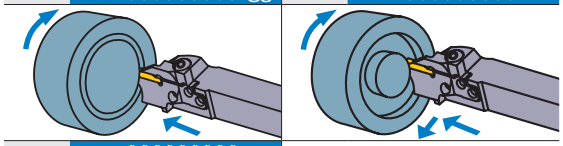
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

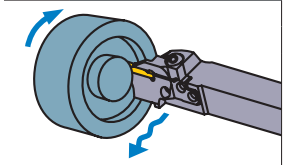
GY SERIES (FACE GROOVING)

4 00° type holder

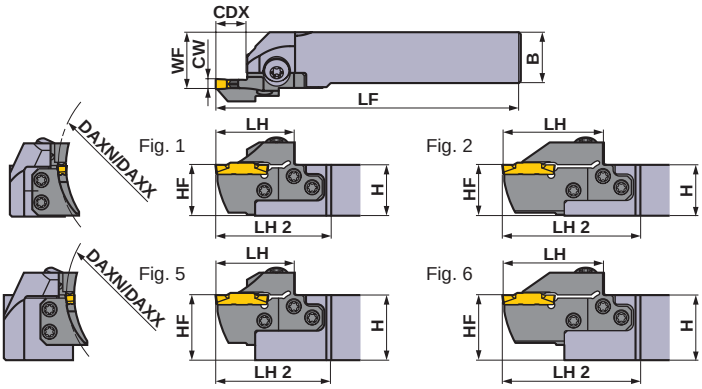
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



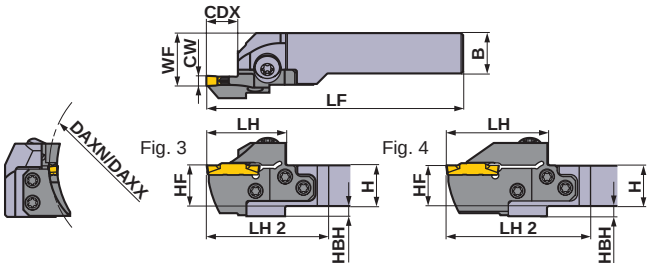
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-050	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-050	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-050	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-050	●	5
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-060	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-060	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-060	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-060	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-060	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-060	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-060	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-060	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-H25-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-060	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-H25-060	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-060	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-H25-060	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-060	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-H25-060	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
*2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : Inventory maintained in Japan.



Right hand tool holder shown.

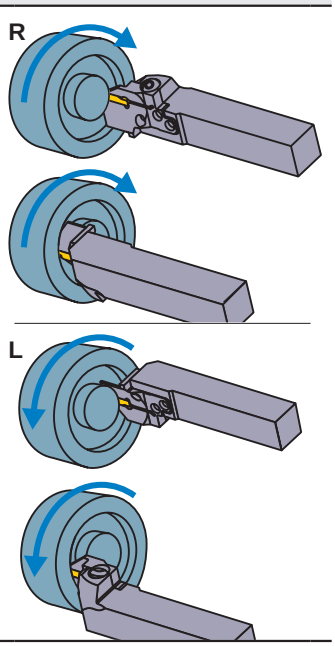
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—

Cutting Mode



Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

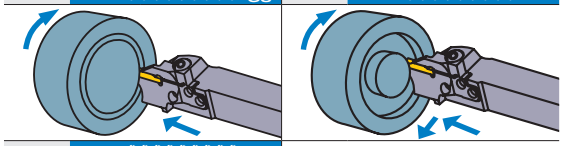
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

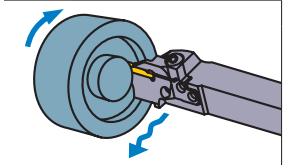
GY SERIES (FACE GROOVING)

4 00° type holder

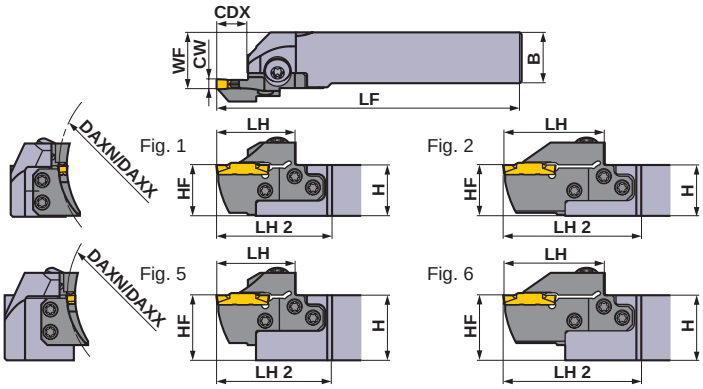
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



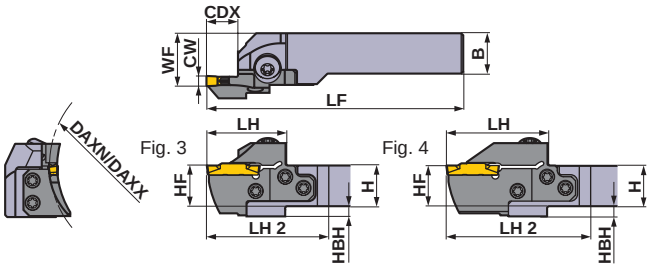
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-085	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-085	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-085	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-085	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-085	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-085	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-085	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-085	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-085	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-H25-085	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-085	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-H25-085	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-085	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-H25-085	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-085	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-H25-085	●	6
		125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-125	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-125	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-125	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-125	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-125	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-125	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-125	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-125	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-125	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-H25-125	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-125	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-H25-125	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-125	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-H25-125	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-125	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-H25-125	●	6

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



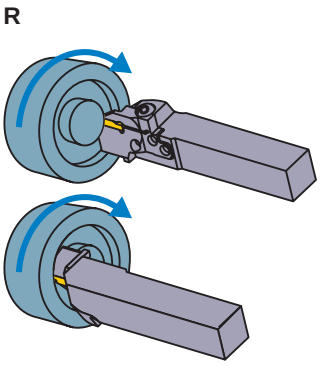
Right hand tool holder shown.

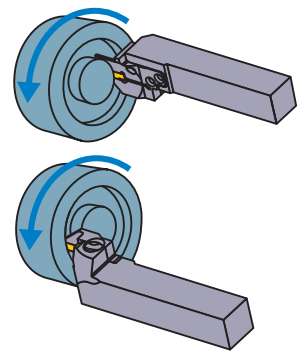
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

● : Standard insert with dimensions

F

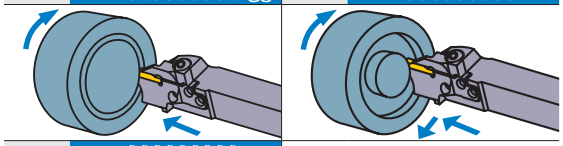
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

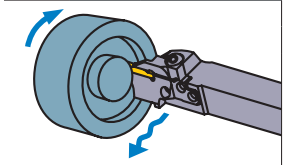
GY SERIES (FACE GROOVING)

4 00° type holder

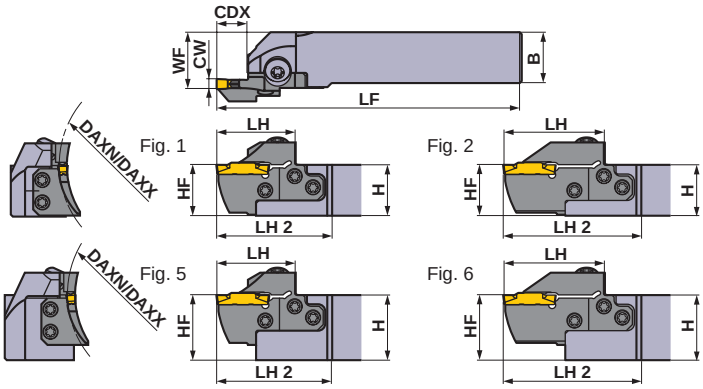
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



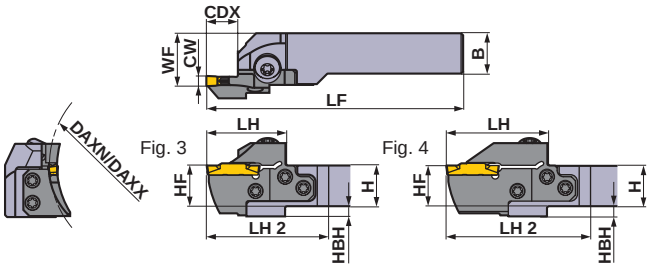
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-180	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-180	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-180	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-180	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-180	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-180	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-180	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-180	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-H25-180	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-180	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-H25-180	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-180	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-H25-180	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-180	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-H25-180	●	6
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-250	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-H14-250	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-250	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-H14-250	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-250	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-H14-250	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-250	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-H14-250	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-250	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-H25-250	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-250	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-H25-250	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-250	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-H25-250	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-250	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-H25-250	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



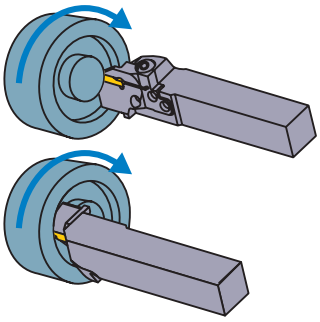
Right hand tool holder shown.

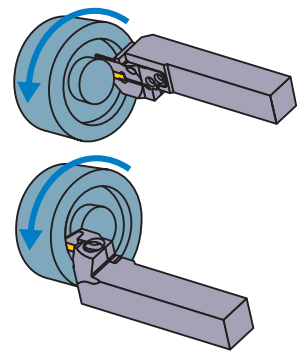
⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

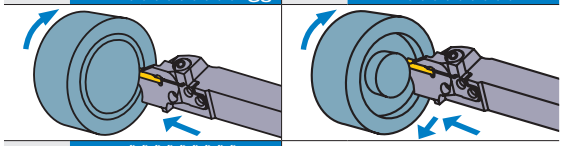
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

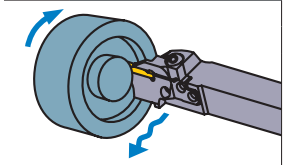
GY SERIES (FACE GROOVING)

4 00° type holder

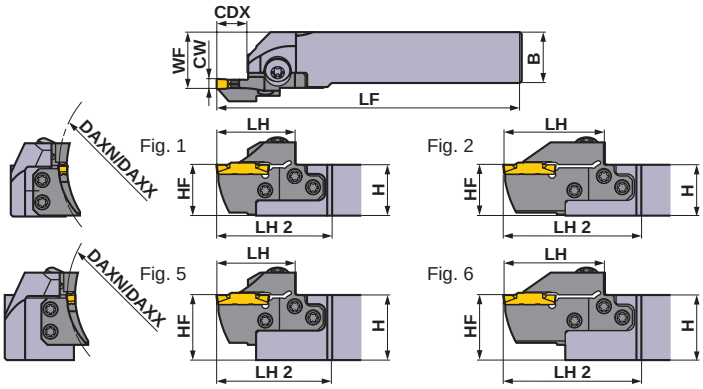
Insert	GY2M○○○○○○○○○○-GS GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○- GF GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



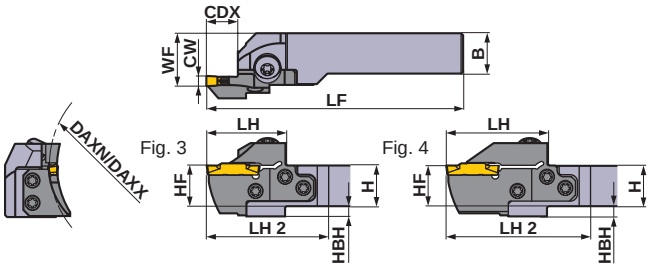
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-050	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-J14-050	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-050	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-J14-050	●	5
		70	110	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-070	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-J14-070	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-070	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-J14-070	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-070	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-J25-070	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-070	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-J25-070	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-070	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-J25-070	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-070	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-J25-070	●	6
		110	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-110	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-J14-110	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-110	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-J14-110	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-110	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-J25-110	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-110	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-J25-110	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : Inventory maintained in Japan.



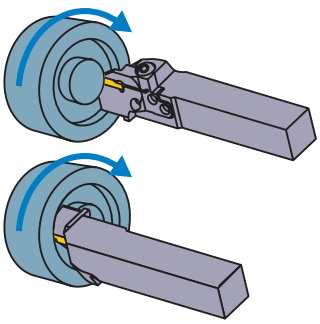
Right hand tool holder shown.

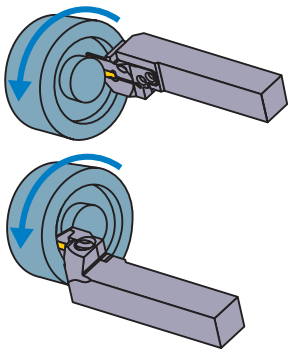
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	





Insert selection

Seat Size	Geometry name
J	GY○○0600/0631/0635J○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	6.00mm	●	●	●	●
	6.35mm	●	●	●	

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

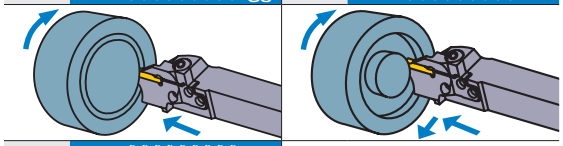
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F096
CAUTION FOR USE ➢ F098

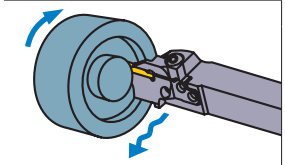
GY SERIES (FACE GROOVING)

4 00° type holder

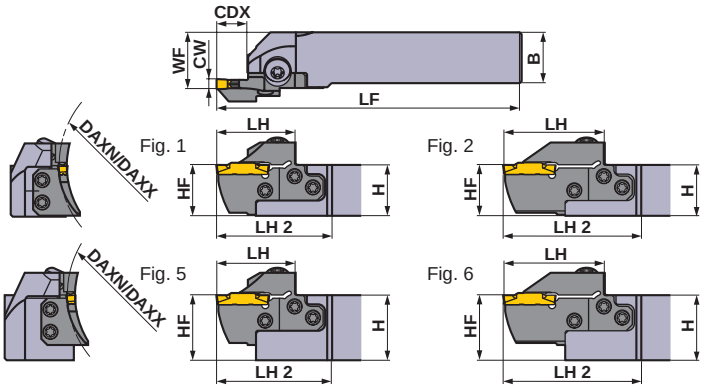
Insert	GY2M○○○○○○○○○○-GS GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the right hand modular blade at the right hand holder and the left hand modular blade at the left hand holder.



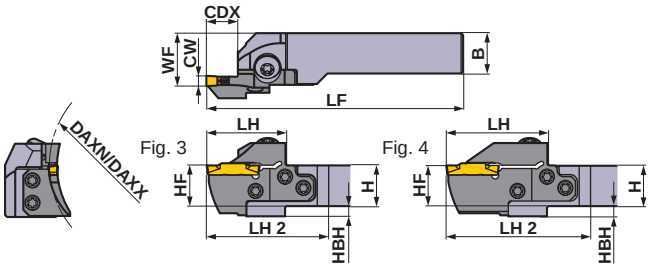
Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
J	6.00 6.31 6.35	170	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-170	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-J14-170	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-170	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-J14-170	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-170	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-J14-170	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-170	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-J25-170	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-170	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-J25-170	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-170	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-J25-170	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-170	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-J25-170	●	6
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-J14-250	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-250	●	5
						L	GYHL3225P00-M25L	●	GYM25LD-J14-250	●	5
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-250	●	5
						L	GYHL3232P00-M25L	●	GYM25LD-J14-250	●	5
				25 ⋆2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-250	●	4
						L	GYHL2020K00-M25L	●	GYM25LD-J25-250	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-250	●	2
						L	GYHL2525M00-M25L	●	GYM25LD-J25-250	●	2
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-250	●	6
						L	GYHL3225P00-M25L	●	GYM25LD-J25-250	●	6
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-250	●	6
						L	GYHL3232P00-M25L	●	GYM25LD-J25-250	●	6

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2**, and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**



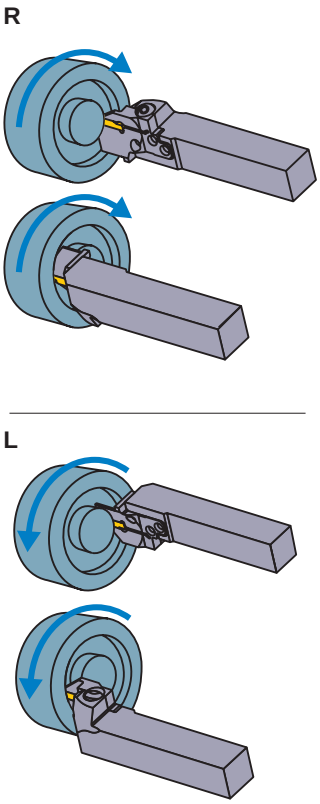
Right hand tool holder shown.

⁎ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench ⁎
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ⁎1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	



Insert selection

Seat Size	Geometry name
J	GY○○0600/0631/0635J○○○○–Breaker shown below

For grooving/cutting off breaker ➢ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	6.00mm	●	●	●	●
	6.35mm	●	●	●	

For multifunctional grooving breaker ➢ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

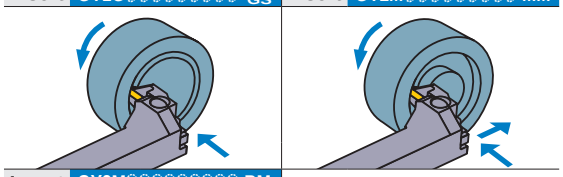
● : Standard insert with dimensions

IDENTIFICATION ➢ F008, F009
CUTTING CONDITIONS ➢ F096
CAUTION FOR USE ➢ F098

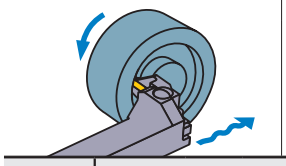
GY SERIES (FACE GROOVING)

5 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

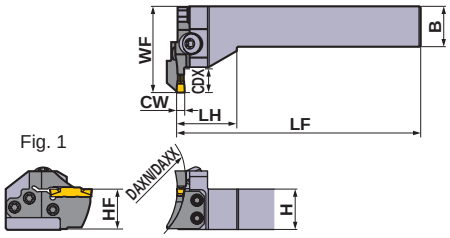


Fig. 1

Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
D	2.00 2.24	40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-060	●	1
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-075	●	1
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-100	●	1
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-135	●	1
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-180	●	1
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-060	●	1
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-075	●	1
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-100	●	1
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-135	●	1
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-180	●	1

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

*1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.

● : Inventory maintained in Japan.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *1						
H	B	LF	LH	HF	WF	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
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25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
25	25	150	38	25	53	
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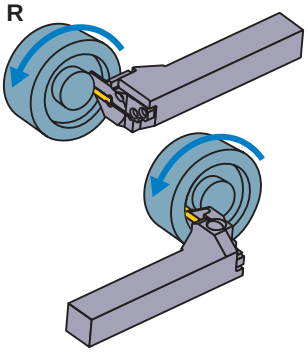
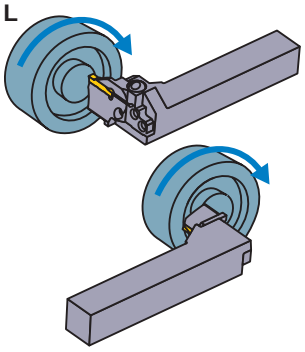
25	25	150	38	25	53	
25	25	150	38	25	53	

Cutting Mode

R



L



Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○–Breaker shown below
E	GY○○0239/0250/0274E○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	2.00mm	●	●	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

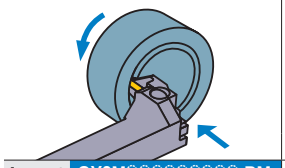
● : Standard insert with dimensions

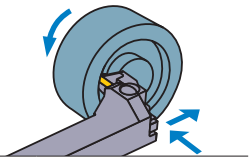
IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

GY SERIES (FACE GROOVING)

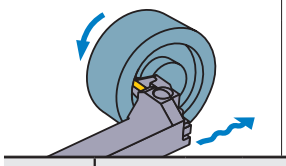
5 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM





Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

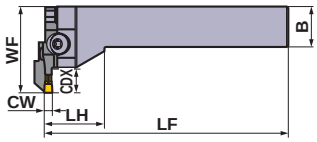


Fig. 1

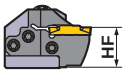


Fig. 2

Right hand tool holder shown.

Seat Size	Dimensions (mm)				Type	Hand (R/L)	Order Number				Fig.
	CW	DAXN	DAXX	CDX			Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	1
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-060	●	2
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	2
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	2
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	2
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	2
		225	999	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	1
				20 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *1					
H	B	LF	LH	HF	WF
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	59
25	25	150	38	25	59
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	59
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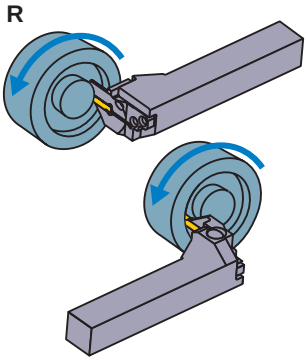
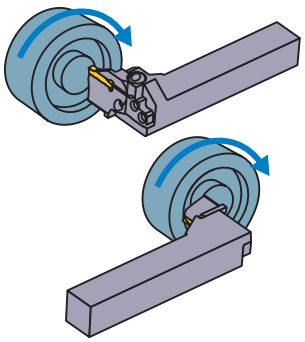
25	25	150	38	25	59
25	25	150	38	25	59
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	59
25	25	150	38	25	59
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	59
25	25	150	38	25	59
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	59
25	25	150	38	25	59

Cutting Mode

R



L



Insert selection

Seat Size	Geometry name
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

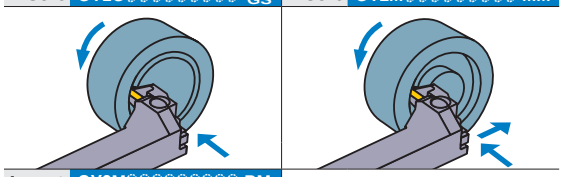
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

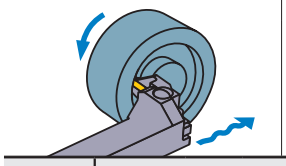
GY SERIES (FACE GROOVING)

5 90° type holder

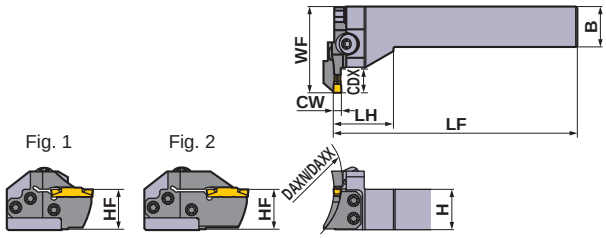
Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM



Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
G	4.00 4.24	40	50	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-040	●	1
		50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-050	●	1
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-060	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-060	●	2
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-085	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-085	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-085	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-085	●	2
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-125	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-125	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-125	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-125	●	2
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-180	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-180	●	2
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-250	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-250	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : Inventory maintained in Japan.

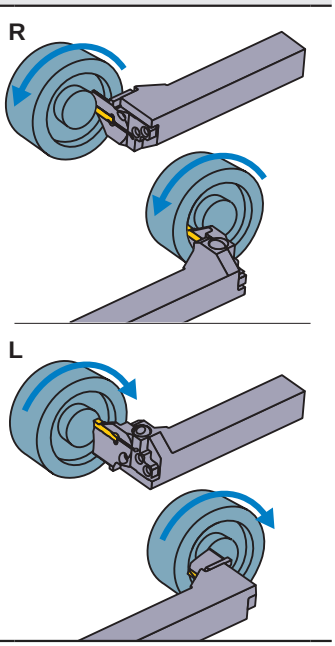
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *1					
H	B	LF	LH	HF	WF
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64

Cutting Mode



Insert selection

Seat Size	Geometry name
G	GY○○0400/0424G○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	4.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

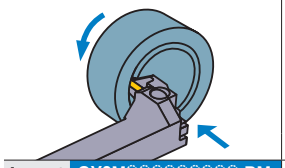
● : Standard insert with dimensions

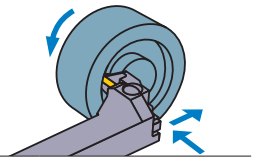
IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

GY SERIES (FACE GROOVING)

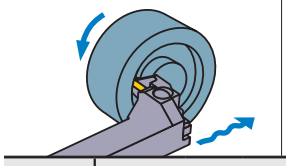
5 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM

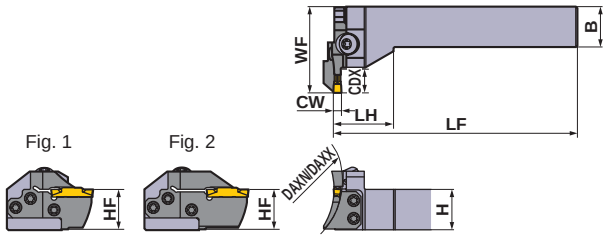




Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-050	●	1
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-060	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-060	●	2
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-085	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-085	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-085	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-085	●	2
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-125	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-125	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-125	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-125	●	2
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-180	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-180	●	2
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	2

CW = Cutting Width **DAXN** = Axial groove outside diameter minimum **DAXX** = Axial groove outside diameter maximum **CDX** = Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : **Inventory maintained in Japan.**

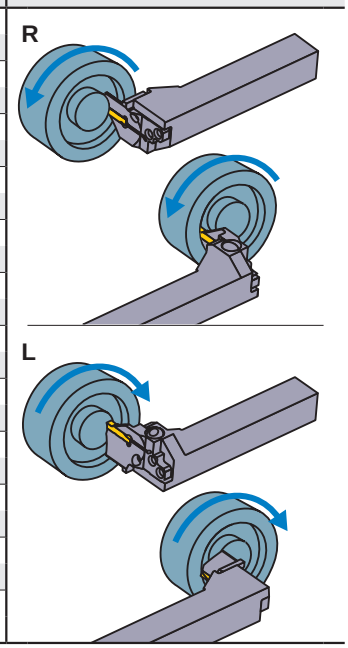
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *1					
H	B	LF	LH	HF	WF
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64

Cutting Mode



Insert selection

Seat Size	Geometry name
H	GY○○0475/0500/0524H○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

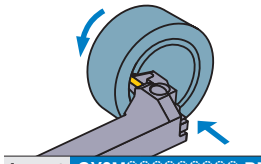
● : Standard insert with dimensions

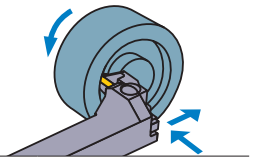
IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

GY SERIES (FACE GROOVING)

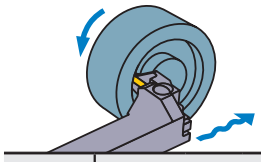
5 90° type holder

Insert	GY2M○○○○○○○○○○-GS GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○- GF GS	Insert	GY2M○○○○○○○○○○-MM





Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

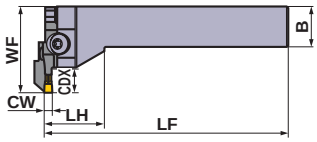


Fig. 1

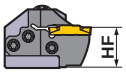


Fig. 2

Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	DAXN	DAXX	CDX	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-050	●	1
		70	110	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-070	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-070	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-070	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-070	●	2
		110	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-110	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-110	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-110	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-110	●	2
		170	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-170	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-170	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-170	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-170	●	2
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-250	●	1
				25 ⋆2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-250	●	2

CW = Cutting Width **DAXN =** Axial groove outside diameter minimum **DAXX =** Axial groove outside diameter maximum **CDX =** Max. Groove Depth

⋆1 Dimensions shown are when standard insert is used. If other insert geometries are used then **LF**, **LH** and **WF** values may vary.
⋆2 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F010—F012.

● : Inventory maintained in Japan.

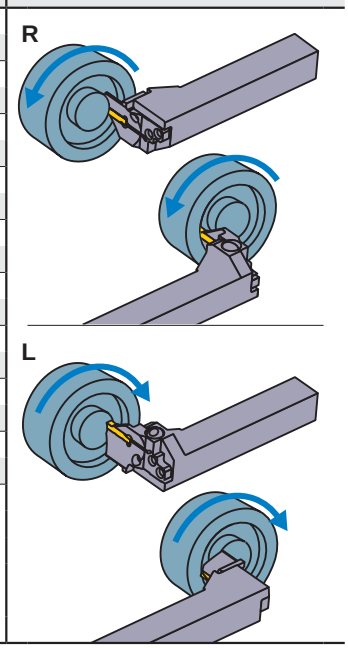
* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	Clamp Screw	Blade Screw (5 pcs.)	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

Dimensions (mm) *1					
H	B	LF	LH	HF	WF
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64
25	25	150	38	25	53
25	25	150	38	25	53
25	25	150	38	25	64
25	25	150	38	25	64

Cutting Mode



Insert selection

Seat Size	Geometry name
J	GY○○0600/0631/0635J○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	6.00mm	●	●	●	●
	6.35mm	●	●	●	

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

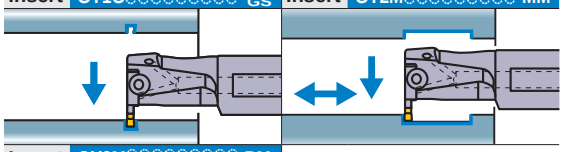
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F096
CAUTION FOR USE ➤ F098

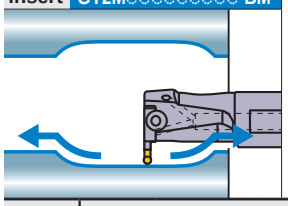
GY SERIES (INTERNAL GROOVING)

6 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM

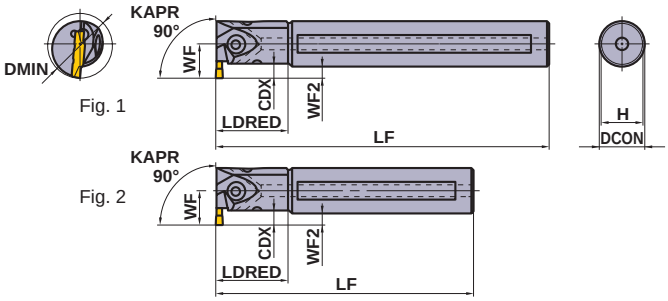


Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

●Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX ⋆3	DMIN	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
D	2.00 2.24	6	25	Mono Block	R	GYAR20K90A-D06	●	—	—	2
					L	GYAL20K90A-D06	●	—	—	2
				Mono Block	R	GYAR20Q90A-D06	●	—	—	1
					L	GYAL20Q90A-D06	●	—	—	1
			32	Mono Block	R	GYAR25K90B-D06	●	—	—	2
					L	GYAL25K90B-D06	●	—	—	2
				Mono Block	R	GYAR25R90B-D06	●	—	—	1
					L	GYAL25R90B-D06	●	—	—	1
		4—9.5 ⋆1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-D10	●	4
					L	GYDL32L90C-M20R	●	GYM20RA-D10	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-D10	●	3
					L	GYDL32S90C-M20R	●	GYM20RA-D10	●	3
		5.5—9.5 ⋆1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-D10	●	4
					L	GYDL40M90D-M20R	●	GYM20RA-D10	●	4
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-D10	●	3
					L	GYDL40T90D-M20R	●	GYM20RA-D10	●	3
		7—11.5 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-D12	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-D12	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-D12	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-D12	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-D12	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-D12	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-D12	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-D12	●	3

CW = Cutting Width **CDX =** Max. Groove Depth **DMIN =** Minimum cutting diameter

⋆1 The maximum groove depth (**CDX**) varies according to the cutting diameter (**DMIN**). For details, please refer to page F102.
⋆2 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF, LDRED, WF** and **WF2** values may vary.
⋆3 The maximum groove depth (**CDX**) is a value within the dimension **LDRED**.

● : Inventory maintained in Japan.

●Modular blade type (Air / coolant through)

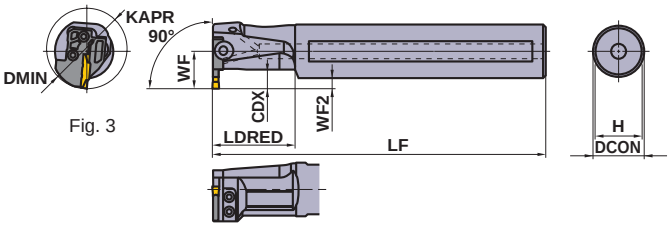


Fig. 3

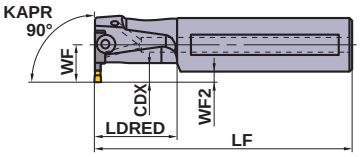


Fig. 4

Right hand tool holder shown.

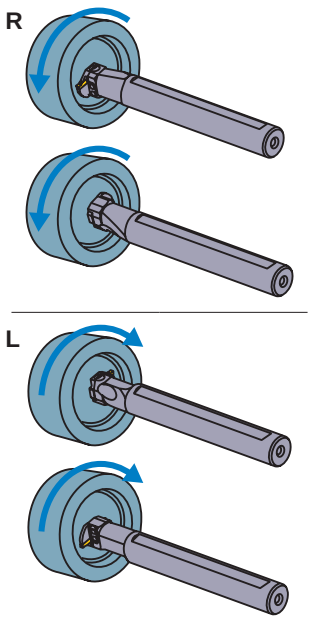
⋆ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	① ② Clamp Screw	4 pcs. Blade Screw	① ② Wrench ⋆
GYAR/L20○90A-○06	①GY05016S (Clamp Torque : 5.0N·m)	–	①TKY20R
GYAR/L25○90B-○06			
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R			
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R			

Dimensions (mm) ⋆2					
DCON	LF	LDRED	WF	WF2	H
20	125	30	14.5	4.5	18
20	125	30	14.5	4.5	18
20	180	30	14.5	4.5	18
20	180	30	14.5	4.5	18
25	125	40	19	6.5	23
25	125	40	19	6.5	23
25	200	40	19	6.5	23
25	200	40	19	6.5	23
32	140	50	22	6	30
32	140	50	22	6	30
32	250	50	22	6	30
32	250	50	22	6	30
40	150	60	28	8	37
40	150	60	28	8	37
40	300	60	28	8	37
40	300	60	28	8	37
40	150	60	28	8	37
40	150	60	28	8	37
40	300	60	28	8	37
40	300	60	28	8	37
50	170	80	34	9	47
50	170	80	34	9	47
50	300	80	34	9	47
50	300	80	34	9	47

Cutting Mode



Insert selection

Seat Size	Geometry name
D	GY○○0200/0224D○○○○–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	2.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying) Ball nose
D	2.00mm	●	●	●	●
	2.24mm	●			

● : Standard insert with dimensions

F

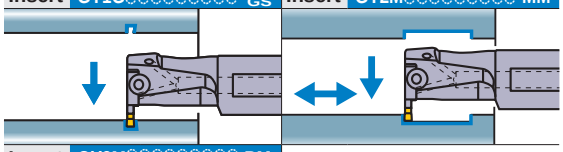
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F102
CAUTION FOR USE ➤ F104

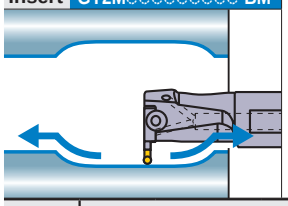
GY SERIES (INTERNAL GROOVING)

6 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM

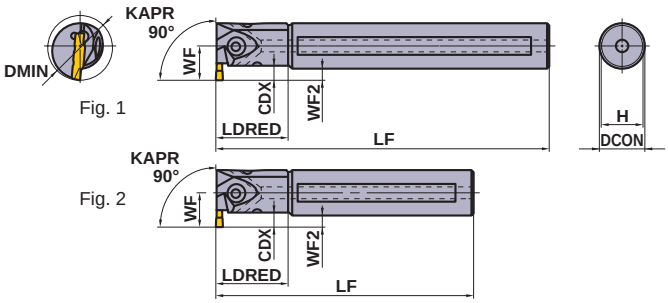


Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

●Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX ⋆3	DMIN	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
E	2.39 2.50 2.74	6	25	Mono Block	R	GYAR20K90A-E06	●	—	—	2
					L	GYAL20K90A-E06	●	—	—	2
				Mono Block	R	GYAR20Q90A-E06	●	—	—	1
					L	GYAL20Q90A-E06	●	—	—	1
			32	Mono Block	R	GYAR25K90B-E06	●	—	—	2
					L	GYAL25K90B-E06	●	—	—	2
				Mono Block	R	GYAR25R90B-E06	●	—	—	1
					L	GYAL25R90B-E06	●	—	—	1
		4—9.5 ⋆1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-E10	●	4
					L	GYDL32L90C-M20R	●	GYM20RA-E10	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-E10	●	3
					L	GYDL32S90C-M20R	●	GYM20RA-E10	●	3
		5.5—9.5 ⋆1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-E10	●	4
					L	GYDL40M90D-M20R	●	GYM20RA-E10	●	4
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-E10	●	3
					L	GYDL40T90D-M20R	●	GYM20RA-E10	●	3
		7—11.5 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-E12	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-E12	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-E12	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-E12	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-E12	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-E12	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-E12	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-E12	●	3

CW = Cutting Width **CDX =** Max. Groove Depth **DMIN =** Minimum cutting diameter

⋆1 The maximum groove depth (**CDX**) varies according to the cutting diameter (**DMIN**). For details, please refer to page F102.
⋆2 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF, LDRED, WF** and **WF2** values may vary.
⋆3 The maximum groove depth (**CDX**) is a value within the dimension **LDRED**.

● : **Inventory maintained in Japan.**

●Modular blade type (Air / coolant through)

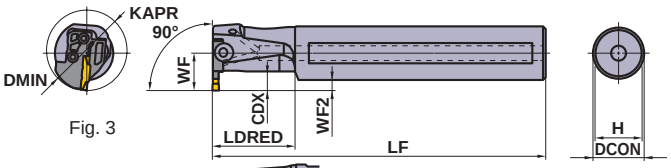


Fig. 3

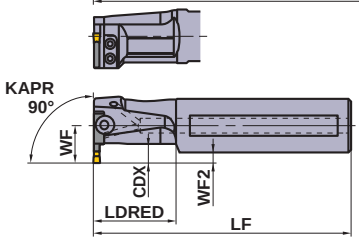


Fig. 4

Right hand tool holder shown.

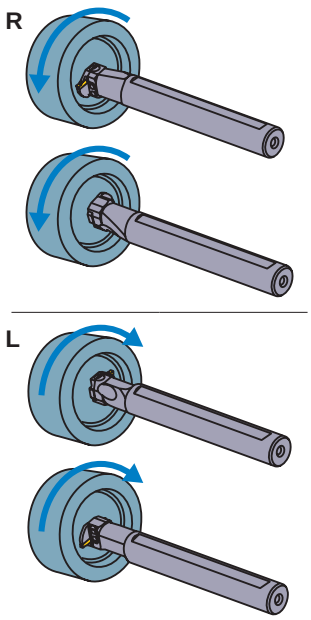
⋆ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	① ② Clamp Screw	4 pcs. Blade Screw	① ② Wrench ⋆
GYAR/L20◌90A-◌06	①GY05016S (Clamp Torque : 5.0N·m)	–	①TKY20R
GYAR/L25◌90B-◌06			
GYDR/L32◌90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYDR/L40◌90D-M20L/R			
GYDR/L40◌90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYDR/L50◌90F-M25L/R			

Dimensions (mm) ⋆2					
DCON	LF	LDRED	WF	WF2	H
20	125	30	14.5	4.5	18
20	125	30	14.5	4.5	18
20	180	30	14.5	4.5	18
20	180	30	14.5	4.5	18
25	125	40	19	6.5	23
25	125	40	19	6.5	23
25	200	40	19	6.5	23
25	200	40	19	6.5	23
32	140	50	22	6	30
32	140	50	22	6	30
32	250	50	22	6	30
32	250	50	22	6	30
40	150	60	28	8	37
40	150	60	28	8	37
40	300	60	28	8	37
40	300	60	28	8	37
40	150	60	28	8	37
40	150	60	28	8	37
40	300	60	28	8	37
40	300	60	28	8	37
50	170	80	34	9	47
50	170	80	34	9	47
50	300	80	34	9	47
50	300	80	34	9	47

Cutting Mode



Insert selection

Seat Size	Geometry name
E	GY◌◌0239/0250/0274E◌◌◌◌–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball nose
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Standard insert with dimensions

F

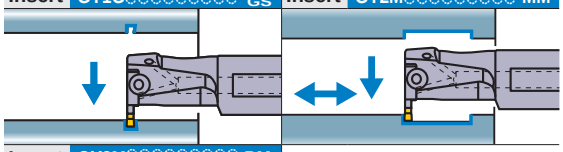
GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F102
CAUTION FOR USE ➤ F104

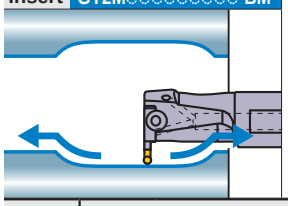
GY SERIES (INTERNAL GROOVING)

6 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM

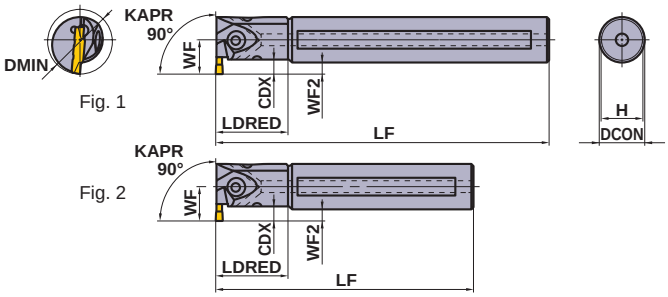


Insert	GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

●Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX ⋆3	DMIN	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
F	3.00 3.18 3.24	6	25	Mono Block	R	GYAR20K90A-F06	●	—	—	2
					L	GYAL20K90A-F06	●	—	—	2
				Mono Block	R	GYAR20Q90A-F06	●	—	—	1
					L	GYAL20Q90A-F06	●	—	—	1
			32	Mono Block	R	GYAR25K90B-F06	●	—	—	2
					L	GYAL25K90B-F06	●	—	—	2
				Mono Block	R	GYAR25R90B-F06	●	—	—	1
					L	GYAL25R90B-F06	●	—	—	1
		4—9.5 ⋆1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	4
					L	GYDL32L90C-M20R	●	GYM20RA-F10	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	3
					L	GYDL32S90C-M20R	●	GYM20RA-F10	●	3
		5.5—9.5 ⋆1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	4
					L	GYDL40M90D-M20R	●	GYM20RA-F10	●	4
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-F10	●	3
					L	GYDL40T90D-M20R	●	GYM20RA-F10	●	3
		7—11.5 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-F12	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-F12	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-F12	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-F12	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-F12	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-F12	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-F12	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-F12	●	3
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	2
					L	GYAL25K90B-G07	●	—	—	2
				Mono Block	R	GYAR25R90B-G07	●	—	—	1
					L	GYAL25R90B-G07	●	—	—	1
		4.5—11.5 ⋆1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	4
					L	GYDL32L90C-M20R	●	GYM20RA-G12	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-G12	●	3
					L	GYDL32S90C-M20R	●	GYM20RA-G12	●	3
		6—11.5 ⋆1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	4
					L	GYDL40M90D-M20R	●	GYM20RA-G12	●	4
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	3
					L	GYDL40T90D-M20R	●	GYM20RA-G12	●	3
		7.5—13 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-G14	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-G14	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-G14	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-G14	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-G14	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-G14	●	3

CW = Cutting Width **CDX =** Max. Groove Depth **DMIN =** Minimum cutting diameter

⋆1 The maximum groove depth (**CDX**) varies according to the cutting diameter (**DMIN**). For details, please refer to page F102.
⋆2 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF, LDRED, WF** and **WF2** values may vary.
⋆3 The maximum groove depth (**CDX**) is a value within the dimension **LDRED**.

● : Inventory maintained in Japan.

●Modular blade type (Air / coolant through)

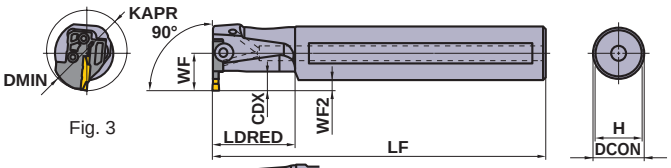


Fig. 3

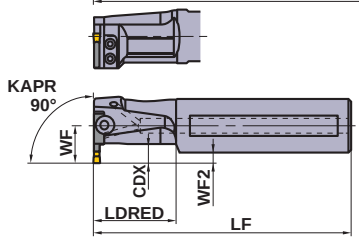


Fig. 4

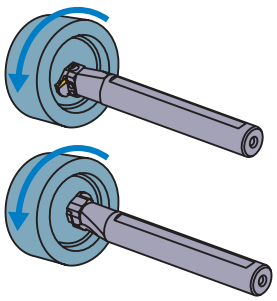
Right hand tool holder shown.

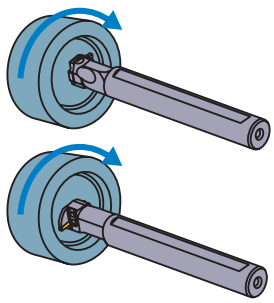
⋆ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	① ② Clamp Screw	4 pcs. Blade Screw	① ② Wrench ⋆
GYAR/L20◌90A-F06	①GY05016S (Clamp Torque : 5.0N·m)	–	①TKY20R
GYAR/L25◌90B-◌◌◌			
GYDR/L32◌90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYDR/L40◌90D-M20L/R			
GYDR/L40◌90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYDR/L50◌90F-M25L/R			

Dimensions (mm) ⋆2						Cutting Mode
DCON	LF	LDRED	WF	WF2	H	
20	125	30	14.5	4.5	18	R
20	125	30	14.5	4.5	18	
20	180	30	14.5	4.5	18	
20	180	30	14.5	4.5	18	
25	125	40	19	6.5	23	
25	125	40	19	6.5	23	
25	200	40	19	6.5	23	
25	200	40	19	6.5	23	
32	140	50	22	6	30	
32	140	50	22	6	30	
32	250	50	22	6	30	
32	250	50	22	6	30	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
50	170	80	34	9	47	
50	170	80	34	9	47	
50	300	80	34	9	47	
50	300	80	34	9	47	
25	125	40	19	6.5	23	L
25	125	40	19	6.5	23	
25	200	40	19	6.5	23	
25	200	40	19	6.5	23	
32	140	50	22	6	30	
32	140	50	22	6	30	
32	250	50	22	6	30	
32	250	50	22	6	30	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
50	170	80	34	9	47	
50	170	80	34	9	47	
50	300	80	34	9	47	
50	300	80	34	9	47	





Insert selection

Seat Size	Geometry name
F	GY◌◌0300/0318/0324F◌◌◌◌–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball nose
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

Seat Size	Geometry name
G	GY◌◌0400/0424G◌◌◌◌–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	Breaker / CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	4.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	Breaker / CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball nose
G	4.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8	●		●	
	4.24mm	●			

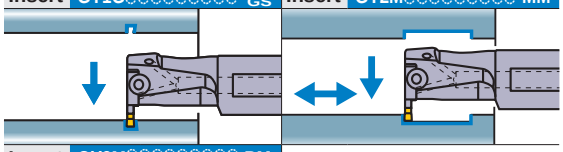
● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F102
CAUTION FOR USE ➤ F104

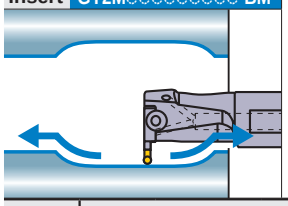
GY SERIES (INTERNAL GROOVING)

6 90° type holder

Insert	GY1M/2M○○○○○○○○○○-GM	Insert	GY2G○○○○○○○○○○-MF
Insert	GY2M○○○○○○○○○○-GS/GU	Insert	GY2M○○○○○○○○○○-MS
Insert	GY1G○○○○○○○○○○-GF/GS	Insert	GY2M○○○○○○○○○○-MM

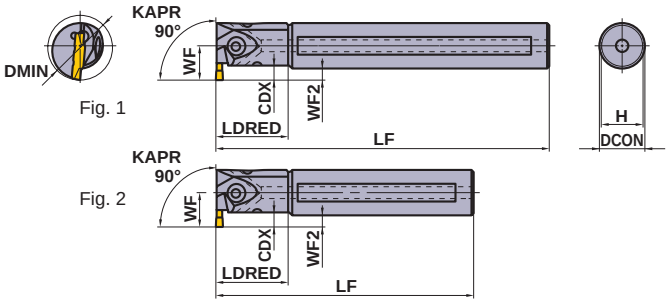


Insert GY2M○○○○○○○○○○-BM



Note 1) Please order the modular blade and modular holder separately.
Note 2) Please set the left hand modular blade at the right hand holder and the right hand modular blade at the left hand holder.

●Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	Dimensions (mm) CW	CDX ⋆3	DMIN	Type	Hand (R/L)	Order Number Holder	Stock	Modular Blade	Stock	Fig.
H	4.75 5.00 5.24	7	32	Mono Block	R	GYAR25K90B-H07	●	—	—	2
					L	GYAL25K90B-H07	●	—	—	2
				Mono Block	R	GYAR25R90B-H07	●	—	—	1
					L	GYAL25R90B-H07	●	—	—	1
		4.5—11.5 ⋆1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-H12	●	4
					L	GYDL32L90C-M20R	●	GYM20RA-H12	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-H12	●	3
					L	GYDL32S90C-M20R	●	GYM20RA-H12	●	3
		6—11.5 ⋆1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-H12	●	4
					L	GYDL40M90D-M20R	●	GYM20RA-H12	●	4
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-H12	●	3
					L	GYDL40T90D-M20R	●	GYM20RA-H12	●	3
		7.5—13 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-H14	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-H14	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-H14	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-H14	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-H14	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-H14	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-H14	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-H14	●	3
J	6.00 6.31 6.35	7.5—13 ⋆1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-J14	●	4
					L	GYDL40M90D-M25R	●	GYM25RA-J14	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-J14	●	3
					L	GYDL40T90D-M25R	●	GYM25RA-J14	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-J14	●	4
					L	GYDL50P90F-M25R	●	GYM25RA-J14	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-J14	●	3
					L	GYDL50T90F-M25R	●	GYM25RA-J14	●	3

CW = Cutting Width **CDX =** Max. Groove Depth **DMIN =** Minimum cutting diameter

⋆1 The maximum groove depth (**CDX**) varies according to the cutting diameter (**DMIN**). For details, please refer to page F102.
⋆2 Dimensions shown are when the standard insert is used. If other insert geometries are used then **LF, LDRED, WF** and **WF2** values may vary.
⋆3 The maximum groove depth (**CDX**) is a value within the dimension **LDRED**.

● : **Inventory maintained in Japan.**

●Modular blade type (Air / coolant through)

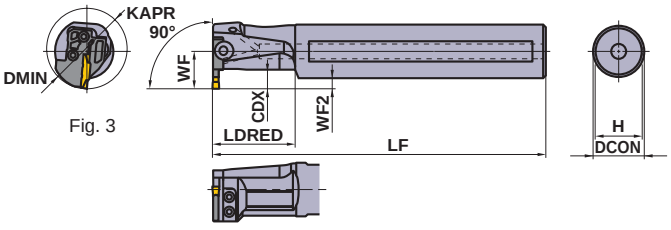


Fig. 3

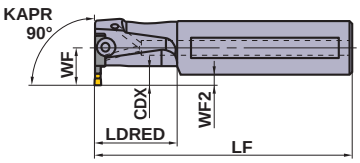


Fig. 4

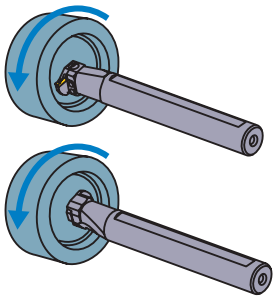
Right hand tool holder shown.

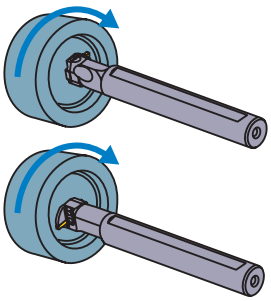
⋆ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder	① ② Clamp Screw	4 pcs. Blade Screw	① ② Wrench ⋆
GYAR/L25◌90B-◌07	①GY05016S (Clamp Torque : 5.0N·m)	–	①TKY20R
GYDR/L32◌90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYDR/L40◌90D-M20L/R			
GYDR/L40◌90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYDR/L50◌90F-M25L/R			

Dimensions (mm) ⋆2						Cutting Mode
DCON	LF	LDRED	WF	WF2	H	
25	125	40	19	6.5	23	R
25	125	40	19	6.5	23	
25	200	40	19	6.5	23	
25	200	40	19	6.5	23	
32	140	50	22	6	30	
32	140	50	22	6	30	
32	250	50	22	6	30	
32	250	50	22	6	30	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
40	150	60	28	8	37	
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
50	170	80	34	9	47	
50	170	80	34	9	47	
50	300	80	34	9	47	
50	300	80	34	9	47	
40	150	60	28	8	37	L
40	150	60	28	8	37	
40	300	60	28	8	37	
40	300	60	28	8	37	
50	170	80	34	9	47	
50	170	80	34	9	47	
50	300	80	34	9	47	
50	300	80	34	9	47	





Insert selection

Seat Size	Geometry name
H	GY◌◌0475/0500/0524H◌◌◌◌–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball nose
H	4.75mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			
	5.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	5.24mm	●			

Seat Size	Geometry name
J	GY◌◌0600/0631/0635J◌◌◌◌–Breaker shown below

For grooving/cutting off breaker ➤ F010, F011

Seat Size	CW \ Breaker	GU (For gummy steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	6.00mm	●	●	●	
	6.35mm	●	●	●	

For multifunctional grooving breaker ➤ F011, F012

Seat Size	CW \ Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball nose
J	6.00mm				●
	RE 0.2	●			
	RE 0.4	●	●	●	
	RE 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	RE 0.2	●			
	RE 0.4	●			
	RE 0.8	●			

● : Standard insert with dimensions

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F102
CAUTION FOR USE ➤ F104

RECOMMENDED CUTTING SPEED [For External Grooving / Cutting Off]

	Work Material	Hardness	Grade	Cutting Speed vc (m/min)
P	Mild Steel	≤160HB	VP20RT	100–220
			VP10RT	110–230
			NX2525	90–210
	Carbon Steel Alloy Steel	160–280HB	VP20RT	80–180
			VP10RT	90–190
			MY5015	110–250
			NX2525	70–170
		280HB≤	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
			NX2525	55–135
M	Stainless Steel	≤270HB	VP20RT	60–140
			VP10RT	70–150
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	80–180
			VP10RT	90–190
			MY5015	140–300
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
S	Heat Resistant Alloy Titanium Alloy	–	VP20RT	30–60
			VP10RT	40–70
			RT9010	40–70
H	Hardened Steel	50HRC≤	BC8110	80–120
			MB8025	80–120

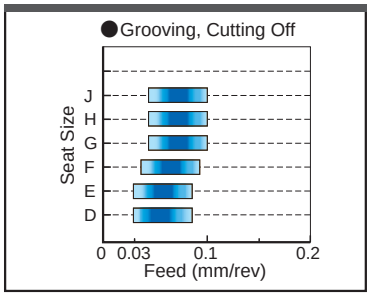
Note 1) **VP20RT** is the first recommended grade for materials other than hardened steel.
Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For External Grooving / Cutting Off]

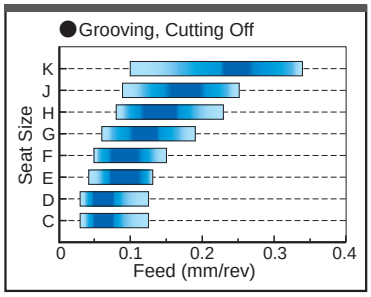
Recommended cutting conditions when combining a GYHR/L2525M00/90-M24R/L modular holder and GYM25R/LA-○○○ modular blade.

■ Recommended feed rate and depth of cut

GU BREAKER



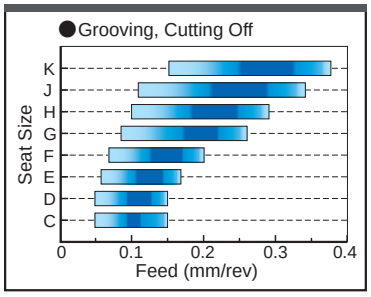
GS BREAKER



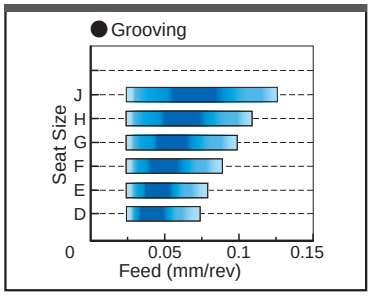
: 1st recommended area

Seat Size	Insert Width (mm)
C	1.50
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35
K	8.00

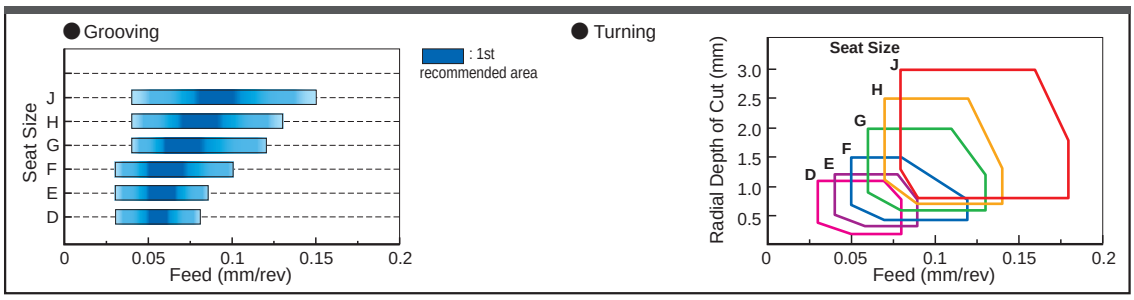
GM BREAKER



FLAT TOP GFGS (CBN)

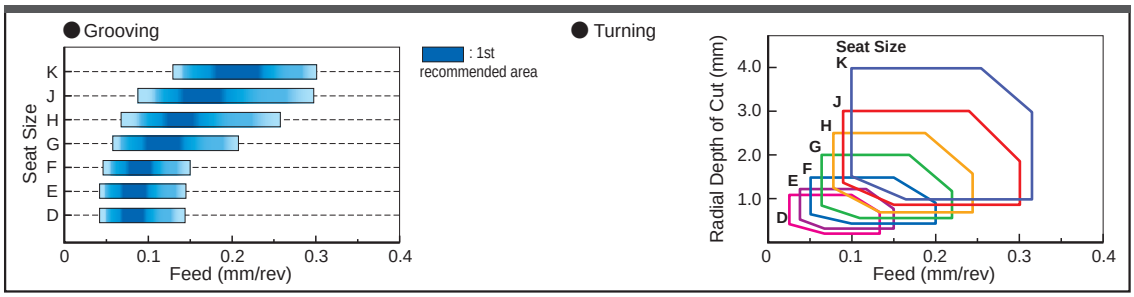


MF BREAKER

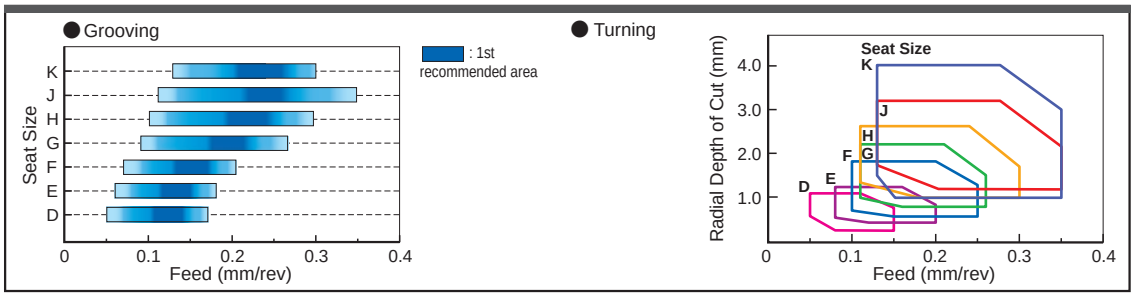


	Seat Size Insert Width (mm)
C	1.50
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35
K	8.00

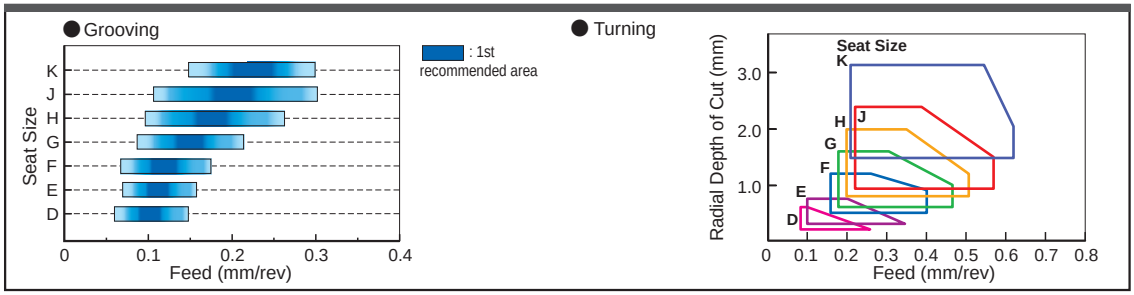
MS BREAKER



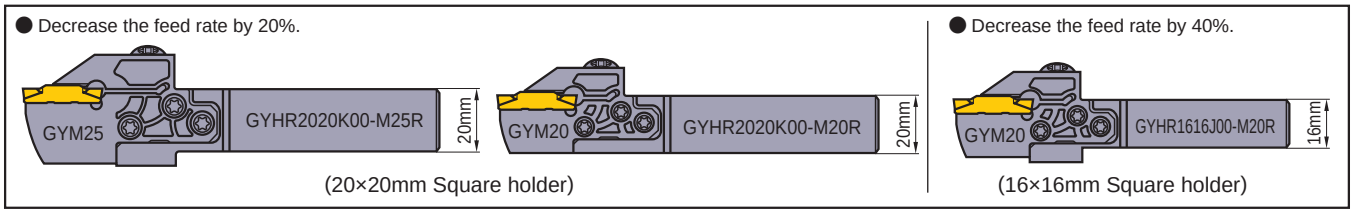
MM BREAKER



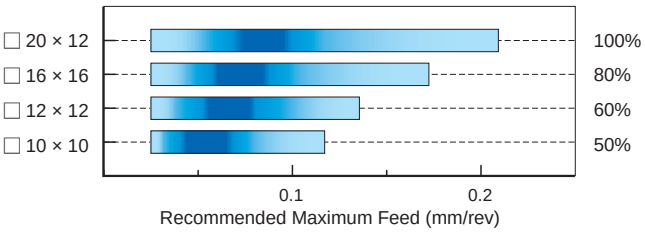
BM BREAKER



Note 1) Lower the recommended cutting speed given in the table by 20% and 40% respectively when combining the following modular holders and modular blades.



■ In the case of mono block type holder for Swiss style lathes

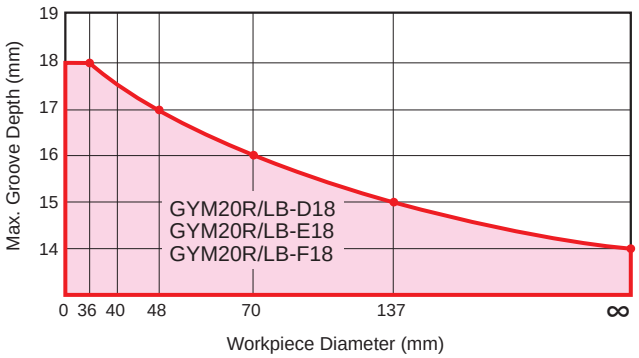


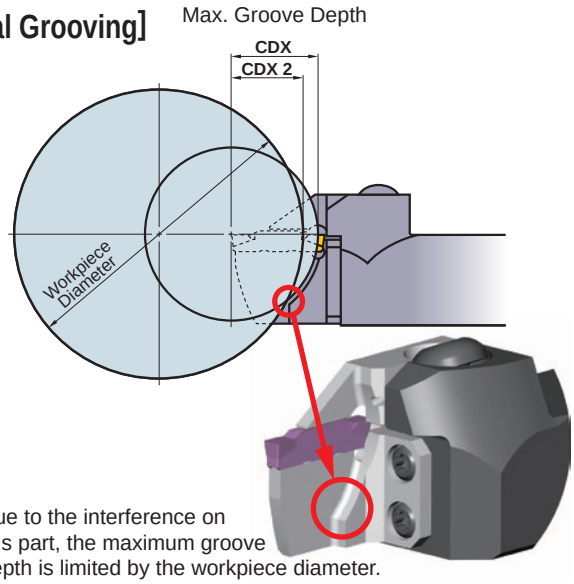
Please refer to the tables above on recommended cutting conditions for external grooving and cutting off.
Apply the percentage ratio shown on each shank size with the values in the table.

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•When using the modular blade GYM○○R/LA-○○○
The maximum groove depth is not limited by the workpiece diameter.

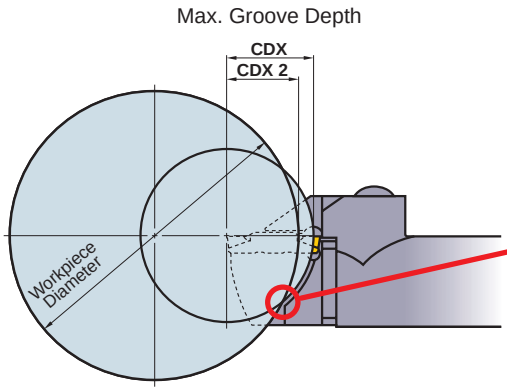
•When using the modular blade GYM○○R/LB-○○○
The maximum groove depth is limited by the workpiece diameter.



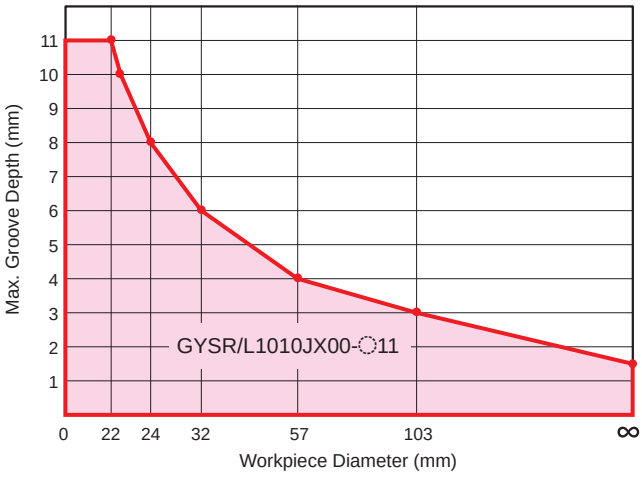


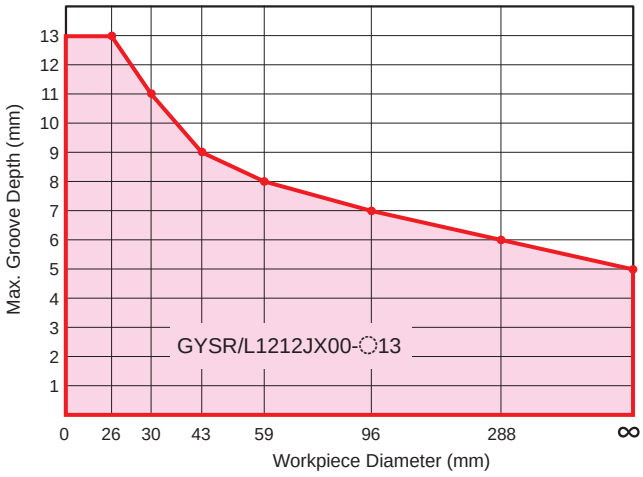
Due to the interference on this part, the maximum groove depth is limited by the workpiece diameter.

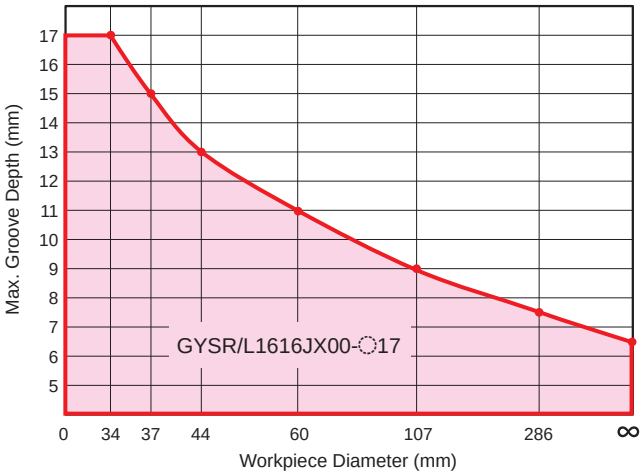
•In the case of mono block type holder for Swiss style lathes
The maximum groove depth is limited by the workpiece diameter.

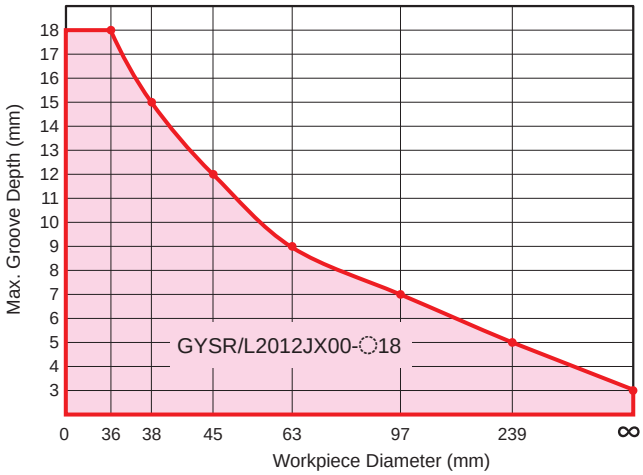


Due to interference, the maximum groove depth is limited by the workpiece diameter.







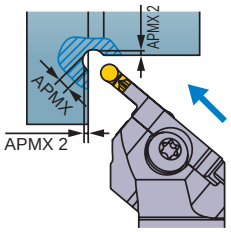


RECOMMENDED CUTTING SPEED [For External Recessing]

	Work Material	Hardness	Grade	Cutting Speed vc (m/min) 50 100 150 200 250
P	Mild Steel	≤180HB	VP20RT	80–180
			VP10RT	90–190
	Carbon Steel Alloy Steel	180–280HB	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
			NX2525	55–135
	Carbon Steel Alloy Steel	280–350HB	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
			NX2525	45–105
M	Stainless Steel	≤350HB	VP20RT	50–110
			VP10RT	60–120
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
S	Titanium Alloy	–	VP20RT	30–60
			VP10RT	40–70
	Heat Resistant Alloy	–	VP20RT	30–60
			VP10RT	40–70

Note 1) VP20RT is the first recommended grade for materials other than hardened steel.
Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

DISTANCE FROM WORK SURFACE TO RECESS DEPTH

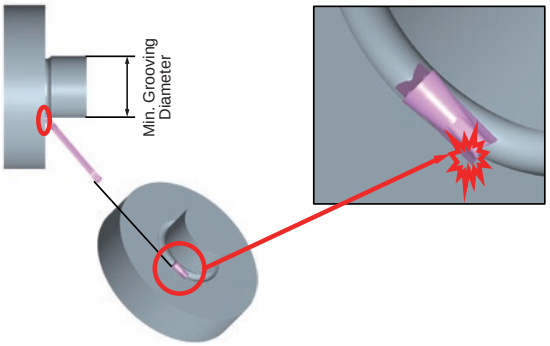


Cutting Width CW (mm)	Recess Depth APMX (mm)	Distance from Work Surface to Recess Depth APMX 2 (mm)
2.00	1.50	0.646
2.50	1.75	0.720
3.00	2.00	0.793
3.18	2.09	0.819
4.00	2.50	0.939
4.75	2.88	1.049
5.00	3.00	1.086
6.00	3.50	1.232
6.35	3.68	1.283

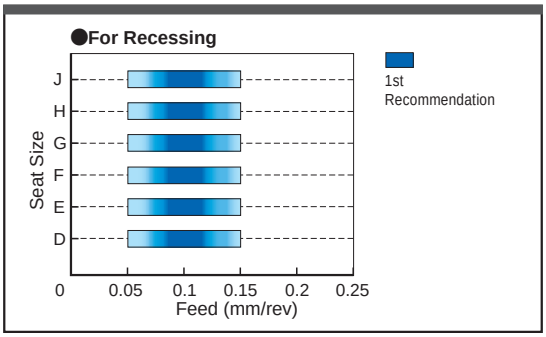
BM BREAKER

Minimum grooving diameter

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter as shown in the table on the “page number” to avoid a collision with the workpiece shown below.



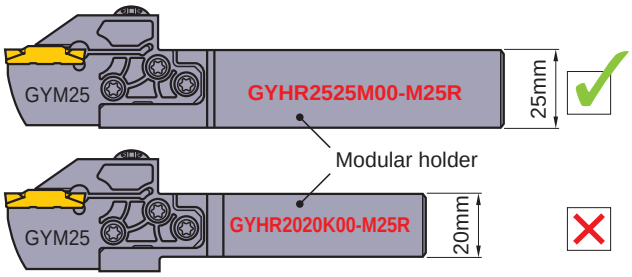
■Recommended feed rate and depth of cut



TOOL SELECTION

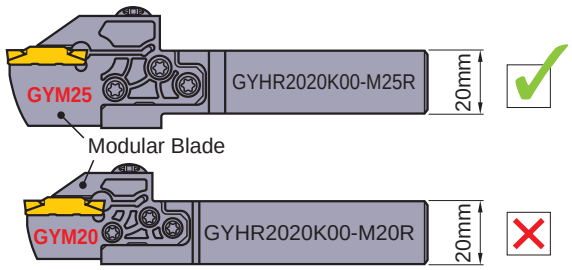
Notes when selecting the tool body

Precautions when selecting a modular holder.



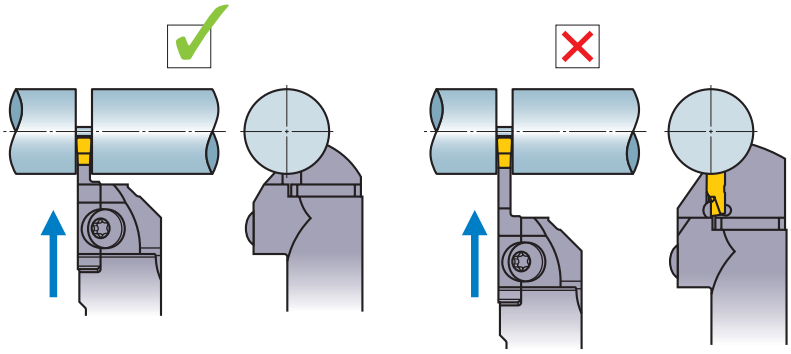
●Select a modular holder with the largest possible shank size to maintain mounting rigidity.

Modular blade (1)



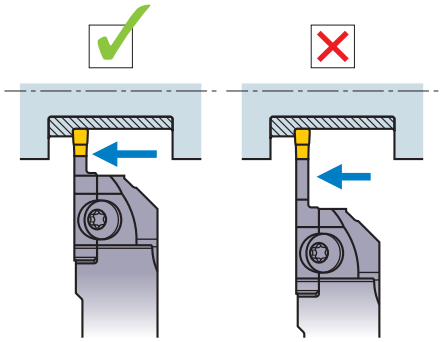
●If there is no restriction for use, select the largest modular blade for the same shank size.

Modular blade (2)



●Select the shortest possible blade suitable for the application.

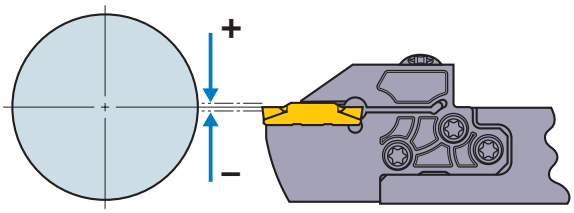
Modular blade (3)



●Select the shortest possible blade suitable for the application.

Notes when setting the tool

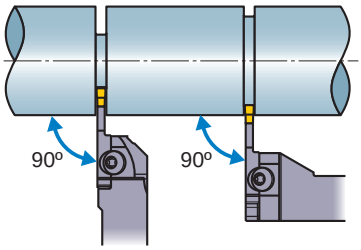
Setting of cutting edge height



<Grooving/Cross-feed machining>
Set the cutting edge height to ±0.1mm parallel to the central axis.

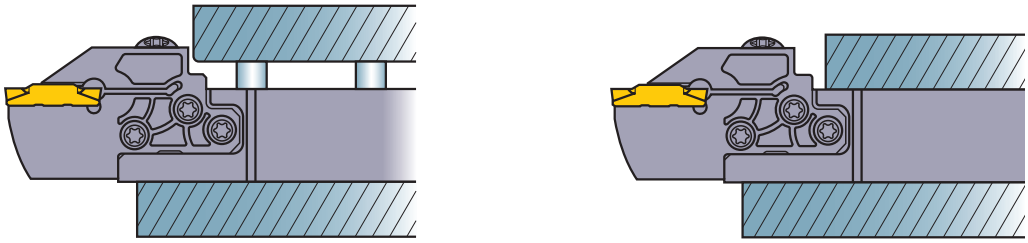
<Cutting off>
Set the cutting edge height to 0–+0.2mm parallel to the central axis.

Tool body setting angle



●Set the insert perpendicular to the central axis.

Overhang

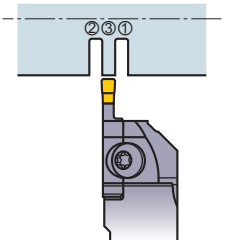


●When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

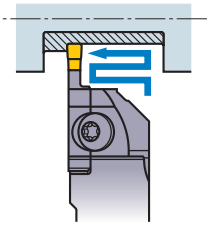
Notes on multi-functional machining (MF, MS and MM breakers)

Machining narrow grooves



●It is recommended to carry out plunging in several passes. Following the steps above makes it difficult for chips to elongate. This also improves the accuracy of workpiece wall surface.

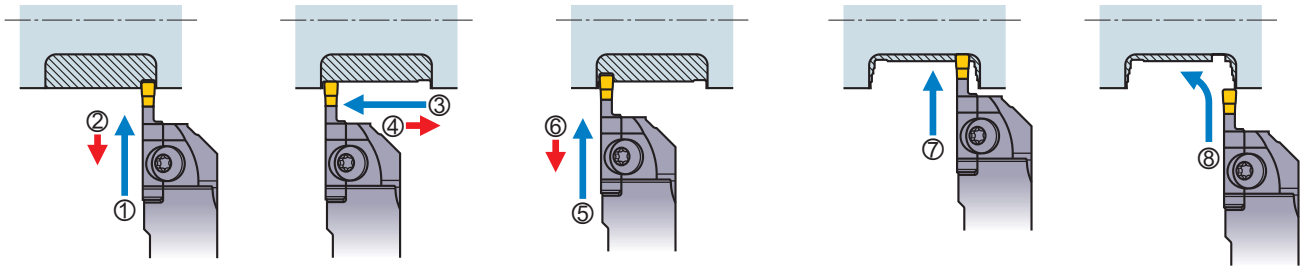
Machining wide grooves



●It is recommended that cross-feed machining is used.

Machining wide grooves

ROUGHING → FINISHING



①Carry out grooving.
②Retract the tool approx 0.1mm.

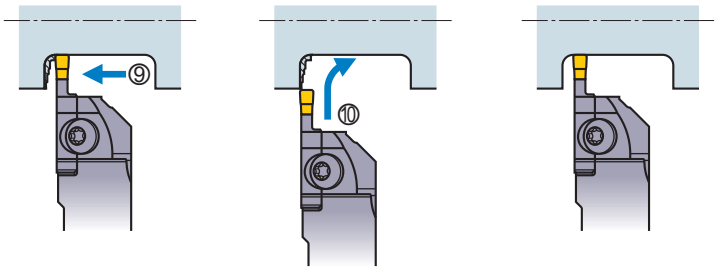
③Carry out cross feed machining.
④Retract the tool approx 0.1mm.

⑤Carry out grooving.
⑥Retract the tool approx 0.1mm.
* Repeat the steps ①–⑥.

⑦Carry out grooving to the end point of the corner radius.

⑧Machining of the wall surface, corner radius and bottom face should be carried out in one process.

FINISHING

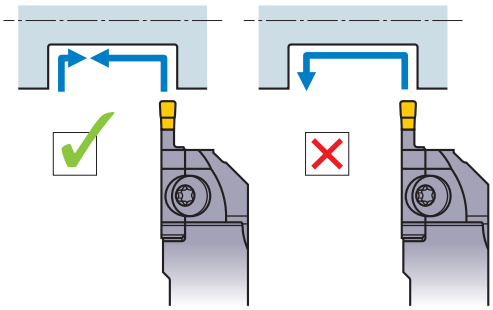


⑨Stop at the bottom of the corner radius.

⑩Machine the counter wall to the corner radius in one process.

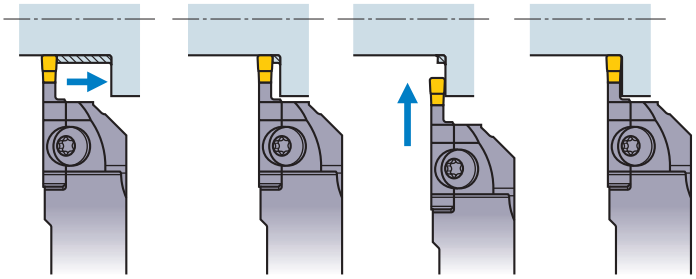
⑪Finish machining.

Precautions when finishing walls



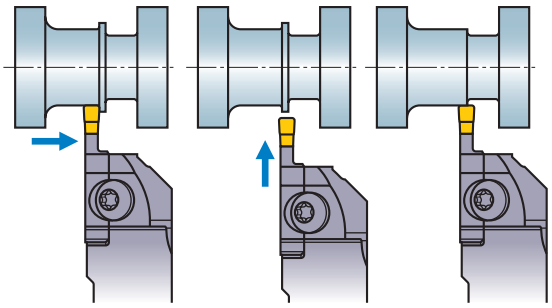
●To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

Wall machining



●When machining a wall, chip jamming can occur. In this case, stop cross feed machining just before the wall (at a point less than the insert width) then remove the remaining material by plunging.

Machining of a ring section

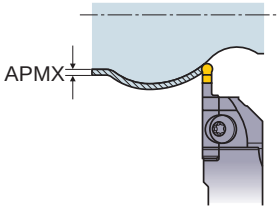


●When a ring remains in a cross feed end process, finish cross feed machining 1–1.5mm short of the end point, then remove the ring by plunging.

MACHINING RECOMMENDATIONS

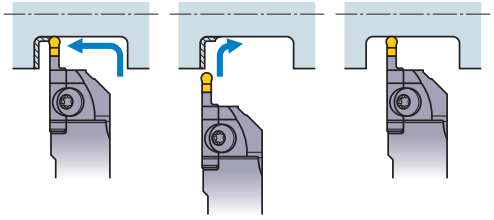
Notes on multi-functional machining (BM breaker)

Copying



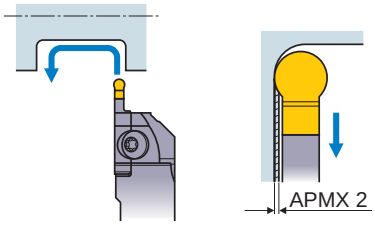
●With the BM breaker insert, 3 dimensional copying is possible.
Set the depth of cut (APMX) to 40% less than the insert width.

Roughing



●Use plunging and cross-feed machining.
When machining the corner, vibration is likely to occur.
To avoid this, reduce the feed by 50%.

Finishing



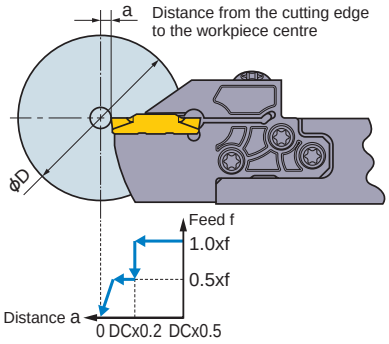
●Carry out finishing in one process.
For the depth of cut (APMX 2) when back turning, refer to the table on the right.

Insert	APMX 2 (mm)
GY2M0200D100N-BM	0.05
GY2M0250E125N-BM	0.10
GY2M0300F150N-BM	0.15
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.20
GY2M0475H238N-BM	0.24
GY2M0500H250N-BM	
GY2M0600J300N-BM	0.30
GY2M0635J318N-BM	
GY2M0800K400N-BM	0.40

Notes for cutting off

Feed

<Feed>

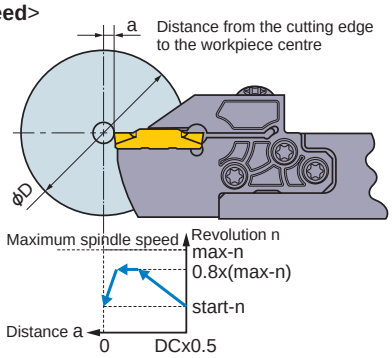


●When the cutting edge approaches the centre, reduce the feed by 50%.

●If necessary, stop the feed prior to reaching the centre of the workpiece to prevent it falling under its own weight.

Revolution

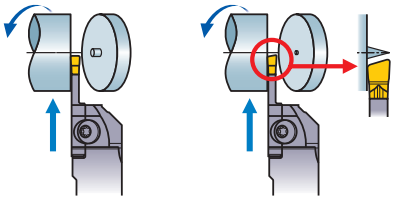
<Spindle speed>



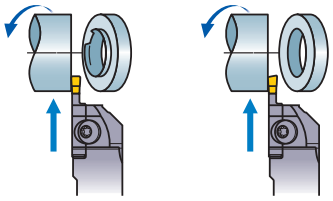
●When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80% of maximum to ensure stability.

●To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

Insert



Neutral insert　　Handed insert

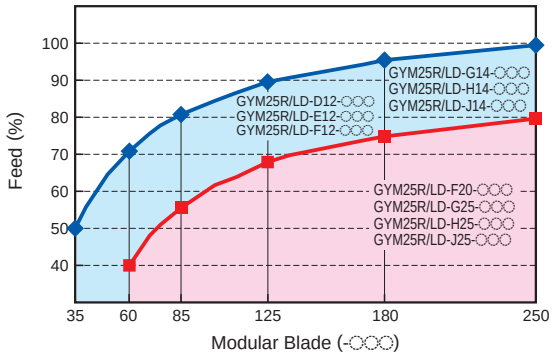


Neutral insert　　Handed insert

●When there is a centre stub on solid bar work or burrs are formed on pipe material, it is possible to decrease them by using a handed insert.
With a handed insert, machining tends to be less stable when compared to using a neutral insert.
Pay special attention to avoid fracturing of the cutting edge and decrease the feed when necessary.

Memo

RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION [For Face Grooving]



Note 1) Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

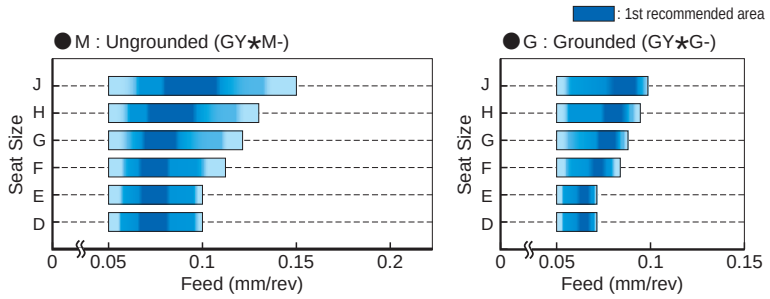
RECOMMENDED CUTTING SPEED [For Face Grooving]

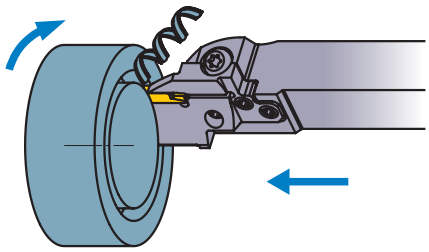
	Work Material	Hardness	Grade	Cutting Speed (m/min) 50–300
P	Mild Steel	≤160HB	VP20RT	80–180
			VP10RT	90–190
			NX2525	70–170
	Carbon Steel Alloy Steel	160–280HB	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
			NX2525	55–135
		280HB≤	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
			NX2525	45–105
M	Stainless Steel	≤270HB	VP20RT	50–110
			VP10RT	60–120
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
S	Heat Resistant Alloy Titanium Alloy	–	VP20RT	30–60
			VP10RT	40–70
			RT9010	40–70
H	Hardened Steel	50HRC≤	BC8110	60–120
			MB8025	60–120

Note 1) VP20RT is the first recommended grade for materials other than hardened steel.
Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

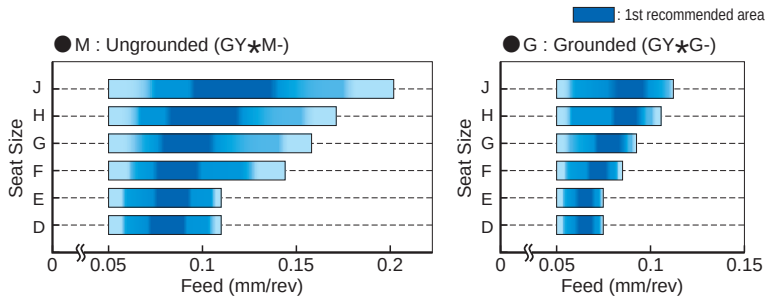
RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

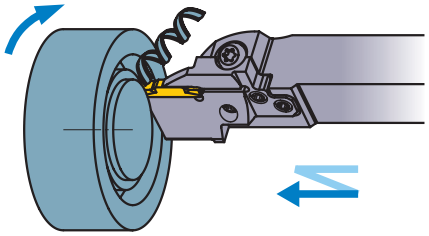
GROOVING





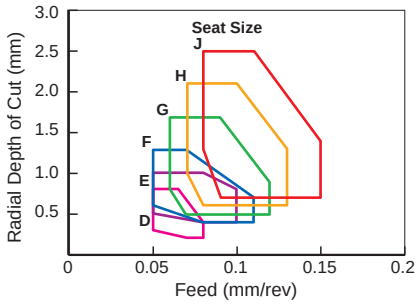
PLUNGING





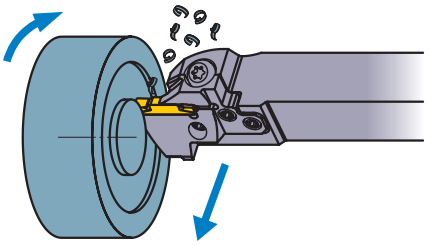
* After the 1st plunge, the width of cut should be set narrower than insert with CW.

TRAVERSE MACHINING (MF BREAKER)

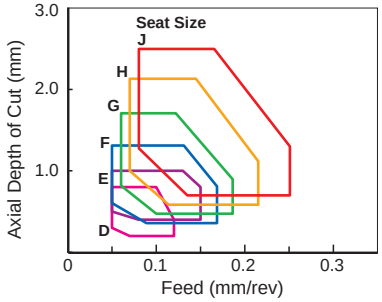


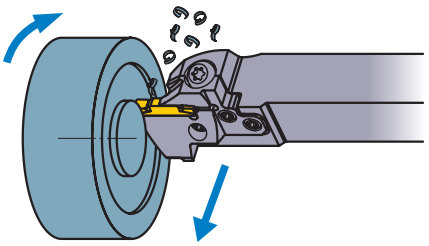
Seat Size	Insert Width (mm)
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24

Seat Size	Insert Width (mm)
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35

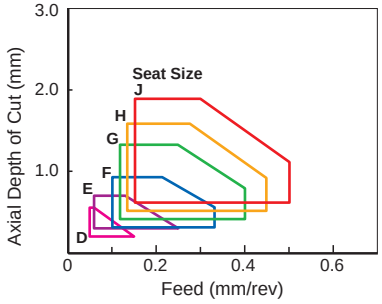


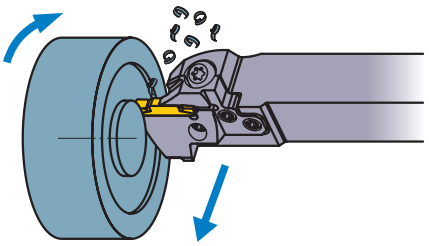
TRAVERSE MACHINING (MM/MS BREAKER)





TRAVERSE MACHINING (BM BREAKER)

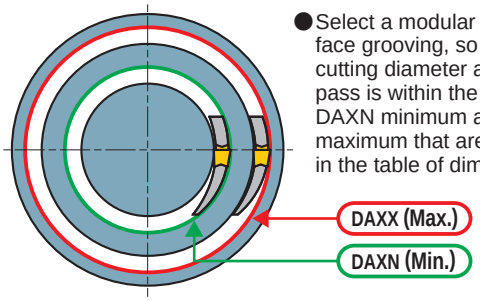




TOOL SELECTION

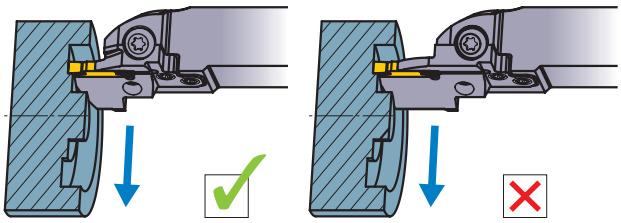
Notes when selecting the tool body

Modular blade (1)



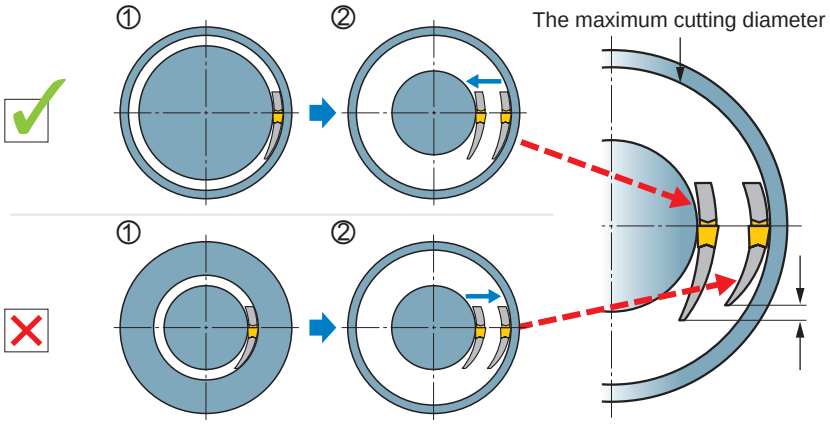
●Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of DAXN minimum and DAXX maximum that are described in the table of dimensions.

Modular blade (2)



●Select the shortest possible blade suitable for the application.

Modular blade (3)



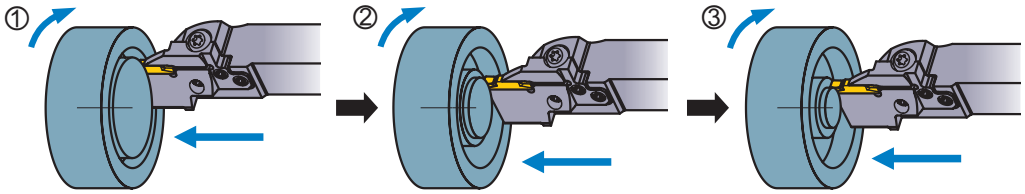
●Select the largest size blade within the maximum cutting diameter of the workpiece.

●Machine from the outer diameter towards the centre.

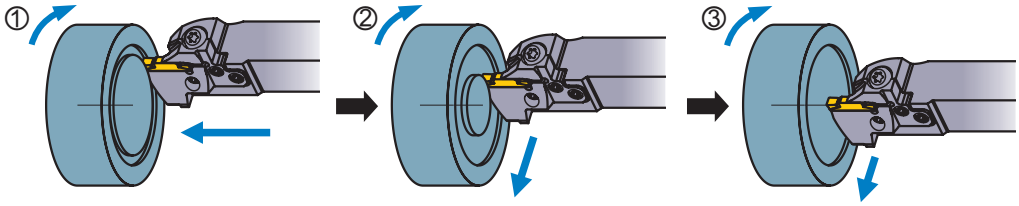
●Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

At first machine the maximum cutting diameter, there is no restriction in the cutting diameter on the remaining process.

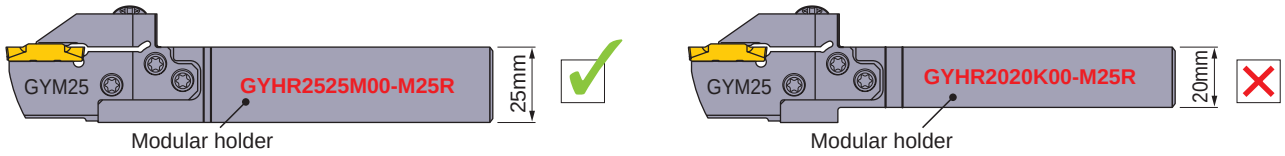
●When plunging in several passes.



●When combining plunging and infeed machining.



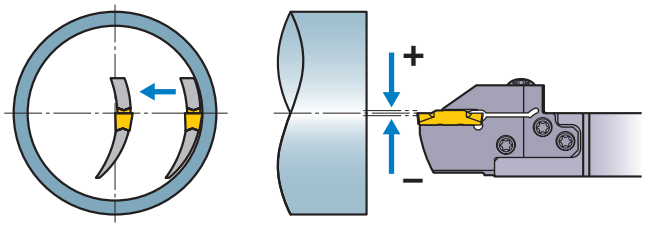
Precautions when selecting a modular holder.



●Select a modular holder with the largest possible shank size to maintain mounting rigidity.

Notes when setting the tool

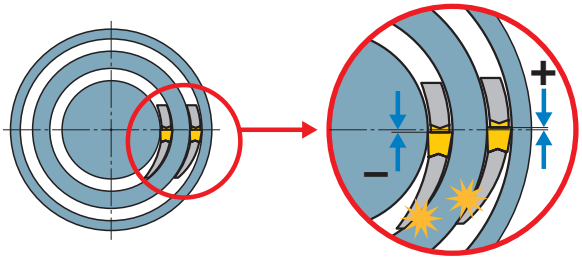
Setting the cutting edge height



●Set the cutting edge height to ±0.1mm parallel to the central axis.

●Cutting edge centre height check should be done by traverse machining towards the centre with a very small depth of cut and ensure that an even surface and no material remains at the centre point afterwards.

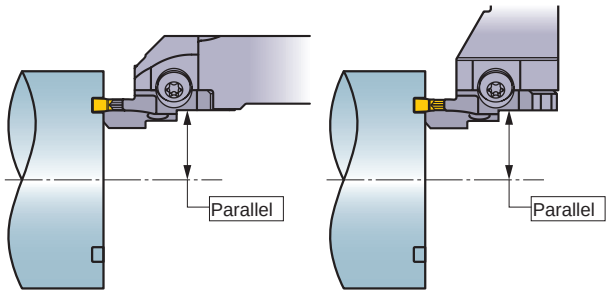
When interfering the wall of groove and the Modular blade



●If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.

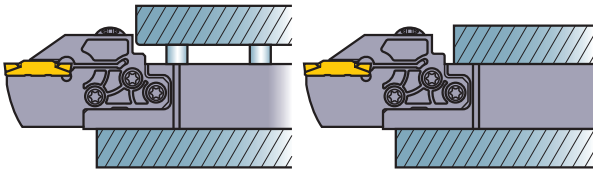
When interference occurs on the inner side of the blade, the cutting edge height is set too high.
When interference occurs on the outer side of the blade, the cutting edge height is set too low.

Setting the tool



●Set the insert parallel to the central axis.

Tool overhang



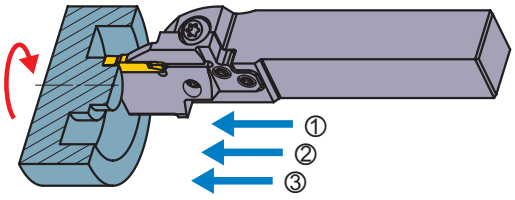
●When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

Notes when face grooving

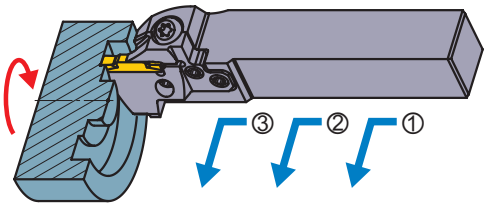
●**Always machine from the outer diameter towards the centre.**

Machining narrow grooves



●Plunging in several passes is recommended.

Machining wide grooves

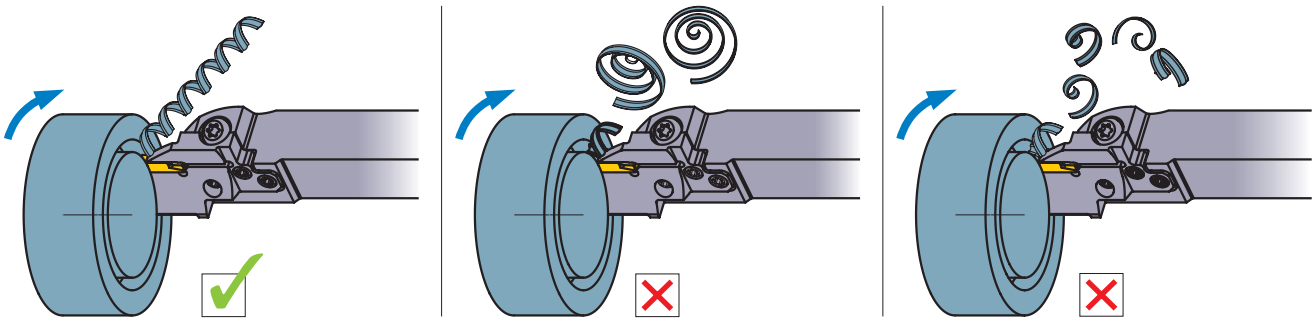


●Cross feed machining is recommended.

MACHINING RECOMMENDATIONS

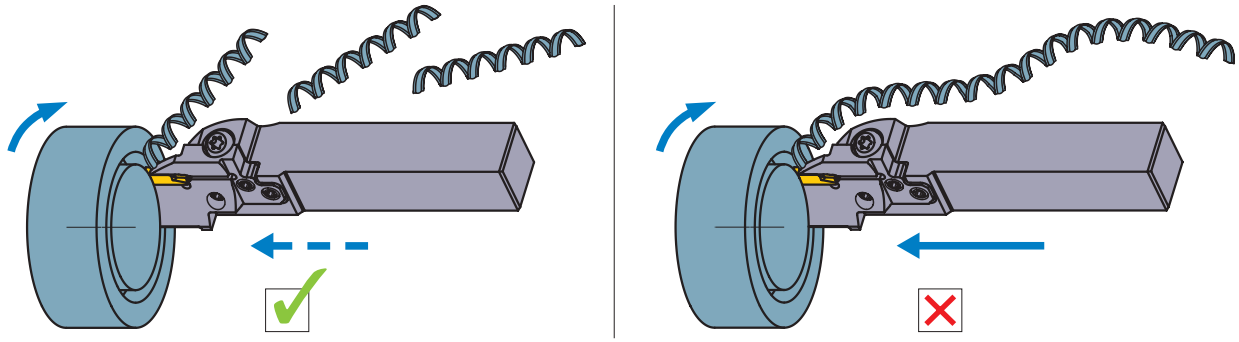
Notes when face grooving

Notes on the first pass (1)



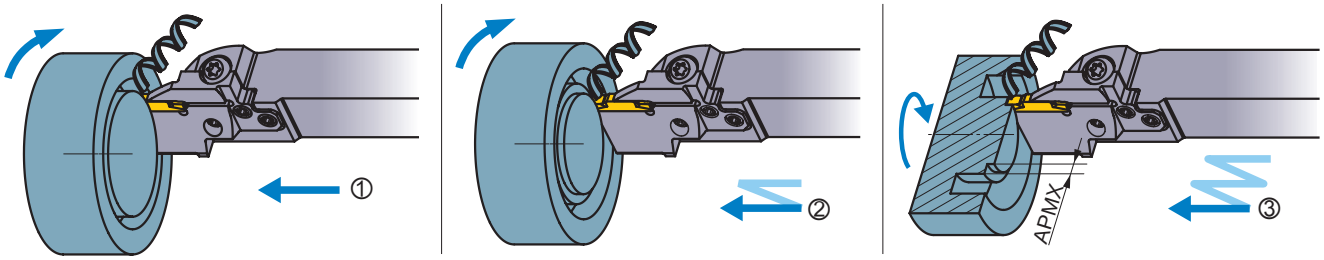
●During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

Notes on the first pass (2)



●When chips become too long, use peck feed to break them into a suitable length.

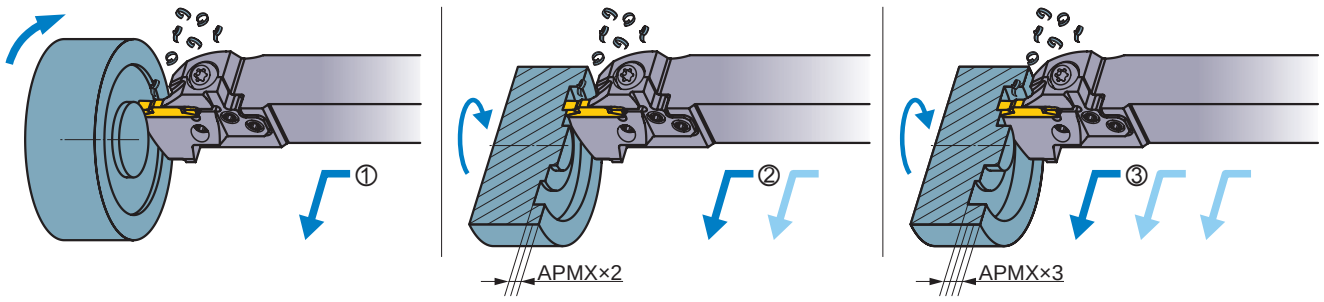
Notes when wide face grooving by plunging in several passes



●When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming.

●Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect of the chip breaker by enlarging the width of the groove to improve chip dispersal.

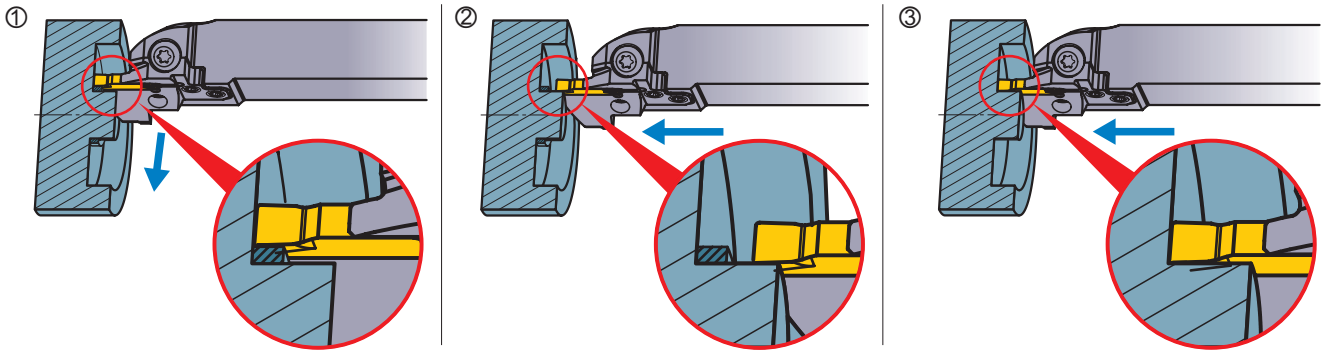
Notes when wide face grooving by combination of plunging and traverse machining (1)



●When face groove machining by using plunge feed and traverse machining, always machine from the outer diameter towards the centre to disperse chips outward to avoid chip jamming problems.

●Set the depth of cut within 40% of the insert width.

Notes when wide face grooving by combination of plunging and traverse machining (2)

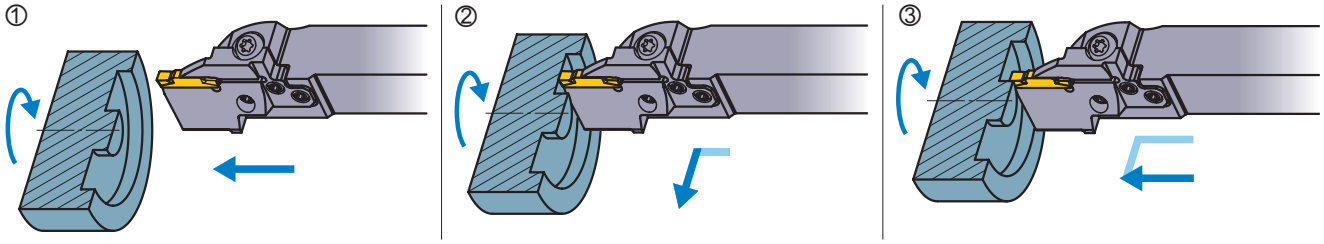


●When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall.
In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)

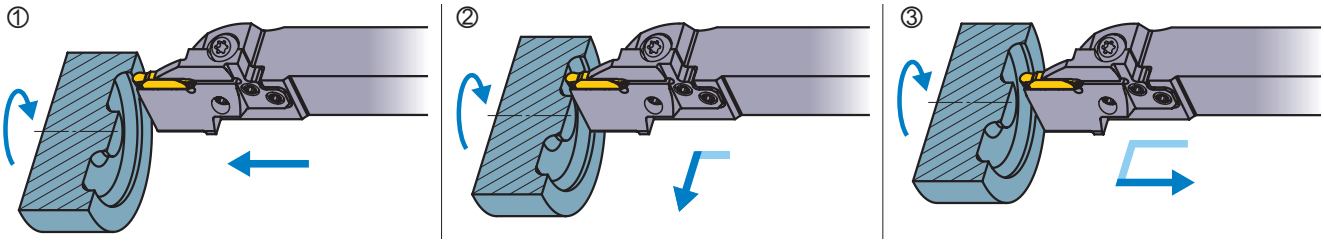
●With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX 2) to 30% less than the insert width.

Finishing (1)

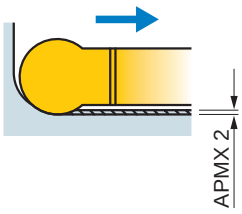


●When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

Finishing (2) (BM Breaker)



●Carry out finishing in one process.
For the depth of cut (APMX 2) when back turning, refer to the table on the right.

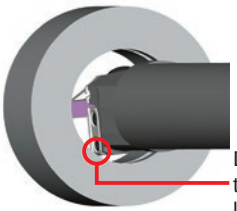


Insert	APMX 2 (mm)
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.15
GY2M0475H238N-BM	0.20
GY2M0500H250N-BM	
GY2M0600J300N-BM	0.25
GY2M0635J318N-BM	

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

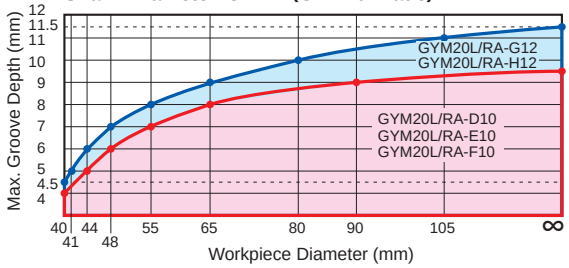
•When using the mono block type
The maximum groove depth is not limited by the cutting diameter.

•When using the modular blade type
The maximum groove depth is limited by the cutting diameter.

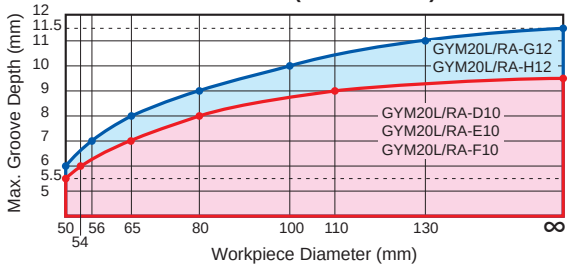


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

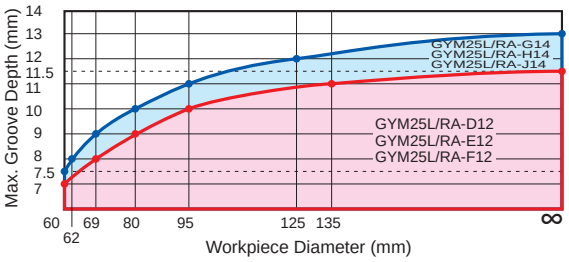
•Shank Diameter=32mm (GYM20 Blade)



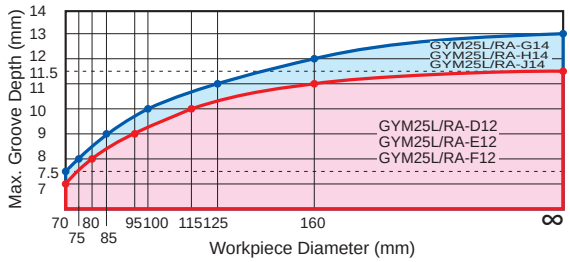
•Shank Diameter=40mm (GYM20 Blade)



•Shank Diameter=40mm (GYM25 Blade)



•Shank Diameter=50mm (GYM25 Blade)



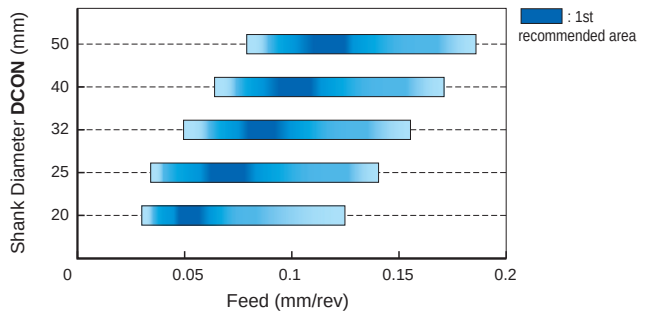
RECOMMENDED CUTTING SPEED [For Internal Grooving]

	Work Material	Hardness	Grade	Cutting Speed (m/min) 50–300
P	Mild Steel	≤160HB	VP20RT	80–180
			VP10RT	90–190
			NX2525	70–170
	Carbon Steel Alloy Steel	160–280HB	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
			NX2525	55–135
		280HB≤	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
			NX2525	45–105
M	Stainless Steel	≤270HB	VP20RT	50–110
			VP10RT	60–120
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
S	Heat Resistant Alloy Titanium Alloy	–	VP20RT	30–60
			VP10RT	40–70
			RT9010	40–70
H	Hardened Steel	50HRC≤	BC8110	60–100
			MB8025	60–100

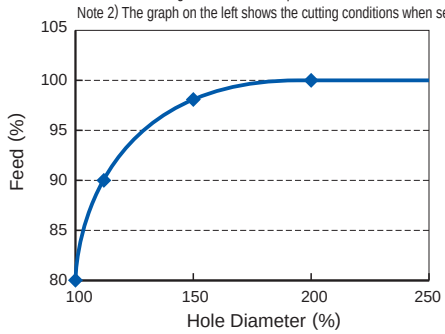
Note 1) VP20RT is the first recommended grade for materials other than hardened steel.
Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

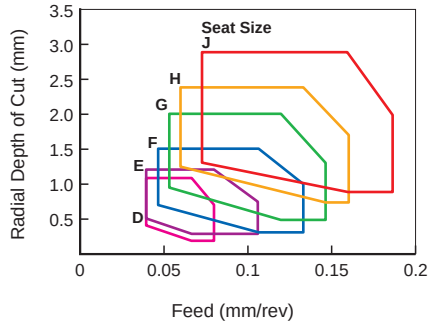
GROOVING



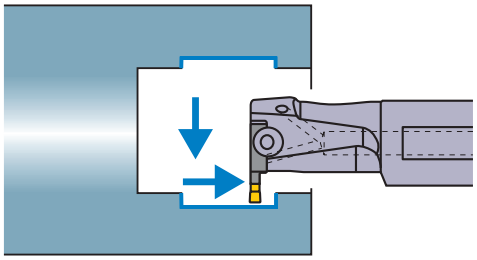
Note 1) The cutting diameter 100% represents the minimum cutting diameter (DMIN).
Note 2) The graph on the left shows the cutting conditions when setting the feed to 100%.



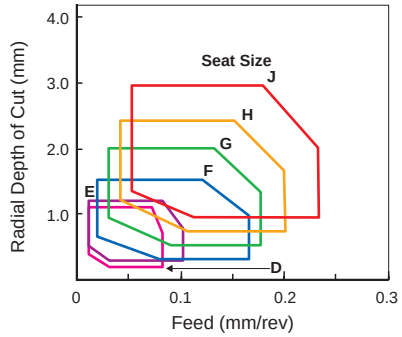
TRAVERSE MACHINING (MF BREAKER)



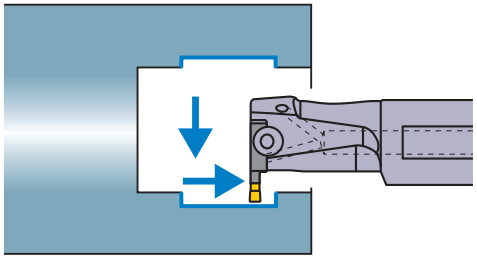
● When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.



TRAVERSE MACHINING (MM/MS BREAKER)

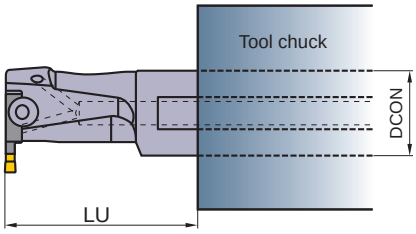


● When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.



Note 1) The above cutting conditions are for when using the tool overhang (LU) 1.6-2.0 times larger than the shank diameter (DCON). (L/D=1.6-2.0)
When using L/D larger than 2.0, reduce the cutting conditions.

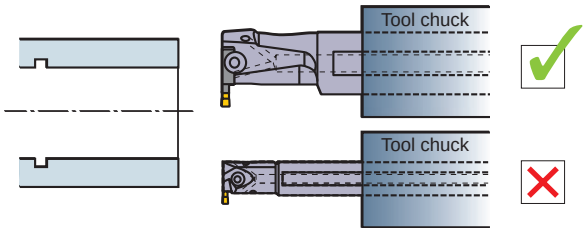
Seat Size	Insert Width (mm)
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35



TOOL SELECTION

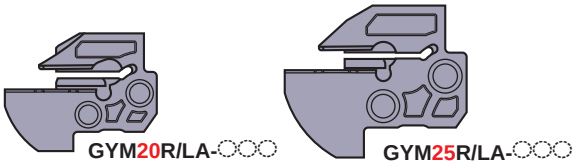
Notes when selecting the tool body

Holder



●When the overhang is the same, select a holder with the largest possible shank size to ensure sufficient clamping rigidity.

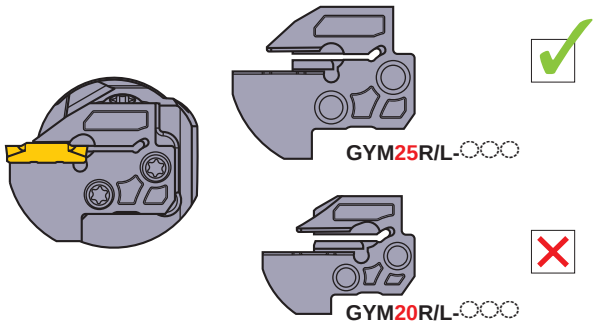
Modular blade (1)



GYM20R/LA-D10	GYM25R/LA-D12
GYM20R/LA-E10	GYM25R/LA-E12
GYM20R/LA-F10	GYM25R/LA-F12
GYM20R/LA-G12	GYM25R/LA-G14
GYM20R/LA-H12	GYM25R/LA-H14
	GYM25R/LA-J14

●For a ø40 shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

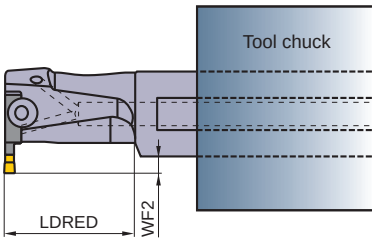
Modular blade (2)



●For an internal holder, select a modular blade listed above.

Notes when setting the tool

Overhang



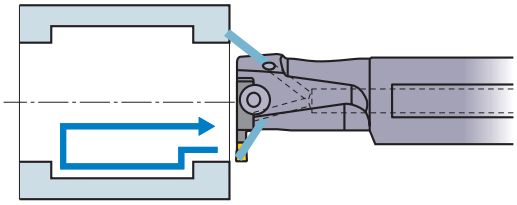
●The maximum groove depth is limited to the dimension LDRED. When machining with longer overhangs, refer to the dimension WF2 of the tool used.

MACHINING RECOMMENDATIONS

Notes on multi-function machining (MF, MS and MM breakers)

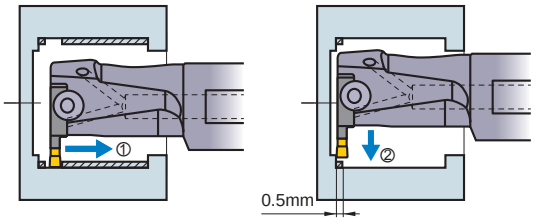
For internal grooving, the machining methods for external grooving can be used, but please note the following precautions.

Coolant



●Supply large amounts of coolant for effective chip disposal during cutting. Maintain supply until the tool has been retracted completely for improved chip disposal.

Machining blind holes

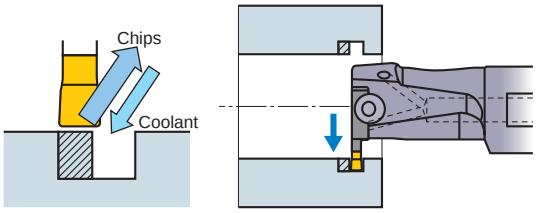


●As continuous chips tend to elongate at the back of the bore, the above operation is recommended.
The recommended width of cut for ② is 0.5mm.

Machining Wide Grooves

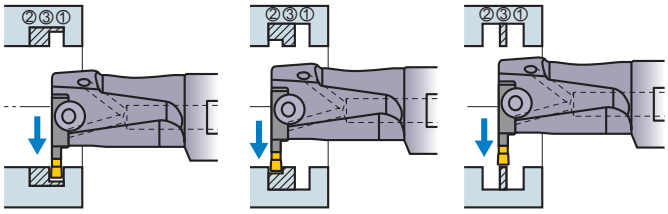
Grooving

●When the cutting edge width is x 2 ≥ groove width



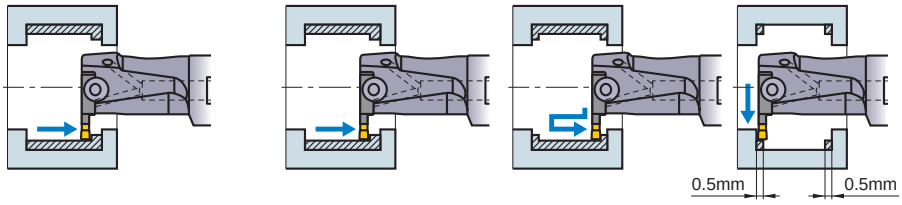
●When the depth of cut is shallower than the cutting edge width, continuous chips are usually produced. When plunging in several passes, it is recommended to carry out machining in the steps above. This ensures that coolant reaches the cutting edge and chips are easily discharged.

●When the cutting edge width is x 2 < groove width



●When the groove depth is larger than the cutting edge width, carry out plunging in the steps above to break up chips efficiently.

Turning

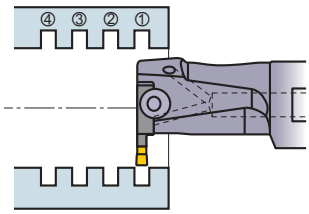


●When chip breaking and disposal are especially important, cross-feed machining is recommended.

●Wide face grooving when the corner R of the work piece is equal to the corner R of the insert, machine as shown above. (When corner R of the work piece is larger than corner R of the insert, refer to the description of external wide grooving.)

●If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

Machining instruction



●It is recommended to carry out grooving from the front end of the workpiece.
This reduces workpiece deflection.

GW SERIES NEW

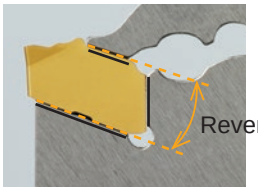
Long Lasting, Easy to Use Cutting Off & Grooving System

Easy to Utilize Configuration that Improves Tool Handling

Clamp

Simple insert clamping method offering high rigidity.

To prevent the insert from being pulled out during machining a reverse taper angle has been designed from the front of the insert, additionally the design also includes 3 large locating faces between the insert and the blade offering increased cutting edge reliability. The blade itself is made from a special alloy steel to suit this application.
In respect to insert indexing a unique wrench is supplied to ensure ease when changing the insert.



Voice of Developer

Just how easy is it to set an insert?

With the use of a unique wrench, it is possible to locate and remove the insert with one simply action making it easier for use in the workshop.

Through Coolant Blade

Increased wear resistance due to the use of 2 through coolant ejection holes.

2 through coolant holes supply the coolant to both the rake and flank face, leading to effective cutting edge cooling and increased wear resistance. Additionally this blade can also be used for both low pressure and high pressure coolant (7MPa).

Voice of Developer

How is it possible to reduce heat generation?

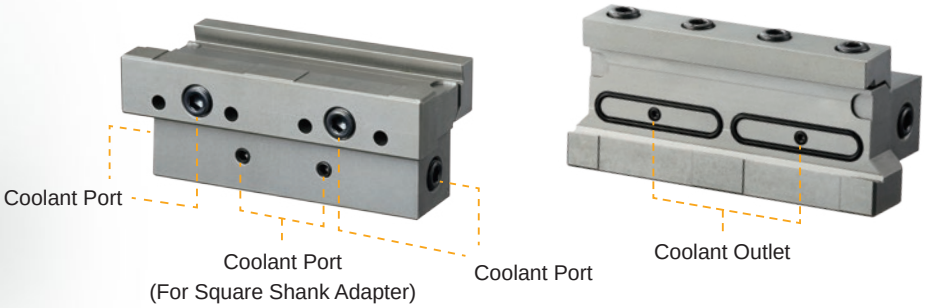
The 2 coolant holes used in the blade are capable of using high coolant pressures of up (7MPa), this is achieved by using as large as possible a through coolant hole diameter. The ejection holes are located close to the cutting edge so as to improve the cutting edge cooling effect and increasing wear resistance.

You Tube

Coolant Ports

Flexible set up possible with the use of 6 coolant ports.

There are 6 coolant ports designed into the tool block. This makes it easier for the end user to set up the tool block and blade to a configuration that suits their needs. If necessary it is also possible to use coolant hose. The ejection type coolant also improves cutting edge cooling and chip evacuation.



Voice of Developer

Possible to set up to suit the requirements of the workshop environment.

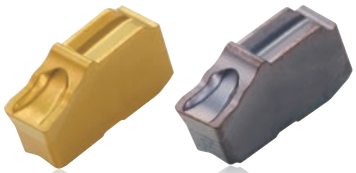
One of the objectives of this product is to respond to the customers complaints that “the product did not fit and could not be used”. Starting with the coolant outlet that prevents leaks even when oil quantity or overhangs change, everything from the material and the shape of the O-ring, to the length of the hose has been tailored to the effective use in the workshop.

Breaker System Offering Excellent Chip Disposal Properties

Low Feeds

GS **Breaker**

Medium Feeds



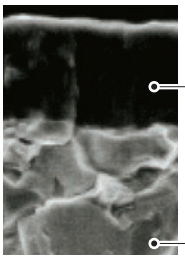
Neutral Right Hand / Left Hand

GM **Breaker**

INSERT GRADE

Work Material / Machining Condition	P Steel	M Stainless Steel	K Cast Iron	S Heat Resistant Alloy / Titanium Alloy
Stable ↑ Machining Condition ↓ Unstable	MY5015		MY5015	
	VP10RT	VP10RT	VP10RT	VP10RT
	VP20RT	VP20RT	VP20RT	VP20RT
	VP30RT	VP30RT		

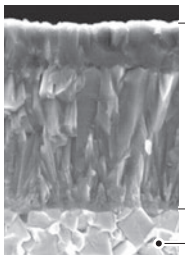
VP20RT (1st Recommendation)



● PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating
Carbide Substrate (90.5HRA)

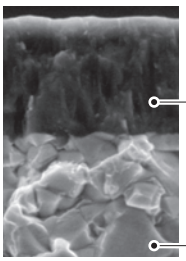
MY5015



● MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast irons. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide
Carbide Substrate

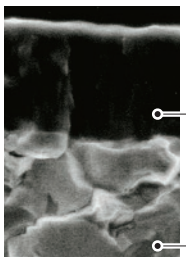
VP10RT



● PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE Coating
Carbide Substrate (92.0HRA)

VP30RT



● A combination of a tough, special cemented carbide substrate and MIRACLE coating. Ideal for heavy interrupted cutting of stainless and general steels.

MIRACLE Coating (Al,Ti)N
Carbide Substrate (88.8HRA)

GW SERIES ORDER NUMBER

■ Insert / Blade / Tool Block

● Insert

①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩
GW	1	M	0300	F	030	R	05	– G	M

①Series Description

②Number of Teeth

1	1 Edge Type

③Peripheral

M	Sintered

④Cutting Width CW

0200	2.00mm
0300	3.00mm
0400	4.00mm
0500	5.00mm

⑤Seat Size *1

D	2.00mm
F	3.00mm
G	4.00mm
H	5.00mm

⑥Corner Radius RE

010	0.10mm
:	:
040	0.40mm

⑦Hand

N	Neutral
R	Right
L	Left

⑧Handed Angle

05	5°

⑨Application 1

G	Grooving/Cutting Off

⑩Application 2

S	Low Feeds
M	Medium Feeds

● Blade

①	②	③	④	⑤	⑥	⑦	⑧
GW	B32	N	A	2 –	F	60 –	C

①Series Description

②Blade Size *2

B26
B32

③Hand

N	Neutral

④Blade Geometry

A	Standard Type

⑤No. of Corners

2	2 Corner

⑥Seat Size *3

D	2.00mm
F	3.00mm
G	4.00mm
H	5.00mm

⑦Max. Groove Depth OHX

36	36mm
60	60mm

⑧Coolant Hole

Standard	Without Coolant Hole
C	With Coolant Hole

● Tool Block

①	②	③	④	⑤	⑥
GW	TB	N	2525 –	B32 –	C

①Series Description

②Tool Block

③Hand

N	Neutral

④Shank Diameter (H x W)

2020	20mm×20mm
2525	25mm×25mm

⑤Blade Size *4

B26
B32

⑥Coolant Hole

Standard	Without Coolant Hole
C	With Coolant Hole

*1 Select seat size with the same symbol as that of blade.
*2 Select blade size with the same symbol as that of tool block.
*3 Select seat size with the same symbol of the insert.
*4 Select blade size with the same symbol as that of blade.

GW NEW HOLDER

- Simple insert clamping method offering high rigidity.
- The blade is possible to use with both external or through coolant.
- Cutting width CW 2.0–5.0mm

TOOL NEWS

GW

For External Cutting Off / Grooving

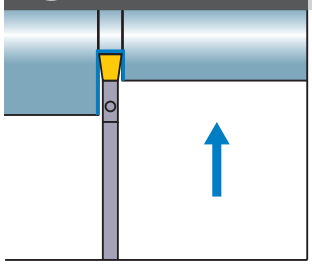


Fig.1

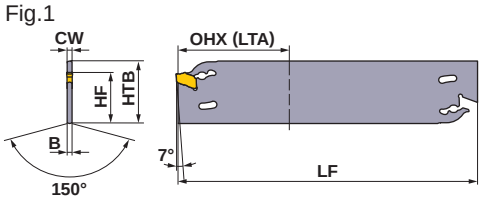
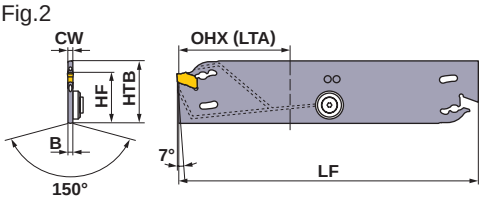


Fig.2



Without Coolant Hole

(mm)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.	Insert Type	Wrench	Tool Block Type
D	2.00	72	**GWB26NA2-D36**	●	16	36	1.55	110	26	21.4	1	GW1M0200D	GWY39L	GWTBN-B26
		120	**GWB32NA2-D60**	●	16	60	1.55	150	32	25	1	GW1M0200D	GWY39L	GWTBN-B32
F	3.00	72	**GWB26NA2-F36**	●	16	36	2.45	110	26	21.4	1	GW1M0300F	GWY39L	GWTBN-B26
		120	**GWB32NA2-F60**	●	16	60	2.45	150	32	25	1	GW1M0300F	GWY39L	GWTBN-B32
G	4.00	72	**GWB26NA2-G36**	●	19	36	3.35	110	26	21.4	1	GW1M0400G	GWY39L	GWTBN-B26
		120	**GWB32NA2-G60**	●	19	60	3.35	150	32	25	1	GW1M0400G	GWY39L	GWTBN-B32
H	5.00	72	**GWB26NA2-H36**	●	19	36	4.25	110	26	21.4	1	GW1M0500H	GWY39L	GWTBN-B26
		120	**GWB32NA2-H60**	●	19	60	4.25	150	32	25	1	GW1M0500H	GWY39L	GWTBN-B32

With Coolant Hole

(mm)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.	Insert Type	Wrench	Tool Block Type
D	2.00	72	**GWB26NA2-D36-C**	●	16	36	1.55	110	26	21.4	2	GW1M0200D	GWY39L	GWTBN-B26-C
		120	**GWB32NA2-D60-C**	●	26	60	1.55	150	32	25	2	GW1M0200D	GWY39L	GWTBN-B32-C
F	3.00	72	**GWB26NA2-F36-C**	●	16	36	2.45	110	26	21.4	2	GW1M0300F	GWY39L	GWTBN-B26-C
		120	**GWB32NA2-F60-C**	●	26	60	2.45	150	32	25	2	GW1M0300F	GWY39L	GWTBN-B32-C
G	4.00	72	**GWB26NA2-G36-C**	●	19	36	3.35	110	26	21.4	2	GW1M0400G	GWY39L	GWTBN-B26-C
		120	**GWB32NA2-G60-C**	●	26	60	3.35	150	32	25	2	GW1M0400G	GWY39L	GWTBN-B32-C
H	5.00	72	**GWB26NA2-H36-C**	●	19	36	4.25	110	26	21.4	2	GW1M0500H	GWY39L	GWTBN-B26-C
		120	**GWB32NA2-H60-C**	●	26	60	4.25	150	32	25	2	GW1M0500H	GWY39L	GWTBN-B32-C

*1 CUTDIA : Maximum Cut Off Diameter *2 OHN : Minimum Overhang Length *3 OHX(LTA) : Maximum Overhang Length
Note 1) Recommended Maximum Coolant Pressure : 7MPa

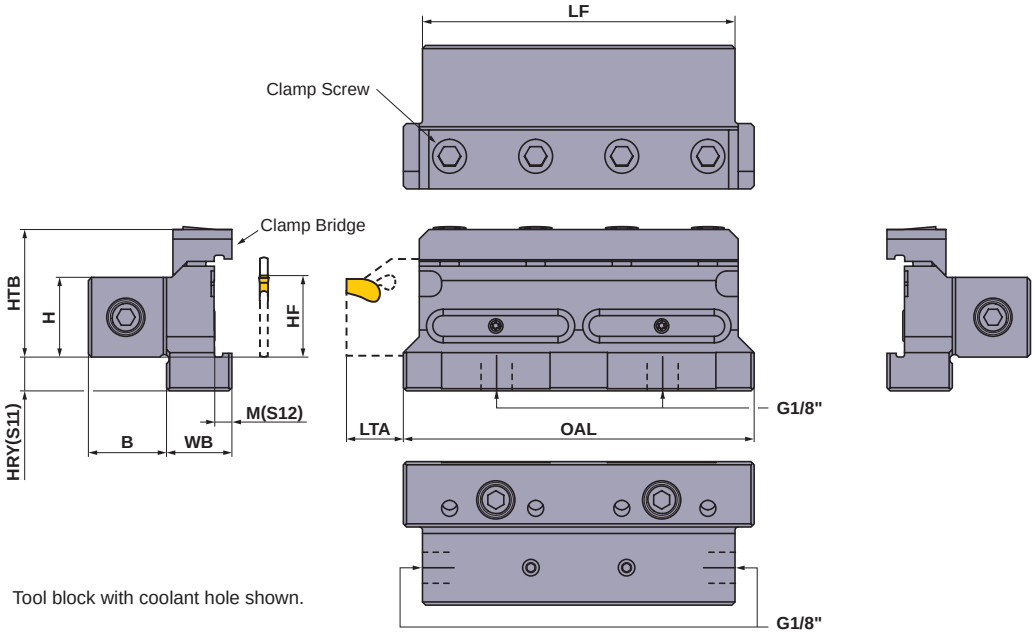
Spare Parts for Blades with Coolant Hole

(mm)

Order Number	CW	Washer	Clamp Screw	Wrench
GWB26NA2-D36-C	2.0	①GWW04038	GW04005F	HKY20R
GWB32NA2-D60-C	2.0	①GWW04038	GW04005F	HKY20R
GWB26NA2-F36-C	3.0	①GWW04038	GW04005F	HKY20R
GWB32NA2-F60-C	3.0	①GWW04038	GW04005F	HKY20R
GWB26NA2-G36-C	4.0	②GWW04026	GW04005F	HKY20R
GWB32NA2-G60-C	4.0	②GWW04026	GW04005F	HKY20R
GWB26NA2-H36-C	5.0	②GWW04026	GW04005F	HKY20R
GWB32NA2-H60-C	5.0	②GWW04026	GW04005F	HKY20R

● : Inventory maintained in Japan.

■ Tool Block



Tool block with coolant hole shown.

Without Coolant Hole (mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	Clamp Bridge	Clamp Screw	Wrench
GWTBN2020-B26	●	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32	●	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26	●	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32	●	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

With Coolant Hole (mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	Clamp Bridge	Clamp Screw	Wrench
GWTBN2020-B26-C	●	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32-C	●	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26-C	●	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32-C	●	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

* Clamp Torque (N • m) : HSC06020=7.0
Note 1) Recommended Maximum Coolant Pressure : 7MPa

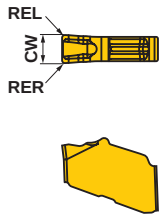
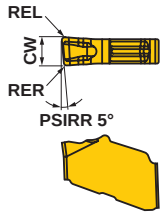
Spare Parts for Tool Block with Coolant Hole

Order Number	O-ring	Plug	Plug	Wrench	Plug	Wrench
GWTBN2020-B26-C	ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2020-B32-C	ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B26-C	ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B32-C	ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Inserts

(mm)

Application	Order Number	Stock Coating MY5015	VP10RT	VP20RT	VP30RT	CW Cutting Width	CW Tolerance	REL	RER	PSIRR	Geometry
Grooving, Cutting Off	**GW1M0200D020N-GS**		●	●	●	2.00	±0.03	0.2	0.2	–	
Grooving, Cutting Off	**GW1M0300F020N-GS**		●	●	●	3.00	±0.03	0.2	0.2	–	
Grooving, Cutting Off	**GW1M0400G020N-GS**		●	●	●	4.00	±0.04	0.2	0.2	–	
Grooving, Cutting Off	**GW1M0500H030N-GS**		●	●	●	5.00	±0.04	0.3	0.3	–	
Grooving, Cutting Off	**GW1M0200D020N-GM**	●	●	●	●	2.00	±0.03	0.2	0.2	–	
Grooving, Cutting Off	**GW1M0300F030N-GM**	●	●	●	●	3.00	±0.03	0.3	0.3	–	
Grooving, Cutting Off	**GW1M0400G030N-GM**	●	●	●	●	4.00	±0.04	0.3	0.3	–	
Grooving, Cutting Off	**GW1M0500H040N-GM**	●	●	●	●	5.00	±0.04	0.4	0.4	–	
Cutting Off	**GW1M0200D020R05-GM**		●	●	●	2.00	±0.03	0.2	0.2	5	
Cutting Off	**GW1M0200D020L05-GM**		●	●	●	2.00	±0.03	0.2	0.2	5	
Cutting Off	**GW1M0300F030R05-GM**		●	●	●	3.00	±0.03	0.3	0.3	5	
Cutting Off	**GW1M0300F030L05-GM**		●	●	●	3.00	±0.03	0.3	0.3	5	
Cutting Off	**GW1M0400G030R05-GM**		●	●	●	4.00	±0.04	0.3	0.3	5	
Cutting Off	**GW1M0400G030L05-GM**		●	●	●	4.00	±0.04	0.3	0.3	5	
Cutting Off	**GW1M0500H040R05-GM**		●	●	●	5.00	±0.04	0.4	0.4	5	
Cutting Off	**GW1M0500H040L05-GM**		●	●	●	5.00	±0.04	0.4	0.4	5	Right hand insert shown.

Coolant Hose Kit

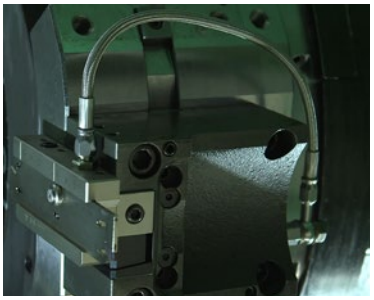
(mm)

Connector Type	Order Number	Stock	Hose Length	Kit Details: Hose Code No.	Banjo Adapter Code No.	Banjo Adapter QTY.	Banjo Bolt Code No.	Banjo Bolt QTY.	Adapter Code No.	Adapter QTY.	Washer Code No.	Washer QTY.
Straight	**CS-1/8-150SS**	●	150	HOSE-1/8-150	–	–	–	–	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-200SS**	●	200	HOSE-1/8-200	–	–	–	–	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-250SS**	●	250	HOSE-1/8-250	–	–	–	–	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-300SS**	●	300	HOSE-1/8-300	–	–	–	–	AD-G1/8	2	WA-M10	2
Elbow Straight	**CS-1/8-150BS**	●	150	HOSE-1/8-150	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-200BS**	●	200	HOSE-1/8-200	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-250BS**	●	250	HOSE-1/8-250	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-300BS**	●	300	HOSE-1/8-300	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow	**CS-1/8-150BB**	●	150	HOSE-1/8-150	AD-BM10	2	BB-G1/8	2	–	–	WA-M10	4
Elbow	**CS-1/8-200BB**	●	200	HOSE-1/8-200	AD-BM10	2	BB-G1/8	2	–	–	WA-M10	4
Elbow	**CS-1/8-250BB**	●	250	HOSE-1/8-250	AD-BM10	2	BB-G1/8	2	–	–	WA-M10	4
Elbow	**CS-1/8-300BB**	●	300	HOSE-1/8-300	AD-BM10	2	BB-G1/8	2	–	–	WA-M10	4

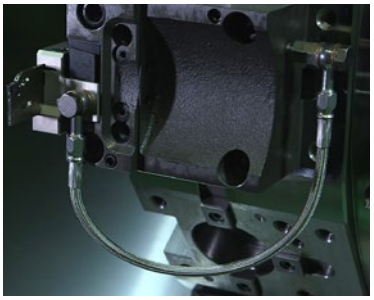
Connection Screw Size = G1/8"

Mounting Example

Elbow Straight Type



Elbow Type



● : Inventory maintained in Japan. (10 inserts in one case)

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

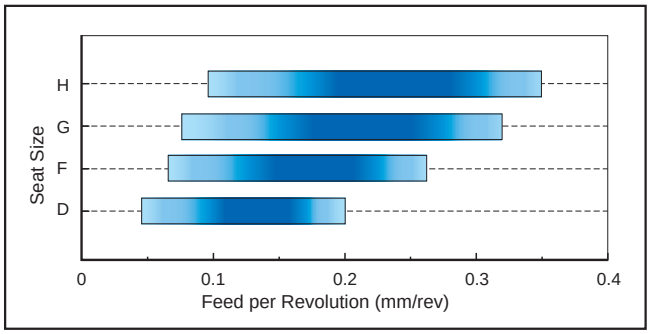
■ Cutting Speed

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤160HB	VP20RT	100–240
			VP10RT	110–250
	Carbon Steel Alloy Steel	160−280HB	VP20RT	80–200
			VP10RT	90–210
			VP30RT	60–180
			MY5015	110–250
		≥280HB	VP20RT	60–160
			VP10RT	70–170
			VP30RT	40–140
			MY5015	90–210
M	Stainless Steel	≤270HB	VP20RT	60–180
			VP10RT	70–190
			VP30RT	40–160
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	80–200
			VP10RT	90–210
			MY5015	140–300
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	60–160
			VP10RT	70–170
			MY5015	90–210
S	Heat Resistant Alloy Titanium Alloy	–	VP20RT	30–60
			VP10RT	40–70

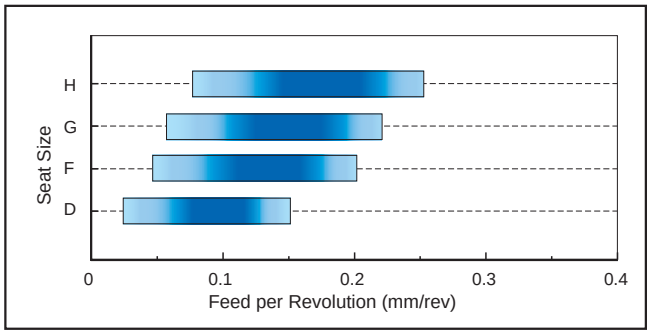
Note 1) VP20RT is the first recommended grade for materials.
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

■ Feed per Revolution

GM Breaker



GS Breaker



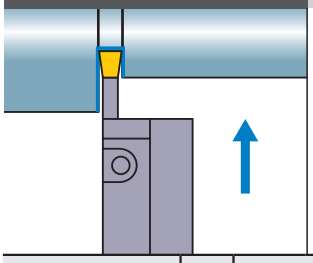
Chip Breaker	Feed per Revolution (mm/rev)			
	Seat Size D	Seat Size F	Seat Size G	Seat Size H
GM Breaker	0.05−0.20	0.07−0.26	0.08−0.32	0.10−0.35
GS Breaker	0.03−0.15	0.05−0.20	0.06−0.22	0.08−0.25

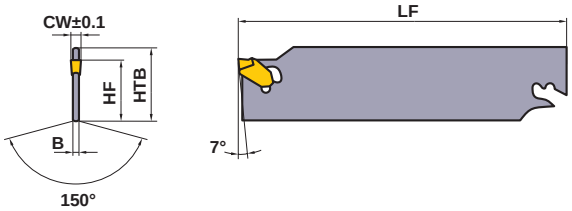
UG HOLDER

- Strengthened insert clamping force.
- Block and blade type and solid type series.
- Cutting width CW 2.2—5.1mm

UGHN

External cutting off, Grooving



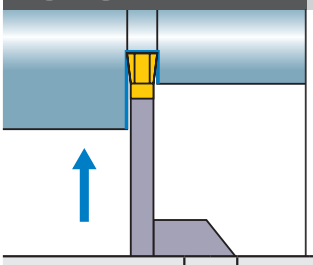


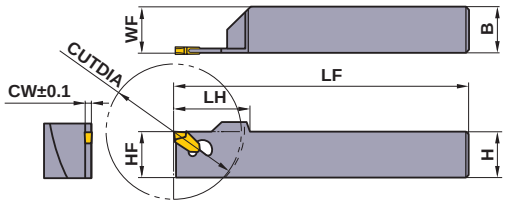
Order Number	Stock	Insert Number		Dimensions(mm)							Wrench	Tool Block
				CW	CUTDIA*1	CDX *2	B	HF	HTB	LF		
UGHN262	▲	KGT	2◌	2.2	50	20	1.60	21.4	26	111	UGS1	KGBN26-20 KGBN26-25
UGHN263	▲		3◌	3.1	75	32.5	2.35	21.4	26	111	UGS1	
UGHN264	▲		4◌	4.1	80	35	3.20	21.4	26	111	UGS1	
UGHN265	▲		5◌	5.1	80	35	4.00	21.4	26	111	UGS1	
UGHN322	▲		2◌	2.2	50	20	1.60	25.0	32	151	UGS1	KGBN32-20 KGBN32-25
UGHN323	▲		3◌	3.1	100	45	2.35	25.0	32	151	UGS1	
UGHN324	▲		4◌	4.1	100	45	3.20	25.0	32	151	UGS1	
UGHN325	▲		5◌	5.1	120	55	4.00	25.0	32	151	UGS1	

*1 CUTDIA : Max. Cut off Diameter
*2 CDX : Max. Groove Depth

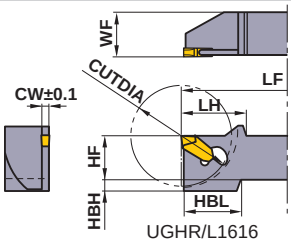
UGH

External cutting off, Grooving





Right hand tool holder shown.



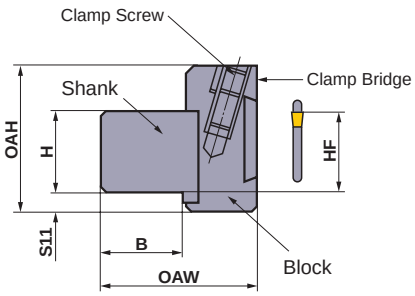
UGHR/L1616

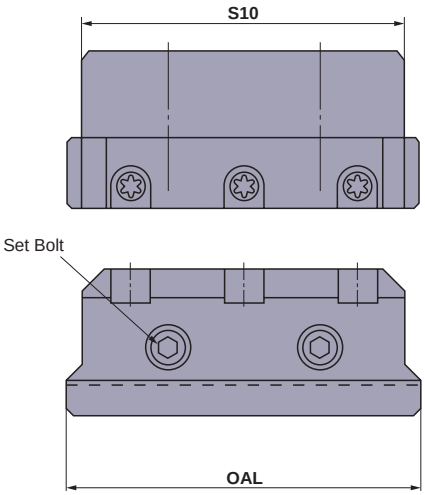
Order Number	Stock		Insert Number		Dimensions(mm)											Wrench
	R	L			CW	CUTDIA	CDX *	B	HF	LF	LH	H	WF	HBH	HBL	
UGHR/L1616H2	▲	▲	KGT	2◌	2.2	32	—	16	16	100	24	16	16.3	4	20	UGS1
UGHR/L1616H3	▲	▲		3◌	3.1	36	—	16	16	100	24	16	16.4	4	20	UGS1
UGHR/L2020K2A	▲	▲		2◌	2.2	32	—	20	20	125	24	20	20.3	—	—	UGS1
UGHR/L2020K2	▲	▲		2◌	2.2	42	8	20	20	125	25	20	20.3	—	—	UGS1
UGHR/L2020K3A	▲	▲		3◌	3.1	36	—	20	20	125	24	20	20.4	—	—	UGS1
UGHR/L2020K3	▲	▲		3◌	3.1	58	21	20	20	125	32	20	20.4	—	—	UGS1
UGHR/L2525M3	▲	▲		3◌	3.1	76	29	25	25	150	42	25	25.4	—	—	UGS1
UGHR/L2525M4	▲	▲		4◌	4.1	76	29	25	25	150	42	25	25.5	—	—	UGS1

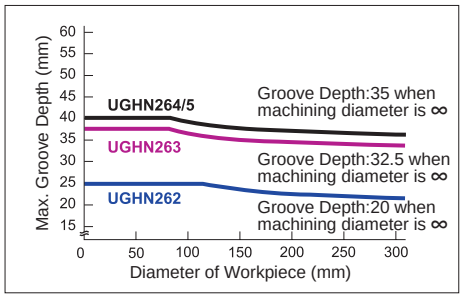
* CDX : Max. Groove Depth

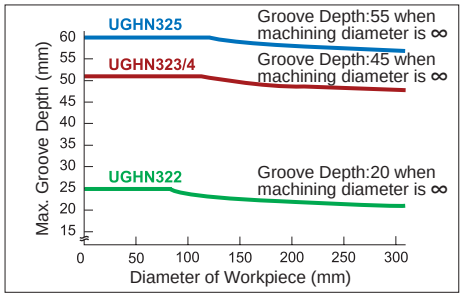
▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

TOOL BLOCK





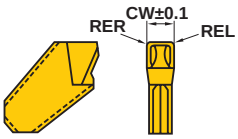
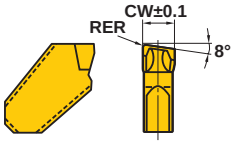




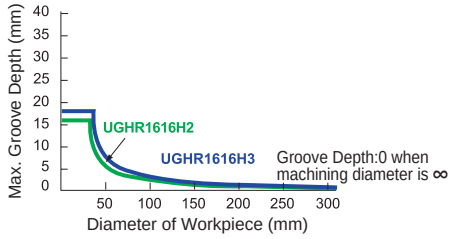
Order Number	Stock	Dimensions(mm)								①	① *	①	② *	②
		B	H	HF	S10	S11	OAH	OAL	OAW	Clamp Bridge	Clamp Screw	Wrench	Set Bolt	Wrench
KGBN26-20	▲	20	20	20	100	11	45	110	43	KGC1	LS15T	TKY25R	HSC08016	HKY60R
KGBN26-25	▲	25	25	25	100	6	45	110	48	KGC1	LS15T	TKY25R	HSC08016	HKY60R
KGBN32-20	▲	20	20	20	100	15.6	52	110	43	KGC1	LS15T	TKY25R	HSC08016	HKY60R
KGBN32-25	▲	25	25	25	100	10.6	52	110	48	KGC1	LS15T	TKY25R	HSC08016	HKY60R

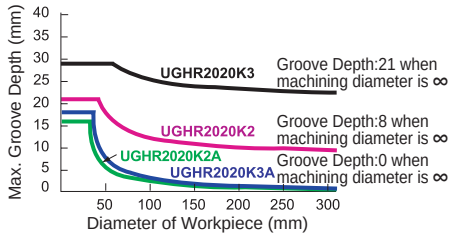
* Clamp Torque (N • m) : LS15T=8.5, HSC08016=24.0

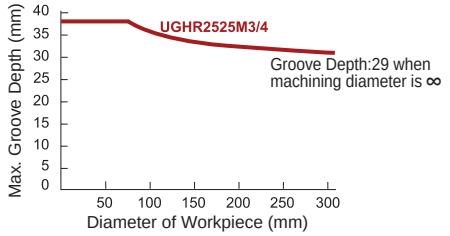
INSERTS

Order Number	Stock						Dimensions(mm)		Geometry
	Coated		Cermet		Carbide				
	UE6020	US735	NX2525		UTi20T		CW	RER/L	
KGT2N	▲		▲		▲		2.2	0.2	
KGT3N	▲	▲	▲		▲		3.1	0.2	
KGT4N	▲	▲	▲		▲		4.1	0.2	
KGT5N	▲	▲	▲		▲		5.1	0.2	
KGT2R	▲		▲		▲		2.2	0.2	
KGT2L	▲		▲		▲		2.2	0.2	
KGT3R	▲		▲		▲		3.1	0.2	
KGT3L	▲		▲		▲		3.1	0.2	
KGT4R	▲		▲		▲		4.1	0.2	
KGT4L	▲		▲		▲		4.1	0.2	
KGT5R	▲		▲		▲		5.1	0.2	
KGT5L	▲		▲		▲		5.1	0.2	Left hand tool holder shown.

Note 1) The above insert is not compatible with other manufacturer's holders.







RECOMMENDED CUTTING CONDITIONS

Work Material		Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)			
					Cutting Width 2.2mm	Cutting Width 3.1mm	Cutting Width 4.1mm	Cutting Width 5.1mm
P	Mild Steel	≤180HB	UE6020 • NX2525 UTi20T	120 (100−140)	0.08 (0.06−0.1)	0.1 (0.08−0.12)	0.12 (0.1−0.14)	0.12 (0.1−0.14)
	Carbon Steel Alloy Steel	180−280HB	UE6020 • NX2525 UTi20T	100 (80−120)	0.05 (0.04−0.06)	0.08 (0.06−0.1)	0.1 (0.08−0.12)	0.1 (0.08−0.12)
		280−350HB	UTi20T	80 (60−100)	0.05 (0.04−0.06)	0.08 (0.06−0.1)	0.1 (0.08−0.12)	0.1 (0.08−0.12)
M	Stainless Steel	≤200HB	US735	80 (60−100)	0.05 (0.04−0.06)	0.08 (0.06−0.1)	0.1 (0.08−0.12)	0.1 (0.08−0.12)

Note 1) Please set the cutting edge height 0.1−0.2mm higher than centre.

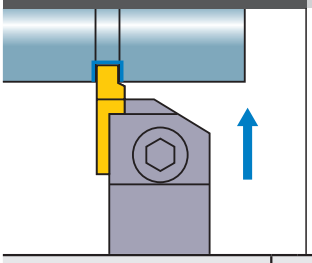
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

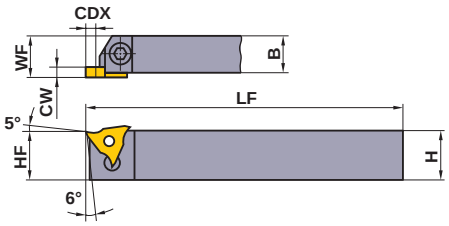
MG HOLDER

- Clamp-on type
- Positive insert suffers from negligible chattering and thus produces a good finished surface.
- Cutting width CW 1.25–6.0mm

MGH

External grooving





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		Dimensions(mm) CW	CDX	H	B	LF	HF	WF
MGHR/L2020K3315	●	●	MGTR/L	33125 – 33400	1.25	1.2	20	20	125	20	20.2
					1.45	1.5					
					1.5≤CW≤2.3	3.0					
MGHR/L2020K3323	●	●			2.3<CW≤3.3	3.0	20	20	125	20	20.2
MGHR/L2525M3315	●	●			1.25	1.2	25	25	150	25	25.2
					1.45	1.5					
					1.5≤CW≤2.3	3.0					
MGHR/L2525M3323	●	●			2.3<CW≤3.3	3.0	25	25	150	25	25.2
MGHR/L2525M3333	●	●			3.3<CW≤4.7	3.0	25	25	150	25	25.2
MGHR/L2020K4315	●	●	MGTR/L	43125 – 43470	1.25	1.2 (2.0)*	20	20	125	20	20.2
					1.45	1.5					
					1.5≤CW≤2.3	3.0 (3.5)*					
MGHR/L2020K4323	●	●			2.3<CW≤3.3	4.5 (4.0)*	20	20	125	20	20.2
MGHR/L2020K4333	●	●			3.3<CW≤4.7(4.0)*	4.5 (5.0)*	20	20	125	20	20.2
MGHR/L2525M4315	●	●			1.25	1.2 (2.0)*	25	25	150	25	25.2
					1.45	1.5					
					1.5≤CW≤2.3	3.0 (3.5)*					
MGHR/L2525M4323	●	●			2.3<CW≤3.3	4.5 (4.0)*	25	25	150	25	25.2
MGHR/L2525M4333	●	●			3.3<CW≤4.7(4.0)*	4.5 (5.0)*	25	25	150	25	25.2
MGHR/L2525M4447	●	●	MGTR/L	44500 – 44600	4.7<CW≤6.3	4.5	25	25	150	25	25.2

* Dimensions when installing the CBN insert.

SPARE PARTS

Order Number	Clamp Bridge	* Clamp Screw	Spring	Wrench
MGHR/L2020K3315 – MGHR/L2525M4447	MTK1R/L	HBH06020	MES3	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0

RECOMMENDED CUTTING CONDITIONS

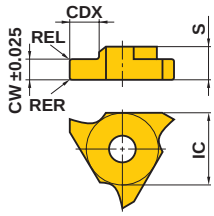
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180–280HB	**VP20MF**	120 (100–140)	0.14 (0.03–0.25)
			NX2525	130 (100–160)	0.12 (0.03–0.2)
M	Stainless Steel	≤200HB	**VP20MF**	120 (100–140)	0.12 (0.03–0.18)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP20MF**	120 (100–140)	0.12 (0.03–0.18)
H	Hardened Steel	50HRC≤	**MB8025**	100 (60–120)	0.05 (0.03–0.1)

Note) For machining a narrow groove, apply a lower feed within the recommended range.

● : Inventory maintained in Japan.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

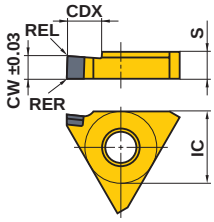
INSERTS

Order Number	Stock							Dimensions(mm)					Geometry
	Coated		Cermet		Carbide		CBN						
	VP20MF		NX2525		UTi20T		MB8025	CW	CDX	IC	S	RER/L	
	R	L	R	L	R	L	R						
MGTR/L33125	●	●	●		●	●		1.25	1.2	9.525	4.76	0.2	MGTR/L...
MGTR/L33145	●	●	●		●	●		1.45	1.5	9.525	4.76	0.2	
MGTR/L33150	●	●	●	●	●	●		1.5	3	9.525	4.76	0.2	
MGTR/L33175	●	●	●	●	●	●		1.75	3	9.525	4.76	0.2	
MGTR/L33200	●	●	●	●	●	●		2	3	9.525	4.76	0.2	
MGTR/L33230	●	●			●	●		2.3	3	9.525	4.76	0.2	
MGTR/L33250	●	●	●	●	●	●		2.5	3	9.525	4.76	0.3	
MGTR/L33270	●	●			●	●		2.7	3	9.525	4.76	0.3	
MGTR/L33280	●	●			●	●		2.8	3	9.525	4.76	0.3	
MGTR/L33300	●	●	●	●	●	●		3	3	9.525	4.76	0.3	
MGTR/L33320	●	●			●			3.2	3	9.525	4.76	0.3	
MGTR/L33330		●			●	●		3.3	3	9.525	4.76	0.3	
MGTR/L33350	●	●	●		●	●		3.5	3	9.525	4.76	0.3	
MGTR/L33400	●	●	●	●	●	●		4	3	9.525	4.76	0.3	
MGTR/L43125	●	●	●	●	●	●	●*	1.25	1.2	12.7	4.76	0.2	
MGTR/L43145	●	●		●	●	●		1.45	1.5	12.7	4.76	0.2	
MGTR/L43150	●	●	●	●	●	●	●*	1.5	3	12.7	4.76	0.2	
MGTR/L43175	●	●	●	●	●	●		1.75	3	12.7	4.76	0.2	
MGTR/L43200	●	●	●	●	●	●	●*	2	3.5	12.7	4.76	0.2	
MGTR/L43230	●	●	●	●	●	●		2.3	3	12.7	4.76	0.2	
MGTR/L43250	●	●	●	●	●	●	●*	2.5	4.5	12.7	4.76	0.3	
MGTR/L43260	●	●	●		●	●		2.6	4.5	12.7	4.76	0.3	
MGTR/L43270	●	●			●	●		2.7	4.5	12.7	4.76	0.3	
MGTR/L43280		●		●	●	●		2.8	4.5	12.7	4.76	0.3	
MGTR/L43300	●	●	●	●	●	●	●*	3	4.5	12.7	4.76	0.3	
MGTR/L43320	●				●	●		3.2	4.5	12.7	4.76	0.3	
MGTR/L43330		●		●	●	●		3.3	4.5	12.7	4.76	0.3	
MGTR/L43350	●	●	●	●	●	●	●*	3.5	4.5	12.7	4.76	0.3	
MGTR/L43400	●	●	●		●	●	●*	4	4.5	12.7	4.76	0.3	
MGTR/L43420	●	●	●		●	●		4.2	4.5	12.7	4.76	0.4	
MGTR/L43430	●	●	●		●	●		4.3	4.5	12.7	4.76	0.4	
MGTR/L43450	●	●	●	●	●	●		4.5	4.5	12.7	4.76	0.4	
MGTR/L43470	●	●	●	●	●	●		4.7	4.5	12.7	4.76	0.4	
MGTR/L44500	●	●			●	●		5	4.5	12.7	6.35	0.4	
MGTR/L44550	●				●			5.5	4.5	12.7	6.35	0.4	
MGTR/L44600	●				●	●		6	4.5	12.7	6.35	0.4	



Right hand insert shown.

CBN Insert



Right hand insert only.

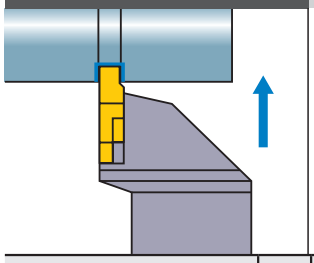
*RER=0.2 REL=0.2

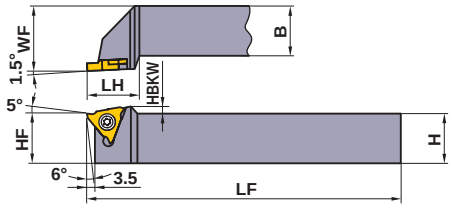
SMG HOLDER

- Screw-on type
- Positive insert suffers from negligible chattering.
- Applicable to narrow grooving and threading.
- Cutting width CW 0.5—1.3mm

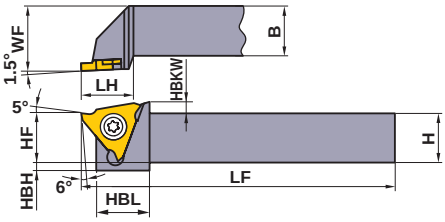
SMGH

External grooving, Threading





Right hand tool holder only.

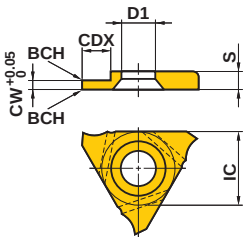


SMGHR1010E16, SMGHR1212F16

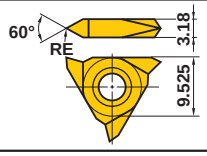
Order Number	Stock	Insert Number		Dimensions(mm)									*	
	R	Grooving	Threading	H	B	LF	LH	HF	WF	HBKW	HBH	HBL	Clamp Screw	Wrench
SMGHR1010E16	●	SMGTR 16×2○○○ 16×2○○○C	SMTTR 160360○○	10	10	70	16.5	10	12	2.5	4	13	FC400890T	TKY10F
SMGHR1212F16	●			12	12	80	16.5	12	16	2.5	2	13	FC400890T	TKY10F
SMGHR1616H16	●			16	16	100	20	16	20	—	—	—	FC400890T	TKY10F
SMGHR2020K16	●			20	20	125	20	20	25	—	—	—	FC400890T	TKY10F
SMGHR2525M16	●			25	25	150	20	25	32	—	—	—	FC400890T	TKY10F

* Clamp Torque (N • m) : FC400890T=2.5

SMG INSERTS (GROOVING)

Order Number	Stock				Dimensions(mm)						Geometry
	Cermet		Carbide								
	NX2525		UTi20T	HTi10	CW	CDX	IC	S	D1	BCH	
SMGTR16X2050				●	0.5	1.5	9.525	2	4.5	—	
SMGTR16X2060	●		●	●	0.6	1.5	9.525	2	4.5	—	
SMGTR16X2050C	●		●	●	0.5	1.5	9.525	2	4.5	0.05	
SMGTR16X2060C	●		●	●	0.6	1.5	9.525	2	4.5	0.05	
SMGTR16X2070C	●		●	●	0.7	2	9.525	2	4.5	0.05	
SMGTR16X2075C	●		●	●	0.75	2	9.525	2	4.5	0.05	
SMGTR16X2080C	●		●	●	0.8	2	9.525	2	4.5	0.1	
SMGTR16X2090C	●		●	●	0.9	2	9.525	2	4.5	0.1	
SMGTR16X2095C	●		●	●	0.95	2	9.525	2	4.5	0.1	
SMGTR16X2100C	●		●	●	1	2.5	9.525	2	4.5	0.1	
SMGTR16X2110C	●		●	●	1.1	2.5	9.525	2	4.5	0.1	
SMGTR16X2120C	●		●	●	1.2	2.5	9.525	2	4.5	0.1	
SMGTR16X2130C	●		●	●	1.3	2.5	9.525	2	4.5	0.1	

SMT INSERTS (THREADING)

Order Number	Stock	Dimensions(mm)	Thread Pitch (mm)	Geometry
	Carbide			
	UTi20T	RE		
SMTTR16036001	●	0.1	1.0—1.5	
SMTTR16036002	●	0.2	1.75—2.0	

Note 1) When installing the threading insert to the tool body, a difference occurs. Please refer to page G027.

RECOMMENDED CUTTING CONDITIONS

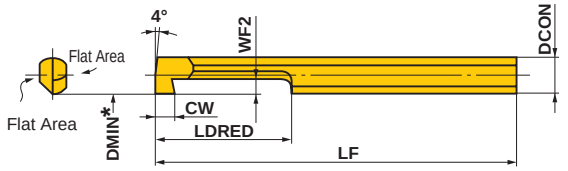
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180—280HB	**UTi20T**	100 (80—120)	0.07 (0.03—0.1)
			NX2525	130 (100—160)	0.07 (0.03—0.1)
M	Stainless Steel	≤200HB	**UTi20T**	130 (100—160)	0.1 (0.05—0.15)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**UTi20T HTi10**	100 (80—120)	0.1 (0.05—0.15)
N	Aluminium Alloy	—	**HTi10**	350 (300—400)	0.1 (0.05—0.15)
	Brass	—	**HTi10**	250 (200—300)	0.1 (0.03—0.15)
	Acrylic	—	**HTi10**	250 (200—300)	0.1 (0.03—0.15)

● : **Inventory maintained in Japan. (10 inserts in one case)**

MICRO-MINI

- Solid carbide type with min. cutting diameter 3.2mm.
- l/d is 5 times the diameter.
- Insert can be ground to suit the application.
- Suitable for a wide range of tooling including threading and grooving.

MICRO-MINI STANDARD (SOLID CARBIDE BORING BAR)

Order Number	Stock	Dimensions(mm)						Geometry
	TF15	CW	DCON	LF	LDRED	DMIN*	WF2	
C03FR-BLS	●	2.0	3	80	15	**3.2**	1.0	
C04FR-BLS	●	2.5	4	80	20	**4.2**	1.5	
C05HR-BLS	●	3.0	5	100	25	**5.2**	2.0	

Right hand tool only.

* DMIN : Min. Cutting Diameter

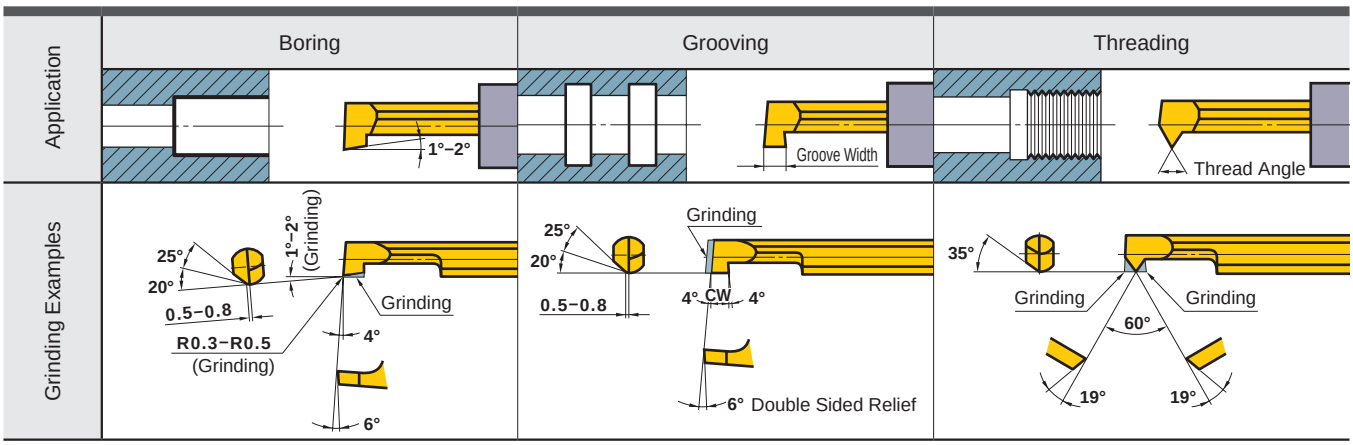
RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Excrescence Quantity (l /d)	Edge Condition	
						Corner Radius or BCH *	Honing *
P	Carbon Steel · Alloy Steel 180−280HB	40 (30−50)	0.05 (−0.1)	0.2 (0.1−0.3)	5	0.1−0.5	0.01−0.05
M	Stainless Steel ≤200HB	40 (30−50)	0.05 (−0.1)	0.2 (0.1−0.3)	5	≤0.4	≤0.03 (Honing not required)
K	Gray Cast Iron ≤350MPa	40 (30−50)	0.05 (−0.05)	0.2 (0.1−0.3)	5	0.1−0.5	0.01−0.05
N	Non-ferrous Metal	80 (60−100)	0.05 (−0.1)	0.3 (0.1−0.5)	5	0.1−0.5	≤0.03 (Honing not required)

*Cutting edge is not honed. Please hone according to the application before machining.

■GRINDING THE CUTTING EDGE OF MICRO-MINI

●MICRO-MINI can be applied to boring and grooving as supplied. But, it can also be reground as shown below.
●For shaping and regrinding, use a diamond whetstone approximately #250−#400. Please grind according to the application using the figure below as a reference.

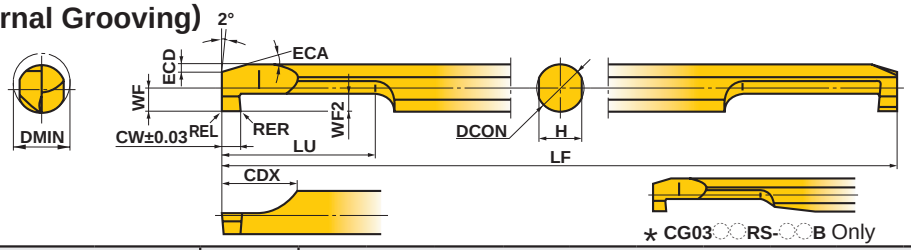


● : Inventory maintained in Japan. (MICRO MINI is available in 1 piece in one pack.)

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

MICRO-MINI TWIN

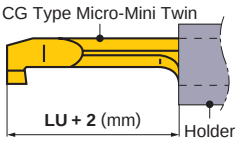
■CG TYPE (Internal Grooving)



Order Number	Stock		Breaker	Dimensions (mm)											
	Micro Grain Carbide	Coated													
	TF15	VP15TF		DMIN	CW	WF2	RER/L	DCON	LF	LU	CDX	WF	H	ECA	ECD
CG0305RS-10	●	●	Without	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3
CG0305RS-10B	●	●	With	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3
CG0306RS-20	●	●	Without	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3
CG0306RS-20B	●	●	With	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3
CG03RS-10	●	●	Without	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3
CG03RS-10B	●	●	With	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3
CG03RS-20	●	●	Without	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3
CG03RS-20B	●	●	With	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3
CG0407RS-10	●	●	Without	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5
CG0407RS-10B	●	●	With	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5
CG0408RS-20	●	●	Without	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5
CG0408RS-20B	●	●	With	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5
CG04RS-10	●	●	Without	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5
CG04RS-10B	●	●	With	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5
CG04RS-20	●	●	Without	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5
CG04RS-20B	●	●	With	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5
CG0510RS-10	●	●	Without	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7
CG0510RS-10B	●	●	With	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7
CG0511RS-20	●	●	Without	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7
CG0511RS-20B	●	●	With	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7
CG05RS-10	●	●	Without	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7
CG05RS-10B	●	●	With	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7
CG05RS-20	●	●	Without	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7
CG05RS-20B	●	●	With	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7
CG0610RS-10	●	●	Without	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7
CG0610RS-10B	●	●	With	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7
CG0611RS-20	●	●	Without	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7
CG0611RS-20B	●	●	With	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7
CG06RS-10	●	●	Without	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7
CG06RS-10B	●	●	With	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7
CG06RS-20	●	●	Without	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7
CG06RS-20B	●	●	With	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7
CG0712RS-10	●	●	Without	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7
CG0712RS-10B	●	●	With	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7
CG0713RS-20	●	●	Without	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7
CG0713RS-20B	●	●	With	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7
CG07RS-10	●	●	Without	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7
CG07RS-10B	●	●	With	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7
CG07RS-20	●	●	Without	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7
CG07RS-20B	●	●	With	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7

● : Inventory maintained in Japan. (MICRO-MINI TWIN is available in 1 piece in one pack.)

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Speed (m/min)	Feed (mm/rev)		Recommended Tool Overhang (mm)
				CG03RS/CG04RS	CG05RS/CG06RS/CG07RS	
P	Carbon Steel · Alloy Steel	180−280HB	80 (40−120)	0.02 (0.01−0.03)	0.03 (0.01−0.05)	
M	Stainless Steel	≤200HB	80 (40−120)	0.02 (0.01−0.03)	0.03 (0.01−0.05)	
K	Gray Cast Iron	Tensile Strength ≤350MPa	80 (40−120)	0.03 (0.01−0.05)	0.03 (0.01−0.05)	
N	Non-ferrous Metal	−	120 (80−160)	0.03 (0.01−0.05)	0.05 (0.01−0.08)	

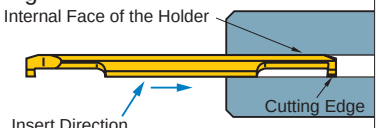
Note 1) Wet cutting is recommended.

■ PRECAUTIONS WHEN USING THE MICRO-MINI TWIN

●When using a holder for general purpose / small automatic lathe:

1 To avoid chipping of the 2nd cutting edge take care when inserting the boring bar into the holder. Refer to fig.1. If the 2nd edge contacts the internal face of the holder there is a possibility that it may chip.

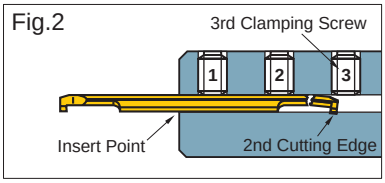
Fig.1



2 When using this type of holder, there is a possibility that damage to the shank and the 2nd cutting edge can occur. Make sure that the clamping screws are tightened to the set torque value. Additionally make sure that there is no clamping screw near the 2nd cutting edge as this can break the boring bar.

◎When using Mitsubishi holders
When using holders with a tool overhang of recommended quantity, ensure that the 3rd clamping screw is removed prior to machining. The set torque value for clamping screw is 2.0 N•m.

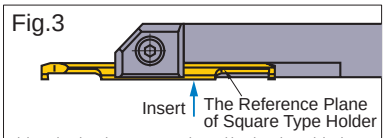
Fig.2



●When using a square type holder:

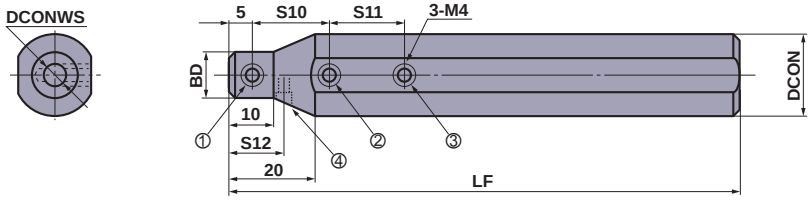
1 When installing the boring bar into the holder, tighten the clamp screws after ensuring the flats on the tool holder are parallel to the reference flats on the micro-mini bar. Refer to fig.3.
2 Make sure that the clamping screws are tightened to the recommended values.
3 Do not tighten the clamp screw without a bar in place, otherwise the bridge will be deformed.

Fig.3

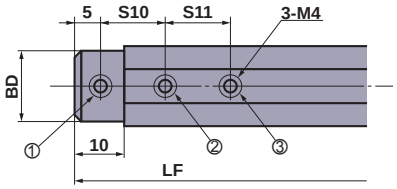


Tighten the clamping screw ensuring making the micro-mini twin boring bars in contact with the reference plane of square type holder.

ROUND TYPE HOLDER



RBH22◌◌N has a temporary set screw for different machine specifications.
(Represented by number 4)



RBH158◌◌N, RBH16◌◌N,
RBH190◌◌N

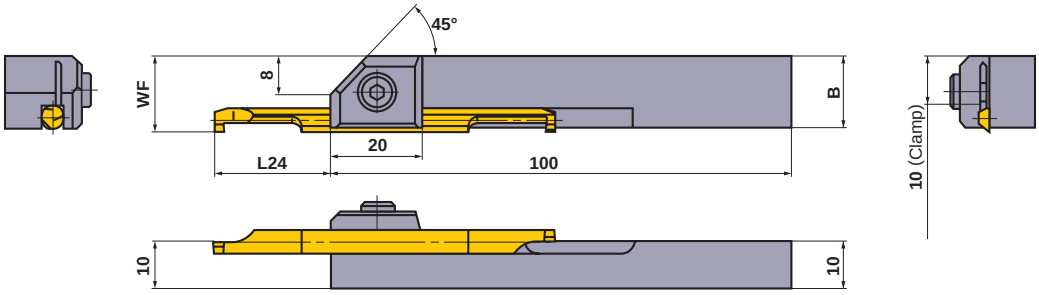
Order Number	Stock	Dimensions (mm)							MICRO-MINI C	MICRO-MINI TWIN CG	⁎1 Clamp Screw				Wrench	Torque (N • m)
		DCON	DCONWS	BD	LF	S10	S11	S12			①	②	③	④		
RBH15830N	●	15.875	3	15	100	10	10	—	03FR-BLS	03RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH15840N	●	15.875	4	15	100	15	15	—	04FR-BLS	04RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH15850N	●	15.875	5	15	100	15	15	—	05HR-BLS	05RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH15860N	●	15.875	6	15	100	15	15	—	—	06RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH15870N	●	15.875	7	15	100	20	20	—	—	07RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH1630N	●	16	3	15	100	10	10	—	03FR-BLS	03RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH1640N	●	16	4	15	100	15	15	—	04FR-BLS	04RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH1650N	●	16	5	15	100	15	15	—	05HR-BLS	05RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH1660N	●	16	6	15	100	15	15	—	—	06RS-◌◌(B)	A	A	A	—	HKY20F	2.0
RBH1670N	●	16	7	15	100	20	20	—	—	07RS-◌◌(B)	A	A	A	—	HKY20F	2.0
⁎2 RBH19030N	●	19.05	3	18	125	10	10	—	03FR-BLS	03RS-◌◌(B)	B	B	B	—	HKY20F	2.0
⁎2 RBH19040N	●	19.05	4	18	125	15	15	—	04FR-BLS	04RS-◌◌(B)	B	B	B	—	HKY20F	2.0
⁎2 RBH19050N	●	19.05	5	18	125	15	15	—	05HR-BLS	05RS-◌◌(B)	B	B	B	—	HKY20F	2.0
⁎2 RBH19060N	●	19.05	6	18	125	15	15	—	—	06RS-◌◌(B)	B	B	B	—	HKY20F	2.0
⁎2 RBH19070N	●	19.05	7	18	125	20	20	—	—	07RS-◌◌(B)	B	B	B	—	HKY20F	2.0
RBH2030N	●	20	3	12	125	10	10	—	03FR-BLS	03RS-◌◌(B)	A	A	B	—	HKY20F	2.0
RBH2040N	●	20	4	13	125	15	15	—	04FR-BLS	04RS-◌◌(B)	A	B	B	—	HKY20F	2.0
RBH2050N	●	20	5	14	125	15	15	—	05HR-BLS	05RS-◌◌(B)	A	B	B	—	HKY20F	2.0
RBH2060N	●	20	6	15	125	15	15	—	—	06RS-◌◌(B)	A	B	B	—	HKY20F	2.0
RBH2070N	●	20	7	16	125	20	20	—	—	07RS-◌◌(B)	A	B	B	—	HKY20F	2.0
RBH2230N	●	22	3	12	125	10	10	10	03FR-BLS	03RS-◌◌(B)	A	B	C	A	HKY20F	2.0
RBH2240N	●	22	4	13	125	15	15	12.5	04FR-BLS	04RS-◌◌(B)	A	B	B	A	HKY20F	2.0
RBH2250N	●	22	5	14	125	15	15	12.5	05HR-BLS	05RS-◌◌(B)	A	B	B	A	HKY20F	2.0
RBH2260N	●	22	6	15	125	15	15	15	—	06RS-◌◌(B)	A	B	B	A	HKY20F	2.0
RBH2270N	●	22	7	16	125	20	20	15	—	07RS-◌◌(B)	A	B	B	A	HKY20F	2.0
RBH2530N	●	25	3	12	150	10	10	—	03FR-BLS	03RS-◌◌(B)	A	B	C	—	HKY20F	2.0
RBH2540N	●	25	4	13	150	15	15	—	04FR-BLS	04RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH2550N	●	25	5	14	150	15	15	—	05HR-BLS	05RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH2560N	●	25	6	15	150	15	15	—	—	06RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH2570N	●	25	7	16	150	20	20	—	—	07RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH25430N	●	25.4	3	12	150	10	10	—	03FR-BLS	03RS-◌◌(B)	A	B	C	—	HKY20F	2.0
RBH25440N	●	25.4	4	13	150	15	15	—	04FR-BLS	04RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH25450N	●	25.4	5	14	150	15	15	—	05HR-BLS	05RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH25460N	●	25.4	6	15	150	15	15	—	—	06RS-◌◌(B)	A	C	C	—	HKY20F	2.0
RBH25470N	●	25.4	7	16	150	20	20	—	—	07RS-◌◌(B)	A	C	C	—	HKY20F	2.0

⁎1 Order number of clamp screw A=HSS04004, B=HSS04006, C=HSS04008
⁎2 Revised order number.

Conventional Order Number	Revised Order Number
RBH1930N	RBH19030N
RBH1940N	RBH19040N
RBH1950N	RBH19050N
RBH1960N	RBH19060N
RBH1970N	RBH19070N

● : Inventory maintained in Japan.

SQUARE TYPE HOLDER



Order Number	Stock	Dimensions (mm)				MICRO-MINI TWIN **CG**	Clamp Screw	Wrench	Torque (N • m)
		MICRO-MINI TWIN **CG**							
		B	**WF**	**L24 ⁎**					
				Width of Cutting Edge 1mm	Width of Cutting Edge 2mm				
SBH1030R	●	13.8	13.8	13−17.5 (14)	14−16.5 (15)	03RS-10(B),03RS-20(B)	HSC05012	HKY40R	9.5
SBH1040R	●	14.7	14.8	18−22.5 (19)	19−21.5 (20)	04RS-10(B),04RS-20(B)	HSC05012	HKY40R	9.5
SBH1050R	●	15.6	15.8	23−27.5 (24)	24−26.5 (25)	05RS-10(B),05RS-20(B)	HSC05012	HKY40R	9.5
SBH1060R	●	16.5	16.8	23−32.5 (24)	24−31.5 (25)	06RS-10(B),06RS-20(B)	HSC05012	HKY40R	9.5
SBH1070R	●	17.4	17.8	28−38 (29)	29−37 (30)	07RS-10(B),07RS-20(B)	HSC05012	HKY40R	9.5

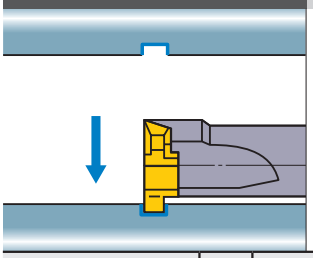
⁎ L24 is the length of overhang for sufficient clamping, and ( ) is the recommended length for machining of carbon and alloy steel.

F TYPE

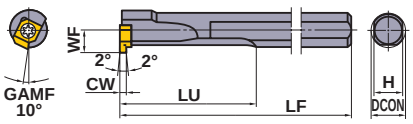
- Min. cutting diameter 10mm
- Screw-on type
- Usable for various applications.
- Max. groove depth : 3mm

FSL51

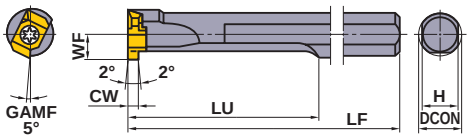
Internal grooving, Threading



1 Corner type (FSL5108R,5110R)



2 Corner type (FSL5112R,5114R,5116R)



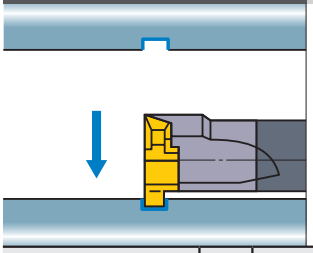
Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions(mm)							Max. Groove Depth (mm)	⋆2 Clamp Screw	Wrench
	R	Grooving	Threading	DCON	LF	LU	WF	H	CW	DMIN ⋆1			
FSL5108R	●	MLG10○○L	MLT1001L	8	125	30	4.8	7	1.2 1.5 2.0	**10**	1.0	TS25	TKY08F
FSL5110R	●	MLG10○○L	MLT1001L	10	150	40	5.8	9		**12**	1.0	TS25	TKY08F
FSL5112R	●	MLG14○○L	MLT1401L	12	180	50	6.8	10.8	1.5 2.0 3.0	**14**	2.0	TS32	TKY08F
FSL5114R	●	MLG14○○L	MLT1401L	14	180	60	7.8	12.4		**16**	2.0	TS32	TKY08F
FSL5116R	●	MLG20○○L	MLT2001L	16	200	70	9.7	14	2.0 3.0 4.0	**20**	3.0	TS43	TKY15F

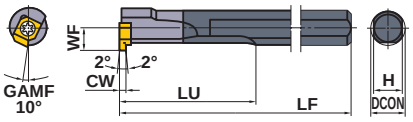
⋆1 DMIN : Min. Cutting Diameter
⋆2 Clamp Torque (N • m) : TS25=1.0, TS32=1.0, TS43=3.5

FSL52

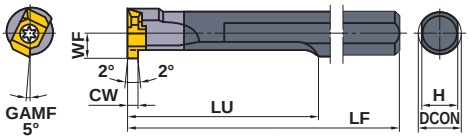
(Carbide shank) Internal grooving, Threading



1 Corner type (FSL5208R,5210R)



2 Corner type (FSL5212R,5214R,5216R)



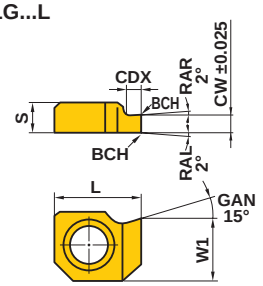
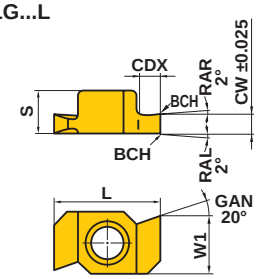
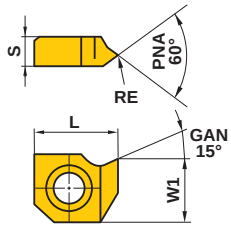
Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions(mm)							Max. Groove Depth (mm)	⋆2 Clamp Screw	Wrench
	R	Grooving	Threading	DCON	LF	LU	WF	H	CW	DMIN ⋆1			
FSL5208R	●	MLG10○○L	MLT1001L	8	125	60	4.8	7	1.2 1.5 2.0	**10**	1.0	TS25	TKY08F
FSL5210R	●	MLG10○○L	MLT1001L	10	150	70	5.8	9		**12**	1.0	TS25	TKY08F
FSL5212R	●	MLG14○○L	MLT1401L	12	180	80	6.8	10.8	1.5 2.0 3.0	**14**	2.0	TS32	TKY08F
FSL5214R	●	MLG14○○L	MLT1401L	14	180	85	7.8	12.4		**16**	2.0	TS32	TKY08F
FSL5216R	●	MLG20○○L	MLT2001L	16	200	115	9.7	14	2.0 3.0 4.0	**20**	3.0	TS43	TKY15F

⋆1 DMIN : Min. Cutting Diameter
⋆2 Clamp Torque (N • m) : TS25=1.0, TS32=1.0, TS43=3.5

● : Inventory maintained in Japan.
(10 inserts in one case)

INSERTS

Application	CW and pitch (mm)	Order Number	Coated UP20M	Carbide UTi20T	Dimensions(mm) L	W1	CDX	S	RE	BCH	Geometry
Grooving	1.2	**MLG1012L**		●	7	5	1	2.38	—	0.1	MLG...L 
	1.5	**MLG1015L**		●	7	5	1	2.38	—	0.1	
	2	**MLG1020L**		●	7	5	1	2.38	—	0.1	
	1.5	**MLG1415L**		●	11.8	6.5	2	4.76	—	0.1	MLG...L 
	2	**MLG1420L**		●	11.8	6.5	2	4.76	—	0.1	
	3	**MLG1430L**		●	11.8	6.5	2	4.76	—	0.1	
	2	**MLG2020L**		●	16.8	9.03	3	6.35	—	0.1	
	3	**MLG2030L**		●	16.8	9.03	3	6.35	—	0.1	
	4	**MLG2040L**		●	16.8	9.03	3	6.35	—	0.1	
Threading	Pitch 1.5—2.0	**MLT1001L**	●	●	7	5	—	2.38	0.1	—	MLT 
	Pitch 1.5—2.5	**MLT1401L**	●	●	11.8	6.5	—	4.76	0.1	—	
	Pitch 1.5—3.5	**MLT2001L**	●	●	16.8	9.03	—	6.35	0.1	—	

RECOMMENDED CUTTING CONDITIONS

Work Material		Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev) 1.2, 1.5mm	2.0mm	3.0mm	4.0mm
P	Carbon Steel Alloy Steel	180—280HB	**UP20M • UTi20T**	90 (60—120)	0.05 (0.02—0.08)	0.05 (0.02—0.08)	0.05 (0.02—0.08)	0.05 (0.02—0.08)
		280—350HB	**UP20M • UTi20T**	80 (50—100)	0.03 (0.02—0.04)	0.03 (0.02—0.04)	0.03 (0.02—0.04)	0.03 (0.02—0.04)

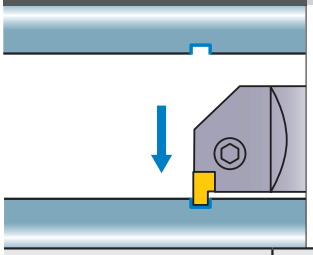
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

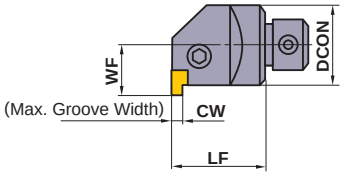
D TYPE BORING HEAD

- Min. cutting diameter : 40mm
- Pin lock type
- Exchangeable head type
- Cutting width CW 1.25−4.7mm

DPT4

Internal grooving





Right hand tool holder only.

Order Number	Stock	Insert Number	Dimensions(mm)								
	R		CW	DCON	LF	WF	DMIN *1	Lock Pin	Lock Screw *2	Stop Ring	Wrench
DPT4132R	●	MGTL43○○○	4.7	32	40	20	**40**	P21S	HSP08014	E01	HKY40R
DPT4140R	●		4.7	40	50	25	**50**	P21S	HSP08014	E01	HKY40R

Note 1) Please use left hand insert.
*1 DMIN : Min. Cutting Diameter
*2 Clamp Torque (N • m) : HSP08014=7.0

F

GROOVING / CUTTING OFF

STANDARD ARBOR FOR D TYPE BORING HEAD

① **B** ② **1** ③ **32** ④ **32**

①Designation

②Arbor Length (mm)

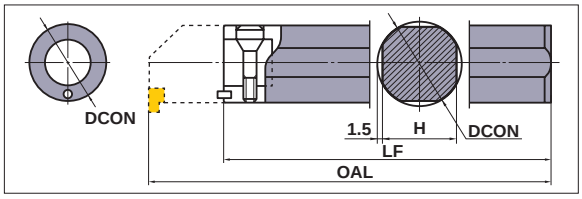
Symbol	DCON	LF	OAL
1	32	260	300
	40	310	360

③Arbor Diameter (mm)

Symbol	Diameter(DCON)
32	32
40	40

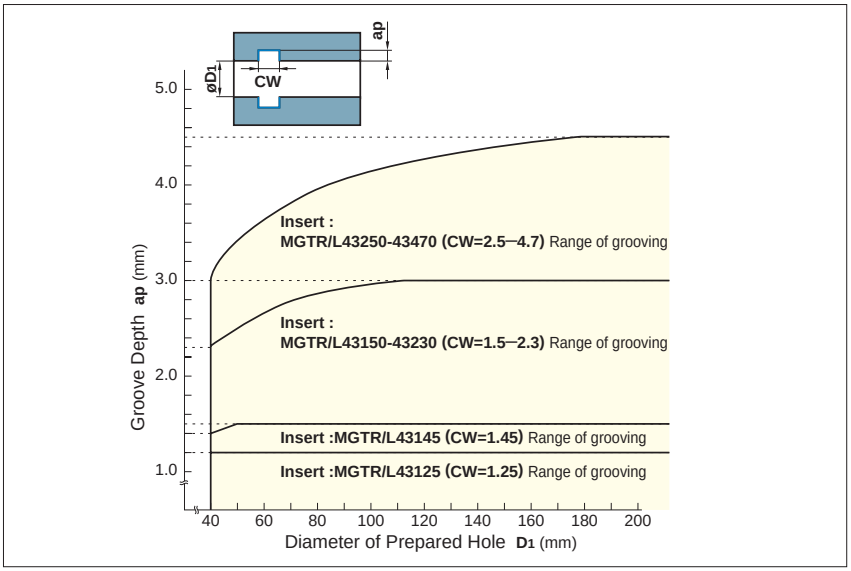
④Head Diameter (mm)

Symbol	Diameter(BD)
32	32
40	40



Order Number	Stock	Dimensions (mm)				Set Bolt	Wrench	Head Order Number
		DCON	LF	H	OAL			
B13232	●	32	260	29	300	SD32	HKY60R	**DPT4132R**
B14040	●	40	310	37	360	SD40	HKY60R	**DPT4140R**

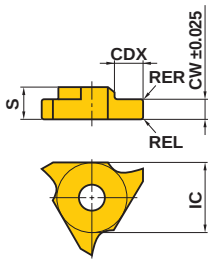
■Relationship between prepared hole and groove depth for DPT4 type



● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Order Number	Stock			Dimensions(mm)					Geometry
	Coated	Cermet	Carbide						
	VP20MF	NX2525	UTi20T	CW	CDX	IC	S	RER/L	
MGTL43125	●	●	●	1.25	1.2	12.7	4.76	0.2	**MGTL...**
MGTL43145	●	●	●	1.45	1.5	12.7	4.76	0.2	
MGTL43150	●	●	●	1.5	3.0	12.7	4.76	0.2	
MGTL43175	●	●	●	1.75	3.0	12.7	4.76	0.2	
MGTL43200	●	●	●	2	3.0	12.7	4.76	0.2	
MGTL43230	●	●	●	2.3	3.0	12.7	4.76	0.2	
MGTL43250	●	●	●	2.5	4.5	12.7	4.76	0.3	
MGTL43260	●		●	2.6	4.5	12.7	4.76	0.3	
MGTL43270	●		●	2.7	4.5	12.7	4.76	0.3	
MGTL43280	●	●	●	2.8	4.5	12.7	4.76	0.3	
MGTL43300	●	●	●	3	4.5	12.7	4.76	0.3	
MGTL43320			●	3.2	4.5	12.7	4.76	0.3	
MGTL43330	●	●	●	3.3	4.5	12.7	4.76	0.3	
MGTL43350	●	●	●	3.5	4.5	12.7	4.76	0.3	
MGTL43400	●		●	4	4.5	12.7	4.76	0.3	
MGTL43420	●		●	4.2	4.5	12.7	4.76	0.4	
MGTL43430	●		●	4.3	4.5	12.7	4.76	0.4	
MGTL43450	●	●	●	4.5	4.5	12.7	4.76	0.4	
MGTL43470	●	●	●	4.7	4.5	12.7	4.76	0.4	



RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180−280HB	**VP20MF**	120 (100−140)	0.14 (0.03−0.25)
			NX2525	130 (100−160)	0.12 (0.03−0.2)
M	Stainless Steel	≤200HB	**VP20MF**	120 (100−140)	0.12 (0.03−0.18)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP20MF**	120 (100−140)	0.12 (0.03−0.18)

Note 1) For machining a narrow groove, apply a lower feed within the recommended range.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

HOW TO READ THE STANDARD OF THREADING

●How this section page is organised

①Classified according to external or internal applications.
②Sub-classified according to product series.
(Refer to the index on the next page.)

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict the available machining applications, such as external and internal threading.

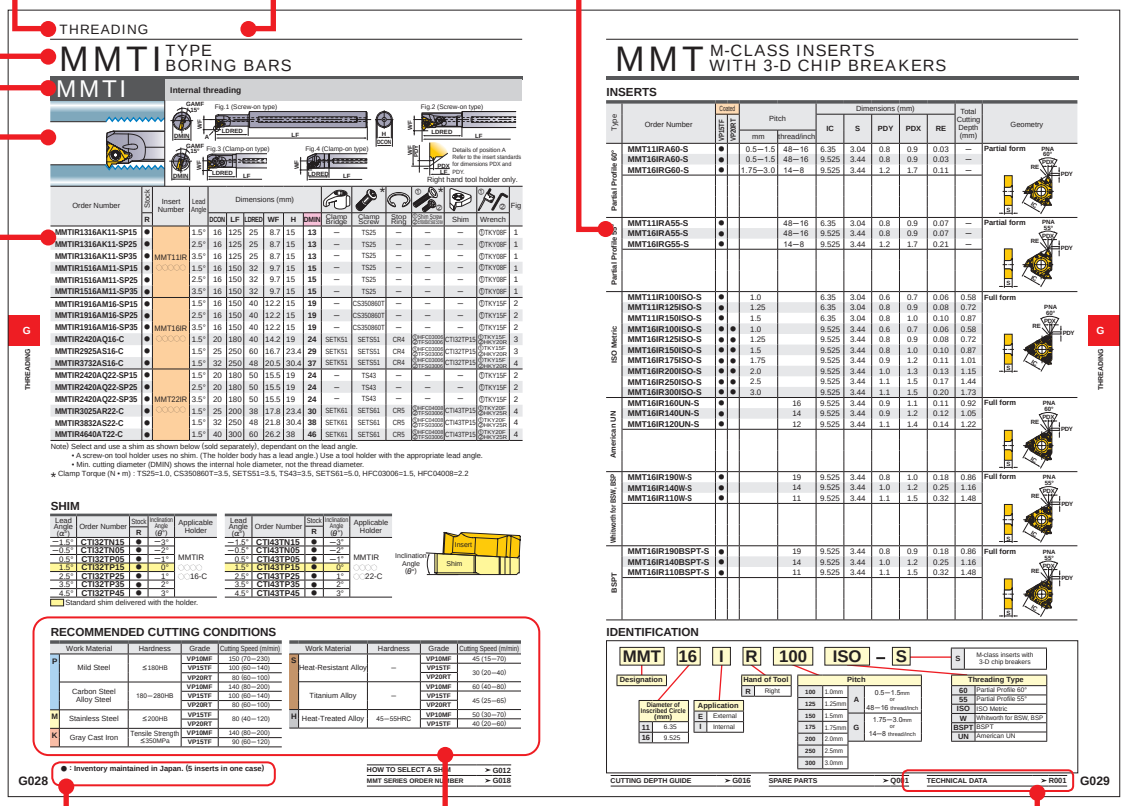
TYPE OF TOOL HOLDER
indicates the initial letters for the order number and cutting applications.

TITLE OF PRODUCT

PRODUCT SECTION

INDICATION OF EXTERNAL /INTERNAL APPLICATION

STANDARDS FOR APPLICABLE INSERTS
indicates stock status, dimensions, etc. for applicable inserts.



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

PAGE REFERENCE ·SPARE PARTS
indicates reference pages, including the above, on the right hand page of each double-page spread.

PRODUCT STANDARDS
indicates order numbers, stock status (per right/left hand), applicable inserts, holder dimensions, and spare parts.

RECOMMENDED CUTTING CONDITIONS
for each work material classification, indicates recommended cutting conditions according to the ISO categories for cutting grades, P, M, K, S, and H.

●To Order : For holder, please specify ①order number and hand of tool (right/left).
For insert, please specify ①insert number and ②grade.

TURNING TOOLS

THREADING

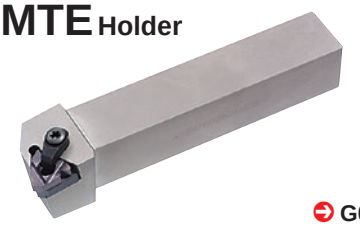
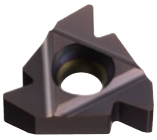
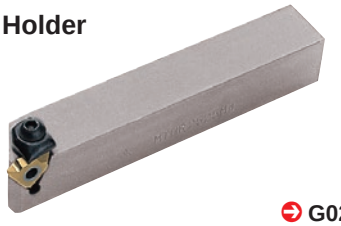
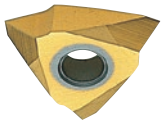
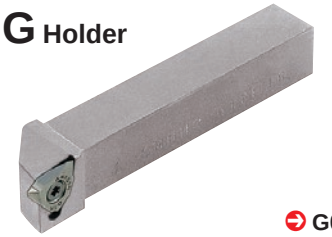
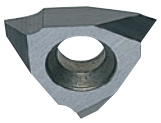
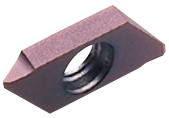
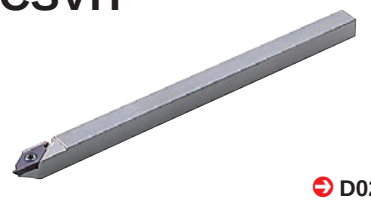
CLASSIFICATION (EXTERNAL THREADING) ···· G002
CLASSIFICATION (INTERNAL THREADING)····· G003
CROSS REFERENCE OF THREAD PITCHES
EXTERNAL ····· G004
INTERNAL ····· G006
STANDARD THREAD AND CORRESPONDING INSERT / HOLDER···· G008

STANDARD OF THREADING TOOLS
MMT SERIES
FEATURES ····· G010
CUTTING CONDITIONS····· G012
STANDARD OF DEPTH OF CUT····· G014
EXTERNAL THREADING
MMTE HOLDER ····· G019
MT HOLDER ····· G024
SMG HOLDER ····· G026
INTERNAL THREADING
MMTI TYPE BORING BARS····· G028
MICRO-MINI TWIN BORING BARS ····· G033
F TYPE BORING BARS····· G036
D TYPE BORING HEAD ····· G038

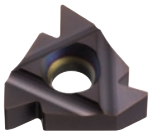
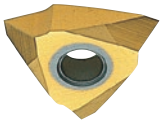
*Arranged by Alphabetical order

G033 **CT**
G038 **DPT2**
G036 **FSL51**
G036 **FSL52**
G037 **MLG (INTERNAL INSERTS)**
G037 **MLT (INTERNAL INSERTS)**
G020 **MMT (EXTERNAL INSERTS)**
G029 **MMT (INTERNAL INSERTS)**
G019 **MMTE**
G028 **MMTI**
G024 **MT1**
G024 **MTH**
G025 **MTT (EXTERNAL INSERTS)**
G039 **MTT (INTERNAL INSERTS)**
G035 **RBH**
G034 **SBH**
G026 **SMGH**
G027 **SMGT (EXTERNAL INSERTS)**
G027 **SMTT (EXTERNAL INSERTS)**

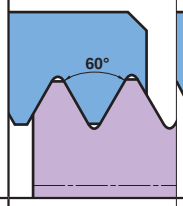
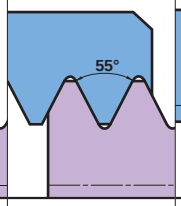
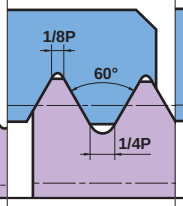
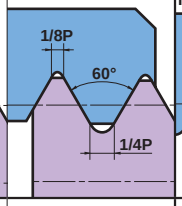
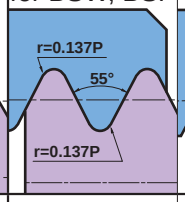
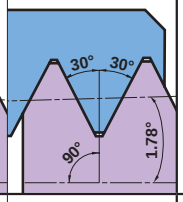
CLASSIFICATION (EXTERNAL THREADING)

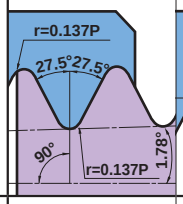
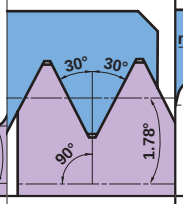
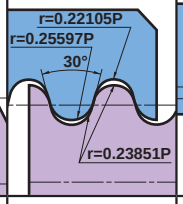
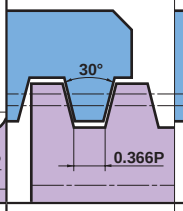
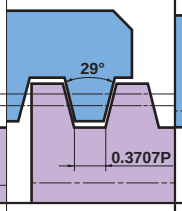
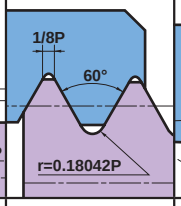
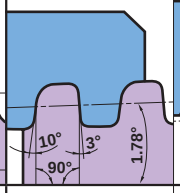
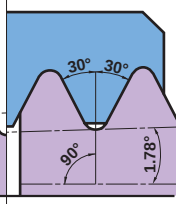
Name of Tool Holder	Insert Shape	Features	Shank Size (H x W x L) (mm)
MMTE Holder  G019		●Various insert types. ●M-class 3-D breaker inserts and G-class ground inserts available. ●Available with a wiper cutting edge to provide a precise thread geometry. ●Able to change lead angle by replacing shim.	12 x 12 x 100 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150 32 x 32 x 170
MT Holder  G024		●Clamp-on type. ●Precision class insert. ●Positive insert suffers from negligible chattering and thus produces good finished surface.	16 x 16 x 100 20 x 20 x 125 25 x 25 x 150 32 x 32 x 170
SMG Holder  G026		●Screw-on type. ●Precision class insert. ●Positive insert suffers from negligible chattering and thus produces good finished surface. ●Holder is capable of performing both threading and grooving.	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150
SMALL TOOLS **TTAH** D024		●Tools to be equipped on Gang type tool posts. ●Small Shank: 8mm–16mm ●High rigidity due to designing of vertical insert. ●The screw designed for common use on front and back enables back clamping. ●Most suitable for threading diameters of 2 mm or smaller. ●Screw-on type.	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120
SMALL TOOLS **CSVH**  D027		●Tools to be equipped on Cam type tool posts. ●Small Shank: 7mm–12mm ●Single holder for front turning, back turning, grooving, threading and cutting off operations. ●The most suitable for machining of small parts with work diameter ϕ5mm or less. ●Screw-on type.	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140

CLASSIFICATION (INTERNAL THREADING)

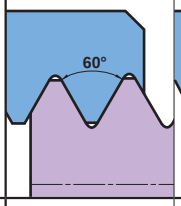
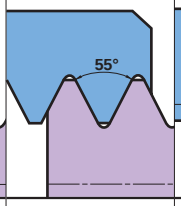
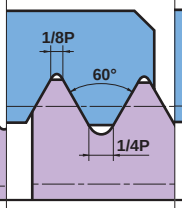
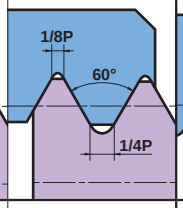
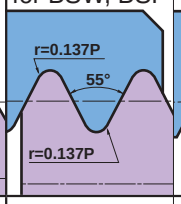
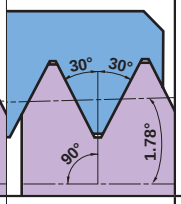
Name of Tool Holder	Insert Shape	Features	Shank Size (Dia. x L x Min. Cutting Dia.) (mm)
MMTI G028		●Minimum cutting diameter 13mm. ●Various insert types. ●M-class 3-D breaker inserts and G-class ground inserts available. ●Available with a wiper cutting edge to provide a precise thread geometry. ●Able to change lead angle by replacing shim.	16 x 125 x 13 16 x 150 x 15 20 x 170 x 24 25 x 200 x 29 32 x 250 x 37 40 x 300 x 46
FSL5 G036		●Minimum cutting diameter 10mm. ●Screw-on type. ●Precision class insert. ●Applicable for threading, grooving and boring. ●Available with a carbide shank to prevent vibration when machining deep holes.	8 x 125 x 10 10 x 150 x 12 12 x 180 x 14 14 x 180 x 16 16 x 200 x 20
DPT2 G038		●Minimum cutting diameter 40mm. ●Pin lock type. ●Precision class insert. ●Exchangeable head type.	32 x 300 x 40 40 x 360 x 50
MICRO-MINI TWIN Boring Bars G033	–	●Minimum cutting diameter 3mm. ●Solid carbide type. ●Economical two cutting edge type.	3 x 50 x 3 4 x 60 x 4.5 5 x 70 x 6 6 x 75 x 7
MICRO-MINI Boring Bars E022	–	●Minimum cutting diameter 3.2mm. ●Solid carbide type. ●Insert can be ground to suit the application.	3 x 80 x 3.2 4 x 80 x 4.2 5 x 100 x 5.2

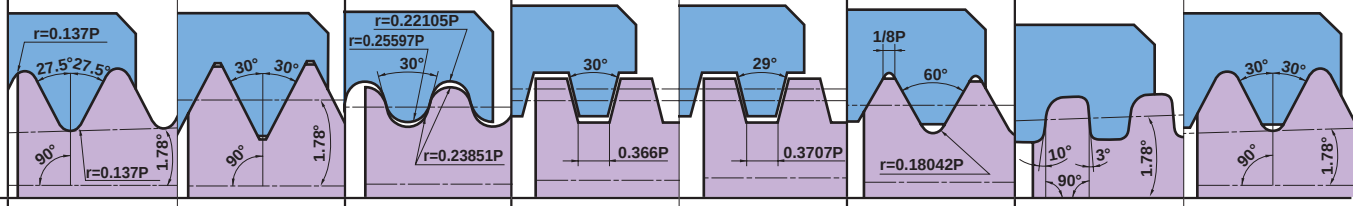
CROSS REFERENCE OF THREAD PITCHS (EXTERNAL)

Application		General machining				Pipe fittings and couplings for gas and water	
Type		Partial Profile 60°	Partial Profile 55°	ISO Metric	American UN	Parallel Pipe Thread Whitworth for BSW, BSP	American NPT
							
Symbol		M UNC UNF	W	M	UNC UNF	G(PF) Rp(PS) W	NPT
Holder	Pitch	mm (thread/inch)	thread/inch	mm	thread/inch	thread/inch	thread/inch
MMT Holder G019	Full form	–	–	0.5–5.0	32–5	28–5	27, 18, 14 11.5, 8
	Partial form	0.5–5.0 (48–5)	48–5	0.5–5.0	48–5	–	–
MT Holder G024	Partial form	0.25–4.5 (64–6)	20–9	0.25–4.5	64–6	–	–
SMG Holder G026	Partial form	0.25–2.0 (48–13)	–	0.25–2.0	48–13	–	–

	Steam, gas and water line pipes		Pipe couplings for food and fire fighting industries	Motion transmissions		Aircraft and aerospace	Oil and gas	
	Taper Pipe Thread BSPT	American NPTF	Round DIN 405	ISO Trapezoidal 30°	American ACME	UNJ	API Buttress Casing	API Round Casing&Tubing
								
	R(PT) Rc(PT) Rp	NPTF	Rd	Tr (TM)	ACME (Tw)	UNJ	BCSG	CSG LCSG
	thread/inch	thread/inch	thread/inch	mm	thread/inch	thread/inch	thread/inch	thread/inch
	28, 19 14, 11	27, 18, 14 11.5, 8	10, 8 6, 4	1.5, 2 3, 4, 5	12, 10 8, 6, 5	32—8	5	10, 8
	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–

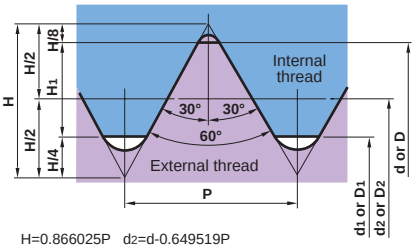
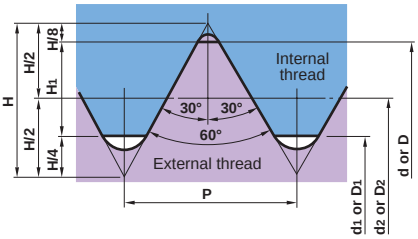
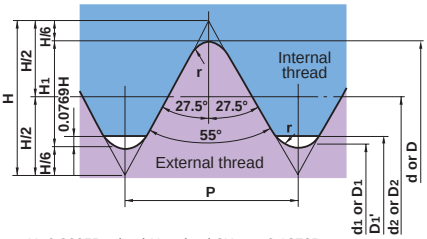
CROSS REFERENCE OF THREAD PITCHS (INTERNAL)

Application		General machining				Pipe fittings and couplings for gas and water	
Type		Partial Profile 60°	Partial Profile 55°	ISO Metric	American UN	Parallel Pipe Thread Whitworth for BSW, BSP	American NPT
							
Symbol		M UNC UNF	W	M	UNC UNF	G(PF) Rp(PS) W	NPT
Holder	Pitch	mm (thread/inch)	thread/inch	mm	thread/inch	thread/inch	thread/inch
MMT **Boring Bars** G028	Full form	–	–	0.5–5.0	32–5	28–5	27, 18, 14 11.5, 8
	Partial form	0.5–5.0 (48–5)	48–5	0.5–5.0	48–5	–	–
FSL5 **Boring Bars** G036	Partial form	1.5–3.5 (16–8)	–	1.5–3.5	16–8	–	–
DPT2 **Boring Head** G038	Partial form	1.0–3.5	–	1.0–3.5	–	–	–
MICRO-MINI TWIN G033	Partial form	0.5–1.75 (36–16)	–	0.5–1.75	36–16	–	–

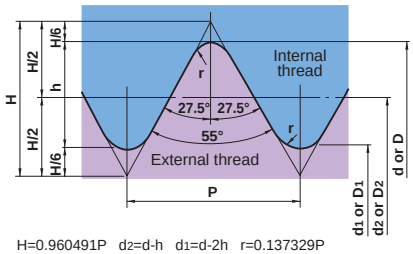
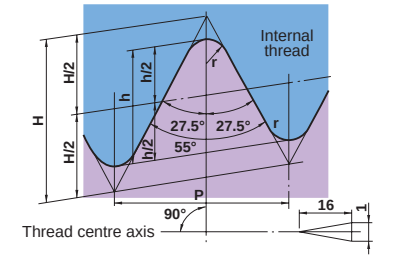
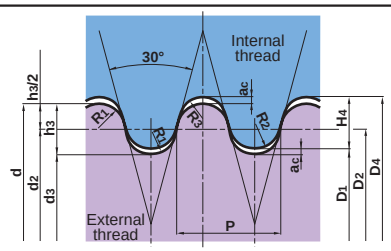
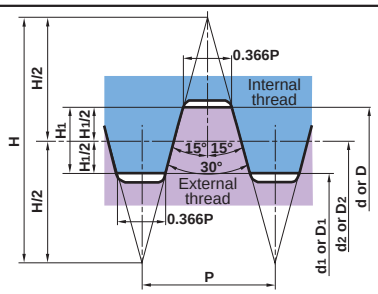
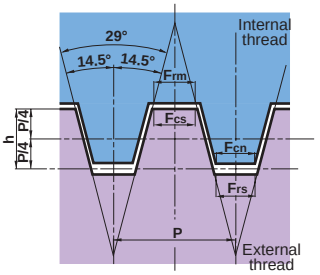
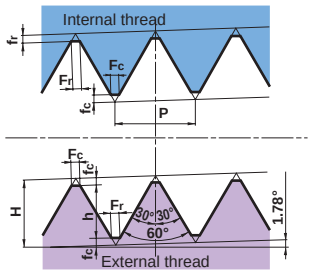
	Steam, gas and water line pipes		Pipe couplings for food and fire fighting industries	Motion transmissions		Aircraft and aerospace	Oil and gas	
	Taper Pipe Thread BSPT	American NPTF	Round DIN 405	ISO Trapezoidal 30°	American ACME	UNJ	API Buttress Casing	API Round Casing&Tubing
								
	R(PT) Rc(PT) Rp	NPTF	Rd	Tr (TM)	ACME (Tw)	UNJ	BCSG	CSG LCSG
	thread/inch	thread/inch	thread/inch	mm	thread/inch	thread/inch	thread/inch	thread/inch
	19, 14, 11	14, 11.5, 8	10, 8 6, 4	1.5, 2 3, 4, 5	12, 10 8, 6, 5	–	5	10, 8
	–	–	–	–	–	* –	–	–
	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–
	–	–	–	–	–	–	–	–

* When machining an internal UNJ thread, cut an internal hole with the appropriate diameter. Then machine with 60° American UN. In this case, a full form type insert cannot be used.

STANDARD THREAD AND CORRESPONDING INSERT / HOLDER

Thread Name	Standard Thread Type	Type	Ext./Int.	Insert Number	Wiper/ General	Tool Holder	Page
ISO Metric	 H=0.866025P d2=d-0.649519P H1=0.541266P d1=d-1.082532P D=d D2=d2 D1=d1	M	Ext.	MMT○○ER○○○ISO	Wiper	MMTER○○○○○-C	G019
				MMT○○ER○○○ISO-S	Wiper		
				MMT○○ER○○○60	General		
				MMT○○ER○○○60-S	General		
				SMTTR/L160360○○	General	SMGHR/L○○○○16	G026
				MTTR/L4360○○	General	MTHR/L○○○○○4 MT1R/L○○○○○4	G024
			Int.	MMT○○IR○○○ISO	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
				MMT○○IR○○○ISO-S	Wiper		
				MMT○○IR○○○60	General		
				MMT○○IR○○○60-S	General		
				MTTR/L4360○○	General	DPT2○○○R	G038
American UN	 H=0.866025×25.4/n d2=(d-0.649519/n)×25.4 H1=0.541266×25.4/n d1=(d-1.082532/n)×25.4 d=(d)×25.4 D=d D2=d2 D1=d1 P=25.4/thread	UNC UNF	Ext.	MMT○○ER○○○UN	Wiper	MMTER○○○○○-C	G019
				MMT○○ER○○○UN-S	Wiper		
				MMT○○ER○○○60	General		
				MMT○○ER○○○60-S	General		
				SMTTR/L160360○○	General	SMGHR/L○○○○16	G026
				MTTR/L4360○○	General	MTHR/L○○○○○4 MT1R/L○○○○○4	G024
			Int.	MMT○○IR○○○UN	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
				MMT○○IR○○○UN-S	Wiper		
				MMT○○IR○○○60	General		
				MMT○○IR○○○60-S	General		
				MTTR/L4360○○	General	DPT2○○○R	G038
Whitworth for BSW, BSP	 H=0.9605P d2=d-H1 d1=d-2H1 r=0.1373P H1=0.6403P D1'=d1+2×0.0769H D=d D2=d2 D1=d1 P=25.4/thread	W	Ext.	MMT○○ER○○○W	Wiper	MMTER○○○○○-C	G019
				MMT○○ER○○○W-S	Wiper		
				MMT○○ER○○○55	General		
				MMT○○ER○○○55-S	General		
				MTTR/L4355○○	General	MTHR/L○○○○○4 MT1R/L○○○○○4	G024
			Int.	MMT○○IR○○○W	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
				MMT○○IR○○○W-S	Wiper		
				MMT○○IR○○○55	General		
				MMT○○IR○○○55-S	General		
				MTTR/L4355○○	General	DPT2○○○R	G038

Wiper : Insert order number is determined by selected pitch.
General : An insert is applicable to several pitch types.

Thread Name	Standard Thread Type	Type	Ext./Int.	Insert Number	Wiper/ General	Tool Holder	Page
Parallel Pipe Thread	 H=0.960491P d2=d-h d1=d-2h r=0.137329P h=0.640327 D=d D2=d2 D1=d1 25.4/thread	PF G Rp	Ext.	MMT○○ER○○○W	Wiper	MMTER○○○○○-C	G019
				MMT○○ER○○○W-S	Wiper		
			Int.	MMT○○IR○○○W	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
				MMT○○IR○○○W-S	Wiper		
BSPT	 H=0.960237P h=0.640327 r=0.137278P P=25.4/thread	BSPT	Ext.	MMT○○ER○○○BSPT	Wiper	MMTER○○○○○-C	G019
				MMT○○ER○○○BSPT-S	Wiper		
			Int.	MMT○○IR○○○BSPT	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
				MMT○○IR○○○BSPT-S	Wiper		
Round DIN 405	 ac=0.05×P h3=H4=0.5×P R1=0.238507×P R2=0.255967×P R3=0.221047×P	Rd	Ext.	MMT○○ER○○○RD	Wiper	MMTER○○○○○-C	G019
			Int.	MMT○○IR○○○RD	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
ISO Trapezoidal 30°		Tr	Ext.	MMT○○ER○○○TR	Wiper	MMTER○○○○○-C	G019
			Int.	MMT○○IR○○○TR	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
American ACME		ACME	Ext.	MMT○○ER○○○ACME	Wiper	MMTER○○○○○-C	G019
			Int.	MMT○○IR○○○TACME	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028
American NPT	 H=0.866025P h=0.800000p	NPT	Ext.	MMT○○ER○○○NPT	Wiper	MMTER○○○○○-C	G019
			Int.	MMT○○IR○○○NPT	Wiper	MMTIR○○A○○○-SP○ MMTIR○○A○16-C	G028

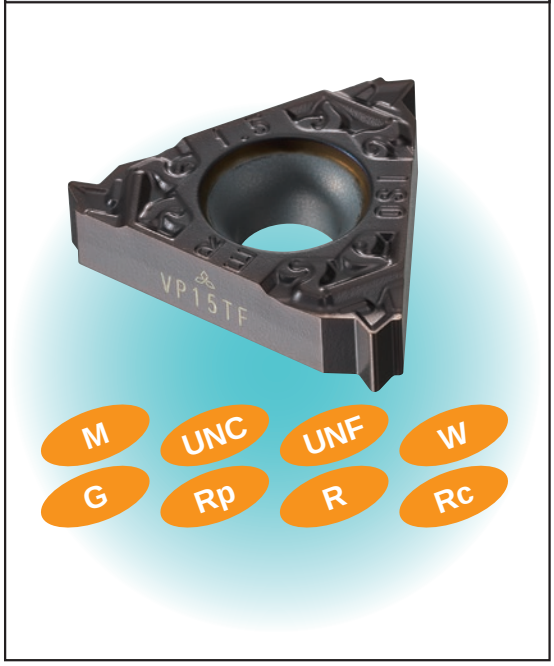
Wiper : Insert order number is determined by selected pitch.
General : An insert is applicable to several pitch types.

FEATURES OF MMT SERIES

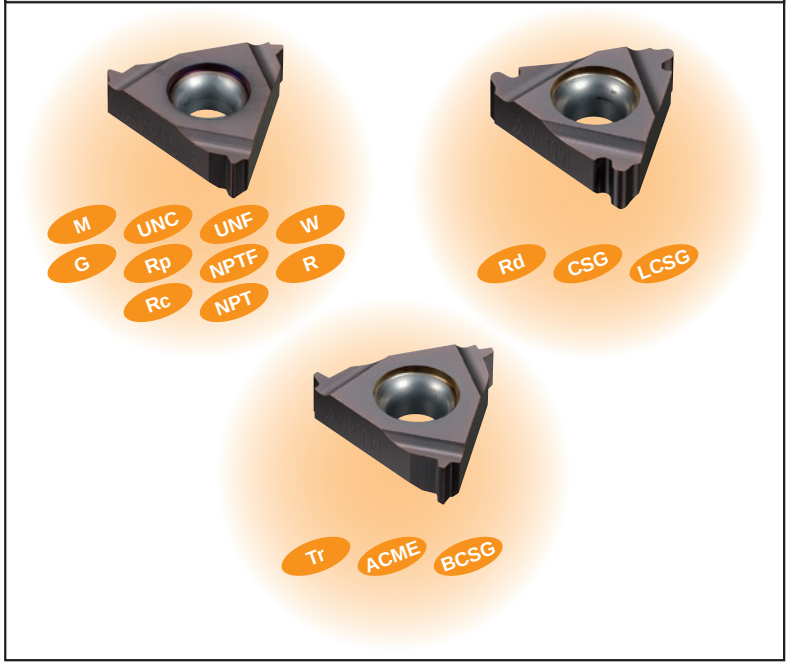
■A WIDE VARIETY OF PRODUCTS

Mitsubishi Miracle Threading (MMT) series. 283 inserts and 26 holders.

M-CLASS INSERTS WITH 3-D CHIP BREAKERS



G-CLASS GROUND INSERTS

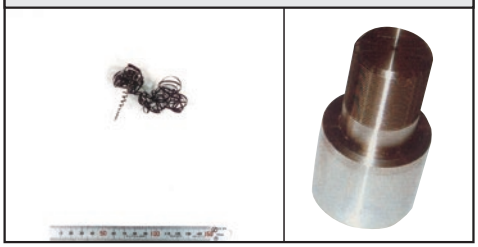


■IDEAL CHIP CONTROL EVEN IN THE LATTER HALF OF PASSES WHEN CONTINUOUS CHIPS ARE USUALLY PRODUCED. (M-CLASS INSERTS WITH 3-D CHIP BREAKERS)

ISO metric external thread pitch 1.5mm Final pass (6th pass)

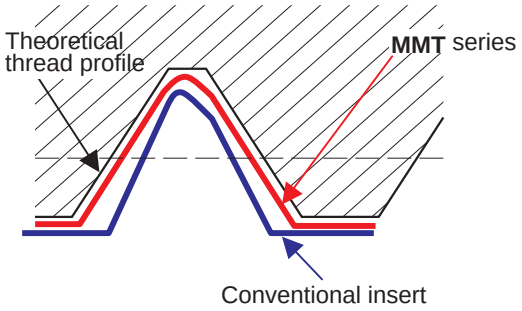
Conventional

MMT



<Cutting Conditions>
Workpiece : JIS SCM440
Insert : MMT16ER150ISO-S
Grade : VP15TF
Cutting speed : 120m/min
Cutting method : Radial Infeed
Depth of cut : Fixed cut area
Pass : 6 times
Coolant : Wet

■A HIGHER LEVEL OF PRECISION THAN CONVENTIONAL INSERTS (G-CLASS GROUND INSERTS)

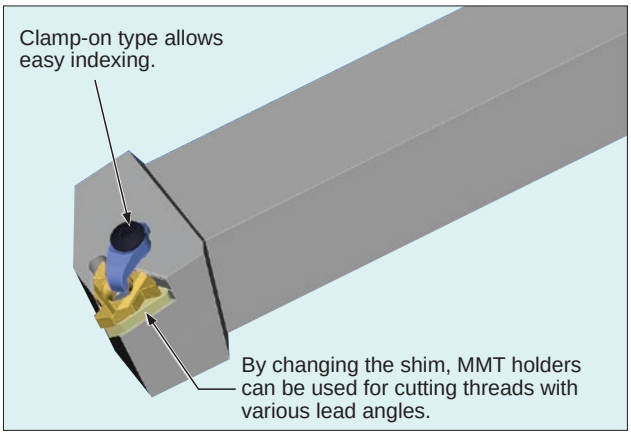


High precision threading can be achieved by using MMT inserts that feature a ground rake face and peripheral cutting edge.

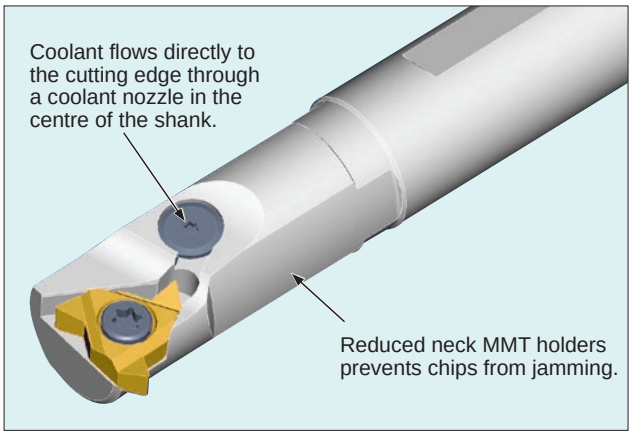
Thread Type	Threading Tolerance
ISO Metric	6g / 6H
American UN	2A / 2B
Whitworth for BSW, BSP	Medium Class A
BSPT	Standard BSPT
Round DIN 405	7h / 7H
ISO Trapezoidal 30°	7e / 7H
American ACME	3G
UNJ	3A
API Buttress Casing	Standard API
API Rounded Casing & Tubing	Standard API RD
American NPT	Standard NPT
American NPTF	Class2

■HOLDER (Use of special surface treatment)

External

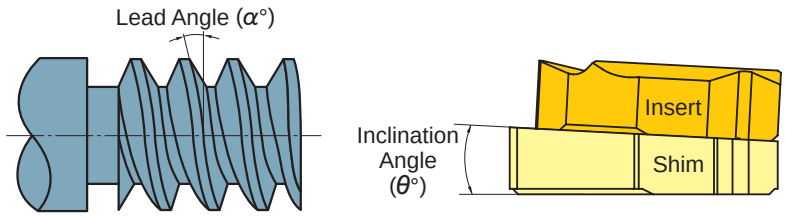


Internal



* Order number of coolant guide screw: TFS03006 (Except MMTIR1316/MMTIR1516)

■SUITABLE FOR THREADING WITH A LARGE LEAD ANGLE



By changing only the shim, MMT holders can be used for turning of threads with various lead angles as well as the turning of left hand threads.

Lead Angle (α°)	Inclination Angle (θ°)
−1.5°	−3°
−0.5°	−2°
0.5°	−1°
1.5°	0°
2.5°	1°
3.5°	2°
4.5°	3°

Standard shim delivered with the holder.

■GRADE

VP10MF (G-class ground insert only)

●Superior wear and plastic deformation resistance

- High wear and plastic deformation resistance for threading when maintaining the thread form is important. Suitable for continuous high precision machining with extensive tool life.
- Effective in combination with G-class inserts for high precision threading.

VP15TF (G-class ground insert, M-class insert with 3-D chip breakers)

●Wide versatility

- High fracture resistance during low rigidity applications such as bar feed machining. Able to withstand harsh conditions for long periods where conventional inserts would be liable to breakage.
- Effective combination of high cost performance M-class inserts with 3-D chip breakers.

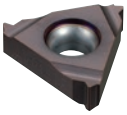
VP20RT (M-class insert with 3-D chip breakers)

●Excellent fracture resistance

- Suitable for stainless steel boring and unstable machining where inserts are vulnerable to fracturing.
- Effective combination of high cost performance M-class inserts with 3-D chip breakers.

■CHOOSING M-CLASS INSERTS WITH 3-D CHIP BREAKERS OR G-CLASS INSERTS

Insert	Chip control	Precision of thread
M-class inserts with 3-D chip breakers	◎	○

Insert	Chip control	Precision of thread
G-class inserts 	○	◎

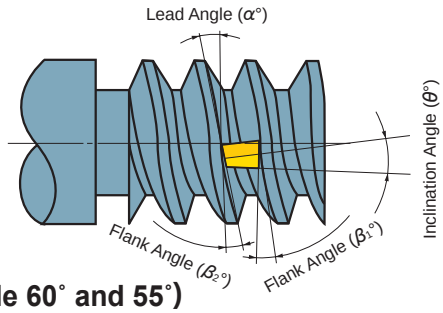
- For ideal chip control and a high cost performance ratio, M-class inserts with 3-D chip breakers are recommended.
- G-class inserts are recommended where higher precision is required.

CUTTING CONDITIONS OF MMT SERIES

SELECTING A SHIM FOR THE MMT SERIES

■FLANK ANGLE AND LEAD ANGLE

Lead angle (α) depends on a combination of thread diameter and pitch. Select a shim so that the lead angle of the thread can coincide with the flank angles of the thread and insert (β_1, β_2). No need to change a shim for general threading with an MMT holder. When threading with a small diameter or large pitch, change the shim depending on the lead angle, referring to the table and graph below. When threading left hand threads, change to a shim with a negative inclination angle.



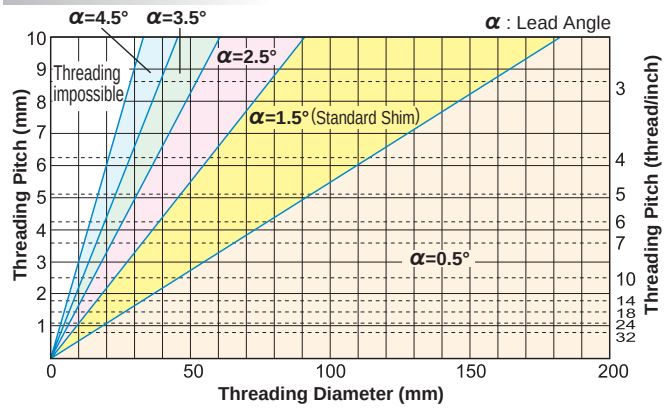
■SHIM REFERENCE TABLE (THREADING DIAMETER) (Thread angle 60˚ and 55˚)

Lead Angle / Pitch (mm)	Right Hand Thread (mm)						Left Hand Thread (mm) *		
	Threading impossible	4.5°	3.5°	2.5°	1.5°	0.5°	Threading impossible	−1.5°	−0.5°
0.5	≤ϕ1.7	ϕ1.7 − ϕ2.3	ϕ2.3 − ϕ3.0	ϕ3.0 − ϕ4.6	ϕ4.6 − ϕ9.1	≥ϕ9.1	≤ϕ3.6	ϕ3.6 − ϕ9.1	≥ϕ9.1
0.75	≤ϕ2.5	ϕ2.5 − ϕ3.4	ϕ3.4 − ϕ4.6	ϕ4.6 − ϕ6.8	ϕ6.8 − ϕ13.7	≥ϕ13.7	≤ϕ5.5	ϕ5.5 − ϕ13.7	≥ϕ13.7
1	≤ϕ3.3	ϕ3.3 − ϕ4.6	ϕ4.6 − ϕ6.1	ϕ6.1 − ϕ9.1	ϕ9.1 − ϕ18.2	≥ϕ18.2	≤ϕ7.3	ϕ7.3 − ϕ18.2	≥ϕ18.2
1.25	≤ϕ4.1	ϕ4.1 − ϕ5.7	ϕ5.7 − ϕ7.6	ϕ7.6 − ϕ11.4	ϕ11.4 − ϕ22.8	≥ϕ22.8	≤ϕ9.1	ϕ9.1 − ϕ22.8	≥ϕ22.8
1.5	≤ϕ5.0	ϕ5.0 − ϕ6.8	ϕ6.8 − ϕ9.1	ϕ9.1 − ϕ13.7	ϕ13.7 − ϕ27.4	≥ϕ27.4	≤ϕ10.9	ϕ10.9 − ϕ27.4	≥ϕ27.4
1.75	≤ϕ5.8	ϕ5.8 − ϕ8.0	ϕ8.0 − ϕ10.6	ϕ10.6 − ϕ16.0	ϕ16.0 − ϕ31.9	≥ϕ31.9	≤ϕ12.8	ϕ12.8 − ϕ31.9	≥ϕ31.9
2	≤ϕ6.6	ϕ6.6 − ϕ9.1	ϕ9.1 − ϕ12.1	ϕ12.1 − ϕ18.2	ϕ18.2 − ϕ36.5	≥ϕ36.5	≤ϕ14.6	ϕ14.6 − ϕ36.5	≥ϕ36.5
2.5	≤ϕ8.3	ϕ8.3 − ϕ11.4	ϕ11.4 − ϕ15.2	ϕ15.2 − ϕ22.8	ϕ22.8 − ϕ45.6	≥ϕ45.6	≤ϕ18.2	ϕ18.2 − ϕ45.6	≥ϕ45.6
3	≤ϕ9.9	ϕ9.9 − ϕ13.7	ϕ13.7 − ϕ18.2	ϕ18.2 − ϕ27.3	ϕ27.3 − ϕ54.7	≥ϕ54.7	≤ϕ21.9	ϕ21.9 − ϕ54.7	≥ϕ54.7
3.5	≤ϕ11.6	ϕ11.6 − ϕ15.9	ϕ15.9 − ϕ21.3	ϕ21.3 − ϕ31.9	ϕ31.9 − ϕ63.8	≥ϕ63.8	≤ϕ25.5	ϕ25.5 − ϕ63.8	≥ϕ63.8
4	≤ϕ13.2	ϕ13.2 − ϕ18.2	ϕ18.2 − ϕ24.3	ϕ24.3 − ϕ36.5	ϕ36.5 − ϕ72.9	≥ϕ72.9	≤ϕ29.2	ϕ29.2 − ϕ72.9	≥ϕ72.9
4.5	≤ϕ14.9	ϕ14.9 − ϕ20.5	ϕ20.5 − ϕ27.3	ϕ27.3 − ϕ41.0	ϕ41.0 − ϕ82.1	≥ϕ82.1	≤ϕ32.8	ϕ32.8 − ϕ82.1	≥ϕ82.1
5	≤ϕ16.5	ϕ16.5 − ϕ22.8	ϕ22.8 − ϕ30.4	ϕ30.4 − ϕ45.6	ϕ45.6 − ϕ91.2	≥ϕ91.2	≤ϕ36.5	ϕ36.5 − ϕ91.2	≥ϕ91.2

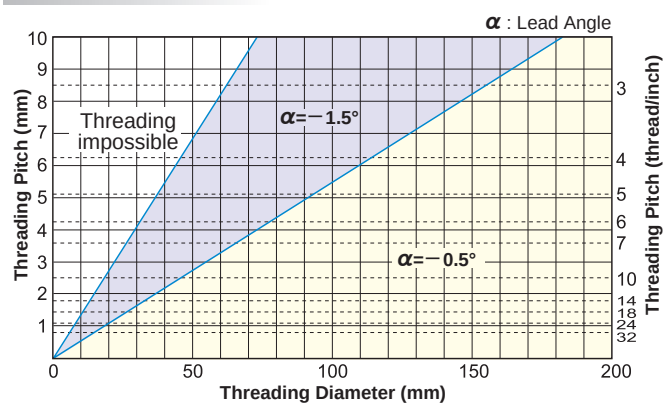
* Back turning in the case of left hand threads.

■SHIM REFERENCE GRAPH (Thread angle 60˚ and 55˚)

Right Hand Thread



Left Hand Thread



Note 1) When a thread lead angle ≤ the tool flank angle, change the shim to prevent side interference with the insert.
(Refer to the table on page G013 for the calculation of thread lead angle and tool flank angle.)

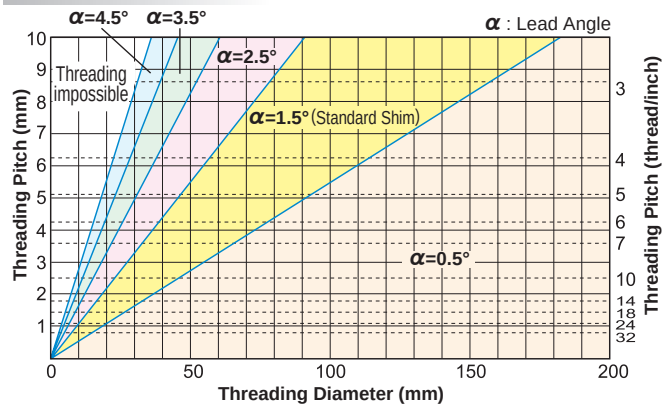
■SHIM REFERENCE TABLE (THREADING DIAMETER) (Thread angle 30˚ and 29˚)

Lead Angle / Pitch (mm)	Right Hand Thread (mm)						Left Hand Thread (mm) *		
	Threading impossible	4.5°	3.5°	2.5°	1.5°	0.5°	Threading impossible	−1.5°	−0.5°
0.5	≤ϕ1.8	ϕ1.8 − ϕ2.3	ϕ2.3 − ϕ3.0	ϕ3.0 − ϕ4.6	ϕ4.6 − ϕ9.1	≥ϕ9.1	≤ϕ4.6	ϕ4.6 − ϕ9.1	≥ϕ9.1
0.75	≤ϕ2.7	ϕ2.7 − ϕ3.4	ϕ3.4 − ϕ4.6	ϕ4.6 − ϕ6.8	ϕ6.8 − ϕ13.7	≥ϕ13.7	≤ϕ6.8	ϕ6.8 − ϕ13.7	≥ϕ13.7
1	≤ϕ3.6	ϕ3.6 − ϕ4.6	ϕ4.6 − ϕ6.1	ϕ6.1 − ϕ9.1	ϕ9.1 − ϕ18.2	≥ϕ18.2	≤ϕ9.1	ϕ9.1 − ϕ18.2	≥ϕ18.2
1.25	≤ϕ4.5	ϕ4.5 − ϕ5.7	ϕ5.7 − ϕ7.6	ϕ7.6 − ϕ11.4	ϕ11.4 − ϕ22.8	≥ϕ22.8	≤ϕ11.4	ϕ11.4 − ϕ22.8	≥ϕ22.8
1.5	≤ϕ5.5	ϕ5.5 − ϕ6.8	ϕ6.8 − ϕ9.1	ϕ9.1 − ϕ13.7	ϕ13.7 − ϕ27.4	≥ϕ27.4	≤ϕ13.7	ϕ13.7 − ϕ27.4	≥ϕ27.4
1.75	≤ϕ6.4	ϕ6.4 − ϕ8.0	ϕ8.0 − ϕ10.6	ϕ10.6 − ϕ16.0	ϕ16.0 − ϕ31.9	≥ϕ31.9	≤ϕ16.0	ϕ16.0 − ϕ31.9	≥ϕ31.9
2	≤ϕ7.3	ϕ7.3 − ϕ9.1	ϕ9.1 − ϕ12.1	ϕ12.1 − ϕ18.2	ϕ18.2 − ϕ36.5	≥ϕ36.5	≤ϕ18.2	ϕ18.2 − ϕ36.5	≥ϕ36.5
2.5	≤ϕ9.1	ϕ9.1 − ϕ11.4	ϕ11.4 − ϕ15.2	ϕ15.2 − ϕ22.8	ϕ22.8 − ϕ45.6	≥ϕ45.6	≤ϕ22.8	ϕ22.8 − ϕ45.6	≥ϕ45.6
3	≤ϕ10.9	ϕ10.9 − ϕ13.7	ϕ13.7 − ϕ18.2	ϕ18.2 − ϕ27.3	ϕ27.3 − ϕ54.7	≥ϕ54.7	≤ϕ27.3	ϕ27.3 − ϕ54.7	≥ϕ54.7
3.5	≤ϕ12.7	ϕ12.7 − ϕ15.9	ϕ15.9 − ϕ21.3	ϕ21.3 − ϕ31.9	ϕ31.9 − ϕ63.8	≥ϕ63.8	≤ϕ31.9	ϕ31.9 − ϕ63.8	≥ϕ63.8
4	≤ϕ14.6	ϕ14.6 − ϕ18.2	ϕ18.2 − ϕ24.3	ϕ24.3 − ϕ36.5	ϕ36.5 − ϕ72.9	≥ϕ72.9	≤ϕ36.5	ϕ36.5 − ϕ72.9	≥ϕ72.9
4.5	≤ϕ16.4	ϕ16.4 − ϕ20.5	ϕ20.5 − ϕ27.3	ϕ27.3 − ϕ41.0	ϕ41.0 − ϕ82.1	≥ϕ82.1	≤ϕ41.0	ϕ41.0 − ϕ82.1	≥ϕ82.1
5	≤ϕ18.2	ϕ18.2 − ϕ22.8	ϕ22.8 − ϕ30.4	ϕ30.4 − ϕ45.6	ϕ45.6 − ϕ91.2	≥ϕ91.2	≤ϕ45.6	ϕ45.6 − ϕ91.2	≥ϕ91.2

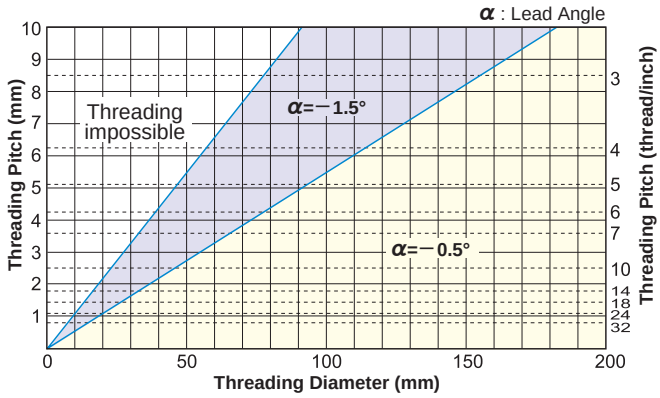
* Back turning in the case of left hand threads.

■SHIM REFERENCE GRAPH (Thread angle 30˚ and 29˚)

Right Hand Thread



Left Hand Thread



Note 1) When a thread lead angle ≤ the tool flank angle, change the shim to prevent side interference with the insert.
(Refer to the table below for the calculation of thread lead angle and tool flank angle.)

■ Selection table

Lead Angle	Opening angle 60°/55° Right Hand Thread		Opening angle 60°/55°* Left Hand Thread		Opening angle 30°/29° Right Hand Thread		Opening angle 30°/29°* Left Hand Thread	
0	P05	P05	N05	N05	P05	P05	N05	N05
0.5	P05	P05	N05	N05	P05	P05	N05	N05
1	P15	P15	N15	N15	P15	P15	N15	N15
1.5	P15	P15	N15	N15	P15	P15	N15	N15
2	P25	P25	N15	N15	P25	P25	Compatible	Compatible
2.5	P25	P25	Compatible	Compatible	P25	P25	Compatible	Compatible
3	P35	P35	Compatible	Compatible	P35	P35	Compatible	Compatible
3.5	P35	P35	Compatible	Compatible	P35	P35	Compatible	Compatible
4	P45	P45	Compatible	Compatible	P45	P45	Compatible	Compatible
4.5	P45	P45	Compatible	Compatible	P45	P45	Compatible	Compatible
5	P45	P45	Compatible	Compatible	Compatible	Compatible	Compatible	Compatible
5.5	Compatible	Compatible	Compatible	Compatible	Compatible	Compatible	Compatible	Compatible

* Back turning in the case of left hand threads.

When replacing a shim, check if the difference between the thread lead angle and shim inclination angle is within:
2.5°−0.5° where thread helix angle is 60° (55°)
2°−1° where thread helix angle is 30° (29°)
*** Inclination angle of a standard shim is 0°.**
*** The holder has a 1.5° lead angle.**

■CALCULATION OF THREAD LEAD ANGLE

$$\tan\alpha = \frac{l}{\pi d} = \frac{nP}{\pi d}$$

α: Lead angle
l : Lead
n : Number of threads
P : Pitch
d : Effective diameter of thread

■EXAMPLE OF SELECTING A SHIM

- When the thread lead angle is 2.2°

①In the case when the thread helix angle is 60°
(2.2° lead angle) − (2.5−0.5°) = -0.3°−1.7° shim inclination angle is appropriate.
Threading with a standard shim (0° inclination angle) is possible. But, replacing with a shim with a 1° inclination angle is recommended, refer to Standard Shim List on pages G019 and G028.

②In the case when the thread helix angle is 30°
(2.2° lead angle) − (2−1°) = -0.2°−1.2° shim inclination angle is appropriate.
Replacing with a shim with a 1° inclination angle is recommended, referring to Standard Shim List on pages G019 and G028.

■RELIEF ANGLE OF AN INSERT SET ON A HOLDER

Thread Helix Angle	Internal Relief Angle	External Relief Angle
60°	8.8°	5.8°
55°	7.9°	5.2°
30°	4.1°	2.7°
29°	4°	2.6°

- Relief angles (β_2, β_1) of an insert become small when the thread helix angle of a trapezoidal, round, or other thread is small. Take care when selecting a shim.

*** Please refer to the "Calculation of Thread Lead Angle" on the website from given QR Code.**

http://www.mitsubishicarbide.com/index.php?cID=2884

MMT STANDARD OF DEPTH OF CUT EXTERNAL (RADIAL INFEED)

■ ISO Metric

Pitch (mm)	Total Cutting Depth	Number of Passes														Insert Type	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts	M-class inserts with 3-D chip breakers
0.5	0.31	0.10	0.08	0.07	0.06											MMT16ER050ISO	—
0.75	0.46	0.16	0.14	0.10	0.06											MMT16ER075ISO	—
1.0	0.61	0.18	0.15	0.12	0.10	0.06										MMT16ER100ISO	MMT16ER100ISO-S
1.25	0.77	0.19	0.17	0.14	0.11	0.10	0.06									MMT16ER125ISO	MMT16ER125ISO-S
1.5	0.92	0.22	0.21	0.17	0.14	0.12	0.06									MMT16ER150ISO	MMT16ER150ISO-S
1.75	1.07	0.22	0.21	0.16	0.13	0.11	0.09	0.09	0.06							MMT16ER175ISO	MMT16ER175ISO-S
2.0	1.23	0.24	0.23	0.17	0.16	0.14	0.12	0.11	0.06							MMT16ER200ISO	MMT16ER200ISO-S
2.5	1.53	0.26	0.23	0.19	0.17	0.15	0.13	0.12	0.11	0.11	0.06					MMT16ER250ISO	MMT16ER250ISO-S
3.0	1.84	0.27	0.25	0.20	0.18	0.16	0.14	0.13	0.12	0.12	0.11	0.10	0.06			MMT16ER300ISO	MMT16ER300ISO-S
3.5	2.15	0.33	0.30	0.24	0.21	0.18	0.17	0.15	0.14	0.14	0.12	0.11	0.06			MMT22ER350ISO	—
4.0	2.45	0.34	0.31	0.24	0.22	0.19	0.17	0.16	0.14	0.14	0.13	0.12	0.12	0.11	0.06	MMT22ER400ISO	—
4.5	2.76	0.38	0.34	0.28	0.24	0.22	0.20	0.18	0.16	0.16	0.15	0.14	0.13	0.12	0.06	MMT22ER450ISO	—
5.0	3.07	0.42	0.38	0.32	0.27	0.24	0.22	0.20	0.18	0.18	0.17	0.16	0.15	0.12	0.06	MMT22ER500ISO	—

■ American UN

Pitch (thread/inch)	Total Cutting Depth	Number of Passes														Insert Type	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts	M-class inserts with 3-D chip breakers
32	0.49	0.17	0.15	0.11	0.06											MMT16ER320UN	—
28	0.56	0.17	0.14	0.10	0.09	0.06										MMT16ER280UN	—
24	0.65	0.18	0.16	0.14	0.11	0.06										MMT16ER240UN	—
20	0.78	0.20	0.18	0.13	0.11	0.10	0.06									MMT16ER200UN	—
18	0.87	0.22	0.20	0.15	0.13	0.11	0.06									MMT16ER180UN	—
16	0.97	0.22	0.20	0.15	0.12	0.11	0.11	0.06								MMT16ER160UN	MMT16ER160UN-S
14	1.11	0.23	0.21	0.16	0.13	0.11	0.11	0.10	0.06							MMT16ER140UN	MMT16ER140UN-S
13	1.20	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.06							MMT16ER130UN	—
12	1.30	0.28	0.23	0.18	0.16	0.14	0.13	0.12	0.06							MMT16ER120UN	MMT16ER120UN-S
11	1.42	0.28	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.06						MMT16ER110UN	—
10	1.56	0.28	0.24	0.19	0.16	0.14	0.13	0.13	0.12	0.11	0.06					MMT16ER100UN	—
9	1.73	0.34	0.29	0.22	0.17	0.15	0.14	0.13	0.12	0.11	0.06					MMT16ER090UN	—
8	1.95	0.35	0.30	0.24	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06				MMT16ER080UN	—
7	2.22	0.37	0.33	0.28	0.24	0.20	0.17	0.16	0.15	0.14	0.12	0.06				MMT22ER070UN	—
6	2.60	0.42	0.35	0.29	0.25	0.21	0.18	0.17	0.16	0.15	0.13	0.12	0.11	0.06		MMT22ER060UN	—
5	3.12	0.43	0.39	0.31	0.27	0.24	0.22	0.20	0.19	0.19	0.18	0.17	0.15	0.12	0.06	MMT22ER050UN	—

■ Whitworth for BSW, BSP

Pitch (thread/inch)	Total Cutting Depth	Number of Passes														Insert Type	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts	M-class inserts with 3-D chip breakers
28	0.58	0.17	0.14	0.11	0.10	0.06										MMT16ER280W	—
26	0.63	0.18	0.15	0.13	0.11	0.06										MMT16ER260W	—
20	0.81	0.20	0.18	0.14	0.12	0.11	0.06									MMT16ER200W	—
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06									MMT16ER190W	MMT16ER190W-S
18	0.90	0.25	0.19	0.15	0.13	0.12	0.06									MMT16ER180W	—
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06							MMT16ER160W	—
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06							MMT16ER140W	MMT16ER140W-S
12	1.36	0.27	0.25	0.20	0.16	0.15	0.14	0.13	0.06							MMT16ER120W	—
11	1.48	0.27	0.24	0.20	0.17	0.15	0.14	0.13	0.12	0.06						MMT16ER110W	MMT16ER110W-S
10	1.63	0.27	0.25	0.20	0.17	0.15	0.15	0.13	0.13	0.12	0.06					MMT16ER100W	—
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06				MMT16ER090W	—
8	2.03	0.30	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06			MMT16ER080W	—
7	2.32	0.34	0.32	0.26	0.22	0.20	0.18	0.17	0.16	0.15	0.14	0.12	0.06			MMT22ER070W	—
6	2.71	0.35	0.33	0.27	0.23	0.21	0.20	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06	MMT22ER060W	—
5	3.25	0.42	0.40	0.35	0.29	0.26	0.24	0.22	0.20	0.19	0.18	0.17	0.15	0.12	0.06	MMT22ER050W	—

■ BSPT

Pitch (thread/inch)	Total Cutting Depth	Number of Passes														Insert Type	
		1	2	3	4	5	6	7	8	9						G-class ground inserts	M-class inserts with 3-D chip breakers
28	0.58	0.17	0.14	0.11	0.10	0.06										MMT16ER280BSPT	—
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06									MMT16ER190BSPT	MMT16ER190BSPT-S
14	1.16	0.24	0.20	0.17	0.14	0.12	0.12	0.11	0.06							MMT16ER140BSPT	MMT16ER140BSPT-S
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06						MMT16ER110BSPT	MMT16ER110BSPT-S

Note 1) • Set the finishing allowance on a diameter at approx. 0.1mm when using a full form insert.
• Please note the cutting depth and the number of passes when a corner radius of a partial form insert or of an internal threading insert is small to prevent damage to the insert corner.
• Please set the cutting depth sufficiently deep enough on materials such as hardened steel or austenitic stainless steel to help prevent premature wear and chipping caused by the outer layer of the material.

MMT STANDARD OF DEPTH OF CUT EXTERNAL (RADIAL INFEED)

■ Round DIN 405

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
10	1.27	0.23	0.21	0.20	0.19	0.16	0.12	0.10	0.06								MMT16ER100RD
8	1.59	0.23	0.21	0.20	0.19	0.18	0.16	0.14	0.12	0.10	0.06						MMT16ER080RD
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.10	0.06				MMT16ER060RD
4	3.18	0.34	0.33	0.32	0.30	0.28	0.26	0.24	0.22	0.20	0.19	0.17	0.15	0.12	0.06		MMT22ER040RD

■ ISO Trapezoidal 30°

Pitch (mm)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
1.5	0.90	0.23	0.21	0.16	0.13	0.11	0.06										MMT16ER150TR
2.0	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									MMT16ER200TR
3.0	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							MMT16ER300TR
4.0	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.06				MMT22ER400TR
5.0	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		MMT22ER500TR

■ American ACME

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
12	1.19	0.27	0.23	0.20	0.17	0.14	0.12	0.06									MMT16ER120ACME
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							MMT16ER100ACME
8	1.84	0.30	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					MMT16ER080ACME
6	2.37	0.34	0.30	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			MMT22ER060ACME
5	2.79	0.36	0.33	0.30	0.26	0.23	0.20	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		MMT22ER050ACME

■ UNJ

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11					
32	0.46	0.16	0.14	0.10	0.06												MMT16ER320UNJ
28	0.52	0.16	0.12	0.09	0.09	0.06											MMT16ER280UNJ
24	0.61	0.17	0.14	0.14	0.10	0.06											MMT16ER240UNJ
20	0.73	0.19	0.16	0.13	0.10	0.09	0.06										MMT16ER200UNJ
18	0.81	0.23	0.18	0.14	0.10	0.10	0.06										MMT16ER180UNJ
16	0.92	0.26	0.21	0.14	0.12	0.10	0.09										MMT16ER160UNJ
14	1.05	0.26	0.23	0.17	0.12	0.11	0.10	0.06									MMT16ER140UNJ
12	1.22	0.28	0.27	0.20	0.17	0.13	0.11	0.06									MMT16ER120UNJ
10	1.47	0.30	0.29	0.21	0.15	0.13	0.12	0.11	0.10	0.06							MMT16ER100UNJ
8	1.83	0.31	0.30	0.23	0.18	0.15	0.14	0.13	0.12	0.11	0.10	0.06					MMT16ER080UNJ

■ API Buttress Casing

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11					
5	1.55	0.25	0.23	0.17	0.15	0.13	0.12	0.12	0.11	0.11	0.10	0.06					MMT22ER050APBU

■ API Round Casing&Tubing

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12				
10	1.41	0.25	0.23	0.16	0.14	0.12	0.12	0.12	0.11	0.10	0.06						MMT16ER100APRD
8	1.81	0.25	0.24	0.19	0.16	0.14	0.14	0.13	0.13	0.13	0.13	0.11	0.06				MMT16ER080APRD

■ American NPT

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
27	0.66	0.15	0.13	0.12	0.11	0.09	0.06										MMT16ER270NPT
18	1.01	0.20	0.16	0.14	0.13	0.12	0.11	0.09	0.06								MMT16ER180NPT
14	1.33	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						MMT16ER140NPT
11.5	1.64	0.24	0.19	0.17	0.15	0.15	0.13	0.13	0.12	0.11	0.10	0.09	0.06				MMT16ER115NPT
8	2.42	0.33	0.28	0.23	0.20	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	MMT16ER080NPT

■ American NPTF

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
27	0.64	0.16	0.14	0.11	0.09	0.08	0.06										MMT16ER270NPTF
18	1.00	0.19	0.16	0.14	0.13	0.12	0.11	0.09	0.06								MMT16ER180NPTF
14	1.35	0.23	0.21	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						MMT16ER140NPTF
11.5	1.63	0.24	0.23	0.19	0.15	0.13	0.11	0.11	0.11	0.10	0.10	0.10	0.06				MMT16ER115NPTF
8	2.38	0.32	0.27	0.23	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	MMT16ER080NPTF

Note 1)
- Set the finishing allowance on a diameter at approx. 0.1mm when using a full form insert.
- Please note the cutting depth and the number of passes when a corner radius of a partial form insert or of an internal threading insert is small to prevent damage to the insert corner.
- Please set the cutting depth sufficiently deep enough on materials such as hardened steel or austenitic stainless steel to help prevent premature wear and chipping caused by the outer layer of the material.

MMT STANDARD OF DEPTH OF CUT INTERNAL (RADIAL INFEED)

■ISO Metric

Pitch (mm)	Total Cutting Depth	Number of Passes														Insert Type			
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts		M-class inserts with 3-D chip breakers	
0.5	0.29	0.09	0.07	0.07	0.06											MMT11IR050ISO	MMT16IR050ISO	—	—
0.75	0.43	0.15	0.13	0.09	0.06											MMT11IR075ISO	MMT16IR075ISO	—	—
1.0	0.58	0.17	0.15	0.11	0.09	0.06										MMT11IR100ISO	MMT16IR100ISO	MMT11IR100ISO-S	MMT16IR100ISO-S
1.25	0.72	0.18	0.16	0.12	0.11	0.09	0.06									MMT11IR125ISO	MMT16IR125ISO	MMT11IR125ISO-S	MMT16IR125ISO-S
1.5	0.87	0.21	0.20	0.16	0.13	0.11	0.06									MMT11IR150ISO	MMT16IR150ISO	MMT11IR150ISO-S	MMT16IR150ISO-S
1.75	1.01	0.21	0.20	0.15	0.12	0.10	0.09	0.08	0.06							MMT11IR175ISO	MMT16IR175ISO	—	MMT16IR175ISO-S
2.0	1.15	0.24	0.22	0.18	0.14	0.12	0.10	0.09	0.06							MMT11IR200ISO	MMT16IR200ISO	—	MMT16IR200ISO-S
2.5	1.44	0.25	0.24	0.21	0.15	0.13	0.12	0.10	0.09	0.09	0.06					—	MMT16IR250ISO	—	MMT16IR250ISO-S
3.0	1.73	0.26	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.10	0.09	0.08	0.06			—	MMT16IR300ISO	—	MMT16IR300ISO-S
3.5	2.02	0.32	0.30	0.23	0.19	0.17	0.15	0.14	0.13	0.12	0.11	0.10	0.06			—	MMT22IR350ISO	—	—
4.0	2.31	0.33	0.31	0.24	0.22	0.18	0.15	0.14	0.13	0.12	0.12	0.11	0.10	0.10	0.06	—	MMT22IR400ISO	—	—
4.5	2.60	0.36	0.33	0.28	0.24	0.21	0.19	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.06	—	MMT22IR450ISO	—	—
5.0	2.89	0.41	0.38	0.32	0.27	0.24	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06	—	MMT22IR500ISO	—	—

■American UN

Pitch (thread/inch)	Total Cutting Depth	Number of Passes														Insert Type		
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts		M-class inserts with 3-D chip breakers
32	0.46	0.16	0.14	0.10	0.06											MMT11IR320UN	MMT16IR320UN	—
28	0.52	0.16	0.13	0.09	0.08	0.06										MMT11IR280UN	MMT16IR280UN	—
24	0.61	0.17	0.15	0.13	0.10	0.06										MMT11IR240UN	MMT16IR240UN	—
20	0.73	0.18	0.15	0.13	0.11	0.10	0.06									MMT11IR200UN	MMT16IR200UN	—
18	0.81	0.20	0.18	0.14	0.12	0.11	0.06									MMT11IR180UN	MMT16IR180UN	—
16	0.92	0.20	0.18	0.15	0.12	0.11	0.10	0.06								MMT11IR160UN	MMT16IR160UN	MMT16IR160UN-S
14	1.05	0.21	0.18	0.15	0.13	0.11	0.11	0.10	0.06							MMT11IR140UN	MMT16IR140UN	MMT16IR140UN-S
13	1.13	0.22	0.19	0.16	0.14	0.13	0.12	0.11	0.06							—	MMT16IR130UN	—
12	1.22	0.24	0.22	0.18	0.16	0.13	0.12	0.11	0.06							—	MMT16IR120UN	MMT16IR120UN-S
11	1.33	0.24	0.22	0.20	0.15	0.12	0.12	0.11	0.11	0.06						—	MMT16IR110UN	—
10	1.47	0.25	0.22	0.21	0.14	0.13	0.12	0.12	0.11	0.11	0.06					—	MMT16IR100UN	—
9	1.63	0.31	0.23	0.21	0.17	0.15	0.14	0.13	0.12	0.11	0.06					—	MMT16IR090UN	—
8	1.83	0.31	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.11	0.06				—	MMT16IR080UN	—
7	2.09	0.36	0.30	0.24	0.21	0.18	0.17	0.16	0.15	0.14	0.12	0.06				—	MMT22IR070UN	—
6	2.44	0.40	0.33	0.25	0.23	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.11	0.06		—	MMT22IR060UN	—
5	2.93	0.41	0.35	0.31	0.26	0.23	0.21	0.20	0.19	0.17	0.15	0.14	0.13	0.12	0.06	—	MMT22IR050UN	—

■Whitworth for BSW, BSP

Pitch (thread/inch)	Total Cutting Depth	Number of Passes														Insert Type		
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	G-class ground inserts		M-class inserts with 3-D chip breakers
28	0.58	0.17	0.14	0.11	0.10	0.06										—	MMT16IR280W	—
26	0.63	0.18	0.15	0.13	0.11	0.06										—	MMT16IR260W	—
20	0.81	0.20	0.18	0.14	0.12	0.11	0.06									—	MMT16IR200W	—
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06									MMT11IR190W	MMT16IR190W	MMT16IR190W-S
18	0.90	0.25	0.19	0.15	0.13	0.12	0.06									—	MMT16IR180W	—
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06							—	MMT16IR160W	—
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06							MMT11IR140W	MMT16IR140W	MMT16IR140W-S
12	1.36	0.27	0.25	0.20	0.16	0.15	0.14	0.13	0.06							—	MMT16IR120W	MMT16IR120W-S
11	1.48	0.27	0.24	0.20	0.17	0.15	0.14	0.13	0.12	0.06						—	MMT16IR110W	—
10	1.63	0.27	0.25	0.20	0.17	0.15	0.15	0.13	0.13	0.12	0.06					—	MMT16IR100W	—
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06				—	MMT16IR090W	—
8	2.03	0.30	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06			—	MMT16IR080W	—
7	2.32	0.34	0.32	0.26	0.22	0.20	0.18	0.17	0.16	0.15	0.14	0.12	0.06			—	MMT22IR070W	—
6	2.71	0.35	0.33	0.27	0.23	0.21	0.20	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06	—	MMT22IR060W	—
5	3.25	0.42	0.40	0.35	0.29	0.26	0.24	0.22	0.20	0.19	0.18	0.17	0.15	0.12	0.06	—	MMT22IR050W	—

Note 1)
- Set the finishing allowance on a diameter at approx. 0.1mm when using a full form insert.
- Please note the cutting depth and the number of passes when a corner radius of a partial form insert or of an internal threading insert is small to prevent damage to the insert corner.
- Please set the cutting depth sufficiently deep enough on materials such as hardened steel or austenitic stainless steel to help prevent premature wear and chipping caused by the outer layer of the material.

MMT STANDARD OF DEPTH OF CUT INTERNAL (RADIAL INFEED)

■ BSPT

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type		
		1	2	3	4	5	6	7	8	9							G-class ground inserts		M-class inserts with 3-D chip breakers
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06										MMT11IR190BSPT	MMT16IR190BSPT	MMT16IR190BSPT-S
14	1.16	0.24	0.20	0.17	0.14	0.12	0.12	0.11	0.06								MMT11IR140BSPT	MMT16IR140BSPT	MMT16IR140BSPT-S
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06							—	MMT16IR110BSPT	MMT16IR110BSPT-S

■ Round DIN 405

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
10	1.27	0.23	0.21	0.20	0.19	0.16	0.12	0.10	0.06								MMT16IR100RD
8	1.59	0.23	0.21	0.20	0.19	0.18	0.16	0.14	0.12	0.10	0.06						MMT16IR080RD
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.10	0.06				MMT16IR060RD
4	3.18	0.34	0.33	0.32	0.30	0.28	0.26	0.24	0.22	0.20	0.19	0.17	0.15	0.12	0.06		MMT22IR040RD

■ ISO Trapezoidal 30°

Pitch (mm)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
1.5	0.90	0.23	0.21	0.16	0.13	0.11	0.06										MMT16IR150TR
2	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									MMT16IR200TR
3	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							MMT16IR300TR
4	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.06				MMT22IR400TR
5	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		MMT22IR500TR

■ American ACME

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14		
12	1.19	0.27	0.23	0.20	0.17	0.14	0.12	0.06									MMT16IR120ACME
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							MMT16IR100ACME
8	1.84	0.30	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					MMT16IR080ACME
6	2.37	0.34	0.30	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			MMT22IR060ACME
5	2.79	0.36	0.33	0.30	0.26	0.23	0.20	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		MMT22IR050ACME

■ API Buttress Casing

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11					
5	1.55	0.25	0.23	0.17	0.15	0.13	0.12	0.12	0.11	0.11	0.10	0.06					MMT22IR050APBU

■ API Round Casing&Tubing

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12				
10	1.41	0.25	0.23	0.16	0.14	0.12	0.12	0.12	0.11	0.10	0.06						MMT16IR100APRD
8	1.81	0.25	0.24	0.19	0.16	0.14	0.14	0.13	0.13	0.13	0.13	0.11	0.06				MMT16IR080APRD

■ American NPT

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
27	0.66	0.15	0.13	0.12	0.11	0.09	0.06										MMT16IR270NPT
18	1.01	0.20	0.16	0.14	0.13	0.12	0.11	0.09	0.06								MMT16IR180NPT
14	1.33	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						MMT16IR140NPT
11.5	1.64	0.24	0.19	0.17	0.15	0.15	0.13	0.13	0.12	0.11	0.10	0.09	0.06				MMT16IR115NPT
8	2.42	0.33	0.28	0.23	0.20	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	MMT16IR080NPT

■ American NPTF

Pitch (thread/inch)	Total Cutting Depth	Number of Passes															Insert Type
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
14	1.35	0.23	0.21	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						MMT16IR140NPTF
11.5	1.63	0.24	0.23	0.19	0.15	0.13	0.11	0.11	0.11	0.10	0.10	0.10	0.06				MMT16IR115NPTF
8	2.38	0.32	0.27	0.23	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	MMT16IR080NPTF

Note 1)
- Set the finishing allowance on a diameter at approx. 0.1mm when using a full form insert.
- Please note the cutting depth and the number of passes when a corner radius of a partial form insert or of an internal threading insert is small to prevent damage to the insert corner.
- Please set the cutting depth sufficiently deep enough on materials such as hardened steel or austenitic stainless steel to help prevent premature wear and chipping caused by the outer layer of the material.

MMT SERIES ORDER NUMBER

HOLDERS

EXTERNAL

MMT E R 12 12 H 16 – C

Designation

Application

E	External

Hand of Tool

R	Right

Tool Size (mm) (Height and Width)

12	12
16	16
20	20
25	25
32	32

Tool Length (mm)

H	100
K	125
M	150
P	170

Insert Size (mm)

16	9.525
22	12.7

Method of Holding

C	Clamp-on

INTERNAL

MMT I R 13 16 A K 11 – S P15

Designation

Application

I	Internal

Hand of Tool

R	Right

Min.Cutting Diameter (mm)

Shank Diameter (mm)

Shank Material

A	Steel Shank with Coolant Hole

Tool Length (mm)

K	125	R	200
M	150	S	250
Q	180	T	300

Insert Size (mm)

11	6.35
16	9.525
22	12.7

Method of Holding

S	Screw-on
C	Clamp-on

Lead Angle

P15	1.5°
P25	2.5°
P35	3.5°

INSERTS

M-CLASS

MMT 16 E R 100 ISO – S

S	M-class inserts with 3-D chip breakers

Designation

Diameter of Inscribed Circle (mm)

11	6.35
16	9.525

Application

E	External
I	Internal

Hand of Tool

R	Right

Pitch

100	1.0mm	A	0.5—1.5mm or 48—16 thread/inch
125	1.25mm		
150	1.5mm	G	1.75—3.0mm or 14—8 thread/inch
175	1.75mm		
200	2.0mm		
250	2.5mm		
300	3.0mm		

Threading Type

60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN

G-CLASS

MMT 16 E R 050 ISO

Designation

Diameter of Inscribed Circle (mm)

11	6.35
16	9.525
22	12.7

Application

E	External
I	Internal

Hand of Tool

R	Right

Pitch

050	0.5mm	A	0.5—1.5mm or 48—16 thread/inch
075	0.75mm		
100	1.0mm		
125	1.25mm	G	1.75—3.0mm or 14—8 thread/inch
150	1.5mm		
175	1.75mm		
200	2.0mm		
250	2.5mm	AG	0.5—3.0mm or 48—8 thread/inch
300	3.0mm		
350	3.5mm		
400	4.0mm	N	3.5—5.0mm or 7—5 thread/inch
450	4.5mm		
500	5.0mm		

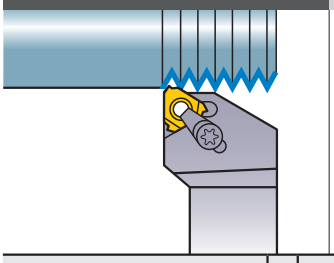
Threading Type

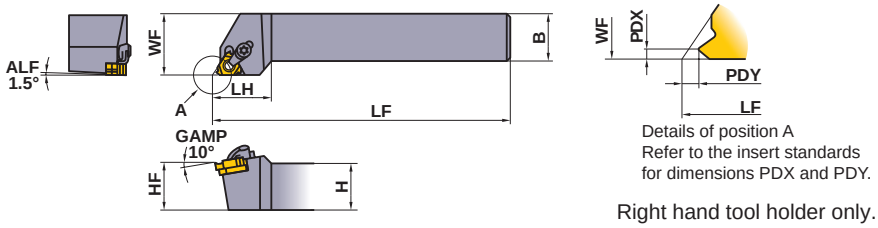
60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN
RD	Round DIN 405
TR	ISO Trapezoidal 30°
ACME	American ACME
UNJ	UNJ
APBU	API Buttress Casing
APRD	API Round Casing&Tubing
NPT	NPT
NPTF	NPTF

MMTE HOLDER

MMTE

External threading





Details of position A
Refer to the insert standards for dimensions PDX and PDY.

Right hand tool holder only.

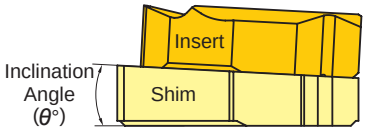
Order Number	Stock R	Insert Number	Dimensions (mm) H	B	LF	LH	HF	WF	Clamp Bridge	Clamp Screw *	Stop Ring	Shim Screw *	Shim	Wrench
MMTER1212H16-C	●	MMT16ER ○○○○○	12	12	100	25	12	16	SETK51	SETS51	CR4	HFC03008	CTE32TP15	①TKY15F ②HKY20R
MMTER1616H16-C	●		16	16	100	25	16	20	SETK51	SETS51	CR4	HFC03008	CTE32TP15	①TKY15F ②HKY20R
MMTER2020K16-C	●		20	20	125	26	20	25	SETK51	SETS51	CR4	HFC03008	CTE32TP15	①TKY15F ②HKY20R
MMTER2525M16-C	●		25	25	150	28	25	32	SETK51	SETS51	CR4	HFC03008	CTE32TP15	①TKY15F ②HKY20R
MMTER3232P16-C	●		32	32	170	32	32	40	SETK51	SETS51	CR4	HFC03008	CTE32TP15	①TKY15F ②HKY20R
MMTER2525M22-C	●	MMT22ER ○○○○○	25	25	150	32	25	32	SETK61	SETS61	CR5	HFC04010	CTE43TP15	①TKY20F ②HKY25R
MMTER3232P22-C	●		32	32	170	32	32	40	SETK61	SETS61	CR5	HFC04010	CTE43TP15	①TKY20F ②HKY25R

Note 1) Select and use a shim as shown below (sold separately), dependant on the lead angle.
* Clamp Torque (N • m) : SETS51=3.5, SETS61=5.0, HFC03008=1.5, HFC04010=2.2

SHIM

Lead Angle (α°)	Order Number	Stock R	Inclination Angle (θ°)	Applicable Holder
−1.5°	**CTE32TN15**	●	−3°	MMTER ○○○○○ 16-C
−0.5°	**CTE32TN05**	●	−2°	
0.5°	**CTE32TP05**	●	−1°	
1.5°	**CTE32TP15**	●	0°	
2.5°	**CTE32TP25**	●	1°	
3.5°	**CTE32TP35**	●	2°	
4.5°	**CTE32TP45**	●	3°	

Lead Angle (α°)	Order Number	Stock R	Inclination Angle (θ°)	Applicable Holder
−1.5°	**CTE43TN15**	●	−3°	MMTER ○○○○○ 22-C
−0.5°	**CTE43TN05**	●	−2°	
0.5°	**CTE43TP05**	●	−1°	
1.5°	**CTE43TP15**	●	0°	
2.5°	**CTE43TP25**	●	1°	
3.5°	**CTE43TP35**	●	2°	
4.5°	**CTE43TP45**	●	3°	



Standard shim delivered with the holder.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**VP10MF**	150 (70−230)
			VP15TF	100 (60−140)
			VP20RT	80 (60−100)
	Carbon Steel Alloy Steel	180−280HB	**VP10MF**	140 (80−200)
			VP15TF	100 (60−140)
			VP20RT	80 (60−100)
M	Stainless Steel	≤200HB	**VP15TF**	80 (40−120)
			VP20RT	
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP10MF**	140 (80−200)
			VP15TF	90 (60−120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
S	Heat-Resistant Alloy	–	**VP10MF**	45 (15−70)
			VP15TF	30 (20−40)
			VP20RT	
	Titanium Alloy	–	**VP10MF**	60 (40−80)
			VP15TF	45 (25−65)
			VP20RT	
H	Heat-Treated Alloy	45−55HRC	**VP10MF**	50 (30−70)
			VP15TF	40 (20−60)

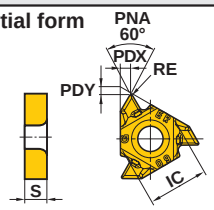
● : **Inventory maintained in Japan.**

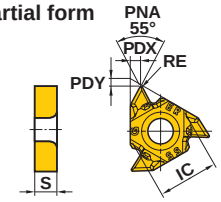
HOW TO SELECT A SHIM	➤ G012
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

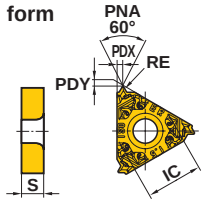
MMT M-CLASS INSERTS WITH 3-D CHIP BREAKERS

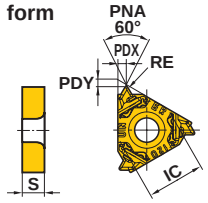
INSERTS

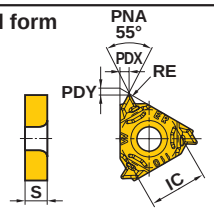
Type	Order Number	Coated VP15TF	Coated VP20RT	Pitch mm	Pitch thread/inch	IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
Partial Profile 60°	MMT16ERA60-S	●		0.5—1.5	48—16	9.525	3.44	0.8	0.9	0.06	—	Partial form
	MMT16ERG60-S	●		1.75—3.0	14—8	9.525	3.44	1.2	1.7	0.23	—	
Partial Profile 55°	MMT16ERA55-S	●			48—16	9.525	3.44	0.8	0.9	0.07	—	Partial form
	MMT16ERG55-S	●			14—8	9.525	3.44	1.2	1.7	0.23	—	
ISO Metric	MMT16ER100ISO-S	●	●	1.0		9.525	3.44	0.7	0.7	0.13	0.61	Full form
	MMT16ER125ISO-S	●	●	1.25		9.525	3.44	0.8	0.9	0.16	0.77	
	MMT16ER150ISO-S	●	●	1.5		9.525	3.44	0.8	1.0	0.20	0.92	
	MMT16ER175ISO-S	●	●	1.75		9.525	3.44	0.9	1.2	0.22	1.07	
	MMT16ER200ISO-S	●	●	2.0		9.525	3.44	1.0	1.3	0.26	1.23	
	MMT16ER250ISO-S	●	●	2.5		9.525	3.44	1.1	1.5	0.33	1.53	
	MMT16ER300ISO-S	●	●	3.0		9.525	3.44	1.2	1.6	0.40	1.84	
American UN	MMT16ER160UN-S	●			16	9.525	3.44	0.9	1.1	0.23	0.97	Full form
	MMT16ER140UN-S	●			14	9.525	3.44	1.0	1.2	0.26	1.11	
	MMT16ER120UN-S	●			12	9.525	3.44	1.1	1.4	0.30	1.30	
Whitworth for BSW, BSP	MMT16ER190W-S	●			19	9.525	3.44	0.8	1.0	0.18	0.86	Full form
	MMT16ER140W-S	●			14	9.525	3.44	1.0	1.2	0.25	1.16	
	MMT16ER110W-S	●			11	9.525	3.44	1.1	1.5	0.32	1.48	
BSPT	MMT16ER190BSPT-S	●			19	9.525	3.44	0.8	0.9	0.18	0.86	Full form
	MMT16ER140BSPT-S	●			14	9.525	3.44	1.0	1.2	0.25	1.16	
	MMT16ER110BSPT-S	●			11	9.525	3.44	1.1	1.5	0.32	1.48	

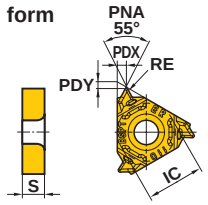












IDENTIFICATION

MMT 16 E R 100 ISO – S

- **MMT** — Designation
- **16** — Diameter of Inscribed Circle (mm)
- **E** — Application
- **R** — Hand of Tool
- **100** — Pitch
- **ISO** — Threading Type
- **S** — M-class inserts with 3-D chip breakers

Diameter of Inscribed Circle (mm)	
11	6.35
16	9.525

Application	
E	External
I	Internal

Hand of Tool	
R	Right

Pitch			
100	1.0mm	A	0.5—1.5mm or 48—16 thread/inch
125	1.25mm		
150	1.5mm	G	1.75—3.0mm or 14—8 thread/inch
175	1.75mm		
200	2.0mm		
250	2.5mm		
300	3.0mm		

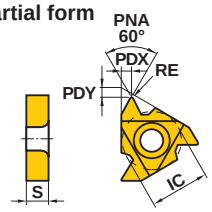
Threading Type	
60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN

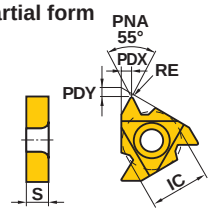
● : Inventory maintained in Japan. (5 inserts in one case)

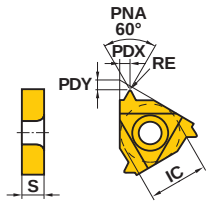
MMT G-CLASS GROUND INSERTS

INSERTS

Type	Thread Tolerance	Order Number	Coated VP10MF	Coated VP15TF	Pitch mm	Pitch thread/inch	Dimensions (mm) IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
Partial Profile 60°	—	MMT16ERA60	●	●	0.5—1.5	48—16	9.525	3.44	0.8	0.9	0.05	—	Partial form
		MMT16ERG60	●	●	1.75—3.0	14—8	9.525	3.44	1.2	1.7	0.27	—	
		MMT16ERAG60	●		0.5—3.0	48—8	9.525	3.44	1.2	1.7	0.08	—	
		MMT22ERN60	●		3.5—5.0	7—5	12.7	4.64	1.7	2.5	0.53	—	
Partial Profile 55°	—	MMT16ERA55	●	●		48—16	9.525	3.44	0.8	0.9	0.05	—	Partial form
		MMT16ERG55	●	●		14—8	9.525	3.44	1.2	1.7	0.21	—	
		MMT16ERAG55	●			48—8	9.525	3.44	1.2	1.7	0.07	—	
		MMT22ERN55	●			7—5	12.7	4.64	1.7	2.5	0.44	—	
ISO Metric	6g	MMT16ER050ISO	●		0.5		9.525	3.44	0.6	0.4	0.06	0.31	Full form
		MMT16ER075ISO	●		0.75		9.525	3.44	0.6	0.6	0.10	0.46	
		MMT16ER100ISO	●	●	1.0		9.525	3.44	0.7	0.7	0.16	0.61	
		MMT16ER125ISO	●	●	1.25		9.525	3.44	0.8	0.9	0.19	0.77	
		MMT16ER150ISO	●	●	1.5		9.525	3.44	0.8	1.0	0.23	0.92	
		MMT16ER175ISO	●	●	1.75		9.525	3.44	0.9	1.2	0.21	1.07	
		MMT16ER200ISO	●	●	2.0		9.525	3.44	1.0	1.3	0.31	1.23	
		MMT16ER250ISO	●	●	2.5		9.525	3.44	1.1	1.5	0.32	1.53	
		MMT16ER300ISO	●	●	3.0		9.525	3.44	1.2	1.6	0.46	1.84	
		MMT22ER350ISO	●		3.5		12.7	4.64	1.6	2.3	0.45	2.15	
		MMT22ER400ISO	●		4.0		12.7	4.64	1.6	2.3	0.52	2.45	
		MMT22ER450ISO	●		4.5		12.7	4.64	1.7	2.4	0.58	2.76	
		MMT22ER500ISO	●		5.0		12.7	4.64	1.7	2.5	0.63	3.07	







IDENTIFICATION

MMT 16 E R 050 ISO

Designation

Diameter of Inscribed Circle (mm)

11	6.35
16	9.525
22	12.7

Application

E	External
I	Internal

Hand of Tool

R	Right

Pitch

050	0.5mm	A	0.5—1.5mm or 48—16 thread/inch
075	0.75mm		
100	1.0mm		
125	1.25mm	G	1.75—3.0mm or 14—8 thread/inch
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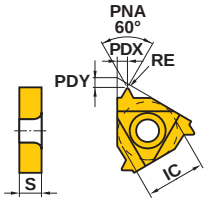
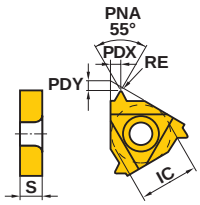
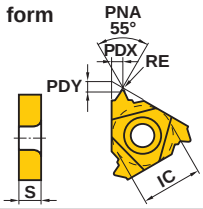
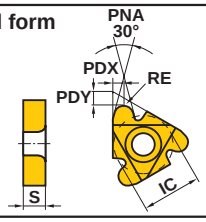
350	3.5mm		
400	4.0mm	N	3.5—5.0mm or 7—5 thread/inch
450	4.5mm		
500	5.0mm		

Threading Type

60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN
RD	Round DIN 405
TR	ISO Trapezoidal 30°
ACME	American ACME
UNJ	UNJ
APBU	API Buttress Casing
APRD	API Round Casing&Tubing
NPT	NPT
NPTF	NPTF

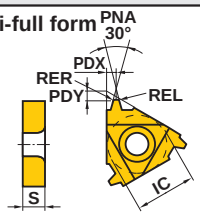
MMT G-CLASS GROUND INSERTS

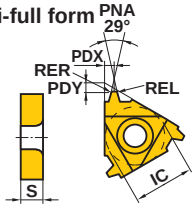
INSERTS

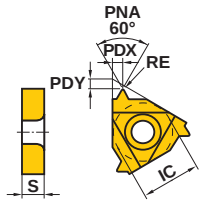
Type	Thread Tolerance	Order Number	Coated VP10MF	Coated VP15TF	Pitch mm	Pitch thread/inch	Dimensions (mm) IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
American UN	2A	MMT16ER320UN	●			32	9.525	3.44	0.6	0.6	0.09	0.49	Full form
		MMT16ER280UN	●			28	9.525	3.44	0.6	0.7	0.10	0.56	
		MMT16ER240UN	●			24	9.525	3.44	0.7	0.8	0.16	0.65	
		MMT16ER200UN	●			20	9.525	3.44	0.8	0.9	0.19	0.78	
		MMT16ER180UN	●			18	9.525	3.44	0.8	1.0	0.21	0.87	
		MMT16ER160UN	●	●		16	9.525	3.44	0.9	1.1	0.24	0.97	
		MMT16ER140UN	●	●		14	9.525	3.44	1.0	1.2	0.22	1.11	
		MMT16ER130UN	●			13	9.525	3.44	1.0	1.3	0.24	1.20	
		MMT16ER120UN	●	●		12	9.525	3.44	1.1	1.4	0.32	1.30	
		MMT16ER110UN	●			11	9.525	3.44	1.1	1.5	0.29	1.42	
		MMT16ER100UN	●			10	9.525	3.44	1.1	1.5	0.32	1.56	
		MMT16ER090UN	●			9	9.525	3.44	1.2	1.7	0.35	1.73	
		MMT16ER080UN	●			8	9.525	3.44	1.2	1.6	0.48	1.95	
		MMT22ER070UN	●			7	12.7	4.64	1.6	2.3	0.47	2.22	
		MMT22ER060UN	●			6	12.7	4.64	1.6	2.3	0.53	2.60	
		MMT22ER050UN	●			5	12.7	4.64	1.7	2.5	0.64	3.12	
Whitworth for BSW, BSP	Medium Class A	MMT16ER280W	●			28	9.525	3.44	0.6	0.7	0.09	0.58	Full form
		MMT16ER260W	●			26	9.525	3.44	0.7	0.8	0.10	0.63	
		MMT16ER200W	●			20	9.525	3.44	0.8	0.9	0.18	0.81	
		MMT16ER190W	●	●		19	9.525	3.44	0.8	1.0	0.19	0.86	
		MMT16ER180W	●			18	9.525	3.44	0.8	1.0	0.20	0.90	
		MMT16ER160W	●			16	9.525	3.44	0.9	1.1	0.23	1.02	
		MMT16ER140W	●	●		14	9.525	3.44	1.0	1.2	0.26	1.16	
		MMT16ER120W	●			12	9.525	3.44	1.1	1.4	0.30	1.36	
		MMT16ER110W	●	●		11	9.525	3.44	1.1	1.5	0.33	1.48	
		MMT16ER100W	●			10	9.525	3.44	1.1	1.5	0.37	1.63	
		MMT16ER090W	●			9	9.525	3.44	1.2	1.7	0.34	1.81	
		MMT16ER080W	●			8	9.525	3.44	1.2	1.5	0.39	2.03	
		MMT22ER070W	●			7	12.7	4.64	1.6	2.3	0.46	2.32	
		MMT22ER060W	●			6	12.7	4.64	1.6	2.3	0.53	2.71	
		MMT22ER050W	●			5	12.7	4.64	1.7	2.4	0.66	3.25	
BSPT	Standard BSPT	MMT16ER280BSPT	●			28	9.525	3.44	0.6	0.6	0.09	0.58	Full form 
		MMT16ER190BSPT	●	●		19	9.525	3.44	0.8	0.9	0.14	0.86	
		MMT16ER140BSPT	●	●		14	9.525	3.44	1.0	1.2	0.26	1.16	
		MMT16ER110BSPT	●	●		11	9.525	3.44	1.1	1.5	0.33	1.48	
Round DIN 405	7h	MMT16ER100RD	●			10	9.525	3.44	1.1	1.2	0.60	1.27	Full form 
		MMT16ER080RD	●			8	9.525	3.44	1.4	1.3	0.75	1.59	
		MMT16ER060RD	●			6	9.525	3.44	1.5	1.7	1.00	2.12	
		MMT22ER040RD	●			4	12.7	4.64	2.2	2.3	1.51	3.18	

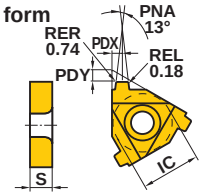
● : Inventory maintained in Japan. (5 inserts in one case)

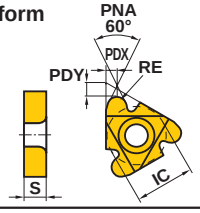
Type	Thread Tolerance	Order Number	Coated VP10MF	Pitch mm	Pitch thread/inch	Dimensions (mm) IC	S	PDY	PDX	RE RER/L	Total Cutting Depth (mm)	Geometry
ISO Trapezoidal 30°	7e	MMT16ER150TR	●	1.5		9.525	3.44	1.0	1.1	0.08	0.90	Semi-full form
		MMT16ER200TR	●	2.0		9.525	3.44	1.1	1.3	0.15	1.25	
		MMT16ER300TR	●	3.0		9.525	3.44	1.3	1.5	0.15	1.75	
		MMT22ER400TR	●	4.0		12.7	4.64	1.7	1.9	0.15	2.25	
		MMT22ER500TR	●	5.0		12.7	4.64	2.1	2.5	0.15	2.75	
American ACME	3G	MMT16ER120ACME	●		12	9.525	3.44	1.1	1.2	0.08	1.19	Semi-full form
		MMT16ER100ACME	●		10	9.525	3.44	1.3	1.4	0.08	1.52	
		MMT16ER080ACME	●		8	9.525	3.44	1.4	1.5	0.10	1.84	
		MMT22ER060ACME	●		6	12.7	4.64	1.8	2.1	0.10	2.37	
		MMT22ER050ACME	●		5	12.7	4.64	2.0	2.3	0.10	2.79	
UNJ	3A	MMT16ER320UNJ	●		32	9.525	3.44	0.6	0.7	0.13	0.46	Full form
		MMT16ER280UNJ	●		28	9.525	3.44	0.7	0.7	0.14	0.52	
		MMT16ER240UNJ	●		24	9.525	3.44	0.7	0.8	0.17	0.61	
		MMT16ER200UNJ	●		20	9.525	3.44	0.8	0.9	0.20	0.73	
		MMT16ER180UNJ	●		18	9.525	3.44	0.8	1.0	0.22	0.81	
		MMT16ER160UNJ	●		16	9.525	3.44	0.9	1.1	0.25	0.92	
		MMT16ER140UNJ	●		14	9.525	3.44	1.0	1.2	0.29	1.05	
		MMT16ER120UNJ	●		12	9.525	3.44	1.1	1.3	0.33	1.22	
		MMT16ER100UNJ	●		10	9.525	3.44	1.2	1.5	0.40	1.47	
		MMT16ER080UNJ	●		8	9.525	3.44	1.2	1.6	0.51	1.83	
API Buttress Casing	Standard API	MMT22ER050APBU	●		5	12.7	4.64	3.1	1.9	0.74/0.18	1.55	Full form
API Round Casing&Tubing	Standard API RD	MMT16ER100APRD	●		10	9.525	3.44	1.2	1.4	0.34	1.41	Full form
		MMT16ER080APRD	●		8	9.525	3.44	1.3	1.5	0.41	1.81	
American NPT	Standard NPT	MMT16ER270NPT	●		27	9.525	3.44	0.7	0.8	0.04	0.66	Full form
		MMT16ER180NPT	●		18	9.525	3.44	0.8	1.0	0.08	1.01	
		MMT16ER140NPT	●		14	9.525	3.44	0.9	1.2	0.09	1.33	
		MMT16ER115NPT	●		11.5	9.525	3.44	1.1	1.5	0.11	1.64	
		MMT16ER080NPT	●		8	9.525	3.44	1.3	1.8	0.14	2.42	
American NPTF	Class 2	MMT16ER270NPTF	●		27	9.525	3.44	0.7	0.8	0.04	0.64	Full form
		MMT16ER180NPTF	●		18	9.525	3.44	0.8	1.0	0.04	1.00	
		MMT16ER140NPTF	●		14	9.525	3.44	0.9	1.2	0.04	1.35	
		MMT16ER115NPTF	●		11.5	9.525	3.44	1.1	1.5	0.04	1.63	
		MMT16ER080NPTF	●		8	9.525	3.44	1.3	1.8	0.04	2.38	

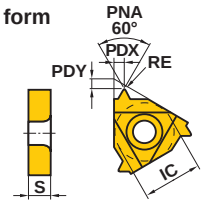


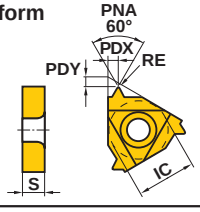












G

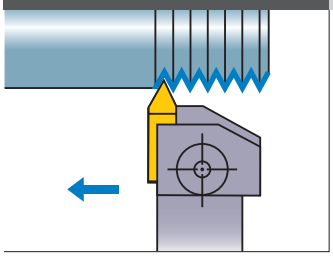
THREADING

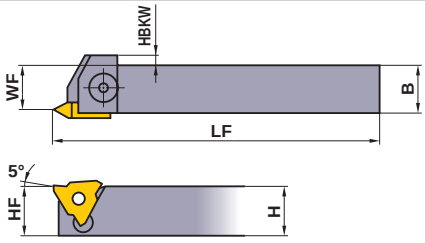
MT HOLDER

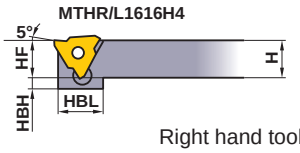
- Clamp-on type.
- Positive insert suffers from negligible chattering and thus produces good finished surfaces.
- Thread pitch ≤4.5mm.

MTH

External threading







Note 1) Cutting in the opposite direction is not possible.

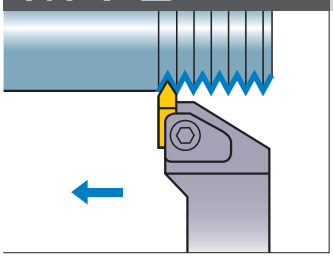
Right hand tool holder shown.

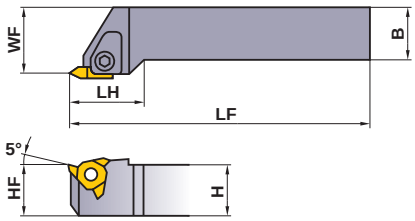
Order Number	Stock R	Stock L	Insert Number	H	B	LF	HF	HBH	HBL	WF	HBKW	Clamp Bridge	Clamp Screw *	Spring	Wrench
MTHR/L1616H4	●	●	MTTR/L43□□□□	16	16	100	16	3	21	13.8	3	MTK1R/L	HBH06020	MES3	HKY40R
MTHR/L2020K4	●	●		20	20	125	20	—	—	17.8	—	MTK1R/L	HBH06020	MES3	HKY40R
MTHR/L2525M4	●	●		25	25	150	25	—	—	22.8	—	MTK1R/L	HBH06020	MES3	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0

MT1

External threading





Note 1) Cutting in the opposite direction is not possible.

Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number	H	B	LF	LH	HF	WF	Clamp Bridge	Clamp Screw *	Spring	Wrench
MT1R/L2020K4	●	●	MTTR/L43□□□□	20	20	125	30	20	25	MTK1R/L	HBH06020	MES3	HKY40R
MT1R/L2525M4	●	●		25	25	150	30	25	32	MTK1R/L	HBH06020	MES3	HKY40R
MT1R/L3232P4	●	●		32	32	170	30	32	40	MTK1R/L	HBH06020	MES3	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0

RECOMMENDED CUTTING CONDITIONS

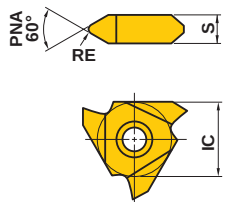
	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UP20M**	140 (100—180)
			NX2525	200 (150—250)
			UTi20T	120 (100—150)
	Carbon Steel Alloy Steel	180—280HB	**UP20M**	120 (100—150)
			NX2525	170 (150—200)
			UTi20T	100 (70—120)

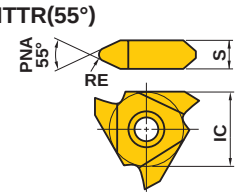
	Work Material	Hardness	Grade	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	**UP20M**	120 (80—150)
			UTi20T	100 (70—130)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**UP20M**	80 (60—100)
			UTi20T	80 (60—100)
			HTi10	100 (70—130)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(10 inserts in one case)

INSERTS

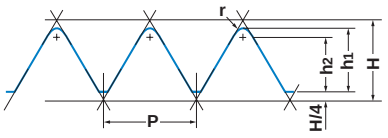
Type	Order Number	Class	Coated UP20M	Cermet NX2525	Cermet	Carbide UTi20T	Carbide HTi10	ISO Pitch mm (thread/inch)	Dimensions (mm) IC	S	RE	Geometry
Partial Profile 60°	MTTR436000	G		●		●		−0.8	12.7	4.76	0	MTTR/L(60°)
	MTTR436001	G	●	●		●	●	1.0−1.75	12.7	4.76	0.1	
	MTTL436001	G	●			●	●	1.0−1.75	12.7	4.76	0.1	
	MTTR436002	G	●	●		●	●	2.0−2.5	12.7	4.76	0.2	
	MTTL436002	G		●		●		2.0−2.5	12.7	4.76	0.2	
	MTTR436003	G	□	●		●	●	3.0−3.5	12.7	4.76	0.3	
	MTTL436003	G		●		●		3.0−3.5	12.7	4.76	0.3	
	MTTR436004	G		●		●		4.0−4.5	12.7	4.76	0.4	Right hand insert shown.
Partial Profile 55°	MTTR435501	G		●		●		(28−10)	12.7	4.76	0.1	MTTR(55°)
	MTTR435502	G		●		●		(16−8)	12.7	4.76	0.2	
	MTTR435503	G		●		●		(11−8)	12.7	4.76	0.3	
												Right hand insert only.





■STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When you use cermet grades or cut stainless steel, please increase the number of passes by 2−3 times.



●METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50
h1		0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76
h2		0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11
r (Corner Radius)		0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

Note 1) The first pass causes a high load on the cutting edge. In order to avoid damage, keep the depth of cut to 0.4−0.5mm maximum.

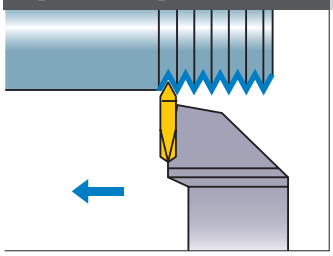
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

SMG HOLDER

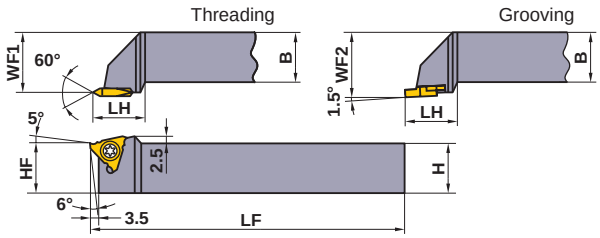
- Screw-on type.
- Positive insert suffers from negligible chattering.
- Suitable for narrow grooving and threading.
- Thread pitch ≤2.0 mm.

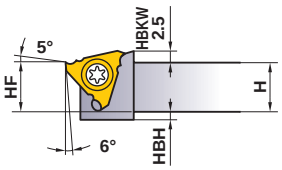
SMGH

External threading, Grooving



Note 1) Cutting in the opposite direction is not possible.





SMGHR1010E16 : HBH=4
SMGHR1212F16 : HBH=2

Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)							*	
	R	Threading	Grooving	H	B	LF	LH	HF	WF1	WF2	Clamp Screw	Wrench
SMGHR1010E16	●	SMTTR160360◌◌	SMGTR16X2◌◌◌ SMGTR16X2◌◌◌C	10	10	70	16.5	10	11.7	12	FC400890T	TKY10F
SMGHR1212F16	●			12	12	80	16.5	12	15.7	16	FC400890T	TKY10F
SMGHR1616H16	●			16	16	100	20	16	19.7	20	FC400890T	TKY10F
SMGHR2020K16	●			20	20	125	20	20	24.7	25	FC400890T	TKY10F
SMGHR2525M16	●			25	25	150	20	25	31.7	32	FC400890T	TKY10F

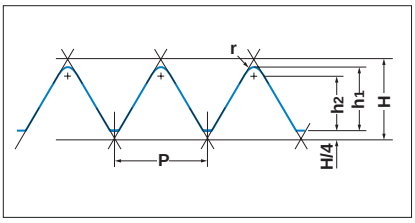
* Clamp Torque (N • m) : FC400890T=2.5

G

THREADING

■STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When you use cermet grades or cut stainless steel, please increase the number of passes by 2−3 times.



●METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00
h1		0.46	0.61	0.77	0.92	1.07	1.23
h2		0.35	0.47	0.59	0.70	0.82	0.94
r (Corner Radius)		0.11	0.14	0.18	0.22	0.25	0.29
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25
	2	0.13	0.15	0.18	0.20	0.20	0.25
	3	0.10	0.10	0.12	0.15	0.20	0.20
	4	0.05	0.10	0.12	0.15	0.15	0.15
	5		0.06	0.10	0.10	0.12	0.15
	6			0.05	0.07	0.10	0.10
	7					0.05	0.08
	8						0.05
	9						

Note 1) The first pass causes a high load on the cutting edge. In order to avoid damage, keep the depth of cut to 0.4−0.5mm maximum.

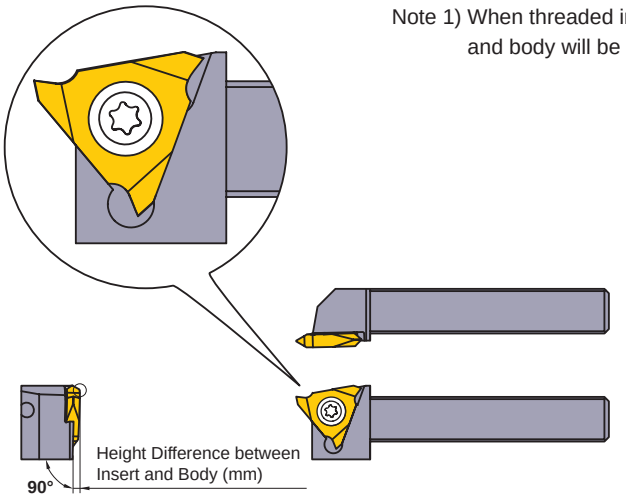
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**NX2525**	200 (150−250)
			UTi20T	120 (100−150)
	Carbon Steel Alloy Steel	180−280HB	**NX2525**	170 (150−200)
			UTi20T	100 (70−120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	**UTi20T**	100 (70−130)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**UTi20T**	80 (60−100)
			HTi10	100 (70−130)

● : Inventory maintained in Japan. (10 inserts in one case)

Conditions when Inserts are Installed

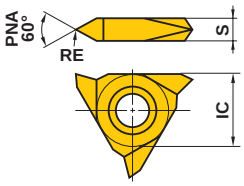


Note 1) When threaded inserts are installed on the body, the height difference between the insert and body will be as shown in the following table.

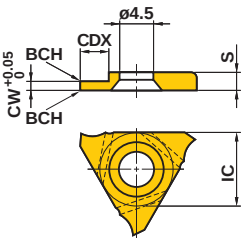
Height Difference between Insert and Body (mm)

Threading	Grooving
1.23	0.05

SMT INSERTS (Threading)

Order Number	Carbide	Thread Pitch (mm)	Dimensions (mm)			Geometry
	UTi20T		IC	S	RE	
SMTTR16036001	●	1.0—1.5	9.525	3.18	0.1	
SMTTR16036002	●	1.75—2.0	9.525	3.18	0.2	

SMG INSERTS (Grooving)

Order Number	Cermet	Carbide		Dimensions (mm)					Geometry
	NX2525	UTi20T	HTi10	CW	CDX	IC	S	BCH	
SMGTR16X2050			●	0.5	1.5	9.525	2	—	
SMGTR16X2060	●	●	●	0.6	1.5	9.525	2	—	
SMGTR16X2050C	●	●	●	0.5	1.5	9.525	2	0.05	
SMGTR16X2060C	●	●	●	0.6	1.5	9.525	2	0.05	
SMGTR16X2070C	●	●	●	0.7	2	9.525	2	0.05	
SMGTR16X2075C	●	●	●	0.75	2	9.525	2	0.05	
SMGTR16X2080C	●	●	●	0.8	2	9.525	2	0.1	
SMGTR16X2090C	●	●	●	0.9	2	9.525	2	0.1	
SMGTR16X2095C	●	●	●	0.95	2	9.525	2	0.1	
SMGTR16X2100C	●	●	●	1	2.5	9.525	2	0.1	
SMGTR16X2110C	●	●	●	1.1	2.5	9.525	2	0.1	
SMGTR16X2120C	●	●	●	1.2	2.5	9.525	2	0.1	
SMGTR16X2130C	●	●	●	1.3	2.5	9.525	2	0.1	

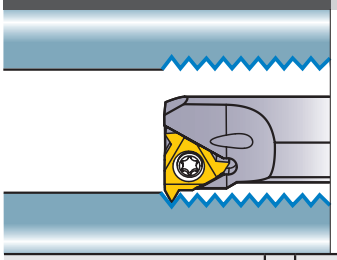
Note 1) Please refer to the page F118 for cutting conditions of grooving.

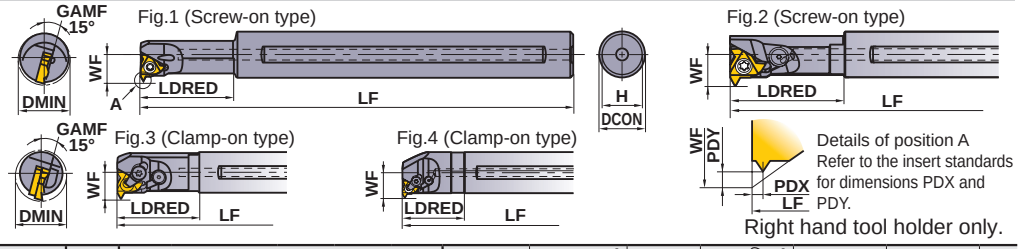
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

MMTI TYPE BORING BARS

MMTI

Internal threading





Right hand tool holder only.

Order Number	Stock R	Insert Number	Lead Angle	Dimensions (mm) DCON	LF	LDRED	WF	H	DMIN	Clamp Bridge	Clamp Screw *	Stop Ring	①Shim Screw ②Embedded Seat Screw *	Shim	Wrench ① ②	Fig
MMTIR1316AK11-SP15	●	MMT11IR	1.5°	16	125	25	8.7	15	**13**	—	TS25	—	—	—	①TKY08F	1
MMTIR1316AK11-SP25	●		2.5°	16	125	25	8.7	15	**13**	—	TS25	—	—	—	①TKY08F	1
MMTIR1316AK11-SP35	●		3.5°	16	125	25	8.7	15	**13**	—	TS25	—	—	—	①TKY08F	1
MMTIR1516AM11-SP15	●		1.5°	16	150	32	9.7	15	**15**	—	TS25	—	—	—	①TKY08F	1
MMTIR1516AM11-SP25	●		2.5°	16	150	32	9.7	15	**15**	—	TS25	—	—	—	①TKY08F	1
MMTIR1516AM11-SP35	●		3.5°	16	150	32	9.7	15	**15**	—	TS25	—	—	—	①TKY08F	1
MMTIR1916AM16-SP15	●	MMT16IR	1.5°	16	150	40	12.2	15	**19**	—	CS350860T	—	—	—	①TKY15F	2
MMTIR1916AM16-SP25	●		2.5°	16	150	40	12.2	15	**19**	—	CS350860T	—	—	—	①TKY15F	2
MMTIR1916AM16-SP35	●		3.5°	16	150	40	12.2	15	**19**	—	CS350860T	—	—	—	①TKY15F	2
MMTIR2420AQ16-C	●		1.5°	20	180	40	14.2	19	**24**	SETK51	SETS51	CR4	①HFC03006 ②TFS03006	CTI32TP15	①TKY15F ②HKY20R	3
MMTIR2925AS16-C	●		1.5°	25	250	60	16.7	23.4	**29**	SETK51	SETS51	CR4	①HFC03006 ②TFS03006	CTI32TP15	①TKY15F ②HKY20R	3
MMTIR3732AS16-C	●		1.5°	32	250	48	20.5	30.4	**37**	SETK51	SETS51	CR4	①HFC03006 ②TFS03006	CTI32TP15	①TKY15F ②HKY20R	4
MMTIR2420AQ22-SP15	●	MMT22IR	1.5°	20	180	50	15.5	19	**24**	—	TS43	—	—	—	①TKY15F	2
MMTIR2420AQ22-SP25	●		2.5°	20	180	50	15.5	19	**24**	—	TS43	—	—	—	①TKY15F	2
MMTIR2420AQ22-SP35	●		3.5°	20	180	50	15.5	19	**24**	—	TS43	—	—	—	①TKY15F	2
MMTIR3025AR22-C	●		1.5°	25	200	38	17.8	23.4	**30**	SETK61	SETS61	CR5	①HFC04008 ②TFS03006	CTI43TP15	①TKY20F ②HKY25R	4
MMTIR3832AS22-C	●		1.5°	32	250	48	21.8	30.4	**38**	SETK61	SETS61	CR5	①HFC04008 ②TFS03006	CTI43TP15	①TKY20F ②HKY25R	4
MMTIR4640AT22-C	●		1.5°	40	300	60	26.2	38	**46**	SETK61	SETS61	CR5	①HFC04008 ②TFS03006	CTI43TP15	①TKY20F ②HKY25R	4

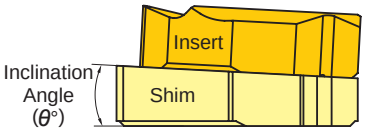
Note) Select and use a shim as shown below (sold separately), dependant on the lead angle.
- A screw-on tool holder uses no shim. (The holder body has a lead angle.) Use a tool holder with the appropriate lead angle.
- Min. cutting diameter (DMIN) shows the internal hole diameter, not the thread diameter.

* Clamp Torque (N • m) : TS25=1.0, CS350860T=3.5, SETS51=3.5, TS43=3.5, SETS61=5.0, HFC03006=1.5, HFC04008=2.2

SHIM

Lead Angle (α°)	Order Number	Stock R	Inclination Angle (θ°)	Applicable Holder
−1.5°	**CTI32TN15**	●	−3°	MMTIR ○○○○ ○○16-C
−0.5°	**CTI32TN05**	●	−2°	
0.5°	**CTI32TP05**	●	−1°	
1.5°	**CTI32TP15**	●	0°	
2.5°	**CTI32TP25**	●	1°	
3.5°	**CTI32TP35**	●	2°	
4.5°	**CTI32TP45**	●	3°	

Lead Angle (α°)	Order Number	Stock R	Inclination Angle (θ°)	Applicable Holder
−1.5°	**CTI43TN15**	●	−3°	MMTIR ○○○○ ○○22-C
−0.5°	**CTI43TN05**	●	−2°	
0.5°	**CTI43TP05**	●	−1°	
1.5°	**CTI43TP15**	●	0°	
2.5°	**CTI43TP25**	●	1°	
3.5°	**CTI43TP35**	●	2°	
4.5°	**CTI43TP45**	●	3°	



Standard shim delivered with the holder.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**VP10MF**	150 (70—230)
			VP15TF	100 (60—140)
			VP20RT	80 (60—100)
	Carbon Steel Alloy Steel	180—280HB	**VP10MF**	140 (80—200)
			VP15TF	100 (60—140)
			VP20RT	80 (60—100)
M	Stainless Steel	≤200HB	**VP15TF**	80 (40—120)
			VP20RT	
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP10MF**	140 (80—200)
			VP15TF	90 (60—120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
S	Heat-Resistant Alloy	—	**VP10MF**	45 (15—70)
			VP15TF	30 (20—40)
			VP20RT	
	Titanium Alloy	—	**VP10MF**	60 (40—80)
			VP15TF	45 (25—65)
			VP20RT	
H	Heat-Treated Alloy	45—55HRC	**VP10MF**	50 (30—70)
			VP15TF	40 (20—60)

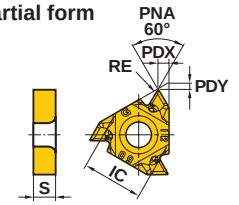
● : **Inventory maintained in Japan. (5 inserts in one case)**

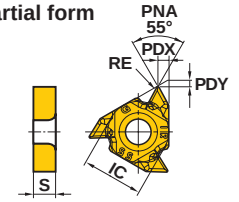
HOW TO SELECT A SHIM ➤ G012
MMT SERIES ORDER NUMBER ➤ G018

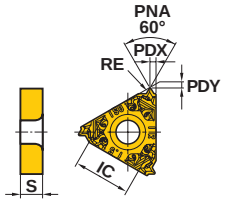
MMT M-CLASS INSERTS WITH 3-D CHIP BREAKERS

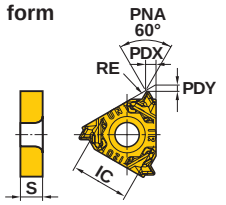
INSERTS

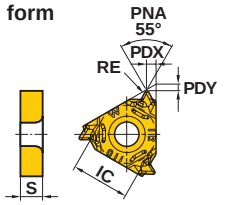
Type	Order Number	Coated VP15TF	Coated VP20RT	Pitch mm	Pitch thread/inch	IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
Partial Profile 60°	MMT11IRA60-S	●		0.5—1.5	48—16	6.35	3.04	0.8	0.9	0.03	—	Partial form
	MMT16IRA60-S	●		0.5—1.5	48—16	9.525	3.44	0.8	0.9	0.03	—	
	MMT16IRG60-S	●		1.75—3.0	14—8	9.525	3.44	1.2	1.7	0.11	—	
Partial Profile 55°	MMT11IRA55-S	●			48—16	6.35	3.04	0.8	0.9	0.07	—	Partial form
	MMT16IRA55-S	●			48—16	9.525	3.44	0.8	0.9	0.07	—	
	MMT16IRG55-S	●			14—8	9.525	3.44	1.2	1.7	0.21	—	
ISO Metric	MMT11IR100ISO-S	●		1.0		6.35	3.04	0.6	0.7	0.06	0.58	Full form
	MMT11IR125ISO-S	●		1.25		6.35	3.04	0.8	0.9	0.08	0.72	
	MMT11IR150ISO-S	●		1.5		6.35	3.04	0.8	1.0	0.10	0.87	
	MMT16IR100ISO-S	●	●	1.0		9.525	3.44	0.6	0.7	0.06	0.58	
	MMT16IR125ISO-S	●	●	1.25		9.525	3.44	0.8	0.9	0.08	0.72	
	MMT16IR150ISO-S	●	●	1.5		9.525	3.44	0.8	1.0	0.10	0.87	
	MMT16IR175ISO-S	●	●	1.75		9.525	3.44	0.9	1.2	0.11	1.01	
	MMT16IR200ISO-S	●	●	2.0		9.525	3.44	1.0	1.3	0.13	1.15	
	MMT16IR250ISO-S	●	●	2.5		9.525	3.44	1.1	1.5	0.17	1.44	
	MMT16IR300ISO-S	●	●	3.0		9.525	3.44	1.1	1.5	0.20	1.73	
American UN	MMT16IR160UN-S	●			16	9.525	3.44	0.9	1.1	0.11	0.92	Full form
	MMT16IR140UN-S	●			14	9.525	3.44	0.9	1.2	0.12	1.05	
	MMT16IR120UN-S	●			12	9.525	3.44	1.1	1.4	0.14	1.22	
Whitworth for BSW, BSP	MMT16IR190W-S	●			19	9.525	3.44	0.8	1.0	0.18	0.86	Full form
	MMT16IR140W-S	●			14	9.525	3.44	1.0	1.2	0.25	1.16	
	MMT16IR110W-S	●			11	9.525	3.44	1.1	1.5	0.32	1.48	
BSPT	MMT16IR190BSPT-S	●			19	9.525	3.44	0.8	0.9	0.18	0.86	Full form
	MMT16IR140BSPT-S	●			14	9.525	3.44	1.0	1.2	0.25	1.16	
	MMT16IR110BSPT-S	●			11	9.525	3.44	1.1	1.5	0.32	1.48	

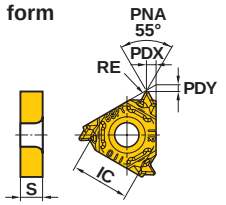












IDENTIFICATION

MMT 16 I R 100 ISO – S

- **MMT** — Designation
- **16** — Diameter of Inscribed Circle (mm)
- **I** — Application
- **R** — Hand of Tool
- **100** — Pitch
- **ISO** — Threading Type
- **S** — M-class inserts with 3-D chip breakers

Diameter of Inscribed Circle (mm)	
11	6.35
16	9.525

Application	
E	External
I	Internal

Hand of Tool	
R	Right

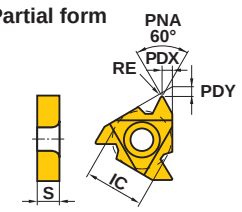
Pitch			
100	1.0mm	A	0.5—1.5mm or 48—16 thread/inch
125	1.25mm		
150	1.5mm	G	1.75—3.0mm or 14—8 thread/inch
175	1.75mm		
200	2.0mm		
250	2.5mm		
300	3.0mm		

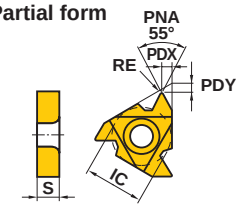
Threading Type	
60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN

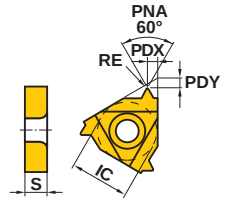
MMT G-CLASS GROUND INSERTS

INSERTS

Type	Thread Tolerance	Order Number	Coated VP10MF	Coated VP15TF	Pitch mm	Pitch thread/inch	IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
Partial Profile 60°	—	MMT11IRA60	●	●	0.5—1.5	48—16	6.35	3.04	0.8	0.9	0.05	—	Partial form
		MMT16IRA60	●	●	0.5—1.5	48—16	9.525	3.44	0.8	0.9	0.05	—	
		MMT16IRG60	●	●	1.75—3.0	14—8	9.525	3.44	1.2	1.7	0.16	—	
		MMT16IRAG60	●		0.5—3.0	48—8	9.525	3.44	1.2	1.7	0.05	—	
		MMT22IRN60	●		3.5—5.0	7—5	12.7	4.64	1.7	2.5	0.30	—	
Partial Profile 55°	—	MMT11IRA55	●	●		48—16	6.35	3.04	0.8	0.9	0.05	—	Partial form
		MMT16IRA55	●	●		48—16	9.525	3.44	0.8	0.9	0.05	—	
		MMT16IRG55	●	●		14—8	9.525	3.44	1.2	1.7	0.21	—	
		MMT16IRAG55	●			48—8	9.525	3.44	1.2	1.7	0.07	—	
		MMT22IRN55	●			7—5	12.7	4.64	1.7	2.5	0.44	—	
ISO Metric	6H	MMT11IR050ISO	●		0.5		6.35	3.04	0.6	0.4	0.03	0.29	Full form
		MMT11IR075ISO	●		0.75		6.35	3.04	0.6	0.6	0.04	0.43	
		MMT11IR100ISO	●	●	1.0		6.35	3.04	0.6	0.7	0.10	0.58	
		MMT11IR125ISO	●	●	1.25		6.35	3.04	0.8	0.9	0.12	0.72	
		MMT11IR150ISO	●	●	1.5		6.35	3.04	0.8	1.0	0.14	0.87	
		MMT11IR175ISO	●		1.75		6.35	3.04	0.9	1.1	0.10	1.01	
		MMT11IR200ISO	●		2.0		6.35	3.04	0.9	1.1	0.18	1.15	
		MMT16IR050ISO	●		0.5		9.525	3.44	0.6	0.4	0.03	0.29	
		MMT16IR075ISO	●		0.75		9.525	3.44	0.6	0.6	0.04	0.43	
		MMT16IR100ISO	●	●	1.0		9.525	3.44	0.6	0.7	0.10	0.58	
		MMT16IR125ISO	●	●	1.25		9.525	3.44	0.8	0.9	0.12	0.72	
		MMT16IR150ISO	●	●	1.5		9.525	3.44	0.8	1.0	0.14	0.87	
		MMT16IR175ISO	●	●	1.75		9.525	3.44	0.9	1.2	0.10	1.01	
		MMT16IR200ISO	●	●	2.0		9.525	3.44	1.0	1.3	0.18	1.15	
		MMT16IR250ISO	●	●	2.5		9.525	3.44	1.1	1.5	0.15	1.44	
		MMT16IR300ISO	●	●	3.0		9.525	3.44	1.1	1.5	0.26	1.73	
		MMT22IR350ISO	●		3.5		12.7	4.64	1.6	2.3	0.22	2.02	
		MMT22IR400ISO	●		4.0		12.7	4.64	1.6	2.3	0.25	2.31	
		MMT22IR450ISO	●		4.5		12.7	4.64	1.6	2.4	0.28	2.60	
		MMT22IR500ISO	●		5.0		12.7	4.64	1.6	2.3	0.32	2.89	







IDENTIFICATION

MMT 16 E R 050 ISO

Designation: MMT

Diameter of Inscribed Circle (mm)

11	6.35
16	9.525
22	12.7

Application

E	External
I	Internal

Hand of Tool

R	Right

Pitch

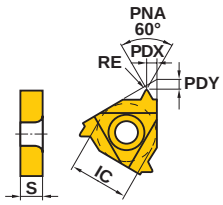
050	0.5mm	A	0.5—1.5mm or 48—16 thread/inch
075	0.75mm		
100	1.0mm		
125	1.25mm	G	1.75—3.0mm or 14—8 thread/inch
150	1.5mm		
175	1.75mm		
200	2.0mm	AG	0.5—3.0mm or 48—8 thread/inch
250	2.5mm		
300	3.0mm		
350	3.5mm	N	3.5—5.0mm or 7—5 thread/inch
400	4.0mm		
450	4.5mm		
500	5.0mm		

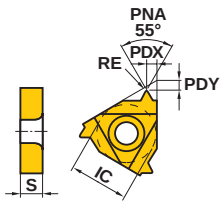
Threading Type

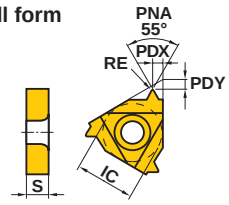
60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN
RD	Round DIN 405
TR	ISO Trapezoidal 30°
ACME	American ACME
UNJ	UNJ
APBU	API Buttress Casing
APRD	API Round Casing&Tubing
NPT	NPT
NPTF	NPTF

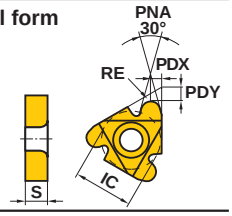
● : Inventory maintained in Japan. (5 inserts in one case)

Type	Thread Tolerance	Order Number	Coated VP10MF	Coated VP15TF	Pitch mm	Pitch thread/inch	Dimensions (mm) IC	S	PDY	PDX	RE	Total Cutting Depth (mm)	Geometry
American UN	2B	MMT11IR320UN	●			32	6.35	3.04	0.6	0.6	0.04	0.46	Full form
		MMT11IR280UN	●			28	6.35	3.04	0.6	0.7	0.05	0.52	
		MMT11IR240UN	●			24	6.35	3.04	0.7	0.8	0.09	0.61	
		MMT11IR200UN	●			20	6.35	3.04	0.8	0.9	0.11	0.73	
		MMT11IR180UN	●			18	6.35	3.04	0.8	1.0	0.12	0.81	
		MMT11IR160UN	●			16	6.35	3.04	0.9	1.1	0.14	0.92	
		MMT11IR140UN	●			14	6.35	3.04	0.9	1.1	0.11	1.05	
		MMT16IR320UN	●			32	9.525	3.44	0.6	0.6	0.04	0.46	
		MMT16IR280UN	●			28	9.525	3.44	0.6	0.7	0.05	0.52	
		MMT16IR240UN	●			24	9.525	3.44	0.7	0.8	0.09	0.61	
		MMT16IR200UN	●			20	9.525	3.44	0.8	0.9	0.11	0.73	
		MMT16IR180UN	●			18	9.525	3.44	0.8	1.0	0.12	0.81	
		MMT16IR160UN	●	●		16	9.525	3.44	0.9	1.1	0.14	0.92	
		MMT16IR140UN	●	●		14	9.525	3.44	0.9	1.2	0.11	1.05	
		MMT16IR130UN	●			13	9.525	3.44	1.0	1.3	0.10	1.13	
		MMT16IR120UN	●	●		12	9.525	3.44	1.1	1.4	0.18	1.22	
		MMT16IR110UN	●			11	9.525	3.44	1.1	1.5	0.13	1.33	
		MMT16IR100UN	●			10	9.525	3.44	1.1	1.5	0.15	1.47	
		MMT16IR090UN	●			9	9.525	3.44	1.2	1.7	0.17	1.63	
		MMT16IR080UN	●			8	9.525	3.44	1.1	1.5	0.27	1.83	
		MMT22IR070UN	●			7	12.7	4.64	1.6	2.3	0.23	2.09	
		MMT22IR060UN	●			6	12.7	4.64	1.6	2.3	0.26	2.44	
		MMT22IR050UN	●			5	12.7	4.64	1.6	2.3	0.32	2.93	
Whitworth for BSW, BSP	Medium Class A	MMT11IR190W	●			19	6.35	3.04	0.8	1.0	0.19	0.86	Full form
		MMT11IR140W	●			14	6.35	3.04	0.9	1.1	0.26	1.16	
		MMT16IR280W	●			28	9.525	3.44	0.6	0.7	0.09	0.58	
		MMT16IR260W	●			26	9.525	3.44	0.7	0.8	0.10	0.63	
		MMT16IR200W	●			20	9.525	3.44	0.8	0.9	0.18	0.81	
		MMT16IR190W	●	●		19	9.525	3.44	0.8	1.0	0.19	0.86	
		MMT16IR180W	●			18	9.525	3.44	0.8	1.0	0.20	0.90	
		MMT16IR160W	●			16	9.525	3.44	0.9	1.1	0.23	1.02	
		MMT16IR140W	●	●		14	9.525	3.44	1.0	1.2	0.26	1.16	
		MMT16IR120W	●			12	9.525	3.44	1.1	1.4	0.30	1.36	
		MMT16IR110W	●	●		11	9.525	3.44	1.1	1.5	0.33	1.48	
		MMT16IR100W	●			10	9.525	3.44	1.1	1.5	0.37	1.63	
		MMT16IR090W	●			9	9.525	3.44	1.2	1.7	0.34	1.81	
		MMT16IR080W	●			8	9.525	3.44	1.2	1.5	0.39	2.03	
		MMT22IR070W	●			7	12.7	4.64	1.6	2.3	0.46	2.32	
		MMT22IR060W	●			6	12.7	4.64	1.6	2.3	0.53	2.71	
		MMT22IR050W	●			5	12.7	4.64	1.7	2.4	0.66	3.25	
BSPT	Standard BSPT	MMT11IR190BSPT	●			19	6.35	3.04	0.8	0.9	0.14	0.86	Full form
		MMT11IR140BSPT	●			14	6.35	3.04	0.9	1.0	0.26	1.16	
		MMT16IR190BSPT	●	●		19	9.525	3.44	0.8	0.9	0.14	0.86	
		MMT16IR140BSPT	●	●		14	9.525	3.44	1.0	1.2	0.26	1.16	
		MMT16IR110BSPT	●	●		11	9.525	3.44	1.1	1.5	0.33	1.48	
Round DIN 405	7H	MMT16IR100RD	●			10	9.525	3.44	1.1	1.2	0.55	1.27	Full form
		MMT16IR080RD	●			8	9.525	3.44	1.4	1.4	0.70	1.59	
		MMT16IR060RD	●			6	9.525	3.44	1.4	1.5	0.93	2.12	
		MMT22IR040RD	●			4	12.7	4.64	2.2	2.3	1.40	3.18	









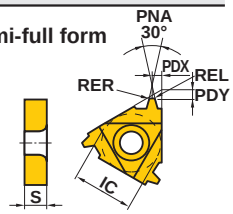
G

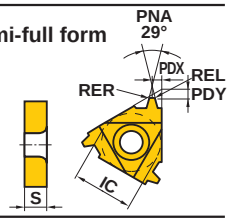
THREADING

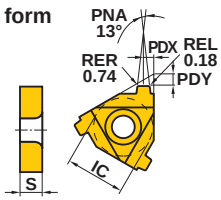
MMT G-CLASS GROUND INSERTS

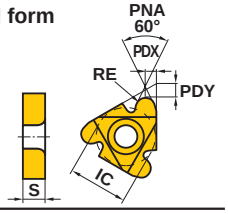
INSERTS

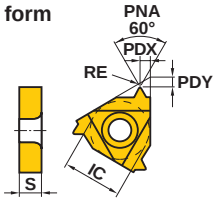
Type	Thread Tolerance	Order Number	Coated VP10MF	Pitch mm	Pitch thread/inch	IC	S	PDY	PDX	RE RER/L	Total Cutting Depth (mm)	Geometry
ISO Trapezoidal 30°	7H	MMT16IR150TR	●	1.5		9.525	3.44	1.0	1.1	0.08	0.90	Semi-full form
		MMT16IR200TR	●	2.0		9.525	3.44	1.1	1.3	0.15	1.25	
		MMT16IR300TR	●	3.0		9.525	3.44	1.3	1.5	0.15	1.75	
		MMT22IR400TR	●	4.0		12.7	4.64	1.7	1.9	0.15	2.25	
		MMT22IR500TR	●	5.0		12.7	4.64	2.1	2.5	0.15	2.75	
American ACME	3G	MMT16IR120ACME	●		12	9.525	3.44	1.2	1.3	0.05	1.19	Semi-full form
		MMT16IR100ACME	●		10	9.525	3.44	1.2	1.3	0.08	1.52	
		MMT16IR080ACME	●		8	9.525	3.44	1.4	1.5	0.10	1.84	
		MMT22IR060ACME	●		6	12.7	4.64	1.8	2.1	0.10	2.37	
		MMT22IR050ACME	●		5	12.7	4.64	2.0	2.3	0.10	2.79	
UNJ		When machining an internal UNJ thread, cut an internal hole with the appropriate diameter. Then machine with 60° American UN. In this case, a full form type insert cannot be used.										
API Buttress Casing	Standard API	MMT22IR050APBU	●		5	12.7	4.64	2.8	1.9	0.74/0.18	1.55	Full form
API Round Casing&Tubing	Standard API RD	MMT16IR100APRD	●		10	9.525	3.44	1.2	1.4	0.34	1.41	Full form
		MMT16IR080APRD	●		8	9.525	3.44	1.3	1.5	0.41	1.81	
American NPT	Standard NPT	MMT16IR270NPT	●		27	9.525	3.44	0.7	0.8	0.04	0.66	Full form
		MMT16IR180NPT	●		18	9.525	3.44	0.8	1.0	0.08	1.01	
		MMT16IR140NPT	●		14	9.525	3.44	0.9	1.2	0.09	1.33	
		MMT16IR115NPT	●		11.5	9.525	3.44	1.1	1.5	0.11	1.64	
		MMT16IR080NPT	●		8	9.525	3.44	1.3	1.8	0.14	2.42	
American NPTF	Class 2	MMT16IR140NPTF	●		14	9.525	3.44	0.9	1.2	0.04	1.35	Full form
		MMT16IR115NPTF	●		11.5	9.525	3.44	1.1	1.5	0.04	1.63	
		MMT16IR080NPTF	●		8	9.525	3.44	1.3	1.8	0.04	2.38	

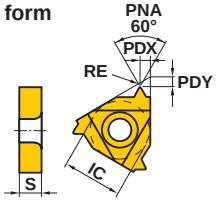










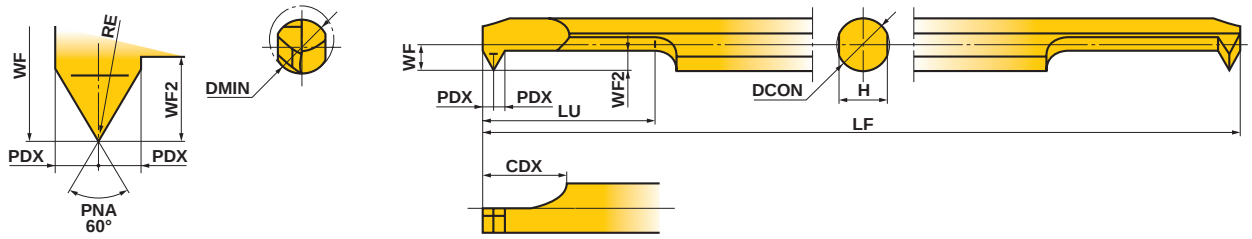


● : Inventory maintained in Japan. (5 inserts in one case)

CUTTING DEPTH GUIDE ➤ G016

MICRO-MINI TWIN

■CT STANDARD



Order Number	Stock: Micro Grain Carbide TF15	Stock: Coated VP15TF	Breaker	Threads: Metric Screw Thread	Threads: Metric Screw Pitch (mm)	Threads: Unified Coarse Screw Thread	Threads: Unified Coarse Screw Pitch (thread/inch)	Dimensions (mm) DMIN	RE	DCON	LF	LU	CDX	WF	PDX	WF2	H
CT0305RS-M4	●	●	Without	≥M4	0.5−1.0	≥NO.8-32UNC	36−24	**3**	0.03	3	50	5.2	6	1.3	0.6	1.2	2.7
CT03RS-M4	●	●	Without	≥M4	0.5−1.0	≥NO.8-36UNF	36−24	**3**	0.03	3	50	10.2	6	1.3	0.6	1.2	2.7
CT03RS-M4B	●	●	With	≥M4	0.5−1.0		36−24	**3**	0.03	3	50	10.2	6	1.3	0.6	1.2	2.7
CT0407RS-M6	●	●	Without	≥M6	0.75−1.25	≥1/4-20UNC	28−20	**4.5**	0.05	4	60	7.6	7	1.8	0.8	1.7	3.6
CT04RS-M6	●	●	Without	≥M6	0.75−1.25	≥1/4-28UNF	28−20	**4.5**	0.05	4	60	15.6	7	1.8	0.8	1.7	3.6
CT04RS-M6B	●	●	With	≥M6	0.75−1.25		28−20	**4.5**	0.05	4	60	15.6	7	1.8	0.8	1.7	3.6
CT0511RS-M8	●	●	Without	≥M8	0.75−1.5	≥5/16-18UNC	24−18	**6**	0.05	5	70	11	8	2.3	1	2.2	4.5
CT05RS-M8	●	●	Without	≥M8	0.75−1.5	≥5/16-24UNF	24−18	**6**	0.05	5	70	21	8	2.3	1	2.2	4.5
CT05RS-M8B	●	●	With	≥M8	0.75−1.5		24−18	**6**	0.05	5	70	21	8	2.3	1	2.2	4.5
CT0611RS-M10	●	●	Without	≥M10	0.75−1.75	≥3/8-16UNC	24−16	**7**	0.05	6	75	11	8	2.8	1	2.2	5.4
CT06RS-M10	●	●	Without	≥M10	0.75−1.75	≥3/8-24UNF	24−16	**7**	0.05	6	75	21	8	2.8	1	2.2	5.4
CT06RS-M10B	●	●	With	≥M10	0.75−1.75		24−16	**7**	0.05	6	75	21	8	2.8	1	2.2	5.4

RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Recommended Tool Overhang (mm)
P	Carbon Steel Alloy Steel	50 (30−80)	Micro-Mini Twin CT; LU+2(mm); Holder
M	Stainless Steel	50 (30−80)	
K	Cast Iron	50 (30−80)	
N	Non-Ferrous Metal	80 (50−100)	

Note 1) Wet cutting is recommended.
Note 2) Pay special attention to machining of small diameters at high revolutions as the feed rate cannot keep up with the speed.

■STANDARD OF DEPTH OF CUT

● The chart on the right shows the cutting depths when machining external ISO metric screw threads.

● Metric

(mm)

P(Pitch)		0.50	0.75	1.00	1.25	1.50	1.75
Total Cutting Depth		**0.29**	**0.43**	**0.58**	**0.72**	**0.87**	**1.01**
Number of Passes	1	0.06	0.06	0.07	0.07	0.07	0.07
	2	0.05	0.06	0.06	0.07	0.07	0.07
	3	0.05	0.05	0.06	0.07	0.07	0.07
	4	0.04	0.05	0.05	0.07	0.07	0.07
	5	0.03	0.04	0.05	0.06	0.06	0.07
	6	0.03	0.04	0.05	0.06	0.06	0.06
	7	0.02	0.04	0.04	0.05	0.06	0.06
	8	0.01	0.03	0.04	0.05	0.06	0.06
	9	–	0.03	0.04	0.05	0.05	0.06
	10	–	0.02	0.03	0.04	0.05	0.05
	11	–	0.01	0.03	0.04	0.05	0.05
	12	–	–	0.03	0.03	0.04	0.05
	13	–	–	0.02	0.03	0.04	0.04
	14	–	–	0.01	0.02	0.03	0.04
	15	–	–	–	0.01	0.03	0.04
	16	–	–	–	–	0.03	0.03
	17	–	–	–	–	0.02	0.03
	18	–	–	–	–	0.01	0.03
	19	–	–	–	–	–	0.03
	20	–	–	–	–	–	0.02
	21	–	–	–	–	–	0.01

● : Inventory maintained in Japan. (MICRO-MINI TWIN is available in 1 piece in one pack.)

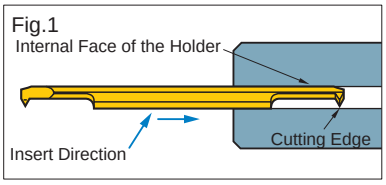
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

■PRECAUTIONS WHEN USING THE MICRO-MINI TWIN

●When using a holder for general purpose / small automatic lathe:

1 To avoid chipping of the 2nd cutting edge take care when inserting the boring bar into the holder. Refer to fig.1. If the 2nd edge contacts the internal face of the holder there is a possibility that it may chip.

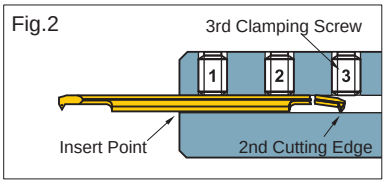
Fig.1



2 When using this type of holder, there is a possibility that damage to the shank and the 2nd cutting edge can occur. Make sure that the clamping screws are tightened to the set torque value. Additionally make sure that there is no clamping screw near the 2nd cutting edge as this can break the boring bar.

◎When using Mitsubishi holders
When using holders with a tool overhang of recommended quantity, ensure that the 3rd clamping screw is removed prior to machining. The set torque value for clamping screw is 2.0 N • m.

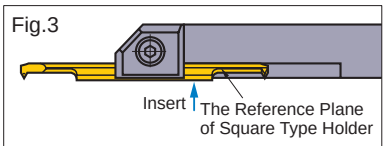
Fig.2



●When using a square type holder:

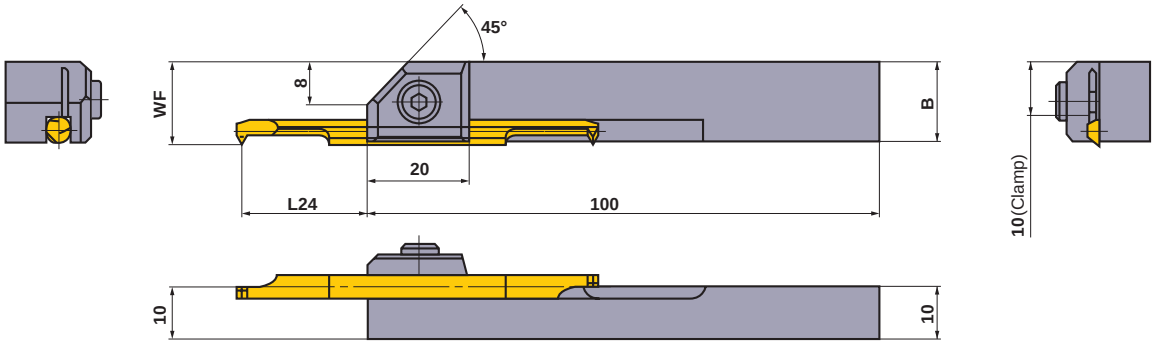
1 When installing the boring bar into the holder, tighten the clamp screws after ensuring the flats on the tool holder are parallel to the reference flats on the micro-mini bar. Refer to fig.3.
2 Make sure that the clamping screws are tightened to the recommended values.
3 Do not tighten the clamp screw without a bar in place, otherwise the bridge will be deformed.

Fig.3



Tighten the clamping screw ensuring making the micro-mini twin boring bars in contact with the reference plane of square type holder.

SQUARE TYPE HOLDER

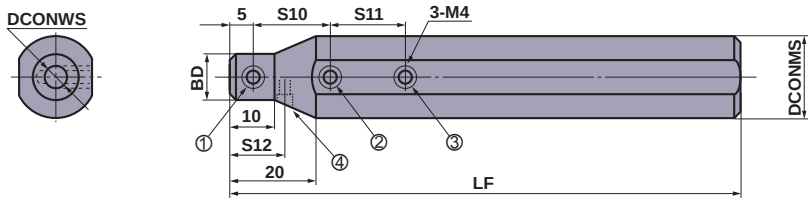


Order Number	Stock	Dimensions (mm) Micro-Mini Twin **CT**			Micro-Mini Twin **CT**	Clamp Screw	Wrench	Torque (N•m)
		B	**WF**	*** L24**				
SBH1030R	●	13.8	13.8	13−17.5(14)	0305RS-M4, 03RS-M4(B)	HSC05012	HKY40R	9.5
SBH1040R	●	14.7	14.8	18.5−22(19.5)	0407RS-M6, 04RS-M6(B)	HSC05012	HKY40R	9.5
SBH1050R	●	15.6	15.8	24−26.5(25)	0511RS-M8, 05RS-M8(B)	HSC05012	HKY40R	9.5
SBH1060R	●	16.5	16.8	24−31.5(25)	0611RS-M10, 06RS-M10(B)	HSC05012	HKY40R	9.5

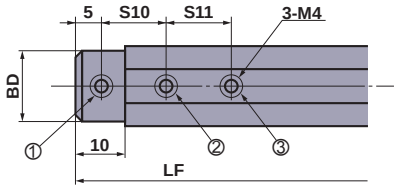
* L24 is the length of overhang for sufficient clamping, and ( ) is the recommended length for machining of carbon and alloy steel.

● : Inventory maintained in Japan.

ROUND TYPE HOLDER



RBH22□□N has a temporary set screw for different machine specifications.
(Represented by number 4)



RBH158□□N, RBH16□□N,
RBH190□□N

Order Number	Stock	Dimensions (mm)							Micro-Mini Twin CT	⋆1 Clamp Screw				Wrench	Torque (N•m)
		DCONMS	DCONWS	BD	LF	S10	S11	S12		①	②	③	④		
RBH15830N	●	15.875	3	15	100	10	10	—	0305RS-M4, 03RS-M4(B)	A	A	A	—	HKY20F	2.0
RBH15840N	●	15.875	4	15	100	15	15	—	0407RS-M6, 04RS-M6(B)	A	A	A	—	HKY20F	2.0
RBH15850N	●	15.875	5	15	100	15	15	—	0511RS-M8, 05RS-M8(B)	A	A	A	—	HKY20F	2.0
RBH15860N	●	15.875	6	15	100	15	15	—	0611RS-M10, 06RS-M10(B)	A	A	A	—	HKY20F	2.0
RBH1630N	●	16	3	15	100	10	10	—	0305RS-M4, 03RS-M4(B)	A	A	A	—	HKY20F	2.0
RBH1640N	●	16	4	15	100	15	15	—	0407RS-M6, 04RS-M6(B)	A	A	A	—	HKY20F	2.0
RBH1650N	●	16	5	15	100	15	15	—	0511RS-M8, 05RS-M8(B)	A	A	A	—	HKY20F	2.0
RBH1660N	●	16	6	15	100	15	15	—	0611RS-M10, 06RS-M10(B)	A	A	A	—	HKY20F	2.0
⋆2 RBH19030N	●	19.05	3	18	125	10	10	—	0305RS-M4, 03RS-M4(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19040N	●	19.05	4	18	125	15	15	—	0407RS-M6, 04RS-M6(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19050N	●	19.05	5	18	125	15	15	—	0511RS-M8, 05RS-M8(B)	B	B	B	—	HKY20F	2.0
⋆2 RBH19060N	●	19.05	6	18	125	15	15	—	0611RS-M10, 06RS-M10(B)	B	B	B	—	HKY20F	2.0
RBH2030N	●	20	3	12	125	10	10	—	0305RS-M4, 03RS-M4(B)	A	A	B	—	HKY20F	2.0
RBH2040N	●	20	4	13	125	15	15	—	0407RS-M6, 04RS-M6(B)	A	B	B	—	HKY20F	2.0
RBH2050N	●	20	5	14	125	15	15	—	0511RS-M8, 05RS-M8(B)	A	B	B	—	HKY20F	2.0
RBH2060N	●	20	6	15	125	15	15	—	0611RS-M10, 06RS-M10(B)	A	B	B	—	HKY20F	2.0
RBH2230N	●	22	3	12	125	10	10	10	0305RS-M4, 03RS-M4(B)	A	B	C	A	HKY20F	2.0
RBH2240N	●	22	4	13	125	15	15	12.5	0407RS-M6, 04RS-M6(B)	A	B	B	A	HKY20F	2.0
RBH2250N	●	22	5	14	125	15	15	12.5	0511RS-M8, 05RS-M8(B)	A	B	B	A	HKY20F	2.0
RBH2260N	●	22	6	15	125	15	15	15	0611RS-M10, 06RS-M10(B)	A	B	B	A	HKY20F	2.0
RBH2530N	●	25	3	12	150	10	10	—	0305RS-M4, 03RS-M4(B)	A	B	C	—	HKY20F	2.0
RBH2540N	●	25	4	13	150	15	15	—	0407RS-M6, 04RS-M6(B)	A	C	C	—	HKY20F	2.0
RBH2550N	●	25	5	14	150	15	15	—	0511RS-M8, 05RS-M8(B)	A	C	C	—	HKY20F	2.0
RBH2560N	●	25	6	15	150	15	15	—	0611RS-M10, 06RS-M10(B)	A	C	C	—	HKY20F	2.0
RBH25430N	●	25.4	3	12	150	10	10	—	0305RS-M4, 03RS-M4(B)	A	B	C	—	HKY20F	2.0
RBH25440N	●	25.4	4	13	150	15	15	—	0407RS-M6, 04RS-M6(B)	A	C	C	—	HKY20F	2.0
RBH25450N	●	25.4	5	14	150	15	15	—	0511RS-M8, 05RS-M8(B)	A	C	C	—	HKY20F	2.0
RBH25460N	●	25.4	6	15	150	15	15	—	0611RS-M10, 06RS-M10(B)	A	C	C	—	HKY20F	2.0

⋆1 Order number of clamp screw A=HSS04004, B=HSS04006, C=HSS04008
⋆2 Revised order number.

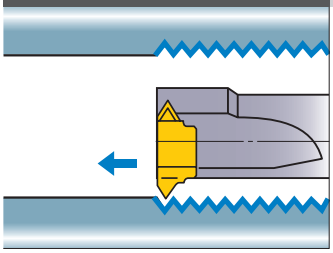
Conventional Order Number	Revised Order Number
RBH1930N	RBH19030N
RBH1940N	RBH19040N
RBH1950N	RBH19050N
RBH1960N	RBH19060N

F TYPE BORING BARS

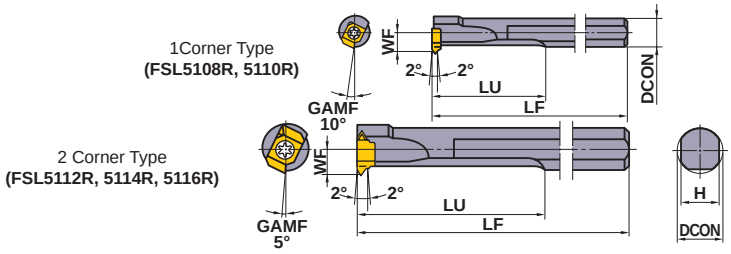
- Minimum cutting diameter 10mm.
- Screw-on type.
- Applicable to threading, grooving.
- Thread pitch 1.5−3.5mm.

FSL51

Internal threading, Grooving



Note 1) Cutting in the opposite direction is not possible.



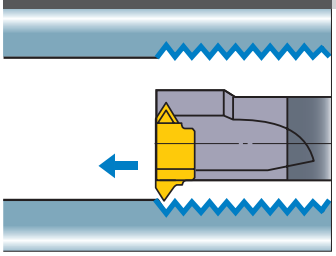
Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)						*2	
	R	Threading	Grooving	DCON	LF	LU	WF	H	DMIN*1	Clamp Screw	Wrench
FSL5108R	●	MLT1001L	MLG10◌◌L	8	125	30	4.8	7	**10**	TS25	TKY08F
FSL5110R	●	MLT1001L	MLG10◌◌L	10	150	40	5.8	9	**12**	TS25	TKY08F
FSL5112R	●	MLT1401L	MLG14◌◌L	12	180	50	6.8	10.8	**14**	TS32	TKY08F
FSL5114R	●	MLT1401L	MLG14◌◌L	14	180	60	7.8	12.4	**16**	TS32	TKY08F
FSL5116R	●	MLT2001L	MLG20◌◌L	16	200	70	9.7	14	**20**	TS43	TKY15F

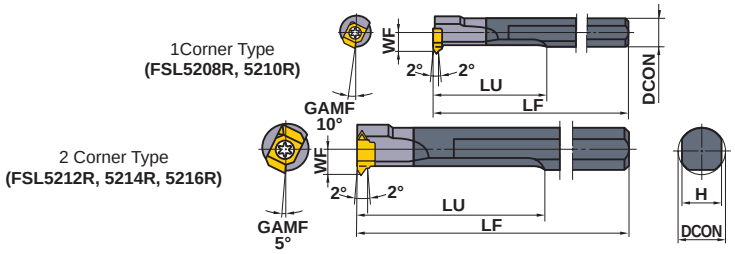
*1 DMIN : Min.Cutting Diameter
*2 Clamp Torque (N • m) : TS25=1.0, TS32=1.0, TS43=3.5

FSL52

(Carbide shank) Internal threading, Grooving



Note 1) Cutting in the opposite direction is not possible.



Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)						*2	
	R	Threading	Grooving	DCON	LF	LU	WF	H	DMIN*1	Clamp Screw	Wrench
FSL5208R	●	MLT1001L	MLG10◌◌L	8	125	60	4.8	7	**10**	TS25	TKY08F
FSL5210R	●	MLT1001L	MLG10◌◌L	10	150	70	5.8	9	**12**	TS25	TKY08F
FSL5212R	●	MLT1401L	MLG14◌◌L	12	180	80	6.8	11	**14**	TS32	TKY08F
FSL5214R	●	MLT1401L	MLG14◌◌L	14	180	85	7.8	12	**16**	TS32	TKY08F
FSL5216R	●	MLT2001L	MLG20◌◌L	16	200	115	9.7	14	**20**	TS43	TKY15F

*1 DMIN : Min.Cutting Diameter
*2 Clamp Torque (N • m) : TS25=1.0, TS32=1.0, TS43=3.5

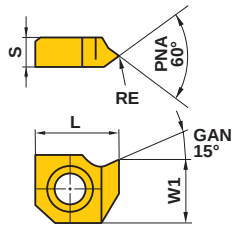
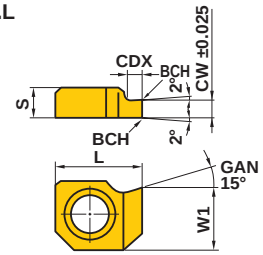
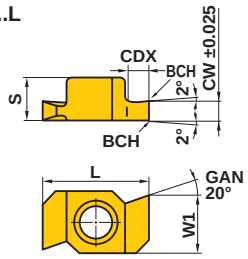
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UP20M**	140 (100−180)
			UTi20T	120 (100−150)
	Carbon Steel Alloy Steel	180−280HB	**UP20M**	120 (100−150)
			UTi20T	100 (70−120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	**UP20M**	120 (80−150)
			UTi20T	100 (70−130)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**UP20M**	80 (60−100)
			UTi20T	80 (60−100)

● : Inventory maintained in Japan. (10 inserts in one case)

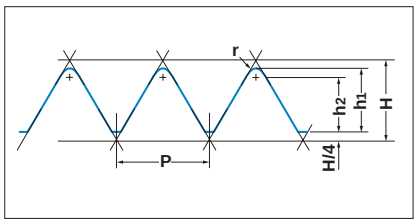
INSERTS

Type	Order Number	Coated UP20M	Carbide UTi20T	Pitch and CW (mm)	Dimensions (mm) L	W1	CDX	S	BCH	RE	Geometry
Threading	**MLT1001L**	●	●	Pitch 1.5—2.0	7	5	—	2.38	—	0.1	**MLT** 
	MLT1401L	●	●	Pitch 1.5—2.5	11.8	6.5	—	4.76	—	0.1	
	MLT2001L	●	●	Pitch 1.5—3.5	16.8	9.03	—	6.35	—	0.1	
Grooving	**MLG1012L**		●	1.2	7	5	1.0	2.38	0.1	—	**MLG...L** 
	MLG1015L		●	1.5	7	5	1.0	2.38	0.1	—	
	MLG1020L		●	2	7	5	1.0	2.38	0.1	—	
	MLG1415L		●	1.5	11.8	6.5	2.0	4.76	0.1	—	**MLG...L** 
	MLG1420L		●	2	11.8	6.5	2.0	4.76	0.1	—	
	MLG1430L		●	3	11.8	6.5	2.0	4.76	0.1	—	
	MLG2020L		●	2	16.8	9.03	3.0	6.35	0.1	—	
	MLG2030L		●	3	16.8	9.03	3.0	6.35	0.1	—	
	MLG2040L		●	4	16.8	9.03	3.0	6.35	0.1	—	

Note 1) Please refer to the page F125 for cutting conditions of grooving.

■STANDARD OF DEPTH OF CUT

- ● The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- ● When you use cermet grades or cut stainless steel, please increase the number of passes by 2—3 times.



●METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50
h_1		0.43	0.58	0.72	0.87	1.01	1.15	1.44	1.73	2.02
h_2		0.38	0.51	0.63	0.76	0.88	1.01	1.21	1.51	1.77
r (Corner Radius)		0.05	0.07	0.09	0.11	0.13	0.14	0.18	0.22	0.25
Number of Passes	1	0.10	0.15	0.18	0.20	0.23	0.25	0.25	0.25	0.30
	2	0.10	0.13	0.15	0.20	0.20	0.20	0.22	0.25	0.25
	3	0.10	0.10	0.12	0.15	0.20	0.15	0.20	0.22	0.22
	4	0.08	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20
	5	0.05	0.05	0.10	0.10	0.10	0.15	0.15	0.20	0.20
	6		0.05	0.05	0.07	0.08	0.10	0.10	0.15	0.20
	7					0.05	0.10	0.10	0.12	0.15
	8						0.05	0.10	0.10	0.15
	9							0.07	0.10	0.10
	10							0.05	0.09	0.10
	11								0.05	0.10
	12									0.05

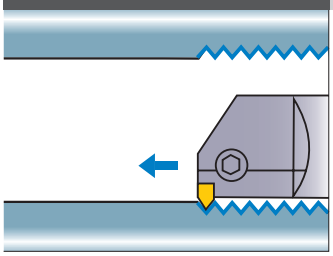
Note 1) The first pass causes a high load on the cutting edge. In order to avoid damage, keep the depth of cut to 0.4—0.5mm maximum.

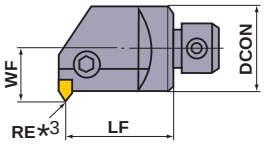
D TYPE BORING HEAD

- Minimum cutting diameter 40mm.
- Pin lock type.
- Exchangeable head type.
- Thread pitch ≤4.5mm.

DPT2

Internal threading





Right hand tool holder only.

Order Number	Stock R	Insert Number	Dimensions (mm) DCON	LF	WF	DMIN*2	RE*3	Lock Pin	Lock Screw *1	Stop Ring	Wrench
DPT2132R	●	MTTL4360◌◌	32	40	20	**40**	0.1	P21S	HSP08014	E01	HKY40R
DPT2140R	●		40	50	25	**50**	0.1	P21S	HSP08014	E01	HKY40R

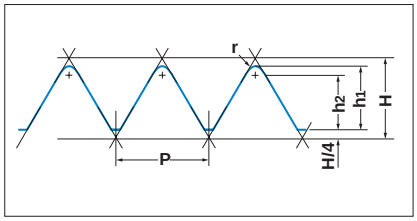
*1 Clamp Torque (N • m) : HSP08014=7.0
*2 DMIN : Min.Cutting Diameter
*3 Dimensions shown for insert corner RE 0.1.

G

THREADING

■STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When you use cermet grades or cut stainless steel, please increase the number of passes by 2−3 times.



●METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50
h1		0.43	0.58	0.72	0.87	1.01	1.15	1.44	1.73	2.02	2.31	2.60
h2		0.38	0.51	0.63	0.76	0.88	1.01	1.21	1.51	1.77	2.02	2.28
r (Corner Radius)		0.05	0.07	0.09	0.11	0.13	0.14	0.18	0.22	0.25	0.29	0.32
Number of Passes	1	0.10	0.15	0.18	0.20	0.23	0.25	0.25	0.25	0.30	0.30	0.35
	2	0.10	0.13	0.15	0.20	0.20	0.20	0.22	0.25	0.25	0.25	0.30
	3	0.10	0.10	0.12	0.15	0.20	0.15	0.20	0.22	0.22	0.25	0.25
	4	0.08	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5	0.05	0.05	0.10	0.10	0.10	0.15	0.15	0.20	0.20	0.23	0.25
	6		0.05	0.05	0.07	0.08	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.10	0.10	0.12	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.07	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.08	0.10
	13										0.05	0.10
	14											0.05

Note 1) The first pass causes a high load on the cutting edge. In order to avoid damage, keep the depth of cut to 0.4−0.5mm maximum.

RECOMMENDED CUTTING CONDITIONS

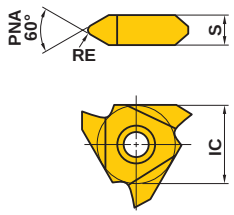
	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UP20M**	140 (100−180)
			NX2525	200 (150−250)
			UTi20T	120 (100−150)
	Carbon Steel Alloy Steel	180−280HB	**UP20M**	120 (100−150)
			NX2525	170 (150−200)
			UTi20T	100 (70−120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	**UP20M**	120 (80−150)
			UTi20T	100 (70−130)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**UP20M**	80 (60−100)
			UTi20T	80 (60−100)
			HTi10	100 (70−130)

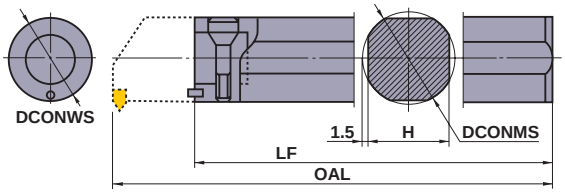
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Type	Order Number	Class	Coated	Cermet		Carbide		ISO Pitch mm	Dimensions (mm)			Geometry
			UP20M	NX2525		UTi20T	HTi10		IC	S	RE	
Partial Profile 60°	**MTTL436001**	G	●			●	●	1.0—1.75	12.7	4.76	0.1	**MTTL(60°)**
	MTTL436002	G		●		●		2.0—2.5	12.7	4.76	0.2	
	MTTL436003	G		●		●		3.0—3.5	12.7	4.76	0.3	

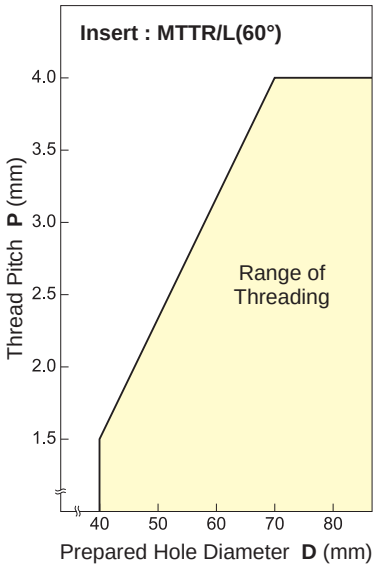


STANDARD ARBOR FOR D TYPE BORING HEAD



Order Number	Stock	Dimensions (mm)					Set Bolt	Wrench	Head
		DCONWS	DCONMS	LF	H	OAL			
B13232	●	32	32	260	29	300	SD32	HKY60R	DPT2132R
B14040	●	40	40	310	37	360	SD40	HKY60R	DPT2140R

■RANGE OF MACHINING



HOW TO READ THE STANDARD OF HSK-T TOOLS

●How this section page is organised

①Organised by application. (Refer to the index on the next page.)

PRODUCT TYPE
indicates the first four letters of the order number, as well as cutting applications.

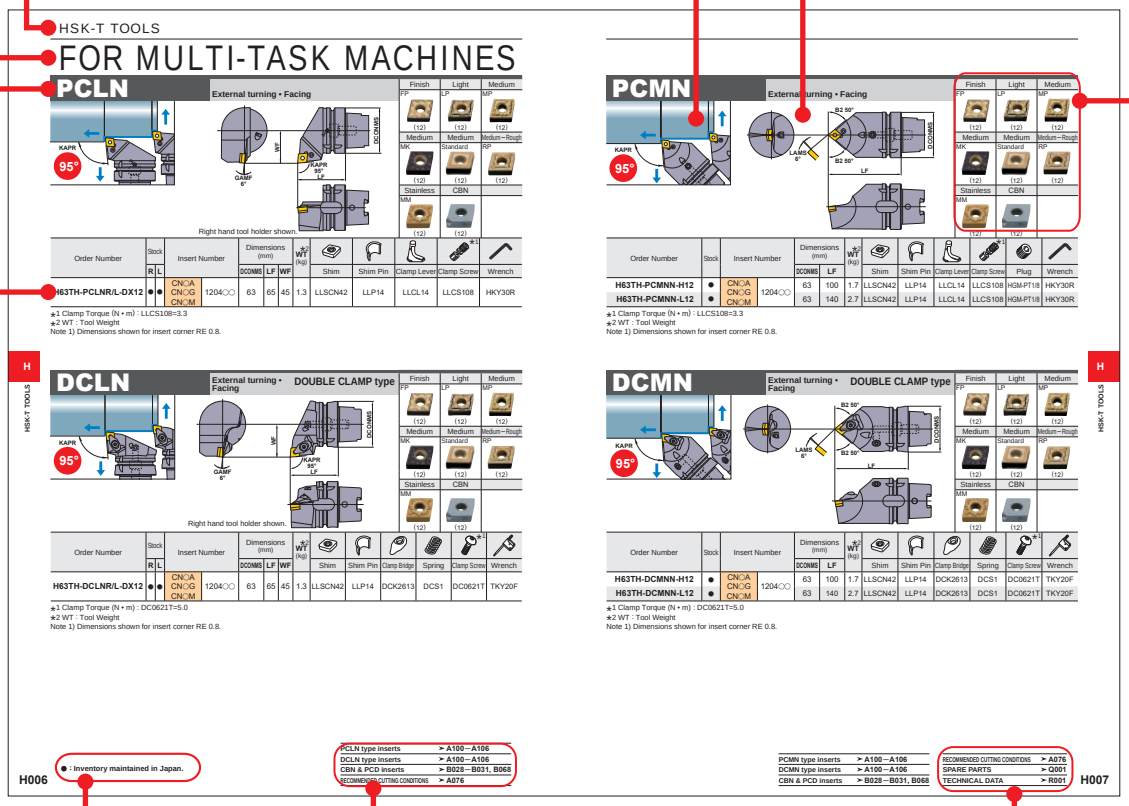
TITLE OF PRODUCT SERIES

PRODUCT SECTION

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict available machining applications along with cutting edge lead angles.

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION



LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

REFERENCE PAGE FOR APPLICABLE INSERTS
indicates reference pages for details of inserts that are applicable to the title product.

PAGE REFERENCE
·SPARE PARTS
·TECHNICAL DATA
indicates reference pages, including the above, on the right hand page of each double-page spread.

PRODUCT STANDARDS
Indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

●To Order : Please specify
①order number and hand of tool (right/left).

HSK-T TOOLS

OVERVIEW OF HSK-T TOOLS ····· H002
CLASSIFICATION OF HSK-T TOOLS ····· H004
HSK-T TOOL STANDARDS

EXTERNAL TURNING • FACING
CN○○ INSERTS TOOL HOLDERS ····· H006
DN○○ INSERTS TOOL HOLDERS ····· H011

EXTERNAL TURNING • FACING • BORING
CN○○ INSERTS TOOL HOLDERS ····· H008

EXTERNAL TURNING • COPYING
DN○○ INSERTS TOOL HOLDERS ····· H009

EXTERNAL TURNING • FACING • COPYING
RC○○ INSERTS TOOL HOLDERS ····· H012

FACING • COPYING
VB○○ INSERTS TOOL HOLDERS ····· H013

GROOVING
MG INSERTS TOOL HOLDERS ····· H014

THREADING
MMT INSERTS TOOL HOLDERS ····· H016
MT INSERTS TOOL HOLDERS ····· H017

EXTERNAL TURNING TOOL HOLDERS ··· H019
BORING BAR HOLDERS ····· H021
BORING BAR SLEEVES ····· H022

*Arranged by Alphabetical order

H022 **H100TH-B○○-○○○**
H020 **H100TH-EN3232R/L-130**
H019 **H100TH-EV3232R/L-180**
H008 **H63TH-A○○○DCLNR/L12**
H021 **H63TH-B○○-○○**
H008 **H63TH-DCLNL-L12-3**
H006 **H63TH-DCLNR/L-DX12**
H007 **H63TH-DCMNN-H/L12**
H011 **H63TH-DDJNL-L15-3**
H009 **H63TH-DDJNR/L-DX15**
H010 **H63TH-DDNNN-H/L15**
H020 **H63TH-EN2525R/L-115**
H021 **H63TH-EV2020R/L-105-3**
H019 **H63TH-EV2525R/L-112**
H014 **H63TH-MGHR/L-DX43○○**
H016 **H63TH-MMTENR-H/L16**
H016 **H63TH-MMTER-DX16**
H017 **H63TH-MTHR/L-DX43**
H006 **H63TH-PCLNR/L-DX12**
H007 **H63TH-PCMNN-H/L12**
H009 **H63TH-PDJNR/L-DX15**
H010 **H63TH-PDNNN-H/L15**
H012 **H63TH-PRDCN-H/L12**
H012 **H63TH-PRGCR/L-DX12**
H013 **H63TH-SVPBR/L-DX16**
H013 **H63TH-SVVBN-H/L16**
H022 **SL32○○-90**

Tooling system
for turning on
multi-task machines

HSK TOOLS

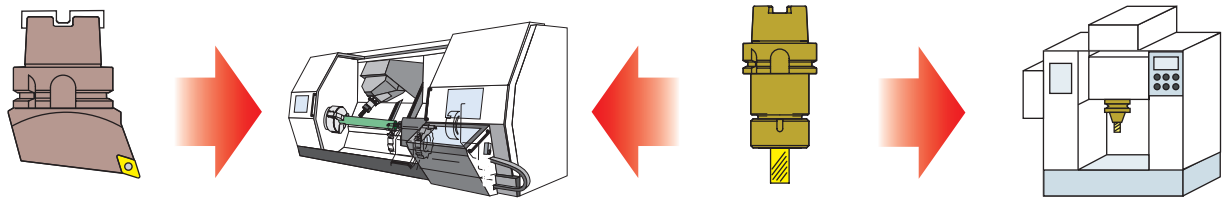
HSK-T System

HSK-T is a new HSK system designed for turning on multi-task machines that are compatible with HSK-A type (ISO standard: ISO12164-1:2001).
The HSK system was developed by a consortium of 17 Japanese manufacturers and registered in ISO standard (ISO12164-3:2008) under the name HSK-T type in 2008 and JIS standard (JIS B6064-3) in 2013.

High accuracy cutting edge positioning

The HSK-T type has a closer tolerance between the spindle key and tool holder keyway than the HSK-A type. This results in higher cutting edge positional accuracies. For milling, the conventional HSK-A type tools can be still used.

Compatible with both multi-task machines and machining centres



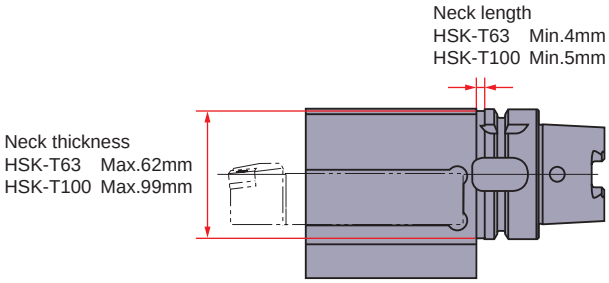
HSK-T
Turning tool holder

HSK-T spindle
Multi-task machines

HSK-A
Rotating tool holder

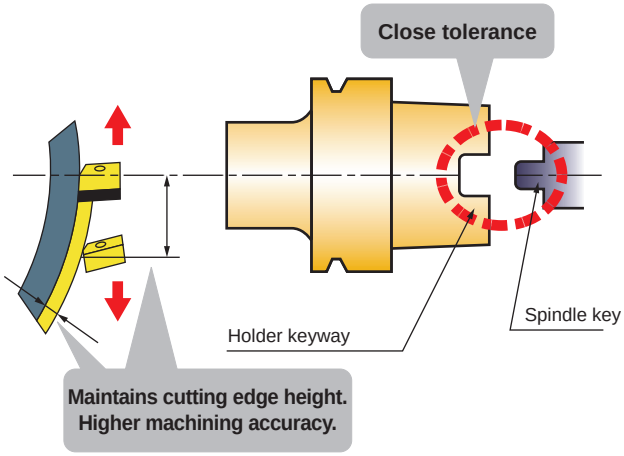
HSK-A spindle
Machining centre

*Note
Short neck length from the flange with thick body of the HSK-T turning tool as shown in the figure at the left.
Because there are machines which cannot be mounted depending on the ATC specifications of the multi-task machine(HSK-A type), please check beforehand.
Also be careful of interference of the magazine with adjacent tools.

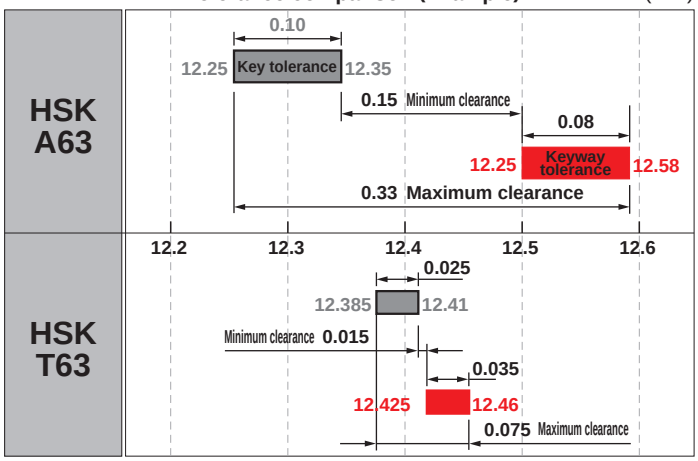


HSK-T turning tool standard (Example)

Improved keyway tolerance



Tolerance comparison (Example) (mm)

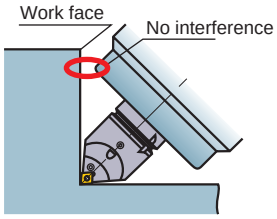


High accuracy and rigidity HSK-T type tooling system developed for use on multi-task machines.

Straight type tools suitable for use on multi-task machines

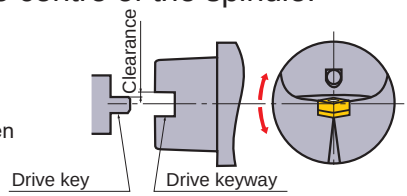
Avoid workpiece interference with improved tool accessibility.

By tilting the machines B spindle (main axis of the tool) at 45 deg, interference between the spindle, holder, workpiece and chuck can be avoided.



Improve centreline height by positioning the cutting edge at the centre of the spindle.

Increased stability and accuracy can be achieved because the cutting edge centreline height is not affected by the gap between the spindle and the key.



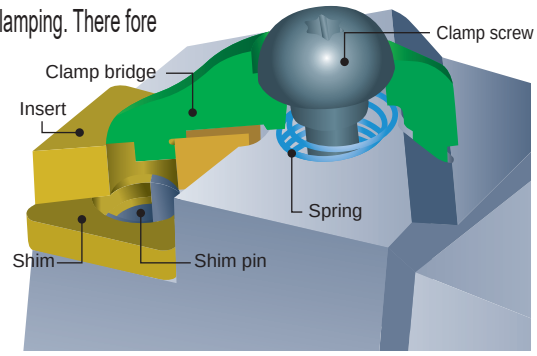
New one-action type double clamp series

The double clamp mechanism offers high rigidity, accuracy and reliability that ensures secure insert clamping. There fore making it suitable turning of difficult to machine materials such as stainless and heat resistant alloys.

Handed type for turning and facing

Straight type for turning and facing

For turning, facing and boring



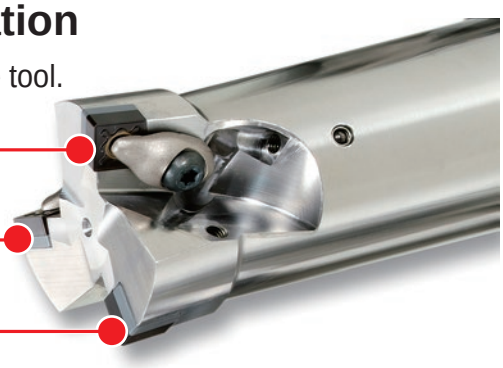
3 on 1 tool for process and tool consolidation

3 turning inserts of the same geometry can be installed on a single tool.

The same type of inserts can be installed for quick change with spare tools.

Different types of inserts can be installed for different applications (roughing, semi finishing and finishing)

Inserts in different grade types can be installed to cover various kinds of workpieces.



New HSK-T100 size for large workpieces

Larger tool holder sizes for high efficiency machining.

Square shank holder type

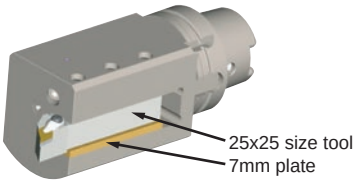
Boring bar / Drill type

Sleeve

A single tool can be used with different sized tool holders.

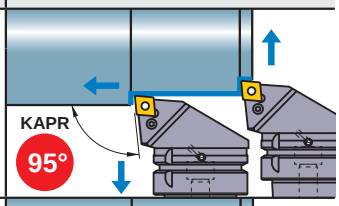
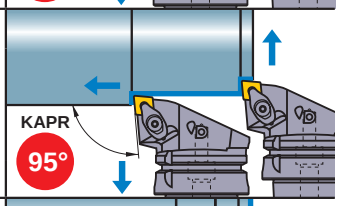
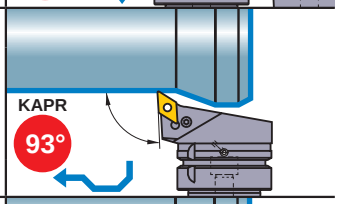
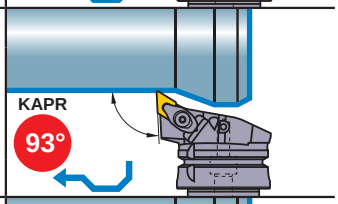
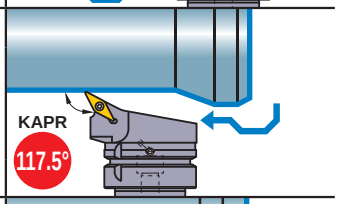
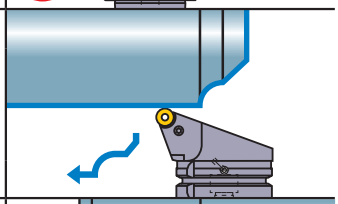
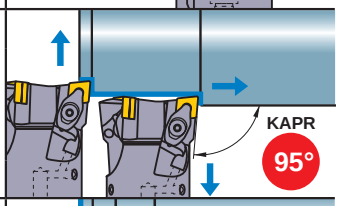
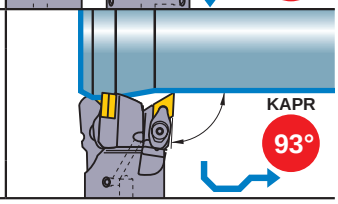
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.

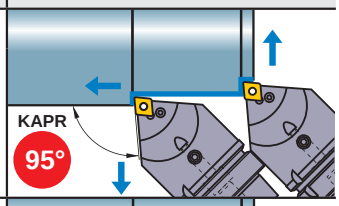
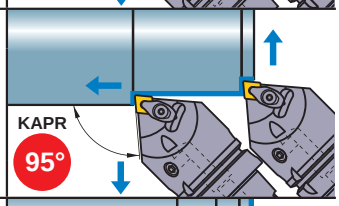
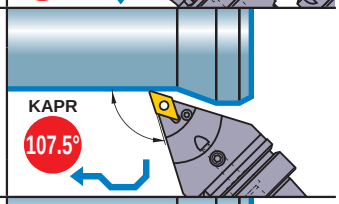
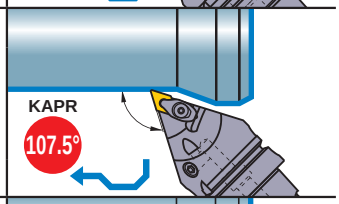
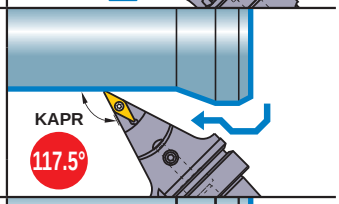
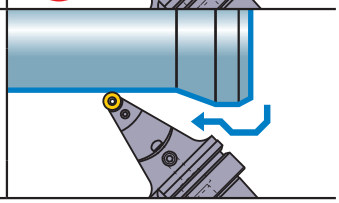
⋆Please prepare a plate on your own.



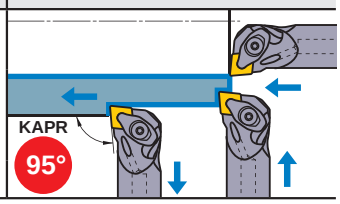
CLASSIFICATION OF HSK-T TOOLS

EXTERNAL TURNING • FACING • COPYING

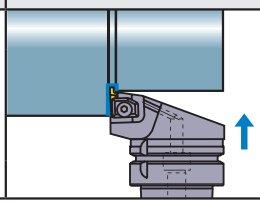
Order Number	Cutting Mode
H63TH-PCLNR/L-DX12 H006	
H63TH-DCLNR/L-DX12 H006	
H63TH-PDJNR/L-DX15 H009	
H63TH-DDJNR/L-DX15 H009	
H63TH-SVPBR/L-DX16 H013	
H63TH-PRGCR/L-DX12 H012	
H63TH-DCLNL-L12-3 H008	
H63TH-DDJNL-L15-3 H011	

Order Number	Cutting Mode
H63TH-PCMNN-H/L12 H007	
H63TH-DCMNN-H/L12 H007	
H63TH-PDNNN-H/L15 H010	
H63TH-DDNNN-H/L15 H010	
H63TH-SVVBN-H/L16 H013	
H63TH-PRDCN-H/L12 H012	

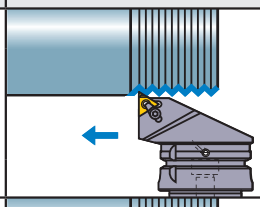
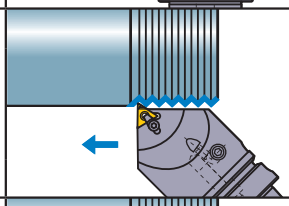
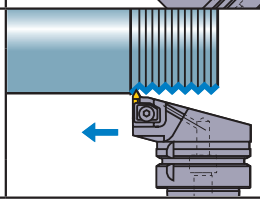
EXTERNAL TURNING • FACING• BORING

Order Number	Cutting Mode
H63TH-A25KDCLNR/L12 **H63TH-A32LDCLNR/L12** H008	

GROOVING

Order Number	Cutting Mode
H63TH-MGHR/L-DX43○○ ➲ H014	

THREADING

Order Number	Cutting Mode
H63TH-MMTER-DX16 ➲ H016	
H63TH-MMTENR-H/L16 ➲ H016	
H63TH-MTHR/L-DX43 ➲ H017	

EXTERNAL TURNING TOOL HOLDERS

Order Number	Holder
H63TH-EV2525R/L-112 ➲ H019	
H100TH-EV3232R/L-180 ➲ H019	
H63TH-EN2525R/L-115 ⋆1 ➲ H020	
H100TH-EN3232R/L-130 ⋆1 ➲ H020	
H63TH-EV2020R/L-105-3 ➲ H021	

BORING BAR HOLDERS

Order Number	Holder
H63TH-B○○-○○ ➲ H021	
H100TH-B○○-○○○ ➲ H022	
SL32○○-90 (Sleeve) ⋆2 ➲ H022	

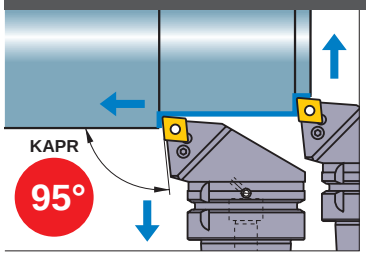
Note 1) The HSK63A shank type has a built-in coolant pipe for installation.

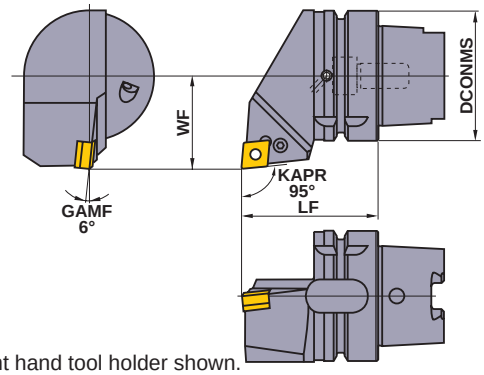
⋆1 Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.
⋆2 The SL32○○-90 sleeve is only for use with H100TH-B32-135.

FOR MULTI-TASK MACHINES

PCLN

External turning • Facing





Right hand tool holder shown.

Finish	Light	Medium
FP	LP	MP
(12)	(12)	(12)
Medium	**Medium**	**Medium–Rough**
MK	Standard	RP
(12)	(12)	(12)
Stainless	**CBN**	
MM		
(12)	(12)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	*2 WT (kg)	Shim	Shim Pin	Clamp Lever	*1 Clamp Screw	Wrench
H63TH-PCLNR/L-DX12	●	●	CN○A CN○G CN○M	1204○○	63	65	45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

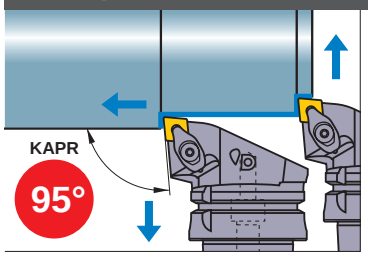
*1 Clamp Torque (N • m) : LLCS108=3.3
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

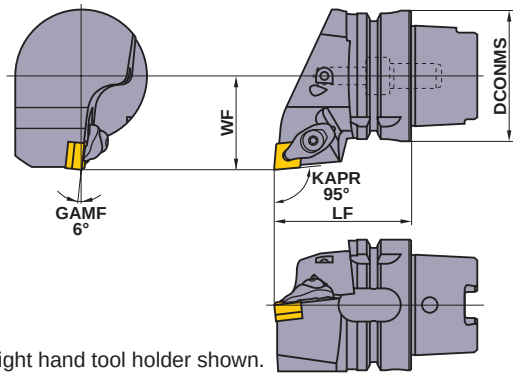
H

HSK-T TOOLS

DCLN

External turning • Facing **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium
FP	LP	MP
(12)	(12)	(12)
Medium	**Medium**	**Medium–Rough**
MK	Standard	RP
(12)	(12)	(12)
Stainless	**CBN**	
MM		
(12)	(12)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	*1 Clamp Screw	Wrench
H63TH-DCLNR/L-DX12	●	●	CN○A CN○G CN○M	1204○○	63	65	45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

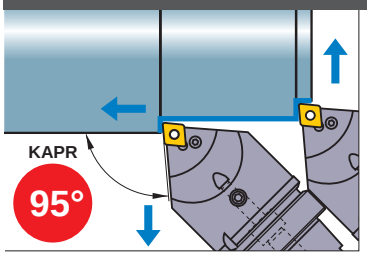
*1 Clamp Torque (N • m) : DC0621T=5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

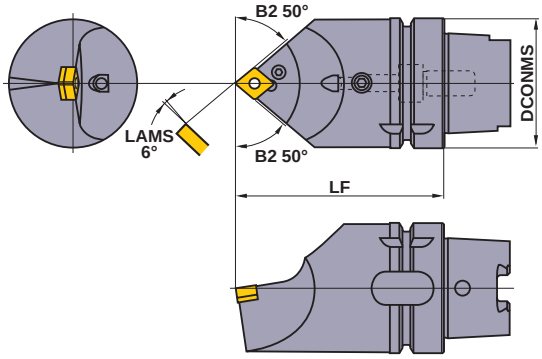
PCLN type inserts	**➤ A100–A106**
DCLN type inserts	**➤ A100–A106**
CBN & PCD inserts	**➤ B028–B031, B068**
RECOMMENDED CUTTING CONDITIONS	**➤ A076**

● : Inventory maintained in Japan.

PCMN

External turning • Facing





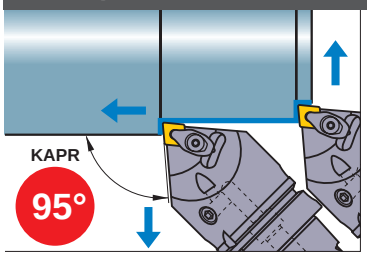
Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium	**Medium**	**Medium – Rough**
MK (12)	Standard (12)	RP (12)
Stainless	**CBN**	
MM (12)	(12)	

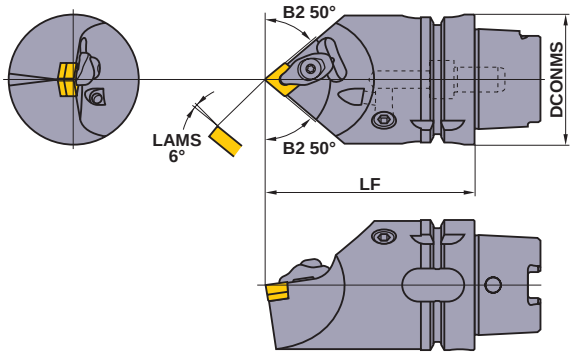
Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	*2 WT (kg)	Shim	Shim Pin	Clamp Lever	*1 Clamp Screw	Plug	Wrench
H63TH-PCMNN-H12	●	CN○A CN○G CN○M	1204○○	63	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R
H63TH-PCMNN-L12	●			63	140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R

*1 Clamp Torque (N • m) : LLCS108=3.3
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

DCMN

External turning • Facing **DOUBLE CLAMP type**





Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium	**Medium**	**Medium – Rough**
MK (12)	Standard (12)	RP (12)
Stainless	**CBN**	
MM (12)	(12)	

Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	*1 Clamp Screw	Wrench
H63TH-DCMNN-H12	●	CN○A CN○G CN○M	1204○○	63	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DCMNN-L12	●			63	140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

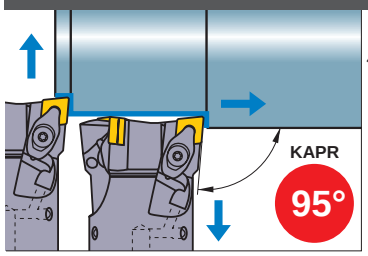
PCMN type inserts	➤ A100–A106
DCMN type inserts	➤ A100–A106
CBN & PCD inserts	➤ B028–B031, B068

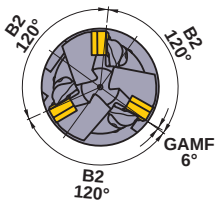
RECOMMENDED CUTTING CONDITIONS	➤ A076
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

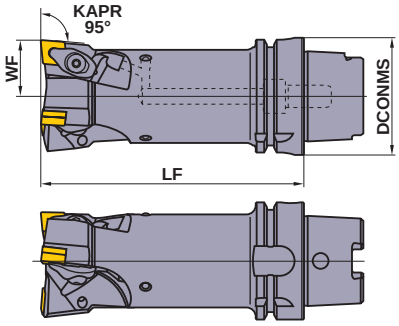
FOR MULTI-TASK MACHINES

DCLN

External turning • Facing **DOUBLE CLAMP type**







Left hand tool holder only.

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium	**Medium**	**Medium–Rough**
MK (12)	Standard (12)	RP (12)
Stainless	**CBN**	
MM (12)	(12)	

Order Number	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	*1 Clamp Screw	Wrench
H63TH-DCLNL-L12-3	●	CN○A CN○G CN○M	1204○○	63	140	30	2.2	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

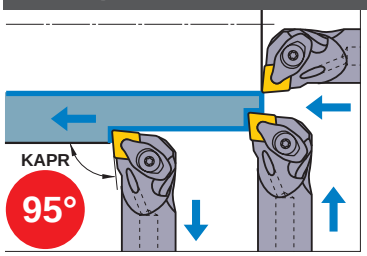
*1 Clamp Torque (N • m) : DC0621T=5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

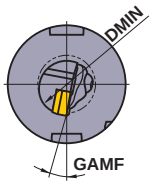
H

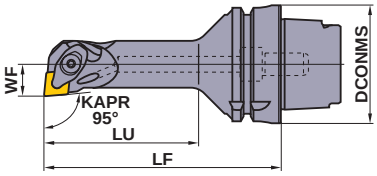
HSK-T TOOLS

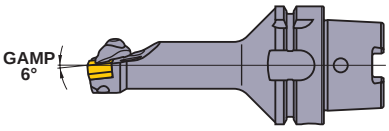
DCLN

External turning • Facing • Boring **DOUBLE CLAMP type**









Right hand tool holder shown.

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium	**Medium**	**Medium–Rough**
MK (12)	Standard (12)	RP (12)
Stainless	**CBN**	
MM (12)	(12)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	LU	WF	GAMF	DMIN (mm)	*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	*1 Clamp Screw	Wrench
H63TH-A25KDCLNR/L12	●	●	CN○A CN○G CN○M	1204○○	63	125	82	17	11°	32	1.1	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-A32LDCLNR/L12	●	●			63	140	100	22	13°	40	1.4	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

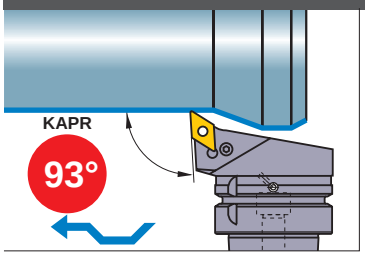
*1 Clamp Torque (N • m) : DC0621T=5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

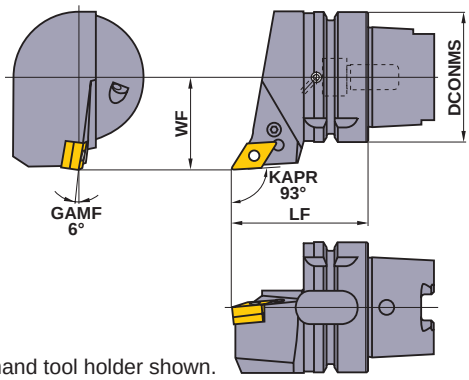
● : Inventory maintained in Japan.

DCLN type inserts	➤ A100–A106
CBN & PCD inserts	➤ B028–B031, B068
RECOMMENDED CUTTING CONDITIONS	➤ A076

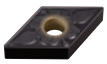
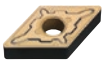
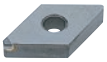
PDJN

External turning • Copying





Right hand tool holder shown.

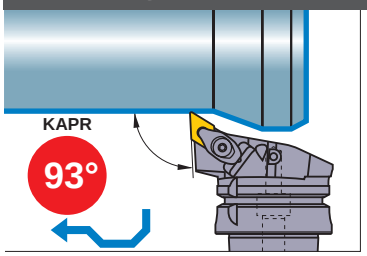
Finish	Light	Medium
FP	LP	MP
(15)	(15)	(15)
Medium	**Medium – Rough**	**Stainless**
MK	RP	MM
		
(15)	(15)	(15)
G Class	**CBN**	
R/L		
		
(15)	(15)	

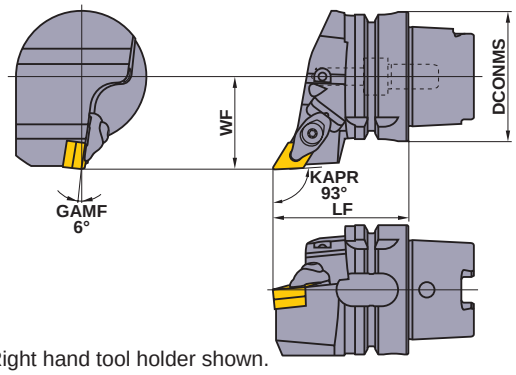
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	★3 WT (kg)	★2 Shim	Shim Pin	Clamp Lever	★1 Clamp Screw	Wrench
H63TH-PDJNR/L-DX15	●	●	DN○A DN○G DN○M DNMX	1504○○	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

★1 Clamp Torque (N • m) : LLCS108=3.3
★2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.
★3 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

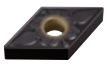
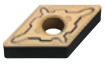
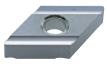
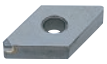
DDJN

External turning • Copying **DOUBLE CLAMP type**





Right hand tool holder shown.

Finish	Light	Medium
FP	LP	MP
(15)	(15)	(15)
Medium	**Medium – Rough**	**Stainless**
MK	RP	MM
		
(15)	(15)	(15)
G Class	**CBN**	
R/L		
		
(15)	(15)	

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	★3 WT (kg)	★2 Shim	Shim Pin	Clamp Bridge	Spring	★1 Clamp Screw	Wrench
H63TH-DDJNR/L-DX15	●	●	DN○A DN○G DN○M DNMX	1504○○	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

★1 Clamp Torque (N • m) : DC0621T=5.0
★2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.
★3 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

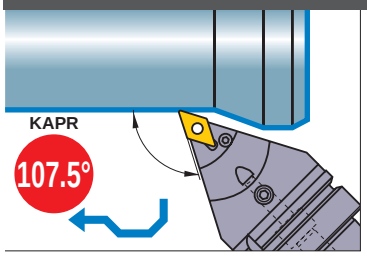
PDJN type inserts	➤ A107—A113
DDJN type inserts	➤ A107—A113
CBN & PCD inserts	➤ B032—B036, B068

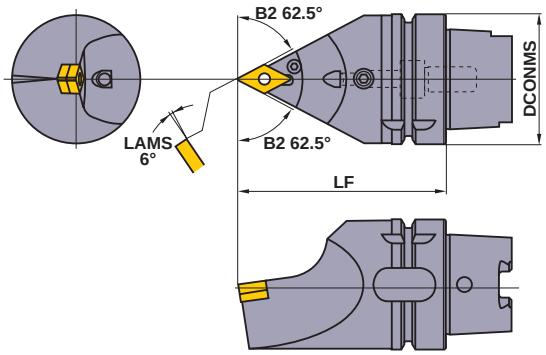
RECOMMENDED CUTTING CONDITIONS	➤ A076
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

FOR MULTI-TASK MACHINES

PDNN

External turning • Copying





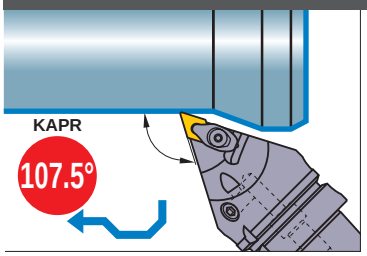
Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium	**Medium–Rough**	**Stainless**
MK (15)	RP (15)	MM (15)
G Class	**CBN**	
R/L (15)	(15)	

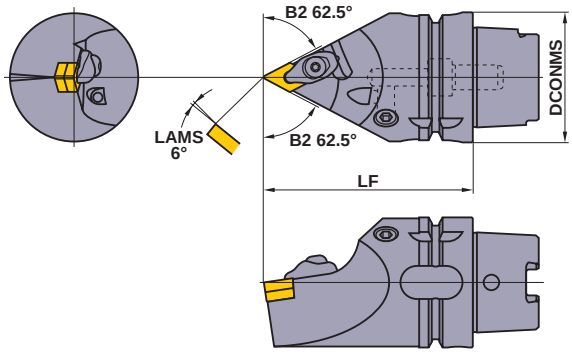
Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	★3 WT (kg)	★2 Shim	Shim Pin	Clamp Lever	★1 Clamp Screw	Plug	Wrench
H63TH-PDNNN-H15	●	DN○A DN○G DN○M	1504○○	63	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R
H63TH-PDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R

★1 Clamp Torque (N • m) : LLCS108=3.3
★2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.
★3 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

DDNN

External turning • Copying **DOUBLE CLAMP type**





Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium	**Medium–Rough**	**Stainless**
MK (15)	RP (15)	MM (15)
G Class	**CBN**	
R/L (15)	(15)	

Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	★3 WT (kg)	★2 Shim	Shim Pin	Clamp Bridge	Spring	★1 Clamp Screw	Wrench
H63TH-DDNNN-H15	●	DN○A DN○G DN○M	1504○○	63	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

★1 Clamp Torque (N • m) : DC0621T=5.0
★2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.
★3 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

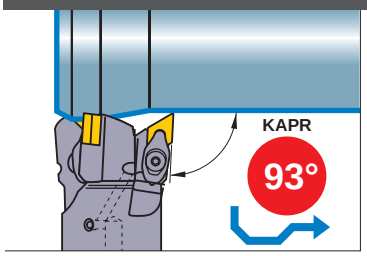
● : Inventory maintained in Japan.

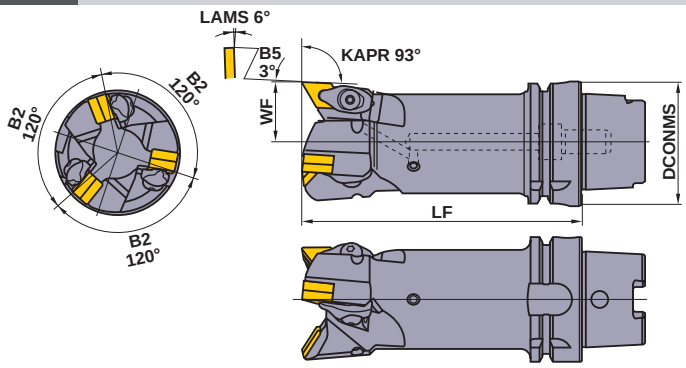
PDNN type inserts	➢ **A107–A113**
DDNN type inserts	➢ **A107–A113**
CBN & PCD inserts	➢ **B032–B036, B068**
RECOMMENDED CUTTING CONDITIONS	➢ **A076**

DDJN

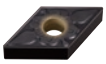
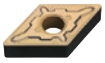
External turning • Facing

DOUBLE CLAMP type





Left hand tool holder only.

Finish	Light
FP (15)	LP (15)
Medium	**Medium**
MP (15)	MK  (15)
Medium – Rough	**Stainless**
RP  (15)	MM (15)

Order Number	Stock	Insert Number		Dimensions (mm)			*3 WT (kg)	*2 Shim	Shim Pin	Clamp Bridge	Spring	*1 Clamp Screw	Wrench
	L			DCONMS	LF	WF							
H63TH-DDJNL-L15-3	●	DN○A DN○G DN○M DNMX	1504○○	63	140	30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0
*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.
*3 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

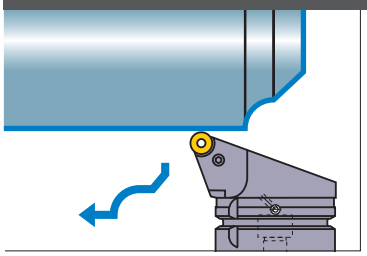
DDNN type inserts ➤ A107—A113
CBN & PCD inserts ➤ B032—B036, B068
RECOMMENDED CUTTING CONDITIONS ➤ A076
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

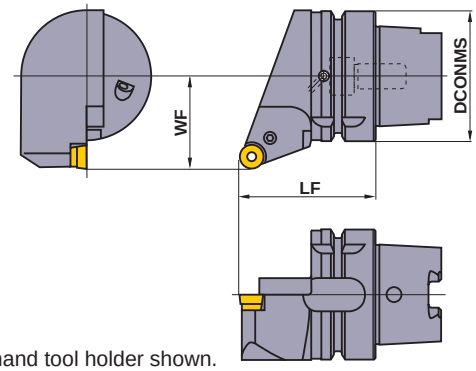
FOR MULTI-TASK MACHINES

PRGC

External turning • Facing • Copying

Medium





(12)

Right hand tool holder shown.

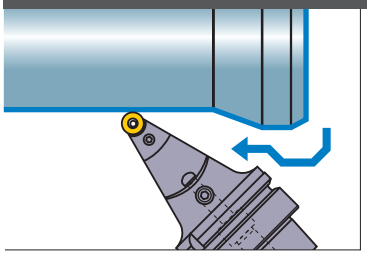
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	*2 WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw *1	Wrench
H63TH-PRGCR/L-DX12	●	●	RCMX	1204M0	63	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R

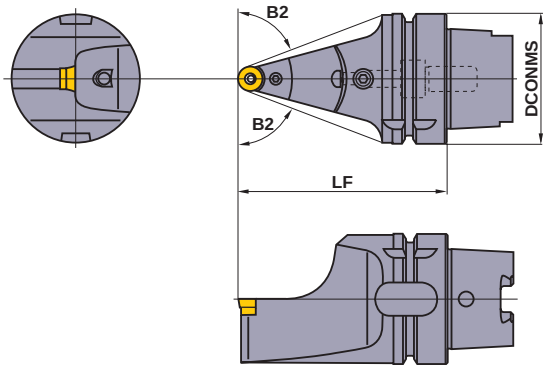
*1 Clamp Torque (N • m) : LLCS106=2.2
*2 WT : Tool Weight

PRDC

External turning • Facing • Copying

Medium





(12)

Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	B2	*2 WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw *1	Plug	Wrench
H63TH-PRDCN-H12	●	RCMX	1204M0	63	100	69°	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R
H63TH-PRDCN-L12	●			63	140	75°	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R

*1 Clamp Torque (N • m) : LLCS106=2.2
*2 WT : Tool Weight

RECOMMENDED CUTTING CONDITIONS

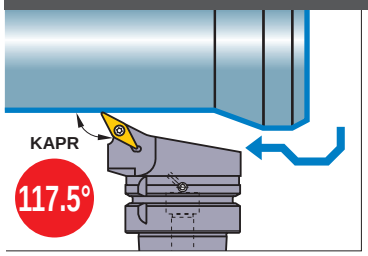
	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Medium Cutting	**Standard**	**UE6110**	205—350
	Carbon Steel • Alloy Steel	180HB—350HB	Medium Cutting	**Standard**	**UE6110**	150—260
M	Stainless Steel	≤200HB	Medium Cutting	**Standard**	**US735**	70—130

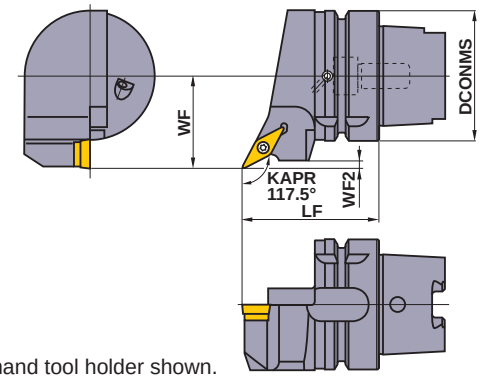
● : Inventory maintained in Japan.

PRGC type inserts ➤ A156
PRDC type inserts ➤ A156

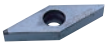
SVPB

Facing • Copying





Right hand tool holder shown.

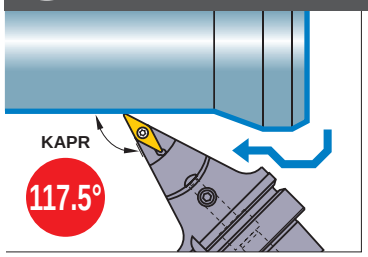
Finish	Light
R/L-F	SV
(16)	(16)
Medium	Medium
MV	MP
(16)	(16)
CBN	
 (16)	

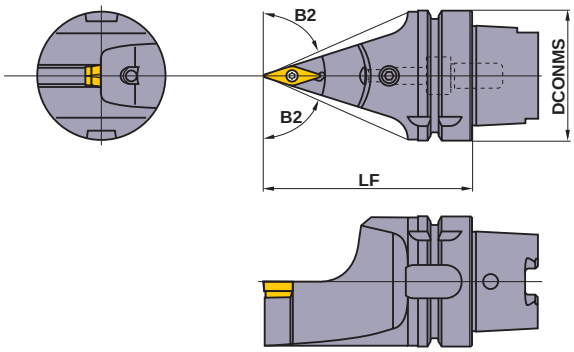
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) DCONMS	LF	WF	WF2	*2 WT (kg)	Shim	Shim Pin	*1 Clamp Screw	Wrench
H63TH-SVPBR/L-DX16	●	●	VB○T VB○W	1604○○	63	65	45	3.8	1.1	SPSVN32	BCP141	TS35D	TKY15F

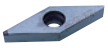
*1 Clamp Torque (N • m) : TS35D=3.5
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

SVVB

Facing • Copying





Finish	Light
R/L-F	SV
(16)	(16)
Medium	Medium
MV	MP
(16)	(16)
CBN	
 (16)	

Order Number	Stock	Insert Number		Dimensions (mm) DCONMS	LF	B2	*2 WT (kg)	Shim	Shim Pin	*1 Clamp Screw	Plug	Wrench
H63TH-SVVBN-H16	●	VB○T VB○W	1604○○	63	100	66.5°	1.3	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F
H63TH-SVVBN-L16	●			63	140	72.5°	2.2	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F

*1 Clamp Torque (N • m) : TS35D=3.5
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	**F**	**AP25N**	250 (150—300)
			Medium Cutting	**MV**	**UE6020**	200 (150—250)
	Carbon Steel Alloy Steel	180HB—350HB	Finish Cutting	**F**	**AP25N**	210 (150—260)
			Medium Cutting	**MV**	**UE6020**	170 (120—210)
M	Stainless Steel	≤200HB	Medium Cutting	**MV**	**US735**	100 (70—120)
K	Gray Cast Iron	Tensile Strength≤350MPa	Medium Cutting	**MV**	**UE6020**	170 (140—200)

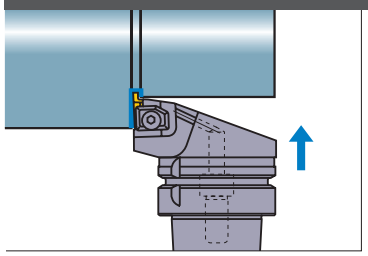
SVPB type inserts	➤ **A167—A169**
SVVB type inserts	➤ **A167—A169**
CBN inserts	➤ **B061**

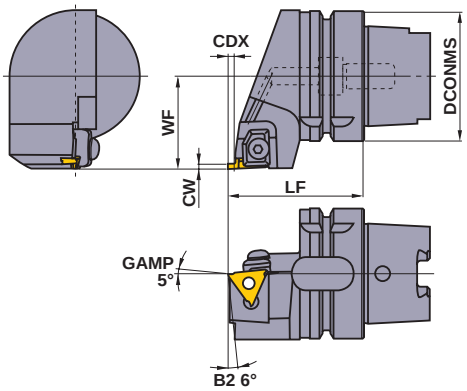
SPARE PARTS	➤ **Q001**
TECHNICAL DATA	➤ **R001**

FOR MULTI-TASK MACHINES

MG

Grooving





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) CW	CDX	LF	WF	*2 WT (kg)	Clamp Bridge	Clamp Screw *1	Spring	Wrench
H63TH-MGHR/L-DX4315	●	●	MGTR/L	43125 I 43470	1.25	1.2	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R
					1.45	1.5	65	45	1.2				
					1.5≤CW≤2.3	3	65	45	1.2				
H63TH-MGHR/L-DX4323	●	●			2.3<CW≤3.3	4.5	65	45	1.2				
H63TH-MGHR/L-DX4333	●	●			3.3<CW≤4.7	4.5	65	45	1.2				

*1 Clamp Torque (N • m) : HBH06020=7.0
*2 WT : Tool Weight

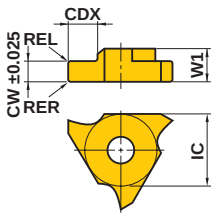
RECOMMENDED CUTTING CONDITIONS

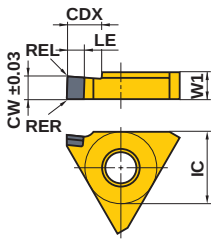
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180—350HB	**VP20MF**	120 (100—140)	0.10 (0.03—0.18)
			NX2525	130 (100—160)	0.12 (0.03—0.2)
M	Stainless Steel	≤200HB	**VP20MF**	120 (100—140)	0.10 (0.03—0.18)
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP20MF**	120 (100—140)	0.10 (0.03—0.18)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

INSERTS FOR MG TYPE

Order Number	Stock							Dimensions (mm)						Geometry
	Coated		Cermet		Carbide		CBN							
	VP20MF		NX2525		UTi20T		MB8025	CW	CDX	IC	W1	RER/L	LE	
	R	L	R	L	R	L	R							
MGTR/L43125	●	●	●	□	●	●	●	1.25	1.2	12.7	4.76	0.2	2.7	**MGTR/L...**
MGTR/L43145	●	□		□	●	□		1.45	1.5	12.7	4.76	0.2	–	
MGTR/L43150	●	●	●	●	●	●	●	1.5	3	12.7	4.76	0.2	2.7	
MGTR/L43175	●	●	●	□	●	●		1.75	3	12.7	4.76	0.2	–	
MGTR/L43200	●	●	●	●	●	●	●	2	3	12.7	4.76	0.2	2.7	
MGTR/L43230	●	●	●	●		●		2.3	3	12.7	4.76	0.2	–	
MGTR/L43250	●	●	●	●	●	●	●	2.5	4.5	12.7	4.76	0.3	2.7	
MGTR/L43260	●	□	□		●	●		2.6	4.5	12.7	4.76	0.3	–	
MGTR/L43270	●	□			●	□		2.7	4.5	12.7	4.76	0.3	–	
MGTR/L43280		●		□	●	●		2.8	4.5	12.7	4.76	0.3	–	
MGTR/L43300	●	●	●	●	●	●	●	3	4.5	12.7	4.76	0.3	2.7	CBN Insert
MGTR/L43320	●				●	●		3.2	4.5	12.7	4.76	0.3	–	
MGTR/L43330		●		□	●	●		3.3	4.5	12.7	4.76	0.3	–	
MGTR/L43350	●	□	●	□	●	●	●	3.5	4.5	12.7	4.76	0.3	2.7	
MGTR/L43400	●	●	●		●	●	●	4	4.5	12.7	4.76	0.3	2.7	
MGTR/L43420	●	□	□		●	□		4.2	4.5	12.7	4.76	0.4	–	
MGTR/L43430	●	□	□		●	●		4.3	4.5	12.7	4.76	0.4	–	
MGTR/L43450	●	●	●	●	●	●		4.5	4.5	12.7	4.76	0.4	–	
MGTR/L43470	●	□	□	□	●	□		4.7	4.5	12.7	4.76	0.4	–	Right hand insert shown.

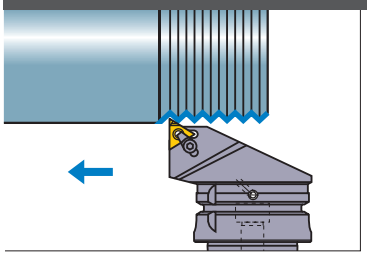


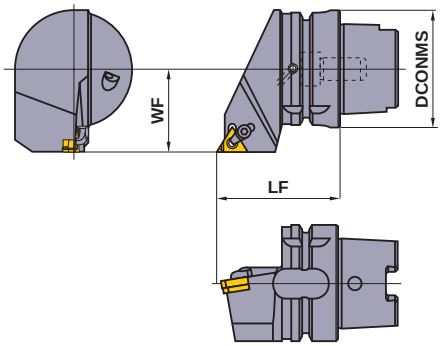


FOR MULTI-TASK MACHINES

MMTE

Threading





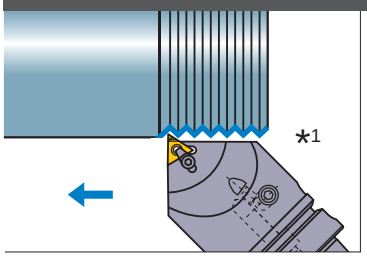
Right hand tool holder only.

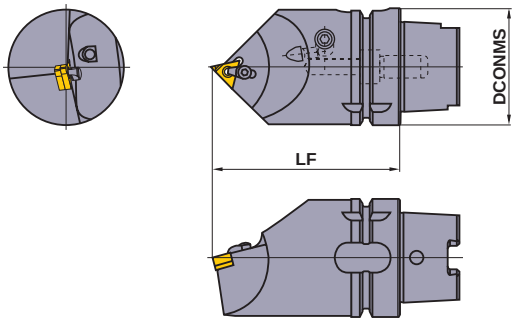
Order Number	Stock	Insert Number		Dimensions (mm)			*2 WT (kg)	Clamp Bridge	Clamp Screw *1	Stop Ring	Shim	Shim Screw *1	F R Wrench
	R			DCONMS	LF	WF							
H63TH-MMTER-DX16	●	MMT16ER	○○○○○	63	65	45	1.2	SETK51	SETS51	CR4	CTE32TP15	HFC03008	TKY15F HKY20R

*1 Clamp Torque (N • m) : SETS51=3.5, HFC03008=1.5
*2 WT : Tool Weight

MMTEN

Threading





Tool holder for right hand insert only.

Order Number	Stock	Insert Number		Dimensions (mm)		*3 WT (kg)	Clamp Bridge	Clamp Screw *2	Stop Ring	Shim	Shim Screw *2	Plug	F R Wrench
				DCONMS	LF								
H63TH-MMTENR-H16	●	MMT16ER	○○○○○	63	100	1.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R
H63TH-MMTENR-L16	●			63	140	2.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R

*1 For use with B axis tilted at 45 degrees.
*2 Clamp Torque (N • m) : SETS51=3.5, HFC03008=1.5
*3 WT : Tool Weight

RECOMMENDED CUTTING CONDITIONS

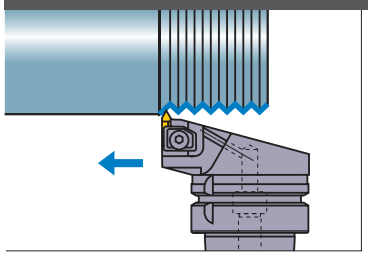
	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**VP10MF**	150 (70—230)
			VP15TF	100 (60—140)
	Carbon Steel Alloy Steel	180—350HB	**VP10MF**	140 (80—200)
			VP15TF	100 (60—140)
M	Stainless Steel	≤200HB	**VP10MF**	130 (80—180)
			VP15TF	80 (40—120)
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP10MF**	140 (80—200)
			VP15TF	90 (60—120)

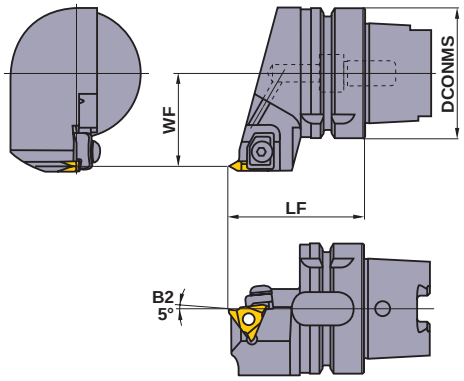
● : Inventory maintained in Japan.

APPLICABLE INSERT ➤ G020 — G023

MT

Threading





Right hand tool holder shown.

Order Number	Stock		Insert Number		Dimensions (mm)			*2 WT (kg)		*1		
	R	L			DCONMS	LF	WF		Clamp Bridge	Clamp Screw	Spring	Wrench
H63TH-MTHR/L-DX43	●	●	MTTR/L	43○○○○	63	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R

*1 Clamp Torque (N • m) : HBH06020=7.0
*2 WT : Tool Weight

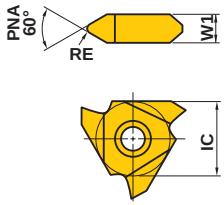
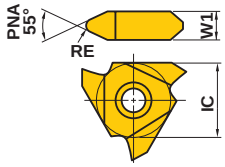
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UP20M**	140 (100—180)
			NX2525	200 (150—250)
			UTi20T	120 (100—150)
	Carbon Steel Alloy Steel	180HB—350HB	**UP20M**	120 (100—150)
			NX2525	170 (150—200)
			UTi20T	100 (70—120)
M	Stainless Steel	≤200HB	**UP20M**	120 (80—150)
			UTi20T	100 (70—130)
K	Gray Cast Iron	Tensile Strength≤350MPa	**UP20M**	80 (60—100)
			UTi20T	80 (60—100)
			HTi10	100 (70—130)

APPLICABLE INSERT	➢ H018
SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

FOR MULTI-TASK MACHINES

INSERTS FOR MT TYPE

Type	Order Number	Class	Coated UP20M	Cermet NX2525	Cermet	Carbide UTi20T	Carbide HTi10	ISO Pitch mm (thread/inch)	Dimensions (mm) IC	W1	RE	Geometry
General • 60°	**MTTR436000**	G		●		●		—0.8	12.7	4.76	0	**MTTR/L(60°)** (G Class)
	MTTR436001	G	●	●		●	●	1.0—1.75	12.7	4.76	0.1	
	MTTL436001	G	●			●	●	1.0—1.75	12.7	4.76	0.1	
	MTTR436002	G	●	●		●	●	2.0—2.5	12.7	4.76	0.2	
	MTTL436002	G		●		●		2.0—2.5	12.7	4.76	0.2	
	MTTR436003	G	□	●		●	●	3.0—3.5	12.7	4.76	0.3	
	MTTL436003	G		●		●		3.0—3.5	12.7	4.76	0.3	
	MTTR436004	G		●		●		4.0—4.5	12.7	4.76	0.4	Right hand insert shown.
General • 55°	**MTTR435501**	G		●		●		(28—10)	12.7	4.76	0.1	**MTTR/L(55°)** (G Class)
	MTTR435502	G		●		●		(16—8)	12.7	4.76	0.2	
	MTTR435503	G		●		●		(11—8)	12.7	4.76	0.3	
												Right hand insert shown.

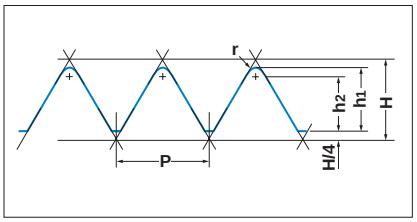
H

HSK-T TOOLS

■ STANDARD DEPTH OF CUT

●The chart on the right shows the cutting depths when machining external ISO metric screw threads.

●When you use cermet grades or cut stainless steel, please increase the number of passes by 2—3 times.



●METRIC THREAD

Unit : mm

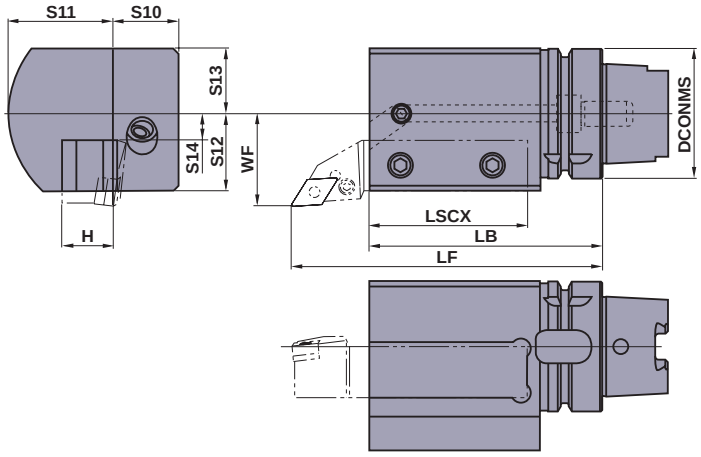
P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50
h_1		0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76
h_2		0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11
r (Corner Radius)		0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

Note 1) The first pass causes a high load on the cutting edge.
In order to avoid damage, keep the depth of cut to 0.4—0.5mm maximum.

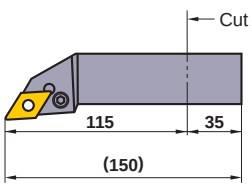
● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(10 inserts in one case)

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■This holder is for 25×25 size tools.
Please shorten the tool as shown below before use.



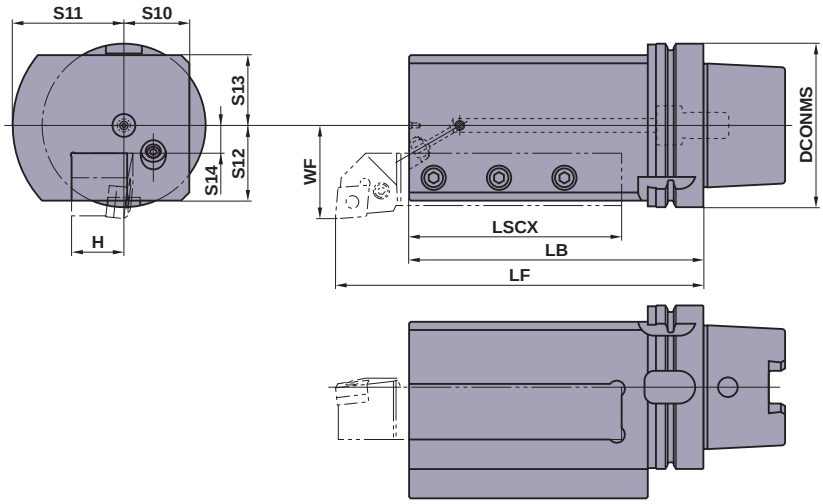
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)											WT* (kg)		
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12	S13		Clamp Screw	Plug
H63TH-EV2525R/L-112	●	●	63	150	112	77	25	32	53	45	13	38	32	3.9	HSS12025	HGM-PT1/8

* WT : Tool Weight

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■This holder is for 32×32 and 32×25 size tools.

Right hand tool holder shown.

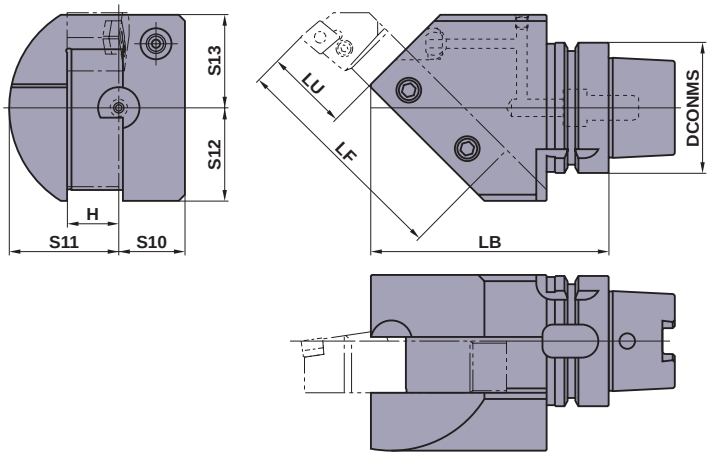
Order Number	Stock		Dimensions (mm)											WT* (kg)		
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12	S13		Clamp Screw	Plug
H100TH-EV3232R/L-180	●	●	100	220	180	130	32	40	68	57	17	46	43	11.7	HSS14035	HSS06006

* WT : Tool Weight
Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

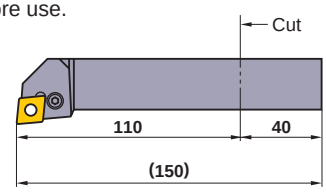
FOR MULTI-TASK MACHINES

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■This holder is for 25×25 size tools.
Please shorten the tool as shown below before use.



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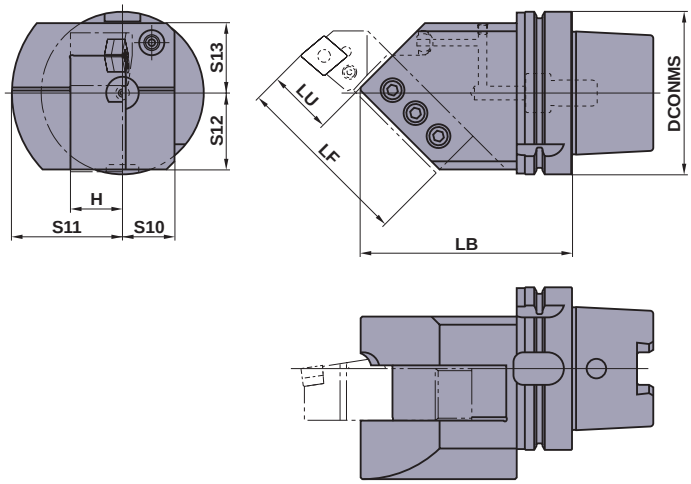
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									WT* (kg)		
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13		Clamp Screw	Plug
H63TH-EN2525R/L-115	●	●	63	115	40	110	25	32	53	45	45	3.7	HSS12030	HSS06006

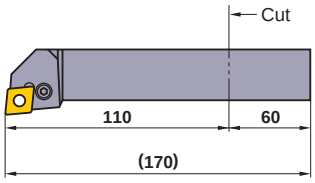
* WT : Tool Weight

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■This holder is for 32×32 and 32×25 size tools.
Please shorten the tool as shown below before use.



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Right hand tool holder shown.

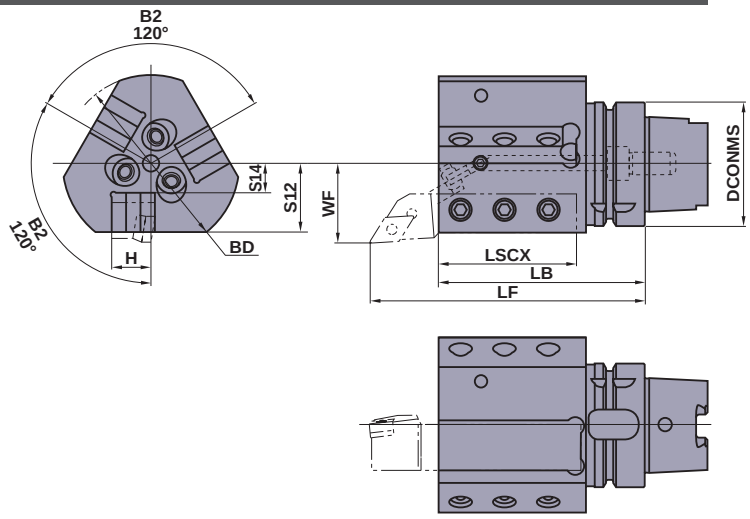
Order Number	Stock		Dimensions (mm)									WT* (kg)		
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13		Clamp Screw	Plug
H100TH-EN3232R/L-130	●	●	100	130	40	110	32	32	68	47	43	6.6	HSS14030	HSS06006

* WT : Tool Weight
Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

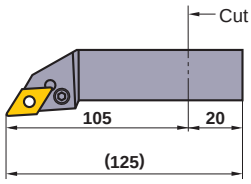
● : **Inventory maintained in Japan.**

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■This holder is for 20×20 size tools.
Please shorten the tool as shown below before use.



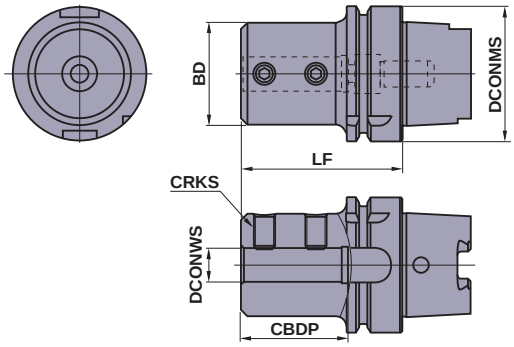
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									WT* (kg)	Clamp Screw	Nozzle Plug	Plug
	R	L	DCONMS	LF	LB	LSCX	H	BD	WF	S14	S12				
H63TH-EV2020R/L-105-3	●	●	63	140	105	70	20	90	40	15	35	2.9	HSS12030	HSS05012	HSS06006

* WT : Tool Weight

BORING BAR HOLDERS

Boring



Order Number	Stock	Dimensions (mm)						WT* (kg)	Clamp Screw
		DCONMS	BD	DCONWS	LF	CBDP	CRKS		
H63TH-B08-65	●	63	28	8	65	40	M8	0.9	HSS08010
H63TH-B10-70	●	63	35	10	70	45	M8	1.0	HSS08012
H63TH-B12-70	●	63	42	12	70	45	M8	1.1	HSS08012
H63TH-B16-75	●	63	48	16	75	50	M10	1.3	HSS10016
H63TH-B20-75	●	63	52	20	75	50	M10	1.4	HSS10016
H63TH-B25-83	●	63	62	25	83	58	M12	1.7	HSS12016
H63TH-B32-87	●	63	62	32	87	62	M12	1.7	HSS12016
H63TH-B40-97	●	63	65	40	97	72	M16	1.8	HSS16012

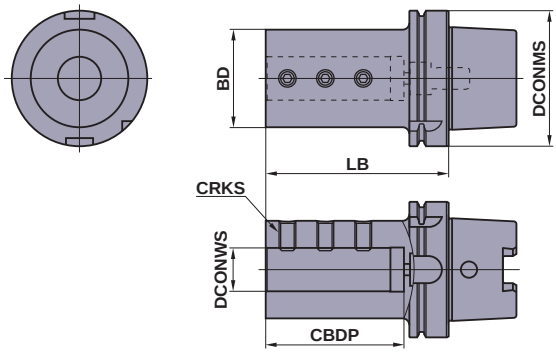
* WT : Tool Weight
Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

FOR MULTI-TASK MACHINES

BORING BAR HOLDERS

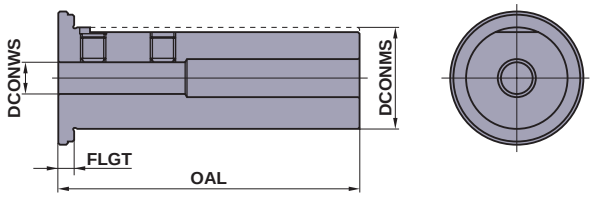
Boring



Order Number	Stock	Dimensions (mm)						WT* (kg)	Clamp Screw
		DCONMS	BD	DCONWS	LB	CBDP	CRKS		
H100TH-B25-120	●	100	62	25	120	88	M12	3.9	HSS12016
H100TH-B32-135	●	100	72	32	135	102	M12	4.8	HSS12018
H100TH-B40-150	●	100	82	40	150	117	M16	5.9	HSS16020
H100TH-B50-180	●	100	92	50	180	147	M16	7.7	HSS16020

* WT : Tool Weight
Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

BORING BAR SLEEVES FOR H100TH-B32-135



Order Number	Stock	Dimensions (mm)				WT* (kg)	Clamp Screw
		DCONWS	DCONMS	OAL	FLGT		
SL3208-90	●	8	32	95	5	0.6	HSS06008
SL3210-90	●	10	32	95	5	0.5	HSS08008
SL3212-90	●	12	32	95	5	0.5	HSS08008
SL3216-90	●	16	32	95	5	0.5	HSS08006
SL3220-90	●	20	32	95	5	0.4	HSS08005

* WT : Tool Weight
Note 1) These sleeves are only compatible with H100TH-B32-135 holder.

● : Inventory maintained in Japan.

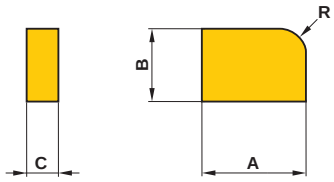
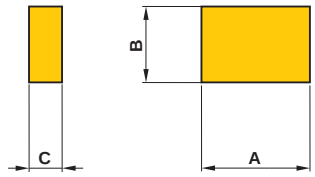
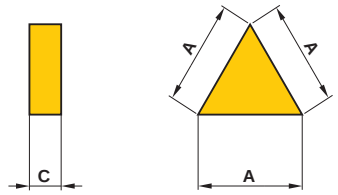
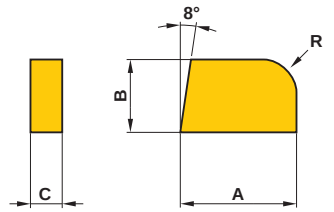
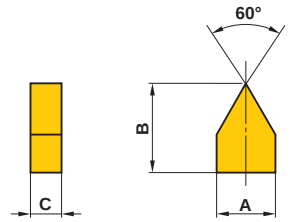
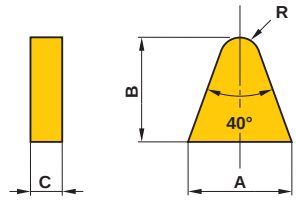
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

TURNING TOOLS

BRAZED TOOLS

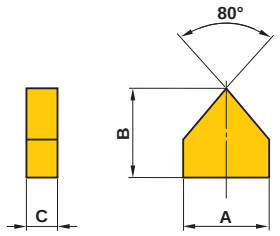
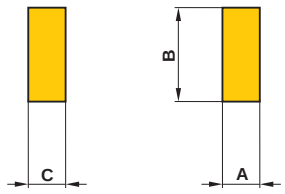
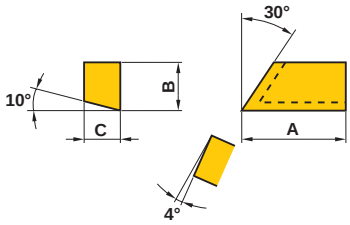
CARBIDE BLANK FOR TURNING TOOLS I002
CARBIDE RODS (MITSUBISHI STANDARD) I004
BRAZED TOOL HOLDERS I005

CARBIDE BLANK FOR TURNING TOOLS

Type	Geometry	Order Number	Stock P: STi10 (HW-P10) *	Stock P: STi20 (HW-P20) *	Stock P: STi40T (HW-P40) *	Stock M: UTi20T (HW-M20) *	Stock K: HTi03A (HW-K01) *	Stock K: HTi05T (HW-K01) *	Stock K: HTi10 (HW-K10) *	Stock K: HTi20 (HW-K20) *	Dimensions (mm) A	B	C	R
01 Type		01-0	●	●	□	●	●	●	●	□	10	6	3	4
		01-1	●	●	●	●	●	●	●	●	13	9	3	5
		01-2	●	●	●	●	●	●	●	●	16	11	4	5
		01-3	●	●	●	●	□	□	●	●	19	13	5	5
		01-4	□	●	●	●	□	□	□	□	22	15	6	8
		01-5	□	□	□	●	□	□	□	□	25	17	7	8
For 31,32 Type		01-6	□	□	□	□	□	□	□	□	30	20	8	8
02 Type		02-0	●	●	●	●	●	●	●	●	10	6	3	—
		02-1	●	●	●	●	●	●	●	●	13	9	3	—
		02-2	●	●	●	●	●	●	●	●	16	11	4	—
		02-3	●	●	●	●	●	●	●	●	19	13	5	—
		02-4	●	●	●	●	□	●	●	●	22	15	6	—
		02-5	□	●	●	●	□	●	●	●	25	17	7	—
For 41,42 Type		02-6	□	●	●	●	□	●	●	●	30	20	8	—
03 Type		03-0	□	●	□	●	□	□	□	□	10	—	3	—
		03-1	□	●	□	●	●	□	●	□	12	—	3	—
		03-2	□	●	□	●	●	□	●	□	15	—	4	—
		03-3	□	●	□	●	□	●	●	●	18	—	5	—
		03-4	□	□	□	□	□	□	□	□	24	—	6	—
		03-5	□	□	□	□	□	□	□	□	24	—	7	—
For 37,38,47 Type		03-6	□	□	□	□	□	□	□	□	28	—	8	—
04 Type		04-0	●	●	□	●	●	●	●	●	10	6	3	4
		04-1	●	●	□	●	●	●	●	●	13	9	3	5
		04-2	●	●	●	●	●	●	●	●	16	11	4	5
		04-3	●	●	●	●	●	●	●	●	19	13	5	5
		04-4	□	●	□	●	□	□	●	□	22	15	6	8
		04-5	□	□	□	□	□	□	□	□	25	17	7	8
For 33,34 Type		04-6	□	□	□	□	□	□	□	□	30	20	8	8
05 Type		05-1	□	●	□	●	□	□	●	□	5	8	3	—
		05-2	●	●	□	●	□	□	●	□	6	10	4	—
		05-3	●	●	□	●	□	□	●	□	7	12	5	—
		05-4	□	●	□	●	□	□	□	□	9	16	6	—
		05-5	□	□	□	□	□	□	□	□	10	18	7	—
		05-6	□	□	□	□	□	□	□	□	11	20	8	—
For 49,51 Type														
06 Type		06-0	●	●	●	●	●	●	●	●	10	10	3	2
		06-1	●	●	●	●	●	●	●	●	13	13	3	2.5
		06-2	●	●	●	●	●	●	●	●	16	16	4	3
		06-3	●	●	●	●	●	●	●	●	19	19	5	4
		06-4	□	●	□	●	□	●	●	●	22	22	6	4
		06-5	□	□	□	□	□	□	□	□	25	25	7	5
		06-6	□	□	□	□	□	□	□	□	30	30	8	6
For 36,39,40 Type														

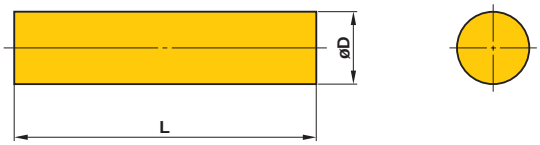
*( ) : Materials for cemented carbide tools and the classification for usage.

● : Inventory maintained in Japan. (10 inserts in one case)
□ : Non stock, produced to order only.

Type	Geometry	Order Number	Stock								Dimensions (mm)			
			P			M	K							
			STi10 (HW-P10) *	STi20 (HW-P20) *	STi40T (HW-P40) *	UTi20T (HW-M20) *	HTi03A (HW-K01) *	HTi05T (HW-K01) *	HTi10 (HW-K10) *	HTi20 (HW-K20) *	A	B	C	R
07 Type		**07-0**	●	●	□	●	□	●	●	□	10	10	3	—
		07-1	□	●	□	●	□	□	●	□	13	13	3	—
		07-2	□	●	□	●	□	□	●	□	16	16	4	—
		07-3	□	●	□	●	□	□	●	□	19	19	5	—
		07-4	□	□	□	□	□	□	□	□	25	20	6	—
		07-5	□	□	□	□	□	□	□	□	25	22	7	—
For 35 Type		**07-6**	□	□	□	□	□	□	□	□	30	25	8	—
08 Type		**08-1**	●	●	●	●	●	●	●	●	3	8	3	—
		08-3	●	●	●	●	●	●	●	●	4	13	4	—
		08-4	●	●	●	●	●	●	●	●	5	15	5	—
		08-5	●	●	●	●	□	●	●	●	6	17	6	—
		08-6	●	●	□	●	□	□	●	●	8	20	8	—
For 43 Type														
09E Type		**09E1**	●	●	□	□	□	□	□	□	20	10	7	—
For 95 Type														

*( ) : Materials for cemented carbide tools and the classification for usage.

CARBIDE RODS



LRB SERIES

Order Number	Stock			Dimensions (mm)	
	HTi10	TF15	MF10	D	L
LRB030	●	●	●	3	330
LRB040	●	●	●	4	330
LRB050	●	●	●	5	330
LRB060	●	●	●	6	330
LRB070	●	●	●	7	330
LRB080	●	●	●	8	330
LRB100	●	●	●	10	330
LRB120	●	●	●	12	330

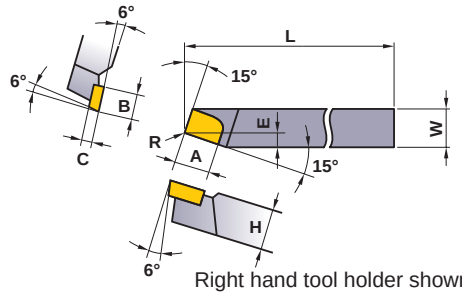
Symbol	Dimensions (mm)	Tolerance (mm)
D	3—8	+0.5 +0.3
	10—12	+0.6 +0.3

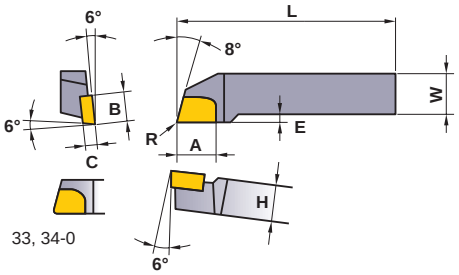
Symbol	Dimensions (mm)	Tolerance (mm)	Bend (mm)
L	330	+10 0	0.3

● : Inventory maintained in Japan. (LRB030~LRB080:10pcs/case LRB100&LRB120:5pcs/case)

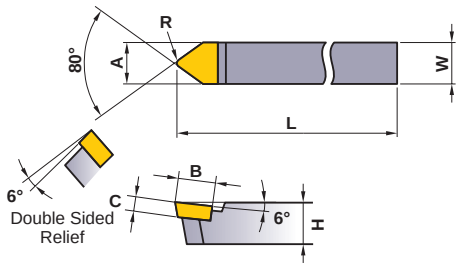
BRAZED TOOL HOLDERS

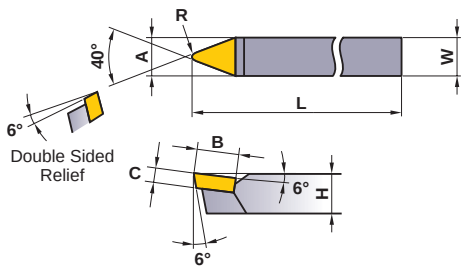
Geometry	Order Number	R/L	Stock P STi10	Stock P STi20	Stock P STi40T	Stock M UTi20T	Stock K HTi05T	Stock K HTi10	Stock K HTi20	Dimensions (mm) Shank W	Shank H	Shank L	Shank E	Carbide A	Carbide B	Carbide C	Carbide R	Blank No.
31 Type(Right Hand)	**31-0**	R		●		●				10	10	80	2.7	10	6	3	0.3	01-0
32 Type(Left Hand)	**32-0**	L		●						10	10	80	2.7	10	6	3	0.3	01-0
	31-1	R		●		●		●		13	13	100	4	13	9	3	0.5	01-1
	32-1	L		●		●		●		13	13	100	4	13	9	3	0.5	01-1
	31-2	R		●		●		●		16	16	120	4.5	16	11	4	0.5	01-2
	32-2	L		●		●		●		16	16	120	4.5	16	11	4	0.5	01-2
	31-3	R	●	●		●	●	●	●	19	19	140	5.5	19	13	5	0.5	01-3
	32-3	L		●		●				19	19	140	5.5	19	13	5	0.5	01-3
	31-4	R	●	●		●	●	●		25	25	160	6.5	22	15	6	1	01-4
Right hand tool holder shown.	**32-4**	L		●	●	●		●		25	25	160	6.5	22	15	6	1	01-4
33 Type(Right Hand)	**33-0**	R	●	●		●	●	●	●	10	10	80	—	10	6	3	0.3	04-0
34 Type(Left Hand)	**34-0**	L	●	●		●	●	●	●	10	10	80	—	10	6	3	0.3	04-0
	33-1	R	●	●	●	●	●	●	●	13	13	100	4	13	9	3	0.5	04-1
	34-1	L	●	●		●	●	●	●	13	13	100	4	13	9	3	0.5	04-1
	33-2	R	●	●	●	●	●	●	●	16	16	120	4	16	11	4	0.5	04-2
	34-2	L	●	●		●	●	●	●	16	16	120	4	16	11	4	0.5	04-2
	33-3	R	●	●	●	●	●	●	●	19	19	140	5	19	13	5	0.5	04-3
	34-3	L	●	●	●	●	●	●	●	19	19	140	5	19	13	5	0.5	04-3
	33-4	R	●	●	●	●	●	●	●	25	25	160	5	22	15	6	1	04-4
	34-4	L	●	●	●	●	●	●	●	25	25	160	5	22	15	6	1	04-4
	33-5	R		●		●				25	30	180	6	25	17	7	1	04-5
	34-5	L		●						25	30	180	6	25	17	7	1	04-5
	33-6	R		●		●				30	35	200	6	30	20	8	1	04-6
Right hand tool holder shown.	**34-6**	L		●		●				30	35	200	6	30	20	8	1	04-6
35 Type	**35-0**	—	●	●		●	●	●	●	10	10	80	—	10	10	3	0.3	07-0
	35-1	—	●	●		●	●	●	●	13	13	100	—	13	13	3	0.5	07-1
	35-2	—	●	●		●	●	●	●	16	16	120	—	16	16	4	0.5	07-2
	35-3	—	●	●		●	●	●	●	19	19	140	—	19	19	5	0.5	07-3
	35-4	—		●		●	●	●		25	25	160	—	25	20	6	1	07-4
36 Type	**36-0**	—	●	●		●	●	●	●	10	10	80	—	10	10	3	2	06-0
	36-1	—	●	●		●	●	●	●	13	13	100	—	13	13	3	2.5	06-1
	36-2	—	●	●		●	●	●	●	16	16	120	—	16	16	4	3	06-2
	36-3	—	●	●	●	●	●	●	●	19	19	140	—	19	19	5	4	06-3
	36-4	—	●	●	●	●	●	●	●	25	25	160	—	22	22	6	4	06-4
	36-5	—		●				●		25	30	180	—	25	25	7	5	06-5
	36-6	—		●		●	●	●		30	35	200	—	30	30	8	6	06-6





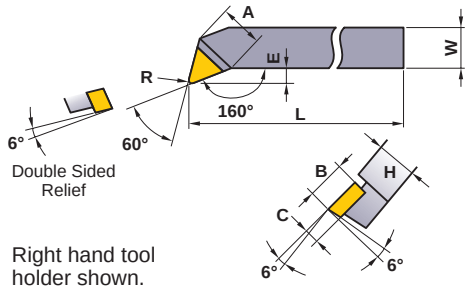
33, 34-0



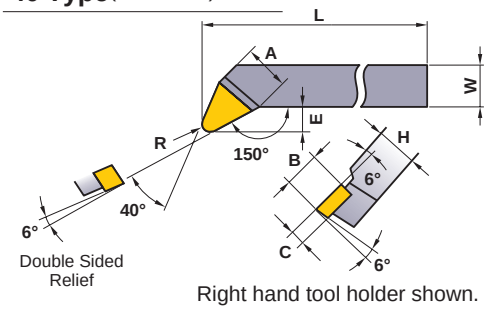


BRAZED TOOL HOLDERS

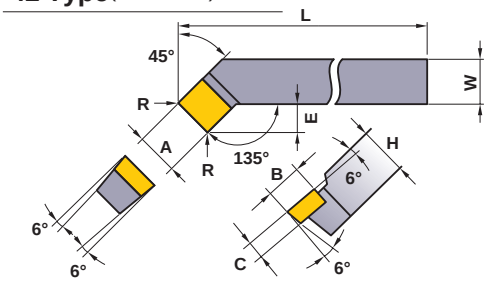
Geometry	Order Number	R/L	Stock P STi10	Stock P STi20	Stock P STi40T	Stock M UTi20T	Stock K HTi05T	Stock K HTi10	Stock K HTi20	Dimensions (mm) Shank W	Shank H	Shank L	Shank E	Carbide A	Carbide B	Carbide C	Carbide R	Blank No.
37 Type(Right Hand)	37-1	R	●	●		●	●	●		13	13	100	5	12	—	3	0.5	03-1
38 Type(Left Hand)	38-1	L		●				●		13	13	100	5	12	—	3	0.5	03-1
	37-2	R	●	●		●	●	●		16	16	120	6	15	—	4	0.5	03-2
	38-2	L		●		●		●		16	16	120	6	15	—	4	0.5	03-2
	37-3	R	●	●		●	●	●		19	19	140	7	18	—	5	0.5	03-3
	38-3	L		●		●	●	●	●	19	19	140	7	18	—	5	0.5	03-3
	37-4	R	●	●		●	●	●		25	25	160	10	24	—	6	1	03-4
	38-4	L		●				●		25	25	160	10	24	—	6	1	03-4
39 Type(Right Hand)	39-0	R	●	●		●	●	●	●	10	10	80	5	10	10	3	2	06-0
40 Type(Left Hand)	40-0	L		●		●	●	●	●	10	10	80	5	10	10	3	2	06-0
	39-1	R	●	●		●	●	●	●	13	13	100	7	13	13	3	2.5	06-1
	40-1	L	●	●		●	●	●	●	13	13	100	7	13	13	3	2.5	06-1
	39-2	R	●	●	●	●	●	●	●	16	16	120	10	16	16	4	3	06-2
	40-2	L	●	●		●	●	●	●	16	16	120	10	16	16	4	3	06-2
	39-3	R	●	●	●	●	●	●	●	19	19	140	12	19	19	5	4	06-3
	40-3	L	●	●	●	●	●	●	●	19	19	140	12	19	19	5	4	06-3
	39-4	R	●	●	●	●	●	●	●	25	25	160	13	22	22	6	4	06-4
	40-4	L		●		●	●	●	●	25	25	160	13	22	22	6	4	06-4
41 Type(Right Hand)	41-0	R		●		●				10	10	80	6	10	6	3	0.3	02-0
42 Type(Left Hand)	41-1	R	●	●		●		●	●	13	13	100	7	13	9	3	0.5	02-1
	42-1	L		●		●		●		13	13	100	7	13	9	3	0.5	02-1
	41-2	R	●	●		●	●	●		16	16	120	10	16	11	4	0.5	02-2
	42-2	L		●		●		●		16	16	120	10	16	11	4	0.5	02-2
	41-3	R	●	●		●	●	●	●	19	19	140	12	19	13	5	0.5	02-3
	42-3	L	●	●		●	●	●		19	19	140	12	19	13	5	0.5	02-3
	41-4	R	●	●		●	●	●		25	25	160	13	22	15	6	1	02-4
	42-4	L		●		●		●		25	25	160	13	22	15	6	1	02-4
43 Type	43-1	—	●	●		●	●	●	●	10	16	100	13	3	8	3	—	08-1
	43-2	—	●	●		●	●	●	●	13	19	120	16	3	8	3	—	08-1
	43-3	—	●	●	●	●	●	●	●	16	22	140	20	4	13	4	—	08-3
	43-4	—	●	●		●	●	●	●	19	25	160	25	5	15	5	—	08-4
	43-5	—		●		●				22	32	180	30	6	17	6	—	08-5



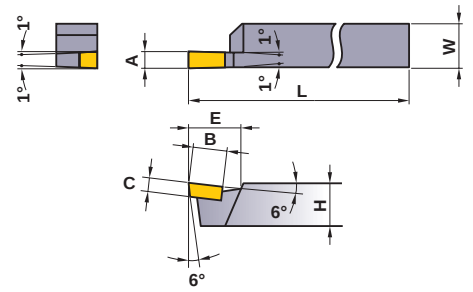
Right hand tool holder shown.



Right hand tool holder shown.

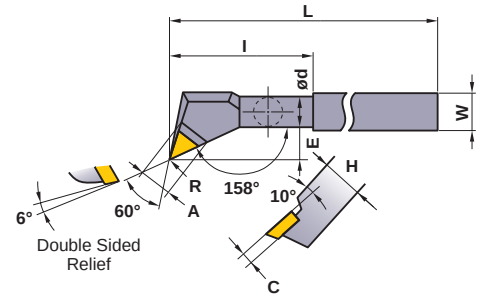


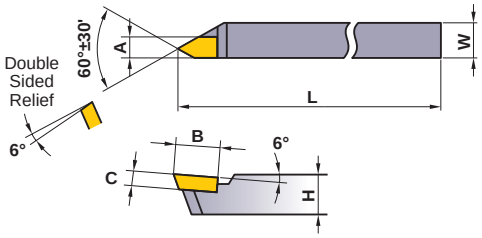
Right hand tool holder shown.

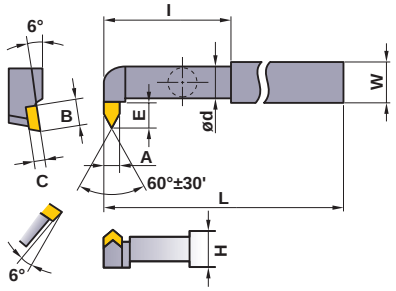


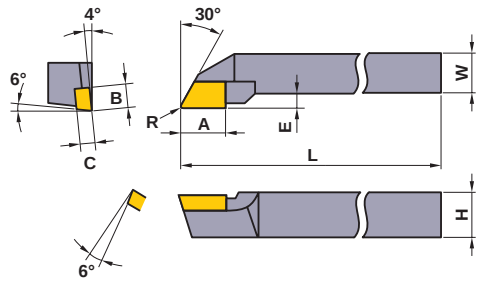
● : Inventory maintained in Japan.

Geometry	Order Number	R/L	Stock P STi10	Stock P STi20	Stock M UTi20T	Stock K HTi05T	Stock K HTi10	Dimensions (mm) Shank W	Shank H	Shank L	Shank d	Shank E	Shank I	Carbide A	Carbide B	Carbide C	Carbide R	Blank No.
47Type (Right Hand)	**47-1**	R	●	●	●	●	●	13	13	140	12	7	50	10	—	3	0.5	03-0
	47-2	R	●	●	●	●	●	16	16	160	15	8	60	12	—	3	0.5	03-1
	47-3	R	●	●	●	●	●	19	19	190	18	9	80	15	—	4	0.5	03-2
	47-4	R		●	●			25	25	230	22	10	100	18	—	5	1	03-3
49Type (Right Hand)	**49-1**	R			●			13	13	100	—	—	—	5	8	3	—	05-1
	49-2	R	●	●	●		●	16	16	120	—	—	—	6	10	4	—	05-2
	49-3	R	●	●	●	●		19	19	140	—	—	—	7	12	5	—	05-3
	49-4	R	●	●	●			25	25	160	—	—	—	9	16	6	—	05-4
51Type (Right Hand)	**51-1**	R		●	●			13	13	140	12	8	50	5	8	3	—	05-1
	51-2	R		●	●			16	16	160	15	10	60	6	10	4	—	05-2
	51-3	R		●	●			19	19	190	18	12	80	7	12	5	—	05-3
95Type	**95-1**	R	●	●				25	25	160	—	5	—	20	10	7	1	09E1









I

BRAZED TOOLS

HOW TO READ THE STANDARD OF SOLID END MILLS

●How this section page is organised

①Organised according to cutting mode for milling. (Refer to END MILL LIST.)

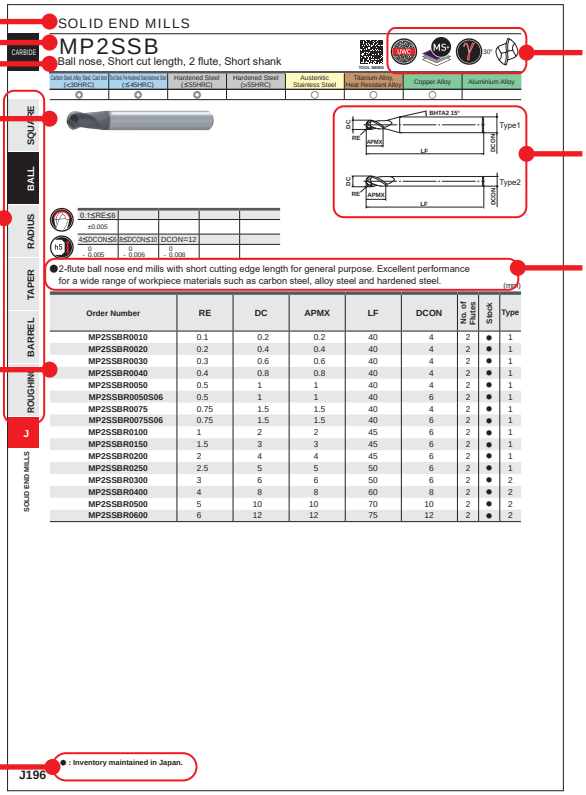
CUTTING EDGE GEOMETRY

PHOTO OF PRODUCT

PRODUCT TITLE

ITEM NUMBER

PRODUCT BLOCK



PRODUCT INFORMATION ICONS

GEOMETRY

PRODUCT FEATURES

LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

PRODUCT STANDARDS
indicates order numbers, dimensions, and stock status.

●To Order:
For solid end mills, please specify ①order number.

MILLING TOOLS

SOLID END MILLS

IDENTIFICATION ····· J002
SYMBOL DESCRIPTIONS ····· J003
COATING TECHNOLOGY ····· J004
TOOL NAVI ····· J006
END MILLS SELECTION CHART CARBIDE ··· J024
END MILLS SELECTION CHART HSS ··· J044

SOLID END MILLS STANDARD
- CARBIDE
  - SQUARE ····· J048
  - BALL ····· J196
  - RADIUS ····· J274
  - TAPER BALL ····· J352
  - BARREL ····· J358
  - ROUGHING ····· J362
- HSS
  - SQUARE ····· J378
  - ROUGHING ····· J402

*Arranged by Alphabetical order

J379	**1LA**
J378	**1MA**
J388	**2LS**
J391	**2MK**
J386	**2MS**
J384	**2SS**
J400	**4LC**
J398	**4MC**
J099	**C2JS**
J106	**C2LA**
J100	**C2LS**
J104	**C2MA**
J252	**C2MB**
J108	**C2MHA**
J095	**C2MS**
J102	**C2SA**
J094	**C2SS**
J128	**C3SA**
J282	**C3SARB**
J182	**C4JC**
J356	**C4LATB**
J183	**C4LC**
J181	**C4MC**
J236	**CBN2XLB**
J280	**CBN2XLRB**
J338	**CE4SRB**
J338	**CE6SRB**
J374	**CMRA**
J230	**CRN2MB**
J277	**CRN2MRB**
J084	**CRN2MS**
J086	**CRN2XL**
J232	**CRN2XLB**
J278	**CRN2XLRB**
J174	**CRN4JC**
J372	**CSRA**
J370	**CSRARB**
J238	**DC2SB**
J240	**DC2XLB**
J244	**DF2MB**
J246	**DF2XLB**
J250	**DF2XLBF**
J266	**DF3XB**
J176	**DF4JC**
J177	**DF4XL**
J180	**DFC4JC**
J195	**DFCJRT**
J335	**DFPSRB**
J089	**DLC2MA**
J242	**DLC2MB**
J376	**GBE**
J198	**MP2MB**
J197	**MP2SB**
J200	**MP2SDB**
J196	**MP2SSB**
J202	**MP2XLB**
J254	**MP3XB**
J134	**MPJHV**
J130	**MPMHV**
J284	**MPMHVRB**
J288	**MPXLRB**
J408	**MR**
J066	**MS2ES**
J054	**MS2JS**
J056	**MS2LS**
J052	**MS2MD**
J274	**MS2MRB**
J049	**MS2MS**
J048	**MS2SS**
J058	**MS2XL**
J062	**MS2XL6**
J114	**MS3ES**
J152	**MS4EC**
J146	**MS4JC**
J144	**MS4MC**
J294	**MS4MRB**
J142	**MS4SC**
J148	**MS4XL**
J140	**MSJHD**
J137	**MSMHD**
J112	**MSMHZD**
J136	**MSSHD**
J392	**S2SDA**
J091	**SED2KMG**
J092	**SED2KPG**
J110	**SEE2L**
J186	**SEE4L**
J185	**SEG4SA**
J382	**VA2MS**
J380	**VA2SS**
J396	**VA4MC**
J404	**VAMFPR**
J393	**VAMH**
J406	**VAMR**
J402	**VASFPR**
J082	**VC2C**
J080	**VC2JS**
J077	**VC2MS**
J075	**VC2SS**
J268	**VC3MB**
J170	**VC4JC**
J326	**VC4JRB**
J168	**VC4MC**
J324	**VC4SRB**
J352	**VC4STB**
J328,J329	**VCHFRB**
J193	**VCLD**
J172	**VCMDSC**
J126	**VCMH**
J332	**VCMHDRB**
J318,J322	**VCPSRB**
J228	**VCXB**
J068	**VF2MD**
J070	**VF2MV**
J216	**VF2SDB**
J217	**VF2SDBL**
J219	**VF2WB**
J072	**VF2XL**
J222	**VF2XLB**
J220	**VF2XLBS**
J260	**VF3XB**
J272	**VF4MB**
J164	**VF4MD**
J166	**VF4MV**
J189	**VF6MHV**
J344	**VF6MHVRB**
J369	**VF6SVRCH**
J194	**VF8MHVCH**
J350	**VF8MHVRBCH**
J316	**VFFDRB**
J306, J312	**VFHVRB**
J191	**VFMD**
J348	**VFMDRB**
J368	**VFMFPR**
J167	**VFMHVCH**
J304	**VFMHVRBCH**
J212	**VFR2SB**
J214	**VFR2SBF**
J210	**VFR2SSB**
J190	**VFSD**
J346	**VFSDRB**
J365	**VFSFPR**
J367	**VFSFPRCH**
J270	**VQ4SVB**
J188	**VQ6MHVCH**
J342	**VQ6MHVRBCH**
J158	**VQJHV**
J154	**VQMHV**
J297	**VQMHVRB**
J302	**VQMHVRBF**
J116	**VQMHZV**
J122	**VQMHZVOH**
J362	**VQSVR**
J340	**VQT5MVRB**
J358	**VQT6UR**
J160	**VQXL**

IDENTIFICATION

ORDER NUMBER OF END MILLS

VQ 4 S VB R0100 *

End Mill Names

- **VQ** : SMART MIRACLE end mills
- **VFR** : IMPACT MIRACLE REVOLUTION end mills
- **VF** : Impact Miracle end mills
- **MP** : MS plus end mills
- **MS** : Mstar end mills
- **VC** : Miracle end mills
- **CRN** : CRN coated end mills
- **DLC** : DLC coated end mills
- **DFC** : CVD diamond coated end mills
- **DF** : Diamond coated end mills
- **DC** : Diamond coated end mills
- **CBN** : CBN end mills
- **CE** Ceramic end mills
- **C** : Carbide end mills
- **VA** : Violet end mills
- **S** : KHAS end mills (High-grade powder high-speed steel)
- **None** : Cobalt high-speed steel

Number of Flutes

- **1** : 1flute
- **2** : 2flute
- **3** : 3flute
- **4** : 4flute
- **5** : 5flute
- **6** : 6flute
- **8** : 8flute
- • • •

Flute Length

- **ES** : Extra short
- **S** : Short
- **M** : Medium
- **J** : Semi long
- **L** : Long
- **XL** : Long neck
- **X** : Taper neck
- **SX** : Extra long
- **MX** : Extra long

Features

- **S** : General-use
- **U** : For stainless steel
- **K** : For keyway
- **A** : For light alloy
- **C** : Center cut
- **D** : For deep cut
- **V** : Irregular spiral helix angle
- **B** : Ball nose
- **VB** : Irregular spiral helix angle, Ball nose
- **R** : Roughing
- **FPR** : Fine roughing
- **H** : High helix
- **T** : Taper
- **TB** : Taper ball nose
- **RB** : Corner radius
- **CH** : Coolant hole
- **UR** : Multi step radius
- **3** : 3mm shank
- **6** : 6mm shank

Dimensions

D＊＊＊＊ : Diameter

ex.

D0050 → ϕ0.5

D0500 → ϕ5

R＊＊＊＊ : Radius of ball nose

ex.

R0050 → R0.5

R0500 → R5

Others

- **S＊＊** : Shank diameter
- **N＊＊＊** : Neck length
- **T＊＊＊＊** : Taper angle one side
- **L＊＊** : Flute length
- **A＊＊＊** : Overall Length

＊Other types are available by special order.

SYMBOL DESCRIPTIONS

Tool Material

Ultra Micro Grain Carbide (UWC)
Ultra micro grain carbide is used as the substrate material.

Cubic Boron Nitride (CBN)
Mitsubishi's original CBN is used.

Ceramic (CERAMIC)
Ceramic is used as the substrate material.

High Hardness Powder Metallurgy HSS (KHA S)
High hardness powder metallurgy HSS is used as the substrate material.

Ultra Micro Grain HSS (CO HSS)
Cobalt high speed steel is used as the substrate material.

High Speed Steel (HSS)
High speed steel is used as the substrate material.

Tolerances

Outside Diameter Tolerance
Indicates diameter tolerance of end mill.

R Tolerance
Indicates the radial tolerance of a ball nose end mill.

R Tolerance
Indicates the radial tolerance of an end mill with a corner radius.

Tolerance of Taper Angle
Indicates the tolerance of the taper angle.

Tolerance of Point Angle
Indicates the tolerance of the point angle.

Shank Diameter Tolerance (h6)
Indicates the shank diameter tolerance of end mill.

Angle, Coolant hole, Sharp corner edge and Gash land

Helix Angle
Indicates the helix angle of the end mill.

End Cutting Edge with Coolant Hole

Peripheral Cutting Edge with Coolant Hole

Sharp Corner Edge
Indicates the end mill has a sharp corner edge.

Gash Land
Indicates the end mill cutting edge has a gash land.

Coating

SMART MIRACLE Coating (VQ)
(Al, Cr)N coaitng optimum for difficult-to-cut materials.

IMPACT MIRACLE REVOLUTION Coating (VFR)
A coating which adds the excellent high oxidation temperature of (AL, Cr, Si) N-based films to the nano crystal technology of VF.

IMPACT MIRACLE Coating (VF)
Single phase nano crystal coating technology for higher film hardness and heat resistance.

MS PLUS Coating (MS+)
Offers higher versatility for carbon steel, alloy steel and hardened steel.

(Al,Ti)N Coating (MS)
(Al,Ti)N offers higher versatility.

MIRACLE Coating (VC)
The original Miracle (Al, Ti)N coating also suitable for dry cutting of carbon steels and hardened steels.

CRN Coating (CRN)
Newly developed CrN coating for Copper Electrodes machining.

DLC Coating (DLC)
Hardness similar to that of CVD diamond coating achieved with high adhesion strength.
(Jointly developed with SHINMAYWA INDUSTRIES, LTD.)

CVD Diamond Coated End Mills (DFC)
Suitable for CFRP

CVD Diamond Coated End Mills (DC)
High performance coating for hard brittle materials excelling in film adhesion to the substrate.

Diamond Coating (DF)
Suitable for graphite machining.

VIOLET Coating (V)
The original Miracle (Al, Ti)N coating achieves longer tool life.

Work Application Range

1st Recommenedation

P M K N S H

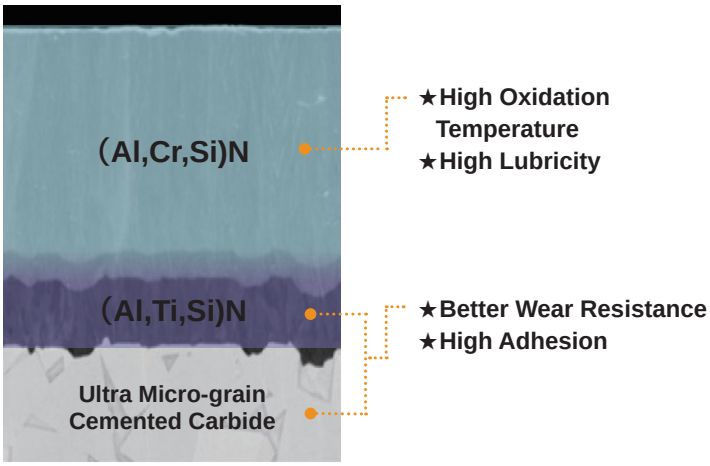
2nd Recommenedation

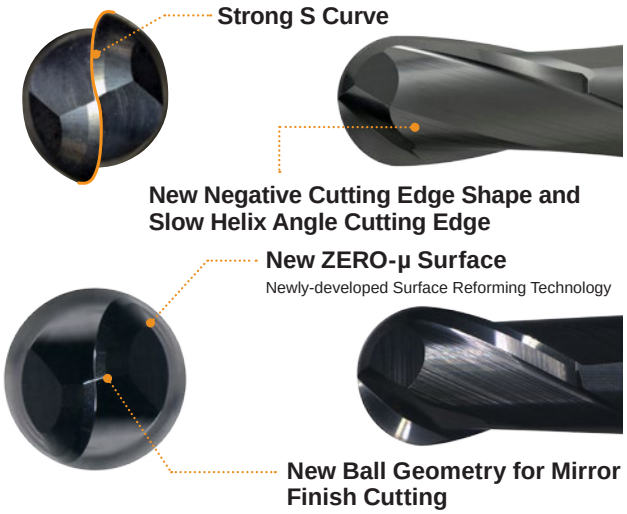
P M K N S H

COATING TECHNOLOGY

IMPACT MIRACLE REVOLUTION Coating

The combination of the (Al, Cr, Si) N coating (newly-developed), which has a high oxidation temperature and high lubricity, together with the (Al, Ti, Si) N coating, which has better wear resistance and high adhesion, allows hardened steel with even greater strength to be maintained.





IMPACT MIRACLE Coating

For higher hardness, higher speed and longer tool life!

In comparison with the conventional coating single-phase nano crystal coating technology offers higher coating hardness and heat resistance. When machining hardened steels it can be seen that the IMPACT MIRACLE coating offers a lower friction of coefficient and as such prevents abnormal damage such as chipping.

Properties of IMPACT MIRACLE COATING

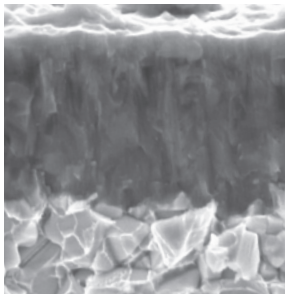
	IMPACT MIRACLE Single-phase nano coating (Al,Ti,Si)N	(Al,Ti,Si)N	(Al,Ti)N
Hardness (HV)	**3700**	3200	2800
Oxidation Temperature (℃)	**1300**	1100	840
Adhesion (N)[1]	**100**	80	80
Wear Coefficient[2] (800℃)	**0.48**	0.53	0.58

1) Adhesion : Measured by critical load scratch test.
2) Coefficient of friction : Measured by ball-on-disk method.
(Counter gear : AISI D2 60HRC)

MS plus Coating

Suitable coating for a broad range of workpiece materials such as carbon steel, alloy steel and hardened steel of approx. 50HRC.

Our original coating technology enables a multilayer of (Al,Ti)N and (Al,Cr)N. It allows machining of a wide range of workpiece materials.

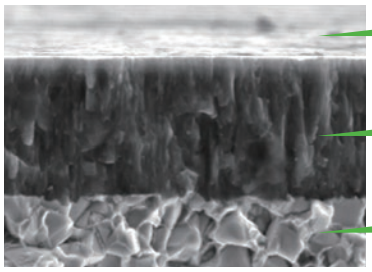


Properties of MS plus coating

	(Al,Ti,Cr)N multilayer	(Al,Ti)N	(Al,Cr)N
Hardness (HV)	**3200**	2800	3100
Oxidation Temperature (℃)	**1100**	800	1100
Adhesion (N)	**100**	80	80

SMART MIRACLE Coating

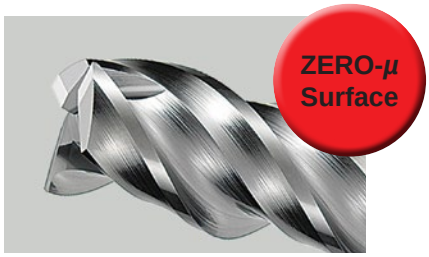
Newly-developed (Al,Cr)N coating with improved wear resistance.
The smoothening treatment of the coating layer reduces the cutting resistance and improves chip discharge significantly. This next-generation coating offers longer tool life and higher efficiency in machining difficult-to-cut materials.



Smoothed Surface"Zero-μ Surface"

Newly Developed(Al,Cr)N Coating

Super Fine Grade Substrate



SMART MIRACLE Coating

ZERO- μ Surface

The original surface treatment technology offers smooth coating layer. A good balance of smooth surface and sharp edge allows smooth chip discharge and reduces the cutting resistance. Machining efficiency and tool life is improved.

DLC Coating

Newly developed DLC coating.
Hardness similar to that of CVD diamond coating achieved with high adhesion strength.

Mitsubishi Materials and SHINMAYWA INDUSTRIES, LTD. have jointly developed a unique DLC coating that has substantially increased "adhesion strength" compared to previous DLC coating.

Diamond Coating (DC)

Proprietary CVD diamond coating produces excellent wear resistance and smooth hole surface.

The newly developed CVD diamond coated carbide material achieves outstanding abrasion resistance and smoothness due to a proprietary fine multilayer diamond crystal control technology.
Suitable for cutting hard brittle materials such as cemented carbide.

Diamond Coating (DF)

Diamond coating for non-ferrous and new non-metal materials.

Owing to Mitsubishi's unique plasma chemical vapor deposition (CVD) coating technology, great combination of coating hardness similar to that of natural diamond has been combined with a good adhesion to carbide substrates.
DF end mill series suitable for graphite machining.

VIOLET Coating

(Al,Ti)N coating, excellent adhesion strength for HSS tools.

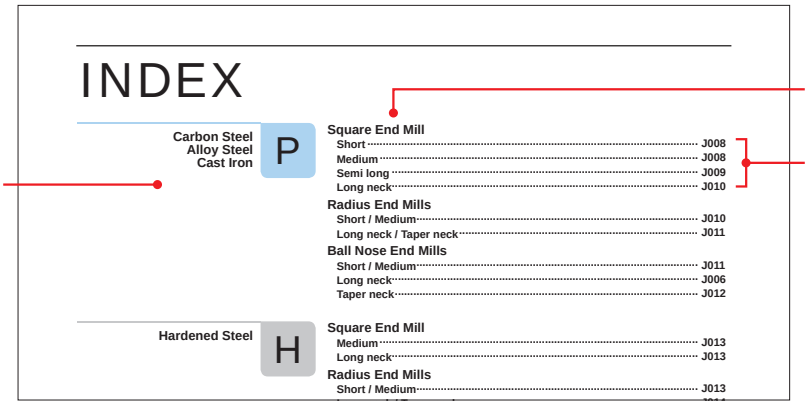
Violet coating is the name of the technology of successfully applying a Miracle type coating to HSS substrate tools. The newly developed technology of applying (Al,Ti)N coating at the low temperatures required for HSS substrates, means that Violet coating has the same level of adhesion strength as Miracle coating. Additionally high film hardness and excellent oxidation resistance properties have also been realised.

TOOL NAVI

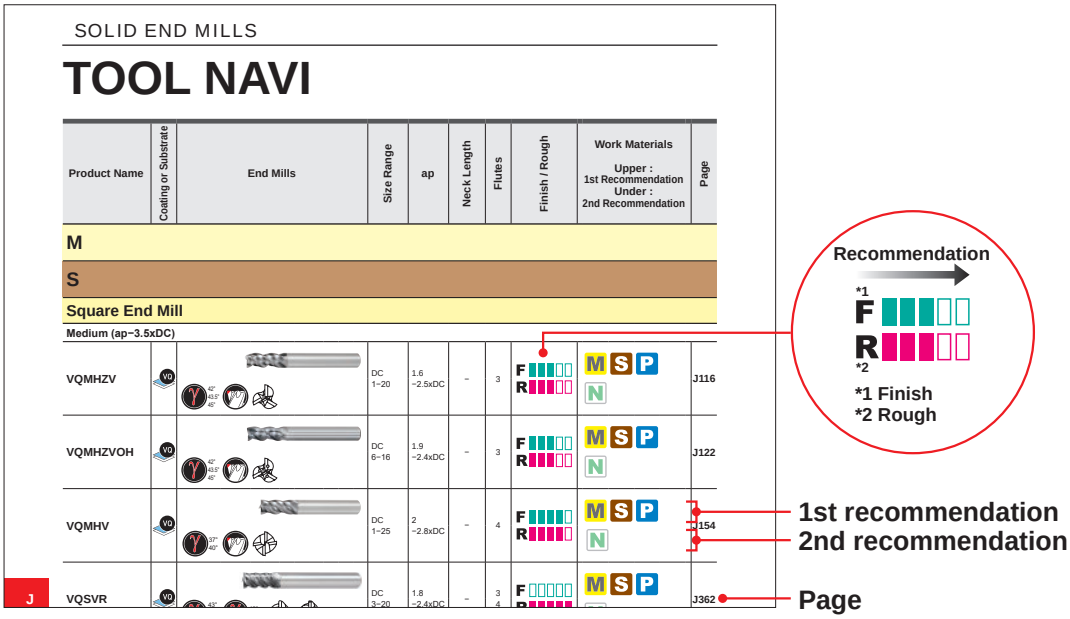
■ HOW TO USE TOOL NAVI

3 steps provide the correct tool and cutting data.

STEP1 Choose work material, end mill type and cutting length.

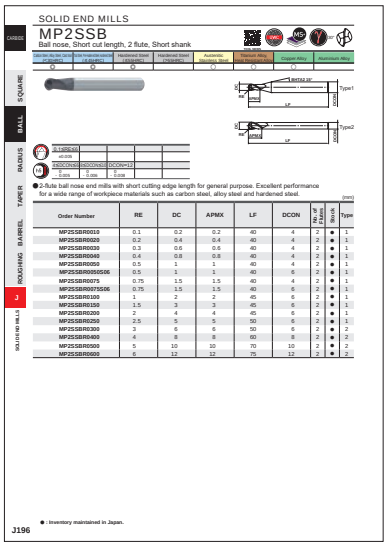


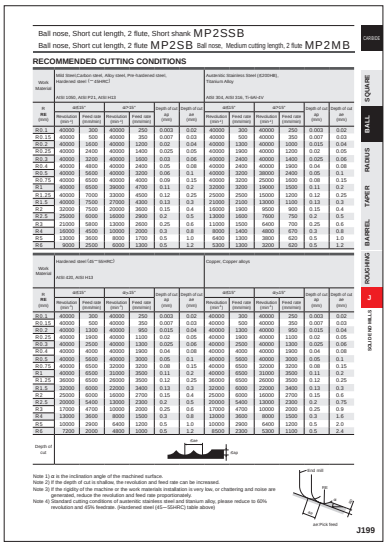
STEP2 Choose end mill.



STEP3 Choose size and cutting condition.

Size





Cutting conditions

INDEX

Carbon Steel / Alloy Steel / Cast Iron — P

Square End Mill
- Short J008
- Medium J008
- Semi long J009
- Long neck J010

Radius End Mills
- Short / Medium J010
- Long neck / Taper neck J011

Ball Nose End Mills
- Short / Medium J011
- Long neck J012
- Taper neck J012

Hardened Steel — H

Square End Mill
- Medium J013
- Long neck J013

Radius End Mills
- Short / Medium J013
- Long neck / Taper neck J014

Ball Nose End Mills
- Short / Medium J014
- Long neck / Taper neck J015

Austenitic Stainless Steel — M

Ti Alloy / Heat Resistant Alloys — S

Square End Mill
- Medium J016
- Semi long J017
- Long neck J017

Radius End Mills
- Short / Medium J017

Ball Nose End Mills
- Short / Medium J018
- Long neck J018

Ti Alloy / Heat Resistant Alloys — S

Ceramic Radius End Mills
- Short J018

Barrel End Mills
- Medium J018

Copper Alloy / Aluminium Alloy — N

Square End Mill
- Short J019
- Medium J019
- Semi long J019
- Long neck J020

Radius End Mills
- Short / Medium J020
- Long neck J020

Ball Nose End Mills
- Short / Medium J021
- Long neck J021
- Tapered flute J021

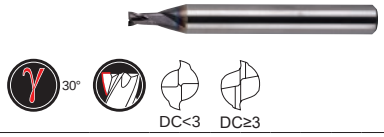
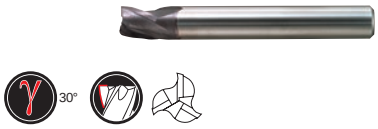
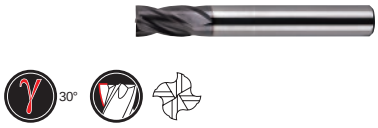
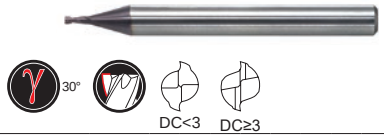
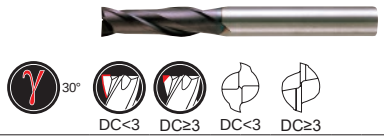
Graphite / FRP — G

Square End Mill
- Semi long J022
- Long neck J022

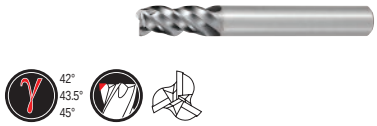
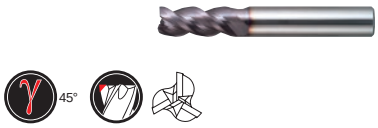
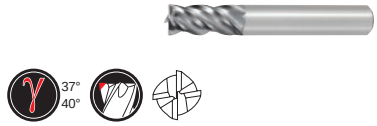
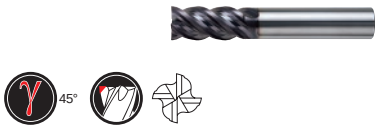
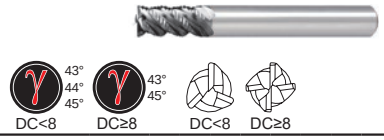
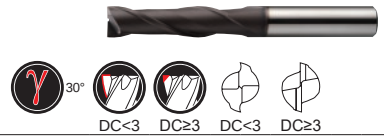
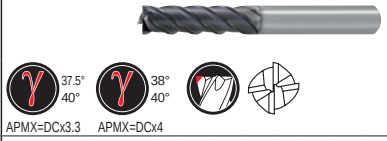
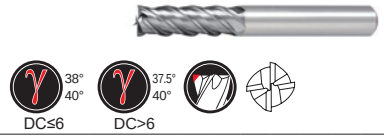
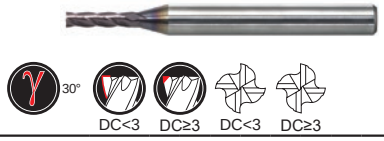
Radius End Mills
- Long neck J022

Ball Nose End Mills
- Short / Medium J022
- Long neck J023
- Taper neck J023

TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
P									
Square End Mill									
Short (ap−1.5xDC)									
MS2ES	MS	30°	DC 3−12	0.5 −1xDC	−	2	F R	P H M S N	J066
MS2SS	MS	 30° DC<3 DC≥3	DC 0.1−12	1.5xDC	−	2	F R	P H M S N	J048
MS3ES	MS	 30°	DC 3−12	0.5 −1xDC	−	3	F R	P H M S N	J114
MS4EC	MS	30°	DC 3−14	0.5 −1xDC	−	4	F R	P H M S N	J152
MS4SC	MS	 30°	DC 1−12	1.5xDC	−	4	F R	P H M S N	J142
MSSHD	MS	45°	DC 3−20	1.5xDC	−	4	F R	P H M S N	J136
Medium (ap−3xDC)									
MS2MS	MS	 30° DC<3 DC≥3	DC 0.2−20	2xDC	−	2	F R	P H M S N	J049
MS2JS	MS	 30° DC<3 DC≥3 DC<3 DC≥3	DC 0.1−12	3xDC	−	2	F R	P H M S N	J054
MPMHV	MS	37° 40°	DC 1−22	2.5xDC	−	4	F R	P M H S N	J130

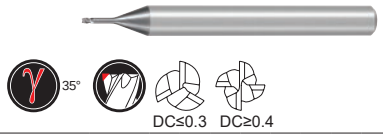
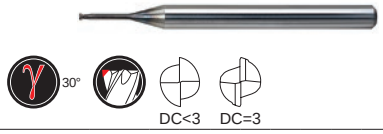
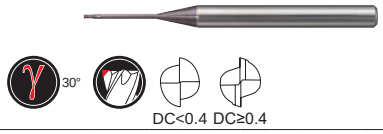
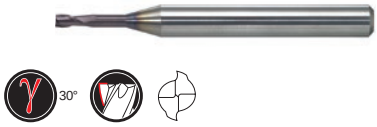
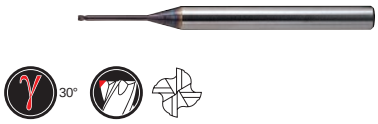
* ap : Depth of Cut
* DC : Cutting Diameter

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
VQMHZV	VQ		DC 1−20	1.6 −2.5xDC	−	3	F R	P M S N	J116
MSMHZD	MS		DC 1−20	1.6 −2.5xDC	−	3	F R	P H M S N	J112
VQMHV	VQ		DC 1−25	2 −2.8xDC	−	4	F R	P M S N	J154
MSMHD	MS		DC 2−25	2 −3.1xDC	−	4	F R	P H M S N	J137
VQSVR	VQ		DC 3−20	1.8 −2.4xDC	−	3 4	F R	P M S N	J362
Semi long (ap−4xDC)									
MS2LS	MS		DC 0.2−12	4xDC	−	2	F R	P H M S N	J056
MPJHV	MS+		DC 1−20	3.3 −4xDC	−	4	F R	P M H S N	J134
VQJHV	VQ		DC 1−20	3.3 −4xDC	−	4	F R	P M S N	J158
MSJHD	MS		DC 2−20	2.8 −4xDC	−	4	F R	P H M S N	J140
MS4JC	MS		DC 1−12	4xDC	−	4	F R	P H M S N	J146

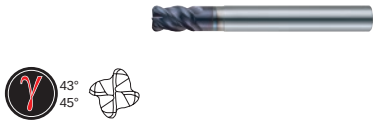
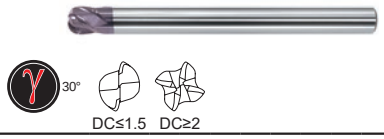
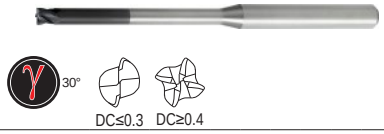
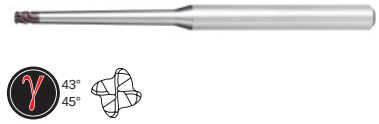
J

SOLID END MILLS

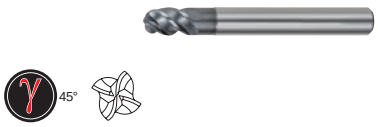
TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
P									
Square End Mill									
Long neck (ap−30xDC)									
VQXL	VQ		DC 0.2−1.0	1.4 −1.67xDC	2.5 −6xDC	3 4	F R	P M S N	J160
VF2XL	VF		DC 0.1−3	1.5 −1.7xDC	2.5 −12.5xDC	2	F R	H P	J072
MS2XL	MS		DC 0.2−6	1.3 −1.6xDC	2.5 −30xDC	2	F R	P H M S N	J058
MS2XL6	MS		DC 0.3−2.5	1.5 −2.7xDC	2.5 −5xDC	2	F R	P H M S N	J062
MS4XL	MS		DC 1−10	1xDC	2.7 −16.2xDC	4	F R	P H M S N	J148
Radius End Mills									
Short / Medium (ap−2.8xDC)									
MS2MRB	MS		DC 1−12	2xDC	−	2	F R	P H M S N	J274
MPMHVRB	MS		DC 1−20	2.5xDC	−	4	F R	P M H S N	J284
VQMHVRB	VQ		DC 2−20	2 −2.8xDC	−	4	F R	P M S N	J297
MS4MRB	MS		DC 3−20	1.9 −2.8xDC	−	4	F R	P H M S N	J294

⋆ ap : Depth of Cut ⋆ DC : Cutting Diameter
⋆ RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
Short / Medium (ap−2.8xDC)									
VFHVRB	VF		DC 1−16	1 −1.6xDC	−	4	F R	P H M S	J306
VCPSRB [High precision]	VC		DC 0.6−12	1xDC	−	2 4	F R	P H M S	J318
Long neck (ap−12xDC) / Taper neck (ap−50xDC)									
MPXLRB	MS+		DC 0.2−6	1xDC	2.5 −12xDC	2 4	F R	P H M S N	J288
VFHVRB	VF		DC 1−12	1 −1.6xDC	2.6 −50xDC	4	F R	P H M S	J312
CBN2XLRB	CBN		DC 0.5−2	0.6xDC	3 −6xDC	2	F R	P H	J280

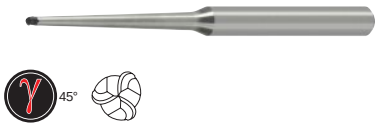
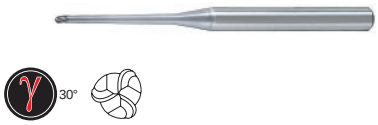
Ball Nose End Mills

Short / Medium (ap−3xDC)									
MP2SSB	MS+		RE 0.1−6	1xDC	−	2	F R	P H M S N	J196
MP2SB	MS+		RE 0.1−6	1.5 −1.7xDC	−	2	F R	P H M S N	J197
MP2MB	MS+		RE 0.25−6	1.8 −3xDC	−	2	F R	P H M S N	J198
MP2SDB	MS+		RE 0.5−6	1 −2xDC	−	2	F R	P H	J200
VQ4SVB	VQ		RE 1−6	1.5xDC	−	4	F R	P M S N	J270

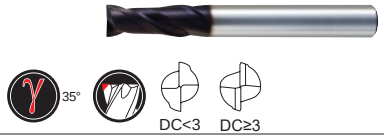
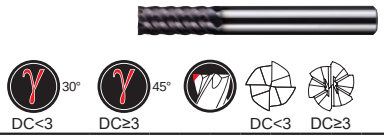
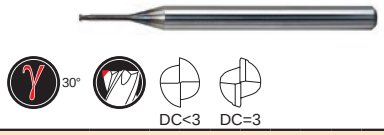
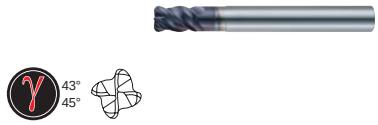
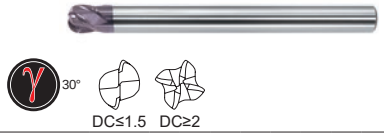
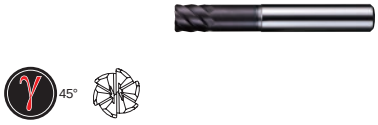
J

SOLID END MILLS

TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
P									
Ball Nose End Mills									
Long neck (ap−20xDC)									
MP2XLB	MS		RE 0.05−3	0.7 −1xDC	1.2 −20xDC	2	F R	P H M S N	J202
VF2XLB	VF		RE 0.1−3	0.8xDC	2.5 −20xDC	2	F R	H P	J222
VF2XLBS	VF		RE 0.2−1	0.8xDC	2.5 −12xDC	2	F R	H P	J220
VF2WB	VF		RE 1−3	220°	2 −3xDC	2	F R	M S P H	J219
CBN2XLB	CBN		RE 0.2−1	0.6 −0.8xDC	0.85 −4xDC	2	F R	P H	J236
Taper neck (ap−70xDC)									
MP3XB	MS		RE 0.5−6	0.8 −1.5xDC	3.3 −50xDC	3	F R	P H M S N	J254
VF3XB	VF		RE 0.4−2.5	0.6 −0.9xDC	6.7 −70xDC	3	F R	P H	J260

* ap : Depth of Cut
* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
H									
Square End Mill									
Medium (ap−3.5xDC)									
VF2MD	VF		DC 0.5−6	2.5xDC	−	2	F R	H P	J068
VF4MD	VF		DC 1−20	2.5xDC	−	4	F R	H P	J164
VFSD	VF		DC 1−12	2xDC	−	4 6	F R	H P	J190
VFMD	VF		DC 1−25	2 −3.5xDC	−	4 6	F R	H P	J191
Long neck (ap−12.5xDC)									
VF2XL	VF		DC 0.1−3	1.5 −1.7xDC	2.5 −12.5xDC	2	F R	H P	J072
Radius End Mills									
Short / Medium (ap−3.3xDC)									
VFHVRB	VF		DC 1−16	1 −1.6xDC	−	4	F R	H P M S	J306
VCPSRB [High precision]	VC		DC 0.6−12	1xDC	−	2 4	F R	H P M S	J318
VFSDRB	VF		DC 3−12	1xDC	−	6	F R	H P	J346
VFMDRB	VF		DC 3−20	2.2 −3.3xDC	−	6	F R	H P	J348

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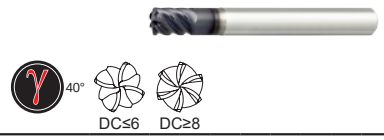
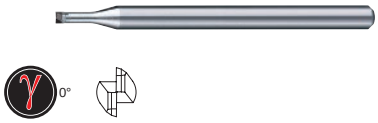
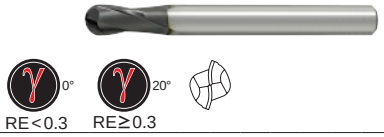
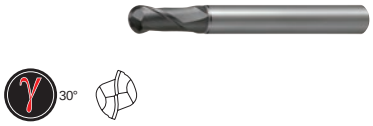
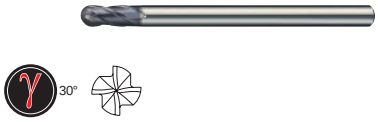
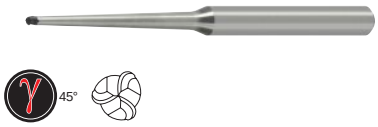
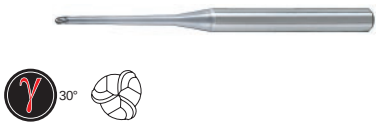
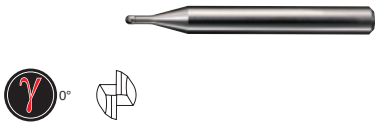
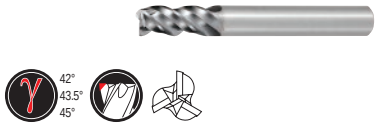
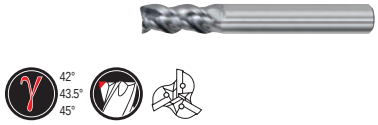
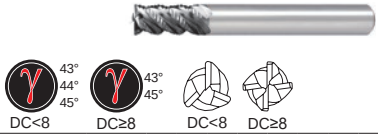
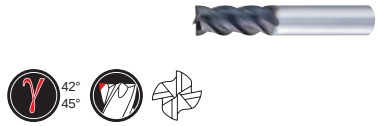
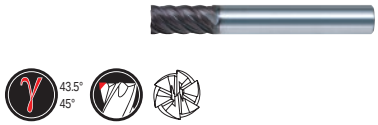
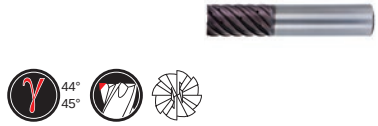
Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
H									
Radius End Mills									
Short / Medium (ap−3.3xDC)									
VFFDRB	VF		DC 3−12	0.06DC	−	4 6	F R	H P	J316
Long neck (ap−6xDC) / Taper neck (ap−50xDC)									
VFHVRB	VF		DC 1−12	1 −1.6xDC	2.6 −50xDC	4	F R	H P M S	J312
CBN2XLRB	CBN		DC 0.5−2	0.6xDC	3 −6xDC	2	F R	H P	J280
Ball Nose End Mills									
Short / Medium (ap−3xDC)									
VFR2SB	VFR		RE 0.1−10	1 −2xDC	−	2	F R	H P	J212
VFR2SBF	VFR		RE 0.5−3	1 −2xDC	−	2	F R	H P	J214
NEW VFR2SSB	VFR		RE 0.5−6	1xDC	−	2	F R	H P	J210
MP2SSB	MS		RE 0.1−6	1xDC	−	2	F R	H P M S N	J196
MP2SB	MS		RE 0.1−6	1.5 −1.7xDC	−	2	F R	H P M S N	J197
MP2MB	MS		RE 0.25−6	1.8 −3xDC	−	2	F R	H P M S N	J198

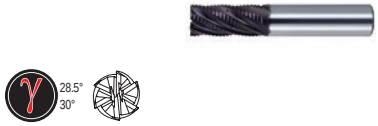
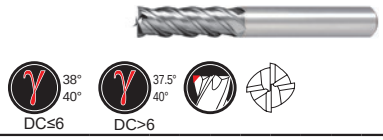
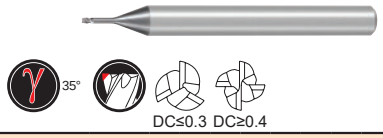
* ap : Depth of Cut
* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
MP2SDB	MS+		RE 0.5−6	1 −2xDC	−	2	F R	H P	J200
VF4MB	VF		RE 0.5−6	1.8 −3xDC	−	4	F R	H P	J272
Long neck (ap−20xDC) / Taper neck (ap−70xDC)									
MP2XLB	MS+		RE 0.05−3	0.7 −1xDC	1.2 −20xDC	2	F R	H P M S N	J202
VF2XLB	VF		RE 0.1−3	0.8xDC	2.5 −20xDC	2	F R	H P	J222
VF2XLBS	VF		RE 0.2−1	0.8xDC	2.5 −12xDC	2	F R	H P	J220
MP3XB	MS+		RE 0.5−6	0.8 −1.5xDC	3.3 −50xDC	3	F R	H P M S N	J254
VF3XB	VF		RE 0.4−2.5	0.6 −0.9xDC	6.6 −70xDC	3	F R	H P	J260
CBN2XLB	CBN		RE 0.2−1	0.6 −0.8xDC	0.85 −4xDC	2	F R	H P	J236

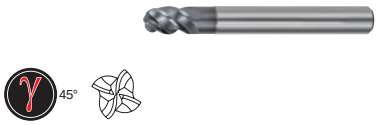
TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
M									
S									
Square End Mill									
Medium (ap−3.5xDC)									
VQMHZV	VQ	 42° 43.5° 45°	DC 1−20	1.6 −2.5xDC	−	3	F R	M S P N	J116
VQMHZVOH	VQ	 42° 43.5° 45°	DC 6−16	1.9 −2.4xDC	−	3	F R	M S P N	J122
VQMHV	VQ	37° 40°	DC 1−25	2 −2.8xDC	−	4	F R	M S P N	J154
VQSVR	VQ	 43° 44° 45° DC<8 43° 45° DC≥8 DC<8 DC≥8	DC 3−20	1.8 −2.4xDC	−	3 4	F R	M S P N	J362
VFMHVCH	VF	 42° 45°	DC 16,20	2.2xDC	−	4	F R	M S P	J167
VF6MHV	VF	 43.5° 45°	DC 6−20	1.9 −2.4xDC	−	6	F R	M S P	J189
NEW VQ6MHVCH	VQ	43.5° 45°	DC 10−20	1.9 −2.2xDC	−	6	F R	M S P N	J188
VF8MHVCH	VF	 44° 45°	DC 16,20	1.9 −2xDC	−	8	F R	M S P	J194
VFSFPRCH	VF	30°	DC 16,20	1.9 −2.1xDC	−	4	F R	M S P	J367

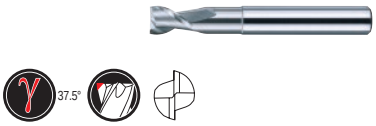
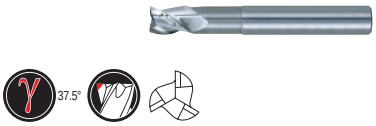
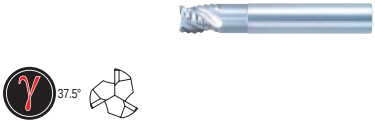
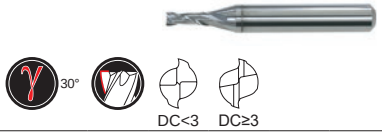
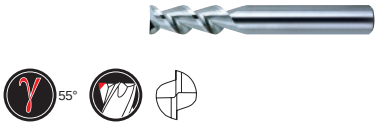
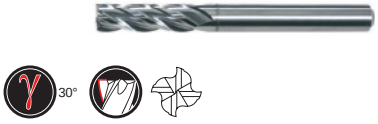
* ap : Depth of Cut
* DC : Cutting Diameter

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
VF6SVRCH	VF	 28.5° 30°	DC 16,20	1.9 −2.1xDC	–	6	F R	M S P	J369
VFMFPR	VF	30°	DC 5−20	2.8 −3.5xDC	–	4	F R	M S P	J368
Semi long (ap−4xDC)									
VQJHV	VQ	 38° 40° DC≤6 37.5° 40° DC>6	DC 1−20	3.3 −4xDC	–	4	F R	M S P N	J158
Long neck (ap−6xDC)									
VQXL	VQ	 35° DC≤0.3 DC≥0.4	DC 0.2−1.0	1.4 −1.67xDC	2.5 −6xDC	3 4	F R	M S P N	J160
Radius End Mills									
Short / Medium (ap−2.8xDC)									
VQMHVRB	VQ	37° 40°	DC 2−20	2 −2.8xDC	–	4	F R	M S P N	J297
VQMHVRBF	VQ	37° 40°	DC 6−16	2.2 −2.4xDC	–	4	F R	M S P N	J302
VFMHVRBCH	VF	42° 45°	DC 16,20	2.2 −2.3xDC	–	4	F R	M S P	J304
VQT5MVRB	VQ	40° 41.5° 43°	DC 16−25	2.2 −2.3xDC	–	5	F R	M S	J340
VF6MHVRB	VF	43.5° 45°	DC 6−20	1.9 −2.4xDC	–	6	F R	M S P	J344
VQ6MHVRBCH	VQ	43.5° 45°	DC 10−20	1.9 −2.2xDC	–	6	F R	M S P N	J342

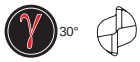
TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
M									
S									
Radius End Mills									
Short / Medium (ap−3xDC)									
VF8MHVRBCH	VF		DC 16,20	1.9 −2xDC	−	8	F R	M S P	J350
Ball Nose End Mills									
Short / Medium (ap−1.5xDC)									
VQ4SVB	VQ		RE 1−6	1.5xDC	−	4	F R	M S P N	J270
Long neck (ap−3xDC)									
VF2WB	VF		RE 1−3	−	2 −3xDC	2	F R	M S P H	J219
S									
Ceramic Radius End Mills									
Short (ap−0.75xDC)									
CE4SRB	CERAMIC		DC 6−12	0.75xDC	−	4	F R	S	J338
CE6SRB	CERAMIC		DC 6−12	0.75xDC	−	6	F R	S	J338
Barrel End Mills									
Medium (ap−2.6xDC)									
NEW VQT6UR	VQ		DC 8−12	2 −2.6xDC	−	6	F R	S M N	J358

* ap : Depth of Cut
* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
N									
Square End Mill									
Short (ap−2xDC)									
C2SA	UWC		DC 3−20	0.9 −2xDC	−	2	F R	N	J102
C3SA	UWC		DC 10−26	0.8 −1.3xDC	−	3	F R	N	J128
CSRA	UWC		DC 10−25	1.1 −1.3xDC	−	3	F R	N	J372
Medium (ap−3.2xDC)									
CRN2MS	CRN		DC 0.2−12	2 −3.2xDC	−	2	F R	N	J084
C2MHA	UWC		DC 3−25	1.5 −3xDC	−	2	F R	N	J108
CMRA	UWC		DC 3−25	1.8 −2.8xDC	−	3	F R	N	J374
Semi long (ap−4xDC)									
CRN4JC	CRN		DC 3−12	2.5 −4xDC	−	4	F R	N	J174

TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
N									
Square End Mill									
Long neck (ap−16xDC)									
CRN2XL	CRN		DC 0.2−6	1.5 −1.7xDC	2.5 −16xDC	2	F R	N	J086
Radius End Mills									
Short / Medium (ap−2.4xDC)									
CRN2MRB	CRN		DC 6−12	2.2 −2.4xDC	−	2	F R	N	J277
C3SARB	UWC		DC 12−25	0.8 −1.3xDC	−	3	F R	N	J282
CSRARB	UWC		DC 10−25	1.1 −1.3xDC	−	3	F R	N	J370
Long neck (ap−13xDC)									
CRN2XLRB	CRN		DC 0.5−6	1.5 −1.6xDC	5 −13xDC	2	F R	N	J278

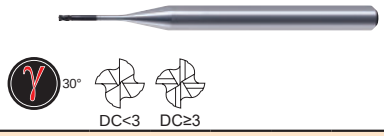
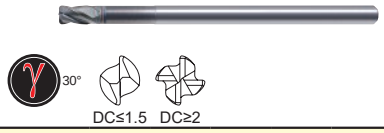
* ap : Depth of Cut
* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
Ball Nose End Mills									
Short / Medium (ap−3xDC)									
CRN2MB	CRN	30°	RE 0.2−6	1.8 −3xDC	−	2	F R	N	J230
DC2SB	DC		RE 0.1−3	0.6 −0.7xDC	−	2	F R	N * For hard brittle materials	J238
Long neck (ap−20xDC)									
CRN2XLB	CRN	30°	RE 0.1−3	1xDC	2.5 −20xDC	2	F R	N	J232
DC2XLB	DC		RE 0.1−3	0.6xDC	1.7 −5xDC	2	F R	N * For hard brittle materials	J240
Tapered flute (ap−20xDC)									
C4LATB	UWC	20°	RE 0.5−2	6.7 −20xDC	−	4	F R	N	J356

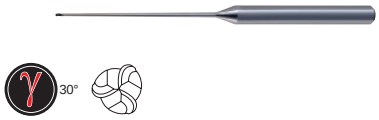
J

SOLID END MILLS

TOOL NAVI

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
G									
Square End Mill									
Semi long (ap−4xDC)									
DF4JC	DF		DC 3−12	3 −4xDC	−	4	F R	G N	J176
DFC4JC	DFC		DC 6−12	2.5 −3.8xDC	−	4	F R	G	J180
DFCJRT	DFC		DC 6−12	2.5 −3.8xDC	−	10 12	F R	G	J195
Long neck (ap−10.7xDC)									
DF4XL	DF		DC 1−12	1.5xDC	2.5 −10.7xDC	4	F R	G N	J177
Radius End Mills									
Long neck (ap−30xDC)									
DFPSRB	DF		DC 0.5−12	1.3 −1.5xDC	3.3 −30xDC	2 4	F R	G N	J335
Ball Nose End Mills									
Short / Medium (ap−5xDC)									
DF2MB	DF		RE 3−6	4.6 −5xDC	−	2	F R	G N	J244

* ap : Depth of Cut
* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Product Name	Coating or Substrate	End Mills	Size Range	ap	Neck Length	Flutes	Finish / Rough	Work Materials Upper : 1st Recommendation Under : 2nd Recommendation	Page
Long neck (ap−40xDC)									
DF2XLB	DF		RE 0.1−3	1.2 −1.5xDC	2.5 −40xDC	2	F R	G N	J246
NEW **DF2XLBF**	DF		RE 0.3−1.5	0.8 −1.5xDC	5 −20xDC	2	F R	G N	J250
Taper neck (ap−50xDC)									
DF3XB	DF		RE 0.5−2	1.5xDC	20 −50xDC	3	F R	G N	J266

END MILLS SELECTION CHART CARBIDE(By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
SQUARE															
	1	For Hardened Steels	CBN	GBE	End mill, 1 flute, Brazed type (CBN)	DC 6–12				◎					J376
	2	General Use	MS	MS2SS	End mill, Short cut length, 2 flute	DC 0.1–12	◎	◎	○		○	○	○		J048
			MS	MS2MS	End mill, Medium cut length, 2 flute	DC 0.2–20	◎	◎	○		○	○	○		J049
			MS	MS2MD	End mill, Medium cut length, 2 flute, Strong geometry type	DC 1–12	◎	◎	○		○	○			J052
			MS	MS2JS	End mill, Semi long cut length, 2 flute	DC 0.1–12	◎	◎	○		○	○	○		J054
			MS	MS2LS	End mill, Long cut length, 2 flute	DC 0.2–12	◎	◎	○		○	○	○		J056
			VC	VC2SS	End mill, Short cut length, 2 flute	DC 0.3–16	○	◎	○		○	○			J075
			VC	VC2MS	End mill, Medium cut length, 2 flute	DC 0.3–25	○	◎	○		○	○			J077
			VC	VC2JS	End mill, Semi long cut length, 2 flute	DC 1–25	○	◎	○		○	○			J080
			UWC	C2SS	End mill, Short cut length, 2 flute	DC 0.4–6	○	○			○	○	○	○	J094
			UWC	C2MS	End mill, Medium cut length, 2 flute	DC 1–20	○	○			○	○	○	○	J095
			UWC	C2JS	End mill, Semi long cut length, 2 flute	DC 1–25	○	○			○	○	○	○	J099
			UWC	C2LS	End mill, Long cut length, 2 flute	DC 1–20	○	○			○	○	○	○	J100
		High Helix	UWC	SEE2L	End mill, Long cut length, 2 flute	DC 3–20	◎	○			○	○	○	○	J110
		For Key Way Slotting	MS	SED2KPG	End mill, Medium cut length, 2 flute, + Tolerance	DC 2–16	◎	◎			○	○			J092
			MS	SED2KMG	End mill, Medium cut length, 2 flute, + Tolerance	DC 2–16	◎	◎			○	○			J091
		For Small Automatic Lathes	MS	MS2ES	End mill, 2 flute, For small automatic lathes	DC 3–12	◎	◎	○		○	○	○		J066

* DC : Cutting Diameter

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
	2	For Hardened Steels	VF	VF2MD	End mill, Medium cut length, 2 flute, For hardened materials	DC 0.5–6		○	◎	◎					J068
			VF	VF2MV	End mill, Medium cut length, 2 flute, Irregular helix flutes	DC 0.5–6		○	◎	◎					J070
		For Copper Electrodes	CRN	CRN2MS	End mill, Medium cut length, 2 flute, For copper electrodes	DC 0.2–12							◎	○	J084
		For Aluminium Alloys	DLC	DLC2MA	Medium cut length, 2 flute	DC 1–20	GFRP : ○ CFRP : ○						○	◎	J089
			UWC	C2SA	End mill, Short cut length, 2 flute, For aluminium alloy	DC 3–20								◎	J102
			UWC	C2MA	End mill, Medium cut length, 2 flute, For aluminium alloy	DC 1–20								◎	J104
			UWC	C2LA	End mill, Long cut length, 2 flute, For aluminium alloy	DC 1–20								◎	J106
			UWC	C2MHA	End mill, Medium cut length, 2 flute, For aluminium alloy	DC 3–25								◎	J108
	3	General Use	MS	MSMHZD	Slotting, Medium cut length, 3 flute	DC 1–20	◎	◎	○		○	○	○		J112
		For Small Automatic Lathes	MS	MS3ES	End mill, 3 flute, For small automatic lathes	DC 3–12	◎	◎	○		○	○	○		J114
		For Difficult-to-cut Materials	VQ	VQMHZV	End mill, Medium cutting length, 3 flute for drilling and slotting	DC 1–20	◎	◎			◎	◎	○		J116
			VQ	VQMHZVOH	End mill, Medium cutting length, 3 flute for drilling and slotting with internal through coolant holes	DC 6–16	◎	◎			◎	◎	○		J122
		For Aluminium Alloys	UWC	C3SA	End mill, Short cut length, 3 flute, For aluminium alloy	DC 10–26								◎	J128
	3 4	For Difficult-to-cut Materials	VC	VCMH	End mill, Medium cut length, 3–4 flute, High helix angle	DC 3–25	○	○	○		◎	◎			J126
	4	General Use	MS+	MPMHV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–22	◎	◎	○		◎	○	○		J130
			MS+	MPJHV	End mill, Semi long cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎	○		◎	○	○		J134
			MS	MS4SC	End mill, Short cut length, 4 flute	DC 1–12	◎	◎	○		○	○	○		J142
			MS	MS4MC	End mill, Medium cut length, 4 flute	DC 1–20	◎	◎	○		○	○	○		J144

END MILLS SELECTION CHART CARBIDE(By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
SQUARE															
	4	General Use	MS	MS4JC	End mill, Semi long cut length, 4 flute	DC 1–12	◎	◎	○		○	○	○		J146
			MS	MSSHD	High power, Short cut length, 4 flute	DC 3–20	◎	◎	○		○	○	○		J136
			MS	MSMHD	High power, Medium cut length, 4 flute	DC 2–25	◎	◎	○		○	○	○		J137
			MS	MSJHD	High power, Semi long cut length, 4 flute	DC 2–20	◎	◎	○		○	○	○		J140
			VC	VC4MC	End mill, Medium cut length, 4 flute	DC 2–25	○	◎	○		○	○			J168
			VC	VC4JC	End mill, Semi long cut length, 4 flute	DC 3–25	○	◎	○		○	○			J170
			UWC	C4MC	End mill, Medium cut length, 4 flute, Center cutting	DC 3–20	○	○			○	○	○	○	J181
			UWC	C4JC	End mill, Semi long cut length, 4 flute, Center cutting	DC 3–25	○	○			○	○	○	○	J182
			UWC	C4LC	End mill, Long cut length, 4 flute, Center cutting	DC 3–20	○	○			○	○	○	○	J183
			UWC	SEE4L	End mill, Long cut length, 4 flute	DC 3–25	○	○			○	○	○	○	J186
		For Small Automatic Lathes	MS	MS4EC	End mill, 4 flute, For small automatic lathes	DC 3–14	◎	◎	○		○	○	○		J152
		For Hardened Steels	VF	VF4MD	End mill, Medium cut length, 4 flute, For hardened materials	DC 1–20		○	◎	◎					J164
			VF	VF4MV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 6–20		○	◎	◎					J166
		For Difficult-to-cut Materials	VQ	VQMHV	End mill, Medium cutting length, 4 flute, Irregular helix flutes	DC 1–25	◎	◎			◎	◎	○		J154
			VQ	VQJHV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎			◎	◎	○		J158
			VF	VFMHVCH	End mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J167

* DC : Cutting Diameter

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
	4	For Copper Electrodes	CRN	CRN4JC	End mill, Semi long cut length, 4 flute, For copper electrodes	DC 3–12							◎	○	J174
	4	For CFRP	DFC	DFC4JC	Diamond coating endmill, 4 flute	DC 6–12	CFRP : ◎								J180
	4	For Graphite	DF	DF4JC	End mill, Semi long cut length, 4 flute, For graphite	DC 3–12	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J176
	4	For Aluminium Alloys	UWC	SEG4SA	End mill, Medium cut length, 4 flute, Irregular spiral helix angle, For aluminium alloy	DC 6–25							○	◎	J185
	4 6	For Hardened Steels	VF	VFSD	End mill, Short cut length, For hardened materials	DC 1–12		○	◎	◎					J190
	4 6	For Hardened Steels	VF	VFMD	End mill, Medium cut length, For hardened materials	DC 1–25		○	◎	◎					J191
	4 6	For Hardened Steels	VC	VCMDSC	End mill, Medium cut length, 4–6 flute	DC 0.5–3		○	◎	◎					J172
	6	For Hardened Steels	VC	VCLD	End mill, Long cut length, 6 flute	DC 6–25		○	◎	◎					J193
	6	For Difficult-to-cut Materials	VF	VF6MHV	End mill, Medium cut length, 6 flute, Irregular helix flutes	DC 6–20	○	○			◎	◎			J189
	6	For Difficult-to-cut Materials	VQ	NEW VQ6MHVCH	End mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple internal through coolant	DC 10–20	○	○			◎	◎	○		J188
	8	For Difficult-to-cut Materials	VF	VF8MHVCH	End mill, Medium cut length, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J194
	10 12	For CFRP	DFC	DFCJRT	Diamond coating endmill with cross-nick	DC 6–12	CFRP : ◎								J195
LONG NECK SQUARE															
	3 4	For Difficult-to-cut Materials	VQ	VQXL	End mill, Short cut length, 3–4 flute, Long neck	DC 0.2–1	◎	◎			◎	◎	○		J160
	2	For Deep Slotting	MS	MS2XL	End mill, Short cut length, 2 flute, Long neck	DC 0.2–6	◎	◎	○		○	○	○		J058
	2	For Deep Slotting	MS	MS2XL6	End mill, Short cut length, 2 flute, 6mm shank	DC 0.3–2.5	◎	◎	○		○	○	○		J062
	2	For Deep Slotting: Hardened Steels	VF	VF2XL	End mill, 2 flute, Long neck	DC 0.1–3	○	◎	◎	◎					J072
	2	For Deep Slotting: Copper electrodes	CRN	CRN2XL	End mill, Medium cut length, 2 flute, Long neck, For copper electrodes	DC 0.2–6							◎	○	J086

END MILLS SELECTION CHART CARBIDE(By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
LONG NECK SQUARE															
	4	For Deep Slotting / General Use	MS	MS4XL	End mill, Short cut length, 4 flute, Long neck	DC 1–10	◎	◎	○		○	○	○		J148
	4	For Graphite	DF	DF4XL	End mill, Long neck, 4 flute, For graphite	DC 1–12	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J177
BALL															
	2	General Use	MS+	MP2SSB	Ball nose, Short cut length, 2 flute, Short shank	RE 0.1–6	◎	◎	◎		○	○	○		J196
	2	General Use	MS+	MP2SB	Ball nose, Short cut length, 2 flute	RE 0.1–6	◎	◎	◎		○	○	○		J197
	2	General Use	MS+	MP2MB	Ball nose, Medium cutting length, 2 flute	RE 0.25–6	◎	◎	◎		○	○	○		J198
	2	General Use	MS+	MP2SDB	Ball nose, Short cut length, 2 flute, High strength	RE 0.5–6	○	◎	◎						J200
	2	For High Feed Machining	VF	VF2SDB	Ball nose, Short cut length, 2 flute, Strong geometry type	RE 0.5–10	○	◎	◎	○					J216
	2	For High Feed Machining	VF	VF2SDBL	Ball nose, Short cut length, 2 flute, Strong geometry type, Long shank	RE 0.5–10	○	◎	◎	○					J217
	2	For Hardened Steels	VFR	VFR2SB	Ball nose, Short cut length, 2 flute	RE 0.1–10		○	◎	◎					J212
	2	For Hardened Steels	VFR	NEW VFR2SSB	Ball nose, Short cut length, 2 flute, Short shank	RE 0.5–6		○	◎	◎					J210
	2	For Hardened Steels	VFR	VFR2SBF	Ball nose, Short cut length, 2 flute, For Mirror finish cutting	RE 0.5–3		○	◎	◎					J214
	2	General Use	UWC	C2MB	Ball nose end mill, Medium cut length, 2 flute	RE 0.5–7.5	◎	○			○	○	○	○	J252
	2	For Copper Electrodes	CRN	CRN2MB	Ball nose, Medium cut length, 2 flute, For copper electrodes	RE 0.2–6							◎	○	J230

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
	2	For Hard Brittle Materials	DC	DC2SB	Ball nose, Short cut length, 2 flute, For hard brittle materials	RE 0.1–3	Cemented Carbide : ◎ Alumina / Zirconia : ○ Silicon Carbide / Nitride : ○ Quartz Glass : ○								J238
	2	For Graphite	DF	DF2MB	Ball nose, Medium cut length, 2 flute, For graphite	RE 3–6	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J244
	2	For Aluminium Alloys	DLC	DLC2MB	Ball nose, Medium cut length, 2 flute	RE 0.1–10	GFRP : ○ CFRP : ○						○	◎	J242
	3	For High Efficiency Machining	VC	VC3MB	Ball nose end mill, Medium cut length, 3 flute	RE 1–10	○	◎	○		○	○			J268
	4	For Hardened Steels	VF	VF4MB	Ball nose, Medium cut length, 4 flute	RE 0.5–6		○	◎	◎					J272
	4	For Difficult-to-cut Materials	VQ	VQ4SVB	Ball nose, Medium cutting length, 4 flute	RE 1–6	◎	◎			◎	◎	○		J270
LONG NECK BALL															
	2	General Use	MS+	MP2XLB	End mill, Short cut length, 2 flute, Long neck	RE 0.05–3	◎	◎	◎		○	○	○		J202
	2	For Hardened Steels	CBN	CBN2XLB	Ball nose, Short cut length, 2 flute, Long neck	RE 0.2–1		◎	◎	◎					J236
	2	For Profiling of Special Geometry	VF	VF2WB	Wide ball nose, Medium cut length, 2 flute	RE 1–3	○	○	○		◎	◎			J219
	2	For Deep Slotting of Hardened Steels	VF	VF2XLBS	Ball nose, Medium cut length, 2 flute, Short shank	RE 0.2–1	○	◎	◎	◎					J220
	2	For Deep Slotting of Hardened Steels	VF	VF2XLB	Ball nose, 2 flute, Long neck	RE 0.1–3	○	◎	◎	◎					J222
	2	For Copper Electrodes	CRN	CRN2XLB	Ball nose, Medium cut length, 2 flute, Long neck, For copper electrodes	RE 0.1–3							◎	○	J232
	2	For Hard Brittle Materials	DC	DC2XLB	Ball nose, Short cut length, 2 flute, For hard brittle materials	RE 0.1–3	Cemented Carbide : ◎ Alumina / Zirconia : ○ Silicon Carbide / Nitride : ○ Quartz Glass : ○								J240
	2	For Graphite	DF	DF2XLB	Ball nose, Medium cut length, 2 flute, Long neck, For graphite	RE 0.1–3	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J246
	2	For Graphite	DF	NEW DF2XLBF	Ball nose, Medium cut length, 2 flute, Long neck, For graphite	RE 0.3–1.5	Graphite : ◎ Zirconia : ◎ Rigid Composite Resin : ◎ Machineable Ceramics : ○						◎	○	J250

END MILLS SELECTION CHART CARBIDE(By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
TAPER NECK BALL															
	2	For Deep Slotting	VC	VCXB	Ball nose taper end mill, Medium cut length, Taper neck	RE 0.5–6	○	◎	○		○	○			J228
	3	For Deep Slotting / General Use	MS+	MP3XB	Ball nose, 3 flute, Taper neck	RE 0.5–6	◎	◎	◎		○	○	○		J254
	3	For Deep Slotting / Hardened Steels	VF	VF3XB	Ball nose, Medium cut length, 3 flute, Taper neck	RE 0.4–2.5	○	◎	◎	◎					J260
	3	For Graphite	DF	DF3XB	Ball nose, Medium cut length, 3 flute, Taper neck, For graphite	RE 0.5–2	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J266
RADIUS															
	2	General Use	MS	MS2MRB	Corner radius end mill, Medium cut length, 2 flute	DC 1–12	◎	◎	○		○	○	○		J274
	2	For Copper Electrodes	CRN	CRN2MRB	Corner radius, Medium cut length, 2 flute, For copper electrodes	DC 6–12							◎	○	J277
	3	For Aluminium Alloys	UWC	C3SARB	Corner radius, Short cut length, 3 flute, For aluminium alloy	DC 12–25								◎	J282
	2 4	For High-Precision Machining	VC	VCPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision	DC 0.6–12	○	◎	◎	○	○	○			J318
	4	General Use	MS+	MPMHVRB	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎	○		◎	○	○		J284
	4	For High Efficiency Machining	VF	VFHVRB	4 flute, Corner radius, Short cut length,Irregular helix flutes	DC 1–16	◎	◎	◎	○	○	○			J306
	4	For High Feed Machining	VC	VCHFRB	Corner radius, Short flute length, 4 flute, High feed machining	DC 2–16	○	◎	◎	○					J328
	4	General Use	MS	MS4MRB	Corner radius end mill, Medium cut length, 4 flute	DC 3–20	◎	◎	○		○	○	○		J294
	4	General Use	VC	VC4SRB	Corner radius end mill, Short cut length, 4 flute	DC 4–12	○	◎	○		○	○			J324
	4	General Use	VC	VC4JRB	Corner radius end mill, Semi long cut length, 4 flute	DC 3–20	○	◎	○		○	○			J326
	4	For Difficult-to-cut Materials	VC	VCMHDRB	Corner radius end mill, Medium cut length, 4 flute, High helix angle	DC 2–25	○	◎	◎		○	○			J332

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
	4	For Difficult-to-cut Materials	VQ	VQMHVRB	Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes	DC 2–20	◎	◎			◎	◎	○		J297
	4	For Difficult-to-cut Materials	VQ	VQMHVRBF	Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes (for finishing)	DC 6–16	◎	◎			◎	◎	○		J302
	4	For Difficult-to-cut Materials	VF	VFMHVRBCH	Corner radius end mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J304
	4 6	For Hardened Steels	VF	VFFDRB	Multi-task corner radius end mill for impact miracle high speed cutting	DC 3–12		○	◎	◎					J316
	6	For Hardened Steels	VF	VFSDRB	Corner radius end mill, 6 flute (S)	DC 3–12		○	◎	◎					J346
	6	For Hardened Steels	VF	VFMDRB	Corner radius, Medium cut length, 6 flute, For hardened materials	DC 3–20		○	◎	◎					J348
	6	For Difficult-to-cut Materials	VF	VF6MHVRB	Corner radius, Medium cut length, 6 flute, Irregular helix flutes	DC 6–20	○	○			◎	◎			J344
	6	For Difficult-to-cut Materials	VQ	NEW VQ6MHVRBCH	Corner radius end mill, Medium cut length, 6 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 10–20	○	○			◎	◎	○		J342
	5	For Difficult-to-cut Materials	VQ	NEW VQT5MVRB	Corner radius, Medium cut length, 5 flute, Irregular helix flutes, With coolant hole	DC 16,20,25					◎	◎			J340
	8	For Difficult-to-cut Materials	VF	VF8MHVRBCH	Corner radius end mill, Medium cut length, 8 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J350
	4	For Heat Resistant Alloy	CERAMIC	CE4SRB	Corner radius end mill, short cut length, 4 flute	DC 6–12						◎			J338
	6	For Heat Resistant Alloy	CERAMIC	CE6SRB	Corner radius end mill, short cut length, 6 flute	DC 6–12						◎			J338

END MILLS SELECTION CHART CARBIDE(By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
LONG NECK CORNER RADIUS															
	2	For Hardened Steels	CBN	CBN2XLRB	Corner radius end mill, Medium cut length, 2 flute, Long neck	DC 0.5–2		◎	◎	◎					J280
	2	For Copper Electrodes	CRN	CRN2XLRB	Corner radius, Medium cut length, 2 flute, For copper electrodes	DC 0.5–6							◎	○	J278
	2 4	For Graphite	DF	DFPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision, For graphite	DC 0.5–12	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J335
	2 4	General Use	MS+	MPXLRB	Corner radius, short cut length, long neck	DC 0.2–6	◎	◎	◎		○	○	○		J288
TAPER NECK RADIUS															
	2 4	For High-Precision Machining	VC	VCPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision	DC 1.5–12	○	◎	◎	○	○	○			J322
	4	For High Efficiency Machining	VF	VFHVRB	4 flute, Corner radius, Short cut length,Irregular helix flutes	DC 1–12	◎	◎	◎	○	○	○			J312
	4	For High Feed Machining	VC	VCHFRB	Corner radius, Short flute length, 4 flute, High feed machining	DC 2–12	○	◎	◎	○					J329
TAPER BALL															
	4	For Hardened Steels	VC	VC4STB	Ball nose taper end mill, Short cut length, 4 flute	RE 0.3–4		○	◎	◎	○	○			J352
	4	For Aluminium Alloys	UWC	C4LATB	Ball nose taper end mill, Long cut length, 4 flute, For aluminum impellers	RE 0.5–2								◎	J356
BARREL ENDMILL															
	6	For Profiling of Special Geometry	VQ	NEW VQT6UR	Barrel, Medium cut length, 6 flute	DC 8–12					○	◎		○	J358

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
ROUGHING															
	3 4	For Difficult-to-cut Materials	VQ	VQSVR	Roughing end mill, Short cut length, 3–4 flute, Irregular helix flutes	DC 3–20	◎	◎			◎	◎	○		J362
	3 4	For Difficult-to-cut Materials	VF	VFSFPR	Roughing end mill, Short cut length, 3–4 flute	DC 3–20	◎	◎			◎	◎			J365
	4	For Difficult-to-cut Materials	VF	VFMFPR	Roughing end mill, Medium cut length, 4 flute	DC 5–20	○	○			◎	◎			J368
	4	For Difficult-to-cut Materials	VF	VFSFPRCH	Roughing end mill, Short cut length, 4 flute, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J367
	6	For Difficult-to-cut Materials	VF	VF6SVRCH	Roughing end mill, Short cut length, 6 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J369
	3	For Aluminium Alloys	UWC	CSRA	Roughing end mill, Short cut length, 3 flute, For aluminium alloy	DC 10–25								◎	J372
	3	For Aluminium Alloys	UWC	CMRA	Roughing end mill, Medium cut length, 3 flute, For aluminium alloy	DC 3–25								◎	J374
CORNER RADIUS, ROUGHING															
	3	For Aluminium Alloys	UWC	CSRARB	Corner radius roughing end mill, Short cut length, 3 flute, For aluminium alloy	DC 10–25								◎	J370
CHAMFER CUTTER															
	2	For Chamfering	VC	VC2C	Chamfer cutter, 2 flute	DC 2–12	◎	◎	○		◎	◎	○	○	J082

END MILLS SELECTION CHART CARBIDE (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
MS PLUS END MILL SERIES															
General Use	SQUARE	4	MS+	MPMHV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–22	◎	◎	○		◎	○	○		J130
			MS+	MPJHV	End mill, Semi long cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎	○		◎	○	○		J134
	BALL	2	MS+	MP2SSB	Ball nose, Short cut length, 2 flute, Short shank	RE 0.1–6	◎	◎	◎		○	○	○		J196
			MS+	MP2SB	Ball nose, Short cut length, 2 flute	RE 0.1–6	◎	◎	◎		○	○	○		J197
			MS+	MP2MB	Ball nose, Medium cutting length, 2 flute	RE 0.25–6	◎	◎	◎		○	○	○		J198
			MS+	MP2SDB	Ball nose, Short cut length, 2 flute, High strength	RE 0.5–6	○	◎	◎						J200
	LONG NECK BALL		MS+	MP2XLB	End mill, Short cut length, 2 flute, Long neck	RE 0.05–3	◎	◎	◎		○	○	○		J202
	TAPER NECK BALL	3	MS+	MP3XB	Ball nose, 3 flute, Taper neck	RE 0.5–6	◎	◎	◎		○	○	○		J254
	RADIUS	4	MS+	MPMHVRB	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎	○		◎	○	○		J284
	LONG NECK CORNER RADIUS	2 4	MS+	MPXLRB	Corner radius, short cut length, long neck	DC 0.2–6	◎	◎	◎		○	○	○		J288
MSTAR END MILL SERIES															
General Use	SQUARE	2	MS	MS2SS	End mill, Short cut length, 2 flute	DC 0.1–12	◎	◎	○		○	○	○		J048
			MS	MS2MS	End mill, Medium cut length, 2 flute	DC 0.2–20	◎	◎	○		○	○	○		J049
			MS	MS2MD	End mill, Medium cut length, 2 flute, Strong geometry type	DC 1–12	◎	◎	○		○	○			J052
			MS	MS2JS	End mill, Semi long cut length, 2 flute	DC 0.1–12	◎	◎	○		○	○	○		J054
			MS	MS2LS	End mill, Long cut length, 2 flute	DC 0.2–12	◎	◎	○		○	○	○		J056
		3	MS	MSMHZD	Slotting, Medium cut length, 3 flute	DC 1–20	◎	◎	○		○	○	○		J112
		4	MS	MS4SC	End mill, Short cut length, 4 flute	DC 1–12	◎	◎	○		○	○	○		J142

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
General Use	SQUARE	4	MS	MS4MC	End mill, Medium cut length, 4 flute	DC 1–20	◎	◎	○		○	○	○		J144
			MS	MS4JC	End mill, Semi long cut length, 4 flute	DC 1–12	◎	◎	○		○	○	○		J146
			MS	MSSHD	High power, Short cut length, 4 flute	DC 3–20	◎	◎	○		○	○	○		J136
			MS	MSMHD	High power, Medium cut length, 4 flute	DC 2–25	◎	◎	○		○	○	○		J137
			MS	MSJHD	High power, Semi long cut length, 4 flute	DC 2–20	◎	◎	○		○	○	○		J140
For Small Automatic Lathes		2	MS	MS2ES	End mill, 2 flute, For small automatic lathes	DC 3–12	◎	◎	○		○	○	○		J066
		3	MS	MS3ES	End mill, 3 flute, For small automatic lathes	DC 3–12	◎	◎	○		○	○	○		J114
		4	MS	MS4EC	End mill, 4 flute, For small automatic lathes	DC 3–14	◎	◎	○		○	○	○		J152
For Deep Slotting	LONG NECK SQUARE	2	MS	MS2XL	End mill, Short cut length, 2 flute, Long neck	DC 0.2–6	◎	◎	○		○	○	○		J058
			MS	MS2XL6	End mill, Short cut length, 2 flute, 6mm shank	DC 0.3–2.5	◎	◎	○		○	○	○		J062
		4	MS	MS4XL	End mill, Short cut length, 4 flute, Long neck	DC 1–10	◎	◎	○		○	○	○		J148
General Use	RADIUS	2	MS	MS2MRB	Corner radius end mill, Medium cut length, 2 flute	DC 1–12	◎	◎	○		○	○	○		J274
		4	MS	MS4MRB	Corner radius end mill, Medium cut length, 4 flute	DC 3–20	◎	◎	○		○	○	○		J294

END MILLS SELECTION CHART CARBIDE (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
SMART MIRACLE END MILL SERIES															
For Difficult-to-cut Materials	SQUARE	3	VQ	VQMHZV	End mill, Medium cutting length, 3 flute for drilling and slotting	DC 1–20	◎	◎			◎	◎	○		J116
For Difficult-to-cut Materials	SQUARE	3	VQ	VQMHZVOH	End mill, Medium cutting length, 3 flute for drilling and slotting with internal through coolant holes	DC 6–16	◎	◎			◎	◎	○		J122
For Difficult-to-cut Materials	SQUARE	4	VQ	VQMHV	End mill, Medium cutting length, 4 flute, Irregular helix flutes	DC 1–25	◎	◎			◎	◎	○		J154
For Difficult-to-cut Materials	SQUARE	6	VQ	NEW VQ6MHVCH	End mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple internal through coolant	DC 10–20	○	○			◎	◎	○		J188
For Difficult-to-cut Materials	SQUARE	4	VQ	VQJHV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 1–20	◎	◎			◎	◎	○		J158
For Difficult-to-cut Materials	LONG NECK SQUARE	3 4	VQ	VQXL	End mill, Short cut length, 3–4 flute, Long neck	DC 0.2–1	◎	◎			◎	◎	○		J160
For Difficult-to-cut Materials	BALL	4	VQ	VQ4SVB	Ball nose, Medium cutting length, 4 flute	RE 1–6	◎	◎			◎	◎	○		J270
For Difficult-to-cut Materials	RADIUS	4	VQ	VQMHVRB	Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes	DC 2–20	◎	◎			◎	◎	○		J297
For Difficult-to-cut Materials	RADIUS	4	VQ	VQMHVRBF	Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes (for finishing)	DC 6–16	◎	◎			◎	◎	○		J302
For Difficult-to-cut Materials	RADIUS	5	VQ	NEW VQT5MVRB	Corner radius, Medium cut length, 5 flute, Irregular helix flutes, With coolant hole	DC 16,20,25					◎	◎			J340
For Difficult-to-cut Materials	RADIUS	6	VQ	NEW VQ6MHVRBCH	End mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple internal through coolant	DC 10–20	○	○			◎	◎	○		J342
For Barrel	BARREL	6	VQ	NEW VQT6UR	Barrel, Medium cut length, 6 flute	DC 8–12					○	◎		○	J358
For Difficult-to-cut Materials	ROUGHING	3 4	VQ	VQSVR	Roughing end mill, Short cut length, 3–4 flute, Irregular helix flutes	DC 3–20	◎	◎			◎	◎	○		J362
IMPACT MIRACLE END MILL SERIES															
For Hardened Steels	SQUARE	2	VF	VF2MD	End mill, Medium cut length, 2 flute, For hardened materials	DC 0.5–6		○	◎	◎					J068
For Hardened Steels	SQUARE	2	VF	VF2MV	End mill, Medium cut length, 2 flute, Irregular helix flutes	DC 0.5–6		○	◎	◎					J070
For Hardened Steels	SQUARE	4	VF	VF4MD	End mill, Medium cut length, 4 flute, For hardened materials	DC 1–20		○	◎	◎					J164
For Hardened Steels	SQUARE	4	VF	VF4MV	End mill, Medium cut length, 4 flute, Irregular helix flutes	DC 6–20		○	◎	◎					J166

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
For Hardened Steels	SQUARE	4 6	VF	VFSD	End mill, Short cut length, For hardened materials	DC 1–12		○	◎	◎					J190
			VF	VFMD	End mill, Medium cut length, For hardened materials	DC 1–25		○	◎	◎					J191
For Profiling of Special Geometry	LONG NECK BALL	2	VF	VF2WB	Wide ball nose, Medium cut length, 2 flute	RE 1–3	○	○	○		◎	◎			J219
For Hardened Steels	BALL	4	VF	VF4MB	Ball nose, Medium cut length, 4 flute	RE 0.5–6		○	◎	◎					J272
	RADIUS	4 6	VF	VFFDRB	Multi-task corner radius end mill for impact miracle high speed cutting	DC 3–12		○	◎	◎					J316
		6	VF	VFSDRB	Corner radius end mill, 6 flute (S)	DC 3–12		○	◎	◎					J346
			VF	VFMDRB	Corner radius, Medium cut length, 6 flute, For hardened materials	DC 3–20		○	◎	◎					J348
For Deep Slotting of Hardened Steels	LONG NECK SQUARE	2	VF	VF2XL	End mill, 2 flute, Long neck	DC 0.1–3	○	◎	◎	◎					J072
	LONG NECK BALL		VF	VF2XLBS	Ball nose, Medium cut length, 2 flute, Short shank	RE 0.2–1	○	◎	◎	◎					J220
			VF	VF2XLB	Ball nose, 2 flute, Long neck	RE 0.1–3	○	◎	◎	◎					J222
	TAPER NECK BALL	3	VF	VF3XB	Ball nose, Medium cut length, 3 flute, Taper neck	RE 0.4–2.5	○	◎	◎	◎					J260
For Difficult-to-cut Materials	ROUGHING	3 4	VF	VFSFPR	Roughing end mill, Short cut length, 3–4 flute	DC 3–20	◎	◎			◎	◎			J365
		4	VF	VFMFPR	Roughing end mill, Medium cut length, 4 flute	DC 5–20	○	○			◎	◎			J368
IMPACT MIRACLE BALL NOSE HIGH POWER END MILL SERIES															
For High Feed Machining	BALL	2	VF	VF2SDB	Ball nose, Short cut length, 2 flute, Strong geometry type	RE 0.5–10	○	◎	◎	○					J216
			VF	VF2SDBL	Ball nose, Short cut length, 2 flute, Strong geometry type, Long shank	RE 0.5–10	○	◎	◎	○					J217
IMPACT MIRACLE CORNER RADIUS END MILL SERIES FOR HIGH EFFICIENCY MACHINIG, IRREGULAR HELIX															
For High Efficiency Machining	RADIUS	4	VF	VFHVRB	4 flute, Corner radius, Short cut length,Irregular helix flutes	DC 1–16	◎	◎	◎	○	○	○			J306
	TAPER NECK RADIUS		VF	VFHVRB	4 flute, Corner radius, Short cut length,Irregular helix flutes	DC 1–12	◎	◎	◎	○	○	○			J312

END MILLS SELECTION CHART CARBIDE (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
IMPACT MIRACLE END MILL SERIES FOR DIFFICULT TO CUT MATERIALS, IRREGULAR HELIX															
For Difficult-to-cut Materials	SQUARE	6	VF	VF6MHV	End mill, Medium cut length, 6 flute, Irregular helix flutes	DC 6–20	○	○			◎	◎			J189
For Difficult-to-cut Materials	R ADIUS	6	VF	VF6MHVRB	Corner radius, Medium cut length, 6 flute, Irregular helix flutes	DC 6–20	○	○			◎	◎			J344
IMPACT MIRACLE REVOLUTION															
For Hardened Steels	BALL	2	VFR	VFR2SB	Ball nose, Short cut length, 2 flute	RE 0.1–10		○	◎	◎					J212
For Hardened Steels	BALL	2	VFR	NEW VFR2SSB	Ball nose, Short cut length, 2 flute, Short shank	RE 0.5–6		○	◎	◎					J210
For Hardened Steels	BALL	2	VFR	VFR2SBF	Ball nose, Short cut length, 2 flute, For Mirror finish cutting	RE 0.5–3		○	◎	◎					J214
COOL STAR END MILL SERIES															
For Difficult-to-cut Materials	SQUARE	4	VF	VFMHVCH	End mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J167
For Difficult-to-cut Materials	SQUARE	8	VF	VF8MHVCH	End mill, Medium cut length, 8 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J194
For Difficult-to-cut Materials	RADIUS	4	VF	VFMHVRBCH	Corner radius end mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J304
For Difficult-to-cut Materials	RADIUS	8	VF	VF8MHVRBCH	Corner radius end mill, Medium cut length, 8 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J350
For Difficult-to-cut Materials	ROUGHING	4	VF	VFSFPRCH	Roughing end mill, Short cut length, 4 flute, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J367
For Difficult-to-cut Materials	ROUGHING	6	VF	VF6SVRCH	Roughing end mill, Short cut length, 6 flute, Irregular helix flutes, with multiple internal through coolant holes	DC 16,20	○	○			◎	◎			J369
MIRACLE END MILL SERIES															
General Use	SQUARE	2	VC	VC2SS	End mill, Short cut length, 2 flute	DC 0.3–16	○	◎	○		○	○			J075
General Use	SQUARE	2	VC	VC2MS	End mill, Medium cut length, 2 flute	DC 0.3–25	○	◎	○		○	○			J077
General Use	SQUARE	2	VC	VC2JS	End mill, Semi long cut length, 2 flute	DC 1–25	○	◎	○		○	○			J080
General Use	SQUARE	4	VC	VC4MC	End mill, Medium cut length, 4 flute	DC 2–25	○	◎	○		○	○			J168
General Use	SQUARE	4	VC	VC4JC	End mill, Semi long cut length, 4 flute	DC 3–25	○	◎	○		○	○			J170

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
For High Efficiency Machining	BALL	3	VC	VC3MB	Ball nose end mill, Medium cut length, 3 flute	RE 1–10	○	◎	○		○	○			J268
For Deep Slotting	TAPER NECK BALL	2	VC	VCXB	Ball nose taper end mill, Medium cut length, Taper neck	RE 0.5–6	○	◎	◎	○	○	○			J228
General Use	RADIUS	4	VC	VC4SRB	Corner radius end mill, Short cut length, 4 flute	DC 4–12	○	◎	○		○	○			J324
			VC	VC4JRB	Corner radius end mill, Semi long cut length, 4 flute	DC 3–20	○	◎	○		○	○			J326
For Chamfering	CHAMFERING	2	VC	VC2C	Chamfer cutter, 2 flute	DC 2–12	◎	◎	○		◎	◎	○	○	J082
MIRACLE ORBIT END MILL SERIES															
For High-Precision Machining	RADIUS	2 4	VC	VCPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision	DC 0.6–12	○	◎	◎	○	○	○			J318
	TAPER NECK RADIUS		VC	VCPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision	DC 1.5–12	○	◎	◎	○	○	○			J322
MIRACLE CORNER RADIUS END MILL SERIES FOR HIGH FEED MACHINING															
For High Feed Machining	RADIUS	4	VC	VCHFRB	Corner radius, Short flute length, 4 flute, High feed machining	DC 2–16	○	◎	◎	○					J328
	TAPER NECK RADIUS		VC	VCHFRB	Corner radius, Short flute length, 4 flute, High feed machining	DC 2–12	○	◎	◎	○					J329
MIRACLE END MILL SERIES FOR HIGH HARDNESS STEEL															
For Hardened Steels	SQUARE	4 6	VC	VCMDSC	End mill, Medium cut length, 4–6 flute	DC 0.5–3		○	◎	◎					J172
		6	VC	VCLD	End mill, Long cut length, 6 flute	DC 6–25		○	◎	◎					J193
	TAPER BALL	4	VC	VC4STB	Ball nose taper end mill, Short cut length, 4 flute	RE 0.3–4		○	◎	◎	○	○			J352
MIRACLE END MILL SERIES FOR DIFFICULT TO CUT MATERIALS															
For Difficult-to-cut Materials	SQUARE	3 4	VC	VCMH	End mill, Medium cut length, 3–4 flute, High helix angle	DC 3–25	○	○	○		◎	◎			J126
	RADIUS	4	VC	VCMHDRB	Corner radius end mill, Medium cut length, 4 flute, High helix angle	DC 2–25	○	◎	◎		○	○			J332

END MILLS SELECTION CHART CARBIDE (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
END MILL SERIES FOR SLOTTING															
For Key Way Slotting	SQUARE	2	MS	SED2KPG	End mill, Medium cut length, 2 flute, + Tolerance	DC 2–16	◎	◎			○	○			J092
			MS	SED2KMG	End mill, Medium cut length, 2 flute, + Tolerance	DC 2–16	◎	◎			○	○			J091
CRN END MILL SERIES															
For Copper Electrodes	SQUARE	2	CRN	CRN2MS	End mill, Medium cut length, 2 flute, For copper electrodes	DC 0.2–12							◎	○	J084
	LONG NECK SQUARE		CRN	CRN2XL	End mill, Medium cut length, 2 flute, Long neck, For copper electrodes	DC 0.2–6							◎	○	J086
	SQUARE	4	CRN	CRN4JC	End mill, Semi long cut length, 4 flute, For copper electrodes	DC 3–12							◎	○	J174
	BALL	2	CRN	CRN2MB	Ball nose, Medium cut length, 2 flute, For copper electrodes	RE 0.2–6							◎	○	J230
	LONG NECK BALL		CRN	CRN2XLB	Ball nose, Medium cut length, 2 flute, Long neck, For copper electrodes	RE 0.1–3							◎	○	J232
	RADIUS		CRN	CRN2MRB	Corner radius, Medium cut length, 2 flute, For copper electrodes	DC 6–12							◎	○	J277
	LONG NECK CORNER RADIUS		CRN	CRN2XLRB	Corner radius, Medium cut length, 2 flute, For copper electrodes	DC 0.5–6							◎	○	J278
DC END MILL SERIES															
For Hard Brittle Materials	BALL	2	DC	DC2SB	Ball nose, Short cut length, 2 flute, For hard brittle materials	RE 0.1–3	Cemented carbide : ◎ Alumina / Zirconia : ○ Silicon carbide / nitride : ○ Quartz glass : ○								J238
	LONG NECK BALL		DC	DC2XLB	Ball nose, Short cut length, 2 flute, For hard brittle materials	RE 0.1–3									J240
DFC END MILL SERIES															
For CFRP	SQUARE	4	DFC	DFC4JC	Diamond coating endmill, 4 flute	DC 6–12	CFRP : ◎								J180
	SQUARE WITH CROSS-NICK	10 12	DFC	DFCJRT	Diamond coating endmill with cross-nick	DC 6–12									J195

★ DC : Cutting Diameter
★ RE : Ball Nose End Mill Radius

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
DF END MILL SERIES															
For Graphite	SQUARE	4	DF	DF4JC	End mill, Semi long cut length, 4 flute, For graphite	DC 3–12	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J176
For Graphite	LONG NECK SQUARE	4	DF	DF4XL	End mill, Long neck, 4 flute, For graphite	DC 1–12							◎	○	J177
For Graphite	BALL	2	DF	DF2MB	Ball nose, Medium cut length, 2 flute, For graphite	RE 3–6							◎	○	J244
For Graphite	LONG NECK BALL	2	DF	DF2XLB	Ball nose, Medium cut length, 2 flute, Long neck, For graphite	RE 0.1–3							◎	○	J246
For Graphite	LONG NECK BALL	2	DF	NEW DF2XLBF	Ball nose, Medium cut length, 2 flute, Long neck, For graphite	RE 0.3–1.5	Graphite : ◎ Zirconia : ◎ Rigid Composite Resin : ◎ Machineable Ceramics : ○						◎	○	J250
For Graphite	TAPER NECK BALL	3	DF	DF3XB	Ball nose, Medium cut length, 3 flute, Taper neck, For graphite	RE 0.5–2	Graphite : ◎ GFRP/CFRP : ○ Machineable Ceramics : ○						◎	○	J266
For Graphite	LONG NECK CORNER RADIUS	2 4	DF	DFPSRB	Corner radius end mill, Short cut length, 2–4 flute, High precision, For graphite	DC 0.5–12							◎	○	J335
DLC END MILL SERIES															
For Aluminium Alloys	SQUARE	2	DLC	DLC2MA	Medium cut length, 2 flute	DC 1–20	GFRP : ○ CFRP : ○						○	◎	J089
For Aluminium Alloys	BALL	2	DLC	DLC2MB	Ball nose, Medium cut length, 2 flute	RE 0.1–10							○	◎	J242
ALIMASTER END MILL SERIES															
For Aluminium Alloys	SQUARE	2	UWC	C2SA	End mill, Short cut length, 2 flute, For aluminium alloy	DC 3–20								◎	J102
For Aluminium Alloys	SQUARE	2	UWC	C2MA	End mill, Medium cut length, 2 flute, For aluminium alloy	DC 1–20								◎	J104
For Aluminium Alloys	SQUARE	2	UWC	C2LA	End mill, Long cut length, 2 flute, For aluminium alloy	DC 1–20								◎	J106
For Aluminium Alloys	SQUARE	2	UWC	C2MHA	End mill, Medium cut length, 2 flute, For aluminium alloy	DC 3–25								◎	J108
For Aluminium Alloys	SQUARE	3	UWC	C3SA	End mill, Short cut length, 3 flute, For aluminium alloy	DC 10–26								◎	J128
For Aluminium Alloys	TAPER BALL	4	UWC	C4LATB	Ball nose taper end mill, Long cut length, 4 flute, For aluminum impellers	RE 0.5–2								◎	J356
For Aluminium Alloys	RADIUS	3	UWC	C3SARB	Corner radius, Short cut length, 3 flute, For aluminium alloy	DC 12–25								◎	J282

END MILLS SELECTION CHART CARBIDE (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
ALIMASTER END MILL SERIES															
For Aluminium Alloys	ROUGHING	3	UWC	CSRA	Roughing end mill, Short cut length, 3 flute, For aluminium alloy	DC 10–25								◎	J372
For Aluminium Alloys	ROUGHING	3	UWC	CMRA	Roughing end mill, Medium cut length, 3 flute, For aluminium alloy	DC 3–25								◎	J374
For Aluminium Alloys	ROUGHING RADIUS	3	UWC	CSRARB	Corner radius roughing end mill, Short cut length, 3 flute, For aluminium alloy	DC 10–25								◎	J370
CARBIDE END MILL SERIES															
General Use	SQUARE	2	UWC	C2SS	End mill, Short cut length, 2 flute	DC 0.4–6	○	○			○	○	○	○	J094
General Use	SQUARE	2	UWC	C2MS	End mill, Medium cut length, 2 flute	DC 1–20	○	○			○	○	○	○	J095
General Use	SQUARE	2	UWC	C2JS	End mill, Semi long cut length, 2 flute	DC 1–25	○	○			○	○	○	○	J099
General Use	SQUARE	2	UWC	C2LS	End mill, Long cut length, 2 flute	DC 1–20	○	○			○	○	○	○	J100
General Use	SQUARE	4	UWC	C4MC	End mill, Medium cut length, 4 flute, Center cutting	DC 3–20	○	○			○	○	○	○	J181
General Use	SQUARE	4	UWC	C4JC	End mill, Semi long cut length, 4 flute, Center cutting	DC 3–25	○	○			○	○	○	○	J182
General Use	SQUARE	4	UWC	C4LC	End mill, Long cut length, 4 flute, Center cutting	DC 3–20	○	○			○	○	○	○	J183
General Use	BALL	2	UWC	C2MB	Ball nose end mill, Medium cut length, 2 flute	RE 0.5–7.5	◎	○			○	○	○	○	J252
High Helix	SQUARE	2	UWC	SEE2L	End mill, Long cut length, 2 flute	DC 3–20	◎	○			○	○	○	○	J110
High Helix	SQUARE	4	UWC	SEE4L	End mill, Long cut length, 4 flute	DC 3–25	○	○			○	○	○	○	J186
For Aluminium Alloys	SQUARE	4	UWC	SEG4SA	End mill, Medium cut length, 4 flute, Irregular spiral helix angle, For aluminium alloy	DC 6–25							○	◎	J185

* DC : Cutting Diameter
* RE : Ball Nose End Mill Radius

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
CBN END MILL SERIES															
For Hardened Steels	SQUARE	1	CBN	GBE	End mill, 1 flute, Brazed type (CBN)	DC 6–12				◎					J376
For Hardened Steels	LONG NECK BALL	2	CBN	CBN2XLB	Ball nose, Short cut length, 2 flute, Long neck	RE 0.2–1		◎	◎	◎					J236
For Hardened Steels	LONG NECK CORNER RADIUS	2	CBN	CBN2XLRB	Corner radius end mill, Medium cut length, 2 flute, Long neck	DC 0.5–2		◎	◎	◎					J280
CERAMIC END MILLS															
For Heat Resistant Alloy	RADIUS	4	CERAMIC	CE4SRB	Corner radius end mill, short cut length, 4 flute	DC 6–12						◎			J338
For Heat Resistant Alloy	RADIUS	6	CERAMIC	CE6SRB	Corner radius end mill, short cut length, 6 flute	DC 6–12						◎			J338

END MILLS SELECTION CHART HSS (By Shape)

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
SQUARE															
	1	For Aluminium Sashes	HSS	1MA	End mill, Medium cut length, 1 flute	DC 3–8								◎	J378
	1	For Aluminium Sashes	HSS	1LA	End mill, Long cut length, 1 flute	DC 4–12								◎	J379
	2	General Use	V	VA2SS	End mill, Short cut length, 2 flute	DC 3–20	◎	○			○	○			J380
	2	General Use	V	VA2MS	End mill, Medium cut length, 2 flute	DC 3–40	◎	○			○	○			J382
	2	General Use	CO HSS	2SS	End mill, Short cut length, 2 flute	DC 0.5–20	◎	○			○	○		○	J384
	2	General Use	CO HSS	2MS	End mill, Medium cut length, 2 flute	DC 1–60	◎	○			○	○		○	J386
	2	General Use	CO HSS	2LS	End mill, Long cut length, 2 flute	DC 1–40	◎	○			○	○		○	J388
	2	For Key Way Slotting	CO HSS	2MK	End mill, Short cut length, 2 flute, For key ways	DC 3–20	◎	○			○			○	J391
	2	For Aluminium Alloys	KHA S	S2SDA	End mill, Short cut length, 2 flute, For aluminium alloy	DC 3–20							○	◎	J392
	2 3 4	For Difficult-to-cut Materials	V	VAMH	End mill, Medium cut length, 2–4 flute	DC 5–30	◎	○			◎	○			J393
	4	General Use	V	VA4MC	End mill, Medium cut length, 4 flute	DC 3–30	◎	○			○	○			J396
	4	General Use	CO HSS	4MC	End mill, Medium cut length, 4 flute, Center cutting	DC 2.5–40	◎	○			○	○		○	J398
	4	General Use	CO HSS	4LC	End mill, Long cut length, 4 flute, Center cutting	DC 3–40	◎	○			○	○		○	J400

* DC : Cutting Diameter

Type	No. of Flutes	Applications, Features	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
ROUGHING															
	4 5 6	For Roughing	V	VASFPR	Roughing end mill, Short cut length, 4–6 flute, Fine pitch form	DC 5–50	◎	○			◎	○			J402
			V	VAMFPR	Roughing end mill, Medium cut length, 4–6 flute, Fine pitch form	DC 5–50	◎	○			◎	○			J404
			V	VAMR	Roughing end mill, Medium cut length, 4–6 flute	DC 5–50	◎	○			◎	○			J406
			CO HSS	MR	Roughing end mill, Medium cut length, 4–6 flute	DC 5–50	◎	○			○	○		○	J408

END MILLS SELECTION CHART HSS (By Series)

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
VIOLET END MILLS															
General Use	SQUARE	2	V	VA2SS	End mill, Short cut length, 2 flute	DC 3–20	◎	○			○	○			J380
General Use	SQUARE	2	V	VA2MS	End mill, Medium cut length, 2 flute	DC 3–40	◎	○			○	○			J382
General Use	SQUARE	4	V	VA4MC	End mill, Medium cut length, 4 flute	DC 3–30	◎	○			○	○			J396
For Difficult-to-cut Materials	SQUARE	2 3 4	V	VAMH	End mill, Medium cut length, 2–4 flute	DC 5–30	◎	○			◎	○			J393
For Roughing	ROUGHING	4 5 6	V	VASFPR	Roughing end mill, Short cut length, 4–6 flute, Fine pitch form	DC 5–50	◎	○			◎	○			J402
For Roughing	ROUGHING	4 5 6	V	VAMFPR	Roughing end mill, Medium cut length, 4–6 flute, Fine pitch form	DC 5–50	◎	○			◎	○			J404
For Roughing	ROUGHING	4 5 6	V	VAMR	Roughing end mill, Medium cut length, 4–6 flute	DC 5–50	◎	○			◎	○			J406
TWO-FLUTE END MILLS															
General Use	SQUARE	2	CO HSS	2SS	End mill, Short cut length, 2 flute	DC 0.5–20	◎	○			○	○		○	J384
General Use	SQUARE	2	CO HSS	2MS	End mill, Medium cut length, 2 flute	DC 1–60	◎	○			○	○		○	J386
General Use	SQUARE	2	CO HSS	2LS	End mill, Long cut length, 2 flute	DC 1–40	◎	○			○	○		○	J388
For Key Way Slotting	SQUARE	2	CO HSS	2MK	End mill, Short cut length, 2 flute, For key ways	DC 3–20	◎	○			○			○	J391
FOUR-FLUTE END MILLS															
General Use	SQUARE	4	CO HSS	4MC	End mill, Medium cut length, 4 flute, Center cutting	DC 2.5–40	◎	○			○	○		○	J398
General Use	SQUARE	4	CO HSS	4LC	End mill, Long cut length, 4 flute, Center cutting	DC 3–40	◎	○			○	○		○	J400

* DC : Cutting Diameter

Applications, Features	Type	No. of Flutes	Coating or Substrate	Product Code	Shape	Size Range	Work Material P: Carbon Steel, Alloy Steel, Cast Iron	P: Tool steel, Pre-hardened Steel, Hardened Steel	H: Hardened Steel(-55HRC)	H: Hardened Steel(55HRC-)	M: Austenitic Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
ROUGHING END MILLS															
For Roughing	ROUGHING	4 5 6	CQ HSS	MR	Roughing end mill, Medium cut length, 4—6 flute	DC 5−50	◎	○			○	○		○	J408
LIGHT ALLOY STEEL END MILLS															
For Aluminium Sashes	SQUARE	1	HSS	1MA	End mill, Medium cut length, 1 flute	DC 3−8								◎	J378
			HSS	1LA	End mill, Long cut length, 1 flute	DC 4−12								◎	J379
For Aluminium Alloys		2	KHA S	S2SDA	End mill, Short cut length, 2 flute, For aluminium alloy	DC 3−20							○	◎	J392

MS2SS

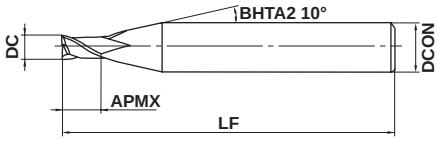
End mill, Short cut length, 2 flute

TOOL NEWS

30°

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



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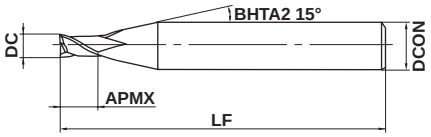
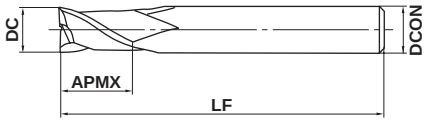


Type2



Type3

DC=0.1	DC>0.1			
0 - 0.010	0 - 0.020			
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2SSD0010	0.1	0.15	40	4	2	●	1
MS2SSD0020	0.2	0.3	40	4	2	●	2
MS2SSD0030	0.3	0.45	40	4	2	●	2
MS2SSD0040	0.4	0.6	40	4	2	●	2
MS2SSD0050	0.5	0.75	40	4	2	●	2
MS2SSD0060	0.6	0.9	40	4	2	●	2
MS2SSD0070	0.7	1.1	40	4	2	●	2
MS2SSD0080	0.8	1.2	40	4	2	●	2
MS2SSD0090	0.9	1.4	40	4	2	●	2
MS2SSD0100	1	1.5	40	4	2	●	2
MS2SSD0120	1.2	1.8	40	4	2	●	2
MS2SSD0150	1.5	2.3	40	4	2	●	2
MS2SSD0180	1.8	2.7	40	4	2	●	2
MS2SSD0200	2	3	40	4	2	●	2
MS2SSD0250	2.5	3.8	40	4	2	●	2
MS2SSD0300	3	4.5	45	6	2	●	2
MS2SSD0400	4	6	50	6	2	●	2
MS2SSD0500	5	7.5	50	6	2	●	2
MS2SSD0600	6	9	50	6	2	●	3
MS2SSD0700	7	10.5	60	8	2	●	2
MS2SSD0800	8	12	60	8	2	●	3
MS2SSD0900	9	13.5	70	10	2	●	2
MS2SSD1000	10	15	70	10	2	●	3
MS2SSD1100	11	16.5	75	12	2	●	2
MS2SSD1200	12	18	75	12	2	●	3

● : Inventory maintained in Japan.

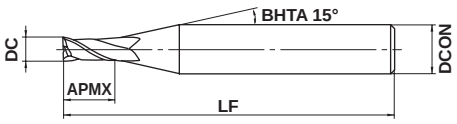
MS2MS

End mill, Medium cut length, 2 flute

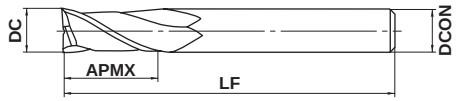
TOOL NEWS

UWC MS 30° DC<3 DC≥3

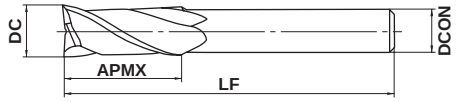
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2MSD0020	0.2	0.4	40	4	2	●	1
MS2MSD0030	0.3	0.6	40	4	2	●	1
MS2MSD0040	0.4	0.8	40	4	2	●	1
MS2MSD0050	0.5	1	40	4	2	●	1
MS2MSD0060	0.6	1.2	40	4	2	●	1
MS2MSD0070	0.7	1.4	40	4	2	●	1
MS2MSD0080	0.8	1.6	40	4	2	●	1
MS2MSD0090	0.9	1.8	40	4	2	●	1
MS2MSD0100	1	2	40	4	2	●	1
MS2MSD0110	1.1	2.2	40	4	2	●	1
MS2MSD0120	1.2	2.4	40	4	2	●	1
MS2MSD0130	1.3	2.6	40	4	2	●	1
MS2MSD0140	1.4	2.8	40	4	2	●	1
MS2MSD0150	1.5	3	40	4	2	●	1
MS2MSD0160	1.6	3.2	40	4	2	●	1
MS2MSD0170	1.7	3.4	40	4	2	●	1
MS2MSD0180	1.8	3.6	40	4	2	●	1
MS2MSD0190	1.9	3.8	40	4	2	●	1
MS2MSD0200	2	4	40	4	2	●	1
MS2MSD0210	2.1	4.2	40	4	2	●	1
MS2MSD0220	2.2	4.4	40	4	2	●	1
MS2MSD0230	2.3	4.6	40	4	2	●	1
MS2MSD0240	2.4	4.8	40	4	2	●	1
MS2MSD0250	2.5	5	40	4	2	●	1
MS2MSD0260	2.6	5.2	40	4	2	●	1
MS2MSD0270	2.7	5.4	40	4	2	●	1
MS2MSD0280	2.8	5.6	40	4	2	●	1
MS2MSD0290	2.9	5.8	40	4	2	●	1
MS2MSD0300	3	6	45	6	2	●	1
MS2MSD0310	3.1	6.2	45	6	2	●	1
MS2MSD0320	3.2	6.4	45	6	2	●	1
MS2MSD0330	3.3	6.6	45	6	2	●	1
MS2MSD0340	3.4	6.8	45	6	2	●	1
MS2MSD0350	3.5	7	45	6	2	●	1

MS2MS

End mill, Medium cut length, 2 flute

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2MSD0360	3.6	7.2	45	6	2	●	1
MS2MSD0370	3.7	7.4	45	6	2	●	1
MS2MSD0380	3.8	7.6	45	6	2	●	1
MS2MSD0390	3.9	7.8	45	6	2	●	1
MS2MSD0400	4	8	50	6	2	●	1
MS2MSD0410	4.1	8.2	50	6	2	●	1
MS2MSD0420	4.2	8.4	50	6	2	●	1
MS2MSD0430	4.3	8.6	50	6	2	●	1
MS2MSD0440	4.4	8.8	50	6	2	●	1
MS2MSD0450	4.5	9	50	6	2	●	1
MS2MSD0460	4.6	9.2	50	6	2	●	1
MS2MSD0470	4.7	9.4	50	6	2	●	1
MS2MSD0480	4.8	9.6	50	6	2	●	1
MS2MSD0490	4.9	9.8	50	6	2	●	1
MS2MSD0500	5	10	50	6	2	●	1
MS2MSD0510	5.1	10.2	50	6	2	●	1
MS2MSD0520	5.2	10.4	50	6	2	●	1
MS2MSD0530	5.3	10.6	50	6	2	●	1
MS2MSD0540	5.4	10.8	50	6	2	●	1
MS2MSD0550	5.5	11	50	6	2	●	1
MS2MSD0560	5.6	11.2	50	6	2	●	1
MS2MSD0570	5.7	11.4	50	6	2	●	1
MS2MSD0580	5.8	11.6	50	6	2	●	1
MS2MSD0590	5.9	11.8	50	6	2	●	1
MS2MSD0600	6	12	50	6	2	●	2
MS2MSD0650	6.5	13	60	8	2	●	1
MS2MSD0700	7	14	60	8	2	●	1
MS2MSD0750	7.5	15	60	8	2	●	1
MS2MSD0800	8	16	60	8	2	●	2
MS2MSD0850	8.5	17	70	10	2	●	1
MS2MSD0900	9	18	70	10	2	●	1
MS2MSD0950	9.5	19	70	10	2	●	1
MS2MSD1000	10	20	70	10	2	●	2
MS2MSD1100	11	22	75	12	2	●	1
MS2MSD1200	12	24	75	12	2	●	2
MS2MSD1600	16	32	90	16	2	●	2
MS2MSD1800	18	36	90	16	2	●	3
MS2MSD2000	20	40	100	20	2	●	2

● : Inventory maintained in Japan.

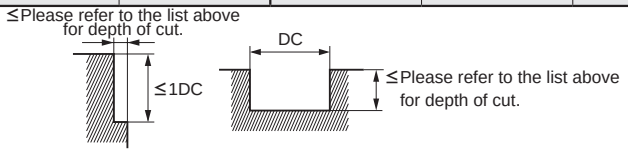
MS2SS
End mill, Short cut length, 2 flute

MS2MS
End mill, Medium cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45−55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.1	40000	40	0.001	40000	40	0.001
0.2	40000	100	0.002	40000	100	0.002
0.3	40000	200	0.005	40000	200	0.005
0.4	40000	600	0.01	40000	600	0.01
0.5	40000	1000	0.015	40000	960	0.015
0.6	40000	1200	0.02	40000	1200	0.02
0.7	40000	1400	0.02	40000	1400	0.02
0.8	40000	1600	0.03	40000	1600	0.03
0.9	40000	1800	0.04	40000	1600	0.04
1	40000	2000	0.06	32000	1600	0.06
1.5	40000	3000	0.12	32000	1900	0.08
2	30000	3000	0.18	24000	1900	0.10
2.5	24000	2600	0.25	19000	1600	0.13
3	20000	2300	0.30	16000	1400	0.15
4	15000	2000	0.40	12000	1200	0.20
5	12000	1600	0.50	9000	900	0.25
6	10000	1400	0.60	7000	700	0.30
8	8000	1000	0.80	5600	550	0.40
10	6400	900	1.00	4500	500	0.50
12	5400	820	1.00	3800	450	0.50
16	2400	380	3.00	1200	100	0.80
20	1900	320	4.00	1000	80	1.00

Depth of cut



DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50−70% and the feed rate to 40−60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MS2MD

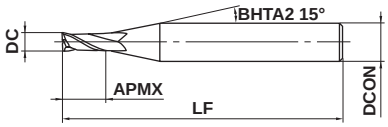
End mill, Medium cut length, 2 flute

TOOL NEWS

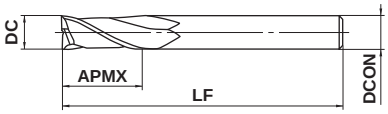
30°

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○		



Type1



Type2

1≤DC≤12				
0 - 0.020				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●Strong edge type, 2 flute end mill with high resistance to corner fracturing.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2MDD0100	1	2.5	40	4	2	●	1
MS2MDD0150	1.5	3.8	40	4	2	●	1
MS2MDD0200	2	5	40	4	2	●	1
MS2MDD0250	2.5	6.3	40	4	2	●	1
MS2MDD0300	3	7.5	50	6	2	●	1
MS2MDD0400	4	10	50	6	2	●	1
MS2MDD0500	5	12.5	50	6	2	●	1
MS2MDD0600	6	15	50	6	2	●	2
MS2MDD0800	8	20	60	8	2	●	2
MS2MDD1000	10	25	70	10	2	●	2
MS2MDD1200	12	30	90	12	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	2000	0.06	32000	1600	0.06
1.5	40000	3000	0.12	32000	1900	0.08
2	30000	3000	0.18	24000	1900	0.10
2.5	24000	2600	0.25	19000	1600	0.13
3	20000	2300	0.30	16000	1400	0.15
4	15000	2000	0.40	12000	1200	0.20
5	12000	1600	0.50	9000	900	0.25
6	10000	1400	0.60	7000	700	0.30
8	8000	1000	0.80	5600	550	0.40
10	6400	900	1.00	4500	500	0.50
12	5400	820	1.00	3800	450	0.50
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC			DC ≤Please refer to the list above for depth of cut. DC:Dia.		

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When drilling, please set the feed rate at 1/3 or below the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

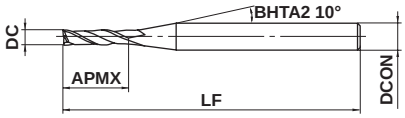
MS2JS

End mill, Semi long cut length, 2 flute

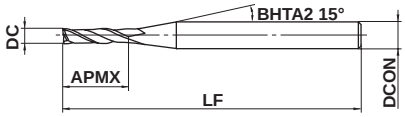
TOOL NEWS

UWC MS γ 30° DC<3 DC≥3 DC<3 DC≥3

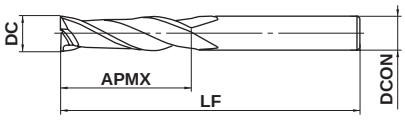
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2



Type3

DC=0.1	DC>0.1			
0 - 0.010	0 - 0.020			
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

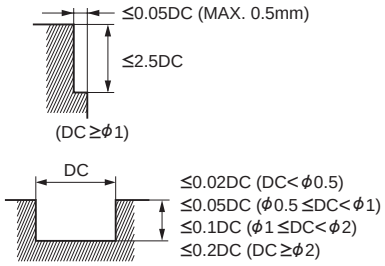
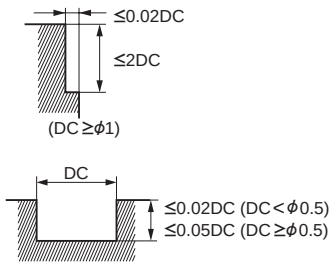
●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2JSD0010	0.1	0.3	40	4	2	●	1
MS2JSD0020	0.2	0.6	40	4	2	●	2
MS2JSD0030	0.3	0.9	40	4	2	●	2
MS2JSD0040	0.4	1.2	40	4	2	●	2
MS2JSD0050	0.5	1.5	40	4	2	●	2
MS2JSD0060	0.6	1.8	40	4	2	●	2
MS2JSD0070	0.7	2.1	40	4	2	●	2
MS2JSD0080	0.8	2.4	40	4	2	●	2
MS2JSD0090	0.9	2.7	40	4	2	●	2
MS2JSD0100	1	3	40	4	2	●	2
MS2JSD0120	1.2	3.6	40	4	2	●	2
MS2JSD0150	1.5	4.5	40	4	2	●	2
MS2JSD0180	1.8	5.4	40	4	2	●	2
MS2JSD0200	2	6	40	4	2	●	2
MS2JSD0250	2.5	7.5	40	4	2	●	2
MS2JSD0300	3	9	45	6	2	●	2
MS2JSD0400	4	12	50	6	2	●	2
MS2JSD0500	5	15	50	6	2	●	2
MS2JSD0600	6	18	50	6	2	●	3
MS2JSD0800	8	24	70	8	2	●	3
MS2JSD1000	10	30	90	10	2	●	3
MS2JSD1200	12	36	90	12	2	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.1	40000	— (40)	40000	— (40)	40000	— (35)	40000	— (25)
0.2	40000	— (45)	40000	— (45)	40000	— (35)	32000	— (25)
0.3	40000	— (55)	32000	— (45)	27000	— (35)	21000	— (25)
0.4	32000	— (60)	24000	— (45)	20000	— (35)	16000	— (25)
0.5	25000	— (60)	19000	— (45)	16000	— (35)	13000	— (25)
0.6	21000	— (60)	16000	— (45)	13000	— (35)	11000	— (25)
0.7	18000	— (60)	14000	— (45)	11000	— (35)	9100	— (25)
0.8	16000	— (60)	12000	— (45)	9900	— (35)	8000	— (25)
0.9	14000	— (60)	11000	— (45)	8800	— (35)	7100	— (25)
1	13000	60 (60)	9500	45 (45)	8000	35 (35)	6400	25 (25)
1.5	8500	60 (60)	6400	45 (45)	5300	35 (35)	4200	25 (25)
2	6400	60 (60)	4800	45 (45)	4000	35 (35)	3200	25 (25)
2.5	5100	60 (60)	3800	45 (45)	3200	40 (40)	2500	25 (25)
3	4200	65 (60)	3400	55 (45)	2600	40 (40)	2100	25 (25)
4	3400	80 (60)	2700	65 (45)	2100 (1600)	50 (30)	1700	35 (25)
5	2900	100 (60)	2300	80 (45)	1800 (1350)	60 (30)	1500	40 (25)
6	2500	120 (60)	2000	100 (50)	1500 (1100)	75 (30)	1300	50 (25)
8	1900	130 (60)	1500	100 (50)	1200 (900)	80 (30)	1000	50 (25)
10	1600	130 (60)	1300	100 (50)	950 (710)	75 (30)	800	50 (25)
12	1300	120 (60)	1100	100 (50)	800 (600)	75 (30)	670	50 (25)
Depth of cut								

( ) : Indicates standard revolution and feed rate for slotting.

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

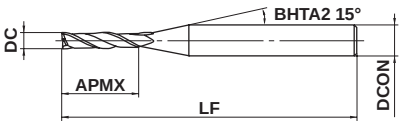
MS2LS

End mill, Long cut length, 2 flute

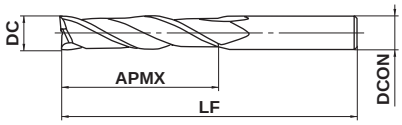
TOOL NEWS

UWC MS γ 30° DC<3 DC≥3 DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

0.2≤DC≤12				
0 / - 0.020				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

●2 flute end mill for general use.

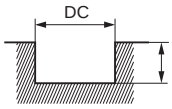
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2LSD0020	0.2	0.8	40	4	2	●	1
MS2LSD0030	0.3	1.2	40	4	2	●	1
MS2LSD0040	0.4	1.6	40	4	2	●	1
MS2LSD0050	0.5	2	40	4	2	●	1
MS2LSD0060	0.6	2.4	40	4	2	●	1
MS2LSD0070	0.7	2.8	40	4	2	●	1
MS2LSD0080	0.8	3.2	40	4	2	●	1
MS2LSD0090	0.9	3.6	40	4	2	●	1
MS2LSD0100	1	4	40	4	2	●	1
MS2LSD0150	1.5	6	40	4	2	●	1
MS2LSD0200	2	8	40	4	2	●	1
MS2LSD0250	2.5	10	50	4	2	●	1
MS2LSD0300	3	12	50	6	2	●	1
MS2LSD0400	4	16	50	6	2	●	1
MS2LSD0500	5	20	60	6	2	●	1
MS2LSD0600	6	24	60	6	2	●	2
MS2LSD0800	8	32	70	8	2	●	2
MS2LSD1000	10	40	90	10	2	●	2
MS2LSD1200	12	48	110	12	2	●	2

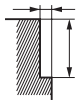
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.2	40000	400	0.001	30000	250	0.001
0.3	40000	600	0.005	35000	420	0.005
0.4	40000	700	0.007	30000	420	0.007
0.5	40000	800	0.01	24000	380	0.01
0.6	33000	800	0.015	21000	480	0.01
0.7	28000	800	0.015	18000	480	0.015
0.8	25000	800	0.02	16000	480	0.02
0.9	22000	800	0.03	15000	500	0.03
1	20000	800	0.04	13000	500	0.04
1.5	13000	800	0.10	9000	500	0.10
2	10000	800	0.15	6700	500	0.15
2.5	9000	800	0.20	6000	500	0.20
3	8000	800	0.20	5200	460	0.20
4	6000	600	0.20	4000	340	0.20
5	4800	480	0.30	3200	280	0.20
6	4000	400	0.30	2600	210	0.20
8	3000	300	0.30	2000	170	0.30
10	2400	240	0.30	1600	140	0.30
12	2000	200	0.30	1300	110	0.30
Depth of cut	 ≤Please refer to the list above for depth of cut. DC:Dia.					

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
3	3500	370	0.05	2600	250	0.03
4	2800	370	0.06	2100	200	0.03
5	2200	330	0.06	1700	160	0.03
6	1800	300	0.06	1500	140	0.03
8	1600	270	0.08	1100	140	0.04
10	1400	240	0.10	900	140	0.05
12	1200	200	0.10	750	120	0.06
Depth of cut	≤Please refer to the list above for depth of cut.  ≤3DC DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When drilling, please set the feed rate at 1/3 or below the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

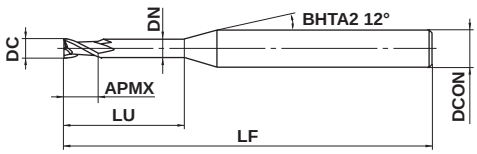
MS2XL

End mill, Short cut length, 2 flute, Long neck

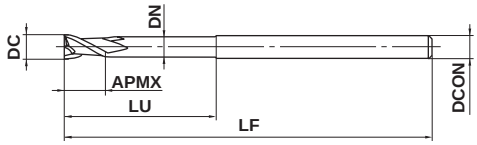
TOOL NEWS

UWC MS 30° DC<0.4 DC≥0.4

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

DC<0.5	DC≥0.5			
0 - 0.010	0 - 0.020			
4≤DCON≤6				
0 - 0.008				

h6

●2 flute long neck end mill.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS2XLD0020N005	0.2	0.3	0.5	0.17	45	4	2	●	1
MS2XLD0020N010	0.2	0.3	1	0.17	45	4	2	●	1
MS2XLD0020N015	0.2	0.3	1.5	0.17	45	4	2	●	1
MS2XLD0030N010	0.3	0.4	1	0.27	45	4	2	●	1
MS2XLD0030N020	0.3	0.4	2	0.27	45	4	2	●	1
MS2XLD0030N030	0.3	0.4	3	0.27	45	4	2	●	1
MS2XLD0030N060	0.3	0.4	6	0.27	45	4	2	●	1
MS2XLD0030N090	0.3	0.4	9	0.27	45	4	2	●	1
MS2XLD0040N020	0.4	0.6	2	0.36	45	4	2	●	1
MS2XLD0040N030	0.4	0.6	3	0.36	45	4	2	●	1
MS2XLD0040N040	0.4	0.6	4	0.36	45	4	2	●	1
MS2XLD0040N080	0.4	0.6	8	0.36	45	4	2	●	1
MS2XLD0040N120	0.4	0.6	12	0.36	45	4	2	●	1
MS2XLD0050N020	0.5	0.7	2	0.46	45	4	2	●	1
MS2XLD0050N040	0.5	0.7	4	0.46	45	4	2	●	1
MS2XLD0050N060	0.5	0.7	6	0.46	45	4	2	●	1
MS2XLD0050N080	0.5	0.7	8	0.46	50	4	2	●	1
MS2XLD0050N100	0.5	0.7	10	0.46	50	4	2	●	1
MS2XLD0050N150	0.5	0.7	15	0.46	50	4	2	●	1
MS2XLD0060N020	0.6	0.9	2	0.56	45	4	2	●	1
MS2XLD0060N040	0.6	0.9	4	0.56	45	4	2	●	1
MS2XLD0060N060	0.6	0.9	6	0.56	45	4	2	●	1
MS2XLD0060N080	0.6	0.9	8	0.56	50	4	2	●	1
MS2XLD0060N100	0.6	0.9	10	0.56	50	4	2	●	1
MS2XLD0060N120	0.6	0.9	12	0.56	50	4	2	●	1
MS2XLD0060N180	0.6	0.9	18	0.56	50	4	2	●	1
MS2XLD0070N020	0.7	1	2	0.66	45	4	2	●	1
MS2XLD0070N040	0.7	1	4	0.66	45	4	2	●	1
MS2XLD0070N060	0.7	1	6	0.66	45	4	2	●	1
MS2XLD0070N080	0.7	1	8	0.66	50	4	2	●	1
MS2XLD0070N100	0.7	1	10	0.66	50	4	2	●	1
MS2XLD0080N040	0.8	1.2	4	0.76	45	4	2	●	1
MS2XLD0080N060	0.8	1.2	6	0.76	45	4	2	●	1
MS2XLD0080N080	0.8	1.2	8	0.76	50	4	2	●	1

● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS2XLD0080N100	0.8	1.2	10	0.76	50	4	2	●	1
MS2XLD0080N120	0.8	1.2	12	0.76	50	4	2	●	1
MS2XLD0080N160	0.8	1.2	16	0.76	50	4	2	●	1
MS2XLD0080N240	0.8	1.2	24	0.76	60	4	2	●	1
MS2XLD0090N060	0.9	1.4	6	0.86	45	4	2	●	1
MS2XLD0090N080	0.9	1.4	8	0.86	50	4	2	●	1
MS2XLD0090N100	0.9	1.4	10	0.86	50	4	2	●	1
MS2XLD0090N150	0.9	1.4	15	0.86	60	4	2	●	1
MS2XLD0100N040	1	1.5	4	0.94	50	4	2	●	1
MS2XLD0100N060	1	1.5	6	0.94	50	4	2	●	1
MS2XLD0100N080	1	1.5	8	0.94	50	4	2	●	1
MS2XLD0100N100	1	1.5	10	0.94	50	4	2	●	1
MS2XLD0100N120	1	1.5	12	0.94	50	4	2	●	1
MS2XLD0100N160	1	1.5	16	0.94	60	4	2	●	1
MS2XLD0100N200	1	1.5	20	0.94	60	4	2	●	1
MS2XLD0100N250	1	1.5	25	0.94	70	4	2	●	1
MS2XLD0100N300	1	1.5	30	0.94	70	4	2	●	1
MS2XLD0120N060	1.2	1.8	6	1.14	50	4	2	●	1
MS2XLD0120N080	1.2	1.8	8	1.14	50	4	2	●	1
MS2XLD0120N100	1.2	1.8	10	1.14	50	4	2	●	1
MS2XLD0120N120	1.2	1.8	12	1.14	50	4	2	●	1
MS2XLD0120N160	1.2	1.8	16	1.14	60	4	2	●	1
MS2XLD0120N200	1.2	1.8	20	1.14	60	4	2	●	1
MS2XLD0150N060	1.5	2.3	6	1.44	50	4	2	●	1
MS2XLD0150N080	1.5	2.3	8	1.44	50	4	2	●	1
MS2XLD0150N100	1.5	2.3	10	1.44	50	4	2	●	1
MS2XLD0150N120	1.5	2.3	12	1.44	50	4	2	●	1
MS2XLD0150N140	1.5	2.3	14	1.44	60	4	2	●	1
MS2XLD0150N160	1.5	2.3	16	1.44	60	4	2	●	1
MS2XLD0150N180	1.5	2.3	18	1.44	60	4	2	●	1
MS2XLD0150N200	1.5	2.3	20	1.44	60	4	2	●	1
MS2XLD0150N250	1.5	2.3	25	1.44	70	4	2	●	1
MS2XLD0150N300	1.5	2.3	30	1.44	70	4	2	●	1
MS2XLD0150N380	1.5	2.3	38	1.44	80	4	2	●	1
MS2XLD0150N450	1.5	2.3	45	1.44	80	4	2	●	1
MS2XLD0200N060	2	3	6	1.9	50	4	2	●	1
MS2XLD0200N080	2	3	8	1.9	50	4	2	●	1
MS2XLD0200N100	2	3	10	1.9	50	4	2	●	1
MS2XLD0200N120	2	3	12	1.9	50	4	2	●	1
MS2XLD0200N140	2	3	14	1.9	60	4	2	●	1
MS2XLD0200N160	2	3	16	1.9	60	4	2	●	1
MS2XLD0200N180	2	3	18	1.9	60	4	2	●	1
MS2XLD0200N200	2	3	20	1.9	60	4	2	●	1
MS2XLD0200N250	2	3	25	1.9	70	4	2	●	1
MS2XLD0200N300	2	3	30	1.9	70	4	2	●	1
MS2XLD0200N350	2	3	35	1.9	80	4	2	●	1
MS2XLD0200N400	2	3	40	1.9	90	4	2	●	1
MS2XLD0200N500	2	3	50	1.9	100	4	2	●	1
MS2XLD0200N600	2	3	60	1.9	110	4	2	●	1
MS2XLD0250N080	2.5	3.7	8	2.4	50	4	2	●	1
MS2XLD0250N120	2.5	3.7	12	2.4	50	4	2	●	1
MS2XLD0250N160	2.5	3.7	16	2.4	60	4	2	●	1

MS2XL

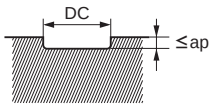
End mill, Short cut length, 2 flute, Long neck

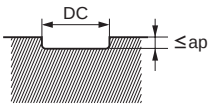
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS2XLD0250N200	2.5	3.7	20	2.4	60	4	2	●	1
MS2XLD0250N250	2.5	3.7	25	2.4	70	4	2	●	1
MS2XLD0250N300	2.5	3.7	30	2.4	70	4	2	●	1
MS2XLD0250N400	2.5	3.7	40	2.4	90	4	2	●	1
MS2XLD0250N500	2.5	3.7	50	2.4	100	4	2	●	1
MS2XLD0300N080	3	4.5	8	2.8	50	6	2	●	1
MS2XLD0300N120	3	4.5	12	2.8	50	6	2	●	1
MS2XLD0300N160	3	4.5	16	2.8	60	6	2	●	1
MS2XLD0300N200	3	4.5	20	2.8	60	6	2	●	1
MS2XLD0300N250	3	4.5	25	2.8	70	6	2	●	1
MS2XLD0300N300	3	4.5	30	2.8	70	6	2	●	1
MS2XLD0300N400	3	4.5	40	2.8	90	6	2	●	1
MS2XLD0300N500	3	4.5	50	2.8	100	6	2	●	1
MS2XLD0400N120	4	6	12	3.8	50	6	2	●	1
MS2XLD0400N160	4	6	16	3.8	60	6	2	●	1
MS2XLD0400N200	4	6	20	3.8	60	6	2	●	1
MS2XLD0400N250	4	6	25	3.8	70	6	2	●	1
MS2XLD0400N300	4	6	30	3.8	70	6	2	●	1
MS2XLD0400N350	4	6	35	3.8	80	6	2	●	1
MS2XLD0400N400	4	6	40	3.8	90	6	2	●	1
MS2XLD0400N450	4	6	45	3.8	90	6	2	●	1
MS2XLD0400N500	4	6	50	3.8	100	6	2	●	1
MS2XLD0400N600	4	6	60	3.8	110	6	2	●	1
MS2XLD0500N160	5	7.5	16	4.8	60	6	2	●	1
MS2XLD0500N250	5	7.5	25	4.8	70	6	2	●	1
MS2XLD0500N350	5	7.5	35	4.8	80	6	2	●	1
MS2XLD0500N500	5	7.5	50	4.8	110	6	2	●	1
MS2XLD0500N600	5	7.5	60	4.8	120	6	2	●	1
MS2XLD0600N200	6	9	20	5.8	80	6	2	●	2
MS2XLD0600N300	6	9	30	5.8	90	6	2	●	2
MS2XLD0600N400	6	9	40	5.8	100	6	2	●	2
MS2XLD0600N500	6	9	50	5.8	110	6	2	●	2
MS2XLD0600N600	6	9	60	5.8	120	6	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.2	0.5	40000	600	0.004
	1	40000	400	0.001
0.3	1	40000	650	0.007
	3	40000	500	0.002
	9	22000	150	0.001
0.4	2	40000	800	0.007
	4	40000	800	0.003
	12	17000	150	0.001
0.5	2	40000	950	0.01
	6	40000	700	0.003
	10	25000	400	0.002
	15	14000	150	0.001
0.6	2	40000	950	0.01
	6	40000	800	0.005
	10	25000	450	0.003
	18	12000	150	0.001
0.7	2	40000	1000	0.02
	6	40000	900	0.01
	8	30000	700	0.005
	10	11000	300	0.005
0.8	4	40000	1200	0.02
	8	40000	1000	0.01
	12	25000	400	0.003
	24	10000	150	0.001
0.9	6	40000	1300	0.02
	10	35000	1000	0.01
	15	9000	400	0.003
1	6	40000	1600	0.04
	8	40000	1600	0.03
	12	30000	1000	0.02
	20	15000	400	0.005
	30	8000	150	0.001
1.2	6	40000	1900	0.06
	8	40000	1900	0.04
	12	25000	1000	0.03
	20	6500	150	0.01
Depth of cut		 DC:Dia.		

Work Material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1.5	6	40000	2400	0.10
	10	30000	1800	0.05
	20	15000	600	0.02
	30	7500	300	0.005
	45	5000	150	0.001
1.6	6	40000	2400	0.12
	10	30000	1800	0.07
	16	20000	1000	0.04
2	6	40000	2400	0.18
	10	30000	1800	0.10
	16	20000	1000	0.06
	30	8000	500	0.04
	40	6000	250	0.01
	60	4200	150	0.003
2.5	8	25000	2500	0.20
	16	18000	1700	0.10
	20	12000	1000	0.08
	40	8000	400	0.03
	50	4000	150	0.015
3	8	20000	2000	0.30
	16	15000	1400	0.15
	20	10000	800	0.10
	40	5000	250	0.02
	50	3700	150	0.010
4	12	15000	3000	0.30
	20	11000	2200	0.22
	30	6400	1200	0.12
	40	4500	400	0.05
	50	2800	150	0.018
	60	1800	60	0.005
5	16	12000	2500	0.35
	35	5100	750	0.15
	60	2200	150	0.02
6	20	10000	2000	0.40
	40	4200	800	0.20
	60	1900	150	0.10
Depth of cut		 DC:Dia.		

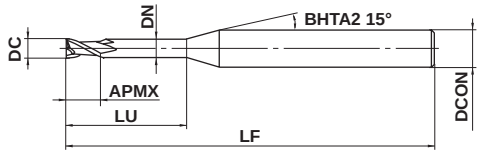
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

MS2XL6

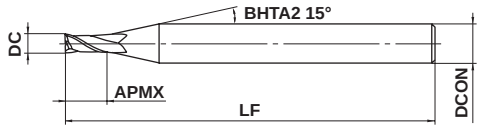
End mill, Short cut length, 2 flute, 6mm shank

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

0.3≤DC≤2.5				
0 / - 0.020				
DCON=6				
0 / - 0.008				

●2 flute long neck end mill.
●ϕ6 shank type.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS2XL6D0030N008	0.3	0.8	—	—	50	6	2	●	2
MS2XL6D0030N015	0.3	0.5	1.5	0.27	50	6	2	●	1
MS2XL6D0040N010	0.4	0.6	1	0.36	50	6	2	●	1
MS2XL6D0040N020	0.4	0.6	2	0.36	50	6	2	●	1
MS2XL6D0050N013	0.5	0.8	1.3	0.46	50	6	2	●	1
MS2XL6D0050N025	0.5	0.8	2.5	0.46	50	6	2	●	1
MS2XL6D0060N015	0.6	0.9	1.5	0.56	50	6	2	●	1
MS2XL6D0060N030	0.6	0.9	3	0.56	50	6	2	●	1
MS2XL6D0070N018	0.7	1.1	1.8	0.66	50	6	2	●	1
MS2XL6D0070N035	0.7	1.1	3.5	0.66	50	6	2	●	1
MS2XL6D0080N020	0.8	1.2	2	0.76	50	6	2	●	1
MS2XL6D0080N040	0.8	1.2	4	0.76	50	6	2	●	1
MS2XL6D0090N023	0.9	1.4	2.3	0.86	50	6	2	●	1
MS2XL6D0090N045	0.9	1.4	4.5	0.86	50	6	2	●	1
MS2XL6D0100N025	1	1.5	2.5	0.94	50	6	2	●	1
MS2XL6D0100N050	1	1.5	5	0.94	50	6	2	●	1
MS2XL6D0110N028	1.1	1.7	2.8	1.04	50	6	2	●	1
MS2XL6D0110N055	1.1	1.7	5.5	1.04	50	6	2	●	1
MS2XL6D0120N030	1.2	1.8	3	1.14	50	6	2	●	1
MS2XL6D0120N060	1.2	1.8	6	1.14	50	6	2	●	1
MS2XL6D0130N033	1.3	2	3.3	1.24	50	6	2	●	1
MS2XL6D0130N065	1.3	2	6.5	1.24	50	6	2	●	1
MS2XL6D0140N035	1.4	2.1	3.5	1.34	50	6	2	●	1
MS2XL6D0140N070	1.4	2.1	7	1.34	50	6	2	●	1
MS2XL6D0150N038	1.5	2.3	3.8	1.44	50	6	2	●	1
MS2XL6D0150N075	1.5	2.3	7.5	1.44	50	6	2	●	1
MS2XL6D0160N040	1.6	2.4	4	1.54	50	6	2	●	1
MS2XL6D0160N080	1.6	2.4	8	1.54	50	6	2	●	1
MS2XL6D0170N043	1.7	2.6	4.3	1.64	50	6	2	●	1
MS2XL6D0170N085	1.7	2.6	8.5	1.64	50	6	2	●	1
MS2XL6D0180N045	1.8	2.7	4.5	1.74	50	6	2	●	1
MS2XL6D0180N090	1.8	2.7	9	1.74	50	6	2	●	1
MS2XL6D0190N048	1.9	2.9	4.8	1.84	50	6	2	●	1
MS2XL6D0190N095	1.9	2.9	9.5	1.84	50	6	2	●	1

● : Inventory maintained in Japan.

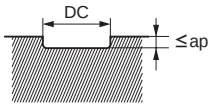
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS2XL6D0200N050	2	3	5	1.90	50	6	2	●	1
MS2XL6D0200N100	2	3	10	1.90	50	6	2	●	1
MS2XL6D0210N053	2.1	3.2	5.3	2.00	50	6	2	●	1
MS2XL6D0210N105	2.1	3.2	10.5	2.00	60	6	2	●	1
MS2XL6D0220N055	2.2	3.3	5.5	2.10	50	6	2	●	1
MS2XL6D0220N110	2.2	3.3	11	2.10	60	6	2	●	1
MS2XL6D0230N058	2.3	3.5	5.8	2.20	50	6	2	●	1
MS2XL6D0230N115	2.3	3.5	11.5	2.20	60	6	2	●	1
MS2XL6D0240N060	2.4	3.6	6	2.30	50	6	2	●	1
MS2XL6D0240N120	2.4	3.6	12	2.30	60	6	2	●	1
MS2XL6D0250N063	2.5	3.8	6.3	2.40	50	6	2	●	1
MS2XL6D0250N125	2.5	3.8	12.5	2.40	60	6	2	●	1

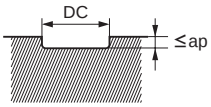
MS2XL6

End mill, Short cut length, 2 flute, 6mm shank

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.3	—	40000	500−1000	0.01	30000	300−800	0.01
	1.5			0.007			0.007
0.4	1	40000	500−1000	0.015	30000	300−800	0.015
	2			0.01			0.01
0.5	1.3	40000	500−1000	0.02	30000	300−800	0.02
	2.5			0.013			0.013
0.6	1.5	33000	500−1000	0.03	25000	300−800	0.03
	3			0.018			0.018
0.7	1.8	29000	500−1000	0.04	22000	300−800	0.04
	3.5			0.025			0.025
0.8	2	25000	500−1000	0.06	20000	300−800	0.06
	4			0.03			0.03
0.9	2.3	22000	500−1000	0.08	18000	300−800	0.08
	4.5			0.05			0.05
1	2.5	20000	500−1000	0.1	16000	300−800	0.1
	5			0.07			0.07
1.1	2.8	18000	500−1000	0.12	14000	300−800	0.12
	5.5			0.08			0.08
1.2	3	16000	500−1000	0.12	13000	300−800	0.12
	6			0.08			0.08
1.3	3.3	15000	500−1000	0.12	12000	300−800	0.12
	6.5			0.08			0.08
1.4	3.5	14000	500−1000	0.12	11000	300−800	0.12
	7			0.08			0.08
1.5	3.8	13000	500−1000	0.15	10000	300−800	0.15
	7.5			0.1			0.1
Depth of cut		 DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

Work Material		Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1.6	4	12000	500−1000	0.15	10000	300−800	0.15
	8			0.1			0.1
1.7	4.3	12000	500−1000	0.17	9500	300−800	0.17
	8.5			0.12			0.12
1.8	4.5	11000	500−1000	0.17	9000	300−800	0.17
	9			0.12			0.12
1.9	4.8	10000	500−1000	0.17	9000	300−800	0.17
	9.5			0.12			0.12
2	5	10000	500−1000	0.2	9000	300−800	0.2
	10			0.15			0.15
2.1	5.3	9800	500−1000	0.2	9000	300−800	0.2
	10.5			0.15			0.15
2.2	5.5	9600	500−1000	0.2	9000	300−800	0.2
	11			0.15			0.15
2.3	5.8	9400	500−1000	0.2	8800	300−800	0.2
	11.5			0.15			0.15
2.4	6	9200	500−1000	0.25	8700	300−800	0.25
	12			0.2			0.2
2.5	6.3	9000	500−1000	0.25	8500	300−800	0.25
	12.5			0.2			0.2
Depth of cut		 DC:Dia.					

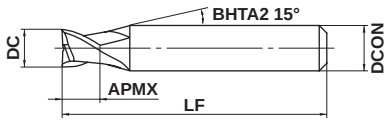
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

MS2ES

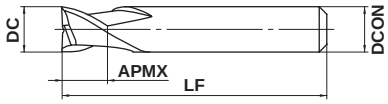
End mill, 2 flute, For small automatic lathes

TOOL NEWS

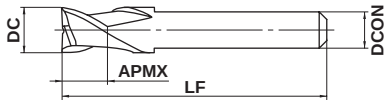
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2



Type3

3≤DC≤12				
0 - 0.020				
4≤DCON≤6	7≤DCON≤10			
0 - 0.008	0 - 0.009			

h6

●2 flute end mill.

Overall length 35mm (mm)

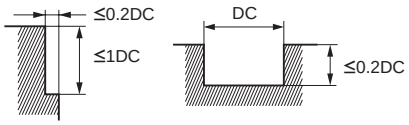
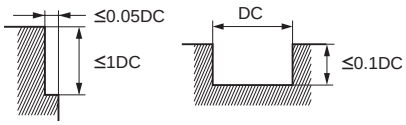
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2ESD0300L35S04	3	3	35	4	2	●	1
MS2ESD0350L35S04	3.5	3.5	35	4	2	●	1
MS2ESD0400L35S04	4	4	35	4	2	●	2
MS2ESD0500L35S05	5	5	35	5	2	●	2
MS2ESD0500L35S06	5	5	35	6	2	●	1
MS2ESD0600L35S05	6	6	35	5	2	●	3
MS2ESD0600L35S06	6	6	35	6	2	●	2
MS2ESD0700L35S07	7	6	35	7	2	●	2
MS2ESD0800L35S07	8	6	35	7	2	●	3
MS2ESD0800L35S08	8	6	35	8	2	●	2
MS2ESD1000L35S07	10	6	35	7	2	●	3
MS2ESD1000L35S10	10	6	35	10	2	●	2
MS2ESD1200L35S10	12	6	35	10	2	●	3

Overall length 45mm (mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2ESD0300L45S04	3	3	45	4	2	●	1
MS2ESD0350L45S04	3.5	3.5	45	4	2	●	1
MS2ESD0400L45S04	4	4	45	4	2	●	2
MS2ESD0500L45S06	5	5	45	6	2	●	1
MS2ESD0600L45S06	6	6	45	6	2	●	2
MS2ESD0700L45S07	7	7	45	7	2	●	2
MS2ESD0800L45S07	8	8	45	7	2	●	3
MS2ESD0800L45S08	8	8	45	8	2	●	2
MS2ESD1000L45S07	10	10	45	7	2	●	3
MS2ESD1000L45S10	10	10	45	10	2	●	2
MS2ESD1200L45S10	12	12	45	10	2	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	10000	600	7000	400	6000	300	5000	120
4	7500	600	5200	400	4500	300	4000	120
5	6000	600	4200	400	3600	300	3200	120
6	5000	600	3500	400	3000	300	2700	120
7	4500	560	3000	360	2700	280	2300	110
8	4000	520	2800	350	2400	260	2000	110
10	3200	450	2200	300	1900	230	1600	100
12	2700	410	1900	270	1600	210	1300	100
Depth of cut								

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VF2MD

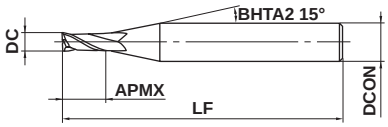
End mill, Medium cut length, 2 flute, For hardened materials

TOOL NEWS

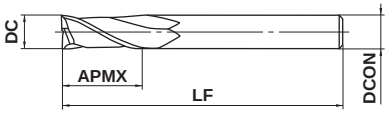
35°

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

0.5≤DC≤6				
0 / - 0.020				
4≤DCON≤6				
0 / - 0.008				

●2 flute end mill suitable for high-speed machining of hardened steel.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF2MDD0050	0.5	1.3	40	4	2	●	1
VF2MDD0100	1	2.5	40	4	2	●	1
VF2MDD0150	1.5	3.8	40	4	2	●	1
VF2MDD0200	2	5	40	4	2	●	1
VF2MDD0250	2.5	6.3	40	4	2	●	1
VF2MDD0300	3	7.5	50	6	2	●	1
VF2MDD0400	4	10	50	6	2	●	1
VF2MDD0500	5	12.5	50	6	2	●	1
VF2MDD0600	6	15	50	6	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.5	40000	1000	0.015	40000	960	0.015	30000	600	0.01
1	40000	2000	0.06	32000	1600	0.06	16000	550	0.05
1.5	40000	3000	0.12	32000	1900	0.08	10600	500	0.08
2	30000	3000	0.18	24000	1900	0.10	8100	400	0.1
2.5	24000	2600	0.25	19000	1600	0.13	6400	350	0.13
3	20000	2300	0.30	16000	1400	0.15	5400	300	0.15
4	15000	2000	0.40	12000	1200	0.20	4000	240	0.2
5	12000	1600	0.50	9000	900	0.25	3200	190	0.2
6	10000	1400	0.60	7000	700	0.30	2700	160	0.2
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC DC ≤Please refer to the list above for depth of cut. DC:Dia.								

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When drilling, please set the feed rate at 1/3 or below the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

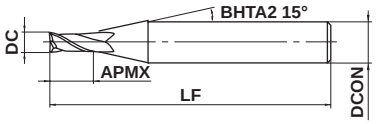
VF2MV

End mill, Medium cut length, 2 flute, Irregular helix flutes

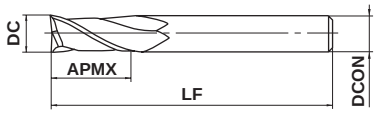
TOOL NEWS

UWC VF 32.5° 37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

0.5≤DC≤6				
0 / - 0.020				
4≤DCON≤6				
0 / - 0.008				

●An irregular helix 2 flute square end mill suitable for high-speed machining of hardened steel.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF2MVD0050	0.5	1.3	40	4	2	●	1
VF2MVD0100	1	2.5	40	4	2	●	1
VF2MVD0150	1.5	3.8	40	4	2	●	1
VF2MVD0200	2	5	40	4	2	●	1
VF2MVD0250	2.5	6.3	40	4	2	●	1
VF2MVD0300	3	7.5	50	6	2	●	1
VF2MVD0400	4	10	50	6	2	●	1
VF2MVD0500	5	12.5	50	6	2	●	1
VF2MVD0600	6	15	50	6	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ae (mm)
0.5	40000	1000	0.015	40000	960	0.015	30000	600	0.01
1	40000	2000	0.06	32000	1600	0.06	16000	550	0.05
1.5	40000	3000	0.12	32000	1900	0.08	10600	500	0.08
2	30000	3000	0.18	24000	1900	0.10	8100	400	0.1
2.5	24000	2600	0.25	19000	1600	0.13	6400	350	0.13
3	20000	2300	0.30	16000	1400	0.15	5400	300	0.15
4	15000	2000	0.40	12000	1200	0.20	4000	240	0.2
5	12000	1600	0.50	9000	900	0.25	3200	190	0.2
6	10000	1400	0.60	7000	700	0.30	2700	160	0.2
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC DC ≤Please refer to the list above for depth of cut. DC:Dia.								

Note 1) When slotting, reduce the revolutions by 50－70% and the feed rate by 40－60%.
Note 2) For austenitic stainless steels, titanium and heat-resistant alloys, the VFMHV is recommended.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

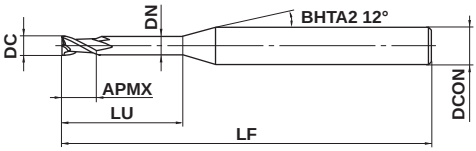
VF2XL

End mill, 2 flute, Long neck

TOOL NEWS

UWC VF 30° DC<3 DC=3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	◎				



Type1

0.1≤DC≤3				
0 / - 0.020				
4≤DCON≤6				
0 / - 0.008				

h6

●2 flute long neck end mill for high-speed machining of hardened steels.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VF2XLD0010N005	0.1	0.15	0.5	0.085	45	4	2	●	1
VF2XLD0020N006	0.2	0.3	0.6	0.17	45	4	2	●	1
VF2XLD0020N010	0.2	0.3	1	0.17	45	4	2	●	1
VF2XLD0020N015	0.2	0.3	1.5	0.17	45	4	2	●	1
VF2XLD0030N010	0.3	0.5	1	0.27	45	4	2	●	1
VF2XLD0030N020	0.3	0.5	2	0.27	45	4	2	●	1
VF2XLD0030N030	0.3	0.5	3	0.27	45	4	2	●	1
VF2XLD0040N010	0.4	0.6	1	0.36	45	4	2	●	1
VF2XLD0040N020	0.4	0.6	2	0.36	45	4	2	●	1
VF2XLD0040N040	0.4	0.6	4	0.36	45	4	2	●	1
VF2XLD0050N020	0.5	0.8	2	0.46	45	4	2	●	1
VF2XLD0050N040	0.5	0.8	4	0.46	45	4	2	●	1
VF2XLD0050N060	0.5	0.8	6	0.46	45	4	2	●	1
VF2XLD0060N020	0.6	0.9	2	0.56	45	4	2	●	1
VF2XLD0060N040	0.6	0.9	4	0.56	45	4	2	●	1
VF2XLD0060N060	0.6	0.9	6	0.56	45	4	2	●	1
VF2XLD0080N040	0.8	1.2	4	0.76	45	4	2	●	1
VF2XLD0080N060	0.8	1.2	6	0.76	45	4	2	●	1
VF2XLD0080N080	0.8	1.2	8	0.76	50	4	2	●	1
VF2XLD0080N100	0.8	1.2	10	0.76	50	4	2	●	1
VF2XLD0100N040	1	1.5	4	0.94	50	4	2	●	1
VF2XLD0100N060	1	1.5	6	0.94	50	4	2	●	1
VF2XLD0100N080	1	1.5	8	0.94	50	4	2	●	1
VF2XLD0100N100	1	1.5	10	0.94	50	4	2	●	1
VF2XLD0100N120	1	1.5	12	0.94	50	4	2	●	1
VF2XLD0150N060	1.5	2.3	6	1.44	50	4	2	●	1
VF2XLD0150N080	1.5	2.3	8	1.44	50	4	2	●	1
VF2XLD0150N100	1.5	2.3	10	1.44	50	4	2	●	1
VF2XLD0150N120	1.5	2.3	12	1.44	50	4	2	●	1
VF2XLD0150N160	1.5	2.3	16	1.44	60	4	2	●	1
VF2XLD0200N060	2	3	6	1.9	50	4	2	●	1
VF2XLD0200N080	2	3	8	1.9	50	4	2	●	1
VF2XLD0200N100	2	3	10	1.9	50	4	2	●	1
VF2XLD0200N120	2	3	12	1.9	50	4	2	●	1

● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VF2XLD0200N160	2	3	16	1.9	60	4	2	●	1
VF2XLD0200N200	2	3	20	1.9	60	4	2	●	1
VF2XLD0300N120	3	4.5	12	2.9	50	6	2	●	1
VF2XLD0300N160	3	4.5	16	2.9	60	6	2	●	1
VF2XLD0300N200	3	4.5	20	2.9	60	6	2	●	1

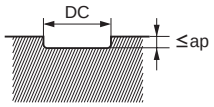
VF2XL

End mill, 2 flute, Long neck

RECOMMENDED CUTTING CONDITIONS

Work Material		Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.1	0.5	40000	100	0.002	40000	80	0.001
0.2	0.6	40000	400	0.004	40000	360	0.004
	1	40000	300	0.003	40000	250	0.002
	1.5	40000	200	0.002	40000	150	0.001
0.3	1	40000	500	0.006	40000	450	0.004
	2	40000	400	0.003	38000	350	0.002
	3	38000	250	0.002	36000	200	0.001
0.4	1	40000	800	0.008	36000	500	0.006
	2	40000	500	0.007	30000	350	0.005
	4	36000	300	0.004	27000	200	0.003
0.5	2	40000	800	0.01	30000	600	0.009
	4	36000	600	0.008	27000	450	0.007
	6	30000	400	0.005	22000	300	0.004
0.6	2	40000	1000	0.015	30000	700	0.012
	4	36000	800	0.01	27000	500	0.01
	6	30000	600	0.006	22000	350	0.006
0.8	4	36000	1200	0.03	27000	900	0.02
	6	30000	900	0.02	22000	650	0.015
	8	24000	600	0.01	18000	450	0.008
	10	20000	400	0.008	15000	300	0.005
1	4	32000	1600	0.05	24000	1100	0.04
	6	32000	1400	0.04	24000	1000	0.03
	8	28000	1000	0.03	21000	750	0.02
	10	28000	800	0.02	21000	600	0.015
	12	24000	500	0.02	18000	370	0.01
1.5	6	22000	1200	0.08	16000	900	0.06
	8	22000	1100	0.07	16000	800	0.05
	10	22000	1000	0.06	16000	750	0.04
	12	20000	800	0.05	15000	600	0.03
	16	18000	500	0.03	13000	350	0.02
2	6	16000	1000	0.15	12000	750	0.15
	8	16000	1000	0.15	12000	750	0.1
	10	16000	800	0.1	12000	600	0.08
	12	16000	800	0.08	12000	600	0.06
	16	15000	600	0.06	11000	450	0.05
	20	14000	500	0.05	10000	350	0.04
3	12	11000	800	0.2	8200	600	0.15
	16	11000	600	0.15	8200	450	0.15
	20	11000	500	0.1	8200	350	0.1

Depth of cut



DC:Dia.

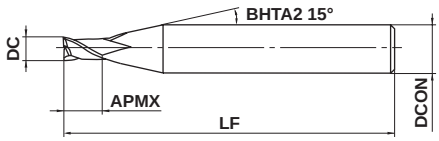
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

VC2SS

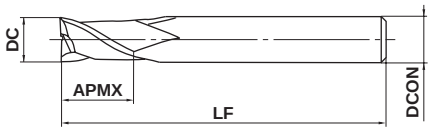
End mill, Short cut length, 2 flute

UWC VC γ 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC2SSD0030	0.3	0.6	50	6	2	●	1
VC2SSD0040	0.4	0.8	50	6	2	●	1
VC2SSD0050	0.5	0.8	50	6	2	●	1
VC2SSD0060	0.6	1	50	6	2	●	1
VC2SSD0070	0.7	1	50	6	2	●	1
VC2SSD0080	0.8	1.3	50	6	2	●	1
VC2SSD0090	0.9	1.3	50	6	2	●	1
VC2SSD0100	1	1.5	50	6	2	●	1
VC2SSD0110	1.1	1.5	50	6	2	●	1
VC2SSD0120	1.2	2	50	6	2	●	1
VC2SSD0130	1.3	2	50	6	2	●	1
VC2SSD0140	1.4	2	50	6	2	●	1
VC2SSD0150	1.5	2.5	50	6	2	●	1
VC2SSD0160	1.6	2.5	50	6	2	●	1
VC2SSD0170	1.7	2.5	50	6	2	●	1
VC2SSD0180	1.8	3	50	6	2	●	1
VC2SSD0190	1.9	3	50	6	2	●	1
VC2SSD0200	2	3	50	6	2	●	1
VC2SSD0210	2.1	3	50	6	2	●	1
VC2SSD0220	2.2	3.5	50	6	2	●	1
VC2SSD0230	2.3	3.5	50	6	2	●	1
VC2SSD0240	2.4	3.5	50	6	2	●	1
VC2SSD0250	2.5	4	50	6	2	●	1
VC2SSD0260	2.6	4	50	6	2	●	1
VC2SSD0270	2.7	4	50	6	2	●	1
VC2SSD0280	2.8	4	50	6	2	●	1
VC2SSD0290	2.9	4.5	50	6	2	●	1
VC2SSD0300	3	4.5	50	6	2	●	1
VC2SSD0350	3.5	5.5	50	6	2	●	1
VC2SSD0400	4	6	50	6	2	●	1
VC2SSD0450	4.5	7	50	6	2	●	1
VC2SSD0500	5	7.5	50	6	2	●	1
VC2SSD0550	5.5	8.5	50	6	2	●	1
VC2SSD0600	6	9	50	6	2	●	2

● : Inventory maintained in Japan.

VC2SS

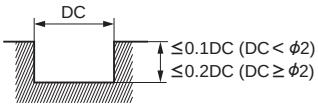
End mill, Short cut length, 2 flute

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC2SSD0800	8	12	60	8	2	●	2
VC2SSD1000	10	15	70	10	2	●	2
VC2SSD1200	12	18	75	12	2	●	2
VC2SSD1400	14	21	75	16	2	●	1
VC2SSD1500	15	23	80	16	2	●	1
VC2SSD1600	16	24	90	16	2	●	2

RECOMMENDED CUTTING CONDITIONS

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.3	40000	190	40000	190	40000	100
0.5	40000	380	40000	380	30000	140
1	30000	720	20000	480	15000	180
1.5	20000	960	14000	670	10000	190
2	15000	1100	10000	720	8000	200
3	10000	1150	7000	800	5000	210
4	7500	900	5200	620	4000	200
5	6000	720	4200	500	3200	160
6	5000	600	3500	420	2700	140
8	4000	520	2800	350	2000	120
10	3200	450	2200	290	1600	110
12	2700	410	1900	260	1300	100
16	2000	340	1400	210	1000	90
Depth of cut	 DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When drilling, please set the feed rate at 1/3 or below the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

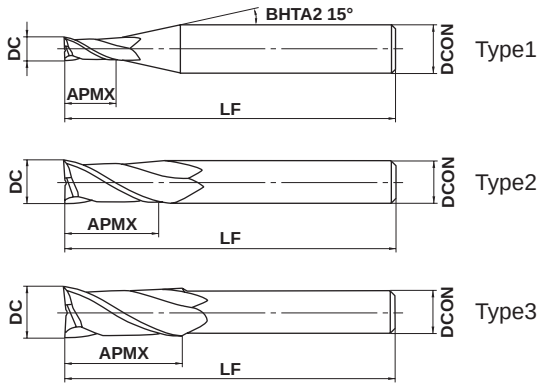
● : **Inventory maintained in Japan.**

VC2MS

End mill, Medium cut length, 2 flute

UWC VC 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=3	4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25
0 - 0.006	0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013

h6

●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC2MSD0030	0.3	0.6	38	3	2	●	1
VC2MSD0040	0.4	0.8	38	3	2	●	1
VC2MSD0050	0.5	1	38	3	2	●	1
VC2MSD0060	0.6	1.2	38	3	2	●	1
VC2MSD0070	0.7	1.4	38	3	2	●	1
VC2MSD0080	0.8	1.6	38	3	2	●	1
VC2MSD0090	0.9	2	38	3	2	●	1
VC2MSD0100	1	2.5	40	4	2	●	1
VC2MSD0110	1.1	2.5	40	4	2	●	1
VC2MSD0120	1.2	3	40	4	2	●	1
VC2MSD0130	1.3	3	40	4	2	●	1
VC2MSD0140	1.4	3	40	4	2	●	1
VC2MSD0150	1.5	4	40	4	2	●	1
VC2MSD0160	1.6	4	40	4	2	●	1
VC2MSD0170	1.7	4	40	4	2	●	1
VC2MSD0180	1.8	5	40	4	2	●	1
VC2MSD0190	1.9	5	40	4	2	●	1
VC2MSD0200	2	6	40	4	2	●	1
VC2MSD0210	2.1	6	40	4	2	●	1
VC2MSD0220	2.2	6	40	4	2	●	1
VC2MSD0230	2.3	6	40	4	2	●	1
VC2MSD0240	2.4	8	40	4	2	●	1
VC2MSD0250	2.5	8	40	4	2	●	1
VC2MSD0260	2.6	8	40	4	2	●	1
VC2MSD0270	2.7	8	40	4	2	●	1
VC2MSD0280	2.8	8	40	4	2	●	1
VC2MSD0290	2.9	8	40	4	2	●	1
VC2MSD0300	3	8	45	6	2	●	1
VC2MSD0350	3.5	10	45	6	2	●	1
VC2MSD0400	4	11	45	6	2	●	1
VC2MSD0450	4.5	11	45	6	2	●	1
VC2MSD0500	5	13	50	6	2	●	1
VC2MSD0550	5.5	13	50	6	2	●	1
VC2MSD0600	6	13	50	6	2	●	2

VC2MS

End mill, Medium cut length, 2 flute

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC2MSD0650	6.5	16	60	8	2	●	1
VC2MSD0700	7	16	60	8	2	●	1
VC2MSD0750	7.5	16	60	8	2	●	1
VC2MSD0800	8	19	60	8	2	●	2
VC2MSD0850	8.5	19	70	10	2	●	1
VC2MSD0900	9	19	70	10	2	●	1
VC2MSD0950	9.5	19	70	10	2	●	1
VC2MSD1000	10	22	70	10	2	●	2
VC2MSD1050	10.5	22	75	12	2	●	1
VC2MSD1100	11	22	75	12	2	●	1
VC2MSD1150	11.5	22	75	12	2	●	1
VC2MSD1200	12	26	75	12	2	●	2
VC2MSD1250	12.5	26	75	12	2	●	3
VC2MSD1300	13	26	75	12	2	●	3
VC2MSD1400	14	26	75	12	2	●	3
VC2MSD1500	15	30	80	16	2	●	1
VC2MSD1600	16	32	90	16	2	●	2
VC2MSD1700	17	32	90	16	2	●	3
VC2MSD1800	18	32	90	16	2	●	3
VC2MSD1900	19	32	100	20	2	●	1
VC2MSD2000	20	38	100	20	2	●	2
VC2MSD2200	22	38	100	20	2	●	3
VC2MSD2400	24	45	120	25	2	●	1
VC2MSD2500	25	45	120	25	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.3	40000	200	0.005	40000	200	0.005
0.5	40000	950	0.015	40000	950	0.015
1	40000	2000	0.06	32000	1600	0.06
1.5	40000	3000	0.12	32000	1900	0.08
2	30000	3000	0.18	24000	1900	0.10
2.5	24000	2600	0.25	19000	1600	0.13
3	20000	2300	0.30	16000	1400	0.15
4	15000	2000	0.40	12000	1200	0.20
5	12000	1600	0.50	9000	900	0.25
6	10000	1400	0.60	7000	700	0.30
8	8000	1000	0.80	5600	550	0.40
10	6400	900	1.00	4500	500	0.50
12	5400	820	1.00	3800	450	0.50
16	2400	380	3.00	1200	100	0.80
20	1900	320	4.00	1000	80	1.00
Depth of cut	≤Please refer to the list above for depth of cut. ≤DC DC ≤Please refer to the list above for depth of cut. DC:Dia.					

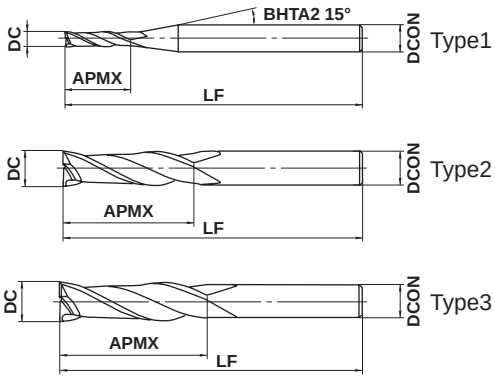
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50－70% and the feed rate to 40－60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VC2JS

End mill, Semi long cut length, 2 flute

UWC VC γ 30° DC<3 DC≥3 DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

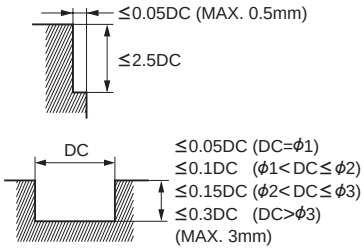
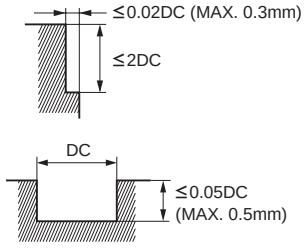
●2 flute end mill with longer cut length than standard.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC2JSD0100	1	3.5	40	4	2	●	1
VC2JSD0150	1.5	5	40	4	2	●	1
VC2JSD0200	2	8	40	4	2	●	1
VC2JSD0250	2.5	10	40	4	2	●	1
VC2JSD0300	3	12	50	6	2	●	1
VC2JSD0350	3.5	15	50	6	2	●	1
VC2JSD0400	4	15	50	6	2	●	1
VC2JSD0450	4.5	15	50	6	2	●	1
VC2JSD0500	5	20	60	6	2	●	1
VC2JSD0550	5.5	20	60	6	2	●	1
VC2JSD0600	6	20	60	6	2	●	2
VC2JSD0650	6.5	25	70	8	2	●	1
VC2JSD0700	7	25	70	8	2	●	1
VC2JSD0750	7.5	25	70	8	2	●	1
VC2JSD0800	8	25	70	8	2	●	2
VC2JSD0850	8.5	25	90	10	2	●	1
VC2JSD0900	9	25	90	10	2	●	1
VC2JSD0950	9.5	25	90	10	2	●	1
VC2JSD1000	10	30	90	10	2	●	2
VC2JSD1050	10.5	30	90	12	2	●	1
VC2JSD1100	11	30	90	12	2	●	1
VC2JSD1150	11.5	30	90	12	2	●	1
VC2JSD1200	12	30	90	12	2	●	2
VC2JSD1300	13	35	90	12	2	●	3
VC2JSD1400	14	40	110	16	2	●	1
VC2JSD1500	15	40	110	16	2	●	1
VC2JSD1600	16	50	110	16	2	●	2
VC2JSD1700	17	50	110	20	2	●	1
VC2JSD1800	18	50	110	20	2	●	1
VC2JSD1900	19	55	110	20	2	●	1
VC2JSD2000	20	55	110	20	2	●	2
VC2JSD2200	22	65	140	25	2	●	1
VC2JSD2400	24	75	140	25	2	●	1
VC2JSD2500	25	75	140	25	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	13000	60 (60)	9000	35 (35)	6500 (6500)	20 (20)	5700	20 (15)
2	6400	60 (60)	4800	45 (45)	3500 (3500)	30 (30)	3000	25 (15)
3	4200	65 (60)	3400	55 (55)	2600 (2600)	40 (40)	2100	30 (20)
4	3400	80 (60)	2700	65 (30)	2100 (1600)	50 (20)	1700	35 (20)
5	2900	100 (60)	2300	80 (40)	1800 (1350)	60 (25)	1500	40 (20)
6	2500	120 (60)	2000	100 (50)	1500 (1100)	75 (30)	1300	50 (25)
8	1900	130 (60)	1500	100 (50)	1200 (900)	85 (35)	1000	50 (25)
10	1600	130 (60)	1300	100 (50)	950 (710)	75 (30)	800	50 (25)
12	1300	120 (60)	1100	90 (45)	800 (600)	60 (25)	670	40 (20)
16	1000	80 (40)	820	65 (30)	600 (450)	45 (20)	500	30 (15)
20	800	65 (30)	650	50 (25)	480 (360)	40 (15)	400	25 (13)
25	650	50 (25)	520	40 (20)	380 (280)	30 (12)	320	20 (10)
Depth of cut								

DC:Dia.

( ) : Indicates standard revolution and feed rates for slotting.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

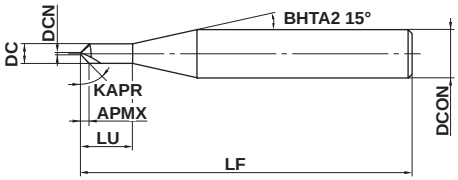
VC2C

Chamfer cutter, 2 flute

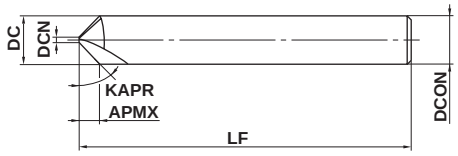
TOOL NEWS

UWC VC γ 5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		◎	◎	○	○



Type1



Type2

DCN				
±0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

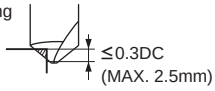
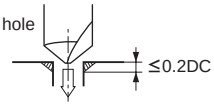
●Chamfering cutters for machining of hardened steel and difficult-to-cut materials.

(mm)

Order Number	DC	DCN	APMX	KAPR	LU	LF	DCON	No. of Flutes	Stock	Type
VC2CD0200	2	0.3	0.85	45°	6	50	6	2	●	1
VC2CD0400	4	0.3	1.85	45°	12	50	6	2	●	1
VC2CD0600	6	0.3	2.85	45°	—	50	6	2	●	2
VC2CD0800	8	0.4	3.8	45°	—	60	8	2	●	2
VC2CD1000	10	0.5	4.75	45°	—	70	10	2	●	2
VC2CD1200	12	0.5	5.75	45°	—	75	12	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	16000	960	11000	590	9500	460	8000	320
4	8000	480	5600	300	4800	230	4000	160
6	5300	320	3700	200	3200	150	2700	110
8	4000	240	2800	150	2400	120	2000	80
10	3200	190	2200	120	1900	90	1600	60
12	2700	160	1900	100	1600	80	1300	50
Depth of cut	Chamfering  ≤0.3DC (MAX. 2.5mm)				Chamfering of hole  ≤0.2DC			DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

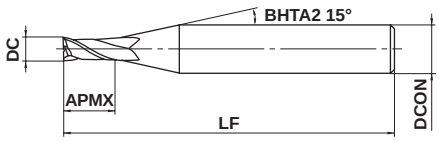
CRN2MS

End mill, Medium cut length, 2 flute, For copper electrodes

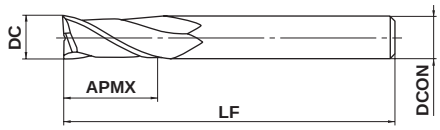
TOOL NEWS

UWC CRN 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○



Type1



Type2

0.2≤DC≤12				
0 / - 0.02				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

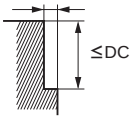
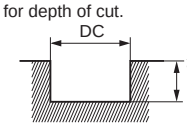
●2 flute end mill with CRN coating for copper electrode machining.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
CRN2MSD0020S04	0.2	0.4	40	4	2	●	1
CRN2MSD0020S06	0.2	0.4	45	6	2	●	1
CRN2MSD0030S04	0.3	0.6	40	4	2	●	1
CRN2MSD0030S06	0.3	0.6	45	6	2	●	1
CRN2MSD0040S04	0.4	0.8	40	4	2	●	1
CRN2MSD0040S06	0.4	0.8	45	6	2	●	1
CRN2MSD0050S04	0.5	1	40	4	2	●	1
CRN2MSD0050S06	0.5	1	45	6	2	●	1
CRN2MSD0060S04	0.6	1.2	40	4	2	●	1
CRN2MSD0070S04	0.7	1.4	40	4	2	●	1
CRN2MSD0080S04	0.8	1.6	40	4	2	●	1
CRN2MSD0080S06	0.8	1.6	45	6	2	●	1
CRN2MSD0090S04	0.9	2	40	4	2	●	1
CRN2MSD0100S04	1	2.5	40	4	2	●	1
CRN2MSD0100S06	1	2.5	45	6	2	●	1
CRN2MSD0110S04	1.1	2.5	40	4	2	●	1
CRN2MSD0120S04	1.2	3	40	4	2	●	1
CRN2MSD0120S06	1.2	3	45	6	2	●	1
CRN2MSD0130S04	1.3	3	40	4	2	●	1
CRN2MSD0140S04	1.4	3	40	4	2	●	1
CRN2MSD0150S04	1.5	4	40	4	2	●	1
CRN2MSD0150S06	1.5	4	45	6	2	●	1
CRN2MSD0160S04	1.6	4	40	4	2	●	1
CRN2MSD0170S04	1.7	4	40	4	2	●	1
CRN2MSD0180S04	1.8	5	40	4	2	●	1
CRN2MSD0190S04	1.9	5	40	4	2	●	1
CRN2MSD0200S06	2	6	45	6	2	●	1
CRN2MSD0250S06	2.5	8	45	6	2	●	1
CRN2MSD0300S06	3	8	45	6	2	●	1
CRN2MSD0400S06	4	11	45	6	2	●	1
CRN2MSD0500S06	5	13	50	6	2	●	1
CRN2MSD0600S06	6	13	50	6	2	●	2
CRN2MSD0800S08	8	19	60	8	2	●	2
CRN2MSD1000S10	10	22	70	10	2	●	2
CRN2MSD1200S12	12	26	75	12	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Copper, Copper alloys		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.2	40000	600	0.01
0.3	40000	600	0.01
0.4	40000	800	0.01
0.5	40000	960	0.015
0.6	40000	1200	0.02
0.7	40000	1400	0.02
0.8	40000	1600	0.03
0.9	40000	1800	0.04
1	40000	2000	0.06
1.5	40000	3000	0.12
2	30000	3000	0.18
2.5	24000	2600	0.25
3	20000	2300	0.30
4	15000	2000	0.40
5	12000	1600	0.50
6	10000	1400	0.60
8	8000	1000	0.80
10	6400	900	1.00
12	5400	820	1.00
Depth of cut	≤Please refer to the list above for depth of cut.  ≤DC  DC ≤Please refer to the list above for depth of cut. DC:Dia.		

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) When drilling, please set the feed rate at 1/3 or below of the table value.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

CRN2XL

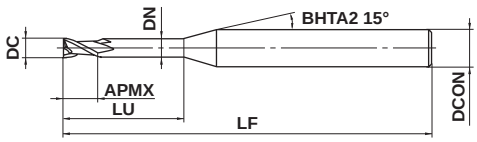
End mill, Medium cut length, 2 flute, Long neck, For copper electrodes

TOOL NEWS

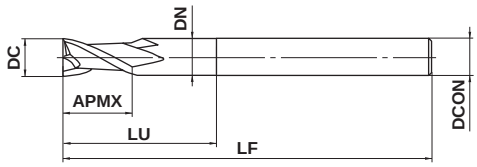
UWC CRN γ 30°

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○



Type1



Type2

0.2≤DC≤6				
0 / - 0.02				
4≤DCON≤6				
0 / - 0.008				

h6

●2 flute long neck end mill with CRN coating for copper electrode machining.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
CRN2XLD0020N005S04	0.2	0.3	0.5	0.17	50	4	2	●	1
CRN2XLD0020N005S06	0.2	0.3	0.5	0.17	50	6	2	●	1
CRN2XLD0020N010S04	0.2	0.3	1	0.17	50	4	2	●	1
CRN2XLD0020N010S06	0.2	0.3	1	0.17	50	6	2	●	1
CRN2XLD0020N015S04	0.2	0.3	1.5	0.17	50	4	2	●	1
CRN2XLD0020N015S06	0.2	0.3	1.5	0.17	50	6	2	●	1
CRN2XLD0030N010S04	0.3	0.5	1	0.27	50	4	2	●	1
CRN2XLD0030N010S06	0.3	0.5	1	0.27	50	6	2	●	1
CRN2XLD0030N030S04	0.3	0.5	3	0.27	50	4	2	●	1
CRN2XLD0030N030S06	0.3	0.5	3	0.27	50	6	2	●	1
CRN2XLD0040N020S04	0.4	0.6	2	0.36	50	4	2	●	1
CRN2XLD0040N020S06	0.4	0.6	2	0.36	50	6	2	●	1
CRN2XLD0040N040S04	0.4	0.6	4	0.36	50	4	2	●	1
CRN2XLD0040N040S06	0.4	0.6	4	0.36	50	6	2	●	1
CRN2XLD0040N060S04	0.4	0.6	6	0.36	50	4	2	●	1
CRN2XLD0040N060S06	0.4	0.6	6	0.36	50	6	2	●	1
CRN2XLD0050N020S04	0.5	0.8	2	0.46	50	4	2	●	1
CRN2XLD0050N020S06	0.5	0.8	2	0.46	50	6	2	●	1
CRN2XLD0050N040S04	0.5	0.8	4	0.46	50	4	2	●	1
CRN2XLD0050N040S06	0.5	0.8	4	0.46	50	6	2	●	1
CRN2XLD0050N060S04	0.5	0.8	6	0.46	50	4	2	●	1
CRN2XLD0050N060S06	0.5	0.8	6	0.46	50	6	2	●	1
CRN2XLD0050N080S04	0.5	0.8	8	0.46	50	4	2	●	1
CRN2XLD0050N080S06	0.5	0.8	8	0.46	50	6	2	●	1
CRN2XLD0080N040S04	0.8	1.2	4	0.76	50	4	2	●	1
CRN2XLD0080N040S06	0.8	1.2	4	0.76	50	6	2	●	1
CRN2XLD0080N060S04	0.8	1.2	6	0.76	50	4	2	●	1
CRN2XLD0080N060S06	0.8	1.2	6	0.76	50	6	2	●	1
CRN2XLD0080N080S04	0.8	1.2	8	0.76	50	4	2	●	1
CRN2XLD0080N080S06	0.8	1.2	8	0.76	50	6	2	●	1
CRN2XLD0080N100S04	0.8	1.2	10	0.76	50	4	2	●	1
CRN2XLD0080N100S06	0.8	1.2	10	0.76	50	6	2	●	1
CRN2XLD0100N060S04	1	1.5	6	0.94	50	4	2	●	1
CRN2XLD0100N060S06	1	1.5	6	0.94	50	6	2	●	1

● : Inventory maintained in Japan.

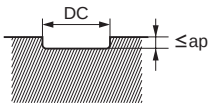
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
CRN2XLD0100N080S04	1	1.5	8	0.94	50	4	2	●	1
CRN2XLD0100N080S06	1	1.5	8	0.94	50	6	2	●	1
CRN2XLD0100N100S04	1	1.5	10	0.94	50	4	2	●	1
CRN2XLD0100N100S06	1	1.5	10	0.94	50	6	2	●	1
CRN2XLD0100N120S04	1	1.5	12	0.94	50	4	2	●	1
CRN2XLD0100N120S06	1	1.5	12	0.94	50	6	2	●	1
CRN2XLD0100N160S04	1	1.5	16	0.94	55	4	2	●	1
CRN2XLD0100N160S06	1	1.5	16	0.94	55	6	2	●	1
CRN2XLD0150N060S04	1.5	2.3	6	1.44	50	4	2	●	1
CRN2XLD0150N060S06	1.5	2.3	6	1.44	50	6	2	●	1
CRN2XLD0150N080S04	1.5	2.3	8	1.44	50	4	2	●	1
CRN2XLD0150N080S06	1.5	2.3	8	1.44	50	6	2	●	1
CRN2XLD0150N100S04	1.5	2.3	10	1.44	50	4	2	●	1
CRN2XLD0150N100S06	1.5	2.3	10	1.44	50	6	2	●	1
CRN2XLD0150N120S04	1.5	2.3	12	1.44	50	4	2	●	1
CRN2XLD0150N120S06	1.5	2.3	12	1.44	50	6	2	●	1
CRN2XLD0150N160S04	1.5	2.3	16	1.44	55	4	2	●	1
CRN2XLD0150N160S06	1.5	2.3	16	1.44	55	6	2	●	1
CRN2XLD0150N200S04	1.5	2.3	20	1.44	60	4	2	●	1
CRN2XLD0150N200S06	1.5	2.3	20	1.44	60	6	2	●	1
CRN2XLD0200N060S06	2	3.0	6	1.90	50	6	2	●	1
CRN2XLD0200N080S06	2	3.0	8	1.90	50	6	2	●	1
CRN2XLD0200N100S06	2	3.0	10	1.90	50	6	2	●	1
CRN2XLD0200N120S06	2	3.0	12	1.90	50	6	2	●	1
CRN2XLD0200N160S06	2	3.0	16	1.90	55	6	2	●	1
CRN2XLD0200N200S06	2	3.0	20	1.90	60	6	2	●	1
CRN2XLD0250N080S06	2.5	3.8	8	2.40	50	6	2	●	1
CRN2XLD0250N120S06	2.5	3.8	12	2.40	55	6	2	●	1
CRN2XLD0250N160S06	2.5	3.8	16	2.40	60	6	2	●	1
CRN2XLD0250N200S06	2.5	3.8	20	2.40	65	6	2	●	1
CRN2XLD0300N200S06	3	4.5	20	2.90	65	6	2	●	1
CRN2XLD0400N200S06	4	6.0	20	3.90	65	6	2	●	1
CRN2XLD0500N250S06	5	7.5	25	4.90	70	6	2	●	1
CRN2XLD0600N300S06	6	9.0	30	5.85	70	6	2	●	2

CRN2XL

End mill, Medium cut length, 2 flute, Long neck, For copper electrodes

RECOMMENDED CUTTING CONDITIONS

Work Material		Copper, Copper alloys		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.2	0.5	40000	800	0.004
	1.0	40000	700	0.003
	1.5	40000	600	0.002
0.3	1	40000	800	0.007
	3	40000	600	0.002
0.4	2	40000	950	0.007
	4	40000	800	0.003
	6	40000	600	0.001
0.5	2	40000	950	0.01
	4	40000	800	0.005
	6	40000	700	0.002
0.8	4	40000	1200	0.02
	6	40000	1200	0.015
	8	40000	1000	0.01
1	6	40000	2000	0.04
	8	40000	2000	0.03
	10	30000	1200	0.02
	12	30000	1000	0.015
1.5	6	40000	2400	0.10
	8	40000	2200	0.09
	10	40000	2000	0.08
	12	30000	1800	0.05
	16	20000	1200	0.03
	20	15000	800	0.02
2	6	40000	2400	0.18
	8	40000	2200	0.15
	10	40000	2000	0.12
	12	30000	1500	0.10
	16	30000	1000	0.06
	20	15000	600	0.03
2.5	8	40000	3000	0.20
	12	40000	2800	0.15
	16	30000	2100	0.10
	20	20000	1000	0.08
3	20	20000	2000	0.12
4	20	15000	2000	0.30
5	25	12000	1500	0.35
6	30	10000	1200	0.40
Depth of cut		 DC:Dia.		

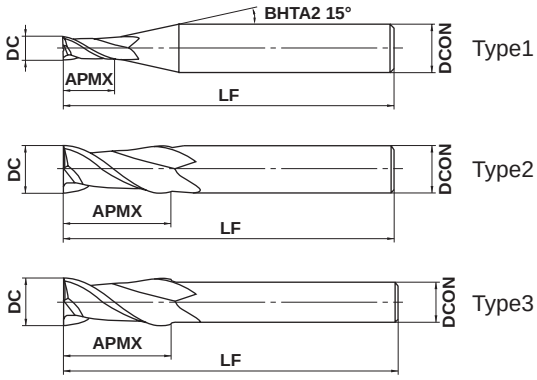
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

DLC2MA

Medium cut length, 2 flute

TOOL NEWS | UWC | DLC | 30° DC<3 | 37.5° DC≥3 | DC<3 | DC≥3

Copper Alloy	Aluminium Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎		○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●2 flute end mill with new high welding resistance DLC coating, ideal for machining non-ferrous materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DLC2MAD0100	1	2.5	40	4	2	●	1
DLC2MAD0150	1.5	4	40	4	2	●	1
DLC2MAD0200	2	6	40	4	2	●	1
DLC2MAD0250	2.5	8	40	4	2	●	1
DLC2MAD0300	3	8	45	6	2	●	1
DLC2MAD0350	3.5	10	45	6	2	●	1
DLC2MAD0400	4	11	45	6	2	●	1
DLC2MAD0450	4.5	11	45	6	2	●	1
DLC2MAD0500	5	13	50	6	2	●	1
DLC2MAD0600	6	13	50	6	2	●	2
DLC2MAD0800	8	19	60	8	2	●	2
DLC2MAD1000	10	22	70	10	2	●	2
DLC2MAD1200	12	26	75	12	2	●	2
DLC2MAD1400	14	26	75	12	2	●	3
DLC2MAD1500	15	30	80	16	2	●	1
DLC2MAD1600	16	32	90	16	2	●	2
DLC2MAD1800	18	32	90	16	2	●	3
DLC2MAD2000	20	38	100	20	2	●	2

● : Inventory maintained in Japan.

DLC2MA

Medium cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting, Copper, Copper alloys	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	600	40000	460
2	40000	1100	38000	850
3	32000	1400	25000	950
4	24000	1500	19000	1000
5	19000	1600	15000	1000
6	16000	1900	13000	1100
8	12000	1900	9500	1200
10	9500	1900	7600	1200
12	8000	1900	6400	1200
16	6000	1900	4800	1200
20	4800	1500	3800	1000
Depth of cut	≤0.2DC (DC < ϕ3) ≤0.5DC (DC ≥ ϕ3) ≤1DC DC:Dia.			

■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting, Copper, Copper alloys	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	460	40000	350
2	38000	850	32000	550
3	25000	950	21000	600
4	19000	1000	16000	650
5	15000	1000	13000	700
6	13000	1100	11000	750
8	9500	1200	8000	800
10	7600	1200	6400	800
12	6400	1200	5300	800
16	4800	1000	4000	720
20	3800	970	3200	660
Depth of cut	DC ≤1DC (MAX. 12mm) DC:Dia.			

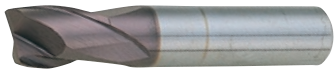
Note 1) When cutting a very hard workpiece, reduce the feed rate.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

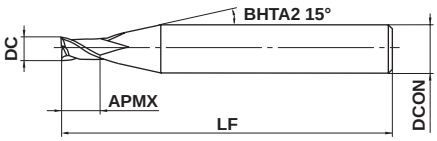
SED2KMG

End mill, Medium cut length, 2 flute, - Tolerance

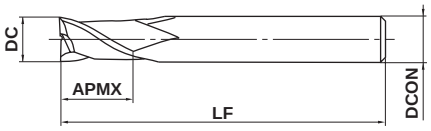
UWC MS 30° DC≤10 DC>10 DC<3 3≤DC≤10 DC≥11

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			○	○		





Type1



Type2

2≤DC≤16				
0 - 0.02				
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●2 flute end mill for key way slotting with minus tolerance cutting diameter.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
SED2020KMG	2	3	45	4	2	●	1
SED2030KMG	3	5	45	6	2	●	1
SED2040KMG	4	6	45	6	2	●	1
SED2050KMG	5	8	50	6	2	●	1
SED2060KMG	6	9	50	6	2	●	2
SED2070KMG	7	10	60	8	2	●	1
SED2080KMG	8	12	60	8	2	●	2
SED2100KMG	10	15	65	10	2	●	2
SED2120KMG	12	15	65	12	2	●	2
SED2140KMG	14	15	70	16	2	●	1
SED2150KMG	15	15	70	16	2	●	1
SED2160KMG	16	15	70	16	2	●	2

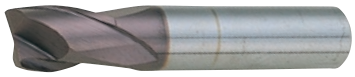
● : Inventory maintained in Japan.

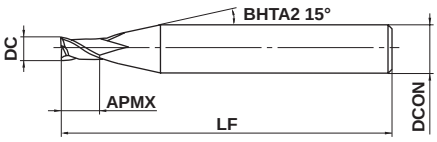
SED2KPG

End mill, Medium cut length, 2 flute, + Tolerance

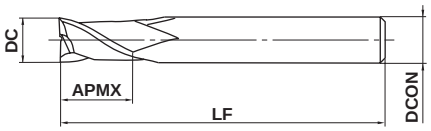
UWC MS 30° DC≤10 DC>10 DC<3 3≤DC≤10 DC≥11

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			○	○		





Type1



Type2

2≤DC≤16				
0 / + 0.02				
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

h6

●2 flute end mill for key way slotting with plus tolerance cutting diameter.

(mm)

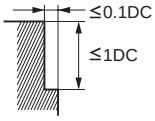
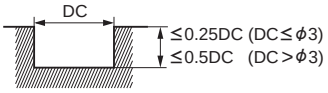
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
SED2020KPG	2	3	45	4	2	●	1
SED2030KPG	3	5	45	6	2	●	1
SED2040KPG	4	6	45	6	2	●	1
SED2050KPG	5	8	50	6	2	●	1
SED2060KPG	6	9	50	6	2	●	2
SED2070KPG	7	10	60	8	2	●	1
SED2080KPG	8	12	60	8	2	●	2
SED2100KPG	10	15	65	10	2	●	2
SED2120KPG	12	15	65	12	2	●	2
SED2140KPG	14	15	70	16	2	●	1
SED2150KPG	15	15	70	16	2	●	1
SED2160KPG	16	15	70	16	2	●	2

● : Inventory maintained in Japan.

SED2KMG
End mill, Short cut length, 2 flute, For key ways

SED2KPG
End mill, Short cut length, 2 flute, For key ways

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Alloy steel (180−280HB) AISI 1045, AISI P20		Carbon steel, Alloy steel (280−380HB) AISI 1045, AISI P20		Pre-hardened steel (35−45HRC)		Stainless steel (270HB≥) AISI 420		Cast iron (Tensile Strength 350MPa≥) AISI No 35 B	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	13000	260 (260)	10300	200 (200)	8800	110 (110)	9800	170 (170)	21500	830 (830)
3	8500	340 (340)	6900	200 (200)	6400	110 (110)	6400	170 (170)	14300	850 (850)
4	6500	380 (380)	5200	250 (200)	4400	140 (110)	4800	200 (160)	10700	860 (860)
5	5100	400 (400)	4100	290 (230)	3500	140 (110)	3800	190 (150)	8600	850 (850)
6	4300	410 (410)	3400	290 (230)	2900	150 (120)	3200	180 (140)	7200	870 (870)
8	3200	410 (410)	2600	250 (200)	2200	140 (110)	2400	150 (120)	5400	880 (880)
10	2600	400 (400)	2070	240 (190)	1800	140 (110)	1900	140 (110)	4300	860 (860)
12	2200	360 (360)	1700	210 (170)	1500	130 (100)	1600	130 (105)	3600	860 (860)
14	1900	340 (340)	1500	200 (160)	1250	130 (100)	1400	130 (100)	3100	860 (860)
16	1600	320 (320)	1300	200 (160)	1100	130 (100)	1200	120 (95)	2700	870 (870)
Depth of cut									DC:Dia.	

( ) : Indicates standard feed rate for slotting.

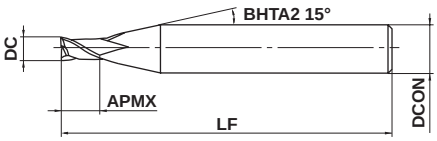
Note 1) The cutting conditions above are a guide only to milling within the standard depth of cut.
Note 2) Ductile cast iron milling has the same cutting conditions as carbon steel and alloy steel. (180−280HB)
Note 3) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2SS

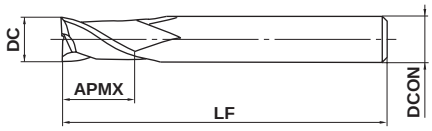
End mill, Short cut length, 2 flute

UWC 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



Type1



Type2

0.4≤DC≤6				
0 - 0.020				
4≤DCON≤6				
0 - 0.008				

h6

●2 flute end mill with short rigid geometry.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2SSD0040	0.4	0.8	40	4	2	▲	1
C2SSD0050	0.5	0.8	40	4	2	▲	1
C2SSD0060	0.6	1	40	4	2	▲	1
C2SSD0070	0.7	1	40	4	2	▲	1
C2SSD0080	0.8	1.3	40	4	2	▲	1
C2SSD0090	0.9	1.3	40	4	2	▲	1
C2SSD0100	1	1.5	40	4	2	▲	1
C2SSD0110	1.1	1.5	40	4	2	▲	1
C2SSD0120	1.2	2	40	4	2	▲	1
C2SSD0130	1.3	2	40	4	2	▲	1
C2SSD0140	1.4	2	40	4	2	▲	1
C2SSD0150	1.5	2.5	40	4	2	▲	1
C2SSD0160	1.6	2.5	40	4	2	▲	1
C2SSD0170	1.7	2.5	40	4	2	▲	1
C2SSD0180	1.8	3	40	4	2	▲	1
C2SSD0190	1.9	3	40	4	2	▲	1
C2SSD0200	2	3	40	4	2	▲	1
C2SSD0210	2.1	3	40	4	2	▲	1
C2SSD0220	2.2	3.5	40	4	2	▲	1
C2SSD0230	2.3	3.5	40	4	2	▲	1
C2SSD0240	2.4	3.5	40	4	2	▲	1
C2SSD0250	2.5	4	40	4	2	▲	1
C2SSD0260	2.6	4	40	4	2	▲	1
C2SSD0270	2.7	4	40	4	2	▲	1
C2SSD0280	2.8	4	40	4	2	▲	1
C2SSD0290	2.9	4.5	40	4	2	▲	1
C2SSD0300	3	4.5	45	6	2	▲	1
C2SSD0350	3.5	5.5	45	6	2	▲	1
C2SSD0400	4	6	45	6	2	▲	1
C2SSD0450	4.5	7	45	6	2	▲	1
C2SSD0500	5	7.5	50	6	2	▲	1
C2SSD0550	5.5	8.5	50	6	2	▲	1
C2SSD0600	6	9	50	6	2	▲	2

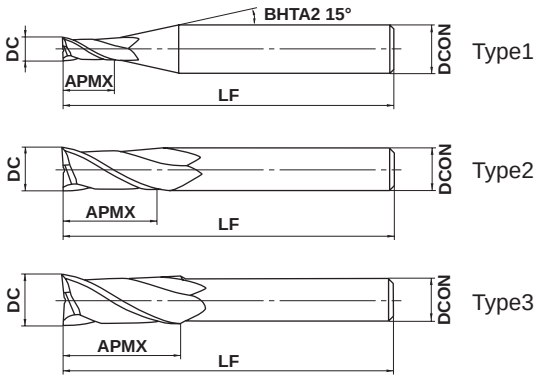
▲ : Product scheduled to be discontinued at the end of March 2020
C2SA (J102) and C2MA (J104) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MS2SS (J048) is alternative for processing of other cutting materials.

C2MS

End mill, Medium cut length, 2 flute

UWC 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MSD0100	1	2.5	40	4	2	▲	1
C2MSD0110	1.1	2.5	40	4	2	▲	1
C2MSD0120	1.2	3	40	4	2	▲	1
C2MSD0130	1.3	3	40	4	2	▲	1
C2MSD0140	1.4	3	40	4	2	▲	1
C2MSD0150	1.5	4	40	4	2	▲	1
C2MSD0160	1.6	4	40	4	2	▲	1
C2MSD0170	1.7	4	40	4	2	▲	1
C2MSD0180	1.8	5	40	4	2	▲	1
C2MSD0190	1.9	5	40	4	2	▲	1
C2MSD0200	2	6	40	4	2	▲	1
C2MSD0210	2.1	6	40	4	2	▲	1
C2MSD0220	2.2	6	40	4	2	▲	1
C2MSD0230	2.3	6	40	4	2	▲	1
C2MSD0240	2.4	8	40	4	2	▲	1
C2MSD0250	2.5	8	40	4	2	▲	1
C2MSD0260	2.6	8	40	4	2	▲	1
C2MSD0270	2.7	8	40	4	2	▲	1
C2MSD0280	2.8	8	40	4	2	▲	1
C2MSD0290	2.9	8	40	4	2	▲	1
C2MSD0300	3	8	45	6	2	▲	1
C2MSD0310	3.1	8	45	6	2	▲	1
C2MSD0320	3.2	8	45	6	2	▲	1
C2MSD0330	3.3	8	45	6	2	▲	1
C2MSD0340	3.4	10	45	6	2	▲	1
C2MSD0350	3.5	10	45	6	2	▲	1
C2MSD0360	3.6	10	45	6	2	▲	1
C2MSD0370	3.7	10	45	6	2	▲	1
C2MSD0380	3.8	11	45	6	2	▲	1
C2MSD0390	3.9	11	45	6	2	▲	1
C2MSD0400	4	11	45	6	2	▲	1
C2MSD0410	4.1	11	45	6	2	▲	1
C2MSD0420	4.2	11	45	6	2	▲	1
C2MSD0430	4.3	11	45	6	2	▲	1

▲ : Product scheduled to be discontinued at the end of March 2020
C2MA(J104) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MS2MS(J049) is alternative for processing of other cutting materials.

C2MS

End mill, Medium cut length, 2 flute

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MSD0440	4.4	11	45	6	2	▲	1
C2MSD0450	4.5	11	45	6	2	▲	1
C2MSD0460	4.6	11	45	6	2	▲	1
C2MSD0470	4.7	11	45	6	2	▲	1
C2MSD0480	4.8	13	50	6	2	▲	1
C2MSD0490	4.9	13	50	6	2	▲	1
C2MSD0500	5	13	50	6	2	▲	1
C2MSD0510	5.1	13	50	6	2	▲	1
C2MSD0520	5.2	13	50	6	2	▲	1
C2MSD0530	5.3	13	50	6	2	▲	1
C2MSD0540	5.4	13	50	6	2	▲	1
C2MSD0550	5.5	13	50	6	2	▲	1
C2MSD0560	5.6	13	50	6	2	▲	1
C2MSD0570	5.7	13	50	6	2	▲	1
C2MSD0580	5.8	13	50	6	2	▲	1
C2MSD0590	5.9	13	50	6	2	▲	1
C2MSD0600	6	13	50	6	2	▲	2
C2MSD0610	6.1	16	60	8	2	▲	1
C2MSD0620	6.2	16	60	8	2	▲	1
C2MSD0630	6.3	16	60	8	2	▲	1
C2MSD0640	6.4	16	60	8	2	▲	1
C2MSD0650	6.5	16	60	8	2	▲	1
C2MSD0660	6.6	16	60	8	2	▲	1
C2MSD0670	6.7	16	60	8	2	▲	1
C2MSD0680	6.8	16	60	8	2	▲	1
C2MSD0690	6.9	16	60	8	2	▲	1
C2MSD0700	7	16	60	8	2	▲	1
C2MSD0710	7.1	16	60	8	2	▲	1
C2MSD0720	7.2	16	60	8	2	▲	1
C2MSD0730	7.3	16	60	8	2	▲	1
C2MSD0740	7.4	16	60	8	2	▲	1
C2MSD0750	7.5	16	60	8	2	▲	1
C2MSD0760	7.6	19	60	8	2	▲	1
C2MSD0770	7.7	19	60	8	2	▲	1
C2MSD0780	7.8	19	60	8	2	▲	1
C2MSD0790	7.9	19	60	8	2	▲	1
C2MSD0800	8	19	60	8	2	▲	2
C2MSD0810	8.1	19	70	10	2	▲	1
C2MSD0820	8.2	19	70	10	2	▲	1
C2MSD0830	8.3	19	70	10	2	▲	1
C2MSD0840	8.4	19	70	10	2	▲	1
C2MSD0850	8.5	19	70	10	2	▲	1
C2MSD0860	8.6	19	70	10	2	▲	1
C2MSD0870	8.7	19	70	10	2	▲	1
C2MSD0880	8.8	19	70	10	2	▲	1
C2MSD0890	8.9	19	70	10	2	▲	1
C2MSD0900	9	19	70	10	2	▲	1
C2MSD0910	9.1	19	70	10	2	▲	1
C2MSD0920	9.2	19	70	10	2	▲	1
C2MSD0930	9.3	19	70	10	2	▲	1
C2MSD0940	9.4	19	70	10	2	▲	1
C2MSD0950	9.5	19	70	10	2	▲	1

▲ : Product scheduled to be discontinued at the end of March 2020
C2MA(J104) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MS2MS(J049) is alternative for processing of other cutting materials.

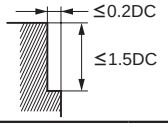
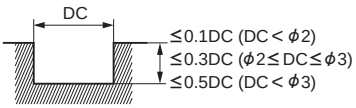
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MSD0960	9.6	22	70	10	2	▲	1
C2MSD0970	9.7	22	70	10	2	▲	1
C2MSD0980	9.8	22	70	10	2	▲	1
C2MSD0990	9.9	22	70	10	2	▲	1
C2MSD1000	10	22	70	10	2	▲	2
C2MSD1100	11	22	75	12	2	▲	1
C2MSD1200	12	26	75	12	2	▲	2
C2MSD1300	13	26	75	12	2	▲	3
C2MSD1400	14	26	75	12	2	▲	3
C2MSD1500	15	30	80	16	2	▲	1
C2MSD1600	16	32	90	16	2	▲	2
C2MSD1700	17	32	90	16	2	▲	3
C2MSD1800	18	32	90	16	2	▲	3
C2MSD1900	19	32	100	20	2	▲	1
C2MSD2000	20	38	100	20	2	▲	2

C2SS
End mill, Short cut length, 2 flute

C2MS
End mill, Medium cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1050, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI H13, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.5	17000	50 (50)	14000	45 (45)	11000	30 (30)	9000	30 (30)
1	10000	65 (65)	8500	55 (55)	6400	40 (40)	5200	35 (35)
2	5500	90 (90)	4800	80 (80)	3800	55 (55)	3100	50 (50)
3	4100	100 (100)	3500	85 (85)	2800	65 (65)	2300	60 (60)
4	3400	170 (135)	2900	140 (110)	2200	90 (70)	1900	80 (60)
5	2900	190 (150)	2400	150 (120)	1800	100 (80)	1500	90 (60)
6	2500	200 (160)	2100	170 (135)	1600	110 (90)	1300	95 (65)
8	1900	200 (160)	1600	170 (135)	1200	105 (85)	1000	100 (70)
10	1500	180 (145)	1250	150 (120)	950	95 (75)	800	90 (65)
12	1250	150 (120)	1050	130 (100)	800	80 (65)	660	75 (50)
16	940	110 (90)	800	95 (75)	600	60 (50)	500	55 (40)
20	750	90 (70)	640	80 (65)	480	50 (40)	400	45 (30)
Depth of cut	  DC:Dia.							

( ) : Indicates standard feed rate for slotting.

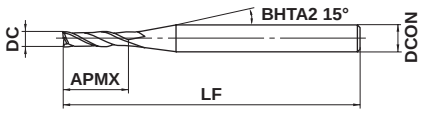
Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2JS

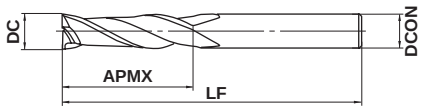
End mill, Semi long cut length, 2 flute

UWC 30° DC<3 DC≥3 DC<3 DC≥3

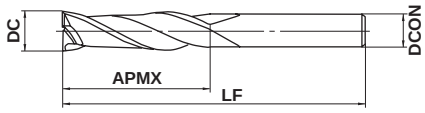
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute uncoated end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2JSD0100	1	3.5	40	4	2	▲	1
C2JSD0150	1.5	5	40	4	2	▲	1
C2JSD0200	2	8	40	4	2	▲	1
C2JSD0250	2.5	10	40	4	2	▲	1
C2JSD0300	3	12	50	6	2	▲	1
C2JSD0350	3.5	15	50	6	2	▲	1
C2JSD0400	4	15	50	6	2	▲	1
C2JSD0450	4.5	15	50	6	2	▲	1
C2JSD0500	5	20	60	6	2	▲	1
C2JSD0550	5.5	20	60	6	2	▲	1
C2JSD0600	6	20	60	6	2	▲	2
C2JSD0650	6.5	25	70	8	2	▲	1
C2JSD0700	7	25	70	8	2	▲	1
C2JSD0750	7.5	25	70	8	2	▲	1
C2JSD0800	8	25	70	8	2	▲	2
C2JSD0850	8.5	25	90	10	2	▲	1
C2JSD0900	9	25	90	10	2	▲	1
C2JSD0950	9.5	25	90	10	2	▲	1
C2JSD1000	10	30	90	10	2	▲	2
C2JSD1050	10.5	30	90	12	2	▲	1
C2JSD1100	11	30	90	12	2	▲	1
C2JSD1150	11.5	30	90	12	2	▲	1
C2JSD1200	12	30	90	12	2	▲	2
C2JSD1300	13	35	90	12	2	▲	3
C2JSD1400	14	40	110	16	2	▲	1
C2JSD1500	15	40	110	16	2	▲	1
C2JSD1600	16	50	110	16	2	▲	2
C2JSD1700	17	50	110	20	2	▲	1
C2JSD1800	18	50	110	20	2	▲	1
C2JSD1900	19	55	110	20	2	▲	1
C2JSD2000	20	55	110	20	2	▲	2
C2JSD2200	22	65	140	25	2	▲	1
C2JSD2400	24	75	140	25	2	▲	1
C2JSD2500	25	75	140	25	2	▲	2

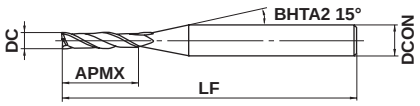
▲ : Product scheduled to be discontinued at the end of March 2020
C2LA(J106) and SEE2L(J110) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MS2JS(J054) is alternative for processing of other cutting materials.

C2LS

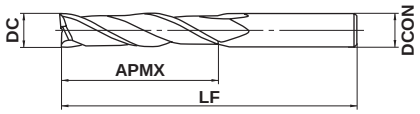
End mill, Long cut length, 2 flute

UWC γ 30°

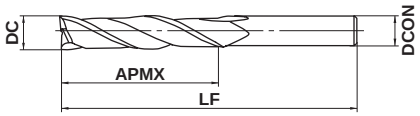
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute end mill with longer cut length than standard.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2LSD0100	1	4	40	4	2	▲	1
C2LSD0150	1.5	6	40	4	2	▲	1
C2LSD0200	2	9	40	4	2	▲	1
C2LSD0250	2.5	12	40	4	2	▲	1
C2LSD0300	3	20	60	6	2	▲	1
C2LSD0350	3.5	22	60	6	2	▲	1
C2LSD0400	4	25	60	6	2	▲	1
C2LSD0450	4.5	25	60	6	2	▲	1
C2LSD0500	5	30	70	6	2	▲	1
C2LSD0550	5.5	30	70	6	2	▲	1
C2LSD0600	6	30	70	6	2	▲	2
C2LSD0650	6.5	30	90	8	2	▲	1
C2LSD0700	7	40	90	8	2	▲	1
C2LSD0750	7.5	40	90	8	2	▲	1
C2LSD0800	8	40	90	8	2	▲	2
C2LSD0850	8.5	40	100	10	2	▲	1
C2LSD0900	9	40	100	10	2	▲	1
C2LSD0950	9.5	40	100	10	2	▲	1
C2LSD1000	10	50	100	10	2	▲	2
C2LSD1050	10.5	50	110	12	2	▲	1
C2LSD1100	11	50	110	12	2	▲	1
C2LSD1150	11.5	50	110	12	2	▲	1
C2LSD1200	12	50	110	12	2	▲	2
C2LSD1250	12.5	50	120	12	2	▲	3
C2LSD1300	13	50	120	12	2	▲	3
C2LSD1400	14	70	130	16	2	▲	1
C2LSD1500	15	70	130	16	2	▲	1
C2LSD1600	16	70	130	16	2	▲	2
C2LSD1700	17	70	140	20	2	▲	1
C2LSD1800	18	70	140	20	2	▲	1
C2LSD1900	19	70	140	20	2	▲	1
C2LSD2000	20	70	140	20	2	▲	2

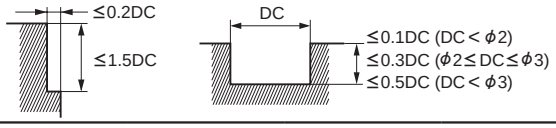
▲ : Product scheduled to be discontinued at the end of March 2020
C2LA(J1068) and SEE2L(J110) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MS2LS(J056) is alternative for processing of other cutting materials.

C2JS
End mill, Semi long cut length, 2 flute

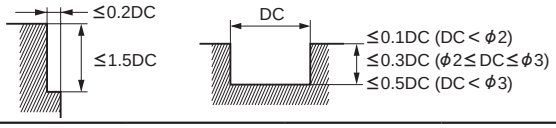
C2LS
End mill, Long cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS

C2JS

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1050, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI H13, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.5	17000	40 (40)	14000	35 (35)	11000	25 (25)	9000	25 (25)
1	10000	50 (50)	8500	40 (40)	6400	30 (30)	5200	25 (30)
2	5500	70 (70)	4800	60 (60)	3800	40 (40)	3100	40 (40)
3	4100	80 (80)	3500	65 (65)	2800	50 (50)	2300	45 (45)
4	3400	130 (100)	2900	100 (80)	2200	70 (50)	1900	60 (45)
5	2900	140 (110)	2400	110 (90)	1800	75 (60)	1500	70 (45)
6	2500	150 (120)	2100	130 (100)	1600	80 (70)	1300	70 (50)
8	1900	150 (120)	1600	130 (100)	1200	80 (65)	1000	75 (55)
10	1500	135 (110)	1300	110 (90)	950	70 (60)	800	70 (50)
12	1300	110 (90)	1100	100 (75)	800	60 (50)	660	60 (40)
16	940	80 (70)	800	70 (60)	600	45 (40)	500	40 (30)
20	750	70 (50)	640	60 (50)	480	40 (30)	400	35 (25)
Depth of cut	 DC:Dia.							

C2LS

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1050, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI H13, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.5	13000	30 (30)	11000	25 (25)	8300	16 (16)	6800	15 (15)
1	7500	35 (35)	6400	30 (30)	4800	20 (20)	3900	20 (20)
2	4100	50 (50)	3600	45 (45)	2900	30 (30)	2300	30 (30)
3	3100	55 (55)	2600	45 (45)	2100	35 (35)	1700	35 (35)
4	2600	100 (75)	2200	80 (60)	1700	50 (40)	1400	45 (35)
5	2200	100 (85)	1800	80 (65)	1400	55 (45)	1100	50 (35)
6	1900	110 (90)	1600	95 (75)	1200	60 (50)	980	55 (35)
8	1400	110 (90)	1200	95 (75)	900	60 (45)	750	55 (40)
10	1100	100 (80)	940	85 (65)	710	50 (40)	600	50 (35)
12	940	85 (65)	790	70 (55)	600	45 (35)	500	40 (30)
16	710	60 (50)	600	55 (40)	450	30 (30)	380	30 (20)
20	560	50 (40)	480	45 (35)	360	30 (20)	300	25 (16)
Depth of cut	 DC:Dia.							

( ) : Indicates standard feed rate for slotting.

Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2SA

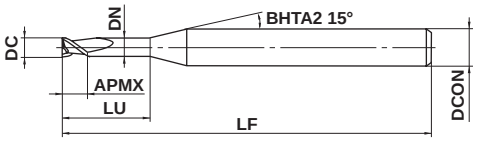
End mill, Short cut length, 2 flute, For aluminium alloy

TOOL NEWS

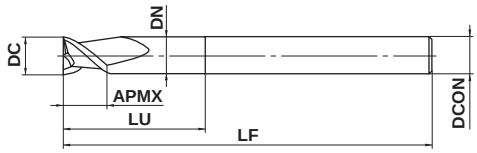
UWC

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●High efficiency machining for aluminium alloys.

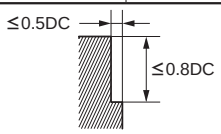
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
C2SAD0300N120	3	6	12	2.7	60	6	2	●	1
C2SAD0400N120	4	6	12	3.7	60	6	2	●	1
C2SAD0500N150	5	8	15	4.7	60	6	2	●	1
C2SAD0600N160	6	8	16	5.7	75	6	2	●	2
C2SAD0800N200	8	10	20	7.4	75	8	2	●	2
C2SAD1000N300	10	12	30	9.4	75	10	2	●	2
C2SAD1000N350	10	12	35	9.4	100	10	2	●	2
C2SAD1200N300	12	15	30	11.4	75	12	2	●	2
C2SAD1200N350	12	15	35	11.4	100	12	2	●	2
C2SAD1200N400	12	15	40	11.4	125	12	2	●	2
C2SAD1600N300	16	15	30	15.4	75	16	2	●	2
C2SAD1600N400	16	15	40	15.4	100	16	2	●	2
C2SAD1600N450	16	15	45	15.4	125	16	2	●	2
C2SAD2000N400	20	20	40	18	100	20	2	●	2
C2SAD2000N500	20	20	50	18	125	20	2	●	2

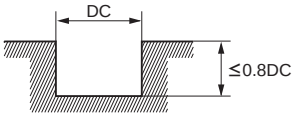
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	40000	1800
4	36000	2400
5	30000	3000
6	27000	3200
8	20000	3400
10	16000	3600
12	13000	3600
16	10000	3600
20	8000	3300
Depth of cut	 DC:Dia.	

■Slotting

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	40000	1600
4	36000	2100
5	30000	2700
6	27000	2800
8	20000	3000
10	16000	3200
12	13000	3200
16	10000	3200
20	8000	3000
Depth of cut	 DC:Dia.	

Note 1) Water-soluble cutting fluid is recommended.
Note 2) Climb cutting is recommended for side milling.
Note 3) If tool clamping is poor, the tool can be pulled out of the holder. Ensure that the tool is sufficiently clamped.
Note 4) This table shows the cutting condition with less than 4D overhang length. If more than 4D, spindle speed, feed rate and depth of cut should be reduced.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2MA

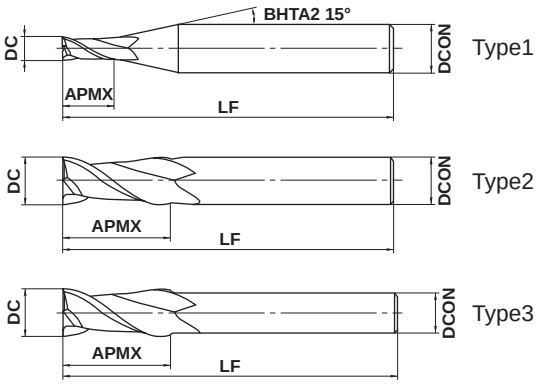
End mill, Medium cut length, 2 flute, For aluminium alloy

TOOL NEWS

UWC

30° DC<3 | 37.5° DC≥3 | DC<3 | DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute uncoated end mill designed especially for aluminium alloys.

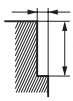
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MAD0100	1	2.5	40	4	2	●	1
C2MAD0150	1.5	4	40	4	2	●	1
C2MAD0200	2	6	40	4	2	●	1
C2MAD0250	2.5	8	40	4	2	●	1
C2MAD0300	3	8	45	6	2	●	1
C2MAD0400	4	11	45	6	2	●	1
C2MAD0500	5	13	50	6	2	●	1
C2MAD0600	6	13	50	6	2	●	2
C2MAD0800	8	19	60	8	2	●	2
C2MAD1000	10	22	70	10	2	●	2
C2MAD1200	12	26	75	12	2	●	2
C2MAD1400	14	26	75	12	2	●	3
C2MAD1500	15	30	80	16	2	●	1
C2MAD1600	16	32	90	16	2	●	2
C2MAD1800	18	32	90	16	2	●	3
C2MAD2000	20	38	100	20	2	●	2

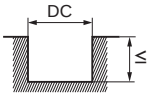
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	600	40000	460
2	40000	1100	38000	850
3	32000	1400	25000	950
4	24000	1500	19000	1000
5	19000	1600	15000	1000
6	16000	1900	13000	1100
8	12000	1900	9500	1200
10	9500	1900	7600	1200
12	8000	1900	6400	1200
16	6000	1900	4800	1200
20	4800	1500	3800	1000
Depth of cut	≤0.2DC (DC < ϕ3) ≤0.5DC (DC ≥ ϕ3)  ≤1DC DC:Dia.			

■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	460	40000	350
2	38000	850	32000	550
3	25000	950	21000	600
4	19000	1000	16000	650
5	15000	1000	13000	700
6	13000	1100	11000	750
8	9500	1200	8000	800
10	7600	1200	6400	800
12	6400	1200	5300	800
16	4800	1000	4000	720
20	3800	970	3200	660
Depth of cut	DC  ≤1DC (MAX. 12mm) DC:Dia.			

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) Climb cutting is recommended for side milling.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2LA

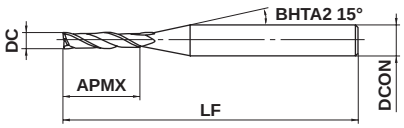
End mill, Long cut length, 2 flute, For aluminium alloy

TOOL NEWS

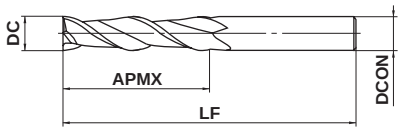
UWC

30° DC<3 | 37.5° DC≥3 | DC<3 | DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●2 flute uncoated end mill designed especially for aluminium alloys.

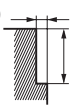
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2LAD0100	1	4	40	4	2	●	1
C2LAD0150	1.5	6	40	4	2	●	1
C2LAD0200	2	9	40	4	2	●	1
C2LAD0250	2.5	12	40	4	2	●	1
C2LAD0300	3	20	60	6	2	●	1
C2LAD0400	4	25	60	6	2	●	1
C2LAD0500	5	30	70	6	2	●	1
C2LAD0600	6	30	70	6	2	●	2
C2LAD0800	8	40	90	8	2	●	2
C2LAD1000	10	50	100	10	2	●	2
C2LAD1200	12	50	110	12	2	●	2
C2LAD1400	14	70	130	16	2	●	1
C2LAD1500	15	70	130	16	2	●	1
C2LAD1600	16	70	130	16	2	●	2
C2LAD1800	18	70	140	20	2	●	1
C2LAD2000	20	70	140	20	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Cutting speed	150m/min		120m/min	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	320	38000	240
2	24000	380	19000	240
3	16000	510	13000	330
4	12000	580	9500	380
5	9500	640	7600	400
6	8000	640	6400	400
8	6000	770	4800	480
10	4800	770	3800	480
12	4000	770	3200	480
16	3000	670	2400	430
20	2400	610	1900	390
Depth of cut	≤0.05DC (DC < ϕ3) ≤0.1DC (DC ≥ ϕ3)  ≤2.5DC DC:Dia.			

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) Climb cutting is recommended for side milling.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C2MHA

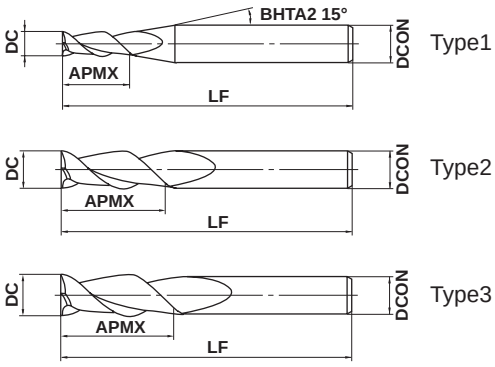
End mill, Medium cut length, 2 flute, For aluminium alloy

TOOL NEWS

UWC

55°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●High efficiency machining for aluminium alloys.

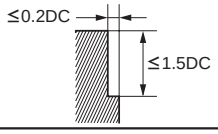
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MHAD0300	3	9	60	6	2	●	1
C2MHAD0400	4	12	60	6	2	●	1
C2MHAD0500	5	15	60	6	2	●	1
C2MHAD0600	6	18	60	6	2	●	2
C2MHAD0800	8	20	75	8	2	●	2
C2MHAD1000	10	25	75	10	2	●	2
C2MHAD1200	12	25	75	12	2	●	2
C2MHAD1400	14	32	75	12	2	●	3
C2MHAD1600	16	32	100	16	2	●	2
C2MHAD2000	20	38	125	20	2	●	2
C2MHAD2500	25	38	125	25	2	●	2

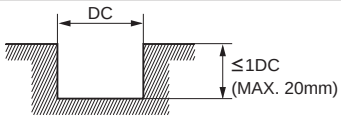
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	40000	2400
4	36000	2600
5	30000	4000
6	27000	4000
8	20000	4000
10	16000	4500
12	13000	4500
16	10000	4500
20	8000	4300
25	6000	3600
Depth of cut	 DC:Dia.	

■Slotting

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	40000	1500
4	36000	1800
5	30000	2800
6	27000	2800
8	20000	2800
10	16000	3200
12	13000	3200
16	10000	3200
20	8000	3000
25	6000	2500
Depth of cut	 DC:Dia.	

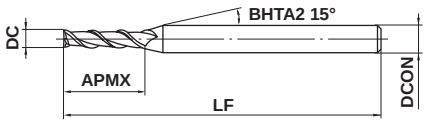
Note 1) Water-soluble cutting fluid is recommended.
Note 2) Climb cutting is recommended for side milling.
Note 3) If tool clamping is poor, the tool can be pulled out of the holder. Ensure that the tool is sufficiently clamped.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

SEE2L

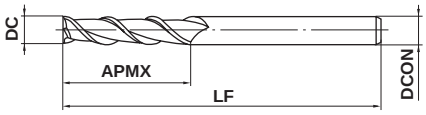
End mill, Long cut length, 2 flute

UWC 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○	○	○



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

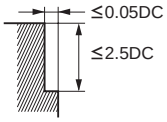
●2 flute uncoated high helix end mill.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
SEE2030L	3	15	55	6	2	●	1
SEE2040L	4	20	60	6	2	●	1
SEE2050L	5	25	65	6	2	●	1
SEE2060L	6	25	65	6	2	●	2
SEE2070L	7	35	80	8	2	●	1
SEE2080L	8	35	80	8	2	●	2
SEE2090L	9	45	90	10	2	●	1
SEE2100L	10	45	95	10	2	●	2
SEE2110L	11	55	105	12	2	●	1
SEE2120L	12	55	105	12	2	●	2
SEE2150L	15	70	125	16	2	●	1
SEE2160L	16	70	125	16	2	●	2
SEE2200L	20	75	140	20	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Alloy steel (180－280HB) AISI 1045, AISI P20		Carbon steel, Alloy steel (280－380HB) AISI 1045, AISI P20		Pre-hardened steel (35－45HRC)		Stainless steel (270HB≥) AISI 420		Cast iron (Tensile Strength 350MPa≥) AISI No 35 B	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	3400	100	3000	40	2100	20	2600	40	5500	160
4	2400	110	2200	60	1600	30	1900	50	4200	180
5	2000	120	1800	60	1300	40	1500	50	3300	200
6	1600	120	1500	60	1000	40	1300	50	2800	210
8	1200	110	1100	60	800	40	960	50	2100	210
10	1000	100	880	60	640	40	760	50	1600	210
12	800	100	760	70	520	40	640	60	1400	210
16	600	90	560	70	400	40	480	70	1000	220
20	480	80	440	80	320	40	400	70	840	230
Depth of cut	 DC:Dia.									

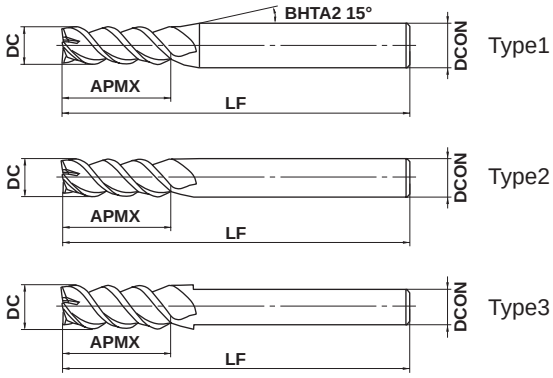
Note 1) The cutting conditions above are a guide only to milling within the standard depth of cut.
Note 2) Ductile cast iron milling has the same cutting conditions as carbon steel and alloy steel. (180－280HB)
Note 3) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MSMHZD

Slotting, Medium cut length, 3 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●A single end mill for both plunging and slotting.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MSMHZDD0100	1	2	45	4	3	●	1
MSMHZDD0150	1.5	3	45	4	3	●	1
MSMHZDD0200	2	4	50	6	3	●	1
MSMHZDD0250	2.5	5	50	6	3	●	1
MSMHZDD0300	3	6	50	6	3	●	1
MSMHZDD0350	3.5	8	50	6	3	●	1
MSMHZDD0400	4	8	50	6	3	●	1
MSMHZDD0450	4.5	10	50	6	3	●	1
MSMHZDD0500	5	10	50	6	3	●	1
MSMHZDD0550	5.5	13	50	6	3	●	1
MSMHZDD0600	6	13	60	6	3	●	2
MSMHZDD0650	6.5	16	60	8	3	●	1
MSMHZDD0700	7	16	60	8	3	●	1
MSMHZDD0750	7.5	16	60	8	3	●	1
MSMHZDD0800	8	19	70	8	3	●	2
MSMHZDD0850	8.5	19	70	10	3	●	1
MSMHZDD0900	9	19	70	10	3	●	1
MSMHZDD0950	9.5	19	70	10	3	●	1
MSMHZDD1000	10	22	80	10	3	●	2
MSMHZDD1100	11	22	80	12	3	●	1
MSMHZDD1200	12	26	90	12	3	●	2
MSMHZDD1300	13	26	90	12	3	●	3
MSMHZDD1400	14	26	90	12	3	●	3
MSMHZDD1500	15	26	110	16	3	●	1
MSMHZDD1600	16	30	110	16	3	●	2
MSMHZDD2000	20	32	140	20	3	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	19000	600	13000	310	10000	200	9500	65
1.5	14000	600	9000	310	7500	210	6400	75
2	11000	600	7200	310	6000	210	4800	75
3	8500	770	5300	380	4400	220	3200	100
4	7200	850	4400	480	3700	250	2400	130
6	5300	940	3200	490	2700	270	1600	130
8	4000	1010	2400	560	2000	280	1200	120
10	3200	1000	1900	480	1600	300	950	110
12	2700	950	1600	440	1300	300	800	90
16	2000	720	1200	350	1000	260	600	70
20	1600	600	1000	290	800	240	480	60
Depth of cut	≤0.2DC (DC>ϕ3) ≤0.1DC (DC≤ϕ3) ≤1.5DC						0.05DC 1.5DC	

DC:Dia.

■Plunging

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	13000	80	10000	50	6000	10
1.5	12000	120	8000	80	6000	20
2	11000	200	7200	140	6000	30
3	8500	250	5300	180	4200	50
4	7200	300	4400	210	3300	60
6	5300	300	3200	210	2200	70
8	4000	320	2400	220	1600	80
10	3200	340	1900	240	1300	70
12	2700	320	1600	220	1100	70
16	2000	250	1200	180	800	55
20	1600	200	1000	140	640	55
Depth of cut	≤1DC (DC≥ϕ2) ≤0.5DC (DC<ϕ2)			≤0.5DC (DC≥ϕ2) ≤0.2DC (DC<ϕ2)		

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	13000	130	10000	80	6000	30	5700	25
1.5	12000	250	8000	150	6000	60	3800	30
2	11000	500	7200	260	6000	130	2800	35
3	8500	640	5300	320	4200	130	1900	50
4	7200	650	4400	370	3300	140	1400	70
6	5300	720	3200	380	2200	140	950	70
8	4000	780	2400	430	1600	140	720	60
10	3200	770	1900	370	1300	150	570	50
12	2700	730	1600	340	1100	150	480	40
16	2000	600	1200	290	800	130	360	30
20	1600	500	1000	240	640	120	290	25
Depth of cut	DC ≤1DC (DC≥ϕ2) ≤0.5DC (DC<ϕ2)		DC ≤0.5DC (DC≥ϕ2) ≤0.2DC (DC<ϕ2)				DC 0.2DC	

DC:Dia.

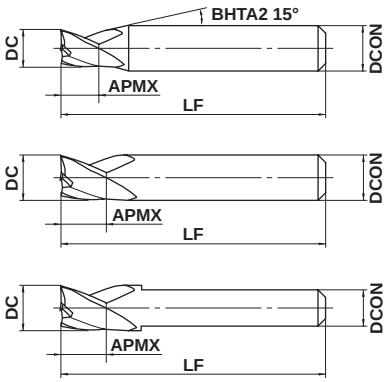
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MS3ES

End mill, 3 flute, For small automatic lathes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



3≤DC≤12				
0 - 0.020				
4≤DCON≤6	7≤DCON≤10			
0 - 0.008	0 - 0.009			

h6

●3 flute end mill.

Overall length 35mm

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS3ESD0300L35S04	3	3	35	4	3	●	1
MS3ESD0350L35S04	3.5	3.5	35	4	3	●	1
MS3ESD0400L35S04	4	4	35	4	3	●	2
MS3ESD0500L35S05	5	5	35	5	3	●	2
MS3ESD0500L35S06	5	5	35	6	3	●	1
MS3ESD0600L35S05	6	6	35	5	3	●	3
MS3ESD0600L35S06	6	6	35	6	3	●	2
MS3ESD0700L35S07	7	6	35	7	3	●	2
MS3ESD0800L35S07	8	6	35	7	3	●	3
MS3ESD0800L35S08	8	6	35	8	3	●	2
MS3ESD1000L35S07	10	6	35	7	3	●	3
MS3ESD1000L35S10	10	6	35	10	3	●	2
MS3ESD1200L35S10	12	6	35	10	3	●	3

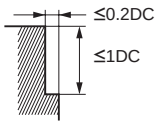
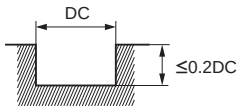
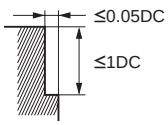
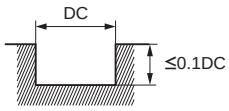
Overall length 45mm

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS3ESD0300L45S04	3	3	45	4	3	●	1
MS3ESD0350L45S04	3.5	3.5	45	4	3	●	1
MS3ESD0400L45S04	4	4	45	4	3	●	2
MS3ESD0500L45S06	5	5	45	6	3	●	1
MS3ESD0600L45S06	6	6	45	6	3	●	2
MS3ESD0700L45S07	7	7	45	7	3	●	2
MS3ESD0800L45S07	8	8	45	7	3	●	3
MS3ESD0800L45S08	8	8	45	8	3	●	2
MS3ESD1000L45S07	10	10	45	7	3	●	3
MS3ESD1000L45S10	10	10	45	10	3	●	2
MS3ESD1200L45S10	12	12	45	10	3	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	10000	600	7000	400	6000	300	5000	120
4	7500	600	5200	400	4500	300	4000	120
5	6000	600	4200	400	3600	300	3200	120
6	5000	600	3500	400	3000	300	2700	120
7	4500	560	3000	360	2700	280	2300	110
8	4000	520	2800	350	2400	260	2000	110
10	3200	450	2200	300	1900	230	1600	100
12	2700	410	1900	270	1600	210	1300	100
Depth of cut	 				 			

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

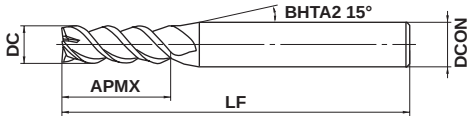
VQMHZV

End mill, Medium cutting length, 3 flute for drilling and slotting

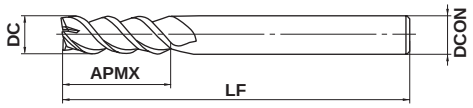
TOOL NEWS

UWC VQ 42° 43.5° 45°

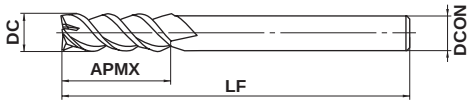
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.02	0 - 0.03			
4≤DCON≤6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

- A single end mill for both plunging and slotting.
- Irregular helical geometry controls the vibration.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHZVD0100	1	2	45	4	3	●	1
VQMHZVD0110	1.1	2.2	45	4	3	●	1
VQMHZVD0120	1.2	2.4	45	4	3	●	1
VQMHZVD0130	1.3	2.6	45	4	3	●	1
VQMHZVD0140	1.4	2.8	45	4	3	●	1
VQMHZVD0150	1.5	3	45	4	3	●	1
VQMHZVD0160	1.6	3.2	45	4	3	●	1
VQMHZVD0170	1.7	3.4	45	4	3	●	1
VQMHZVD0180	1.8	3.6	45	4	3	●	1
VQMHZVD0190	1.9	3.8	45	4	3	●	1
VQMHZVD0200	2	4	50	6	3	●	1
VQMHZVD0210	2.1	4.2	50	6	3	●	1
VQMHZVD0220	2.2	4.4	50	6	3	●	1
VQMHZVD0230	2.3	4.6	50	6	3	●	1
VQMHZVD0240	2.4	4.8	50	6	3	●	1
VQMHZVD0250	2.5	5	50	6	3	●	1
VQMHZVD0260	2.6	5.2	50	6	3	●	1
VQMHZVD0270	2.7	5.4	50	6	3	●	1
VQMHZVD0280	2.8	5.6	50	6	3	●	1
VQMHZVD0290	2.9	5.8	50	6	3	●	1
VQMHZVD0300	3	6	50	6	3	●	1
VQMHZVD0310	3.1	7	50	6	3	●	1
VQMHZVD0320	3.2	7	50	6	3	●	1
VQMHZVD0330	3.3	7	50	6	3	●	1
VQMHZVD0340	3.4	7	50	6	3	●	1
VQMHZVD0350	3.5	8	50	6	3	●	1
VQMHZVD0360	3.6	8	50	6	3	●	1
VQMHZVD0370	3.7	8	50	6	3	●	1
VQMHZVD0380	3.8	8	50	6	3	●	1
VQMHZVD0390	3.9	8	50	6	3	●	1
VQMHZVD0400	4	8	50	6	3	●	1
VQMHZVD0450	4.5	10	50	6	3	●	1

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHZVD0500	5	10	50	6	3	●	1
VQMHZVD0550	5.5	13	50	6	3	●	1
VQMHZVD0600	6	13	60	6	3	●	2
VQMHZVD0650	6.5	16	60	8	3	●	1
VQMHZVD0700	7	16	60	8	3	●	1
VQMHZVD0750	7.5	16	60	8	3	●	1
VQMHZVD0800	8	19	70	8	3	●	2
VQMHZVD0850	8.5	19	70	10	3	●	1
VQMHZVD0900	9	19	70	10	3	●	1
VQMHZVD0950	9.5	19	70	10	3	●	1
VQMHZVD1000	10	22	80	10	3	●	2
VQMHZVD1100	11	22	80	12	3	●	1
VQMHZVD1200	12	26	90	12	3	●	2
VQMHZVD1300	13	26	90	12	3	●	3
VQMHZVD1400	14	26	90	12	3	●	3
VQMHZVD1500	15	26	110	16	3	●	1
VQMHZVD1600	16	30	110	16	3	●	2
VQMHZVD2000	20	32	140	20	3	●	2

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

VQMHZV

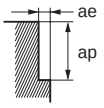
End mill, Medium cutting length, 3 flute for drilling and slotting

RECOMMENDED CUTTING CONDITIONS

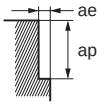
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	100	32000	720	1.5	0.2	80	25000	530	1.5	0.2	60	19000	430	1.5	0.2	50	16000	340	1.5	0.1
1.5	130	28000	1300	2.25	0.3	100	21000	630	2.25	0.3	85	18000	540	2.25	0.3	65	14000	420	2.25	0.15
2	150	24000	1800	3	0.6	120	19000	860	3	0.6	100	16000	620	3	0.6	75	12000	540	3	0.4
3	150	16000	1900	4.5	0.9	120	13000	940	4.5	0.9	100	11000	660	4.5	0.9	75	8000	580	4.5	0.6
4	150	12000	2000	6	1.2	120	9500	940	6	1.2	100	8000	670	6	1.2	75	6000	590	6	0.8
5	150	9500	1900	7.5	1.5	120	7600	960	7.5	1.5	100	6400	670	7.5	1.5	75	4800	600	7.5	1
6	150	8000	1900	9	1.8	120	6400	960	9	1.8	100	5300	830	9	1.8	75	4000	600	9	1.2
8	150	6000	1900	12	2.4	120	4800	1000	12	2.4	100	4000	900	12	2.4	75	3000	630	12	1.6
10	150	4800	1700	15	3	120	3800	910	15	3	100	3200	960	15	3	75	2400	580	15	2
12	150	4000	1400	18	3.6	120	3200	860	18	3.6	100	2700	890	18	3.6	75	2000	540	18	2.4
16	150	3000	1200	24	4.8	120	2400	720	24	4.8	100	2000	720	24	4.8	75	1500	450	24	3.2
20	150	2400	970	30	6	120	1900	570	30	6	100	1600	580	30	6	75	1200	360	30	4
Depth of cut																				

General-purpose conditions

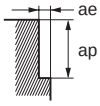
Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	100	32000	480	1.5	0.2	80	25000	350	1.5	0.2	60	19000	280	1.5	0.2	50	16000	220	1.5	0.1
1.5	120	25000	740	2.25	0.3	100	21000	420	2.25	0.3	80	17000	340	2.25	0.3	65	14000	280	2.25	0.15
2	120	19000	940	3	0.6	100	16000	480	3	0.6	80	13000	340	3	0.6	70	11000	330	3	0.4
3	120	13000	1000	4.5	0.9	100	11000	520	4.5	0.9	80	8500	340	4.5	0.9	70	7400	350	4.5	0.6
4	120	9500	1000	6	1.2	100	8000	520	6	1.2	80	6400	350	6	1.2	70	5600	370	6	0.8
5	120	7600	980	7.5	1.5	100	6400	530	7.5	1.5	80	5100	350	7.5	1.5	70	4500	370	7.5	1
6	120	6400	1000	9	1.8	100	5300	540	9	1.8	80	4200	400	9	1.8	70	3700	370	9	1.2
8	120	4800	1000	12	2.4	100	4000	550	12	2.4	80	3200	430	12	2.4	70	2800	390	12	1.6
10	120	3800	900	15	3	100	3200	510	15	3	80	2500	450	15	3	70	2200	350	15	2
12	120	3200	760	18	3.6	100	2700	480	18	3.6	80	2100	420	18	3.6	70	1900	340	18	2.4
16	120	2400	640	24	4.8	100	2000	400	24	4.8	80	1600	340	24	4.8	70	1400	280	24	3.2
20	120	1900	510	30	6	100	1600	320	30	6	80	1300	270	30	6	70	1100	220	30	4
Depth of cut																				

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the feed rate can be increased.

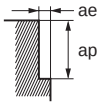
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency cutting conditions

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	120	38000	860	1.5	0.2	40	13000	160	1.5	0.05
1.5	150	32000	1400	2.25	0.3	40	8500	170	2.25	0.08
2	180	29000	2200	3	0.6	40	6400	170	3	0.2
3	180	19000	2300	4.5	0.9	40	4200	180	4.5	0.3
4	180	14000	2300	6	1.2	40	3200	180	6	0.4
5	180	11000	2300	7.5	1.5	40	2500	180	7.5	0.5
6	180	9500	2300	9	1.8	40	2100	190	9	0.6
8	180	7200	2300	12	2.4	40	1600	190	12	0.8
10	180	5700	2100	15	3	40	1300	220	15	1
12	180	4800	1700	18	3.6	40	1100	210	18	1.2
16	180	3600	1500	24	4.8	40	800	150	24	1.6
20	180	2900	1200	30	6	40	640	120	30	2
Depth of cut										

General-purpose conditions

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	120	38000	560	1.5	0.2	30	9500	75	1.5	0.05
1.5	140	30000	890	2.25	0.3	30	6400	82	2.25	0.07
2	140	22000	1100	3	0.6	30	4800	86	3	0.2
3	140	15000	1200	4.5	0.9	30	3200	89	4.5	0.3
4	140	11000	1200	6	1.2	30	2400	90	6	0.4
5	140	8900	1200	7.5	1.5	30	1900	90	7.5	0.5
6	140	7400	1200	9	1.8	30	1600	95	9	0.6
8	140	5600	1200	12	2.4	30	1200	95	12	0.8
10	140	4500	1100	15	3	30	950	110	15	1
12	140	3700	880	18	3.6	30	800	100	18	1.2
16	140	2800	750	24	4.8	30	600	76	24	1.6
20	140	2200	590	30	6	30	480	61	30	2
Depth of cut										

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

VQMHZV

End mill, Medium cutting length, 3 flute for drilling and slotting

RECOMMENDED CUTTING CONDITIONS

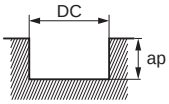
■Slotting

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
1	100	32000	380	0.5	80	25000	150	0.5	60	19000	100	0.5	45	14000	80	0.3	120	38000	460	0.5	30	9500	60	0.2
1.5	130	28000	590	0.75	100	21000	250	0.75	85	18000	220	0.75	60	12000	140	0.4	150	32000	670	0.75	30	6400	80	0.3
2	150	24000	940	2	120	19000	460	2	100	16000	480	2	60	9500	230	1	180	29000	1100	2	30	4800	100	0.6
3	150	16000	1100	3	120	13000	550	3	100	11000	500	3	60	6400	270	1.5	180	19000	1300	3	30	3200	120	0.9
4	150	12000	1400	4	120	9500	680	4	100	8000	530	4	60	4800	350	2	180	14000	1700	4	30	2400	130	1.2
5	150	9500	1400	5	120	7600	680	5	100	6400	540	5	60	3800	350	2.5	180	11000	1700	5	30	1900	130	1.5
6	150	8000	1400	6	120	6400	770	6	100	5300	560	6	60	3200	380	3	180	9500	1700	6	30	1600	130	1.8
8	150	6000	1300	8	120	4800	720	8	100	4000	600	8	60	2400	360	4	180	7200	1500	8	30	1200	140	2.4
10	150	4800	1200	10	120	3800	630	10	100	3200	670	10	60	1900	310	5	180	5700	1400	10	30	950	160	3
12	150	4000	960	12	120	3200	580	12	100	2700	650	12	60	1600	290	6	180	4800	1200	12	30	800	150	3.6
16	150	3000	810	12	120	2400	500	12	100	2000	480	12	60	1200	250	8	180	3600	970	12	30	600	120	4.8
20	150	2400	650	12	120	1900	400	12	100	1600	380	12	60	950	200	10	180	2900	780	12	30	480	90	6

Depth of cut

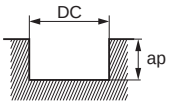


DC:Dia.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
1	100	32000	250	0.5	80	25000	99	0.5	60	19000	80	0.5	45	14000	60	0.3	120	38000	300	0.5	25	8000	30	0.2
1.5	100	21000	290	0.75	80	17000	130	0.75	60	13000	100	0.75	50	11000	87	0.4	120	25000	350	0.75	25	5300	40	0.3
2	100	16000	410	2	80	13000	210	2	60	9500	190	2	50	8000	130	1	120	19000	490	2	25	4000	55	0.6
3	100	11000	500	3	80	8500	240	3	60	6400	190	3	50	5300	150	1.5	120	13000	590	3	25	2700	64	0.9
4	100	8000	630	4	80	6400	300	4	60	4800	210	4	50	4000	190	2	120	9500	750	4	25	2000	70	1.2
5	100	6400	630	5	80	5100	300	5	60	3800	210	5	50	3200	190	2.5	120	7600	750	5	25	1600	71	1.5
6	100	5300	630	6	80	4200	330	6	60	3200	220	6	50	2700	210	3	120	6400	760	6	25	1300	72	1.8
8	100	4000	550	8	80	3200	320	8	60	2400	240	8	50	2000	200	4	120	4800	670	8	25	990	78	2.4
10	100	3200	510	10	80	2500	270	10	60	1900	260	10	50	1600	170	5	120	3800	600	10	25	800	89	3
12	100	2700	430	12	80	2100	250	12	60	1600	250	12	50	1300	150	6	120	3200	510	12	25	660	84	3.6
16	100	2000	360	12	80	1600	220	12	60	1200	190	12	50	990	140	8	120	2400	430	12	25	500	63	4.8
20	100	1600	290	12	80	1300	180	12	60	950	150	12	50	800	110	10	120	1900	340	12	25	400	50	6

Depth of cut



DC:Dia.

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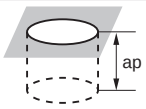
Note 4) When the depth of cut is smaller than shown the feed rate can be increased.

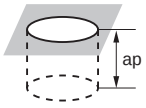
■ Plunging

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH					Copper, Copper alloy				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
1	65	20000	160	0.5	0.1	50	16000	100	0.5	0.1	50	16000	50	0.5	0.05	30	9500	30	0.5	0.05	75	24000	190	0.5	0.1
1.5	85	18000	270	0.75	0.3	60	13000	120	0.75	0.3	60	13000	80	0.75	0.1	35	7400	40	0.75	0.1	100	21000	320	0.75	0.3
2	100	16000	480	2	0.5	70	11000	200	2	0.4	60	9500	90	1	0.15	40	6400	60	1	0.1	120	19000	570	2	0.5
3	100	11000	660	3	1	70	7400	270	3	0.6	60	6400	100	1.5	0.2	40	4200	60	1.5	0.2	120	13000	780	3	1.0
4	100	8000	800	4	2	70	5600	340	4	0.8	60	4800	100	2	0.4	40	3200	60	2	0.4	120	9500	950	4	2
5	100	6400	960	5	2.5	70	4500	410	5	1	60	3800	100	2.5	0.5	40	2500	60	2.5	0.5	120	7600	1100	5	2.5
6	100	5300	950	6	3	70	3700	440	6	1.2	60	3200	100	3	0.6	40	2100	60	3	0.6	120	6400	1200	6	3
8	100	4000	720	8	4	70	2800	340	8	1.6	60	2400	70	4	0.6	40	1600	50	4	0.6	120	4800	860	8	4
10	100	3200	580	10	5	70	2200	260	10	2.5	60	1900	60	5	0.6	40	1300	40	5	0.6	120	3800	680	10	5
12	100	2700	490	12	5	70	1900	230	12	3	60	1600	50	6	0.6	40	1100	30	6	0.6	120	3200	580	12	5
16	100	2000	360	16	5	70	1400	170	16	4	60	1200	40	8	0.6	40	800	20	8	0.6	120	2400	430	16	5
20	100	1600	290	20	5	70	1100	130	20	5	60	950	30	10	0.6	40	640	20	10	0.6	120	1900	340	20	5
Depth of cut																									

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH					Copper, Copper alloy				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
1	65	20000	160	0.5	0.05	50	16000	100	0.5	0.05	50	16000	50	0.5	0.05	30	9500	30	0.5	0.05	75	24000	190	0.5	0.05
1.5	85	18000	270	0.75	0.15	60	13000	120	0.75	0.1	60	13000	80	0.75	0.05	35	7400	40	0.75	0.05	100	21000	320	0.75	0.15
2	100	16000	480	2	0.25	70	11000	200	2	0.2	60	9500	90	1	0.05	40	6400	60	1	0.05	120	19000	570	2	0.25
3	100	11000	660	3	0.3	70	7400	270	3	0.3	60	6400	100	1.5	0.1	40	4200	60	1.5	0.1	120	13000	780	3	0.3
4	100	8000	800	4	0.4	70	5600	340	4	0.4	60	4800	100	2	0.2	40	3200	60	2	0.2	120	9500	950	4	0.4
5	100	6400	960	5	0.5	70	4500	410	5	0.5	60	3800	100	2.5	0.25	40	2500	60	2.5	0.25	120	7600	1100	5	0.5
6	100	5300	950	6	0.6	70	3700	440	6	0.6	60	3200	100	3	0.3	40	2100	60	3	0.3	120	6400	1200	6	0.6
8	100	4000	720	8	0.7	70	2800	340	8	0.7	60	2400	70	4	0.3	40	1600	50	4	0.3	120	4800	860	8	0.7
10	100	3200	580	10	0.75	70	2200	260	10	0.75	60	1900	60	5	0.3	40	1300	40	5	0.3	120	3800	680	10	0.75
12	100	2700	490	12	0.75	70	1900	230	12	0.75	60	1600	50	6	0.3	40	1100	30	6	0.3	120	3200	580	12	0.75
16	100	2000	360	16	0.75	70	1400	170	16	0.75	60	1200	40	8	0.3	40	800	20	8	0.3	120	2400	430	16	0.75
20	100	1600	290	20	0.75	70	1100	130	20	0.75	60	950	30	10	0.3	40	640	20	10	0.3	120	1900	340	20	0.75
Depth of cut																									

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.

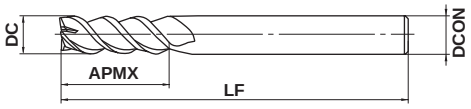
VQMHZVOH

End mill, Medium cutting length, 3 flute for drilling and slotting with internal through coolant holes

TOOL NEWS

UWC VQ 42° 43.5° 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



Type1

DC≤12	DC=16			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

- A single end mill for both plunging and slotting.
- Excellent peformance in slotting and pocketing with oil supply from the end cutting edge.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHZVOHD0600	6	13	60	6	3	●	1
VQMHZVOHD0800	8	19	70	8	3	●	1
VQMHZVOHD1000	10	22	80	10	3	●	1
VQMHZVOHD1200	12	26	90	12	3	●	1
VQMHZVOHD1600	16	30	110	16	3	●	1

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

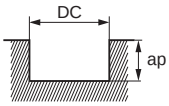
■ Slotting

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
6	150	8000	1400	6	120	6400	770	6	100	5300	560	6	60	3200	380	3	180	9500	1700	6	30	1600	130	1.8
8	150	6000	1300	8	120	4800	720	8	100	4000	600	8	60	2400	360	4	180	7200	1500	8	30	1200	140	2.4
10	150	4800	1200	10	120	3800	630	10	100	3200	670	10	60	1900	310	5	180	5700	1400	10	30	950	160	3
12	150	4000	960	12	120	3200	580	12	100	2700	650	12	60	1600	290	6	180	4800	1200	12	30	800	150	3.6
16	150	3000	810	12	120	2400	500	12	100	2000	480	12	60	1200	250	8	180	3600	970	12	30	600	120	4.8

Depth of cut

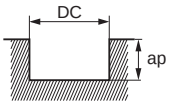


DC:Dia.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
6	100	5300	630	6	80	4200	330	6	60	3200	220	6	50	2700	210	3	120	6400	760	6	25	1300	72	1.8
8	100	4000	550	8	80	3200	320	8	60	2400	240	8	50	2000	200	4	120	4800	670	8	25	990	78	2.4
10	100	3200	510	10	80	2500	270	10	60	1900	260	10	50	1600	170	5	120	3800	600	10	25	800	89	3
12	100	2700	430	12	80	2100	250	12	60	1600	250	12	50	1300	150	6	120	3200	510	12	25	660	84	3.6
16	100	2000	360	12	80	1600	220	12	60	1200	190	12	50	990	140	8	120	2400	430	12	25	500	63	4.8

Depth of cut



DC:Dia.

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the feed rate can be increased.

VQMHZVOH

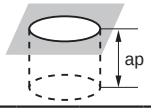
End mill, Medium cutting length, 3 flute for drilling and slotting with internal through coolant holes

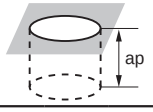
RECOMMENDED CUTTING CONDITIONS

■ Plunging

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
6	100	5300	950	9	3	70	3700	440	9	1.2	60	3200	100	6	0.6	40	2100	60	6	0.6
8	100	4000	720	12	4	70	2800	340	12	1.6	60	2400	70	8	0.6	40	1600	50	8	0.6
10	100	3200	580	15	5	70	2200	260	15	2.5	60	1900	60	10	0.6	40	1300	40	10	0.6
12	100	2700	490	18	5	70	1900	230	18	3	60	1600	50	12	0.6	40	1100	30	12	0.6
16	100	2000	360	24	5	70	1400	170	24	4	60	1200	40	16	0.6	40	800	20	16	0.6
Depth of cut																				

Work Material	Copper, Copper alloy				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
6	120	6400	1200	9	3
8	120	4800	860	12	4
10	120	3800	680	15	5
12	120	3200	580	18	5
16	120	2400	430	24	5
Depth of cut					

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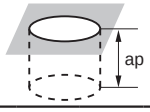
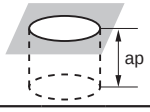
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				
Dia. **DC** (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
6	100	5300	950	9	0.6	70	3700	440	9	0.6	60	3200	100	6	0.3	40	2100	60	6	0.3
8	100	4000	720	12	0.7	70	2800	340	12	0.7	60	2400	70	8	0.3	40	1600	50	8	0.3
10	100	3200	580	15	0.75	70	2200	260	15	0.75	60	1900	60	10	0.3	40	1300	40	10	0.3
12	100	2700	490	18	0.75	70	1900	230	18	0.75	60	1600	50	12	0.3	40	1100	30	12	0.3
16	100	2000	360	24	0.75	70	1400	170	24	0.75	60	1200	40	16	0.3	40	800	20	16	0.3
Depth of cut																				

Work Material	Copper, Copper alloy				
Dia. **DC** (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Step (mm)
6	120	6400	1200	9	0.6
8	120	4800	860	12	0.7
10	120	3800	680	15	0.75
12	120	3200	580	18	0.75
16	120	2400	430	24	0.75
Depth of cut					

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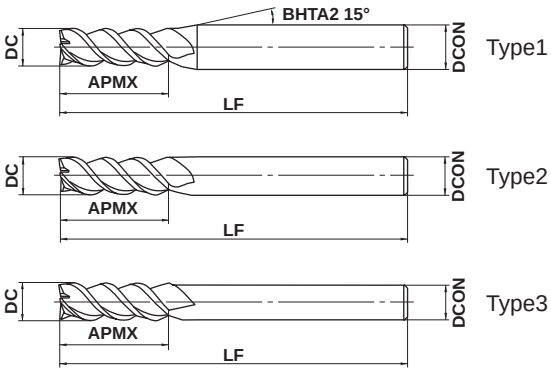
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.

VCMH

End mill, Medium cut length, 3—4 flute, High helix angle

UWC VC 50° DC≤18 DC≥20

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○	○		◎	◎		



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

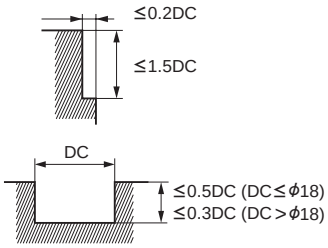
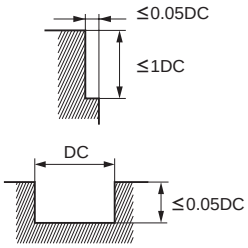
●3—4 flute end mill for milling difficult-to-cut and soft materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VCMHD0300	3	8	45	6	3	●	1
VCMHD0400	4	11	45	6	3	●	1
VCMHD0500	5	13	50	6	3	●	1
VCMHD0600	6	13	50	6	3	●	2
VCMHD0700	7	16	60	8	3	●	1
VCMHD0800	8	19	60	8	3	●	2
VCMHD0900	9	19	70	10	3	●	1
VCMHD1000	10	22	70	10	3	●	2
VCMHD1100	11	22	75	12	3	●	1
VCMHD1200	12	26	75	12	3	●	2
VCMHD1300	13	26	75	12	3	●	3
VCMHD1400	14	26	75	12	3	●	3
VCMHD1500	15	30	80	16	3	●	1
VCMHD1600	16	32	90	16	3	●	2
VCMHD1800	18	32	90	16	3	●	3
VCMHD2000	20	38	100	20	4	●	2
VCMHD2500	25	45	120	25	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45－55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	5300	130	4400	100	2400	50	1500	25
4	4400	220	3700	160	2000	80	1300	40
5	3600	260	3000	190	1700	100	1100	50
6	3200	280	2700	200	1500	100	1000	50
8	2400	300	2000	210	1200	110	800	45
10	1900	290	1600	210	960	115	640	45
12	1600	250	1300	170	800	95	530	40
16	1200	180	1000	130	600	70	400	30
18	1100	170	900	120	530	65	350	25
20	960	190	800	140	480	75	320	25
25	760	150	640	110	380	60	260	20
Depth of cut								

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The above table shows cutting conditions for side milling. For slotting, please set the revolution at 80－100% and the feed rate at 60－80% of the table figure. Please set the revolution rate at 60% and the feed rate at 40% when slotting austenitic stainless steels.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C3SA

End mill, Short cut length, 3 flute, For aluminium alloy

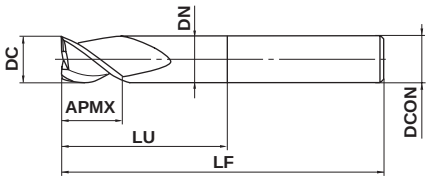
TOOL NEWS

UWC

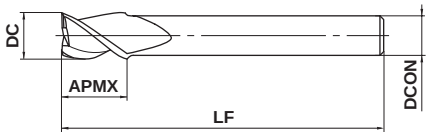
37.5°

Non-center Cutting Center Cutting

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
8≤DCON≤10	12≤DCON≤16	20≤DCON≤25		
0 - 0.009	0 - 0.011	0 - 0.013		

h6

●High efficiency machining for aluminium alloys.

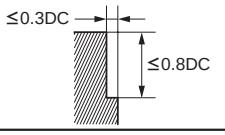
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type	Center cutting edge
C3SAD1000A100S08	10	12	—	—	100	8	3	●	2	○
C3SAD1000N300	10	12	30	9.4	75	10	3	●	1	—
C3SAD1000N350	10	12	35	9.4	100	10	3	●	1	—
C3SAD1200A150S10	12	15	—	—	150	10	3	●	2	○
C3SAD1200N300	12	15	30	11.4	75	12	3	●	1	—
C3SAD1200N350	12	15	35	11.4	100	12	3	●	1	—
C3SAD1200N400	12	15	40	11.4	125	12	3	●	1	—
C3SAD1600A200S14	16	15	—	—	200	14	3	●	2	○
C3SAD1600N300	16	15	30	15.4	75	16	3	●	1	—
C3SAD1600N400	16	15	40	15.4	100	16	3	●	1	—
C3SAD1600N450	16	15	45	15.4	125	16	3	●	1	—
C3SAD1700A150S16	17	18	—	—	150	16	3	●	2	○
C3SAD1800A200S16	18	18	—	—	200	16	3	●	2	○
C3SAD2000A200S18	20	20	—	—	200	18	3	●	2	○
C3SAD2000N400	20	20	40	18	100	20	3	●	1	—
C3SAD2000N600	20	20	60	18	125	20	3	●	1	—
C3SAD2000N850	20	20	85	18	150	20	3	●	1	—
C3SAD2500N500	25	20	50	23	100	25	3	●	1	—
C3SAD2500N650	25	20	65	23	125	25	3	●	1	—
C3SAD2500N900	25	20	90	23	150	25	3	●	1	—
C3SAD2600A200S25	26	20	—	—	200	25	3	●	2	○

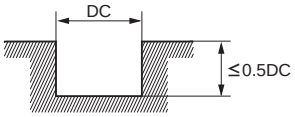
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
12	13000	5400
16	10000	5400
18	9000	5000
20	8000	5000
25	6000	4500
Depth of cut	 DC:Dia.	

■Slotting

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
12	13000	3200
16	10000	3200
18	9000	3000
20	8000	3000
25	6000	2800
Depth of cut	 DC:Dia.	

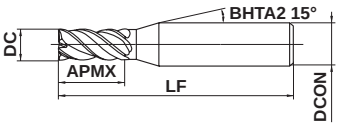
Note 1) Water-soluble cutting fluid is recommended.
Note 2) Climb cutting is recommended for side milling.
Note 3) This table shows the cutting condition with less than 4D overhang length. If more than 4D, spindle speed, feed rate and depth of cut should be reduced.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

MPMHV

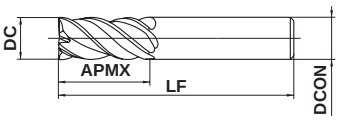
End mill, Medium cut length, 4 flute, Irregular helix flutes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		◎	○	○	



Type1



Type2

DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=4	DCON=6	DCON=8		
0 - 0.005	0 - 0.005	0 - 0.006		
DCON=6(DC=8)	DCON=8(DC=10)	DCON=10	12≤DCON≤16	DCON=20
0 - 0.008	0 - 0.009	0 - 0.009	0 - 0.011	0 - 0.013

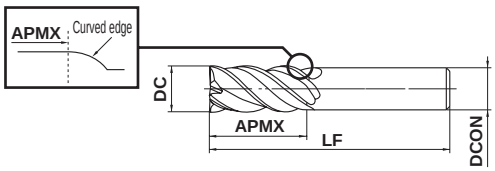
h5

h6

●flute irregular helix end mill for reduced vibration when machining stainless steels and carbon steels.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MPMHVD0100	1	2.5	45	4	4	●	1
MPMHVD0150	1.5	3.8	45	4	4	●	1
MPMHVD0200	2	5	45	4	4	●	1
MPMHVD0250	2.5	6.3	45	4	4	●	1
MPMHVD0300	3	7.5	45	6	4	●	1
MPMHVD0400	4	10	45	6	4	●	1
MPMHVD0500	5	12.5	50	6	4	●	1
MPMHVD0600	6	15	60	6	4	●	2
MPMHVD0700	7	17.5	70	8	4	●	2
MPMHVD0800	8	20	70	8	4	●	2
MPMHVD1000	10	25	80	10	4	●	2
MPMHVD1200	12	30	100	12	4	●	2
MPMHVD1600	16	40	110	16	4	●	2
MPMHVD2000	20	50	125	20	4	●	2



Type3

■Slim Shank

	Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
NEW	MPMHVD0700S06	7	17.5	80	6	4	●	3
	MPMHVD0800S06	8	20	90	6	4	●	3
NEW	MPMHVD0900S08	9	22.5	90	8	4	●	3
	MPMHVD1000S08	10	25	100	8	4	●	3
	MPMHVD1100S10	11	28	100	10	4	●	3
	MPMHVD1200S10	12	30	110	10	4	●	3
	MPMHVD1300S12	13	32	110	12	4	●	3
NEW	MPMHVD1400S12	14	35	130	12	4	●	3
NEW	MPMHVD1800S16	18	45	150	16	4	●	3
NEW	MPMHVD2200S20	22	55	160	20	4	●	3

CUTTING CONDITIONS ➤ J132

● : Inventory maintained in Japan.

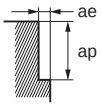
RECOMMENDED CUTTING CONDITIONS

■Side milling

*Please refer to page J132 for cutting conditions of slim shank.

Work Material	Carbon steel, Alloy steel (180−280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450				Carbon steel, Alloy steel (280−350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT				Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V				Hardened steel (45−55HRC) AISI H13, AISI L6			
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	38000	910	1.7	0.2	31000	500	1.7	0.2	25000	500	1.7	0.2	18000	290	1.7	0.05
1.5	27000	970	2.5	0.3	22000	530	2.5	0.3	18000	500	2.5	0.3	13000	310	2.5	0.08
2	21000	1500	3.5	0.4	17000	820	3.5	0.4	14000	640	3.5	0.4	10000	320	3.5	0.1
2.5	18000	1700	4.2	0.5	15000	900	4.2	0.5	12000	820	4.2	0.5	8500	360	4.2	0.13
3	16000	1800	5	0.6	13000	940	5	0.6	11000	880	5	0.6	7400	380	5	0.15
4	12000	1700	7	0.8	9500	950	7	0.8	8000	900	7	0.8	5600	400	7	0.2
5	9500	1800	8.5	1	7600	1100	8.5	1	6400	900	8.5	1	4500	430	8.5	0.25
6	8000	2100	10	1.2	6400	1300	10	1.2	5300	1100	10	1.2	3700	440	10	0.3
7	6800	2000	12	1.4	5500	1400	12	1.4	4500	1200	12	1.4	3200	450	12	0.35
8	6000	2000	13.5	1.6	4800	1400	13.5	1.6	4000	1200	13.5	1.6	2800	450	13.5	0.4
10	4800	2100	17	2	3800	1500	17	2	3200	1100	17	2	2200	440	17	0.5
12	4000	1900	20.5	2.4	3200	1400	20.5	2.4	2700	1100	20.5	2.4	1900	380	20.5	0.6
16	3000	1400	27.2	3.2	2400	1100	27.2	3.2	2000	840	27.2	3.2	1400	340	27.2	0.8
20	2400	1200	34	4	1900	840	34	4	1600	670	34	4	1100	260	34	1

Depth of cut



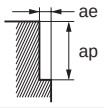
Note 1) Wet cutting mode is recommended for cutting stainless steels and titanium alloys, and air blow is recommended for carbon steels.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

MPMHV

End mill, Medium cut length, 4 flute, Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

■Side milling (Slim Shank)

Work Material	Carbon steel, Alloy steel (180－280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450				Carbon steel, Alloy steel (280－350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT				Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V				Hardened steel (45－55HRC) AISI H13, AISI L6			
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
7	4100	1200	12	0.7	3300	860	12	0.7	2700	700	12	0.7	1900	270	12	0.35
8	3600	1200	13.5	0.8	2900	870	13.5	0.8	2400	720	13.5	0.8	1700	270	13.5	0.4
9	3200	1200	15	0.9	2500	900	15	0.9	2100	660	15	0.9	1500	270	15	0.45
10	2900	1300	17	1	2300	920	17	1	1900	670	17	1	1300	260	17	0.5
11	2600	1200	18.5	1.1	2100	880	18.5	1.1	1700	520	18.5	1.1	1200	190	18.5	0.55
12	2400	1200	20.5	1.2	1900	840	20.5	1.2	1600	650	20.5	1.2	1100	220	20.5	0.6
13	2200	1100	22	1.3	1800	790	22	1.3	1500	490	22	1.3	1000	160	22	0.65
14	2000	960	24	1.4	1600	700	24	1.4	1400	460	24	1.4	950	150	24	0.7
18	1600	770	31	1.8	1300	570	31	1.8	1100	360	31	1.8	740	120	31	0.9
22	1300	620	37.5	2.2	1000	440	37.5	2.2	870	280	37.5	2.2	610	98	37.5	1.2
Depth of cut																

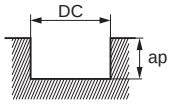
Note 1) Wet cutting mode is recommended for cutting stainless steels and titanium alloys, and air blow is recommended for carbon steels.

Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

Slotting

Work Material	Carbon steel, Alloy steel (180−280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450			Carbon steel, Alloy steel (280−350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT			Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			Hardened steel (45−55HRC) AISI H13, AISI L6		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	31000	620	0.5	24000	380	0.5	20000	320	0.5	9500	110	0.2
1.5	22000	630	0.8	17000	410	0.8	14000	340	0.8	6400	130	0.3
2	17000	650	2	14000	450	2	11000	350	2	4800	130	0.4
2.5	15000	830	2.5	12000	580	2.5	9700	470	2.5	3800	130	0.5
3	13000	940	3	10000	660	3	8500	510	3	3200	140	0.6
4	9500	820	4	7600	600	4	6400	460	4	2400	150	0.8
5	7600	910	5	6100	670	5	5100	510	5	1900	170	1
6	6400	860	6	5100	630	6	4200	470	6	1600	190	1.2
7	5500	960	7	4400	710	7	3600	530	7	1400	190	1.4
8	4800	1000	8	3800	750	8	3200	580	8	1200	190	1.6
10	3800	910	10	3100	680	10	2500	500	10	950	150	2
12	3200	920	12	2500	660	12	2100	500	12	800	160	2.4
16	2400	690	16	1900	500	16	1600	380	16	600	120	3.2
20	1900	550	20	1500	400	20	1300	310	20	480	96	4

Depth of cut



DC:Dia.

Note 3) Slim shank type is not recommended for grooving.

MPJHV

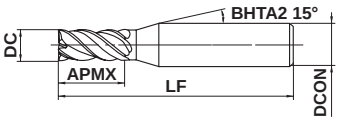
End mill, Semi long cut length, 4 flute, Irregular helix flutes

TOOL NEWS

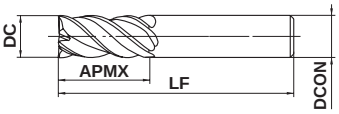
37.5° 40° APMX=DCx3.3

38° 40° APMX=DCx4

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		◎	○	○	



Type1



Type2

DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=4	DCON=6	DCON=8		
0 - 0.005	0 - 0.005	0 - 0.006		
DCON=10	DCON=12	DCON=16	DCON=20	
0 - 0.009	0 - 0.011	0 - 0.011	0 - 0.013	

- Irregular helix flutes end mill for reduced vibration when machining stainless steels and carbon steels.
- Semi long flute length suitable for vertical wall finishing.

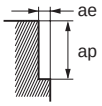
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MPJHVD0100AP04	1	4	45	4	4	●	1
MPJHVD0150AP06	1.5	6	45	4	4	●	1
MPJHVD0200AP06	2	6.5	60	6	4	●	1
MPJHVD0200AP08	2	8	60	6	4	●	1
MPJHVD0250AP10	2.5	10	60	6	4	●	1
MPJHVD0300AP10	3	10	60	6	4	●	1
MPJHVD0300AP12	3	12	60	6	4	●	1
MPJHVD0400AP13	4	13	60	6	4	●	1
MPJHVD0400AP16	4	16	60	6	4	●	1
MPJHVD0500AP17	5	17	60	6	4	●	1
MPJHVD0500AP20	5	20	60	6	4	●	1
MPJHVD0600AP20	6	20	60	6	4	●	2
MPJHVD0600AP24	6	24	60	6	4	●	2
MPJHVD0800AP26	8	26	80	8	4	●	2
MPJHVD0800AP32	8	32	80	8	4	●	2
MPJHVD1000AP33	10	33	100	10	4	●	2
MPJHVD1000AP40	10	40	100	10	4	●	2
MPJHVD1200AP40	12	40	110	12	4	●	2
MPJHVD1200AP48	12	48	110	12	4	●	2
MPJHVD1600AP53	16	53	125	16	4	●	2
MPJHVD1600AP64	16	64	125	16	4	●	2
MPJHVD2000AP66	20	66	140	20	4	●	2
MPJHVD2000AP80	20	80	140	20	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material		Carbon steel, Alloy steel (180－280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450				Carbon steel, Alloy steel (280－350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT				Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V				Hardened steel (45－55HRC) AISI H13, AISI L6			
Dia. **DC** (mm)	Length of cut **APMX** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	4	19000	300	3	0.03	15000	240	3	0.03	13000	210	3	0.03	13000	160	3	0.02
1.5	6	16000	320	4.5	0.05	13000	260	4.5	0.05	11000	220	4.5	0.05	8500	170	4.5	0.03
2	6.5	15000	500	5	0.1	12000	380	5	0.1	10000	320	5	0.1	7700	220	5	0.06
	8	14000	470	6	0.06	11000	350	6	0.06	9500	300	6	0.06	7300	200	6	0.04
2.5	10	13000	660	7.5	0.08	11000	520	7.5	0.08	8900	390	7.5	0.08	6300	250	7.5	0.05
3	10	13000	890	7.4	0.15	10000	620	7.4	0.15	8400	470	7.4	0.15	5900	300	7.4	0.09
	12	12000	820	9	0.09	9500	590	9	0.09	8000	450	9	0.09	5600	280	9	0.06
4	13	9400	940	9.9	0.2	7500	650	9.9	0.2	6300	530	9.9	0.2	4700	320	9.9	0.12
	16	9000	900	12	0.12	7200	620	12	0.12	6000	500	12	0.12	4500	310	12	0.08
5	17	7500	990	12.4	0.25	6000	680	12.4	0.25	5000	560	12.4	0.25	3800	350	12.4	0.15
	20	7200	950	15	0.15	5700	650	15	0.15	4800	540	15	0.15	3600	330	15	0.1
6	20	6300	1100	14.9	0.3	5000	760	14.9	0.3	4200	640	14.9	0.3	3200	350	14.9	0.18
	24	6000	1000	18	0.18	4800	730	18	0.18	4000	610	18	0.18	3000	330	18	0.12
8	26	4700	1100	19.8	0.4	3800	800	19.8	0.4	3100	620	19.8	0.4	2400	360	19.8	0.24
	32	4500	1000	24	0.24	3600	760	24	0.24	3000	600	24	0.24	2300	350	24	0.16
10	33	3800	1000	24.8	0.5	3000	760	24.8	0.5	2500	590	24.8	0.5	1900	330	24.8	0.3
	40	3600	970	30	0.3	2900	730	30	0.3	2400	570	30	0.3	1800	310	30	0.2
12	40	3100	1000	29.7	0.6	2500	720	29.7	0.6	2100	550	29.7	0.6	1600	300	29.7	0.36
	48	3000	970	36	0.36	2400	690	36	0.36	2000	520	36	0.36	1500	280	36	0.24
16	53	2400	780	27.2	0.48	1900	550	39.6	0.8	1600	420	39.6	0.8	1200	240	39.6	0.48
	64	2200	710	48	0.48	1800	520	48	0.48	1500	390	48	0.48	1100	220	48	0.32
20	66	1900	620	34	0.6	1500	430	49.5	1	1300	340	49.5	1	950	190	49.5	0.6
	80	1800	580	60	0.6	1400	400	60	0.6	1200	310	60	0.6	900	180	60	0.4
Depth of cut																	

Note 1) Wet cutting mode is recommended for cutting stainless steels and titanium alloys, and air blow is recommended for carbon steels.

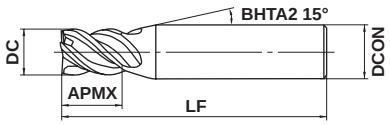
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

MSSHD

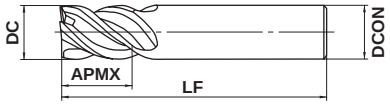
High power, Short cut length, 4 flute

TOOL NEWS

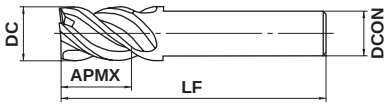
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute high power end mill.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MSSHDD0300	3	4.5	45	6	4	●	1
MSSHDD0350	3.5	5.3	45	6	4	●	1
MSSHDD0400	4	6	45	6	4	●	1
MSSHDD0450	4.5	6.8	45	6	4	●	1
MSSHDD0500	5	7.5	50	6	4	●	1
MSSHDD0550	5.5	8.3	50	6	4	●	1
MSSHDD0600	6	9	50	6	4	●	2
MSSHDD0650	6.5	9.8	60	8	4	●	1
MSSHDD0700	7	10.5	60	8	4	●	1
MSSHDD0750	7.5	11.3	60	8	4	●	1
MSSHDD0800	8	12	60	8	4	●	2
MSSHDD0850	8.5	12.8	70	10	4	●	1
MSSHDD0900	9	13.5	70	10	4	●	1
MSSHDD0950	9.5	14.3	70	10	4	●	1
MSSHDD1000	10	15	70	10	4	●	2
MSSHDD1100	11	16.5	75	12	4	●	1
MSSHDD1200	12	18	75	12	4	●	2
MSSHDD1300	13	19.5	75	12	4	●	3
MSSHDD1400	14	21	90	16	4	●	1
MSSHDD1500	15	22.5	90	16	4	●	1
MSSHDD1600	16	24	90	16	4	●	2
MSSHDD1700	17	25.5	100	16	4	●	3
MSSHDD1800	18	27	100	16	4	●	3
MSSHDD1900	19	28.5	110	20	4	●	1
MSSHDD2000	20	30	110	20	4	●	2

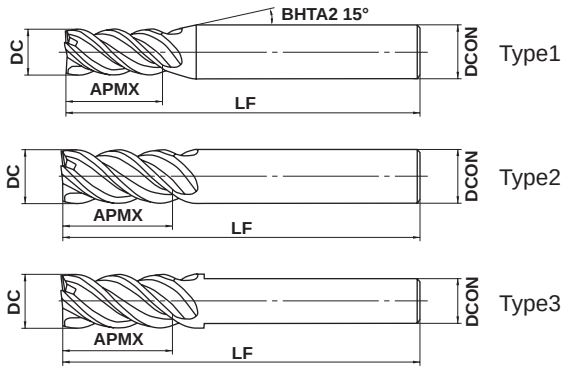
● : Inventory maintained in Japan.

MSMHD

High power, Medium cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute high power end mill.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MSMHDD0200	2	4	45	4	4	●	1
MSMHDD0210	2.1	5	45	4	4	●	1
MSMHDD0220	2.2	5	45	4	4	●	1
MSMHDD0230	2.3	5	45	4	4	●	1
MSMHDD0240	2.4	5	45	4	4	●	1
MSMHDD0250	2.5	5	45	4	4	●	1
MSMHDD0260	2.6	6	45	4	4	●	1
MSMHDD0270	2.7	6	45	4	4	●	1
MSMHDD0280	2.8	6	45	4	4	●	1
MSMHDD0290	2.9	6	45	4	4	●	1
MSMHDD0300	3	8	45	6	4	●	1
MSMHDD0310	3.1	8	45	6	4	●	1
MSMHDD0320	3.2	8	45	6	4	●	1
MSMHDD0330	3.3	8	45	6	4	●	1
MSMHDD0340	3.4	8	45	6	4	●	1
MSMHDD0350	3.5	8	45	6	4	●	1
MSMHDD0360	3.6	11	45	6	4	●	1
MSMHDD0370	3.7	11	45	6	4	●	1
MSMHDD0380	3.8	11	45	6	4	●	1
MSMHDD0390	3.9	11	45	6	4	●	1
MSMHDD0400	4	11	45	6	4	●	1
MSMHDD0410	4.1	12	45	6	4	●	1
MSMHDD0420	4.2	12	45	6	4	●	1
MSMHDD0430	4.3	12	45	6	4	●	1
MSMHDD0440	4.4	12	45	6	4	●	1
MSMHDD0450	4.5	12	45	6	4	●	1
MSMHDD0460	4.6	13	50	6	4	●	1
MSMHDD0470	4.7	13	50	6	4	●	1
MSMHDD0480	4.8	13	50	6	4	●	1
MSMHDD0490	4.9	13	50	6	4	●	1
MSMHDD0500	5	13	50	6	4	●	1
MSMHDD0510	5.1	13	50	6	4	●	1
MSMHDD0520	5.2	13	50	6	4	●	1
MSMHDD0530	5.3	13	50	6	4	●	1

MSMHD

High power, Medium cut length, 4 flute

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MSMHDD0540	5.4	13	50	6	4	●	1
MSMHDD0550	5.5	13	50	6	4	●	1
MSMHDD0560	5.6	13	50	6	4	●	1
MSMHDD0570	5.7	13	50	6	4	●	1
MSMHDD0580	5.8	13	50	6	4	●	1
MSMHDD0590	5.9	13	50	6	4	●	1
MSMHDD0600	6	13	50	6	4	●	2
MSMHDD0650	6.5	16	60	8	4	●	1
MSMHDD0700	7	19	60	8	4	●	1
MSMHDD0750	7.5	19	60	8	4	●	1
MSMHDD0800	8	19	60	8	4	●	2
MSMHDD0850	8.5	19	70	10	4	●	1
MSMHDD0900	9	22	70	10	4	●	1
MSMHDD0950	9.5	22	70	10	4	●	1
MSMHDD1000	10	22	70	10	4	●	2
MSMHDD1100	11	26	75	12	4	●	1
MSMHDD1200S10	12	26	75	10	4	●	3
MSMHDD1200	12	26	75	12	4	●	2
MSMHDD1300	13	26	75	12	4	●	3
MSMHDD1400	14	30	90	16	4	●	1
MSMHDD1500	15	35	90	16	4	●	1
MSMHDD1600	16	35	90	16	4	●	2
MSMHDD1700	17	35	100	16	4	●	3
MSMHDD1800	18	40	100	16	4	●	3
MSMHDD1900	19	40	110	20	4	●	1
MSMHDD2000	20	45	110	20	4	●	2
MSMHDD2200	22	50	125	20	4	●	3
MSMHDD2500	25	55	125	25	4	●	2

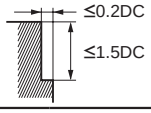
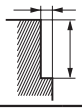
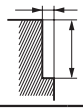
● : Inventory maintained in Japan.

MSSHD
High power, Short cut length, 4 flute

MSMHD
High power, Medium cut length, 4 flute

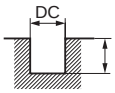
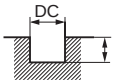
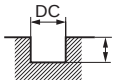
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	15000	550	10000	340	10000	320	6400	160	4800	100
3	11000	800	7400	500	7400	480	4800	250	4000	170
4	8000	900	5600	540	5600	520	3600	270	3200	240
5	6400	1000	4500	600	4500	580	2900	300	2600	240
6	5800	1100	3700	640	3700	600	2400	320	2100	230
8	4400	1100	2800	660	2800	600	1800	330	1600	220
10	3500	1000	2200	640	2200	560	1400	320	1300	200
12	2900	1000	1900	640	1900	530	1200	320	1100	170
16	2200	800	1400	500	1400	450	900	250	800	130
20	1800	750	1100	460	1100	440	720	230	640	100
25	1400	600	900	400	900	380	570	200	510	80
Depth of cut	 ≤0.2DC ≤1.5DC				 ≤0.1DC ≤1.5DC		 ≤0.05DC ≤1.5DC			

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	12000	400	7000	200	7000	100	4200	80	2300	40
3	9000	600	5300	300	5300	150	3200	130	1900	70
4	7200	720	4000	360	4000	180	2400	140	1400	95
5	5800	720	3200	360	3200	180	1900	150	1100	95
6	5000	800	2700	400	2700	200	1600	160	950	95
8	3700	800	2000	400	2000	200	1200	170	720	90
10	3000	720	1600	360	1600	180	960	160	570	80
12	2500	720	1300	360	1300	180	800	160	480	70
16	2000	600	1000	280	1000	150	600	130	360	50
20	1600	540	800	250	800	130	480	120	290	40
25	1300	480	640	220	640	120	380	100	230	35
Depth of cut	 DC ≤1DC (MAX. 12mm)				 DC ≤0.5DC		 DC ≤0.2DC			

DC:Dia.

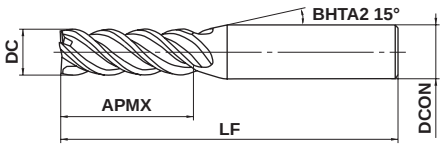
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MSJHD

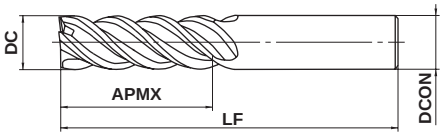
High power, Semi long cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●4 flute high power end mill.

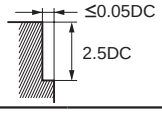
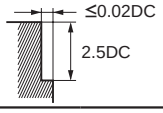
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MSJHDD0200	2	8	60	6	4	▲	1
MSJHDD0250	2.5	10	60	6	4	▲	1
MSJHDD0300	3	12	60	6	4	▲	1
MSJHDD0350	3.5	14	60	6	4	▲	1
MSJHDD0400	4	16	60	6	4	▲	1
MSJHDD0450	4.5	18	60	6	4	▲	1
MSJHDD0500	5	20	60	6	4	▲	1
MSJHDD0600	6	24	60	6	4	▲	2
MSJHDD0700	7	25	80	8	4	▲	1
MSJHDD0800	8	28	80	8	4	▲	2
MSJHDD0900	9	32	90	10	4	▲	1
MSJHDD1000	10	35	90	10	4	▲	2
MSJHDD1100	11	35	100	12	4	▲	1
MSJHDD1200	12	36	100	12	4	▲	2
MSJHDD1400	14	42	110	16	4	▲	1
MSJHDD1500	15	45	110	16	4	▲	1
MSJHDD1600	16	48	125	16	4	▲	2
MSJHDD2000	20	55	140	20	4	▲	2

▲ : Product scheduled to be discontinued at the end of March 2020
MPJHV (J134) is alternative product.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	11000	370	7000	230	7000	210	5000	100	3800	55
3	8000	550	5100	320	5100	300	3800	190	2500	80
4	6200	620	4000	350	4000	340	3000	210	1900	110
5	5000	670	3200	370	3200	360	2400	220	1500	110
6	4200	750	2600	400	2600	390	2000	220	1300	110
8	3200	780	2000	420	2000	400	1500	230	960	100
10	2500	690	1600	410	1600	380	1200	210	760	100
12	2100	670	1300	380	1300	340	1000	190	640	80
16	1600	570	1000	320	1000	280	750	170	480	65
20	1200	470	800	290	800	260	600	150	380	50
Depth of cut										

DC:Dia.

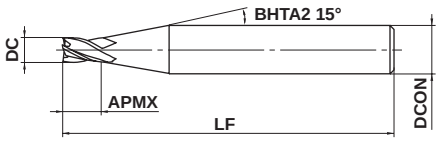
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MS4SC

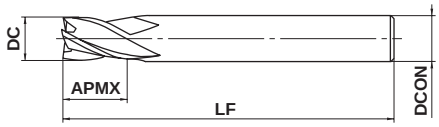
End mill, Short cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

1≤DC≤12				
0 - 0.020				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4SCD0100	1	1.5	40	4	4	●	1
MS4SCD0150	1.5	2.3	40	4	4	●	1
MS4SCD0200	2	3	40	4	4	●	1
MS4SCD0250	2.5	3.8	40	4	4	●	1
MS4SCD0300	3	4.5	50	6	4	●	1
MS4SCD0400	4	6	50	6	4	●	1
MS4SCD0500	5	7.5	50	6	4	●	1
MS4SCD0600	6	9	50	6	4	●	2
MS4SCD0800	8	12	60	8	4	●	2
MS4SCD1000	10	15	70	10	4	●	2
MS4SCD1200	12	18	75	12	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	3000	0.06	32000	2400	0.06
1.5	40000	4500	0.12	32000	3600	0.08
2	30000	4500	0.18	24000	3600	0.10
2.5	24000	3900	0.25	19000	3000	0.13
3	20000	3500	0.30	16000	2700	0.15
4	15000	3000	0.40	12000	2400	0.20
5	12000	2400	0.50	9000	1800	0.25
6	10000	2100	0.60	7000	1500	0.30
8	8000	1500	0.80	5600	1100	0.40
10	6400	1400	1.00	4500	950	0.50
12	5400	1200	1.00	3800	860	0.50
16	2400	550	3.00	1200	120	0.80
20	1900	480	4.00	1000	100	1.00
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC DC ≤Please refer to the list above for depth of cut. DC:Dia.					

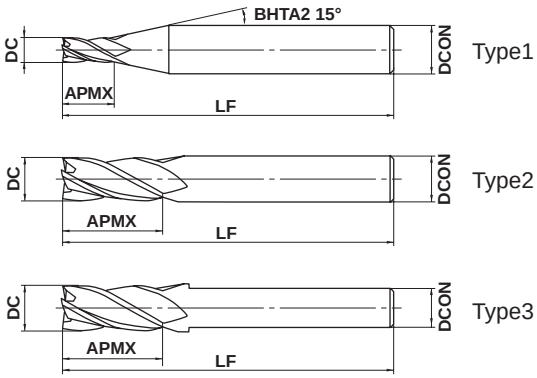
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50－70% and the feed rate to 40－60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MS4MC

End mill, Medium cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4MCD0100	1	2.5	40	4	4	●	1
MS4MCD0150	1.5	3.8	40	4	4	●	1
MS4MCD0200	2	5	40	4	4	●	1
MS4MCD0250	2.5	6.3	40	4	4	●	1
MS4MCD0300	3	7.5	50	6	4	●	1
MS4MCD0350	3.5	9	50	6	4	●	1
MS4MCD0400	4	10	50	6	4	●	1
MS4MCD0450	4.5	11.5	50	6	4	●	1
MS4MCD0500	5	12.5	50	6	4	●	1
MS4MCD0550	5.5	14	50	6	4	●	1
MS4MCD0600	6	15	50	6	4	●	2
MS4MCD0650	6.5	16.5	60	8	4	●	1
MS4MCD0700	7	17.5	60	8	4	●	1
MS4MCD0750	7.5	19	60	8	4	●	1
MS4MCD0800	8	20	60	8	4	●	2
MS4MCD0850	8.5	21.5	70	10	4	●	1
MS4MCD0900	9	22.5	70	10	4	●	1
MS4MCD0950	9.5	24	70	10	4	●	1
MS4MCD1000	10	25	70	10	4	●	2
MS4MCD1100	11	27.5	75	12	4	●	1
MS4MCD1200	12	30	90	12	4	●	2
MS4MCD1400	14	35	90	12	4	●	3
MS4MCD1600	16	40	100	16	4	●	2
MS4MCD1800	18	45	100	16	4	●	3
MS4MCD2000	20	50	110	20	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	3000	0.06	32000	2400	0.06
1.5	40000	4500	0.12	32000	3600	0.08
2	30000	4500	0.18	24000	3600	0.10
2.5	24000	3900	0.25	19000	3000	0.13
3	20000	3500	0.30	16000	2700	0.15
4	15000	3000	0.40	12000	2400	0.20
5	12000	2400	0.50	9000	1800	0.25
6	10000	2100	0.60	7000	1500	0.30
8	8000	1500	0.80	5600	1100	0.40
10	6400	1400	1.00	4500	950	0.50
12	5400	1200	1.00	3800	860	0.50
16	2400	550	3.00	1200	120	0.80
20	1900	480	4.00	1000	100	1.00
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC			DC ≤Please refer to the list above for depth of cut.		

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50－70% and the feed rate to 40－60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

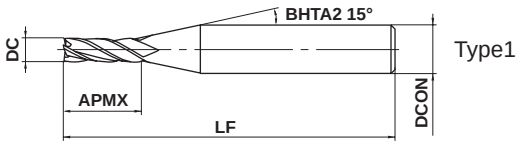
MS4JC

End mill, Semi long cut length, 4 flute

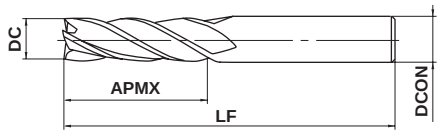
TOOL NEWS

UWC MS 30° DC<3 DC≥3 DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

1≤DC≤12				
0 - 0.020				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

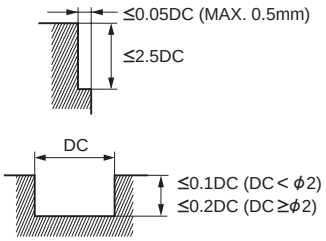
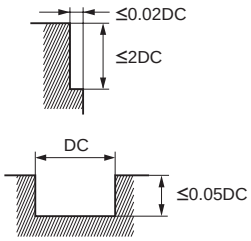
●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4JCD0100	1	4	40	4	4	●	1
MS4JCD0150	1.5	6	40	4	4	●	1
MS4JCD0200	2	8	40	4	4	●	1
MS4JCD0250	2.5	10	50	4	4	●	1
MS4JCD0300	3	12	50	6	4	●	1
MS4JCD0400	4	16	50	6	4	●	1
MS4JCD0500	5	20	60	6	4	●	1
MS4JCD0600	6	24	60	6	4	●	2
MS4JCD0800	8	32	70	8	4	●	2
MS4JCD1000	10	40	90	10	4	●	2
MS4JCD1200	12	48	110	12	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	11100	85	9500	65	8000	50	6400	35
1.5	7400	85	6400	90	5300	50	4200	35
2	5600	85	4800	90	4000	50	3200	35
2.5	4500	85	3800	90	3200	55	2500	35
3	3700	90	3400	90	2600	60	2100	35
4	3000	110	2700	90	2100	70	1700	50
5	2600	140	2300	110	1800	85	1500	55
6	2300	170	2000	140	1500	110	1300	70
8	1700	180	1500	140	1200	110	1000	70
10	1400	180	1300	140	950	110	800	70
12	1200	170	1100	140	800	110	670	70
Depth of cut								

DC:Dia.

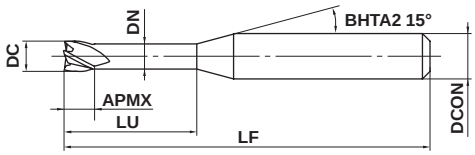
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MS4XL

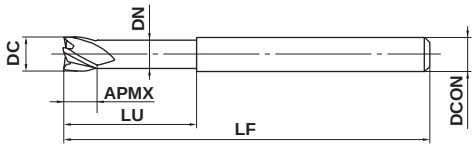
End mill, Short cut length, 4 flute, Long neck

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

1≤DC≤10				
0 / - 0.020				
4≤DCON≤6	8≤DCON≤10			
0 / - 0.008	0 / - 0.009			

●4 flute long neck end mill.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS4XLD0100N040	1	1	4	0.94	50	4	4	●	1
MS4XLD0100N060	1	1	6	0.94	50	4	4	●	1
MS4XLD0100N080	1	1	8	0.94	50	4	4	●	1
MS4XLD0100N100	1	1	10	0.94	50	4	4	●	1
MS4XLD0100N120	1	1	12	0.94	50	4	4	●	1
MS4XLD0100N160	1	1	16	0.94	60	4	4	●	1
MS4XLD0110N060	1.1	1.1	6	1.04	50	4	4	●	1
MS4XLD0110N100	1.1	1.1	10	1.04	50	4	4	●	1
MS4XLD0110N160	1.1	1.1	16	1.04	60	4	4	●	1
MS4XLD0120N060	1.2	1.2	6	1.14	50	4	4	●	1
MS4XLD0120N080	1.2	1.2	8	1.14	50	4	4	●	1
MS4XLD0120N100	1.2	1.2	10	1.14	50	4	4	●	1
MS4XLD0120N120	1.2	1.2	12	1.14	50	4	4	●	1
MS4XLD0120N160	1.2	1.2	16	1.14	60	4	4	●	1
MS4XLD0130N060	1.3	1.3	6	1.24	50	4	4	●	1
MS4XLD0130N120	1.3	1.3	12	1.24	50	4	4	●	1
MS4XLD0130N180	1.3	1.3	18	1.24	60	4	4	●	1
MS4XLD0140N060	1.4	1.4	6	1.34	50	4	4	●	1
MS4XLD0140N080	1.4	1.4	8	1.34	50	4	4	●	1
MS4XLD0140N100	1.4	1.4	10	1.34	50	4	4	●	1
MS4XLD0140N120	1.4	1.4	12	1.34	50	4	4	●	1
MS4XLD0140N140	1.4	1.4	14	1.34	60	4	4	●	1
MS4XLD0140N160	1.4	1.4	16	1.34	60	4	4	●	1
MS4XLD0140N220	1.4	1.4	22	1.34	60	4	4	●	1
MS4XLD0150N060	1.5	1.5	6	1.44	50	4	4	●	1
MS4XLD0150N080	1.5	1.5	8	1.44	50	4	4	●	1
MS4XLD0150N100	1.5	1.5	10	1.44	50	4	4	●	1
MS4XLD0150N120	1.5	1.5	12	1.44	50	4	4	●	1
MS4XLD0150N140	1.5	1.5	14	1.44	60	4	4	●	1
MS4XLD0150N160	1.5	1.5	16	1.44	60	4	4	●	1
MS4XLD0150N180	1.5	1.5	18	1.44	60	4	4	●	1
MS4XLD0150N200	1.5	1.5	20	1.44	60	4	4	●	1
MS4XLD0160N060	1.6	1.6	6	1.54	50	4	4	●	1
MS4XLD0160N080	1.6	1.6	8	1.54	50	4	4	●	1

● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS4XLD0160N100	1.6	1.6	10	1.54	50	4	4	●	1
MS4XLD0160N120	1.6	1.6	12	1.54	50	4	4	●	1
MS4XLD0160N140	1.6	1.6	14	1.54	60	4	4	●	1
MS4XLD0160N160	1.6	1.6	16	1.54	60	4	4	●	1
MS4XLD0160N180	1.6	1.6	18	1.54	60	4	4	●	1
MS4XLD0160N200	1.6	1.6	20	1.54	60	4	4	●	1
MS4XLD0160N260	1.6	1.6	26	1.54	70	4	4	●	1
MS4XLD0170N060	1.7	1.7	6	1.64	50	4	4	●	1
MS4XLD0170N140	1.7	1.7	14	1.64	60	4	4	●	1
MS4XLD0170N240	1.7	1.7	24	1.64	70	4	4	●	1
MS4XLD0180N060	1.8	1.8	6	1.74	50	4	4	●	1
MS4XLD0180N080	1.8	1.8	8	1.74	50	4	4	●	1
MS4XLD0180N100	1.8	1.8	10	1.74	50	4	4	●	1
MS4XLD0180N120	1.8	1.8	12	1.74	50	4	4	●	1
MS4XLD0180N140	1.8	1.8	14	1.74	60	4	4	●	1
MS4XLD0180N160	1.8	1.8	16	1.74	60	4	4	●	1
MS4XLD0180N180	1.8	1.8	18	1.74	60	4	4	●	1
MS4XLD0180N200	1.8	1.8	20	1.74	60	4	4	●	1
MS4XLD0180N250	1.8	1.8	25	1.74	70	4	4	●	1
MS4XLD0190N060	1.9	1.9	6	1.84	50	4	4	●	1
MS4XLD0190N160	1.9	1.9	16	1.84	60	4	4	●	1
MS4XLD0190N280	1.9	1.9	28	1.84	70	4	4	●	1
MS4XLD0200N060	2	2	6	1.9	50	4	4	●	1
MS4XLD0200N080	2	2	8	1.9	50	4	4	●	1
MS4XLD0200N100	2	2	10	1.9	50	4	4	●	1
MS4XLD0200N120	2	2	12	1.9	50	4	4	●	1
MS4XLD0200N140	2	2	14	1.9	60	4	4	●	1
MS4XLD0200N160	2	2	16	1.9	60	4	4	●	1
MS4XLD0200N180	2	2	18	1.9	60	4	4	●	1
MS4XLD0200N200	2	2	20	1.9	60	4	4	●	1
MS4XLD0200N250	2	2	25	1.9	70	4	4	●	1
MS4XLD0200N300	2	2	30	1.9	70	4	4	●	1
MS4XLD0250N080	2.5	2.5	8	2.4	50	4	4	●	1
MS4XLD0250N120	2.5	2.5	12	2.4	50	4	4	●	1
MS4XLD0250N160	2.5	2.5	16	2.4	60	4	4	●	1
MS4XLD0250N200	2.5	2.5	20	2.4	60	4	4	●	1
MS4XLD0250N250	2.5	2.5	25	2.4	70	4	4	●	1
MS4XLD0300N080	3	3	8	2.9	50	6	4	●	1
MS4XLD0300N120	3	3	12	2.9	50	6	4	●	1
MS4XLD0300N160	3	3	16	2.9	60	6	4	●	1
MS4XLD0300N200	3	3	20	2.9	60	6	4	●	1
MS4XLD0300N250	3	3	25	2.9	70	6	4	●	1
MS4XLD0300N300	3	3	30	2.9	70	6	4	●	1
MS4XLD0350N150	3.5	3.5	15	3.4	60	6	4	●	1
MS4XLD0350N250	3.5	3.5	25	3.4	70	6	4	●	1
MS4XLD0350N350	3.5	3.5	35	3.4	80	6	4	●	1
MS4XLD0400N120	4	4	12	3.9	50	6	4	●	1
MS4XLD0400N160	4	4	16	3.9	60	6	4	●	1
MS4XLD0400N200	4	4	20	3.9	60	6	4	●	1
MS4XLD0400N250	4	4	25	3.9	70	6	4	●	1
MS4XLD0400N300	4	4	30	3.9	70	6	4	●	1
MS4XLD0400N350	4	4	35	3.9	80	6	4	●	1

MS4XL

End mill, Short cut length, 4 flute, Long neck

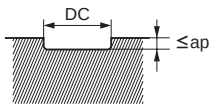
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MS4XLD0400N400	4	4	40	3.9	90	6	4	●	1
MS4XLD0400N450	4	4	45	3.9	90	6	4	●	1
MS4XLD0400N500	4	4	50	3.9	100	6	4	●	1
MS4XLD0500N160	5	5	16	4.9	60	6	4	●	1
MS4XLD0500N250	5	5	25	4.9	70	6	4	●	1
MS4XLD0500N350	5	5	35	4.9	80	6	4	●	1
MS4XLD0500N500	5	5	50	4.9	110	6	4	●	1
MS4XLD0600N200	6	6	20	5.85	80	6	4	●	2
MS4XLD0600N300	6	6	30	5.85	90	6	4	●	2
MS4XLD0600N400	6	6	40	5.85	100	6	4	●	2
MS4XLD0600N500	6	6	50	5.85	110	6	4	●	2
MS4XLD0800N300	8	8	30	7.85	90	8	4	●	2
MS4XLD0800N500	8	8	50	7.85	110	8	4	●	2
MS4XLD0800N700	8	8	70	7.85	130	8	4	●	2
MS4XLD1000N400	10	10	40	9.7	100	10	4	●	2
MS4XLD1000N600	10	10	60	9.7	120	10	4	●	2
MS4XLD1000N800	10	10	80	9.7	140	10	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	4	40000	3000	0.04
	8	36000	2400	0.03
	12	20000	1000	0.02
	16	10000	500	0.005
1.2	6	40000	3000	0.05
	10	36000	2400	0.04
	12	20000	1200	0.03
	16	12000	600	0.01
1.5	6	40000	3200	0.06
	12	32000	2400	0.05
	16	16000	1100	0.03
	20	10000	600	0.01
1.8	6	40000	3600	0.08
	12	32000	2800	0.06
	20	12000	1000	0.02
	25	7000	600	0.01
2	6	40000	4000	0.1
	12	32000	3200	0.07
	16	24000	2400	0.05
	20	12000	1200	0.03
	30	5000	500	0.01
2.5	8	32000	4000	0.2
	25	9000	1100	0.04
	50	2500	300	0.005
3	8	25000	3600	0.4
	16	18000	2500	0.2
	25	12000	1700	0.1
	30	7000	800	0.05

Work Material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
3.5	15	20000	3000	0.6
	25	11000	1600	0.15
	35	5500	800	0.06
4	12	18000	3000	1
	20	12000	2000	0.5
	30	8000	1300	0.2
	40	4200	700	0.08
	50	2400	400	0.03
5	16	14000	2700	1
	25	9500	1800	0.5
	35	6400	1200	0.2
	50	3200	600	0.05
6	20	11000	2200	1.2
	30	8000	1600	0.6
	40	5400	1100	0.25
	50	3200	640	0.15
8	30	8000	1600	1.6
	50	4000	800	0.5
	70	2000	400	0.2
10	40	6400	1300	2
	60	3200	640	0.6
	80	1600	320	0.3
Depth of cut				

DC:Dia.
ap:Depth of Cut in the Axial Direction

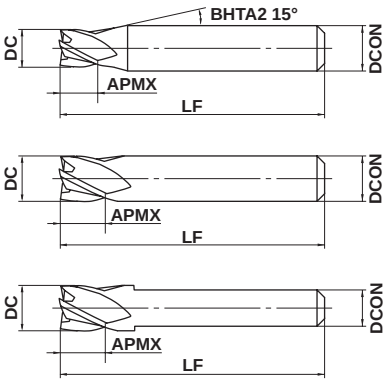
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

MS4EC

End mill, 4 flute, For small automatic lathes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	7≤DCON≤10			
0 - 0.008	0 - 0.009			

h6

●4 flute end mill.

Overall length 35mm (mm)

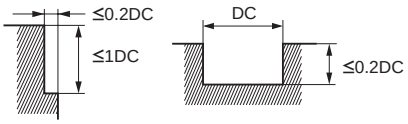
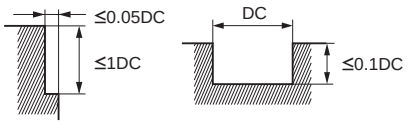
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4ECD0300L35S04	3	3	35	4	4	●	1
MS4ECD0350L35S04	3.5	3.5	35	4	4	●	1
MS4ECD0400L35S04	4	4	35	4	4	●	2
MS4ECD0500L35S05	5	5	35	5	4	●	2
MS4ECD0500L35S06	5	5	35	6	4	●	1
MS4ECD0600L35S05	6	6	35	5	4	●	3
MS4ECD0600L35S06	6	6	35	6	4	●	2
MS4ECD0700L35S07	7	6	35	7	4	●	2
MS4ECD0800L35S07	8	6	35	7	4	●	3
MS4ECD0800L35S08	8	6	35	8	4	●	2
MS4ECD1000L35S07	10	6	35	7	4	●	3
MS4ECD1000L35S10	10	6	35	10	4	●	2
MS4ECD1200L35S10	12	6	35	10	4	●	3

Overall length 45mm (mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4ECD0300L45S04	3	3	45	4	4	●	1
MS4ECD0350L45S04	3.5	3.5	45	4	4	●	1
MS4ECD0400L45S04	4	4	45	4	4	●	2
MS4ECD0500L45S06	5	5	45	6	4	●	1
MS4ECD0600L45S06	6	6	45	6	4	●	2
MS4ECD0700L45S07	7	7	45	7	4	●	2
MS4ECD0800L45S07	8	8	45	7	4	●	3
MS4ECD0800L45S08	8	8	45	8	4	●	2
MS4ECD1000L45S07	10	10	45	7	4	●	3
MS4ECD1000L45S10	10	10	45	10	4	●	2
MS4ECD1200L45S10	12	12	45	10	4	●	3
MS4ECD1400L45S10	14	14	45	10	4	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	10000	900	7000	600	6000	450	5000	180
4	7500	900	5200	600	4500	450	4000	180
5	6000	900	4200	600	3600	450	3200	180
6	5000	900	3500	600	3000	450	2700	180
7	4500	840	3000	540	2700	420	2300	160
8	4000	780	2800	520	2400	390	2000	160
10	3200	680	2200	450	1900	340	1600	140
12	2700	620	1900	410	1600	310	1300	120
14	2300	550	1600	350	1400	280	1200	120
Depth of cut								

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

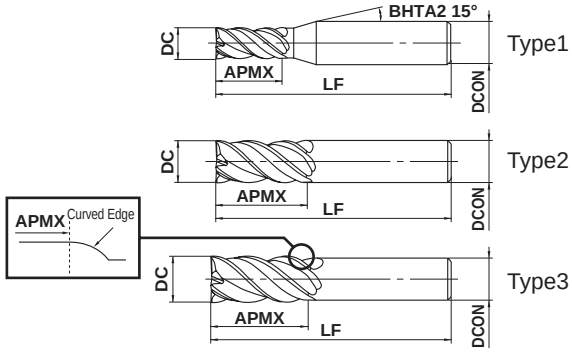
VQMHV

End mill, Medium cutting length, 4 flute, Irregular helix flutes

TOOL NEWS

UWC VQ 37° 40°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

● Smart Miracle vibration control end mill achieving stable machining of difficult-to-cut materials and for long overhang applications.

(mm)

	Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
NEW	VQMHVD0100	1	2	45	4	4	●	1
NEW	VQMHVD0150	1.5	3	45	4	4	●	1
	VQMHVD0200	2	4	45	4	4	●	1
	VQMHVD0250	2.5	5	45	4	4	●	1
	VQMHVD0300	3	8	45	6	4	●	1
	VQMHVD0350	3.5	8	45	6	4	●	1
	VQMHVD0400	4	11	45	6	4	●	1
	VQMHVD0500	5	13	50	6	4	●	1
	VQMHVD0600	6	13	50	6	4	●	2
	VQMHVD0700	7	19	60	8	4	●	1
	VQMHVD0800	8	19	60	8	4	●	2
	VQMHVD0900	9	22	70	10	4	●	1
	VQMHVD0900S08	9	22	75	8	4	●	3
	VQMHVD1000	10	22	70	10	4	●	2
	VQMHVD1000S08	10	22	100	8	4	●	3
	VQMHVD1100	11	26	75	12	4	●	1
	VQMHVD1100S10	11	26	100	10	4	●	3
	VQMHVD1200	12	26	75	12	4	●	2
	VQMHVD1200S10	12	26	110	10	4	●	3
	VQMHVD1300	13	26	75	12	4	●	3
	VQMHVD1300S12	13	26	110	12	4	●	3
	VQMHVD1400	14	30	90	16	4	●	1
	VQMHVD1400S12	14	32	130	12	4	●	3
	VQMHVD1600	16	35	90	16	4	●	2
	VQMHVD1800	18	40	100	16	4	●	3
	VQMHVD1800S16	18	42	150	16	4	●	3
	VQMHVD2000	20	45	110	20	4	●	2
	VQMHVD2500	25	55	125	25	4	●	2

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

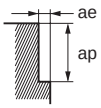
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

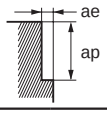
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH,17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	130	40000	1800	1.5	0.3	120	38000	910	1.5	0.3	80	25000	500	1.5	0.2	75	24000	580	1.5	0.2
2	150	24000	2400	3	0.6	120	19000	1100	3	0.6	100	16000	830	3	0.6	75	12000	720	3	0.4
3	150	16000	2600	4.5	0.9	120	13000	1200	4.5	0.9	100	11000	880	4.5	0.9	75	8000	770	4.5	0.6
4	150	12000	2600	6	1.2	120	9500	1300	6	1.2	100	8000	900	6	1.2	75	6000	790	6	0.8
5	150	9500	2600	7.5	1.5	120	7600	1300	7.5	1.5	100	6400	900	7.5	1.5	75	4800	810	7.5	1
6	150	8000	2600	9	1.8	120	6400	1300	9	1.8	100	5300	1100	9	1.8	75	4000	810	9	1.2
8	150	6000	2500	12	2.4	120	4800	1300	12	2.4	100	4000	1200	12	2.4	75	3000	840	12	1.6
10	150	4800	2300	15	3	120	3800	1200	15	3	100	3200	1300	15	3	75	2400	770	15	2
12	150	4000	1900	18	3.6	120	3200	1200	18	3.6	100	2700	1200	18	3.6	75	2000	720	18	2.4
16	150	3000	1600	24	4.8	120	2400	960	24	4.8	100	2000	960	24	4.8	75	1500	600	24	3.2
20	150	2400	1300	30	6	120	1900	760	30	6	100	1600	770	30	6	75	1200	480	30	4
25	150	1900	1100	37.5	7.5	120	1500	600	37.5	7.5	100	1300	620	37.5	7.5	75	950	380	37.5	5
Depth of cut																				

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH,17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	120	38000	1000	1.5	0.3	100	32000	560	1.5	0.3	80	25000	400	0.75	0.1	70	22000	390	1.5	0.2
2	120	19000	1300	3	0.6	100	16000	630	3	0.6	80	13000	450	1.5	0.2	70	11000	440	3	0.4
3	120	13000	1400	4.5	0.9	100	11000	700	4.5	0.9	80	8500	450	2.2	0.3	70	7400	470	4.5	0.6
4	120	9500	1400	6	1.2	100	8000	700	6	1.2	80	6400	470	3	0.6	70	5600	490	6	0.8
5	120	7600	1400	7.5	1.5	100	6400	710	7.5	1.5	80	5100	470	4.5	0.9	70	4500	500	7.5	1
6	120	6400	1400	9	1.8	100	5300	710	9	1.8	80	4200	580	6	1.2	70	3700	500	9	1.2
8	120	4800	1300	12	2.4	100	4000	740	12	2.4	80	3200	630	7.5	1.5	70	2800	520	12	1.6
10	120	3800	1200	15	3	100	3200	680	15	3	80	2500	660	9	1.8	70	2200	460	15	2
12	120	3200	1000	18	3.6	100	2700	640	18	3.6	80	2100	610	12	2.4	70	1900	450	18	2.4
16	120	2400	860	24	4.8	100	2000	530	24	4.8	80	1600	510	15	3	70	1400	370	24	3.2
20	120	1900	680	30	6	100	1600	420	30	6	80	1300	410	18	3.6	70	1100	290	30	4
25	120	1500	390	37.5	7.5	100	1300	340	37.5	7.5	80	1000	210	24	4.8	70	890	230	37.5	5
Depth of cut																				

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

VQMHV

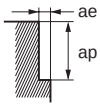
End mill, Medium length of cut, 4 flute, Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

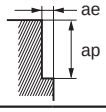
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	130	40000	1800	1.5	0.3	40	13000	210	1.5	0.1
2	180	29000	2900	3	0.6	40	6400	230	3	0.2
3	180	19000	3000	4.5	0.9	40	4200	240	4.5	0.3
4	180	14000	3000	6	1.2	40	3200	240	6	0.4
5	180	11000	3000	7.5	1.5	40	2500	240	7.5	0.5
6	180	9500	3000	9	1.8	40	2100	250	9	0.6
8	180	7200	3000	12	2.4	40	1600	260	12	0.8
10	180	5700	2700	15	3	40	1300	290	15	1
12	180	4800	2300	18	3.6	40	1100	280	18	1.2
16	180	3600	1900	24	4.8	40	800	200	24	1.6
20	180	2900	1600	30	6	40	640	160	30	2
25	180	2300	1300	37.5	7.5	40	510	130	37.5	2.5
Depth of cut										

General-purpose conditions

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	130	40000	1300	1.5	0.3	30	9600	92	1.5	0.1
2	140	22000	1500	3	0.6	30	4800	110	3	0.2
3	140	15000	1600	4.5	0.9	30	3200	120	4.5	0.3
4	140	11000	1600	6	1.2	30	2400	120	6	0.4
5	140	8900	1600	7.5	1.5	30	1900	120	7.5	0.5
6	140	7400	1600	9	1.8	30	1600	130	9	0.6
8	140	5600	1600	12	2.4	30	1200	130	12	0.8
10	140	4500	1400	15	3	30	950	140	15	1
12	140	3700	1200	18	3.6	30	800	140	18	1.2
16	140	2800	1000	24	4.8	30	600	100	24	1.6
20	140	2200	780	30	6	30	480	81	30	2
25	140	1800	670	37.5	7.5	30	380	64	37.5	2.5
Depth of cut										

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

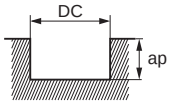
■Slotting

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
2	150	24000	1200	2	120	19000	610	2	100	16000	640	2	60	9500	300	1	180	29000	1500	2	30	4800	130	0.6
3	150	16000	1500	3	120	13000	730	3	100	11000	660	3	60	6400	360	1.5	180	19000	1700	3	30	3200	150	0.9
4	150	12000	1900	4	120	9500	910	4	100	8000	700	4	60	4800	460	2	180	14000	2200	4	30	2400	170	1.2
5	150	9500	1900	5	120	7600	910	5	100	6400	720	5	60	3800	460	2.5	180	11000	2200	5	30	1900	170	1.5
6	150	8000	1900	6	120	6400	1000	6	100	5300	740	6	60	3200	510	3	180	9500	2300	6	30	1600	180	1.8
8	150	6000	1700	8	120	4800	960	8	100	4000	800	8	60	2400	480	4	180	7200	2000	8	30	1200	190	2.4
10	150	4800	1500	10	120	3800	840	10	100	3200	900	10	60	1900	420	5	180	5700	1800	10	30	950	210	3
12	150	4000	1300	12	120	3200	770	12	100	2700	860	12	60	1600	380	6	180	4800	1500	12	30	800	200	3.6
16	150	3000	1100	12	120	2400	670	12	100	2000	640	12	60	1200	340	8	180	3600	1300	12	30	600	150	4.8
20	150	2400	860	12	120	1900	530	12	100	1600	510	12	60	950	270	10	180	2900	1000	12	30	480	120	6
25	150	1900	760	12	120	1500	420	12	100	1300	420	12	60	760	210	12	180	2300	920	12	30	380	100	7.5

Depth of cut

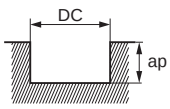


DC:Dia.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	100	32000	500	1	80	25000	250	1	80	25000	300	1	50	16000	150	0.5	120	38000	590	1	25	8000	67	0.3
2	100	16000	550	2	80	13000	270	2	60	9500	250	2	50	8000	170	1	120	19000	650	2	25	4000	74	0.6
3	100	11000	670	3	80	8500	310	3	60	6400	250	3	50	5300	200	1.5	120	13000	790	3	25	2700	86	0.9
4	100	8000	840	4	80	6400	410	4	60	4800	280	4	50	4000	250	2	120	9500	1000	4	25	2000	93	1.2
5	100	6400	840	5	80	5100	410	5	60	3800	280	5	50	3200	250	2.5	120	7600	1000	5	25	1600	95	1.5
6	100	5300	840	6	80	4200	440	6	60	3200	300	6	50	2700	290	3	120	6400	1000	6	25	1300	96	1.8
8	100	4000	740	8	80	3200	420	8	60	2400	320	8	50	2000	260	4	120	4800	890	8	25	990	100	2.4
10	100	3200	680	10	80	2500	360	10	60	1900	350	10	50	1600	230	5	120	3800	800	10	25	800	120	3
12	100	2700	570	12	80	2100	330	12	60	1600	340	12	50	1300	210	6	120	3200	680	12	25	660	110	3.6
16	100	2000	480	12	80	1600	300	12	60	1200	250	12	50	990	180	8	120	2400	570	12	25	500	84	4.8
20	100	1600	380	12	80	1300	240	12	60	950	200	12	50	800	150	10	120	1900	450	12	25	400	68	6
25	100	1300	340	12	80	1000	180	12	60	760	160	12	50	640	120	12	120	1500	400	12	25	320	50	7.5

Depth of cut



DC:Dia.

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

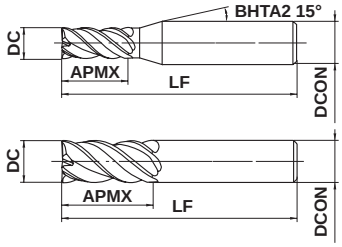
VQJHV

End mill, Medium cut length, 4 flute, Irregular helix flutes

TOOL NEWS

38° 40° DC≤6 37.5° 40° DC>6

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

● Smart Miracle vibration control end mill achieving stable machining of difficult-to-cut materials and for long overhang applications.

(mm)

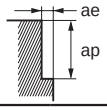
	Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
NEW	VQJHVD0100	1	4	45	4	4	●	1
NEW	VQJHVD0150	1.5	6	45	4	4	●	1
	VQJHVD0200	2	8	60	6	4	●	1
	VQJHVD0250	2.5	10	60	6	4	●	1
	VQJHVD0300	3	12	60	6	4	●	1
	VQJHVD0350	3.5	14	60	6	4	●	1
	VQJHVD0400	4	16	60	6	4	●	1
	VQJHVD0450	4.5	18	60	6	4	●	1
	VQJHVD0500	5	20	60	6	4	●	1
	VQJHVD0600	6	24	60	6	4	●	2
	VQJHVD0700	7	25	80	8	4	●	1
	VQJHVD0800	8	28	80	8	4	●	2
	VQJHVD0900	9	32	90	10	4	●	1
	VQJHVD1000	10	35	90	10	4	●	2
	VQJHVD1200	12	40	100	12	4	●	2
	VQJHVD1600	16	55	125	16	4	●	2
	VQJHVD2000	20	70	140	20	4	●	2

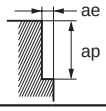
Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 306, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy SUS630, SUS631, 15-5PH, 17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	130	40000	530	2.5	0.1	100	32000	410	2.5	0.1	80	25000	300	2.5	0.05	75	24000	290	2.5	0.05
2	130	21000	700	5	0.2	100	16000	510	5	0.2	80	13000	390	5	0.1	75	12000	360	5	0.1
3	130	14000	960	7.5	0.3	100	11000	680	7.5	0.3	80	8500	490	7.5	0.15	75	8000	460	7.5	0.15
4	130	10000	1000	10	0.4	100	8000	690	10	0.4	80	6400	540	10	0.2	75	6000	510	10	0.2
5	130	8300	1100	12.5	0.5	100	6400	730	12.5	0.5	80	5100	570	12.5	0.25	75	4800	540	12.5	0.25
6	130	6900	1200	15	0.6	100	5300	810	15	0.6	80	4200	630	15	0.3	75	4000	600	15	0.3
8	130	5200	1200	20	0.8	100	4000	840	20	0.8	80	3200	640	20	0.4	75	3000	600	20	0.4
10	130	4100	1100	25	1	100	3200	810	25	1	80	2500	590	25	0.5	75	2400	570	25	0.5
12	130	3400	1100	30	1.2	100	2700	780	30	1.2	80	2100	550	30	0.6	75	2000	520	30	0.6
16	130	2600	920	40	1.6	100	2000	640	40	1.6	80	1600	450	40	0.8	75	1500	420	40	0.8
20	130	2100	820	50	2	100	1600	570	50	2	80	1300	420	50	1	75	1200	390	50	1
Depth of cut																				

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	130	40000	530	2.5	0.1	40	13000	73	2.5	0.02
2	160	25000	830	5	0.2	40	6400	90	5	0.04
3	160	17000	1200	7.5	0.3	40	4200	130	7.5	0.06
4	160	13000	1300	10	0.4	40	3200	190	10	0.08
5	160	10000	1300	12.5	0.5	40	2500	180	12.5	0.1
6	160	8500	1500	15	0.6	40	2100	180	15	0.12
8	160	6400	1500	20	0.8	40	1600	170	20	0.16
10	160	5100	1300	25	1	40	1300	170	25	0.2
12	160	4200	1300	30	1.2	40	1100	140	30	0.24
16	160	3200	1100	40	1.6	40	800	110	40	0.32
20	160	2500	970	50	2	40	640	80	50	0.4
Depth of cut										

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

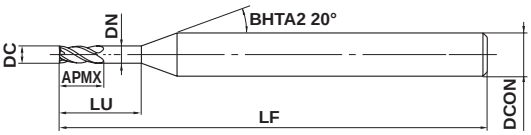
VQXL

End mill, Short cut length, 4 flute, Long neck

TOOL NEWS

UWC VQ 35° DC≤0.3 DC≥0.4

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



Type1

DC≤1				
0 - 0.010				
DCON=4				
0 - 0.005				

- The use of SMART MIRACLE Coating improves chip discharge dramatically.
- Multi-cutters at a small diameter of ϕ1 is realized.

(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VQXLD0020N006	0.2	0.3	0.6	0.18	40	4	3	●	1
VQXLD0030N009	0.3	0.5	0.9	0.28	40	4	3	●	1
VQXLD0030N015	0.3	0.5	1.5	0.28	40	4	3	●	1
VQXLD0040N010	0.4	0.6	1	0.37	40	4	4	●	1
VQXLD0040N018	0.4	0.6	1.8	0.37	40	4	4	●	1
VQXLD0050N015	0.5	0.7	1.5	0.47	40	4	4	●	1
VQXLD0050N025	0.5	0.7	2.5	0.47	40	4	4	●	1
VQXLD0050N030	0.5	0.7	3	0.47	40	4	4	●	1
VQXLD0060N030	0.6	0.9	3	0.57	40	4	4	●	1
VQXLD0070N035	0.7	1	3.5	0.67	40	4	4	●	1
VQXLD0080N024	0.8	1.2	2.4	0.77	40	4	4	●	1
VQXLD0080N030	0.8	1.2	3	0.77	40	4	4	●	1
VQXLD0080N040	0.8	1.2	4	0.77	40	4	4	●	1
VQXLD0100N050	1	1.5	5	0.96	40	4	4	●	1

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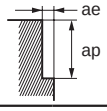
Torque chart

Order Number	ISO 10664 Torque type
VQXLD0020N006	T4
VQXLD0030N009	T6
VQXLD0030N015	
VQXLD0040N010	T8
VQXLD0040N018	
VQXLD0050N015	T15
VQXLD0050N025	
VQXLD0050N030	
VQXLD0080N024	TS25
VQXLD0080N040	
VQXLD0100N050	T40

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material		Carbon steel, Alloy steel, Austenitic stainless steels, Titanium alloys Cobaly chromium alloy, Copper, Copper alloy AISI 1045, AISI 4140, AISI 4340, AISI 304, AISI 316, AISI 304LN, AISI 316LN, Ti-6Al-4V					Heat resistant alloys, Pre-hardened steel, Hardened steel Inconel718, AISI P21, AISI P20, AISI H13, AISI L6, AISI 431, AISI 420				
Dia. **DC** (mm)	Neck Length **LU** (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.6	25	40000	360	0.03	0.01	20	32000	290	0.03	0.01
0.3	0.9	40	40000	480	0.045	0.015	20	21000	250	0.045	0.015
0.3	1.5	40	40000	360	0.045	0.015	20	21000	190	0.045	0.015
0.4	1	50	40000	800	0.06	0.02	20	16000	320	0.06	0.02
0.4	1.8	50	40000	560	0.06	0.02	20	16000	220	0.06	0.025
0.5	1.5	60	38000	910	0.075	0.025	20	13000	310	0.075	0.025
0.5	2.5	60	38000	610	0.075	0.025	20	13000	210	0.075	0.025
0.5	3	60	38000	550	0.075	0.025	20	13000	180	0.075	0.025
0.6	3	60	32000	640	0.09	0.03	20	10500	210	0.09	0.03
0.7	3.5	60	27000	650	0.11	0.035	20	9100	200	0.11	0.035
0.8	2.4	60	24000	960	0.12	0.04	20	8000	260	0.12	0.04
0.8	3	60	24000	860	0.12	0.04	20	8000	230	0.12	0.04
0.8	4	60	24000	670	0.12	0.04	20	8000	190	0.12	0.04
1	5	60	20000	800	0.15	0.05	20	6500	210	0.15	0.05
Depth of cut											

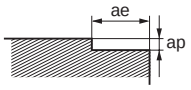
Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

VQXL

End mill, Short cut length, 4 flute, Long neck

RECOMMENDED CUTTING CONDITIONS

■Bottom face milling

Work Material		Carbon steel, Alloy steel, Austenitic stainless steels, Titanium alloys Cobaly chromium alloy, Copper, Copper alloy AISI 1045, AISI 4140, AISI 4340, AISI 304, AISI 316, AISI 304LN, AISI 316LN, Ti-6Al-4V					Heat resistant alloys, Pre-hardened steel, Hardened steel Inconel718, AISI P21, AISI P20, AISI H13, AISI L6, AISI 431, AISI 420				
Dia. **DC** (mm)	Neck Length **LU** (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.6	25	40000	360	0.015	≤0.2	20	32000	290	0.015	≤0.1
0.3	0.9	40	40000	480	0.025	≤0.3	20	21000	250	0.025	≤0.15
0.3	1.5	40	40000	360	0.02	≤0.3	20	21000	190	0.02	≤0.15
0.4	1	50	40000	800	0.03	≤0.4	20	16000	320	0.03	≤0.2
0.4	1.8	50	40000	560	0.02	≤0.4	20	16000	220	0.02	≤0.2
0.5	1.5	60	38000	910	0.04	≤0.5	20	13000	310	0.04	≤0.25
0.5	2.5	60	38000	610	0.03	≤0.5	20	13000	210	0.03	≤0.25
0.5	3	60	38000	550	0.03	≤0.5	20	13000	180	0.03	≤0.25
0.6	3	60	32000	640	0.035	≤0.6	20	10500	210	0.035	≤0.3
0.7	3.5	60	27000	640	0.035	≤0.7	20	9100	190	0.035	≤0.35
0.8	2.4	60	24000	960	0.06	≤0.8	20	8000	260	0.06	≤0.4
0.8	3	60	24000	840	0.05	≤0.8	20	8000	230	0.05	≤0.4
0.8	4	60	24000	670	0.04	≤0.8	20	8000	190	0.04	≤0.4
1	5	60	20000	800	0.05	≤1	20	6500	210	0.05	≤0.5
Depth of cut											

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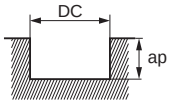
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

■Slotting

Work Material		Carbon steel, Alloy steel, Austenitic stainless steels, Titanium alloys Cobaly chromium alloy, Copper, Copper alloy AISI 1045, AISI 4140, AISI 4340, AISI 304, AISI 306, AISI 304LN, AISI 316LN, Ti-6Al-4V				Heat resistant alloys, Pre-hardened steel, Hardened steel Inconel718, AISI P21, AISI P20, AISI H13, AISI L6, AISI 431, AISI 420			
Dia. **DC** (mm)	Neck Length **LU** (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.2	0.6	20	30000	270	0.03	15	24000	220	0.03
0.3	0.9	30	30000	360	0.045	14	15000	180	0.045
0.3	1.5	30	30000	270	0.045	14	15000	140	0.045
0.4	1	40	30000	600	0.06	15	12000	240	0.06
0.4	1.8	40	30000	420	0.06	15	12000	170	0.06
0.5	1.5	45	28000	670	0.075	15	9500	230	0.075
0.5	2.5	45	28000	450	0.075	15	9500	150	0.075
0.5	3	45	28000	390	0.075	15	9500	130	0.075
0.6	3	45	24000	480	0.09	15	7800	160	0.09
0.7	3.5	45	20000	480	0.11	15	6800	140	0.11
0.8	2.4	45	18000	720	0.12	15	6000	190	0.12
0.8	3	45	18000	650	0.12	15	6000	170	0.12
0.8	4	45	18000	500	0.12	15	6000	140	0.12
1	5	45	15000	600	0.15	15	4800	150	0.15
Depth of cut		 DC:Dia.							

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) When the depth of cut is small, the feed rate can be increased.

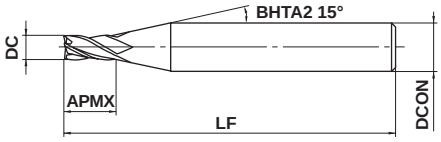
VF4MD

End mill, Medium cut length, 4 flute, For hardened materials

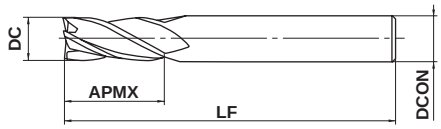
TOOL NEWS

UWC VF γ 35°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute end mill suitable for high-speed machining of hardened steel.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF4MDD0100	1	2.5	40	4	4	●	1
VF4MDD0150	1.5	3.8	40	4	4	●	1
VF4MDD0200	2	5	40	4	4	●	1
VF4MDD0250	2.5	6.3	40	4	4	●	1
VF4MDD0300	3	7.5	50	6	4	●	1
VF4MDD0400	4	10	50	6	4	●	1
VF4MDD0500	5	12.5	50	6	4	●	1
VF4MDD0600	6	15	50	6	4	●	2
VF4MDD0800	8	20	60	8	4	●	2
VF4MDD1000	10	25	70	10	4	●	2
VF4MDD1200	12	30	90	12	4	●	2
VF4MDD1600	16	40	100	16	4	●	2
VF4MDD2000	20	50	110	20	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	3000	0.06	32000	2400	0.06	16000	710	0.05
1.5	40000	4500	0.12	32000	3600	0.08	10600	650	0.08
2	30000	4500	0.18	24000	3600	0.10	8100	520	0.10
2.5	24000	3900	0.25	19000	3000	0.13	6400	450	0.13
3	20000	3500	0.30	16000	2700	0.15	5400	390	0.15
4	15000	3000	0.40	12000	2400	0.20	4000	450	0.20
5	12000	2400	0.50	9000	1800	0.25	3200	380	0.20
6	10000	2100	0.60	7000	1400	0.30	2700	320	0.20
8	8000	1500	0.80	5600	1100	0.40	2000	240	0.20
10	6400	1400	1.00	4500	950	0.50	1600	210	0.30
12	5400	1200	1.00	3800	860	0.50	1300	160	0.30
16	2400	550	3.00	1200	280	0.80	1000	130	0.30
20	1900	480	4.00	1000	240	1.00	800	100	0.30
Depth of cut	≤Please refer to the list above for depth of cut. ≤1DC			DC ≤Please refer to the list above for depth of cut.			DC:Dia.		

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When drilling, please set the feed rate at 1/3 or below the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

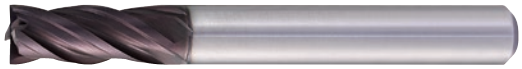
VF4MV

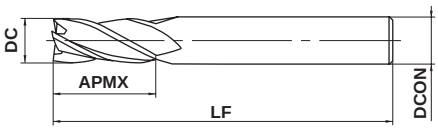
End mill, Medium cut length, 4 flute, For hardened materials

TOOL NEWS

UWC VF 35° 38°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				





Type1

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●An irregular helix 4 flute square end mill suitable for high-speed machining of hardened steel.

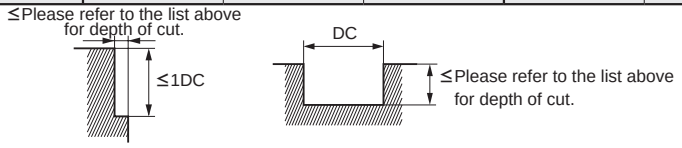
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF4MVD0600	6	15	50	6	4	●	1
VF4MVD0800	8	20	60	8	4	●	1
VF4MVD1000	10	25	70	10	4	●	1
VF4MVD1200	12	30	90	12	4	●	1
VF4MVD1600	16	40	100	16	4	●	1
VF4MVD2000	20	50	110	20	4	●	1

RECOMMENDED CUTTING CONDITIONS

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
6	10000	2100	0.60	7000	1400	0.30	2700	320	0.20
8	8000	1500	0.80	5600	1100	0.40	2000	240	0.20
10	6400	1400	1.00	4500	950	0.50	1600	210	0.30
12	5400	1200	1.00	3800	860	0.50	1300	160	0.30
16	2400	550	3.00	1200	280	0.80	1000	130	0.30
20	1900	480	4.00	1000	240	1.00	800	100	0.30

Depth of cut



DC:Dia.

Note 1) When slotting, reduce the revolutions by 50−70% and the feed rate by 40−60%.
Note 2) For austenitic stainless steels, titanium and heat-resistant alloys, the VFMHV is recommended.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

● : **Inventory maintained in Japan.**

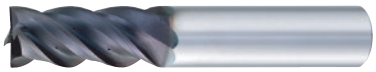
VFMHVCH

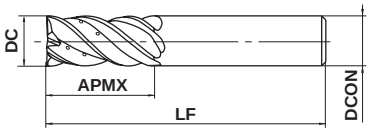
End mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS





Type1

16≤DC≤20				
0 - 0.03				
DCON=16	DCON=20			
0 - 0.011	0 - 0.013			

h6

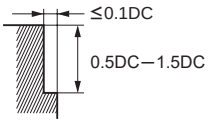
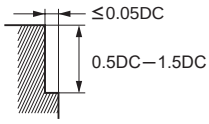
● Vibration control end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFMHVCHD1600	16	35	90	16	4	●	1
VFMHVCHD2000	20	45	110	20	4	●	1

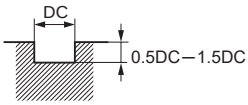
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1140	2000	560	800	110
20	2400	860	1600	510	600	100
Depth of cut						

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	2400	670	1400	380	1400	170
20	1900	610	1100	350	1100	130
Depth of cut						

DC:Dia.

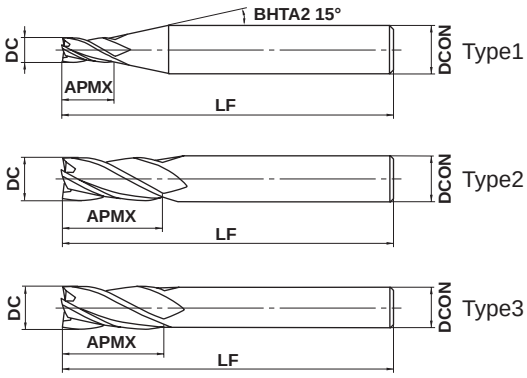
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

VC4MC

End mill, Medium cut length, 4 flute

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC4MCD0200	2	6	40	4	4	●	1
VC4MCD0250	2.5	8	40	4	4	●	1
VC4MCD0300	3	8	45	6	4	●	1
VC4MCD0350	3.5	10	45	6	4	●	1
VC4MCD0400	4	11	45	6	4	●	1
VC4MCD0450	4.5	11	45	6	4	●	1
VC4MCD0500	5	13	50	6	4	●	1
VC4MCD0550	5.5	13	50	6	4	●	1
VC4MCD0600	6	13	50	6	4	●	2
VC4MCD0650	6.5	16	60	8	4	●	1
VC4MCD0700	7	16	60	8	4	●	1
VC4MCD0750	7.5	16	60	8	4	●	1
VC4MCD0800	8	19	60	8	4	●	2
VC4MCD0850	8.5	19	70	10	4	●	1
VC4MCD0900	9	19	70	10	4	●	1
VC4MCD0950	9.5	19	70	10	4	●	1
VC4MCD1000	10	22	70	10	4	●	2
VC4MCD1050	10.5	22	75	12	4	●	1
VC4MCD1100	11	22	75	12	4	●	1
VC4MCD1150	11.5	22	75	12	4	●	1
VC4MCD1200	12	26	75	12	4	●	2
VC4MCD1250	12.5	26	75	12	4	●	3
VC4MCD1300	13	26	75	12	4	●	3
VC4MCD1400	14	26	75	12	4	●	3
VC4MCD1500	15	30	80	16	4	●	1
VC4MCD1600	16	32	90	16	4	●	2
VC4MCD1700	17	32	90	16	4	●	3
VC4MCD1800	18	32	90	16	4	●	3
VC4MCD1900	19	32	100	20	4	●	1
VC4MCD2000	20	38	100	20	4	●	2
VC4MCD2200	22	38	100	20	4	●	3
VC4MCD2400	24	45	120	25	4	●	1
VC4MCD2500	25	45	120	25	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
2	30000	4500	0.18	24000	3600	0.10
2.5	24000	3900	0.25	19000	3000	0.13
3	20000	3500	0.30	16000	2700	0.15
4	15000	3000	0.40	12000	2400	0.20
5	12000	2400	0.50	9000	1800	0.25
6	10000	2100	0.60	7000	1470	0.30
8	8000	1500	0.80	5600	1050	0.40
10	6400	1400	1.00	4500	950	0.50
12	5400	1200	1.00	3800	860	0.50
16	2400	550	2.00	1200	120	0.80
20	1900	480	3.00	1000	100	1.00
Depth of cut	≤Please refer to the list above for depth of cut. ≤DC DC ≤Please refer to the list above for depth of cut. DC:Dia.					

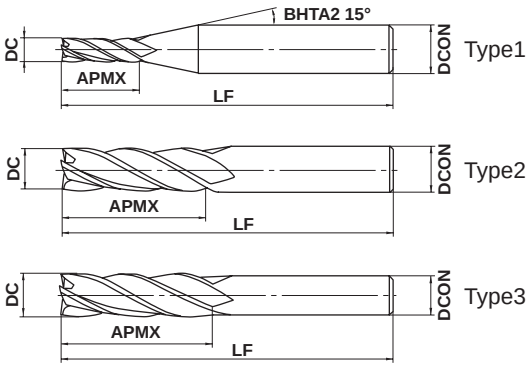
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50－70% and the feed rate to 40－60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VC4JC

End mill, Semi long cut length, 4 flute

UWC VC γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

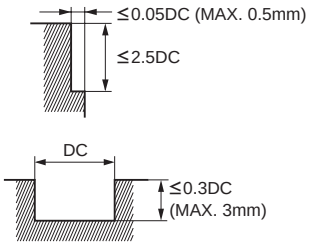
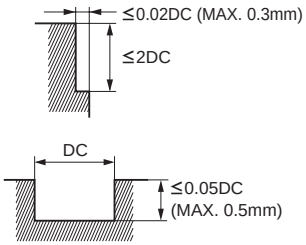
●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC4JCD0300	3	12	50	6	4	●	1
VC4JCD0350	3.5	15	50	6	4	●	1
VC4JCD0400	4	15	50	6	4	●	1
VC4JCD0450	4.5	15	50	6	4	●	1
VC4JCD0500	5	20	60	6	4	●	1
VC4JCD0550	5.5	20	60	6	4	●	1
VC4JCD0600	6	20	60	6	4	●	2
VC4JCD0650	6.5	25	70	8	4	●	1
VC4JCD0700	7	25	70	8	4	●	1
VC4JCD0750	7.5	25	70	8	4	●	1
VC4JCD0800	8	25	70	8	4	●	2
VC4JCD0850	8.5	25	90	10	4	●	1
VC4JCD0900	9	25	90	10	4	●	1
VC4JCD0950	9.5	25	90	10	4	●	1
VC4JCD1000	10	30	90	10	4	●	2
VC4JCD1050	10.5	30	90	12	4	●	1
VC4JCD1100	11	30	90	12	4	●	1
VC4JCD1150	11.5	30	90	12	4	●	1
VC4JCD1200	12	30	90	12	4	●	2
VC4JCD1300	13	35	90	12	4	●	3
VC4JCD1400	14	40	110	16	4	●	1
VC4JCD1500	15	40	110	16	4	●	1
VC4JCD1600	16	50	110	16	4	●	2
VC4JCD1700	17	50	110	20	4	●	1
VC4JCD1800	18	50	110	20	4	●	1
VC4JCD1900	19	55	110	20	4	●	1
VC4JCD2000	20	55	110	20	4	●	2
VC4JCD2200	22	65	140	25	4	●	1
VC4JCD2400	24	75	140	25	4	●	1
VC4JCD2500	25	75	140	25	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	4200	110	3400	95	2600	70	2100	50
4	3400	140	2700	110	2100	85	1700	60
5	2900	170	2300	140	1800	100	1500	70
6	2500	200	2000	170	1500	130	1300	85
8	1900	220	1500	170	1200	150	1000	85
10	1600	220	1300	170	950	130	800	85
12	1300	170	1100	150	800	100	670	70
16	1000	140	820	110	600	80	500	50
20	800	110	650	85	480	70	400	40
25	650	85	520	70	380	50	320	35
Depth of cut								

DC:Dia.

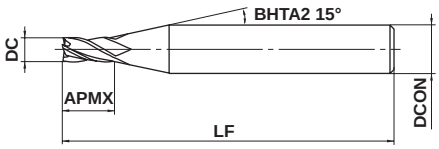
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The above table shows cutting conditions for standard side milling. For slotting, please reduce the feed rate only to 50% of the table figure. Please set the revolution rate at 60% and the feed rate at 40% when slotting austenitic stainless steels.
Note 4) When drilling, please set the feed rate at 1/3 or below the values above.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VCMDSC

End mill, Medium cut length, 4−6 flute

UWC VC 30° DC<3 DC=3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1

0.5≤DC≤3				
0 / - 0.020				
DCON=6				
0 / - 0.008				

h6

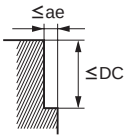
●Recommended for shape nose cutting hardened steels.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VCMDSCD0050	0.5	1	45	6	4	●	1
VCMDSCD0100	1	2.5	45	6	4	●	1
VCMDSCD0150	1.5	4	45	6	4	●	1
VCMDSCD0200	2	6	45	6	4	●	1
VCMDSCD0250	2.5	8	45	6	4	●	1
VCMDSCD0300	3	8	45	6	6	●	1

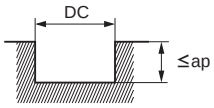
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ae (mm)
0.5	40000	2000	0.03	30000	600	0.02
1	40000	3000	0.05	20000	900	0.03
1.5	40000	5000	0.08	18000	1100	0.05
2	40000	5600	0.10	16000	1300	0.06
3	34000	5600	0.15	13000	1600	0.09
Depth of cut	 DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The above condition are for shoulder milling. For slotting ϕ3 or larger diameters, set the revolution, feed rate and depth of cut at 20－40% of the table figures.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

■Slot milling with small diameter tools

Work Material	Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
0.5	20000	200	0.05	15000	90	0.03
1	15000	300	0.1	11000	110	0.05
1.5	10000	280	0.15	7500	150	0.07
2	8000	320	0.2	6000	190	0.1
Depth of cut	 DC:Dia.					

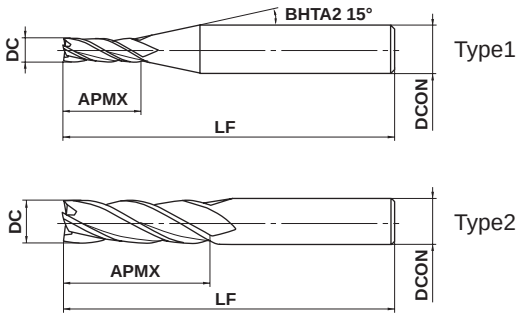
Note 1) Air blow or oil mist is recommended for good chip evacuation.

CRN4JC

End mill, Semi long cut length, 4 flute, For copper electrodes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○



3≤DC≤12				
0 - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

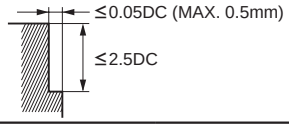
●4 flute end mill with CRN coating for copper electrode machining.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
CRN4JCD0300	3	12	50	6	4	●	1
CRN4JCD0400	4	15	50	6	4	●	1
CRN4JCD0500	5	20	60	6	4	●	1
CRN4JCD0600	6	20	60	6	4	●	2
CRN4JCD0800	8	25	70	8	4	●	2
CRN4JCD1000	10	30	90	10	4	●	2
CRN4JCD1200	12	30	90	12	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Copper, Copper alloys	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	10600	280
4	8000	330
5	6400	380
6	5300	420
8	4000	460
10	3200	460
12	2700	460
Depth of cut	 DC:Dia.	

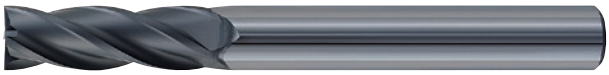
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) When drilling, please set the feed rate at 1/3 or below of the table value.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

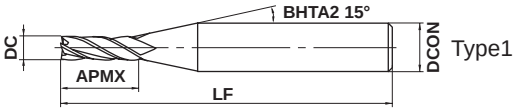
DF4JC

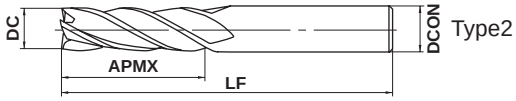
End mill, Semi long cut length, 4 flute, For graphite

TOOL NEWS

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○







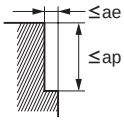
3≤DC≤12				
0 - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

●4 flute end mill with original diamond coating for graphite machining.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DF4JCD0300	3	12	60	6	4	●	1
DF4JCD0400	4	16	60	6	4	●	1
DF4JCD0600	6	24	60	6	4	●	2
DF4JCD0800	8	28	70	8	4	●	2
DF4JCD1000	10	35	90	10	4	●	2
DF4JCD1200	12	36	110	12	4	●	2

RECOMMENDED CUTTING CONDITIONS

Work Material	Graphite				Copper, Copper alloys			
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)
3	22000	2500	6	0.15	10600	280	6	0.15
4	18000	2900	8	0.2	8000	330	8	0.2
6	14000	3200	12	0.3	6400	380	12	0.3
8	10500	2900	16	0.4	4000	420	16	0.4
10	8700	2600	20	0.5	3200	460	20	0.5
12	7200	2200	24	0.6	2700	460	24	0.6
Depth of cut	 DC:Dia.							

Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : **Inventory maintained in Japan.**

DF4XL

End mill, Long neck, 4 flute, For graphite

TOOL NEWS

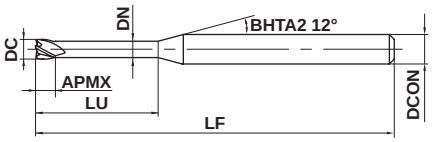
UWC

DF

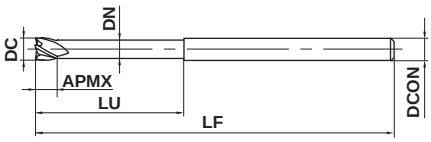
30°

DC<3 DC≥3

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○



Type1



Type2

1≤DC≤12				
0 - 0.02				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●4 flute long neck end mill with original diamond coating for graphite machining.

(mm)

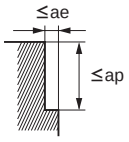
Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
DF4XLD0100N060	1	1.5	6	0.94	50	4	4	●	1
DF4XLD0100N080	1	1.5	8	0.94	50	4	4	●	1
DF4XLD0100N100	1	1.5	10	0.94	50	4	4	●	1
DF4XLD0150N100	1.5	2.3	10	1.44	60	4	4	●	1
DF4XLD0150N160	1.5	2.3	16	1.44	60	4	4	●	1
DF4XLD0200N100	2	3	10	1.9	60	4	4	●	1
DF4XLD0200N160	2	3	16	1.9	60	4	4	●	1
DF4XLD0200N200	2	3	20	1.9	60	4	4	●	1
DF4XLD0300N160	3	4.5	16	2.9	70	4	4	●	1
DF4XLD0300N200	3	4.5	20	2.9	70	4	4	●	1
DF4XLD0300N300	3	4.5	30	2.9	70	4	4	●	1
DF4XLD0400N200	4	6	20	3.9	80	4	4	●	2
DF4XLD0400N400	4	6	40	3.9	80	4	4	●	2
DF4XLD0600N300	6	9	30	5.85	70	6	4	●	2
DF4XLD0800N300	8	12	30	7.85	90	8	4	●	2
DF4XLD1000N300	10	15	30	9.7	90	10	4	●	2
DF4XLD1200N300	12	18	30	11.7	110	12	4	●	2

DF4XL

End mill, Long neck, 4 flute, For graphite

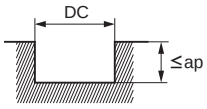
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material		Graphite				Copper, Copper alloys			
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)
1	6	30000	1300	1	0.05	30000	1300	1	0.05
	8	25000	1000	1	0.05	25000	1000	1	0.05
	10	22000	700	1	0.05	22000	700	1	0.05
1.5	10	25000	1200	1.5	0.075	21000	1000	1.5	0.075
	16	18000	800	1.5	0.075	18000	800	1.5	0.075
2	10	22000	1500	2	0.1	16000	1100	2	0.1
	16	19000	1100	2	0.1	16000	930	2	0.1
	20	16000	800	2	0.1	16000	800	2	0.1
3	16	21000	1900	3	0.15	10600	960	3	0.15
	20	18000	1500	3	0.15	10600	890	3	0.15
	30	14000	1000	3	0.15	10600	760	3	0.15
4	20	18000	2400	4	0.4	8000	1100	4	0.4
	40	13000	1500	4	0.4	8000	920	4	0.4
6	30	14000	3200	6	0.6	5300	1200	6	0.6
8	30	10500	2900	8	0.8	4000	1100	8	0.8
10	30	8700	2600	10	1.0	3200	960	10	1.0
12	30	7200	2200	12	1.2	2650	800	12	1.2
Depth of cut									

Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

Slotting

Work Material		Graphite			Copper, Copper alloys		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of Cut ap (mm)
1	6	30000	1000	0.1	30000	980	0.1
	8	25000	700	0.08	25000	700	0.08
	10	22000	500	0.06	22000	500	0.06
1.5	10	25000	1100	0.14	21000	750	0.14
	16	18000	600	0.1	18000	600	0.1
2	10	22000	1200	0.2	16000	820	0.2
	16	19000	800	0.16	16000	700	0.16
	20	16000	600	0.12	16000	600	0.12
3	16	21000	1400	0.3	10600	720	0.3
	20	18000	1100	0.25	10600	670	0.25
	30	14000	700	0.2	10600	570	0.2
4	20	18000	1800	0.5	8000	820	0.5
	40	13000	900	0.4	8000	690	0.4
6	30	14000	2300	1.2	5300	900	1.2
8	30	10500	2000	2.0	4000	820	2.0
10	30	8700	1900	3.0	3200	720	3.0
12	30	7200	1700	4.0	2650	600	4.0
Depth of cut		 DC:Dia.					

Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

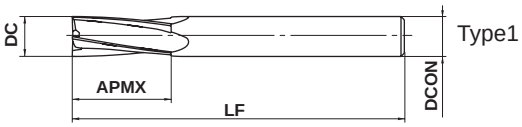
DFC4JC

Diamond coating endmill, 4 flute

TOOL NEWS

CFRP

◎



6≤DC≤12				
0 - 0.03				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

●4 flute end mill with original CVD diamond coating for CFRP machining.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DFC4JCD0600	6	20	70	6	4	●	1
DFC4JCD0800	8	30	80	8	4	●	1
DFC4JCD1000	10	30	90	10	4	●	1
DFC4JCD1200	12	30	100	12	4	●	1

Note 1) Please contact Mitsubishi Materials for geometries and through coolant types that are non-standard.

RECOMMENDED CUTTING CONDITIONS

Work Material	CFRP	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
6	11000	950
8	8000	780
10	6400	700
12	5300	650

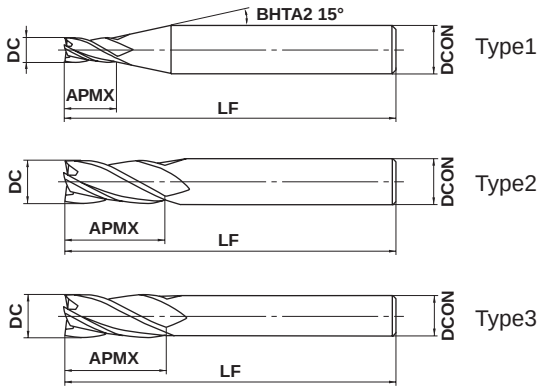
Note 1) Cutting conditions may differ considerably due to the kind of CFRP, the rigidity of the machine, or the clamping and geometry of the workpiece. Please use the above table as a guideline.
Note 2) When high machining accuracy is needed or if large burrs or delamination occur, we recommend reducing the feed rate.
Note 3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.
Note 4) Please take precautions against dust.

● : **Inventory maintained in Japan.**

C4MC

End mill, Medium cut length, 4 flute, Center cutting

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●4 flute uncoated center cutting end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C4MCD0300	3	8	45	6	4	▲	1
C4MCD0350	3.5	10	45	6	4	▲	1
C4MCD0400	4	11	45	6	4	▲	1
C4MCD0450	4.5	11	45	6	4	▲	1
C4MCD0500	5	13	50	6	4	▲	1
C4MCD0550	5.5	13	50	6	4	▲	1
C4MCD0600	6	13	50	6	4	▲	2
C4MCD0650	6.5	16	60	8	4	▲	1
C4MCD0700	7	16	60	8	4	▲	1
C4MCD0750	7.5	16	60	8	4	▲	1
C4MCD0800	8	19	60	8	4	▲	2
C4MCD0850	8.5	19	70	10	4	▲	1
C4MCD0900	9	19	70	10	4	▲	1
C4MCD0950	9.5	19	70	10	4	▲	1
C4MCD1000	10	22	70	10	4	▲	2
C4MCD1050	10.5	22	75	12	4	▲	1
C4MCD1100	11	22	75	12	4	▲	1
C4MCD1150	11.5	22	75	12	4	▲	1
C4MCD1200	12	26	75	12	4	▲	2
C4MCD1250	12.5	26	75	12	4	▲	3
C4MCD1300	13	26	75	12	4	▲	3
C4MCD1400	14	26	75	12	4	▲	3
C4MCD1500	15	30	80	16	4	▲	1
C4MCD1600	16	32	90	16	4	▲	2
C4MCD1700	17	32	90	16	4	▲	3
C4MCD1800	18	32	90	16	4	▲	3
C4MCD1900	19	32	100	20	4	▲	1
C4MCD2000	20	38	100	20	4	▲	2

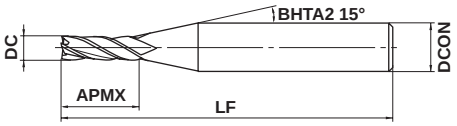
▲ : Product scheduled to be discontinued at the end of March 2020
SEG4SA(J185) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and SEG4SA(J185),VQMHV(J154) is alternative for processing of other cutting materials.

C4JC

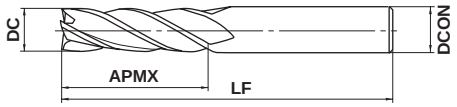
End mill, Semi long cut length, 4 flute, Center cutting

UWC γ 30°

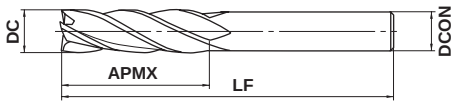
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



Type1



Type2



Type3

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute uncoated end mill for general use.

(mm)

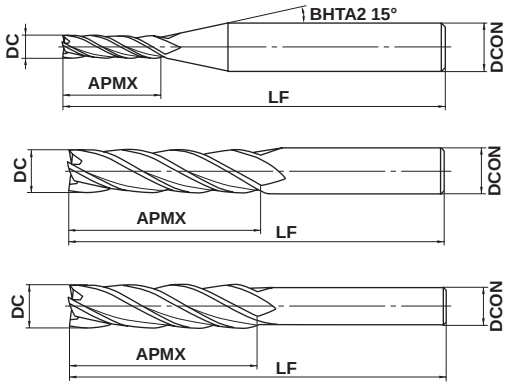
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C4JCD0300	3	12	50	6	4	▲	1
C4JCD0350	3.5	15	50	6	4	▲	1
C4JCD0400	4	15	50	6	4	▲	1
C4JCD0450	4.5	15	50	6	4	▲	1
C4JCD0500	5	20	60	6	4	▲	1
C4JCD0550	5.5	20	60	6	4	▲	1
C4JCD0600	6	20	60	6	4	▲	2
C4JCD0650	6.5	25	70	8	4	▲	1
C4JCD0700	7	25	70	8	4	▲	1
C4JCD0750	7.5	25	70	8	4	▲	1
C4JCD0800	8	25	70	8	4	▲	2
C4JCD0850	8.5	25	90	10	4	▲	1
C4JCD0900	9	25	90	10	4	▲	1
C4JCD0950	9.5	25	90	10	4	▲	1
C4JCD1000	10	30	90	10	4	▲	2
C4JCD1050	10.5	30	90	12	4	▲	1
C4JCD1100	11	30	90	12	4	▲	1
C4JCD1150	11.5	30	90	12	4	▲	1
C4JCD1200	12	30	90	12	4	▲	2
C4JCD1300	13	35	90	12	4	▲	3
C4JCD1400	14	40	110	16	4	▲	1
C4JCD1500	15	40	110	16	4	▲	1
C4JCD1600	16	50	110	16	4	▲	2
C4JCD1700	17	50	110	20	4	▲	1
C4JCD1800	18	50	110	20	4	▲	1
C4JCD1900	19	55	110	20	4	▲	1
C4JCD2000	20	55	110	20	4	▲	2
C4JCD2200	22	65	140	25	4	▲	1
C4JCD2400	24	75	140	25	4	▲	1
C4JCD2500	25	75	140	25	4	▲	2

▲ : Product scheduled to be discontinued at the end of March 2020
SEE4L(J186) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MPJHV(J134),VQJHV(J158) is alternative for processing of other cutting materials.

C4LC

End mill, Long cut length, 4 flute, Center cutting

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			○	○	○	○



DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

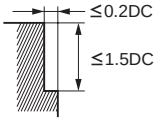
●4 flute end mill with longer cut length than standard.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C4LCD0300	3	20	60	6	4	▲	1
C4LCD0350	3.5	22	60	6	4	▲	1
C4LCD0400	4	25	60	6	4	▲	1
C4LCD0450	4.5	25	60	6	4	▲	1
C4LCD0500	5	30	70	6	4	▲	1
C4LCD0550	5.5	30	70	6	4	▲	1
C4LCD0600	6	30	70	6	4	▲	2
C4LCD0650	6.5	30	90	8	4	▲	1
C4LCD0700	7	40	90	8	4	▲	1
C4LCD0750	7.5	40	90	8	4	▲	1
C4LCD0800	8	40	90	8	4	▲	2
C4LCD0850	8.5	40	100	10	4	▲	1
C4LCD0900	9	40	100	10	4	▲	1
C4LCD0950	9.5	40	100	10	4	▲	1
C4LCD1000	10	50	100	10	4	▲	2
C4LCD1050	10.5	50	110	12	4	▲	1
C4LCD1100	11	50	110	12	4	▲	1
C4LCD1150	11.5	50	110	12	4	▲	1
C4LCD1200	12	50	110	12	4	▲	2
C4LCD1250	12.5	50	120	12	4	▲	3
C4LCD1300	13	50	120	12	4	▲	3
C4LCD1400	14	70	130	16	4	▲	1
C4LCD1500	15	70	130	16	4	▲	1
C4LCD1600	16	70	130	16	4	▲	2
C4LCD1700	17	70	140	20	4	▲	1
C4LCD1800	18	70	140	20	4	▲	1
C4LCD1900	19	70	140	20	4	▲	1
C4LCD2000	20	70	140	20	4	▲	2

RECOMMENDED CUTTING CONDITIONS (C4MC)

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1050, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI P20, AISI H13, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	4100	150	3500	130	2800	100	2300	90
4	3400	260	2900	210	2200	140	1900	120
5	2900	290	2400	230	1800	150	1500	135
6	2500	300	2100	260	1600	170	1300	140
8	1900	300	1600	260	1200	160	1000	150
10	1500	270	1250	230	950	140	800	135
12	1250	230	1050	200	800	120	660	110
16	940	170	800	140	600	90	500	80
20	750	140	640	120	480	75	400	70
Depth of cut	 DC:Dia.							

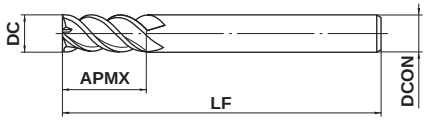
Note 1) Decrease the feed rate by 20−30% for C4JC.
Note 2) Decrease the revolution by 20−30% and the feed rate by 40−50% for C4LC.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

SEG4SA

End mill, Medium cut length, 4 flute, Irregular spiral helix angle, For aluminium alloy

UWC 38° 41°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						○	◎



Type1

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

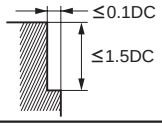
●4 flute end mill with irregular helix angle for aluminium alloy.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
SEG4060SA	6	14	50	6	4	●	1
SEG4080SA	8	19	60	8	4	●	1
SEG4100SA	10	24	70	10	4	●	1
SEG4120SA	12	29	75	12	4	●	1
SEG4160SA	16	38	90	16	4	●	1
SEG4200SA	20	48	110	20	4	●	1
SEG4250SA	25	59	125	25	4	●	1

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy Plastics		Pure copper	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
6	9600	1700	4800	840
8	7200	1800	3600	900
10	5800	1800	2900	910
12	4800	2000	2400	980
16	3600	2000	1800	980
20	2900	2400	1400	1100
25	2300	2400	1100	1100
Depth of cut	 ≤0.1DC ≤1.5DC DC:Dia.			

Note 1) The cutting conditions above are a guide only to milling within the standard depth of cut.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

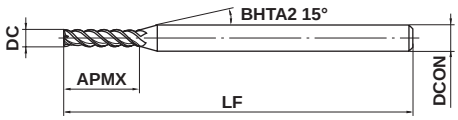
● : **Inventory maintained in Japan.**

SEE4L

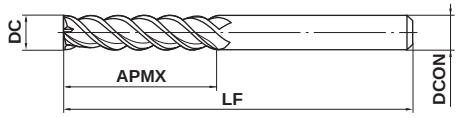
End mill, Long cut length, 4 flute

UWC 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○	○	○



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

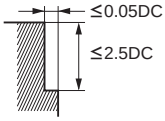
●4 flute high helix end mill.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
SEE4030L	3	15	55	6	4	●	1
SEE4040L	4	20	60	6	4	●	1
SEE4050L	5	25	65	6	4	●	1
SEE4060L	6	25	65	6	4	●	2
SEE4070L	7	35	80	8	4	●	1
SEE4080L	8	35	80	8	4	●	2
SEE4090L	9	45	90	10	4	●	1
SEE4100L	10	45	95	10	4	●	2
SEE4110L	11	55	105	12	4	●	1
SEE4120L	12	55	105	12	4	●	2
SEE4140L	14	70	125	16	4	●	1
SEE4150L	15	70	125	16	4	●	1
SEE4160L	16	70	125	16	4	●	2
SEE4180L	18	70	125	20	4	●	1
SEE4200L	20	75	140	20	4	●	2
SEE4250L	25	85	160	25	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Alloy steel (180−280HB) AISI 1045, AISI P20		Carbon steel, Alloy steel (280−380HB) AISI 1045, AISI P20		Pre-hardened steel (35−45HRC)		Stainless steel (270HB≥) AISI 420		Cast iron (Tensile Strength 350MPa≥) AISI No 35 B	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	3400	150	3000	60	2100	30	2600	60	5500	240
4	2400	170	2200	90	1600	50	1900	80	4200	270
5	2000	180	1800	90	1300	60	1500	80	3300	300
6	1600	180	1500	90	1000	60	1300	80	2800	320
8	1200	170	1100	90	800	60	960	80	2100	320
10	1000	150	880	90	640	60	760	80	1600	320
12	800	150	760	110	520	60	640	90	1400	320
14	720	150	640	110	480	60	560	110	1200	320
16	600	140	560	110	400	60	480	110	1000	330
18	560	140	480	120	360	60	440	110	960	330
20	480	120	440	120	320	60	400	110	840	350
25	400	120	360	110	240	50	320	90	680	330
Depth of cut	 DC:Dia.									

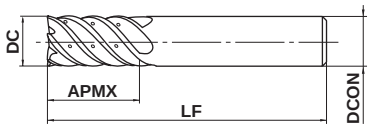
Note 1) The cutting conditions above are a guide only to milling within the standard depth of cut.
Note 2) Ductile cast iron milling has the same cutting conditions as carbon steel and alloy steel. (180−280HB)
Note 3) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VQ6MHVCH NEW

End mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple internal through coolant

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎	○	

CoolStar
END MILLS



Type1

DC≤12	DC>12			
0 / - 0.020	0 / - 0.030			
DCON=10	DCON=12	DCON=16	DCON=20	
0 / - 0.009	0 / - 0.011	0 / - 0.011	0 / - 0.013	

h6

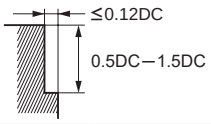
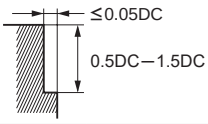
● Vibration control end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VQ6MHVCHD1000	10	22	70	10	6	●	1
VQ6MHVCHD1200	12	26	75	12	6	●	1
VQ6MHVCHD1600	16	32	90	16	6	●	1
VQ6MHVCHD2000	20	38	100	20	6	●	1

RECOMMENDED CUTTING CONDITIONS

■Shoulder Milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V		Copper, Copper alloy		Heat Resistant Alloys Inconel 718	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	—	—	4800	2000	—	—	1300	260
12	—	—	4000	2000	—	—	1100	230
16	4000	2200	3000	1600	2400	1400	800	180
20	3200	1900	2400	1400	1900	1100	640	150
Depth of Cut								

DC:Dia.

■Trochoid Milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	—	—	4800	1400
12	—	—	4000	1200
16	4000	1600	3000	1100
20	3200	1400	2400	900
Depth of Cut				

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.

Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

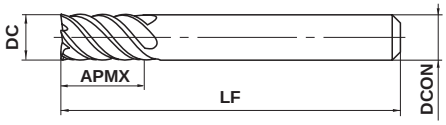
● : **Inventory maintained in Japan.**

VF6MHV

End mill, Medium cut length, 6 flute, Irregular helix flutes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		



Type1

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

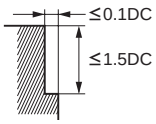
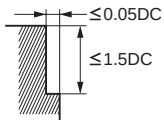
● Newly developed irregular helix 6 flute geometry reduces vibrations and achieves high efficiency machining. Suitable for machining of difficult-to-cut materials such as stainless steel, titanium alloy and inconel.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF6MHVD0600	6	13	50	6	6	●	1
VF6MHVD0800	8	19	60	8	6	●	1
VF6MHVD1000	10	22	70	10	6	●	1
VF6MHVD1200	12	26	75	12	6	●	1
VF6MHVD1600	16	32	90	16	6	●	1
VF6MHVD2000	20	38	100	20	6	●	1

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
6	10600	2900	8000	2000	2100	320
8	8000	2900	6000	2000	1600	300
10	6400	2700	4800	2000	1300	260
12	5300	2700	4000	2000	1100	230
16	4000	2200	3000	1600	800	180
20	3200	1900	2400	1400	640	150
Depth of cut						

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

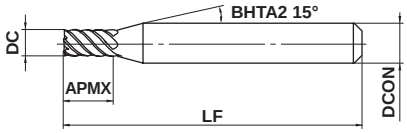
VFSD

End mill, Short cut length, For hardened materials

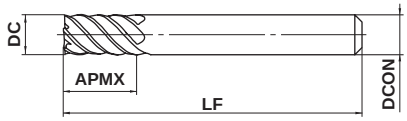
TOOL NEWS

UWC VF 30° 45° DC<3 DC≥3 DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

1≤DC≤12				
0 - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●End mill with Impact Miracle coating for high hardened materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFSDD0100	1	2	45	6	4	●	1
VFSDD0150	1.5	3	45	6	4	●	1
VFSDD0200	2	4	45	6	4	●	1
VFSDD0250	2.5	5	45	6	4	●	1
VFSDD0300	3	6	45	6	6	●	1
VFSDD0350	3.5	7	45	6	6	●	1
VFSDD0400	4	8	45	6	6	●	1
VFSDD0500	5	10	50	6	6	●	1
VFSDD0600	6	12	50	6	6	●	2
VFSDD0800	8	16	60	8	6	●	2
VFSDD1000	10	20	70	10	6	●	2
VFSDD1200	12	24	75	12	6	●	2

● : Inventory maintained in Japan.

VFMD

End mill, Medium cut length, For hardened materials

TOOL NEWS

UWC

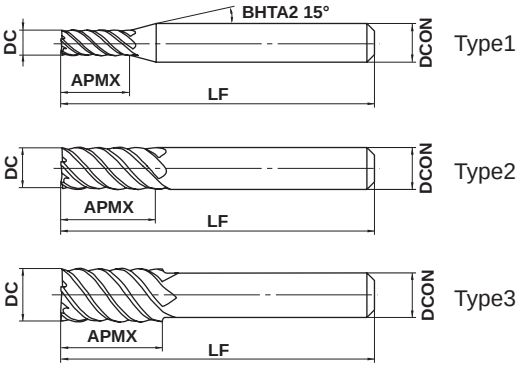
VF

30° DC<3

45° DC≥3

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●End mill with Impact Miracle coating for high hardened materials.

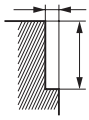
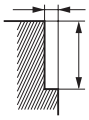
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFMDD0100	1	3.5	60	6	4	●	1
VFMDD0150	1.5	5	60	6	4	●	1
VFMDD0200	2	7	60	6	4	●	1
VFMDD0250	2.5	8	60	6	4	●	1
VFMDD0300	3	10	60	6	6	●	1
VFMDD0400	4	12	60	6	6	●	1
VFMDD0500	5	15	60	6	6	●	1
VFMDD0600	6	15	60	6	6	●	2
VFMDD0800	8	20	75	8	6	●	2
VFMDD1000	10	25	80	10	6	●	2
VFMDD1200	12	30	100	12	6	●	2
VFMDD1400	14	35	105	12	6	●	3
VFMDD1500	15	40	110	16	6	●	1
VFMDD1600	16	40	110	16	6	●	2
VFMDD1800	18	40	120	16	6	●	3
VFMDD2000	20	45	125	20	6	●	2
VFMDD2200	22	45	135	20	6	●	3
VFMDD2500	25	60	160	25	6	●	2

VFSD
End mill, Short cut length, For hardened materials

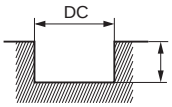
VFMD
End mill, Medium cut length, For hardened materials

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2			Hardened steel (62−70HRC) AISI W1, AISI M2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	1200	0.05	40000	800	0.03	32000	500	0.02
2	40000	2000	0.1	24000	1000	0.05	16000	600	0.05
3	32000	3800	0.2	16000	1900	0.1	11000	1200	0.05
4	24000	4400	0.2	12000	2200	0.1	8000	1300	0.05
6	16000	5800	0.3	8000	2900	0.2	5300	1800	0.1
8	12000	5800	0.4	6000	2900	0.2	4000	1800	0.1
10	9600	5800	0.5	4800	2900	0.3	3200	1800	0.2
12	8000	4800	0.6	4000	2400	0.3	2700	1500	0.2
16	6000	3600	0.8	3000	1800	0.5	2000	1100	0.3
20	4800	2900	1.0	2400	1400	0.5	1600	880	0.3
25	3800	2300	1.0	1900	1100	0.5	1300	720	0.3
Depth of cut	 ≤Please refer to the list above for depth of cut. ≤1.5DC			 ≤Please refer to the list above for depth of cut. ≤1.0DC					

DC:Dia.

■Slot milling with small diameter tools

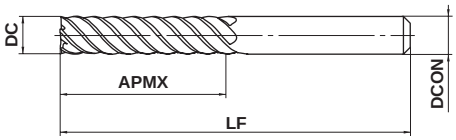
Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	15000	300	0.1	9500	110	0.05
2	8000	320	0.2	4800	190	0.1
Depth of cut	 ≤Please refer to the list above for depth of cut. DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VCLD

End mill, Long cut length, 6 flute

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**20≤DCON≤25**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

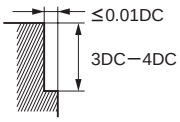
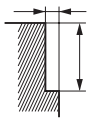
h6

● Ideal for tool steel and hardened materials machining

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VCLDD0600	6	26	70	6	6	●	1
VCLDD0800	8	36	90	8	6	●	1
VCLDD1000	10	46	100	10	6	●	1
VCLDD1200	12	56	110	12	6	●	1
VCLDD1600	16	66	130	16	6	●	1
VCLDD2000	20	76	140	20	6	●	1
VCLDD2500	25	92	180	25	6	●	1

RECOMMENDED CUTTING CONDITIONS

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45−55HRC) AISI H13		Hardened steel (55−62HRC) AISI D2		Hardened steel (62−70HRC) AISI W1, AISI M2	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
6	2100	450	1600	330	1300	240	1100	190
8	1600	430	1200	310	1000	230	800	170
10	1300	420	960	290	800	220	640	150
12	1100	380	800	260	660	200	530	140
16	800	310	600	220	500	160	400	120
20	640	270	480	190	400	140	320	110
25	510	230	380	160	320	120	260	90
Depth of cut	 ≤0.01DC 3DC−4DC				 ≤0.005DC 3DC−4DC			

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : **Inventory maintained in Japan.**

VF8MHVCH

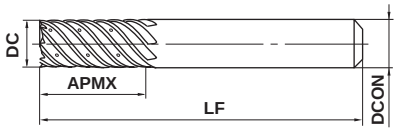
End mill, Medium cut length, Irregular helix flutes, with multiple internal through coolant holes

TOOL NEWS

44°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS



Type1

16≤DC≤20				
0 - 0.03				
DCON=16	DCON=20			
0 - 0.011	0 - 0.013			

h6

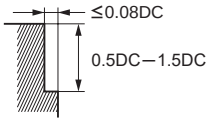
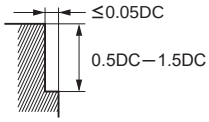
● Vibration control end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF8MHVCHD1600	16	32	90	16	8	●	1
VF8MHVCHD2000	20	38	100	20	8	●	1

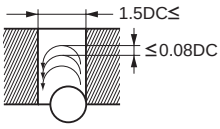
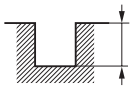
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	4000	2400	3000	2100	800	240
20	3200	1900	2400	1900	640	200
Depth of cut						

DC:Dia.

■Trochoidal slotting

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	4000	1900	3000	1400
20	3200	1500	2400	1200
Depth of cut				

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

● : Inventory maintained in Japan.

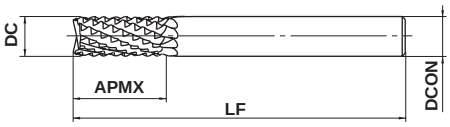
DFCJRT

Diamond coating endmill with cross-nick

TOOL NEWS

CFRP

◎



Type1

h6	DCON=6	8≤DCON≤10	DCON=12		
	0 - 0.008	0 - 0.009	0 - 0.011		

● Cross-nick type end mill with original CVD diamond coating for CFRP machining.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DFCJRTD0600	6	20	70	6	10	●	1
DFCJRTD0800	8	30	80	8	10	●	1
DFCJRTD1000	10	30	90	10	12	●	1
DFCJRTD1200	12	30	100	12	12	●	1

Note 1) Please contact Mitsubishi Materials for geometries and through coolant types that are non-standard.

RECOMMENDED CUTTING CONDITIONS

Work Material	CFRP	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
6	11000	1200
8	8000	1000
10	6400	900
12	5300	850

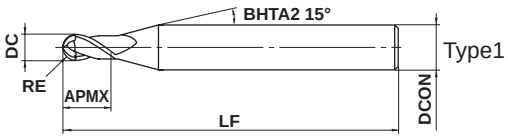
Note 1) Cutting conditions may differ considerably due to the kind of CFRP, the rigidity of the machine, or the clamping and geometry of the workpiece. Please use the above table as a guideline.
Note 2) When high machining accuracy is needed or if large burrs or delamination occur, we recommend reducing the feed rate.
Note 3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.
Note 4) Please take precautions against dust.

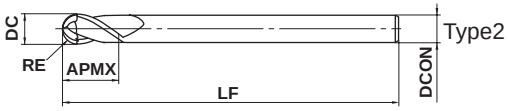
MP2SSB

Ball nose, Short cut length, 2 flute, Short shank

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





0.1≤RE≤6				
±0.005				

4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.005	0 - 0.006	0 - 0.008		

●2-flute ball nose end mills with short cutting edge length for general purpose. Excellent performance for a wide range of workpiece materials such as carbon steel, alloy steel and hardened steel.

(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MP2SSBR0010	0.1	0.2	0.2	40	4	2	●	1
MP2SSBR0020	0.2	0.4	0.4	40	4	2	●	1
MP2SSBR0030	0.3	0.6	0.6	40	4	2	●	1
MP2SSBR0040	0.4	0.8	0.8	40	4	2	●	1
MP2SSBR0050	0.5	1	1	40	4	2	●	1
MP2SSBR0050S06	0.5	1	1	40	6	2	●	1
MP2SSBR0075	0.75	1.5	1.5	40	4	2	●	1
MP2SSBR0075S06	0.75	1.5	1.5	40	6	2	●	1
MP2SSBR0100	1	2	2	45	6	2	●	1
MP2SSBR0150	1.5	3	3	45	6	2	●	1
MP2SSBR0200	2	4	4	45	6	2	●	1
MP2SSBR0250	2.5	5	5	50	6	2	●	1
MP2SSBR0300	3	6	6	50	6	2	●	2
MP2SSBR0400	4	8	8	60	8	2	●	2
MP2SSBR0500	5	10	10	70	10	2	●	2
MP2SSBR0600	6	12	12	75	12	2	●	2

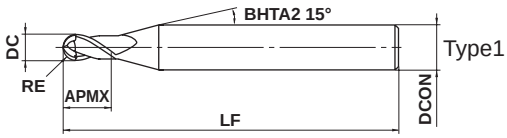
● : Inventory maintained in Japan.

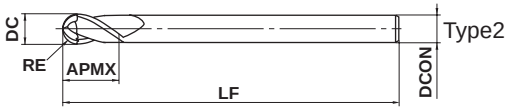
MP2SB

Ball nose, Short cut length, 2 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





0.1≤RE≤6				
±0.005				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 / - 0.005	0 / - 0.006	0 / - 0.008		

●2-flute ball nose end mills with short cutting edge length for general purpose. Excellent performance for a wide range of workpiece materials such as carbon steel, alloy steel and hardened steel.

(mm)

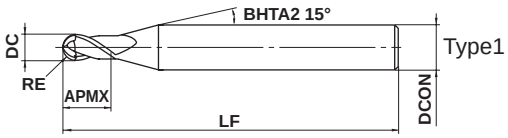
Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MP2SBR0010	0.1	0.2	0.3	45	4	2	●	1
MP2SBR0015	0.15	0.3	0.5	45	4	2	●	1
MP2SBR0020	0.2	0.4	0.6	45	4	2	●	1
MP2SBR0020S06	0.2	0.4	0.6	50	6	2	●	1
MP2SBR0025	0.25	0.5	0.8	45	4	2	●	1
MP2SBR0030	0.3	0.6	0.9	45	4	2	●	1
MP2SBR0030S06	0.3	0.6	0.9	50	6	2	●	1
MP2SBR0035	0.35	0.7	1.1	45	4	2	●	1
MP2SBR0040	0.4	0.8	1.2	45	4	2	●	1
MP2SBR0040S06	0.4	0.8	1.2	50	6	2	●	1
MP2SBR0045	0.45	0.9	1.4	45	4	2	●	1
MP2SBR0050	0.5	1	1.5	45	4	2	●	1
MP2SBR0050S06	0.5	1	1.5	50	6	2	●	1
MP2SBR0060	0.6	1.2	1.8	45	4	2	●	1
MP2SBR0070	0.7	1.4	2.1	45	4	2	●	1
MP2SBR0075	0.75	1.5	2.3	45	4	2	●	1
MP2SBR0075S06	0.75	1.5	2.3	50	6	2	●	1
MP2SBR0080	0.8	1.6	2.4	45	4	2	●	1
MP2SBR0090	0.9	1.8	2.7	45	4	2	●	1
MP2SBR0100	1	2	3	50	4	2	●	1
MP2SBR0100S06	1	2	3	50	6	2	●	1
MP2SBR0125	1.25	2.5	3.8	50	4	2	●	1
MP2SBR0150	1.5	3	4.5	70	6	2	●	1
MP2SBR0200	2	4	6	70	6	2	●	1
MP2SBR0250	2.5	5	7.5	80	6	2	●	1
MP2SBR0300	3	6	9	80	6	2	●	2
MP2SBR0400	4	8	12	90	8	2	●	2
MP2SBR0500	5	10	15	100	10	2	●	2
MP2SBR0600	6	12	18	110	12	2	●	2

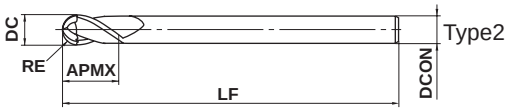
MP2MB

Ball nose, Medium cutting length, 2 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





0.25≤RE≤6				
±0.005				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.005	0 - 0.006	0 - 0.008		

●2-flute ball nose end mills with medium cutting edge length for general purpose. Excellent performance for a wide range of workpiece materials such as carbon steel, alloy steel and hardened steel.

(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MP2MBR0025	0.25	0.5	1	45	4	2	●	1
MP2MBR0030	0.3	0.6	1.2	45	4	2	●	1
MP2MBR0040	0.4	0.8	1.6	45	4	2	●	1
MP2MBR0050	0.5	1	2.5	45	4	2	●	1
MP2MBR0060	0.6	1.2	2.5	45	4	2	●	1
MP2MBR0070	0.7	1.4	3	45	4	2	●	1
MP2MBR0075	0.75	1.5	4	45	4	2	●	1
MP2MBR0080	0.8	1.6	4	45	4	2	●	1
MP2MBR0090	0.9	1.8	5	45	4	2	●	1
MP2MBR0100	1	2	6	50	4	2	●	1
MP2MBR0125	1.25	2.5	6	50	4	2	●	1
MP2MBR0150	1.5	3	8	70	6	2	●	1
MP2MBR0150S03	1.5	3	8	70	3	2	●	2
MP2MBR0175	1.75	3.5	8	70	6	2	●	1
MP2MBR0200	2	4	8	70	6	2	●	1
MP2MBR0200S04	2	4	8	70	4	2	●	2
MP2MBR0250	2.5	5	12	80	6	2	●	1
MP2MBR0300	3	6	12	80	6	2	●	2
MP2MBR0400	4	8	14	90	8	2	●	2
MP2MBR0500	5	10	18	100	10	2	●	2
MP2MBR0600	6	12	22	110	12	2	●	2

● : Inventory maintained in Japan.

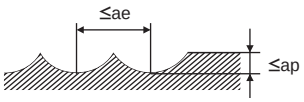
Ball nose, Short cut length, 2 flute, Short shank MP2SSB
Ball nose, Short cut length, 2 flute MP2SB Ball nose, Medium cutting length, 2 flute MP2MB

RECOMMENDED CUTTING CONDITIONS

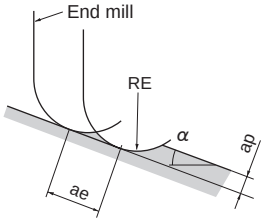
Work Material	Mild Steel,Carbon steel, Alloy steel, Pre-hardened steel, Hardened steel (−45HRC) AISI 1050, AISI P21, AISI H13						Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R0.1	40000	300	40000	250	0.003	0.02	40000	300	40000	250	0.003	0.02
R0.15	40000	500	40000	350	0.007	0.03	40000	500	40000	350	0.007	0.03
R0.2	40000	1600	40000	1200	0.02	0.04	40000	1300	40000	1000	0.015	0.04
R0.25	40000	2400	40000	1400	0.025	0.05	40000	1900	40000	1200	0.02	0.05
R0.3	40000	3200	40000	1600	0.03	0.06	40000	2400	40000	1400	0.025	0.06
R0.4	40000	4800	40000	2400	0.05	0.08	40000	2400	40000	1900	0.04	0.08
R0.5	40000	5600	40000	3200	0.06	0.1	40000	3200	38000	2400	0.05	0.1
R0.75	40000	6500	40000	4000	0.09	0.15	40000	3200	25000	1600	0.08	0.15
R1	40000	6500	39000	4700	0.11	0.2	32000	3200	19000	1500	0.11	0.2
R1.25	40000	7000	33000	4500	0.12	0.25	25000	2500	15000	1200	0.12	0.25
R1.5	40000	7500	27000	4300	0.13	0.3	21000	2100	13000	1100	0.13	0.3
R2	32000	7500	20000	3600	0.15	0.4	16000	1900	9500	900	0.15	0.4
R2.5	25000	6000	16000	2900	0.2	0.5	13000	1600	7600	750	0.2	0.5
R3	21000	5800	13000	2600	0.25	0.6	11000	1500	6400	700	0.25	0.6
R4	16000	4500	10000	2000	0.3	0.8	8000	1400	4800	670	0.3	0.8
R5	13000	3600	8000	1700	0.5	1.0	6400	1300	3800	620	0.5	1.0
R6	9000	2500	6000	1300	0.5	1.2	5300	1300	3200	620	0.5	1.2

Work Material	Hardened steel (45−55HRC) AISI 420, AISI H13						Copper, Copper alloys					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R0.1	40000	300	40000	250	0.003	0.02	40000	300	40000	250	0.003	0.02
R0.15	40000	500	40000	350	0.007	0.03	40000	500	40000	350	0.007	0.03
R0.2	40000	1300	40000	950	0.015	0.04	40000	1300	40000	950	0.015	0.04
R0.25	40000	1900	40000	1100	0.02	0.05	40000	1900	40000	1100	0.02	0.05
R0.3	40000	2500	40000	1300	0.025	0.06	40000	2500	40000	1300	0.025	0.06
R0.4	40000	4000	40000	1900	0.04	0.08	40000	4000	40000	1900	0.04	0.08
R0.5	40000	5600	40000	3000	0.05	0.1	40000	5600	40000	3000	0.05	0.1
R0.75	40000	6500	32000	3200	0.08	0.15	40000	6500	32000	3200	0.08	0.15
R1	40000	6500	31000	3500	0.11	0.2	40000	6500	31000	3500	0.11	0.2
R1.25	36000	6500	26000	3500	0.12	0.25	36000	6500	26000	3500	0.12	0.25
R1.5	32000	6000	22000	3400	0.13	0.3	32000	6000	22000	3400	0.13	0.3
R2	25000	6000	16000	2700	0.15	0.4	25000	6000	16000	2700	0.15	0.6
R2.5	20000	5400	13000	2300	0.2	0.5	20000	5400	13000	2300	0.2	0.75
R3	17000	4700	10000	2000	0.25	0.6	17000	4700	10000	2000	0.25	0.9
R4	13000	3600	8000	1500	0.3	0.8	13000	3600	8000	1500	0.3	1.6
R5	10000	2900	6400	1200	0.5	1.0	10000	2900	6400	1200	0.5	2.0
R6	7200	2000	4800	1000	0.5	1.2	8500	2300	5300	1100	0.5	2.4

Depth of cut



Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 4) Standard cutting conditions of austenitic stainless steel and titanium alloy, please reduce to 60% revolution and 45% feedrate. (Hardened steel (45−55HRC) table above)



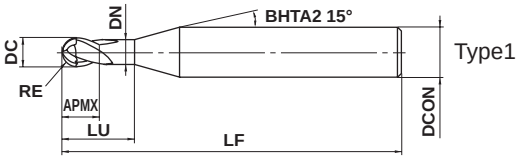
ae:Pick feed

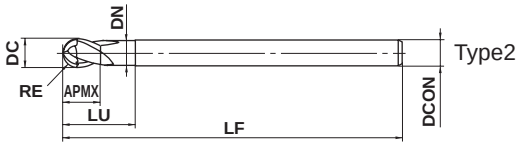
MP2SDB

Ball nose, Short cut length, 2 flute, High strength

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎					





0.5≤RE≤6				
±0.01				
4≤DCON≤6	DCON=8			
0 / - 0.005	0 / - 0.006			
DCON=10	DCON=12			
0 / - 0.009	0 / - 0.011			

●Excellent chipping resistance with a strong S curve cutting edge.
Ideal for semi-finish machining of forging dies.

(mm)

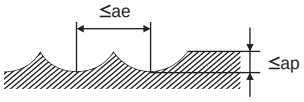
Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
MP2SDBR0050	0.5	1	1	2	0.96	45	4	2	●	1
MP2SDBR0075S06	0.75	1.5	1.5	3	1.44	50	6	2	●	1
MP2SDBR0100	1	2	2	4	1.90	50	4	2	●	1
MP2SDBR0100S06	1	2	2	4	1.90	60	6	2	●	1
MP2SDBR0150	1.5	3	3	6	2.90	70	6	2	●	1
MP2SDBR0200	2	4	4	8	3.90	60	4	2	●	2
MP2SDBR0200S06	2	4	4	8	3.90	70	6	2	●	1
MP2SDBR0250	2.5	5	5	10	4.90	80	6	2	●	1
MP2SDBR0300	3	6	12	18	5.85	80	6	2	●	2
MP2SDBR0300A120	3	6	12	18	5.85	120	6	2	●	2
MP2SDBR0400	4	8	14	24	7.85	90	8	2	●	2
MP2SDBR0400A130	4	8	14	24	7.85	130	8	2	●	2
MP2SDBR0500	5	10	18	30	9.70	100	10	2	●	2
MP2SDBR0500A140	5	10	18	30	9.70	140	10	2	●	2
MP2SDBR0600	6	12	22	36	11.70	110	12	2	●	2
MP2SDBR0600A140	6	12	22	36	11.70	140	12	2	●	2

Note 1) MS plus end mills series MP2SB and MP2MB are recommended for finish surface processing.

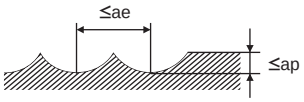
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

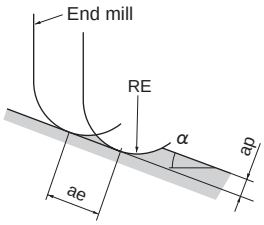
■Overhang below 5D (D:Dia.)

Work Material	Carbon steel, Alloy steel, Tool steel, Alloy tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21						Hardened steel (45－55HRC) AISI H13, AISI L6					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 0.5	40000	3900	36000	2100	0.1	0.25	40000	4300	36000	2200	0.1	0.25
R 0.75	40000	4200	36000	2600	0.15	0.35	40000	4700	36000	2700	0.15	0.35
R 1	40000	4500	36000	3100	0.2	0.5	40000	5000	36000	3300	0.2	0.5
R 1.5	37000	5300	24000	2700	0.3	0.75	37000	5800	24000	2800	0.3	0.75
R 2X4	24000	3200	15000	2000	0.25	0.7	19000	2800	13000	1600	0.25	0.7
R 2	30000	4900	19000	2500	0.4	1	28000	5000	19000	2400	0.4	1
R 2.5	25000	4500	16000	2300	0.5	1.3	22000	4200	16000	2200	0.5	1.25
R 3	22000	4300	14000	2200	0.6	1.8	18000	3800	12000	1800	0.6	1.5
R 4	19000	3900	12000	2000	0.8	2.4	15000	3200	9500	1600	0.8	2
R 5	15000	3300	9500	1800	1	3	11000	2500	7000	1400	1	2.5
R 6	12000	2550	8000	1600	1.2	3.6	9000	2000	6000	1300	1.2	3
Depth of cut												

■Overhang below 7D (D:Dia.)

Work Material	Carbon steel, Alloy steel, Tool steel, Alloy tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21						Hardened steel (45－55HRC) AISI H13, AISI L6					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 3	10000	1500	6900	1000	0.2	1	8000	1400	5300	770	0.2	0.8
R 4	8000	1400	5600	900	0.3	1.5	6400	1300	4000	650	0.3	1.2
R 5	6000	1200	4100	740	0.4	2	4800	1100	3200	580	0.4	1.6
R 6	5000	1000	3400	600	0.45	2.4	4000	900	2700	490	0.45	2
Depth of cut												

Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.



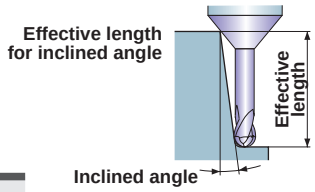
ae:Pick feed

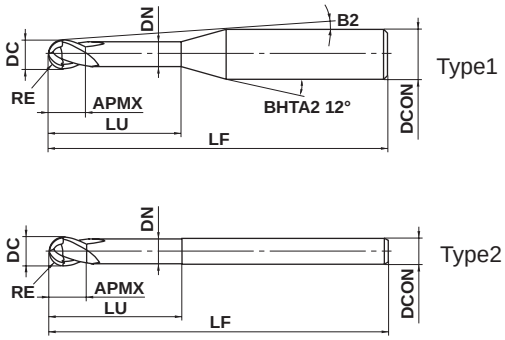
MP2XLB

End mill, Short cut length, 2 flute, Long neck

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





0.05≤RE≤3			
±0.005			
4≤DCON≤6			
0 / - 0.005			

●2-flute long neck ball nose end mills. Excellent performance for a wide range of workpiece materials such as carbon steel, alloy steel and hardened steel.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
MP2XLBR0005N003	0.05	0.1	0.08	0.3	0.085	11.6°	50	4	2	●	1	0.3	0.3	0.4	0.4
MP2XLBR0005N005	0.05	0.1	0.08	0.5	0.085	11.4°	50	4	2	●	1	0.5	0.5	0.6	0.7
MP2XLBR0010N005	0.1	0.2	0.15	0.5	0.18	11.5°	50	4	2	●	1	0.5	0.5	0.6	0.7
MP2XLBR0010N008	0.1	0.2	0.15	0.75	0.18	11.2°	50	4	2	●	1	0.8	0.8	0.9	1.0
MP2XLBR0010N010	0.1	0.2	0.15	1	0.18	10.9°	50	4	2	●	1	1.0	1.1	1.2	1.3
MP2XLBR0010N013	0.1	0.2	0.15	1.25	0.18	10.6°	50	4	2	●	1	1.3	1.4	1.5	1.7
MP2XLBR0010N015	0.1	0.2	0.15	1.5	0.18	10.4°	50	4	2	●	1	1.6	1.6	1.8	2.0
MP2XLBR0010N018	0.1	0.2	0.15	1.75	0.18	10.2°	50	4	2	●	1	1.8	1.9	2.1	2.3
MP2XLBR0010N020	0.1	0.2	0.15	2	0.18	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0010N025	0.1	0.2	0.15	2.5	0.18	9.5°	50	4	2	●	1	2.6	2.7	3.0	3.3
MP2XLBR0015N005	0.15	0.3	0.24	0.5	0.28	11.5°	50	4	2	●	1	0.5	0.5	0.6	0.6
MP2XLBR0015N008	0.15	0.3	0.24	0.75	0.28	11.2°	50	4	2	●	1	0.8	0.8	0.9	1.0
MP2XLBR0015N010	0.15	0.3	0.24	1	0.28	10.9°	50	4	2	●	1	1.0	1.1	1.2	1.3
MP2XLBR0015N010S06	0.15	0.3	0.24	1	0.28	11.3°	50	6	2	●	1	1.0	1.1	1.2	1.3
MP2XLBR0015N013	0.15	0.3	0.24	1.25	0.28	10.7°	50	4	2	●	1	1.3	1.4	1.5	1.6
MP2XLBR0015N013S06	0.15	0.3	0.24	1.25	0.28	11.1°	50	6	2	●	1	1.3	1.4	1.5	1.6
MP2XLBR0015N015	0.15	0.3	0.24	1.5	0.28	10.4°	50	4	2	●	1	1.6	1.6	1.8	2.0
MP2XLBR0015N015S06	0.15	0.3	0.24	1.5	0.28	10.9°	50	6	2	●	1	1.6	1.6	1.8	2.0
MP2XLBR0015N018	0.15	0.3	0.24	1.75	0.28	10.2°	50	4	2	●	1	1.8	1.9	2.1	2.3
MP2XLBR0015N020	0.15	0.3	0.24	2	0.28	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0015N025	0.15	0.3	0.24	2.5	0.28	9.5°	50	4	2	●	1	2.6	2.7	3.0	3.3
MP2XLBR0015N030	0.15	0.3	0.24	3	0.28	9.1°	50	4	2	●	1	3.1	3.3	3.6	4.0
MP2XLBR0015N035	0.15	0.3	0.24	3.5	0.28	8.7°	50	4	2	●	1	3.7	3.8	4.2	4.6
MP2XLBR0015N040	0.15	0.3	0.24	4	0.28	8.4°	50	4	2	●	1	4.2	4.4	4.8	5.3
MP2XLBR0020N005	0.2	0.4	0.3	0.5	0.37	11.6°	50	4	2	●	1	0.5	0.5	0.5	0.6
MP2XLBR0020N008	0.2	0.4	0.3	0.75	0.37	11.3°	50	4	2	●	1	0.7	0.8	0.9	0.9
MP2XLBR0020N010	0.2	0.4	0.3	1	0.37	11°	50	4	2	●	1	1.0	1.1	1.2	1.3
MP2XLBR0020N010S06	0.2	0.4	0.3	1	0.37	11.3°	50	6	2	●	1	1.0	1.1	1.2	1.3
MP2XLBR0020N015	0.2	0.4	0.3	1.5	0.37	10.4°	50	4	2	●	1	1.5	1.6	1.7	1.9
MP2XLBR0020N020	0.2	0.4	0.3	2	0.37	9.9°	50	4	2	●	1	2.1	2.2	2.3	2.6
MP2XLBR0020N020S06	0.2	0.4	0.3	2	0.37	10.6°	50	6	2	●	1	2.1	2.2	2.3	2.6
MP2XLBR0020N025	0.2	0.4	0.3	2.5	0.37	9.5°	50	4	2	●	1	2.6	2.7	2.9	3.3

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MP2XLBR0020N030	0.2	0.4	0.3	3	0.37	9.1°	50	4	2	●	1	3.1	3.2	3.5	3.9
MP2XLBR0020N035	0.2	0.4	0.3	3.5	0.37	8.7°	50	4	2	●	1	3.6	3.8	4.1	4.6
MP2XLBR0020N040	0.2	0.4	0.3	4	0.37	8.4°	50	4	2	●	1	4.2	4.3	4.7	5.2
MP2XLBR0020N045	0.2	0.4	0.3	4.5	0.37	8°	50	4	2	●	1	4.7	4.9	5.3	5.9
MP2XLBR0020N050	0.2	0.4	0.3	5	0.37	7.7°	50	4	2	●	1	5.2	5.4	5.9	6.6
MP2XLBR0020N055	0.2	0.4	0.3	5.5	0.37	7.5°	50	4	2	●	1	5.7	6.0	6.5	7.2
MP2XLBR0020N060	0.2	0.4	0.3	6	0.37	7.2°	50	4	2	●	1	6.2	6.5	7.1	7.9
MP2XLBR0025N010	0.25	0.5	0.37	1	0.47	11°	50	4	2	●	1	1.0	1.0	1.1	1.2
MP2XLBR0025N015	0.25	0.5	0.37	1.5	0.47	10.4°	50	4	2	●	1	1.5	1.6	1.7	1.9
MP2XLBR0025N015S06	0.25	0.5	0.37	1.5	0.47	11°	50	6	2	●	1	1.5	1.6	1.7	1.9
MP2XLBR0025N020	0.25	0.5	0.37	2	0.47	9.9°	50	4	2	●	1	2.1	2.1	2.3	2.6
MP2XLBR0025N020S06	0.25	0.5	0.37	2	0.47	10.6°	50	6	2	●	1	2.1	2.1	2.3	2.6
MP2XLBR0025N025	0.25	0.5	0.37	2.5	0.47	9.5°	50	4	2	●	1	2.6	2.7	2.9	3.2
MP2XLBR0025N025S06	0.25	0.5	0.37	2.5	0.47	10.3°	50	6	2	●	1	2.6	2.7	2.9	3.2
MP2XLBR0025N030	0.25	0.5	0.37	3	0.47	9.1°	50	4	2	●	1	3.1	3.2	3.5	3.9
MP2XLBR0025N030S06	0.25	0.5	0.37	3	0.47	10°	50	6	2	●	1	3.1	3.2	3.5	3.9
MP2XLBR0025N035	0.25	0.5	0.37	3.5	0.47	8.7°	50	4	2	●	1	3.6	3.8	4.1	4.6
MP2XLBR0025N040	0.25	0.5	0.37	4	0.47	8.3°	50	4	2	●	1	4.1	4.3	4.7	5.2
MP2XLBR0025N045	0.25	0.5	0.37	4.5	0.47	8°	50	4	2	●	1	4.7	4.9	5.3	5.9
MP2XLBR0025N050	0.25	0.5	0.37	5	0.47	7.7°	50	4	2	●	1	5.2	5.4	5.9	6.6
MP2XLBR0025N055	0.25	0.5	0.37	5.5	0.47	7.4°	50	4	2	●	1	5.7	6.0	6.5	7.2
MP2XLBR0025N060	0.25	0.5	0.37	6	0.47	7.2°	50	4	2	●	1	6.2	6.5	7.1	7.9
MP2XLBR0025N070	0.25	0.5	0.37	7	0.47	6.7°	50	4	2	●	1	7.3	7.6	8.3	9.2
MP2XLBR0025N080	0.25	0.5	0.37	8	0.47	6.3°	50	4	2	●	1	8.3	8.7	9.5	10.5
MP2XLBR0025N090	0.25	0.5	0.37	9	0.47	5.9°	50	4	2	●	1	9.4	9.8	10.7	11.9
MP2XLBR0025N100	0.25	0.5	0.37	10	0.47	5.6°	50	4	2	●	1	10.4	10.9	11.9	13.2
MP2XLBR0030N015	0.3	0.6	0.45	1.5	0.57	10.4°	50	4	2	●	1	1.5	1.6	1.8	2.0
MP2XLBR0030N015S06	0.3	0.6	0.45	1.5	0.57	11°	50	6	2	●	1	1.5	1.6	1.8	2.0
MP2XLBR0030N020	0.3	0.6	0.45	2	0.57	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0030N020S06	0.3	0.6	0.45	2	0.57	10.6°	50	6	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0030N025	0.3	0.6	0.45	2.5	0.57	9.4°	50	4	2	●	1	2.6	2.7	3.0	3.3
MP2XLBR0030N030	0.3	0.6	0.45	3	0.57	9°	50	4	2	●	1	3.1	3.3	3.6	4.0
MP2XLBR0030N030S06	0.3	0.6	0.45	3	0.57	9.9°	50	6	2	●	1	3.1	3.3	3.6	4.0
MP2XLBR0030N035	0.3	0.6	0.45	3.5	0.57	8.6°	50	4	2	●	1	3.7	3.8	4.2	4.6
MP2XLBR0030N040	0.3	0.6	0.45	4	0.57	8.2°	50	4	2	●	1	4.2	4.4	4.8	5.3
MP2XLBR0030N040S06	0.3	0.6	0.45	4	0.57	9.3°	50	6	2	●	1	4.2	4.4	4.8	5.3
MP2XLBR0030N045	0.3	0.6	0.45	4.5	0.57	7.9°	50	4	2	●	1	4.7	4.9	5.4	5.9
MP2XLBR0030N050	0.3	0.6	0.45	5	0.57	7.6°	50	4	2	●	1	5.2	5.5	6.0	6.6
MP2XLBR0030N050S06	0.3	0.6	0.45	5	0.57	8.8°	50	6	2	●	1	5.2	5.5	6.0	6.6
MP2XLBR0030N055	0.3	0.6	0.45	5.5	0.57	7.3°	50	4	2	●	1	5.8	6.0	6.6	7.3
MP2XLBR0030N060	0.3	0.6	0.45	6	0.57	7.1°	50	4	2	●	1	6.3	6.6	7.2	7.9
MP2XLBR0030N060S06	0.3	0.6	0.45	6	0.57	8.3°	50	6	2	●	1	6.3	6.6	7.2	7.9
MP2XLBR0030N065	0.3	0.6	0.45	6.5	0.57	6.8°	50	4	2	●	1	6.8	7.1	7.8	8.6
MP2XLBR0030N070	0.3	0.6	0.45	7	0.57	6.6°	50	4	2	●	1	7.3	7.6	8.4	9.3
MP2XLBR0030N080	0.3	0.6	0.45	8	0.57	6.2°	50	4	2	●	1	8.4	8.7	9.6	10.6
MP2XLBR0030N080S06	0.3	0.6	0.45	8	0.57	7.6°	50	6	2	●	1	8.4	8.7	9.6	10.6
MP2XLBR0030N085	0.3	0.6	0.45	8.5	0.57	6°	50	4	2	●	1	8.9	9.3	10.2	11.3
MP2XLBR0030N090	0.3	0.6	0.45	9	0.57	5.8°	50	4	2	●	1	9.4	9.8	10.8	11.9
MP2XLBR0030N095	0.3	0.6	0.45	9.5	0.57	5.7°	50	4	2	●	1	9.9	10.4	11.4	12.6
MP2XLBR0030N100	0.3	0.6	0.45	10	0.57	5.5°	50	4	2	●	1	10.5	10.9	12.0	13.2

MP2XLB

End mill, Short cut length, 2 flute, Long neck

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MP2XLBR0030N110	0.3	0.6	0.45	11	0.57	5.2°	50	4	2	●	1	11.5	12.0	13.2	14.6
MP2XLBR0030N120	0.3	0.6	0.45	12	0.57	5°	50	4	2	●	1	12.5	13.1	14.4	15.9
MP2XLBR0040N020	0.4	0.8	0.6	2	0.77	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0040N020S06	0.4	0.8	0.6	2	0.77	10.6°	50	6	2	●	1	2.1	2.2	2.4	2.6
MP2XLBR0040N024S06	0.4	0.8	0.6	2.4	0.77	10.3°	50	6	2	●	1	2.5	2.6	2.8	3.1
MP2XLBR0040N030	0.4	0.8	0.6	3	0.77	8.9°	50	4	2	●	1	3.1	3.3	3.6	3.9
MP2XLBR0040N030S06	0.4	0.8	0.6	3	0.77	9.9°	50	6	2	●	1	3.1	3.3	3.6	3.9
MP2XLBR0040N040	0.4	0.8	0.6	4	0.77	8.2°	50	4	2	●	1	4.2	4.4	4.8	5.2
MP2XLBR0040N040S06	0.4	0.8	0.6	4	0.77	9.3°	50	6	2	●	1	4.2	4.4	4.8	5.2
MP2XLBR0040N050	0.4	0.8	0.6	5	0.77	7.5°	50	4	2	●	1	5.2	5.5	6.0	6.6
MP2XLBR0040N060	0.4	0.8	0.6	6	0.77	6.9°	50	4	2	●	1	6.3	6.5	7.2	7.9
MP2XLBR0040N070	0.4	0.8	0.6	7	0.77	6.5°	50	4	2	●	1	7.3	7.6	8.4	9.2
MP2XLBR0040N080	0.4	0.8	0.6	8	0.77	6°	50	4	2	●	1	8.4	8.7	9.5	10.6
MP2XLBR0040N090	0.4	0.8	0.6	9	0.77	5.7°	50	4	2	●	1	9.4	9.8	10.7	11.9
MP2XLBR0040N100	0.4	0.8	0.6	10	0.77	5.4°	50	4	2	●	1	10.5	10.9	11.9	13.2
MP2XLBR0040N120	0.4	0.8	0.6	12	0.77	4.8°	50	4	2	●	1	12.5	13.1	14.3	15.9
MP2XLBR0050N030	0.5	1	0.75	3	0.96	8.7°	50	4	2	●	1	3.2	3.4	3.7	4.1
MP2XLBR0050N030S06	0.5	1	0.75	3	0.96	9.8°	50	6	2	●	1	3.2	3.4	3.7	4.1
MP2XLBR0050N040	0.5	1	0.75	4	0.96	7.9°	50	4	2	●	1	4.3	4.5	4.9	5.4
MP2XLBR0050N040S06	0.5	1	0.75	4	0.96	9.2°	50	6	2	●	1	4.3	4.5	4.9	5.4
MP2XLBR0050N050	0.5	1	0.75	5	0.96	7.3°	50	4	2	●	1	5.3	5.6	6.1	6.7
MP2XLBR0050N050S06	0.5	1	0.75	5	0.96	8.6°	50	6	2	●	1	5.3	5.6	6.1	6.7
MP2XLBR0050N060	0.5	1	0.75	6	0.96	6.7°	50	4	2	●	1	6.4	6.7	7.3	8.1
MP2XLBR0050N060S06	0.5	1	0.75	6	0.96	8.2°	50	6	2	●	1	6.4	6.7	7.3	8.1
MP2XLBR0050N070	0.5	1	0.75	7	0.96	6.2°	50	4	2	●	1	7.4	7.8	8.5	9.4
MP2XLBR0050N080	0.5	1	0.75	8	0.96	5.8°	50	4	2	●	1	8.5	8.9	9.7	10.7
MP2XLBR0050N080S06	0.5	1	0.75	8	0.96	7.3°	50	6	2	●	1	8.5	8.9	9.7	10.7
MP2XLBR0050N090	0.5	1	0.75	9	0.96	5.5°	50	4	2	●	1	9.5	10.0	10.9	12.0
MP2XLBR0050N100	0.5	1	0.75	10	0.96	5.1°	50	4	2	●	1	10.6	11.1	12.1	13.4
MP2XLBR0050N100S06	0.5	1	0.75	10	0.96	6.7°	60	6	2	●	1	10.6	11.1	12.1	13.4
MP2XLBR0050N120	0.5	1	0.75	12	0.96	4.6°	50	4	2	●	1	12.7	13.2	14.5	16.0
MP2XLBR0050N120S06	0.5	1	0.75	12	0.96	6.1°	60	6	2	●	1	12.7	13.2	14.5	16.0
MP2XLBR0050N140	0.5	1	0.75	14	0.96	4.2°	55	4	2	●	1	14.8	15.4	16.9	18.7
MP2XLBR0050N160	0.5	1	0.75	16	0.96	3.8°	55	4	2	●	1	16.9	17.6	19.3	21.3
MP2XLBR0050N160S06	0.5	1	0.75	16	0.96	5.2°	65	6	2	●	1	16.9	17.6	19.3	21.3
MP2XLBR0050N180	0.5	1	0.75	18	0.96	3.5°	55	4	2	●	1	18.9	19.8	21.7	24.0
MP2XLBR0050N200	0.5	1	0.75	20	0.96	3.3°	55	4	2	●	1	21.0	22.0	24.1	26.6
MP2XLBR0050N200S06	0.5	1	0.75	20	0.96	4.6°	65	6	2	●	1	21.0	22.0	24.1	26.6
MP2XLBR0060N060	0.6	1.2	0.9	6	1.16	6.6°	50	4	2	●	1	6.4	6.7	7.3	8.0
MP2XLBR0060N060S06	0.6	1.2	0.9	6	1.16	8.1°	55	6	2	●	1	6.4	6.7	7.3	8.0
MP2XLBR0060N080	0.6	1.2	0.9	8	1.16	5.7°	50	4	2	●	1	8.5	8.9	9.7	10.7
MP2XLBR0060N080S06	0.6	1.2	0.9	8	1.16	7.3°	55	6	2	●	1	8.5	8.9	9.7	10.7
MP2XLBR0060N100	0.6	1.2	0.9	10	1.16	5°	50	4	2	●	1	10.6	11.0	12.1	13.3
MP2XLBR0060N100S06	0.6	1.2	0.9	10	1.16	6.6°	55	6	2	●	1	10.6	11.0	12.1	13.3
MP2XLBR0060N120	0.6	1.2	0.9	12	1.16	4.4°	50	4	2	●	1	12.7	13.2	14.5	16.0
MP2XLBR0060N120S06	0.6	1.2	0.9	12	1.16	6°	65	6	2	●	1	12.7	13.2	14.5	16.0
MP2XLBR0060N140	0.6	1.2	0.9	14	1.16	4°	55	4	2	●	1	14.8	15.4	16.9	18.7
MP2XLBR0060N160	0.6	1.2	0.9	16	1.16	3.7°	55	4	2	●	1	16.9	17.6	19.3	21.3
MP2XLBR0060N160S06	0.6	1.2	0.9	16	1.16	5.1°	65	6	2	●	1	16.9	17.6	19.3	21.3
MP2XLBR0060N180	0.6	1.2	0.9	18	1.16	3.4°	60	4	2	●	1	18.9	19.8	21.7	24.0

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MP2XLBR0060N200	0.6	1.2	0.9	20	1.16	3.1°	60	4	2	●	1	21.0	21.9	24.0	26.6
MP2XLBR0060N240	0.6	1.2	0.9	24	1.16	2.7°	60	4	2	●	1	25.2	26.3	28.8	*
MP2XLBR0070N080	0.7	1.4	1.05	8	1.34	5.5°	50	4	2	●	1	8.4	8.8	9.6	10.6
MP2XLBR0070N120	0.7	1.4	1.05	12	1.34	4.3°	50	4	2	●	1	12.6	13.1	14.4	15.9
MP2XLBR0070N160	0.7	1.4	1.05	16	1.34	3.5°	50	4	2	●	1	16.8	17.5	19.2	21.2
MP2XLBR0075N030	0.75	1.5	1.1	3	1.44	8.6°	50	4	2	●	1	3.1	3.3	3.6	3.9
MP2XLBR0075N040	0.75	1.5	1.1	4	1.44	7.7°	50	4	2	●	1	4.2	4.4	4.8	5.2
MP2XLBR0075N060	0.75	1.5	1.1	6	1.44	6.3°	50	4	2	●	1	6.3	6.6	7.2	7.9
MP2XLBR0075N060S06	0.75	1.5	1.1	6	1.44	8°	50	6	2	●	1	6.3	6.6	7.2	7.9
MP2XLBR0075N080	0.75	1.5	1.1	8	1.44	5.4°	50	4	2	●	1	8.4	8.8	9.6	10.6
MP2XLBR0075N080S06	0.75	1.5	1.1	8	1.44	7.2°	60	6	2	●	1	8.4	8.8	9.6	10.6
MP2XLBR0075N100	0.75	1.5	1.1	10	1.44	4.7°	50	4	2	●	1	10.5	11.0	12.0	13.2
MP2XLBR0075N100S06	0.75	1.5	1.1	10	1.44	6.5°	60	6	2	●	1	10.5	11.0	12.0	13.2
MP2XLBR0075N120	0.75	1.5	1.1	12	1.44	4.2°	50	4	2	●	1	12.6	13.1	14.4	15.9
MP2XLBR0075N120S06	0.75	1.5	1.1	12	1.44	5.9°	60	6	2	●	1	12.6	13.1	14.4	15.9
MP2XLBR0075N140	0.75	1.5	1.1	14	1.44	3.8°	55	4	2	●	1	14.7	15.3	16.8	18.5
MP2XLBR0075N160	0.75	1.5	1.1	16	1.44	3.4°	55	4	2	●	1	16.8	17.5	19.2	21.2
MP2XLBR0075N160S06	0.75	1.5	1.1	16	1.44	5°	60	6	2	●	1	16.8	17.5	19.2	21.2
MP2XLBR0075N180	0.75	1.5	1.1	18	1.44	3.1°	60	4	2	●	1	18.9	19.7	21.6	23.8
MP2XLBR0075N200	0.75	1.5	1.1	20	1.44	2.9°	60	4	2	●	1	21.0	21.9	23.9	*
MP2XLBR0075N220	0.75	1.5	1.1	22	1.44	2.7°	60	4	2	●	1	23.0	24.0	26.3	*
MP2XLBR0080N080	0.8	1.6	1.2	8	1.54	5.3°	55	4	2	●	1	8.4	8.8	9.6	10.5
MP2XLBR0080N120	0.8	1.6	1.2	12	1.54	4.1°	55	4	2	●	1	12.6	13.1	14.4	15.9
MP2XLBR0080N160	0.8	1.6	1.2	16	1.54	3.3°	55	4	2	●	1	16.8	17.5	19.1	21.2
MP2XLBR0080N200	0.8	1.6	1.2	20	1.54	2.8°	55	4	2	●	1	21.0	21.9	23.9	*
MP2XLBR0090N080	0.9	1.8	1.4	8	1.74	5.1°	55	4	2	●	1	8.4	8.8	9.6	10.5
MP2XLBR0090N120	0.9	1.8	1.4	12	1.74	3.9°	55	4	2	●	1	12.6	13.1	14.3	15.8
MP2XLBR0090N160	0.9	1.8	1.4	16	1.74	3.1°	55	4	2	●	1	16.8	17.5	19.1	21.1
MP2XLBR0090N200	0.9	1.8	1.4	20	1.74	2.6°	55	4	2	●	1	20.9	21.8	23.9	*
MP2XLBR0100N040	1	2	1.5	4	1.94	7.2°	50	4	2	●	1	4.2	4.4	4.7	5.2
MP2XLBR0100N040S06	1	2	1.5	4	1.94	9°	50	6	2	●	1	4.2	4.4	4.7	5.2
MP2XLBR0100N060	1	2	1.5	6	1.94	5.8°	50	4	2	●	1	6.3	6.6	7.1	7.8
MP2XLBR0100N060S06	1	2	1.5	6	1.94	7.8°	50	6	2	●	1	6.3	6.6	7.1	7.8
MP2XLBR0100N080	1	2	1.5	8	1.94	4.8°	50	4	2	●	1	8.4	8.8	9.5	10.5
MP2XLBR0100N080S06	1	2	1.5	8	1.94	6.9°	50	6	2	●	1	8.4	8.8	9.5	10.5
MP2XLBR0100N100	1	2	1.5	10	1.94	4.2°	50	4	2	●	1	10.5	10.9	11.9	13.1
MP2XLBR0100N100S06	1	2	1.5	10	1.94	6.2°	50	6	2	●	1	10.5	10.9	11.9	13.1
MP2XLBR0100N120	1	2	1.5	12	1.94	3.6°	50	4	2	●	1	12.6	13.1	14.3	15.8
MP2XLBR0100N120S06	1	2	1.5	12	1.94	5.6°	60	6	2	●	1	12.6	13.1	14.3	15.8
MP2XLBR0100N140	1	2	1.5	14	1.94	3.2°	55	4	2	●	1	14.7	15.3	16.7	18.4
MP2XLBR0100N140S06	1	2	1.5	14	1.94	5.1°	60	6	2	●	1	14.7	15.3	16.7	18.4
MP2XLBR0100N160	1	2	1.5	16	1.94	2.9°	55	4	2	●	1	16.8	17.5	19.1	*
MP2XLBR0100N160S06	1	2	1.5	16	1.94	4.7°	65	6	2	●	1	16.8	17.5	19.1	21.1
MP2XLBR0100N180	1	2	1.5	18	1.94	2.7°	55	4	2	●	1	18.9	19.7	21.5	*
MP2XLBR0100N180S06	1	2	1.5	18	1.94	4.3°	65	6	2	●	1	18.9	19.7	21.5	23.8
MP2XLBR0100N200	1	2	1.5	20	1.94	2.4°	65	4	2	●	1	20.9	21.8	23.9	*
MP2XLBR0100N200S06	1	2	1.5	20	1.94	4°	65	6	2	●	1	20.9	21.8	23.9	26.4
MP2XLBR0100N220	1	2	1.5	22	1.94	2.3°	65	4	2	●	1	23.0	24.0	26.3	*
MP2XLBR0100N250	1	2	1.5	25	1.94	2°	65	4	2	●	1	26.2	27.3	*	*
MP2XLBR0100N250S06	1	2	1.5	25	1.94	3.5°	90	6	2	●	1	26.2	27.3	29.9	33

* No interference

MP2XLB

End mill, Short cut length, 2 flute, Long neck

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MP2XLBR0100N300	1	2	1.5	30	1.94	1.7°	80	4	2	●	1	31.4	32.7	*	*
MP2XLBR0100N300S06	1	2	1.5	30	1.94	3°	90	6	2	●	1	31.4	32.7	35.9	*
MP2XLBR0100N350	1	2	1.5	35	1.94	1.5°	80	4	2	●	1	36.6	38.2	*	*
MP2XLBR0100N350S06	1	2	1.5	35	1.94	2.7°	90	6	2	●	1	36.6	38.2	41.8	*
MP2XLBR0100N400	1	2	1.5	40	1.94	1.4°	80	4	2	●	1	41.8	43.6	*	*
MP2XLBR0100N400S06	1	2	1.5	40	1.94	2.4°	90	6	2	●	1	41.8	43.6	47.8	*
MP2XLBR0125N100	1.25	2.5	1.9	10	2.4	3.5°	55	4	2	●	1	10.4	10.8	11.8	12.9
MP2XLBR0125N150	1.25	2.5	1.9	15	2.4	2.5°	55	4	2	●	1	15.6	16.3	17.8	*
MP2XLBR0125N200	1.25	2.5	1.9	20	2.4	2°	55	4	2	●	1	20.8	21.7	*	*
MP2XLBR0125N250	1.25	2.5	1.9	25	2.4	1.6°	70	4	2	●	1	26.1	27.2	*	*
MP2XLBR0125N300	1.25	2.5	1.9	30	2.4	1.4°	70	4	2	●	1	31.3	32.6	*	*
MP2XLBR0125N350	1.25	2.5	1.9	35	2.4	1.2°	70	4	2	●	1	36.5	38.1	*	*
MP2XLBR0150N060S03	1.5	3	2.3	6	2.9	–	60	3	2	●	1	*	*	*	*
MP2XLBR0150N080	1.5	3	2.3	8	2.9	6.3°	60	6	2	●	1	8.3	8.6	9.3	10.2
MP2XLBR0150N100	1.5	3	2.3	10	2.9	5.5°	60	6	2	●	1	10.4	10.8	11.7	12.9
MP2XLBR0150N120	1.5	3	2.3	12	2.9	4.9°	60	6	2	●	1	12.5	13.0	14.1	15.5
MP2XLBR0150N140	1.5	3	2.3	14	2.9	4.4°	60	6	2	●	1	14.6	15.2	16.5	18.2
MP2XLBR0150N160	1.5	3	2.3	16	2.9	4°	70	6	2	●	1	16.7	17.3	18.9	20.8
MP2XLBR0150N200	1.5	3	2.3	20	2.9	3.4°	70	6	2	●	1	20.8	21.7	23.7	26.1
MP2XLBR0150N250	1.5	3	2.3	25	2.9	2.8°	70	6	2	●	1	26.1	27.2	29.7	*
MP2XLBR0150N300	1.5	3	2.3	30	2.9	2.5°	70	6	2	●	1	31.3	32.6	35.7	*
MP2XLBR0150N350	1.5	3	2.3	35	2.9	2.2°	90	6	2	●	1	36.5	38.0	41.7	*
MP2XLBR0150N400	1.5	3	2.3	40	2.9	1.9°	90	6	2	●	1	41.7	43.5	*	*
MP2XLBR0175N150	1.75	3.5	2.6	15	3.4	3.8°	65	6	2	●	1	15.6	16.2	17.7	19.4
MP2XLBR0175N250	1.75	3.5	2.6	25	3.4	2.5°	65	6	2	●	1	26.0	27.1	29.6	*
MP2XLBR0175N350	1.75	3.5	2.6	35	3.4	1.9°	90	6	2	●	1	36.5	38.0	*	*
MP2XLBR0175N450	1.75	3.5	2.6	45	3.4	1.5°	90	6	2	●	1	46.9	48.9	*	*
MP2XLBR0200N080S04	2	4	3	8	3.9	–	65	4	2	●	2	*	*	*	*
MP2XLBR0200N100	2	4	3	10	3.9	4.5°	65	6	2	●	1	10.4	10.8	11.6	12.7
MP2XLBR0200N120	2	4	3	12	3.9	3.9°	65	6	2	●	1	12.5	12.9	14.0	15.4
MP2XLBR0200N140	2	4	3	14	3.9	3.4°	65	6	2	●	1	14.6	15.1	16.4	18.0
MP2XLBR0200N160	2	4	3	16	3.9	3.1°	70	6	2	●	1	16.6	17.3	18.8	20.7
MP2XLBR0200N200	2	4	3	20	3.9	2.6°	70	6	2	●	1	20.8	21.7	23.6	*
MP2XLBR0200N250	2	4	3	25	3.9	2.1°	70	6	2	●	1	26.0	27.1	29.6	*
MP2XLBR0200N300	2	4	3	30	3.9	1.8°	80	6	2	●	1	31.2	32.6	*	*
MP2XLBR0200N350	2	4	3	35	3.9	1.6°	80	6	2	●	1	36.5	38.0	*	*
MP2XLBR0200N400	2	4	3	40	3.9	1.4°	90	6	2	●	1	41.7	43.5	*	*
MP2XLBR0200N450	2	4	3	45	3.9	1.2°	90	6	2	●	1	46.9	48.9	*	*
MP2XLBR0200N500	2	4	3	50	3.9	1.1°	100	6	2	●	1	52.1	54.3	*	*
MP2XLBR0250N150	2.5	5	3.8	15	4.9	2°	70	6	2	●	1	15.6	16.2	*	*
MP2XLBR0250N200	2.5	5	3.8	20	4.9	1.5°	70	6	2	●	1	20.8	21.6	*	*
MP2XLBR0250N250	2.5	5	3.8	25	4.9	1.2°	70	6	2	●	1	26.0	27.1	*	*
MP2XLBR0250N300	2.5	5	3.8	30	4.9	1°	80	6	2	●	1	31.2	*	*	*
MP2XLBR0250N350	2.5	5	3.8	35	4.9	0.9°	80	6	2	●	1	36.4	*	*	*
MP2XLBR0250N400	2.5	5	3.8	40	4.9	0.8°	90	6	2	●	1	41.7	*	*	*
MP2XLBR0300N200	3	6	6	20	5.85	–	70	6	2	●	2	*	*	*	*
MP2XLBR0300N250	3	6	6	25	5.85	–	70	6	2	●	2	*	*	*	*
MP2XLBR0300N300	3	6	6	30	5.85	–	80	6	2	●	2	*	*	*	*
MP2XLBR0300N400	3	6	6	40	5.85	–	90	6	2	●	2	*	*	*	*
MP2XLBR0300N500	3	6	6	50	5.85	–	100	6	2	●	2	*	*	*	*

* No interference

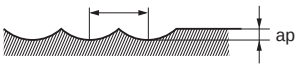
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel,Alloy steel,Alloy Tool Steel, Pre-hardened steel, Precipitation hardeningstainless steel AISI 1055, AISI P21, ASTM 630			Hardened steel (45−55HRC)			Copper, Copper alloys		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R0.05	0.3	50000	200	0.002	50000	200	0.002	50000	200	0.004
	0.5	50000	200	0.001	50000	200	0.002	50000	200	0.002
R0.1	0.5	50000	400	0.003	50000	320	0.003	50000	320	0.006
	1	50000	400	0.002	50000	320	0.002	50000	320	0.004
	1.5	40000	300	0.001	40000	240	0.001	40000	240	0.002
	2	40000	200	0.001	40000	160	0.001	40000	160	0.002
	2.5	40000	100	0.001	40000	80	0.001	40000	80	0.002
R0.15	1	50000	600	0.007	50000	480	0.007	50000	480	0.014
	1.5	50000	600	0.005	50000	480	0.005	50000	480	0.01
	2	50000	600	0.003	50000	480	0.003	50000	480	0.006
	2.5	40000	400	0.003	40000	320	0.003	40000	320	0.006
	3	40000	300	0.002	40000	240	0.002	40000	240	0.004
	3.5	30000	250	0.002	30000	200	0.002	30000	200	0.004
	4	30000	200	0.002	30000	160	0.002	30000	160	0.004
R0.2	1	50000	1800	0.015	50000	1400	0.015	50000	1400	0.03
	2	50000	1300	0.01	50000	1000	0.01	50000	1000	0.02
	3	50000	900	0.005	50000	700	0.005	50000	700	0.01
	4	40000	600	0.004	40000	480	0.004	40000	480	0.008
	5	40000	400	0.003	40000	320	0.003	40000	320	0.006
	6	30000	200	0.002	30000	160	0.002	30000	160	0.004
R0.25	2	50000	2500	0.02	50000	2000	0.02	50000	2000	0.04
	3	50000	1500	0.015	50000	1200	0.015	50000	1200	0.03
	4	45000	1200	0.01	45000	950	0.01	45000	950	0.02
	5	45000	900	0.007	45000	700	0.007	45000	700	0.014
	6	36000	600	0.006	36000	480	0.006	36000	480	0.012
	7	32000	400	0.005	32000	320	0.005	32000	320	0.01
	8	32000	300	0.003	32000	240	0.003	32000	240	0.006
	10	26000	200	0.002	26000	160	0.002	26000	160	0.004
R0.3	2	50000	3500	0.03	50000	2800	0.03	50000	2800	0.06
	3	50000	3500	0.03	50000	2800	0.03	50000	2800	0.06
	4	44000	2500	0.02	44000	2000	0.02	44000	2000	0.04
	5	37000	1200	0.01	37000	950	0.01	37000	950	0.02
	6	37000	1000	0.008	37000	800	0.008	37000	800	0.016
	7	35000	750	0.008	35000	600	0.008	35000	600	0.016
	8	35000	600	0.006	35000	480	0.006	35000	480	0.012
	9	30000	500	0.004	30000	400	0.004	30000	400	0.008
	10	30000	500	0.003	30000	400	0.003	30000	400	0.006
	11	22000	300	0.002	22000	240	0.002	22000	240	0.004
	12	22000	200	0.002	22000	160	0.002	22000	160	0.004

Depth ofcut

≤0.1RE (RE≤1)
≤0.2RE (RE>1)



RE:Radius

Note 1) When the inclination angle of machined surface is large, or machining with large cutting load such as corner area, reduce the revolution and feed rate.
Note 2) The use of oil mist is recommended when machining with small diameter.
Note 3) The revolution and feed rate can increase for the small depth of cut.
Note 4) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.
Note 5) For hardened steel over 55HRC, use VF2XLB.
Note 6) Standard cutting conditions of austenitic stainless steel and titanium alloy, please reduce to 60% revolution and 45% feed rate. (Hardened steel (45−55HRC) table above)

MP2XLB

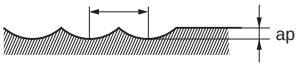
End mill, Short cut length, 2 flute, Long neck

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel,Alloy steel,Alloy Tool Steel, Pre-hardened steel, Precipitation hardeningstainless steel AISI 1055, AISI P21, ASTM 630			Hardened steel (45−55HRC)			Copper, Copper alloys		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R0.4	2	50000	4400	0.04	50000	3500	0.04	50000	3500	0.08
	3	50000	4000	0.04	50000	3200	0.04	50000	3200	0.08
	4	50000	4000	0.02	50000	3200	0.02	50000	3200	0.04
	5	35000	2400	0.02	35000	1900	0.02	35000	1900	0.04
	6	35000	2400	0.02	35000	1900	0.02	35000	1900	0.04
	7	30000	1500	0.015	30000	1200	0.015	30000	1200	0.03
	8	30000	1500	0.01	30000	1200	0.01	30000	1200	0.02
	10	30000	700	0.008	30000	560	0.008	30000	560	0.016
	12	22000	500	0.006	22000	400	0.006	22000	400	0.012
R0.5	3	40000	4000	0.05	40000	3200	0.05	40000	3200	0.1
	4	40000	4000	0.05	40000	3200	0.05	40000	3200	0.1
	6	35000	3000	0.03	35000	2400	0.03	35000	2400	0.06
	8	30000	2000	0.02	30000	1600	0.02	30000	1600	0.04
	10	20000	1000	0.01	20000	800	0.01	20000	800	0.02
	12	20000	1000	0.01	20000	800	0.01	20000	800	0.02
	14	18000	600	0.008	18000	480	0.008	18000	480	0.016
	16	18000	500	0.008	18000	400	0.008	18000	400	0.016
	18	13000	300	0.005	13000	240	0.005	13000	240	0.01
	20	13000	250	0.005	13000	200	0.005	13000	200	0.01
R0.6	6	40000	4400	0.04	40000	3500	0.04	40000	3500	0.08
	8	40000	4000	0.04	40000	3200	0.04	40000	3200	0.08
	10	27000	1900	0.02	27000	1500	0.02	27000	1500	0.04
	12	16000	1400	0.02	16000	1100	0.02	16000	1100	0.04
	18	15000	700	0.008	15000	560	0.008	15000	560	0.016
	24	11000	300	0.006	11000	240	0.006	11000	240	0.012
R0.7	8	40000	4000	0.05	40000	3200	0.05	40000	2560	0.1
	12	26000	2000	0.04	26000	1600	0.04	26000	1280	0.08
	16	17000	1400	0.03	17000	1120	0.03	17000	896	0.06
R0.75	6	40000	6000	0.07	36000	4300	0.07	36000	4300	0.14
	8	40000	6000	0.07	36000	4300	0.07	36000	4300	0.14
	10	40000	5000	0.06	36000	3600	0.06	36000	3600	0.12
	12	32000	3400	0.04	29000	2400	0.04	29000	2400	0.08
	16	15000	1400	0.03	15000	1100	0.03	15000	1100	0.06
	20	12000	900	0.02	12000	720	0.02	12000	720	0.04
	22	9000	400	0.01	9000	320	0.01	9000	320	0.02
R0.8	8	40000	6000	0.08	32000	3800	0.08	32000	3800	0.16
	12	36000	4500	0.06	29000	2800	0.06	29000	2800	0.12
	16	14000	1400	0.04	14000	1100	0.04	14000	1100	0.08
	20	12000	1000	0.03	12000	800	0.03	12000	800	0.06
R0.9	8	40000	6600	0.09	32000	4200	0.09	32000	4200	0.18
	12	40000	5000	0.07	32000	3200	0.07	32000	3200	0.14
	16	28000	2800	0.04	22000	1800	0.04	22000	1800	0.08
	20	10000	800	0.03	10000	640	0.03	10000	640	0.06

Depth ofcut

≤0.1RE (RE≤1)
≤0.2RE (RE>1)



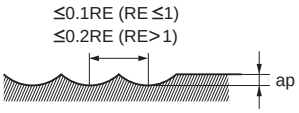
RE:Radius

Note 1) When the inclination angle of machined surface is large, or machining with large cutting load such as corner area, reduce the revolution and feed rate.
Note 2) The use of oil mist is recommended when machining with small diameter.
Note 3) The revolution and feed rate can increase for the small depth of cut.
Note 4) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.
Note 5) For hardened steel over 55HRC, use VF2XLB.
Note 6) Standard cutting conditions of austenitic stainless steel and titanium alloy, please reduce to 60% revolution and 45% feed rate. (Hardened steel (45−55HRC) table above)

● : **Inventory maintained in Japan.**

Work Material		Carbon steel,Alloy steel,Alloy Tool Steel, Pre-hardened steel, Precipitation hardeningstainless steel AISI 1055, AISI P21, ASTM 630			Hardened steel (45−55HRC)			Copper, Copper alloys		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R1	4	40000	8000	0.1	32000	5000	0.1	32000	5000	0.2
	6	40000	8000	0.1	32000	5000	0.1	32000	5000	0.2
	8	40000	6000	0.1	32000	3800	0.1	32000	3800	0.2
	10	40000	5000	0.08	32000	3200	0.08	32000	3200	0.16
	12	40000	5000	0.08	32000	3200	0.08	32000	3200	0.16
	16	32000	3500	0.05	26000	2200	0.05	26000	2200	0.1
	20	10000	1000	0.04	10000	800	0.04	10000	800	0.08
	25	10000	1000	0.04	10000	800	0.04	10000	800	0.08
	30	10000	800	0.02	10000	640	0.02	10000	640	0.04
	35	10000	600	0.02	10000	480	0.02	10000	480	0.04
	40	8000	400	0.01	8000	320	0.01	8000	320	0.02
R1.25	10	36000	6000	0.12	29000	3800	0.12	29000	3800	0.24
	15	32000	4500	0.1	26000	2900	0.1	26000	2900	0.2
	20	26000	3200	0.07	21000	2000	0.07	21000	2000	0.14
	25	12000	1400	0.06	8000	720	0.06	8000	720	0.12
	30	8000	900	0.04	8000	700	0.04	8000	700	0.08
	35	8000	800	0.02	8000	640	0.02	8000	510	0.04
R1.5	6	32000	7000	0.15	26000	4500	0.15	22000	3800	0.3
	10	32000	7000	0.15	26000	4500	0.15	22000	3800	0.3
	16	32000	5000	0.1	26000	3200	0.1	22000	2700	0.2
	20	27000	3800	0.1	22000	2400	0.1	22000	2400	0.2
	25	21000	2700	0.08	17000	1700	0.08	17000	1700	0.16
	30	10000	700	0.08	6000	560	0.08	6000	560	0.16
	35	6000	700	0.06	6000	560	0.06	6000	560	0.12
	40	6000	600	0.04	6000	480	0.04	6000	480	0.08
R1.75	15	27500	4400	0.13	22000	2800	0.13	18000	2300	0.26
	25	23000	3600	0.1	18000	2200	0.1	18000	2200	0.2
	35	10000	1400	0.08	10000	1100	0.08	10000	1100	0.16
	45	7500	900	0.04	7500	720	0.04	7500	720	0.08
R2	10	24000	6000	0.2	19000	3800	0.2	16000	3200	0.4
	20	24000	3800	0.15	19000	2400	0.15	16000	2000	0.3
	30	20000	3000	0.1	16000	1900	0.1	16000	1900	0.2
	40	12000	1700	0.1	12000	1400	0.1	12000	1400	0.2
	50	8000	1000	0.05	8000	800	0.05	8000	800	0.1
R2.5	20	22000	6000	0.2	18000	3800	0.2	13000	2800	0.4
	25	22000	4400	0.2	18000	2800	0.2	13000	2000	0.4
	30	22000	3800	0.15	18000	2400	0.15	13000	1700	0.3
	40	22000	3600	0.1	18000	2300	0.1	13000	1600	0.2
R3	20	20000	6000	0.2	16000	3800	0.2	11000	2600	0.4
	30	20000	6000	0.2	16000	3800	0.2	11000	2600	0.4
	40	20000	4500	0.15	16000	2800	0.15	11000	2000	0.3
	50	20000	3000	0.15	16000	1900	0.15	11000	1300	0.3

Depth ofcut



RE:Radius

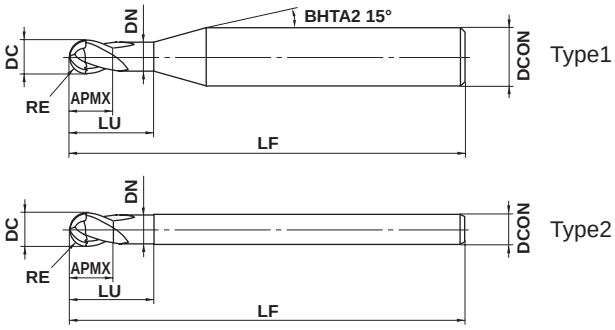
Note 1) When the inclination angle of machined surface is large, or machining with large cutting load such as corner area, reduce the revolution and feed rate.
Note 2) The use of oil mist is recommended when machining with small diameter.
Note 3) The revolution and feed rate can increase for the small depth of cut.
Note 4) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.
Note 5) For hardened steel over 55HRC, use VF2XLB.
Note 6) Standard cutting conditions of austenitic stainless steel and titanium alloy, please reduce to 60% revolution and 45% feed rate. (Hardened steel (45−55HRC) table above)

VFR2SSB NEW

Ball nose, Short cut length, 2 flute, Short shank

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



RE≤6				
±0.005				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.005	0 - 0.006	0 - 0.008		

h5

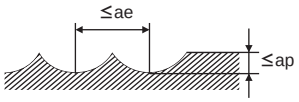
●Optimization of the cutting edge curve, helix angle, and rake angle have improved the edge strength at all areas of the ball blades.

(mm)

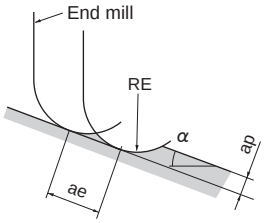
Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VFR2SSBR0050S04	0.5	1	1	2	0.94	40	4	2	●	1
VFR2SSBR0050	0.5	1	1	2	0.94	40	6	2	●	1
VFR2SSBR0075S04	0.75	1.5	1.5	3	1.44	40	4	2	●	1
VFR2SSBR0075	0.75	1.5	1.5	3	1.44	40	6	2	●	1
VFR2SSBR0100	1	2	2	4	1.9	45	6	2	●	1
VFR2SSBR0150	1.5	3	3	6	2.9	45	6	2	●	1
VFR2SSBR0200	2	4	4	8	3.9	45	6	2	●	1
VFR2SSBR0250	2.5	5	5	10	4.9	50	6	2	●	1
VFR2SSBR0300	3	6	6	12	5.85	50	6	2	●	2
VFR2SSBR0400	4	8	8	14	7.85	60	8	2	●	2
VFR2SSBR0500	5	10	10	18	9.7	70	10	2	●	2
VFR2SSBR0600	6	12	12	22	11.7	75	12	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45－55HRC) AISI H13						Hardened steel (55－62HRC) AISI D2						Hardened steel (62－70HRC) AISI W1, AISI M2					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 0.1	40000	320	40000	240	0.003	0.02	40000	320	40000	160	0.003	0.02	40000	320	40000	160	0.002	0.02
R 0.15	40000	640	40000	560	0.01	0.03	40000	640	40000	400	0.007	0.03	40000	640	40000	400	0.005	0.03
R 0.2	40000	1600	40000	1200	0.02	0.04	40000	1400	40000	1000	0.015	0.04	40000	1200	40000	1000	0.01	0.04
R 0.3	40000	3200	40000	1600	0.03	0.06	40000	2800	40000	1200	0.025	0.06	40000	2000	40000	1200	0.02	0.06
R 0.4	40000	6400	40000	2400	0.05	0.08	40000	4000	40000	1600	0.04	0.08	40000	2800	40000	1600	0.03	0.08
R 0.5	40000	8000	40000	3200	0.06	0.10	40000	5600	40000	2400	0.05	0.10	40000	3600	32000	1300	0.04	0.10
R 0.75	40000	9600	40000	4000	0.09	0.15	40000	7200	32000	2500	0.075	0.15	32000	4500	21000	1200	0.05	0.15
R 1	40000	9600	39000	4700	0.11	0.20	40000	8000	24000	2400	0.1	0.20	24000	3800	16000	1000	0.07	0.20
R 1.25	40000	10400	32000	4500	0.12	0.25	37000	8100	19000	2300	0.11	0.25	19000	3400	13000	1000	0.08	0.25
R 1.5	40000	12000	27000	4300	0.13	0.30	32000	7700	16000	2200	0.12	0.30	16000	3200	11000	880	0.09	0.30
R 2	32000	10880	20000	3600	0.15	0.40	24000	6200	12000	1900	0.13	0.40	12000	2400	8000	800	0.1	0.40
R 2.5	25000	9000	16000	2900	0.20	0.50	19000	5300	9600	1700	0.15	0.50	9600	2100	6000	600	0.1	0.50
R 3	21000	8400	13000	2600	0.25	0.60	16000	4800	8000	1600	0.2	0.60	8000	1700	5000	600	0.11	0.60
R 4	16000	6400	10000	2000	0.30	0.80	12000	3600	6000	1200	0.2	0.80	6000	1400	4000	480	0.11	0.80
R 5	13000	5200	8000	1700	0.50	1.00	10000	3200	4800	960	0.2	1.00	4800	1100	3000	420	0.12	1.00
R 6	9000	3600	6000	1300	0.50	1.20	7000	2200	3600	720	0.3	1.20	3600	860	2200	310	0.12	1.20
R 8	6000	2400	4000	1000	0.50	1.60	5000	1600	2500	500	0.3	1.60	2500	650	1500	240	0.15	1.60
R10	4500	1800	3000	780	0.50	2.00	4000	1300	1800	360	0.3	2.00	1800	470	1000	160	0.15	2.00
Depth of cut																		

Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Please reduce the feed rate when the surface finish is important.
Note 3) α is the inclination angle of the machined surface.



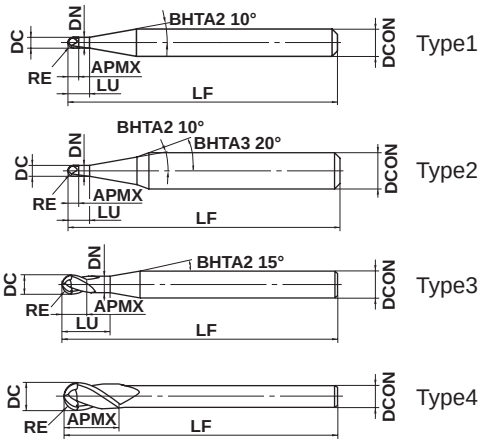
ae:Pick Feed

VFR2SB

Ball nose, Short cut length, 2 flute

TOOL NEWS UWC VFR 0° RE<0.3 20° RE≥0.3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



RE≤6	RE>6			
±0.005	±0.010			
DCON=3	4≤DCON≤6	8≤DCON≤10	DCON=12	DCON=20
0 - 0.004	0 - 0.005	0 - 0.006	0 - 0.008	0 - 0.009

h5

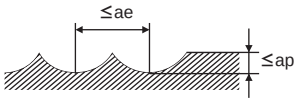
●Optimization of the cutting edge curve, helix angle, and rake angle have improved the edge strength at all areas of the ball blades.

(mm)

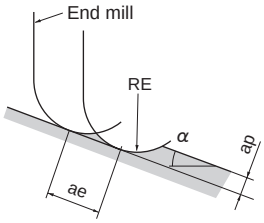
Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VFR2SBR0010	0.1	0.2	0.2	0.4	0.17	45	4	2	●	1
VFR2SBR0010S06	0.1	0.2	0.2	0.4	0.17	50	6	2	●	2
VFR2SBR0015	0.15	0.3	0.3	0.6	0.27	45	4	2	●	1
VFR2SBR0015S06	0.15	0.3	0.3	0.6	0.27	50	6	2	●	2
VFR2SBR0020	0.2	0.4	0.4	0.8	0.36	45	4	2	●	1
VFR2SBR0020S06	0.2	0.4	0.4	0.8	0.36	50	6	2	●	2
VFR2SBR0030	0.3	0.6	0.6	1.2	0.56	45	4	2	●	3
VFR2SBR0030S06	0.3	0.6	0.6	1.2	0.56	50	6	2	●	3
VFR2SBR0040	0.4	0.8	0.8	1.6	0.76	45	4	2	●	3
VFR2SBR0040S06	0.4	0.8	0.8	1.6	0.76	50	6	2	●	3
VFR2SBR0050	0.5	1	1	2	0.94	45	4	2	●	3
VFR2SBR0050S06	0.5	1	1	2	0.94	50	6	2	●	3
VFR2SBR0060	0.6	1.2	1.2	2.4	1.14	45	4	2	●	3
VFR2SBR0060S06	0.6	1.2	1.2	2.4	1.14	50	6	2	●	3
VFR2SBR0070	0.7	1.4	1.4	2.8	1.34	45	4	2	●	3
VFR2SBR0070S06	0.7	1.4	1.4	2.8	1.34	50	6	2	●	3
VFR2SBR0075	0.75	1.5	1.5	3	1.44	45	4	2	●	3
VFR2SBR0075S06	0.75	1.5	1.5	3	1.44	50	6	2	●	3
VFR2SBR0080	0.8	1.6	1.6	3.2	1.54	45	4	2	●	3
VFR2SBR0080S06	0.8	1.6	1.6	3.2	1.54	50	6	2	●	3
VFR2SBR0090	0.9	1.8	1.8	3.6	1.74	45	4	2	●	3
VFR2SBR0090S06	0.9	1.8	1.8	3.6	1.74	50	6	2	●	3
VFR2SBR0100	1	2	2	4	1.9	50	4	2	●	3
VFR2SBR0100S06	1	2	2	4	1.9	60	6	2	●	3
VFR2SBR0125S06	1.25	2.5	2.5	5	2.4	60	6	2	●	3
VFR2SBR0150	1.5	3	3	6	2.9	70	6	2	●	3
VFR2SBR0150S03	1.5	3	3	—	—	60	3	2	●	4
VFR2SBR0200	2	4	4	8	3.9	70	6	2	●	3
VFR2SBR0200S04	2	4	4	—	—	60	4	2	●	4
VFR2SBR0250	2.5	5	5	10	4.9	80	6	2	●	3
VFR2SBR0300	3	6	12	—	—	80	6	2	●	4
VFR2SBR0400	4	8	14	—	—	90	8	2	●	4
VFR2SBR0500	5	10	18	—	—	100	10	2	●	4
VFR2SBR0600	6	12	22	—	—	110	12	2	●	4
VFR2SBR0800	8	16	30	—	—	140	16	2	●	4
VFR2SBR1000	10	20	38	—	—	160	20	2	●	4

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45－55HRC) AISI H13						Hardened steel (55－62HRC) AISI D2						Hardened steel (62－70HRC) AISI W1, AISI M2					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 0.1	40000	320	40000	240	0.003	0.02	40000	320	40000	160	0.003	0.02	40000	320	40000	160	0.002	0.02
R 0.15	40000	640	40000	560	0.01	0.03	40000	640	40000	400	0.007	0.03	40000	640	40000	400	0.005	0.03
R 0.2	40000	1600	40000	1200	0.02	0.04	40000	1400	40000	1000	0.015	0.04	40000	1200	40000	1000	0.01	0.04
R 0.3	40000	3200	40000	1600	0.03	0.06	40000	2800	40000	1200	0.025	0.06	40000	2000	40000	1200	0.02	0.06
R 0.4	40000	6400	40000	2400	0.05	0.08	40000	4000	40000	1600	0.04	0.08	40000	2800	40000	1600	0.03	0.08
R 0.5	40000	8000	40000	3200	0.06	0.10	40000	5600	40000	2400	0.05	0.10	40000	3600	32000	1300	0.04	0.10
R 0.75	40000	9600	40000	4000	0.09	0.15	40000	7200	32000	2500	0.075	0.15	32000	4500	21000	1200	0.05	0.15
R 1	40000	9600	39000	4700	0.11	0.20	40000	8000	24000	2400	0.1	0.20	24000	3800	16000	1000	0.07	0.20
R 1.25	40000	10400	32000	4500	0.12	0.25	37000	8100	19000	2300	0.11	0.25	19000	3400	13000	1000	0.08	0.25
R 1.5	40000	12000	27000	4300	0.13	0.30	32000	7700	16000	2200	0.12	0.30	16000	3200	11000	880	0.09	0.30
R 2	32000	10880	20000	3600	0.15	0.40	24000	6200	12000	1900	0.13	0.40	12000	2400	8000	800	0.1	0.40
R 2.5	25000	9000	16000	2900	0.20	0.50	19000	5300	9600	1700	0.15	0.50	9600	2100	6000	600	0.1	0.50
R 3	21000	8400	13000	2600	0.25	0.60	16000	4800	8000	1600	0.2	0.60	8000	1700	5000	600	0.11	0.60
R 4	16000	6400	10000	2000	0.30	0.80	12000	3600	6000	1200	0.2	0.80	6000	1400	4000	480	0.11	0.80
R 5	13000	5200	8000	1700	0.50	1.00	10000	3200	4800	960	0.2	1.00	4800	1100	3000	420	0.12	1.00
R 6	9000	3600	6000	1300	0.50	1.20	7000	2200	3600	720	0.3	1.20	3600	860	2200	310	0.12	1.20
R 8	6000	2400	4000	1000	0.50	1.60	5000	1600	2500	500	0.3	1.60	2500	650	1500	240	0.15	1.60
R10	4500	1800	3000	780	0.50	2.00	4000	1300	1800	360	0.3	2.00	1800	470	1000	160	0.15	2.00
Depth of cut																		

Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Please reduce the feed rate when the surface finish is important.
Note 3) α is the inclination angle of the machined surface.



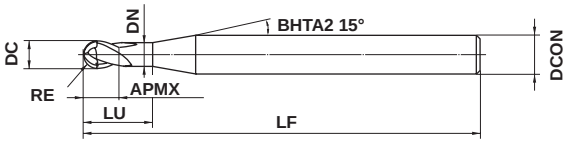
ae:Pick Feed

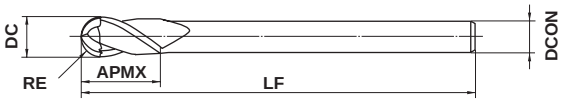
VFR2SBF

Ball nose, Short cut length, 2 flute, For Mirror finish cutting

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				





RE≤3				
±0.010				
4≤DCON≤6				
0 - 0.005				

h5

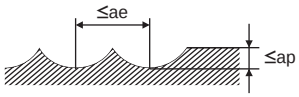
●New ball geometry for mirror finish cutting.

(mm)

Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VFR2SBFR0050	0.5	1	1	2	0.94	45	4	2	●	1
VFR2SBFR0075	0.75	1.5	1.5	3	1.44	45	4	2	●	1
VFR2SBFR0100	1	2	2	4	1.9	60	6	2	●	1
VFR2SBFR0125	1.25	2.5	2.5	5	2.4	60	6	2	●	1
VFR2SBFR0150	1.5	3	3	6	2.9	70	6	2	●	1
VFR2SBFR0200	2	4	4	8	3.9	70	6	2	●	1
VFR2SBFR0250	2.5	5	5	10	4.9	80	6	2	●	1
VFR2SBFR0300	3	6	12	—	—	80	6	2	●	2

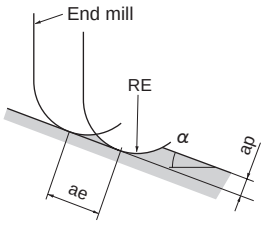
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon Steel, Alloy Steel (180—280HB) Alloy steel (≤350HB), Pre-hardened steel (35—45HRC) Hardened steel (45—52HRC), Hardened steel (55—62HRC) AISI 1045, AISI 4140, SKD, SKT, AISI P21, AISI P20, AISI H13, L6, AISI D2						Hardened steel (62—70HRC) AISI W1, AISI M2					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 0.5	40000	800	40000	800	0.007	0.007	40000	560	40000	560	0.005	0.005
R 0.75	40000	800	40000	800	0.009	0.009	40000	560	40000	560	0.007	0.007
R 1.0	35000	1050	35000	1050	0.011	0.011	35000	700	35000	700	0.009	0.009
R 1.25	35000	1050	35000	1050	0.013	0.013	35000	700	35000	700	0.011	0.011
R 1.5	35000	1050	35000	1050	0.015	0.015	35000	700	35000	700	0.013	0.013
R 2.0	25000	1000	25000	1000	0.017	0.017	25000	750	25000	750	0.015	0.015
R 2.5	25000	1000	25000	1000	0.020	0.020	25000	750	25000	750	0.015	0.015
R 3.0	25000	1000	25000	1000	0.020	0.020	25000	750	25000	750	0.015	0.015
Depth of cut												

Note 1) The tools are recommended for use only in finish machining.
Note 2) Air blowing or oil mist is recommended as coolants.
Note 3) Note the following points when using the tools.
- Avoid using equipment abruptly without proper preparation. After sufficiently energizing equipment, ensure that there will be no changes to the depth of cut such as due to elongation of the main axis during machining.
- If the tools are used immediately after rough machining of a surface, large uneven areas (cusp heights) will cause deflection of the tools and waviness of the machined surface. Therefore, it is recommended to add a medium finish machining process which uses the same value of ae as indicated in the table above.

Note 4) α is the inclination angle of the machined surface.



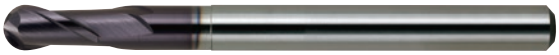
ae:Pick Feed

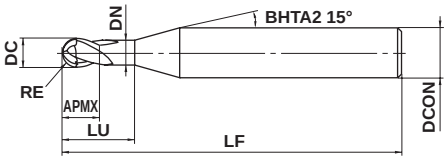
VF2SDB

Ball nose, Short cut length, 2 flute, Strong geometry type

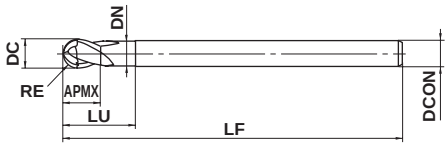
TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○				





Type1



Type2

RE≤6.5	RE>6.5			
±0.01	±0.02			
DC≤12	DC>12			
0 / - 0.02	0 / - 0.03			
DCON=3	4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20
0 / - 0.006	0 / - 0.008	0 / - 0.009	0 / - 0.011	0 / - 0.013

h6

●2 flute ball nose end mill with Impact Miracle coating for high hardness materials and achieves excellent fracture resistance.

(mm)

Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VF2SDBR0050	0.5	1	1	2	0.94	45	4	2	▲	1
VF2SDBR0100	1	2	2	4	1.9	60	6	2	▲	1
VF2SDBR0100S04	1	2	2	4	1.9	50	4	2	▲	1
VF2SDBR0150	1.5	3	3	6	2.9	70	6	2	▲	1
VF2SDBR0150S03	1.5	3	3	6	2.9	60	3	2	▲	2
VF2SDBR0200	2	4	4	8	3.9	70	6	2	▲	1
VF2SDBR0200S04	2	4	4	8	3.9	60	4	2	▲	2
VF2SDBR0250	2.5	5	5	10	4.9	80	6	2	▲	1
VF2SDBR0300	3	6	12	22	5.85	80	6	2	▲	2
VF2SDBR0400	4	8	14	27	7.85	90	8	2	▲	2
VF2SDBR0500	5	10	18	31	9.7	100	10	2	▲	2
VF2SDBR0600	6	12	22	35	11.7	110	12	2	▲	2
VF2SDBR0800	8	16	30	50	15.5	140	16	2	▲	2
VF2SDBR1000	10	20	38	58	19.5	160	20	2	▲	2

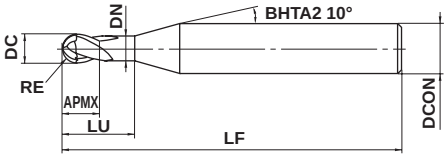
▲ : Product scheduled to be discontinued at the end of March 2020
MP2SDB(J200) is alternative product.

VF2SDBL

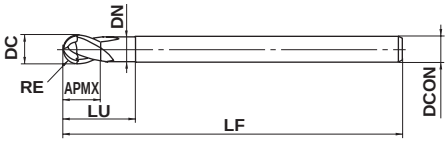
Ball nose, Short cut length, 2 flute, Strong geometry type, Long shank

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○				



Type1



Type2

RE≤6.5	RE>6.5			
±0.01	±0.02			
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●2 flute end mill with long shank for general use.

(mm)

Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VF2SDBLR0050	0.5	1	1	2	0.94	60	6	2	▲	1
VF2SDBLR0100	1	2	2	4	1.9	80	6	2	▲	1
VF2SDBLR0150	1.5	3	3	6	2.9	90	6	2	▲	1
VF2SDBLR0200	2	4	4	8	3.9	90	6	2	▲	1
VF2SDBLR0250	2.5	5	5	10	4.9	110	8	2	▲	1
VF2SDBLR0300	3	6	12	22	5.85	120	6	2	▲	2
VF2SDBLR0400	4	8	14	27	7.85	130	8	2	▲	2
VF2SDBLR0500	5	10	18	31	9.7	140	10	2	▲	2
VF2SDBLR0600	6	12	22	35	11.7	140	12	2	▲	2
VF2SDBLR0800	8	16	30	50	15.5	200	16	2	▲	2
VF2SDBLR1000	10	20	38	58	19.5	200	20	2	▲	2

VF2SDB

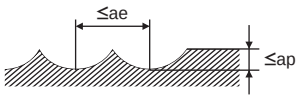
Ball nose, Short cut length, 2 flute, Strong geometry type

VF2SDBL

Ball nose, Short cut length, 2 flute, Strong geometry type, Long shank

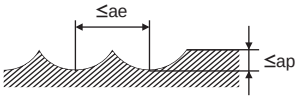
RECOMMENDED CUTTING CONDITIONS

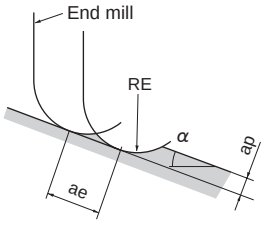
■Overhang below DC×5 (DC:Dia.)

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21						Hardened steel (45－55HRC) AISI H13						Hardened steel (55－62HRC) AISI D2					
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°		α>15°		Depth of cut ap (mm)	Depth of cut ae (mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)			Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 0.5	40000	5200	36000	2300	0.10	0.25	40000	5200	36000	2300	0.10	0.25	40000	5000	40000	2400	0.05	0.10
R 1	40000	6000	36000	3500	0.20	0.50	40000	6000	36000	3500	0.20	0.50	36000	5000	24000	2400	0.10	0.20
R 1.5x3	29000	4600	19000	2400	0.20	0.50	25000	4000	16000	2000	0.20	0.50	17000	2400	11000	1000	0.12	0.30
R 1.5	37000	7000	24000	3000	0.30	0.75	37000	7000	24000	3000	0.30	0.75	25000	6000	16000	2200	0.12	0.30
R 2x4	24000	4300	15000	2200	0.25	0.70	19000	3400	13000	1700	0.25	0.70	12000	1900	8200	900	0.13	0.40
R 2	30000	6500	19000	2800	0.40	1.00	28000	6000	19000	2600	0.40	1.00	18000	4800	12000	2000	0.13	0.40
R 2.5	25000	6000	16000	2600	0.50	1.30	22000	5000	16000	2300	0.50	1.25	15000	4200	9500	1700	0.15	0.50
R 3	22000	6000	14000	2400	0.60	1.80	18000	4500	12000	1900	0.60	1.50	12000	3500	8000	1600	0.20	0.60
R 4	19000	5200	12000	2200	0.80	2.40	15000	3800	9500	1700	0.80	2.00	9800	3000	6500	1300	0.20	0.80
R 5	15000	4300	9500	2000	1.00	3.00	11000	3000	7000	1500	1.00	2.50	7500	2400	5000	1000	0.20	1.00
R 6	12000	3400	8000	1800	1.20	3.60	9000	2400	6000	1400	1.20	3.00	6000	1900	4000	800	0.30	1.20
R 8	9000	2600	6000	1500	1.60	4.80	7000	1900	4500	1100	1.60	4.00	4500	1500	3000	600	0.30	1.60
R10	7500	2200	4800	1200	2.00	6.00	5500	1500	3600	900	2.00	5.00	3600	1200	2500	500	0.30	2.00
Depth of cut																		

Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

■Overhang DC×7 (DC:Dia.)

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45－55HRC) AISI H13			
R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R 1.5x3	16000	2000	0.10	0.30	13000	1500	0.10	0.30
R 2x4	13000	2000	0.15	0.50	10000	1500	0.15	0.50
R 3	10000	2000	0.20	1.00	8000	1600	0.20	0.80
R 4	8000	1800	0.30	1.50	6400	1400	0.40	1.20
R 5	6000	1600	0.40	2.00	4800	1200	0.40	1.60
R 6	5000	1300	0.45	2.40	4000	1000	0.45	2.00
R 8	3800	1000	0.60	3.00	3100	800	0.60	2.50
R10	3000	800	0.80	4.00	2500	650	0.80	3.00
Depth of cut								



ae:Pick Feed

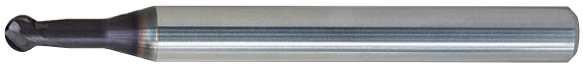
Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

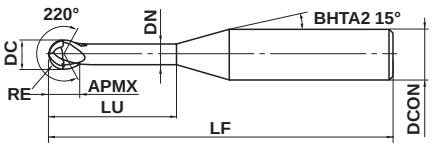
VF2WB

Wide ball nose, Medium cut length, 2 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○	○		◎	◎		





Type1

1≤RE≤3				
±0.01				
DCON=6				
0 / - 0.008				

● Ball nose end mill suitable for machining of undercut geometries and complex geometries using a 5-axis machine.

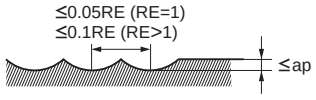
(mm)

Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VF2WBR0100N060	1	2	1.3	6	1.6	60	6	2	●	1
VF2WBR0150N080	1.5	3	2	8	2.4	60	6	2	●	1
VF2WBR0200N100	2	4	2.6	10	3.2	60	6	2	●	1
VF2WBR0300N120	3	6	4	12	4.8	80	6	2	●	1

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			Hardened steel (45−55HRC) AISI H13		
R RE (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R1	40000	5000	0.07	40000	5000	0.06	32000	2500	0.05	32000	3000	0.03
R1.5	32000	5000	0.12	32000	5000	0.11	26000	2500	0.10	26000	3000	0.07
R2	24000	3800	0.15	24000	3800	0.13	20000	2000	0.12	20000	2800	0.10
R3	16000	2800	0.20	16000	2800	0.18	13000	1500	0.15	13000	2100	0.12

Depth of cut



RE:Radius

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.

● : Inventory maintained in Japan.

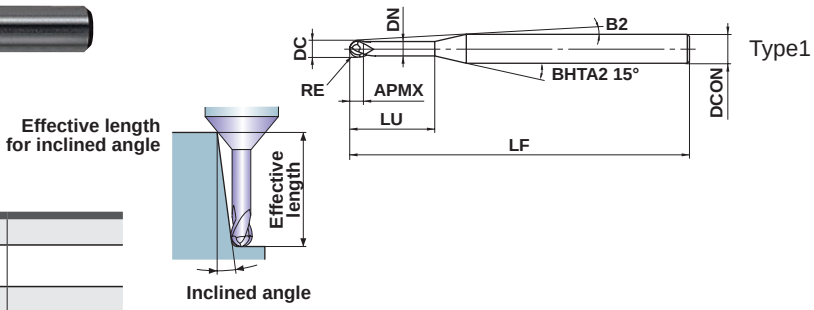
VF2XLBS

IMPACT MIRACLE, Ball nose, 2 flute, Long neck, Short shank

TOOL NEWS

UWC VF γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	◎				



0.2≤RE≤1				
±0.007				
0.4≤DC≤2				
0 / - 0.02				
DCON=4				
0 / - 0.008				

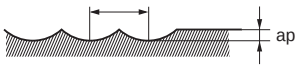
- 2 flute long neck ball nose end mill for high-speed machining of hardened steel.
- Short shank type suitable for use with a shrink fit holder.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VF2XLBSR0020N010	0.2	0.4	0.32	1	0.36	13.4°	40	4	2	●	1	1.0	1.0	1.1	1.2
VF2XLBSR0020N020	0.2	0.4	0.32	2	0.36	11.9°	40	4	2	●	1	2.0	2.1	2.3	2.5
VF2XLBSR0020N030	0.2	0.4	0.32	3	0.36	10.7°	40	4	2	●	1	3.1	3.2	3.4	3.7
VF2XLBSR0020N040	0.2	0.4	0.32	4	0.36	9.7°	40	4	2	●	1	4.1	4.3	4.6	4.9
VF2XLBSR0025N040	0.25	0.5	0.4	4	0.46	9.6°	40	4	2	●	1	4.1	4.3	4.6	4.9
VF2XLBSR0025N060	0.25	0.5	0.4	6	0.46	8.1°	40	4	2	●	1	6.2	6.4	6.9	7.4
VF2XLBSR0030N020	0.3	0.6	0.48	2	0.56	11.8°	40	4	2	●	1	2.1	2.2	2.3	2.5
VF2XLBSR0030N030	0.3	0.6	0.48	3	0.56	10.5°	40	4	2	●	1	3.1	3.3	3.5	3.8
VF2XLBSR0030N040	0.3	0.6	0.48	4	0.56	9.5°	40	4	2	●	1	4.2	4.3	4.6	5.0
VF2XLBSR0030N060	0.3	0.6	0.48	6	0.56	8.0°	40	4	2	●	1	6.3	6.5	6.9	7.5
VF2XLBSR0040N040	0.4	0.8	0.64	4	0.76	9.4°	40	4	2	●	1	4.2	4.3	4.6	5.0
VF2XLBSR0040N060	0.4	0.8	0.64	6	0.76	7.8°	40	4	2	●	1	6.3	6.5	6.9	7.5
VF2XLBSR0050N030	0.5	1	0.8	3	0.94	10.1°	40	4	2	●	1	3.2	3.3	3.6	3.9
VF2XLBSR0050N040	0.5	1	0.8	4	0.94	9.1°	40	4	2	●	1	4.2	4.4	4.8	5.2
VF2XLBSR0050N060	0.5	1	0.8	6	0.94	7.5°	40	4	2	●	1	6.3	6.6	7.1	7.7
VF2XLBSR0050N080	0.5	1	0.8	8	0.94	6.4°	40	4	2	●	1	8.4	8.8	9.4	10.2
VF2XLBSR0100N060	1	2	1.6	6	1.9	6.4°	40	4	2	●	1	6.2	6.5	6.9	7.4
VF2XLBSR0100N080	1	2	1.6	8	1.9	5.3°	40	4	2	●	1	8.3	8.7	9.2	9.9
VF2XLBSR0100N100	1	2	1.6	10	1.9	4.5°	40	4	2	●	1	10.4	10.8	11.5	12.4

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Hardened steel (45－55HRC) AISI H13			Hardened steel (55－62HRC) AISI D2		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R 0.2	1	40000	1400	0.015	40000	1400	0.01
	2	40000	1000	0.01	40000	1000	0.006
	3	40000	700	0.005	40000	700	0.003
	4	40000	600	0.004	40000	500	0.003
R 0.25	4	36000	900	0.01	36000	900	0.007
	6	36000	600	0.006	36000	500	0.004
R 0.3	2	40000	2800	0.03	40000	2800	0.02
	3	40000	2800	0.03	40000	2800	0.02
	4	35000	2000	0.02	35000	2000	0.015
	6	30000	800	0.008	30000	800	0.005
R 0.4	4	40000	3000	0.02	40000	3000	0.015
	6	30000	1600	0.02	30000	1600	0.01
R 0.5	3	40000	4000	0.05	40000	4000	0.04
	4	40000	4000	0.05	40000	4000	0.04
	6	35000	2000	0.03	35000	2000	0.02
	8	30000	1600	0.02	30000	1600	0.01
R 1	6	40000	6000	0.1	24000	3400	0.1
	8	40000	5000	0.1	24000	3000	0.1
	10	40000	5000	0.08	24000	3000	0.07
Depth of cut		≤0.1RE (RE≤1) ≤0.2RE (RE>1)  RE:Radius					

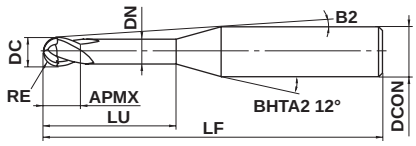
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

VF2XLB

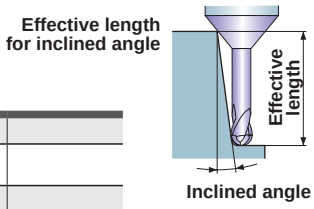
IMPACT MIRACLE, Ball nose, 2 flute, Long neck

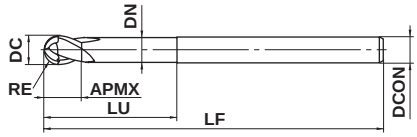
TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	◎				



Type1





Type2

	RE≤1	RE>1			
	±0.007	±0.010			
0.2≤DC≤6	0 - 0.02				
4≤DCON≤6 (h6)	0 - 0.008				

●2 flute long neck ball nose end mill with Impact Miracle coating for high hardened materials.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VF2XLBR0010N005S04	0.1	0.2	0.16	0.5	0.17	11.5°	50	4	2	●	1	0.5	0.5	0.6	0.6
VF2XLBR0010N005S06	0.1	0.2	0.16	0.5	0.17	11.7°	50	6	2	●	1	0.5	0.5	0.6	0.6
VF2XLBR0010N008S04	0.1	0.2	0.16	0.75	0.17	11.2°	50	4	2	●	1	0.7	0.8	0.9	1.0
VF2XLBR0010N010S04	0.1	0.2	0.16	1	0.17	10.9°	50	4	2	●	1	1.0	1.1	1.2	1.3
VF2XLBR0010N010S06	0.1	0.2	0.16	1	0.17	11.3°	50	6	2	●	1	1.0	1.1	1.2	1.3
VF2XLBR0010N013S04	0.1	0.2	0.16	1.25	0.17	10.7°	50	4	2	●	1	1.3	1.3	1.5	1.6
VF2XLBR0010N015S04	0.1	0.2	0.16	1.5	0.17	10.4°	50	4	2	●	1	1.5	1.6	1.8	2.0
VF2XLBR0010N015S06	0.1	0.2	0.16	1.5	0.17	10.9°	50	6	2	●	1	1.5	1.6	1.8	2.0
VF2XLBR0010N018S04	0.1	0.2	0.16	1.75	0.17	10.2°	50	4	2	●	1	1.8	1.9	2.1	2.3
VF2XLBR0010N020S04	0.1	0.2	0.16	2	0.17	10°	50	4	2	●	1	2.1	2.2	2.4	2.6
VF2XLBR0010N025S04	0.1	0.2	0.16	2.5	0.17	9.5°	50	4	2	●	1	2.6	2.7	3.0	3.3
VF2XLBR0015N010S04	0.15	0.3	0.24	1	0.27	11°	50	4	2	●	1	1.0	1.1	1.2	1.3
VF2XLBR0015N010S06	0.15	0.3	0.24	1	0.27	11.3°	50	6	2	●	1	1.0	1.1	1.2	1.3
VF2XLBR0015N013S04	0.15	0.3	0.24	1.25	0.27	10.7°	50	4	2	●	1	1.3	1.3	1.5	1.6
VF2XLBR0015N015S04	0.15	0.3	0.24	1.5	0.27	10.4°	50	4	2	●	1	1.5	1.6	1.8	1.9
VF2XLBR0015N015S06	0.15	0.3	0.24	1.5	0.27	10.9°	50	6	2	●	1	1.5	1.6	1.8	1.9
VF2XLBR0015N018S04	0.15	0.3	0.24	1.75	0.27	10.2°	50	4	2	●	1	1.8	1.9	2.1	2.3
VF2XLBR0015N020S04	0.15	0.3	0.24	2	0.27	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
VF2XLBR0015N020S06	0.15	0.3	0.24	2	0.27	10.6°	50	6	2	●	1	2.1	2.2	2.4	2.6
VF2XLBR0015N025S04	0.15	0.3	0.24	2.5	0.27	9.5°	50	4	2	●	1	2.6	2.7	3.0	3.3
VF2XLBR0015N030S04	0.15	0.3	0.24	3	0.27	9.1°	50	4	2	●	1	3.1	3.2	3.6	3.9
VF2XLBR0015N040S04	0.15	0.3	0.24	4	0.27	8.4°	50	4	2	●	1	4.2	4.3	4.8	5.3
VF2XLBR0020N010S04	0.2	0.4	0.32	1	0.36	11°	50	4	2	●	1	1.0	1.0	1.1	1.2
VF2XLBR0020N010S06	0.2	0.4	0.32	1	0.36	11.3°	50	6	2	●	1	1.0	1.0	1.1	1.2
VF2XLBR0020N015S04	0.2	0.4	0.32	1.5	0.36	10.4°	50	4	2	●	1	1.5	1.6	1.7	1.9
VF2XLBR0020N015S06	0.2	0.4	0.32	1.5	0.36	11°	50	6	2	●	1	1.5	1.6	1.7	1.9
VF2XLBR0020N020S04	0.2	0.4	0.32	2	0.36	10°	50	4	2	●	1	2.0	2.1	2.3	2.6
VF2XLBR0020N020S06	0.2	0.4	0.32	2	0.36	10.6°	50	6	2	●	1	2.0	2.1	2.3	2.6
VF2XLBR0020N025S04	0.2	0.4	0.32	2.5	0.36	9.5°	50	4	2	●	1	2.6	2.7	2.9	3.2
VF2XLBR0020N025S06	0.2	0.4	0.32	2.5	0.36	10.3°	50	6	2	●	1	2.6	2.7	2.9	3.2
VF2XLBR0020N030S04	0.2	0.4	0.32	3	0.36	9.1°	50	4	2	●	1	3.1	3.2	3.5	3.9
VF2XLBR0020N030S06	0.2	0.4	0.32	3	0.36	10°	50	6	2	●	1	3.1	3.2	3.5	3.9
VF2XLBR0020N040S04	0.2	0.4	0.32	4	0.36	8.4°	50	4	2	●	1	4.1	4.3	4.7	5.2
VF2XLBR0020N050S04	0.2	0.4	0.32	5	0.36	7.8°	50	4	2	●	1	5.2	5.4	5.9	6.6

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VF2XLBR0025N015S04	0.25	0.5	0.4	1.5	0.46	10.5°	50	4	2	●	1	1.5	1.6	1.7	1.9
VF2XLBR0025N015S06	0.25	0.5	0.4	1.5	0.46	11°	50	6	2	●	1	1.5	1.6	1.7	1.9
VF2XLBR0025N020S04	0.25	0.5	0.4	2	0.46	10°	50	4	2	●	1	2.0	2.1	2.3	2.6
VF2XLBR0025N020S06	0.25	0.5	0.4	2	0.46	10.6°	50	6	2	●	1	2.0	2.1	2.3	2.6
VF2XLBR0025N025S04	0.25	0.5	0.4	2.5	0.46	9.5°	50	4	2	●	1	2.6	2.7	2.9	3.2
VF2XLBR0025N030S04	0.25	0.5	0.4	3	0.46	9.1°	50	4	2	●	1	3.1	3.2	3.5	3.9
VF2XLBR0025N030S06	0.25	0.5	0.4	3	0.46	10°	50	6	2	●	1	3.1	3.2	3.5	3.9
VF2XLBR0025N035S04	0.25	0.5	0.4	3.5	0.46	8.7°	50	4	2	●	1	3.6	3.8	4.1	4.5
VF2XLBR0025N040S04	0.25	0.5	0.4	4	0.46	8.3°	50	4	2	●	1	4.1	4.3	4.7	5.2
VF2XLBR0025N040S06	0.25	0.5	0.4	4	0.46	9.4°	50	6	2	●	1	4.1	4.3	4.7	5.2
VF2XLBR0025N050S04	0.25	0.5	0.4	5	0.46	7.7°	50	4	2	●	1	5.2	5.4	5.9	6.5
VF2XLBR0025N050S06	0.25	0.5	0.4	5	0.46	8.9°	50	6	2	●	1	5.2	5.4	5.9	6.5
VF2XLBR0025N060S04	0.25	0.5	0.4	6	0.46	7.2°	50	4	2	●	1	6.2	6.5	7.1	7.9
VF2XLBR0025N060S06	0.25	0.5	0.4	6	0.46	8.4°	60	6	2	●	1	6.2	6.5	7.1	7.9
VF2XLBR0030N020S04	0.3	0.6	0.48	2	0.56	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
VF2XLBR0030N020S06	0.3	0.6	0.48	2	0.56	10.6°	50	6	2	●	1	2.1	2.2	2.4	2.6
VF2XLBR0030N025S04	0.3	0.6	0.48	2.5	0.56	9.4°	50	4	2	●	1	2.6	2.7	3.0	3.3
VF2XLBR0030N030S04	0.3	0.6	0.48	3	0.56	9°	50	4	2	●	1	3.1	3.3	3.6	3.9
VF2XLBR0030N030S06	0.3	0.6	0.48	3	0.56	9.9°	50	6	2	●	1	3.1	3.3	3.6	3.9
VF2XLBR0030N035S04	0.3	0.6	0.48	3.5	0.56	8.6°	50	4	2	●	1	3.6	3.8	4.2	4.6
VF2XLBR0030N040S04	0.3	0.6	0.48	4	0.56	8.3°	50	4	2	●	1	4.2	4.4	4.8	5.2
VF2XLBR0030N040S06	0.3	0.6	0.48	4	0.56	9.3°	50	6	2	●	1	4.2	4.4	4.8	5.2
VF2XLBR0030N050S04	0.3	0.6	0.48	5	0.56	7.6°	50	4	2	●	1	5.2	5.4	6.0	6.6
VF2XLBR0030N050S06	0.3	0.6	0.48	5	0.56	8.8°	50	6	2	●	1	5.2	5.4	6.0	6.6
VF2XLBR0030N060S04	0.3	0.6	0.48	6	0.56	7.1°	50	4	2	●	1	6.3	6.5	7.1	7.9
VF2XLBR0030N060S06	0.3	0.6	0.48	6	0.56	8.4°	50	6	2	●	1	6.3	6.5	7.1	7.9
VF2XLBR0030N070S04	0.3	0.6	0.48	7	0.56	6.6°	50	4	2	●	1	7.3	7.6	8.3	9.2
VF2XLBR0030N080S04	0.3	0.6	0.48	8	0.56	6.2°	50	4	2	●	1	8.3	8.7	9.5	10.6
VF2XLBR0030N080S06	0.3	0.6	0.48	8	0.56	7.6°	60	6	2	●	1	8.3	8.7	9.5	10.6
VF2XLBR0040N020S04	0.4	0.8	0.64	2	0.76	9.9°	50	4	2	●	1	2.1	2.2	2.3	2.6
VF2XLBR0040N020S06	0.4	0.8	0.64	2	0.76	10.6°	50	6	2	●	1	2.1	2.2	2.3	2.6
VF2XLBR0040N030S04	0.4	0.8	0.64	3	0.76	8.9°	50	4	2	●	1	3.1	3.3	3.5	3.9
VF2XLBR0040N030S06	0.4	0.8	0.64	3	0.76	9.9°	50	6	2	●	1	3.1	3.3	3.5	3.9
VF2XLBR0040N040S04	0.4	0.8	0.64	4	0.76	8.2°	50	4	2	●	1	4.2	4.3	4.7	5.2
VF2XLBR0040N040S06	0.4	0.8	0.64	4	0.76	9.3°	50	6	2	●	1	4.2	4.3	4.7	5.2
VF2XLBR0040N050S04	0.4	0.8	0.64	5	0.76	7.5°	50	4	2	●	1	5.2	5.4	5.9	6.5
VF2XLBR0040N060S04	0.4	0.8	0.64	6	0.76	7°	50	4	2	●	1	6.3	6.5	7.1	7.9
VF2XLBR0040N060S06	0.4	0.8	0.64	6	0.76	8.3°	50	6	2	●	1	6.3	6.5	7.1	7.9
VF2XLBR0040N070S04	0.4	0.8	0.64	7	0.76	6.5°	50	4	2	●	1	7.3	7.6	8.3	9.2
VF2XLBR0040N080S04	0.4	0.8	0.64	8	0.76	6.1°	50	4	2	●	1	8.3	8.7	9.5	10.5
VF2XLBR0040N080S06	0.4	0.8	0.64	8	0.76	7.5°	50	6	2	●	1	8.3	8.7	9.5	10.5
VF2XLBR0040N100S04	0.4	0.8	0.64	10	0.76	5.4°	50	4	2	●	1	10.4	10.9	11.9	13.2
VF2XLBR0040N100S06	0.4	0.8	0.64	10	0.76	6.8°	60	6	2	●	1	10.4	10.9	11.9	13.2
VF2XLBR0050N030S04	0.5	1	0.8	3	0.94	8.8°	50	4	2	●	1	3.2	3.3	3.6	4.0
VF2XLBR0050N030S06	0.5	1	0.8	3	0.94	9.8°	50	6	2	●	1	3.2	3.3	3.6	4.0
VF2XLBR0050N040S04	0.5	1	0.8	4	0.94	8°	50	4	2	●	1	4.2	4.4	4.8	5.3
VF2XLBR0050N040S06	0.5	1	0.8	4	0.94	9.2°	50	6	2	●	1	4.2	4.4	4.8	5.3
VF2XLBR0050N050S04	0.5	1	0.8	5	0.94	7.3°	50	4	2	●	1	5.3	5.5	6.0	6.7
VF2XLBR0050N050S06	0.5	1	0.8	5	0.94	8.7°	50	6	2	●	1	5.3	5.5	6.0	6.7
VF2XLBR0050N060S04	0.5	1	0.8	6	0.94	6.8°	50	4	2	●	1	6.3	6.6	7.2	8.0
VF2XLBR0050N060S06	0.5	1	0.8	6	0.94	8.2°	50	6	2	●	1	6.3	6.6	7.2	8.0
VF2XLBR0050N070S04	0.5	1	0.8	7	0.94	6.3°	50	4	2	●	1	7.4	7.7	8.4	9.3

VF2XLB

IMPACT MIRACLE, Ball nose, 2 flute, Long neck

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VF2XLBR0050N080S04	0.5	1	0.8	8	0.94	5.9°	50	4	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0050N080S06	0.5	1	0.8	8	0.94	7.4°	50	6	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0050N090S04	0.5	1	0.8	9	0.94	5.5°	50	4	2	●	1	9.5	9.9	10.8	12.0
VF2XLBR0050N100S04	0.5	1	0.8	10	0.94	5.2°	50	4	2	●	1	10.5	11.0	12.0	13.3
VF2XLBR0050N100S06	0.5	1	0.8	10	0.94	6.7°	50	6	2	●	1	10.5	11.0	12.0	13.3
VF2XLBR0050N120S04	0.5	1	0.8	12	0.94	4.6°	50	4	2	●	1	12.6	13.2	14.4	15.9
VF2XLBR0050N120S06	0.5	1	0.8	12	0.94	6.1°	60	6	2	●	1	12.6	13.2	14.4	15.9
VF2XLBR0050N140S04	0.5	1	0.8	14	0.94	4.2°	60	4	2	●	1	14.7	15.3	16.8	18.6
VF2XLBR0050N160S04	0.5	1	0.8	16	0.94	3.8°	60	4	2	●	1	16.8	17.5	19.2	21.3
VF2XLBR0050N160S06	0.5	1	0.8	16	0.94	5.3°	70	6	2	●	1	16.8	17.5	19.2	21.3
VF2XLBR0050N180S04	0.5	1	0.8	18	0.94	3.5°	60	4	2	●	1	18.9	19.7	21.6	23.9
VF2XLBR0050N200S04	0.5	1	0.8	20	0.94	3.3°	60	4	2	●	1	21.0	21.9	24.0	26.6
VF2XLBR0050N200S06	0.5	1	0.8	20	0.94	4.6°	70	6	2	●	1	21.0	21.9	24.0	26.6
VF2XLBR0060N060S04	0.6	1.2	0.96	6	1.14	6.6°	50	4	2	●	1	6.3	6.6	7.2	8.0
VF2XLBR0060N060S06	0.6	1.2	0.96	6	1.14	8.1°	50	6	2	●	1	6.3	6.6	7.2	8.0
VF2XLBR0060N080S04	0.6	1.2	0.96	8	1.14	5.7°	50	4	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0060N080S06	0.6	1.2	0.96	8	1.14	7.3°	50	6	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0060N100S04	0.6	1.2	0.96	10	1.14	5°	50	4	2	●	1	10.5	11.0	12.0	13.3
VF2XLBR0060N100S06	0.6	1.2	0.96	10	1.14	6.6°	50	6	2	●	1	10.5	11.0	12.0	13.3
VF2XLBR0060N120S04	0.6	1.2	0.96	12	1.14	4.5°	50	4	2	●	1	12.6	13.2	14.4	15.9
VF2XLBR0060N120S06	0.6	1.2	0.96	12	1.14	6°	50	6	2	●	1	12.6	13.2	14.4	15.9
VF2XLBR0060N140S04	0.6	1.2	0.96	14	1.14	4°	60	4	2	●	1	14.7	15.3	16.8	18.6
VF2XLBR0060N160S04	0.6	1.2	0.96	16	1.14	3.7°	60	4	2	●	1	16.8	17.5	19.2	21.2
VF2XLBR0060N160S06	0.6	1.2	0.96	16	1.14	5.2°	70	6	2	●	1	16.8	17.5	19.2	21.2
VF2XLBR0070N080S04	0.7	1.4	1.12	8	1.34	5.5°	50	4	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0070N120S04	0.7	1.4	1.12	12	1.34	4.3°	50	4	2	●	1	12.6	13.1	14.4	15.9
VF2XLBR0070N160S04	0.7	1.4	1.12	16	1.34	3.5°	60	4	2	●	1	16.8	17.5	19.2	21.2
VF2XLBR0075N060S04	0.75	1.5	1.2	6	1.44	6.3°	50	4	2	●	1	6.3	6.6	7.2	7.9
VF2XLBR0075N060S06	0.75	1.5	1.2	6	1.44	8°	50	6	2	●	1	6.3	6.6	7.2	7.9
VF2XLBR0075N080S04	0.75	1.5	1.2	8	1.44	5.4°	50	4	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0075N080S06	0.75	1.5	1.2	8	1.44	7.2°	50	6	2	●	1	8.4	8.8	9.6	10.6
VF2XLBR0075N100S04	0.75	1.5	1.2	10	1.44	4.7°	50	4	2	●	1	10.5	11.0	12.0	13.2
VF2XLBR0075N100S06	0.75	1.5	1.2	10	1.44	6.5°	50	6	2	●	1	10.5	11.0	12.0	13.2
VF2XLBR0075N120S04	0.75	1.5	1.2	12	1.44	4.2°	50	4	2	●	1	12.6	13.1	14.4	15.9
VF2XLBR0075N120S06	0.75	1.5	1.2	12	1.44	5.9°	50	6	2	●	1	12.6	13.1	14.4	15.9
VF2XLBR0075N140S04	0.75	1.5	1.2	14	1.44	3.8°	50	4	2	●	1	14.7	15.3	16.8	18.5
VF2XLBR0075N140S06	0.75	1.5	1.2	14	1.44	5.4°	50	6	2	●	1	14.7	15.3	16.8	18.5
VF2XLBR0075N160S04	0.75	1.5	1.2	16	1.44	3.4°	60	4	2	●	1	16.8	17.5	19.2	21.2
VF2XLBR0075N160S06	0.75	1.5	1.2	16	1.44	5°	60	6	2	●	1	16.8	17.5	19.2	21.2
VF2XLBR0075N180S04	0.75	1.5	1.2	18	1.44	3.1°	60	4	2	●	1	18.9	19.7	21.6	23.8
VF2XLBR0075N200S04	0.75	1.5	1.2	20	1.44	2.9°	60	4	2	●	1	21.0	21.9	23.9	*
VF2XLBR0075N200S06	0.75	1.5	1.2	20	1.44	4.3°	70	6	2	●	1	21.0	21.9	23.9	26.5
VF2XLBR0080N080S04	0.8	1.6	1.28	8	1.54	5.3°	50	4	2	●	1	8.4	8.8	9.6	10.5
VF2XLBR0080N120S04	0.8	1.6	1.28	12	1.54	4.1°	50	4	2	●	1	12.6	13.1	14.4	15.9
VF2XLBR0080N160S04	0.8	1.6	1.28	16	1.54	3.3°	60	4	2	●	1	16.8	17.5	19.1	21.2
VF2XLBR0080N200S04	0.8	1.6	1.28	20	1.54	2.8°	60	4	2	●	1	21.0	21.9	23.9	*
VF2XLBR0090N080S04	0.9	1.8	1.44	8	1.74	5.1°	50	4	2	●	1	8.4	8.8	9.6	10.5
VF2XLBR0090N120S04	0.9	1.8	1.44	12	1.74	3.9°	50	4	2	●	1	12.6	13.1	14.3	15.8
VF2XLBR0090N160S04	0.9	1.8	1.44	16	1.74	3.1°	60	4	2	●	1	16.8	17.5	19.1	21.1
VF2XLBR0090N200S04	0.9	1.8	1.44	20	1.74	2.6°	60	4	2	●	1	20.9	21.8	23.9	*
VF2XLBR0100N060S04	1	2	1.6	6	1.9	5.8°	50	4	2	●	1	6.2	6.5	7.0	7.7
VF2XLBR0100N060S06	1	2	1.6	6	1.9	7.9°	50	6	2	●	1	6.2	6.5	7.0	7.7

* No interference

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VF2XLBR0100N080S04	1	2	1.6	8	1.9	4.9°	50	4	2	●	1	8.3	8.7	9.4	10.4
VF2XLBR0100N080S06	1	2	1.6	8	1.9	6.9°	50	6	2	●	1	8.3	8.7	9.4	10.4
VF2XLBR0100N100S04	1	2	1.6	10	1.9	4.2°	50	4	2	●	1	10.4	10.9	11.8	13.0
VF2XLBR0100N100S06	1	2	1.6	10	1.9	6.2°	50	6	2	●	1	10.4	10.9	11.8	13.0
VF2XLBR0100N120S04	1	2	1.6	12	1.9	3.7°	50	4	2	●	1	12.5	13.0	14.2	15.7
VF2XLBR0100N120S06	1	2	1.6	12	1.9	5.6°	50	6	2	●	1	12.5	13.0	14.2	15.7
VF2XLBR0100N140S04	1	2	1.6	14	1.9	3.3°	50	4	2	●	1	14.6	15.2	16.6	18.3
VF2XLBR0100N140S06	1	2	1.6	14	1.9	5.1°	50	6	2	●	1	14.6	15.2	16.6	18.3
VF2XLBR0100N160S04	1	2	1.6	16	1.9	2.9°	60	4	2	●	1	16.7	17.4	19.0	*
VF2XLBR0100N160S06	1	2	1.6	16	1.9	4.7°	60	6	2	●	1	16.7	17.4	19.0	21.0
VF2XLBR0100N180S04	1	2	1.6	18	1.9	2.7°	60	4	2	●	1	18.8	19.6	21.4	*
VF2XLBR0100N180S06	1	2	1.6	18	1.9	4.4°	60	6	2	●	1	18.8	19.6	21.4	23.6
VF2XLBR0100N200S04	1	2	1.6	20	1.9	2.5°	60	4	2	●	1	20.9	21.8	23.8	*
VF2XLBR0100N200S06	1	2	1.6	20	1.9	4.1°	60	6	2	●	1	20.9	21.8	23.8	26.3
VF2XLBR0100N220S04	1	2	1.6	22	1.9	2.3°	60	4	2	●	1	22.9	23.9	26.2	*
VF2XLBR0100N250S04	1	2	1.6	25	1.9	2°	70	4	2	●	1	26.1	27.2	*	*
VF2XLBR0100N250S06	1	2	1.6	25	1.9	3.5°	70	6	2	●	1	26.1	27.2	29.8	32.9
VF2XLBR0100N300S04	1	2	1.6	30	1.9	1.7°	70	4	2	●	1	31.3	32.6	*	*
VF2XLBR0100N300S06	1	2	1.6	30	1.9	3°	80	6	2	●	1	31.3	32.6	35.8	*
VF2XLBR0100N350S04	1	2	1.6	35	1.9	1.5°	80	4	2	●	1	36.5	38.1	*	*
VF2XLBR0125N100S06	1.25	2.5	2	10	2.4	5.9°	60	6	2	●	1	10.4	10.8	11.8	12.9
VF2XLBR0125N150S06	1.25	2.5	2	15	2.4	4.6°	60	6	2	●	1	15.6	16.3	17.8	19.6
VF2XLBR0125N200S06	1.25	2.5	2	20	2.4	3.7°	70	6	2	●	1	20.8	21.7	23.8	26.2
VF2XLBR0125N250S06	1.25	2.5	2	25	2.4	3.2°	70	6	2	●	1	26.1	27.2	29.7	32.9
VF2XLBR0125N300S06	1.25	2.5	2	30	2.4	2.8°	80	6	2	●	1	31.3	32.6	35.7	*
VF2XLBR0125N350S06	1.25	2.5	2	35	2.4	2.4°	80	6	2	●	1	36.5	38.1	41.7	*
VF2XLBR0150N080S06	1.5	3	2.4	8	2.9	6.3°	60	6	2	●	1	8.3	8.6	9.3	10.2
VF2XLBR0150N100S06	1.5	3	2.4	10	2.9	5.5°	60	6	2	●	1	10.4	10.8	11.7	12.9
VF2XLBR0150N120S06	1.5	3	2.4	12	2.9	4.9°	60	6	2	●	1	12.5	13.0	14.1	15.5
VF2XLBR0150N140S06	1.5	3	2.4	14	2.9	4.4°	60	6	2	●	1	14.6	15.2	16.5	18.2
VF2XLBR0150N160S06	1.5	3	2.4	16	2.9	4°	60	6	2	●	1	16.7	17.3	18.9	20.8
VF2XLBR0150N200S06	1.5	3	2.4	20	2.9	3.4°	70	6	2	●	1	20.8	21.7	23.7	26.1
VF2XLBR0150N250S06	1.5	3	2.4	25	2.9	2.8°	70	6	2	●	1	26.1	27.2	29.7	*
VF2XLBR0150N300S06	1.5	3	2.4	30	2.9	2.5°	70	6	2	●	1	31.3	32.6	35.7	*
VF2XLBR0150N350S06	1.5	3	2.4	35	2.9	2.2°	80	6	2	●	1	36.5	38.0	41.7	*
VF2XLBR0150N400S06	1.5	3	2.4	40	2.9	1.9°	90	6	2	●	1	41.7	43.5	*	*
VF2XLBR0175N160S06	1.75	3.5	2.8	16	3.4	3.6°	60	6	2	●	1	16.7	17.3	18.9	20.8
VF2XLBR0175N200S06	1.75	3.5	2.8	20	3.4	3°	70	6	2	●	1	20.8	21.7	23.7	*
VF2XLBR0175N250S06	1.75	3.5	2.8	25	3.4	2.5°	70	6	2	●	1	26.0	27.1	29.6	*
VF2XLBR0175N300S06	1.75	3.5	2.8	30	3.4	2.1°	80	6	2	●	1	31.3	32.6	35.6	*
VF2XLBR0175N350S06	1.75	3.5	2.8	35	3.4	1.9°	80	6	2	●	1	36.5	38.0	*	*
VF2XLBR0175N400S06	1.75	3.5	2.8	40	3.4	1.7°	90	6	2	●	1	41.7	43.5	*	*
VF2XLBR0200N100S06	2	4	3.2	10	3.9	4.5°	70	6	2	●	1	10.4	10.8	11.6	12.7
VF2XLBR0200N120S06	2	4	3.2	12	3.9	3.9°	70	6	2	●	1	12.5	12.9	14.0	15.4
VF2XLBR0200N140S06	2	4	3.2	14	3.9	3.4°	70	6	2	●	1	14.6	15.1	16.4	18.0
VF2XLBR0200N160S06	2	4	3.2	16	3.9	3.1°	70	6	2	●	1	16.6	17.3	18.8	20.7
VF2XLBR0200N200S06	2	4	3.2	20	3.9	2.6°	70	6	2	●	1	20.8	21.7	23.6	*
VF2XLBR0200N250S06	2	4	3.2	25	3.9	2.1°	70	6	2	●	1	26.0	27.1	29.6	*
VF2XLBR0200N300S06	2	4	3.2	30	3.9	1.8°	70	6	2	●	1	31.2	32.6	*	*
VF2XLBR0200N350S06	2	4	3.2	35	3.9	1.6°	80	6	2	●	1	36.5	38.0	*	*
VF2XLBR0200N400S06	2	4	3.2	40	3.9	1.4°	90	6	2	●	1	41.7	43.5	*	*
VF2XLBR0200N450S06	2	4	3.2	45	3.9	1.2°	90	6	2	●	1	46.9	48.9	*	*

* No interference

VF2XLB

IMPACT MIRACLE, Ball nose, 2 flute, Long neck

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VF2XLBR0200N500S06	2	4	3.2	50	3.9	1.1°	100	6	2	●	1	52.1	54.3	*	*
VF2XLBR0250N200S06	2.5	5	4	20	4.9	1.5°	70	6	2	●	1	20.8	21.6	*	*
VF2XLBR0250N250S06	2.5	5	4	25	4.9	1.2°	70	6	2	●	1	26.0	27.1	*	*
VF2XLBR0250N300S06	2.5	5	4	30	4.9	1°	80	6	2	●	1	31.2	*	*	*
VF2XLBR0250N350S06	2.5	5	4	35	4.9	0.9°	80	6	2	●	1	36.4	*	*	*
VF2XLBR0300N300S06	3	6	4.8	30	5.85	—	80	6	2	●	2	*	*	*	*
VF2XLBR0300N400S06	3	6	4.8	40	5.85	—	90	6	2	●	2	*	*	*	*
VF2XLBR0300N500S06	3	6	4.8	50	5.85	—	100	6	2	●	2	*	*	*	*

* No interference

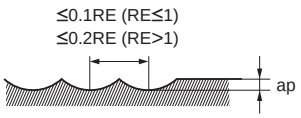
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R 0.1	0.5	40000	300	0.003	40000	300	0.002
	1	40000	300	0.002	40000	300	0.002
	1.5	40000	300	0.001	40000	200	0.001
	2	40000	200	0.001	40000	100	0.001
	2.5	40000	100	0.001	40000	60	0.001
R 0.15	1	40000	500	0.007	40000	500	0.005
	1.5	40000	500	0.005	40000	500	0.003
	2	40000	500	0.003	40000	500	0.002
	2.5	40000	400	0.003	40000	400	0.002
	3	40000	300	0.002	40000	300	0.001
	4	30000	200	0.002	30000	200	0.001
R 0.2	1	40000	1400	0.015	40000	1400	0.01
	1.5	40000	1000	0.01	40000	1000	0.006
	2	40000	1000	0.01	40000	1000	0.006
	2.5	40000	700	0.005	40000	700	0.003
	3	40000	700	0.005	40000	700	0.003
	4	40000	600	0.004	40000	500	0.003
	5	40000	400	0.003	40000	300	0.002
R 0.25	1.5	40000	2000	0.02	40000	2000	0.015
	2	40000	2000	0.02	40000	2000	0.015
	3	40000	1200	0.015	40000	1200	0.01
	4	36000	900	0.01	36000	900	0.007
	5	36000	700	0.007	36000	600	0.005
	6	36000	600	0.006	36000	500	0.004
R 0.3	2	40000	2800	0.03	40000	2800	0.02
	3	40000	2800	0.03	40000	2800	0.02
	4	35000	2000	0.02	35000	2000	0.015
	5	30000	1000	0.01	30000	1000	0.007
	6	30000	800	0.008	30000	800	0.005
	7	30000	600	0.008	30000	600	0.005
	8	25000	400	0.006	25000	400	0.004
R 0.4	2	40000	3500	0.04	40000	3500	0.03
	3	40000	3000	0.04	40000	3000	0.03
	4	40000	3000	0.02	40000	3000	0.015
	6	30000	1600	0.02	30000	1600	0.01
	8	25000	1000	0.01	25000	1000	0.007
	10	25000	600	0.008	25000	600	0.005
R 0.5	3	40000	4000	0.05	40000	4000	0.04
	4	40000	4000	0.05	40000	4000	0.04
	5	40000	3000	0.03	40000	3000	0.02
	6	35000	2000	0.03	35000	2000	0.02
	8	30000	1600	0.02	30000	1600	0.01
	10	20000	1000	0.01	20000	1000	0.01
	12	20000	1000	0.01	18000	800	0.008
	14	18000	600	0.008	18000	480	0.008
	16	18000	500	0.008	18000	400	0.006
	18	13000	300	0.005	13000	240	0.004
	20	13000	250	0.005	13000	200	0.004
R 0.6	6	40000	4000	0.05	35000	3500	0.04
	8	40000	3000	0.05	27000	2000	0.04
	10	27000	1900	0.03	24000	1700	0.02
	12	16000	1100	0.02	16000	1000	0.01
	14	16000	850	0.01	16000	780	0.01
	16	15000	500	0.01	14000	400	0.006
R 0.7	8	40000	4500	0.06	28000	3200	0.05
	12	32000	3000	0.03	19000	1800	0.02
	16	15000	1000	0.02	14000	800	0.01
R 0.75	6	40000	5000	0.07	32000	4000	0.06
	8	40000	5000	0.07	28000	3500	0.06
	10	40000	4500	0.06	21000	2400	0.04
	12	32000	3400	0.04	19000	2000	0.03
	14	16000	1500	0.04	13000	1200	0.03
	16	13000	1200	0.03	13000	1200	0.02

Work Material		Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R 0.75	18	13000	1100	0.02	10000	800	0.02
	20	12000	900	0.02	9000	700	0.01
R 0.8	8	40000	5000	0.08	26000	3200	0.07
	12	35000	3800	0.05	20000	2100	0.03
	16	13000	1200	0.04	12000	1100	0.02
	20	10000	750	0.02	8000	600	0.01
R 0.9	8	40000	5000	0.09	25000	3100	0.08
	12	36000	3800	0.06	18000	1900	0.04
	16	25000	2500	0.04	14000	1300	0.025
	20	10000	1000	0.03	8000	800	0.02
R 1	6	40000	6000	0.1	24000	3400	0.1
	8	40000	5000	0.1	24000	3000	0.1
	10	40000	5000	0.08	24000	3000	0.07
	12	40000	5000	0.08	24000	2600	0.05
	14	40000	5000	0.06	21000	2300	0.05
	16	32000	3500	0.05	16000	1700	0.03
	18	24000	2400	0.04	13000	1300	0.03
	20	10000	1000	0.04	10000	1000	0.03
	22	10000	1000	0.04	10000	1000	0.02
	25	10000	1000	0.04	8000	800	0.02
	30	10000	800	0.02	8000	800	0.015
	35	10000	500	0.02	8000	400	0.01
R 1.25	10	36000	5000	0.12	20000	2600	0.11
	15	36000	4600	0.08	18000	2000	0.075
	20	26000	3000	0.07	13000	1400	0.05
	25	10000	1100	0.06	8000	800	0.04
	30	8000	800	0.05	7000	700	0.03
	35	8000	500	0.03	5000	400	0.03
R 1.5	8	32000	6400	0.15	16000	3000	0.15
	10	32000	5100	0.15	16000	2200	0.15
	12	32000	5100	0.13	16000	2200	0.13
	14	32000	4500	0.13	16000	2200	0.1
	16	32000	4500	0.1	16000	1800	0.1
	20	27000	3800	0.1	14000	1600	0.06
	25	21000	2700	0.08	11000	1200	0.06
	30	9000	1000	0.08	7000	700	0.05
	35	6000	700	0.06	6000	600	0.04
	40	6000	600	0.04	5000	400	0.03
R 1.75	16	28000	4200	0.13	14000	1600	0.13
	20	26000	3800	0.13	13000	1600	0.11
	25	23000	3300	0.12	11000	1200	0.08
	30	13000	1900	0.09	9000	1000	0.07
	35	9000	1200	0.08	6000	600	0.06
	40	8500	1100	0.07	5500	500	0.04
R 2	10	24000	4800	0.2	12000	2200	0.2
	12	24000	4800	0.2	12000	2200	0.2
	14	24000	3800	0.15	12000	1500	0.15
	16	24000	3800	0.15	12000	1500	0.15
	20	24000	3800	0.15	12000	1500	0.15
	25	24000	3800	0.15	10000	1100	0.1
	30	20000	3000	0.1	10000	1100	0.08
	35	12000	1700	0.1	8000	900	0.08
	40	11000	1500	0.1	5000	500	0.06
	45	10000	1300	0.08	5000	500	0.05
	50	8000	1000	0.05	4000	400	0.04
R 2.5	20	19000	3400	0.2	10000	1400	0.2
	25	19000	3400	0.2	10000	1400	0.2
	30	19000	3200	0.15	8000	1000	0.15
	35	16000	2700	0.1	8000	900	0.1
R 3	30	16000	3500	0.2	8000	1000	0.2
	40	16000	3000	0.15	8000	800	0.15
	50	16000	2700	0.15	6000	500	0.15

Depth of cut



RE:Radius

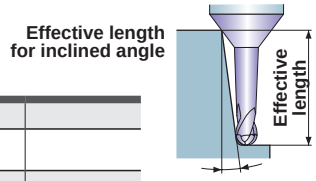
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

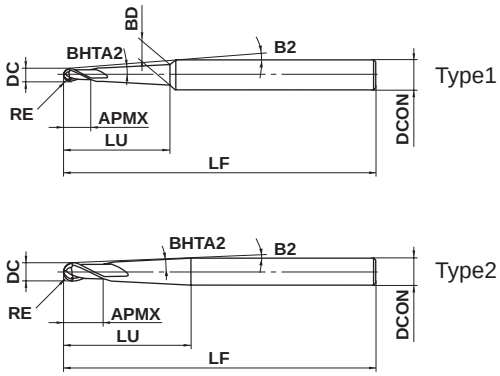
VCXB

Ball nose taper end mill, Medium cut length, Taper neck

UWC VC γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		





0.5≤RE≤6				
±0.01				
1≤DC≤12				
0 - 0.020				
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

●2 flute taper end mill with taper neck.

(mm)

Order Number	RE	DC	BHTA2	APMX	LU	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 1°	2°	3°
VCXBR0050T0100L016	0.5	1	1°	2	16	6.6°	1.38	50	6	2	▲	1	16.2	17.0	18.0
VCXBR0050T0100L021	0.5	1	1°	2	21	5.4°	1.56	60	6	2	▲	1	21.2	22.3	23.5
VCXBR0050T0100L026	0.5	1	1°	2	26	4.6°	1.73	70	6	2	▲	1	26.2	27.6	29.1
VCXBR0050T0130	0.5	1	1.5°	2	23	5.1°	1.97	60	6	2	▲	1	—	23.9	25.2
VCXBR0050T0300	0.5	1	3°	2	42	3.4°	5.08	80	6	2	▲	1	—	—	42.4
VCXBR0050T0500	0.5	1	5°	2	23	5.8°	4.46	60	6	2	▲	1	—	—	—
VCXBR0100T0100L021	1	2	1°	4	21	4.6°	2.43	50	6	2	▲	1	21.3	22.4	23.6
VCXBR0100T0100L031	1	2	1°	4	31	3.4°	2.78	60	6	2	▲	1	31.3	33.0	34.8
VCXBR0100T0100L041	1	2	1°	4	41	2.7°	3.13	70	6	2	▲	1	41.3	43.5	*
VCXBR0100T0130	1	2	1.5°	4	23	4.4°	2.8	60	6	2	▲	1	—	24.1	25.4
VCXBR0100T0300	1	2	3°	4	41	2.9°	5.71	80	6	2	▲	1	—	—	*
VCXBR0100T0500	1	2	5°	4	23	4.9°	5.02	60	6	2	▲	1	—	—	—
VCXBR0150T0100L031	1.5	3	1°	6	31	2.7°	3.71	60	6	2	▲	1	31.4	33.0	*
VCXBR0150T0100L041	1.5	3	1°	6	41	2.1°	4.06	70	6	2	▲	1	41.4	43.5	*
VCXBR0150T0100L051	1.5	3	1°	6	51	1.7°	4.41	80	6	2	▲	1	51.4	*	*
VCXBR0150T0130	1.5	3	1.5°	6	52	1.7°	5.21	90	6	2	▲	1	—	*	*
VCXBR0150T0300	1.5	3	3°	6	32	2.8°	5.56	70	6	2	▲	1	—	—	*
VCXBR0200T0100L036	2	4	1°	8	36	1.7°	4.81	70	6	2	▲	1	36.5	*	*
VCXBR0200T0100L046	2	4	1°	8	46	1.3°	5.16	80	6	2	▲	1	46.5	*	*
VCXBR0200T0100L060	2	4	1°	8	60	1°	5.65	90	6	2	▲	1	60.5	*	*
VCXBR0200T0130	2	4	1.5°	8	49	1.3°	5.95	90	6	2	▲	1	—	*	*
VCXBR0200T0300	2	4	3°	8	28	2.2°	—	70	6	2	▲	2	—	—	*
VCXBR0250T0100L036	2.5	5	1°	10	36	0.9°	5.71	80	6	2	▲	1	*	*	*
VCXBR0250T0100L065	2.5	5	1°	10	65	1.4°	6.72	110	8	2	▲	1	65.6	*	*
VCXBR0250T0130	2.5	5	1.5°	10	61	1.5°	7.42	110	8	2	▲	1	—	*	*
VCXBR0250T0300	2.5	5	3°	10	41	2.3°	—	90	8	2	▲	2	—	—	*
VCXBR0300T0100L051	3	6	1°	12	51	1.2°	7.11	90	8	2	▲	1	51.8	*	*
VCXBR0300T0100L065	3	6	1°	12	65	1°	7.6	110	8	2	▲	1	65.8	*	*
VCXBR0300T0100L092	3	6	1°	12	92	1.3°	8.54	140	10	2	▲	1	92.8	*	*
VCXBR0300T0130	3	6	1.5°	12	53	1.2°	7.85	110	8	2	▲	1	—	*	*
VCXBR0300T0300	3	6	3°	12	34	1.9°	—	90	8	2	▲	2	—	—	*
VCXBR0400T0100L068	4	8	1°	14	68	0.9°	9.64	110	10	2	▲	1	*	*	*
VCXBR0400T0100L092	4	8	1°	14	92	1.3°	10.47	140	12	2	▲	1	92.8	*	*
VCXBR0400T0130	4	8	1.5°	14	55	1.2°	9.85	120	10	2	▲	1	—	*	*

* No interference

▲ : Product scheduled to be discontinued at the end of March 2020
MP3XB(J254) is alternative product.

(mm)

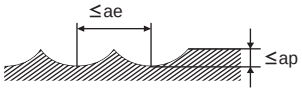
Order Number	RE	DC	BHTA2	APMX	LU	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 1°	2°	3°
VCXBR0400T0300	4	8	3°	14	36	1.8°	—	100	10	2	▲	2	—	—	*
VCXBR0500T0100L070	5	10	1°	18	70	0.9°	11.76	130	12	2	▲	1	*	*	*
VCXBR0500T0100L100	5	10	1°	18	100	1.8°	12.8	160	16	2	▲	1	100.7	*	*
VCXBR0500T0130	5	10	1.5°	18	59	1.1°	—	130	12	2	▲	2	—	*	*
VCXBR0500T0300	5	10	3°	18	40	1.7°	—	110	12	2	▲	2	—	—	*
VCXBR0600T0100L070	6	12	1°	22	70	1.8°	13.62	140	16	2	▲	1	70.9	*	*
VCXBR0600T0100L100	6	12	1°	22	100	1.2°	14.66	160	16	2	▲	1	100.9	*	*
VCXBR0600T0130	6	12	1.5°	22	83	1.5°	15.08	160	16	2	▲	1	—	*	*
VCXBR0600T0300	6	12	3°	22	63	2.1°	—	140	16	2	▲	2	—	—	*

* No interference

RECOMMENDED CUTTING CONDITIONS

Work Material					Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45—55HRC) AISI H13	
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LU** (mm)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
R0.5	1°	16	0.02	0.1	22000	530	12000	230
	1°	21	0.01					
	1°	26	0.01					
	1.5°	23	0.02					
	3°	42	0.05					
	5°	23	0.05					
R1	1°	21	0.05	0.2	18000	570	10000	260
	1°	31	0.04					
	1°	41	0.03					
	1.5°	23	0.1					
	3°	41	0.1					
	5°	23	0.1					
R2	1°	36	0.2	0.8	14000	670	6000	200
	1°	46	0.15					
	1°	60	0.1					
	1.5°	49	0.2					
	3°	28	0.2					
R3	1°	51	0.3	1.2	10000	840	5000	220
	1°	65	0.2					
	1°	92	0.1					
	1.5°	53	0.3					
	3°	34	0.3					
R4	1.5°	55	0.4	1.6	8000	840	4000	270
	3°	36	0.4					
R5	1°	70	0.4	2	6000	840	3000	310
	1°	100	0.3					
	1.5°	59	0.5					
	3°	40	0.5					
R6	1°	70	0.6	2.4	5000	900	2500	340
	1°	100	0.4					
	1.5°	83	0.6					
	3°	63	0.6					

Depth of cut



Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

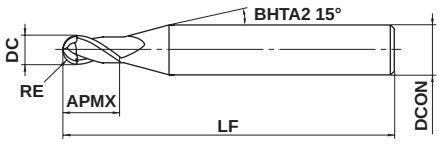
CRN2MB

Ball nose, Medium cut length, 2 flute, For copper electrodes

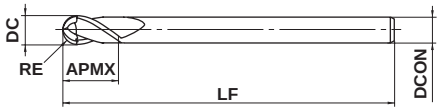
TOOL NEWS

UWC CRN γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○



Type1



Type2

0.2≤RE≤6				
±0.01				
0.4≤DC≤12				
0 / - 0.02				
DCON=3	4≤DCON≤6	8≤DCON≤10	DCON=12	
0 / - 0.006	0 / - 0.008	0 / - 0.009	0 / - 0.011	

h6

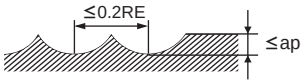
●2 flute ball nose end mill with CRN coating for copper electrode machining.

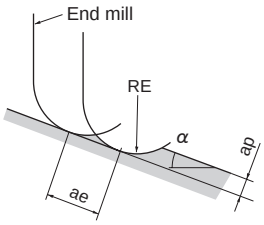
(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
CRN2MBR0020S04	0.2	0.4	0.8	45	4	2	●	1
CRN2MBR0020S06	0.2	0.4	0.8	50	6	2	●	1
CRN2MBR0030S04	0.3	0.6	1.2	45	4	2	●	1
CRN2MBR0030S06	0.3	0.6	1.2	50	6	2	●	1
CRN2MBR0040S04	0.4	0.8	1.6	45	4	2	●	1
CRN2MBR0040S06	0.4	0.8	1.6	50	6	2	●	1
CRN2MBR0050S04	0.5	1	2.5	45	4	2	●	1
CRN2MBR0050S06	0.5	1	2.5	50	6	2	●	1
CRN2MBR0075S04	0.75	1.5	4	45	4	2	●	1
CRN2MBR0075S06	0.75	1.5	4	50	6	2	●	1
CRN2MBR0100S06	1	2	6	50	6	2	●	1
CRN2MBR0125S06	1.25	2.5	6	50	6	2	●	1
CRN2MBR0150S03	1.5	3	8	70	3	2	●	2
CRN2MBR0150S06	1.5	3	8	70	6	2	●	1
CRN2MBR0175S06	1.75	3.5	8	70	6	2	●	1
CRN2MBR0200S04	2	4	8	70	4	2	●	2
CRN2MBR0200S06	2	4	8	70	6	2	●	1
CRN2MBR0250S06	2.5	5	12	80	6	2	●	1
CRN2MBR0300S06	3	6	12	80	6	2	●	2
CRN2MBR0400S08	4	8	14	90	8	2	●	2
CRN2MBR0500S10	5	10	18	100	10	2	●	2
CRN2MBR0600S12	6	12	22	110	12	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Copper, Copper alloys				
R **RE** (mm)	$\alpha \leq 15°$		$\alpha > 15°$		Depth of cut ap(mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	
R0.2	40000	1600	40000	1200	0.02
R0.3	40000	3200	40000	1600	0.03
R0.4	40000	6400	40000	2400	0.05
R0.5	40000	8000	40000	3200	0.06
R0.75	40000	9600	40000	4000	0.09
R1	40000	9600	39000	4700	0.11
R1.25	40000	12000	30000	4500	0.12
R1.5	40000	12000	27000	4300	0.13
R2	32000	11000	20000	3600	0.15
R2.5	25000	9000	16000	2900	0.20
R3	21000	8400	13000	2600	0.25
R4	16000	6400	10000	2000	0.30
R5	13000	5200	8000	1700	0.50
R6	9000	3600	6000	1300	0.50
Depth of cut	 RE:Radius				



ae:Pick Feed

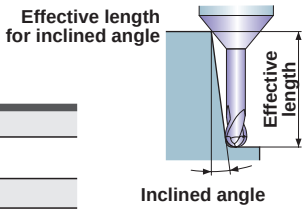
Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Water-soluble cutting fluid is recommended.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

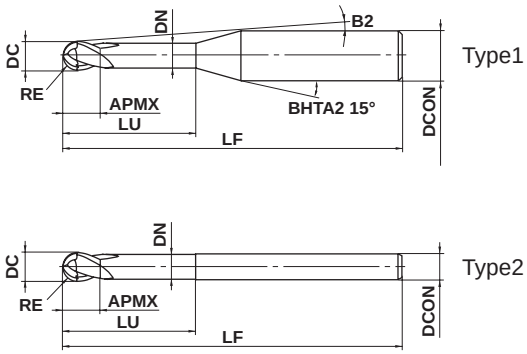
CRN2XLB

Ball nose, Medium cut length, 2 flute, Long neck, For copper electrodes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○





0.1≤RE≤3			
±0.01			
0.2≤DC≤6			
0 / - 0.02			
4≤DCON≤6			
0 / - 0.008			

●2 flute long neck ball nose end mill with CRN coating for copper electrode machining.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
CRN2XLBR0010N005S04	0.1	0.2	0.2	0.5	0.17	14.1°	50	4	2	●	1	0.5	0.5	0.6	0.6
CRN2XLBR0010N005S06	0.1	0.2	0.2	0.5	0.17	14.4°	50	6	2	●	1	0.5	0.5	0.6	0.6
CRN2XLBR0010N010S04	0.1	0.2	0.2	1	0.17	13.3°	50	4	2	●	1	1.0	1.1	1.2	1.3
CRN2XLBR0010N010S06	0.1	0.2	0.2	1	0.17	13.8°	50	6	2	●	1	1.0	1.1	1.2	1.3
CRN2XLBR0010N015S04	0.1	0.2	0.2	1.5	0.17	12.5°	50	4	2	●	1	1.5	1.6	1.7	1.9
CRN2XLBR0010N015S06	0.1	0.2	0.2	1.5	0.17	13.3°	50	6	2	●	1	1.5	1.6	1.7	1.9
CRN2XLBR0015N010S04	0.15	0.3	0.3	1	0.27	13.3°	50	4	2	●	1	1.0	1.1	1.2	1.3
CRN2XLBR0015N010S06	0.15	0.3	0.3	1	0.27	13.9°	50	6	2	●	1	1.0	1.1	1.2	1.3
CRN2XLBR0015N015S04	0.15	0.3	0.3	1.5	0.27	12.5°	50	4	2	●	1	1.5	1.6	1.7	1.9
CRN2XLBR0015N015S06	0.15	0.3	0.3	1.5	0.27	13.3°	50	6	2	●	1	1.5	1.6	1.7	1.9
CRN2XLBR0015N020S04	0.15	0.3	0.3	2	0.27	11.9°	50	4	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0015N020S06	0.15	0.3	0.3	2	0.27	12.8°	50	6	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0020N010S04	0.2	0.4	0.4	1	0.36	13.4°	50	4	2	●	1	1.0	1.0	1.1	1.2
CRN2XLBR0020N010S06	0.2	0.4	0.4	1	0.36	13.9°	50	6	2	●	1	1.0	1.0	1.1	1.2
CRN2XLBR0020N015S04	0.2	0.4	0.4	1.5	0.36	12.6°	50	4	2	●	1	1.5	1.6	1.7	1.8
CRN2XLBR0020N015S06	0.2	0.4	0.4	1.5	0.36	13.4°	50	6	2	●	1	1.5	1.6	1.7	1.8
CRN2XLBR0020N020S04	0.2	0.4	0.4	2	0.36	11.9°	50	4	2	●	1	2.0	2.1	2.3	2.5
CRN2XLBR0020N020S06	0.2	0.4	0.4	2	0.36	12.8°	50	6	2	●	1	2.0	2.1	2.3	2.5
CRN2XLBR0020N030S04	0.2	0.4	0.4	3	0.36	10.7°	50	4	2	●	1	3.1	3.2	3.4	3.7
CRN2XLBR0020N030S06	0.2	0.4	0.4	3	0.36	11.9°	50	6	2	●	1	3.1	3.2	3.4	3.7
CRN2XLBR0025N015S04	0.25	0.5	0.5	1.5	0.46	12.6°	50	4	2	●	1	1.5	1.6	1.7	1.8
CRN2XLBR0025N015S06	0.25	0.5	0.5	1.5	0.46	13.4°	50	6	2	●	1	1.5	1.6	1.7	1.8
CRN2XLBR0025N020S04	0.25	0.5	0.5	2	0.46	11.9°	50	4	2	●	1	2.0	2.1	2.3	2.4
CRN2XLBR0025N020S06	0.25	0.5	0.5	2	0.46	12.9°	50	6	2	●	1	2.0	2.1	2.3	2.4
CRN2XLBR0025N030S04	0.25	0.5	0.5	3	0.46	10.6°	50	4	2	●	1	3.1	3.2	3.4	3.7
CRN2XLBR0025N030S06	0.25	0.5	0.5	3	0.46	11.9°	50	6	2	●	1	3.1	3.2	3.4	3.7
CRN2XLBR0025N040S04	0.25	0.5	0.5	4	0.46	9.6°	50	4	2	●	1	4.1	4.3	4.6	4.9
CRN2XLBR0025N040S06	0.25	0.5	0.5	4	0.46	11.1°	50	6	2	●	1	4.1	4.3	4.6	4.9
CRN2XLBR0025N060S04	0.25	0.5	0.5	6	0.46	8.1°	50	4	2	●	1	6.2	6.4	6.9	7.4
CRN2XLBR0025N060S06	0.25	0.5	0.5	6	0.46	9.7°	50	6	2	●	1	6.2	6.4	6.9	7.4
CRN2XLBR0025N080S04	0.25	0.5	0.5	8	0.46	7°	50	4	2	●	1	8.3	8.5	9.2	9.9
CRN2XLBR0025N080S06	0.25	0.5	0.5	8	0.46	8.7°	50	6	2	●	1	8.3	8.5	9.2	9.9
CRN2XLBR0025N100S04	0.25	0.5	0.5	10	0.46	6.2°	50	4	2	●	1	10.3	10.7	11.5	12.4
CRN2XLBR0025N100S06	0.25	0.5	0.5	10	0.46	7.8°	50	6	2	●	1	10.3	10.7	11.5	12.4

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
CRN2XLBR0030N020S04	0.3	0.6	0.6	2	0.56	11.8°	50	4	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0030N020S06	0.3	0.6	0.6	2	0.56	12.8°	50	6	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0030N040S04	0.3	0.6	0.6	4	0.56	9.5°	50	4	2	●	1	4.2	4.3	4.6	5.0
CRN2XLBR0030N040S06	0.3	0.6	0.6	4	0.56	11°	50	6	2	●	1	4.2	4.3	4.6	5.0
CRN2XLBR0030N060S04	0.3	0.6	0.6	6	0.56	8°	50	4	2	●	1	6.3	6.5	6.9	7.5
CRN2XLBR0030N060S06	0.3	0.6	0.6	6	0.56	9.7°	50	6	2	●	1	6.3	6.5	6.9	7.5
CRN2XLBR0030N080S04	0.3	0.6	0.6	8	0.56	6.9°	50	4	2	●	1	8.3	8.6	9.2	10.0
CRN2XLBR0030N080S06	0.3	0.6	0.6	8	0.56	8.6°	50	6	2	●	1	8.3	8.6	9.2	10.0
CRN2XLBR0030N100S04	0.3	0.6	0.6	10	0.56	6°	50	4	2	●	1	10.4	10.8	11.5	12.5
CRN2XLBR0030N100S06	0.3	0.6	0.6	10	0.56	7.8°	50	6	2	●	1	10.4	10.8	11.5	12.5
CRN2XLBR0040N020S04	0.4	0.8	0.8	2	0.76	11.7°	50	4	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0040N020S06	0.4	0.8	0.8	2	0.76	12.8°	50	6	2	●	1	2.1	2.2	2.3	2.5
CRN2XLBR0040N040S04	0.4	0.8	0.8	4	0.76	9.4°	50	4	2	●	1	4.2	4.3	4.6	5.0
CRN2XLBR0040N040S06	0.4	0.8	0.8	4	0.76	11°	50	6	2	●	1	4.2	4.3	4.6	5.0
CRN2XLBR0040N060S04	0.4	0.8	0.8	6	0.76	7.8°	50	4	2	●	1	6.3	6.5	6.9	7.5
CRN2XLBR0040N060S06	0.4	0.8	0.8	6	0.76	9.6°	50	6	2	●	1	6.3	6.5	6.9	7.5
CRN2XLBR0040N080S04	0.4	0.8	0.8	8	0.76	6.7°	50	4	2	●	1	8.3	8.6	9.2	10.0
CRN2XLBR0040N080S06	0.4	0.8	0.8	8	0.76	8.5°	50	6	2	●	1	8.3	8.6	9.2	10.0
CRN2XLBR0040N100S04	0.4	0.8	0.8	10	0.76	5.9°	50	4	2	●	1	10.4	10.8	11.5	12.4
CRN2XLBR0040N100S06	0.4	0.8	0.8	10	0.76	7.7°	50	6	2	●	1	10.4	10.8	11.5	12.4
CRN2XLBR0050N030S04	0.5	1	1	3	0.94	10.1°	50	4	2	●	1	3.2	3.3	3.6	3.9
CRN2XLBR0050N030S06	0.5	1	1	3	0.94	11.6°	50	6	2	●	1	3.2	3.3	3.6	3.9
CRN2XLBR0050N040S04	0.5	1	1	4	0.94	9.1°	50	4	2	●	1	4.2	4.4	4.8	5.2
CRN2XLBR0050N040S06	0.5	1	1	4	0.94	10.8°	50	6	2	●	1	4.2	4.4	4.8	5.2
CRN2XLBR0050N050S04	0.5	1	1	5	0.94	8.2°	50	4	2	●	1	5.3	5.5	6.0	6.4
CRN2XLBR0050N050S06	0.5	1	1	5	0.94	10.1°	50	6	2	●	1	5.3	5.5	6.0	6.4
CRN2XLBR0050N060S04	0.5	1	1	6	0.94	7.5°	50	4	2	●	1	6.3	6.6	7.1	7.7
CRN2XLBR0050N060S06	0.5	1	1	6	0.94	9.4°	50	6	2	●	1	6.3	6.6	7.1	7.7
CRN2XLBR0050N070S04	0.5	1	1	7	0.94	6.9°	50	4	2	●	1	7.4	7.7	8.3	8.9
CRN2XLBR0050N070S06	0.5	1	1	7	0.94	8.8°	50	6	2	●	1	7.4	7.7	8.3	8.9
CRN2XLBR0050N080S04	0.5	1	1	8	0.94	6.4°	50	4	2	●	1	8.4	8.8	9.4	10.2
CRN2XLBR0050N080S06	0.5	1	1	8	0.94	8.3°	50	6	2	●	1	8.4	8.8	9.4	10.2
CRN2XLBR0050N100S04	0.5	1	1	10	0.94	5.6°	50	4	2	●	1	10.5	10.9	11.7	12.6
CRN2XLBR0050N100S06	0.5	1	1	10	0.94	7.5°	50	6	2	●	1	10.5	10.9	11.7	12.6
CRN2XLBR0050N120S04	0.5	1	1	12	0.94	5°	50	4	2	●	1	12.6	13.1	14.0	15.1
CRN2XLBR0050N120S06	0.5	1	1	12	0.94	6.8°	50	6	2	●	1	12.6	13.1	14.0	15.1
CRN2XLBR0050N140S04	0.5	1	1	14	0.94	4.5°	50	4	2	●	1	14.7	15.2	16.3	17.6
CRN2XLBR0050N140S06	0.5	1	1	14	0.94	6.2°	55	6	2	●	1	14.7	15.2	16.3	17.6
CRN2XLBR0050N160S04	0.5	1	1	16	0.94	4.1°	55	4	2	●	1	16.8	17.4	18.6	20.1
CRN2XLBR0050N160S06	0.5	1	1	16	0.94	5.7°	55	6	2	●	1	16.8	17.4	18.6	20.1
CRN2XLBR0050N180S04	0.5	1	1	18	0.94	3.7°	55	4	2	●	1	18.9	19.5	20.9	22.6
CRN2XLBR0050N180S06	0.5	1	1	18	0.94	5.3°	60	6	2	●	1	18.9	19.5	20.9	22.6
CRN2XLBR0050N200S04	0.5	1	1	20	0.94	3.4°	55	4	2	●	1	20.9	21.6	23.2	25.1
CRN2XLBR0050N200S06	0.5	1	1	20	0.94	5°	60	6	2	●	1	20.9	21.6	23.2	25.1
CRN2XLBR0075N080S04	0.75	1.5	1.5	8	1.44	5.9°	50	4	2	●	1	8.4	8.8	9.4	10.1
CRN2XLBR0075N080S06	0.75	1.5	1.5	8	1.44	8.1°	50	6	2	●	1	8.4	8.8	9.4	10.1
CRN2XLBR0075N100S04	0.75	1.5	1.5	10	1.44	5.1°	50	4	2	●	1	10.5	10.9	11.7	12.6
CRN2XLBR0075N100S06	0.75	1.5	1.5	10	1.44	7.2°	50	6	2	●	1	10.5	10.9	11.7	12.6
CRN2XLBR0075N120S04	0.75	1.5	1.5	12	1.44	4.4°	50	4	2	●	1	12.6	13.1	14.0	15.1
CRN2XLBR0075N120S06	0.75	1.5	1.5	12	1.44	6.5°	50	6	2	●	1	12.6	13.1	14.0	15.1
CRN2XLBR0075N140S04	0.75	1.5	1.5	14	1.44	4°	50	4	2	●	1	14.7	15.2	16.3	17.6
CRN2XLBR0075N140S06	0.75	1.5	1.5	14	1.44	5.9°	55	6	2	●	1	14.7	15.2	16.3	17.6

CRN2XLB

Ball nose, Medium cut length, 2 flute, Long neck, For copper electrodes

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
CRN2XLBR0075N160S04	0.75	1.5	1.5	16	1.44	3.6°	55	4	2	●	1	16.8	17.3	18.6	20.0
CRN2XLBR0075N160S06	0.75	1.5	1.5	16	1.44	5.4°	55	6	2	●	1	16.8	17.3	18.6	20.0
CRN2XLBR0075N180S04	0.75	1.5	1.5	18	1.44	3.3°	55	4	2	●	1	18.8	19.5	20.9	22.5
CRN2XLBR0075N180S06	0.75	1.5	1.5	18	1.44	5°	60	6	2	●	1	18.8	19.5	20.9	22.5
CRN2XLBR0075N200S04	0.75	1.5	1.5	20	1.44	3°	55	4	2	●	1	20.9	21.6	23.2	*
CRN2XLBR0075N200S06	0.75	1.5	1.5	20	1.44	4.6°	60	6	2	●	1	20.9	21.6	23.2	25.0
CRN2XLBR0100N080S04	1	2	2	8	1.90	5.3°	50	4	2	●	1	8.3	8.7	9.2	9.9
CRN2XLBR0100N080S06	1	2	2	8	1.90	7.8°	50	6	2	●	1	8.3	8.7	9.2	9.9
CRN2XLBR0100N100S04	1	2	2	10	1.90	4.5°	50	4	2	●	1	10.4	10.8	11.5	12.4
CRN2XLBR0100N100S06	1	2	2	10	1.90	6.9°	50	6	2	●	1	10.4	10.8	11.5	12.4
CRN2XLBR0100N120S04	1	2	2	12	1.90	3.9°	50	4	2	●	1	12.5	12.9	13.8	14.9
CRN2XLBR0100N120S06	1	2	2	12	1.90	6.1°	50	6	2	●	1	12.5	12.9	13.8	14.9
CRN2XLBR0100N140S04	1	2	2	14	1.90	3.4°	50	4	2	●	1	14.6	15.1	16.1	17.4
CRN2XLBR0100N140S06	1	2	2	14	1.90	5.6°	55	6	2	●	1	14.6	15.1	16.1	17.4
CRN2XLBR0100N160S04	1	2	2	16	1.90	3.1°	55	4	2	●	1	16.7	17.2	18.4	19.9
CRN2XLBR0100N160S06	1	2	2	16	1.90	5.1°	55	6	2	●	1	16.7	17.2	18.4	19.9
CRN2XLBR0100N200S04	1	2	2	20	1.90	2.5°	60	4	2	●	1	20.8	21.5	23.0	*
CRN2XLBR0100N200S06	1	2	2	20	1.90	4.3°	60	6	2	●	1	20.8	21.5	23.0	24.8
CRN2XLBR0100N250S06	1	2	2	25	1.90	3.7°	65	6	2	●	1	26.0	26.8	28.8	31.0
CRN2XLBR0100N300S06	1	2	2	30	1.90	3.2°	70	6	2	●	1	31.1	32.2	34.5	37.3
CRN2XLBR0150N160S06	1.5	3	3	16	2.90	4.3°	60	6	2	●	1	16.6	17.2	18.4	19.7
CRN2XLBR0150N250S06	1.5	3	3	25	2.90	3°	70	6	2	●	1	26.0	26.8	28.7	*
CRN2XLBR0150N350S06	1.5	3	3	35	2.90	2.2°	80	6	2	●	1	36.3	37.5	40.2	*
CRN2XLBR0200N160S06	2	4	4	16	3.90	3.2°	70	6	2	●	1	16.6	17.1	18.3	19.6
CRN2XLBR0200N200S06	2	4	4	20	3.90	2.7°	70	6	2	●	1	20.8	21.4	22.9	*
CRN2XLBR0200N300S06	2	4	4	30	3.90	1.8°	70	6	2	●	1	31.1	32.1	*	*
CRN2XLBR0200N400S06	2	4	4	40	3.90	1.4°	90	6	2	●	1	41.4	42.8	*	*
CRN2XLBR0200N500S06	2	4	4	50	3.90	1.2°	100	6	2	●	1	51.8	53.5	*	*
CRN2XLBR0250N200S06	2.5	5	5	20	4.90	1.5°	70	6	2	●	1	20.7	21.4	*	*
CRN2XLBR0250N300S06	2.5	5	5	30	4.90	1°	80	6	2	●	1	31.1	*	*	*
CRN2XLBR0300N300S06	3	6	6	30	5.85	—	80	6	2	●	2	*	*	*	*
CRN2XLBR0300N500S06	3	6	6	50	5.85	—	100	6	2	●	2	*	*	*	*

* No interference

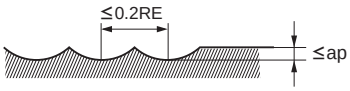
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Copper, Copper alloys		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap(mm)
R0.1	0.5	40000	800	0.003
	1.0	40000	600	0.002
	1.5	40000	400	0.001
R0.15	1	40000	1200	0.007
	2	40000	800	0.003
R0.2	1	40000	2000	0.015
	2	40000	1300	0.01
	3	40000	800	0.005
R0.25	2	40000	2000	0.02
	4	40000	1200	0.01
	6	36000	600	0.006
	10	26000	200	0.002
R0.3	2	40000	3200	0.03
	6	40000	1200	0.008
	10	30000	500	0.003
R0.4	4	40000	4000	0.02
	6	40000	2500	0.02
	10	30000	700	0.008
R0.5	4	40000	6400	0.05
	6	40000	4800	0.03
	8	40000	3000	0.02
	10	33000	2000	0.01
	16	18000	500	0.008
	20	13000	250	0.005

Work Material		Copper, Copper alloys		
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap(mm)
R0.75	8	40000	8000	0.07
	12	35000	4500	0.04
	16	20000	2000	0.03
	20	12000	900	0.02
R1	8	40000	9600	0.10
	10	40000	6400	0.08
	12	40000	6000	0.08
	16	30000	3000	0.05
	20	20000	2000	0.04
	30	10000	800	0.02
R1.5	16	40000	12000	0.10
	25	25000	6000	0.08
	35	6000	700	0.06
R2	16	32000	11000	0.15
	20	32000	9000	0.15
	30	20000	4500	0.10
	40	15000	3000	0.08
	50	8000	1000	0.05
R2.5	20	25000	9500	0.20
	30	20000	3300	0.15
R3	30	21000	8400	0.20
	50	20000	3000	0.15

Depth of cut



RE:Radius

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

CBN2XLB

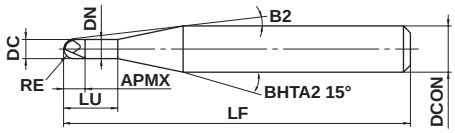
Ball nose, Short cut length, 2 flute, Long neck

TOOL NEWS

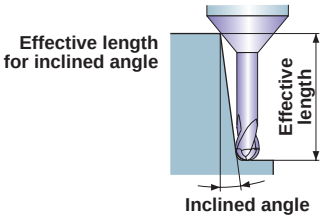
CBN

γ 0°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	◎	◎	◎				



Type1



0.2≤RE≤1				
±0.005				
4≤DCON≤6				
0 - 0.005				

h5

●Solid CBN ball nose. A wide variation of neck lengths available.

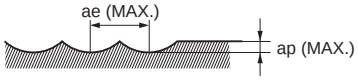
(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
CBN2XLBR0020N010S04	0.2	0.4	0.3	1	0.36	13.4°	51	4	2	●	1	1	1	1.1	1.2
CBN2XLBR0020N010S06	0.2	0.4	0.3	1	0.36	13.9°	51	6	2	●	1	1	1	1.1	1.2
CBN2XLBR0020N016S04	0.2	0.4	0.3	1.6	0.36	12.4°	51	4	2	●	1	1.6	1.7	1.8	2
CBN2XLBR0020N016S06	0.2	0.4	0.3	1.6	0.36	13.3°	51	6	2	●	1	1.6	1.7	1.8	2
⁎CBN2XLBR0030N009S06	0.3	0.6	0.4	0.9	0.56	14.1°	62	6	2	●	1	0.9	0.9	1	1.1
CBN2XLBR0030N015S04	0.3	0.6	0.5	1.5	0.56	12.6°	51	4	2	●	1	1.5	1.6	1.7	1.8
CBN2XLBR0030N015S06	0.3	0.6	0.5	1.5	0.56	13.4°	51	6	2	●	1	1.5	1.6	1.7	1.8
CBN2XLBR0030N024S04	0.3	0.6	0.5	2.4	0.56	11.3°	51	4	2	●	1	2.5	2.6	2.7	2.9
CBN2XLBR0030N024S06	0.3	0.6	0.5	2.4	0.56	12.5°	51	6	2	●	1	2.5	2.6	2.7	2.9
⁎CBN2XLBR0040N010S06	0.4	0.8	0.5	1	0.76	14.1°	62	6	2	●	1	1	1	1.1	1.2
CBN2XLBR0040N020S04	0.4	0.8	0.6	2	0.76	11.8°	51	4	2	●	1	2	2.1	2.3	2.4
CBN2XLBR0040N020S06	0.4	0.8	0.6	2	0.76	12.9°	51	6	2	●	1	2	2.1	2.3	2.4
CBN2XLBR0040N032S04	0.4	0.8	0.6	3.2	0.76	10.3°	51	4	2	●	1	3.3	3.4	3.6	3.9
CBN2XLBR0040N032S06	0.4	0.8	0.6	3.2	0.76	11.7°	51	6	2	●	1	3.3	3.4	3.6	3.9
⁎CBN2XLBR0050N011S06	0.5	1	0.6	1.1	0.94	14.1°	62	6	2	●	1	1.1	1.1	1.2	1.2
CBN2XLBR0050N025S04	0.5	1	0.8	2.5	0.94	11°	51	4	2	●	1	2.6	2.7	2.8	3
CBN2XLBR0050N025S06	0.5	1	0.8	2.5	0.94	12.3°	51	6	2	●	1	2.6	2.7	2.8	3
CBN2XLBR0050N040S04	0.5	1	0.8	4	0.94	9.3°	51	4	2	●	1	4.1	4.3	4.6	4.9
CBN2XLBR0050N040S06	0.5	1	0.8	4	0.94	11°	51	6	2	●	1	4.1	4.3	4.6	4.9
CBN2XLBR0075N038S04	0.75	1.5	1.1	3.8	1.44	9.1°	52	4	2	●	1	3.9	4.1	4.3	4.6
CBN2XLBR0075N038S06	0.75	1.5	1.1	3.8	1.44	11°	52	6	2	●	1	3.9	4.1	4.3	4.6
CBN2XLBR0075N060S04	0.75	1.5	1.1	6	1.44	7.1°	52	4	2	●	1	6.2	6.4	6.8	7.3
CBN2XLBR0075N060S06	0.75	1.5	1.1	6	1.44	9.3°	52	6	2	●	1	6.2	6.4	6.8	7.3
⁎CBN2XLBR0100N017S06	1	2	1.2	1.7	1.9	13.6°	62	6	2	●	1	1.7	1.7	1.8	1.9
CBN2XLBR0100N050S04	1	2	1.5	5	1.9	7.3°	52	4	2	●	1	5.1	5.3	5.6	6
CBN2XLBR0100N050S06	1	2	1.5	5	1.9	9.8°	52	6	2	●	1	5.1	5.3	5.6	6
CBN2XLBR0100N080S04	1	2	1.5	8	1.9	5.3°	52	4	2	●	1	8.2	8.5	9	9.7
CBN2XLBR0100N080S06	1	2	1.5	8	1.9	7.9°	52	6	2	●	1	8.2	8.5	9	9.7

⁎ Designed with short cutting edge and neck lengths for high rigidity.

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2				Hardened steel (62−70HRC) AISI W1, AISI M2			
R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.2	50000	1500	0.006	0.01	50000	1200	0.006	0.01	50000	1200	0.004	0.008
R0.3	50000	2000	0.01	0.02	50000	1500	0.01	0.02	50000	1500	0.008	0.015
R0.4	50000	3000	0.02	0.05	50000	2000	0.02	0.04	50000	2000	0.015	0.03
R0.5	50000	3000	0.03	0.06	50000	2000	0.03	0.05	50000	2000	0.02	0.03
R0.75	50000	3500	0.04	0.08	50000	2500	0.03	0.06	50000	2500	0.02	0.04
R1	50000	4000	0.05	0.1	50000	3000	0.04	0.07	50000	3000	0.03	0.05
Depth of cut												

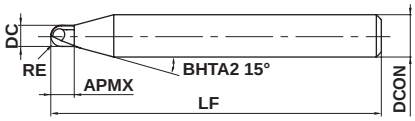
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Oil mist coolant is recommended.
Note 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

DC2SB

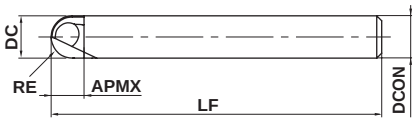
Ball nose, Short cut length, 2 flute, For hard brittle materials

TOOL NEWS

Cemented carbide	Alumina Zirconia	Silicon carbide Silicon nitride	Quartz glass
◎	○	○	○



Type1



Type2

0.1≤RE≤3				
±0.01				
4≤DCON≤6				
0 / - 0.008				

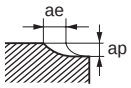
●Suitable DC ball end mill for cemented carbide and other hard brittle materials processing.

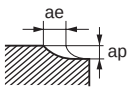
(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DC2SBR0010	0.1	0.2	0.12	50	4	2	●	1
DC2SBR0020	0.2	0.4	0.24	50	4	2	●	1
DC2SBR0030	0.3	0.6	0.42	50	4	2	●	1
DC2SBR0040	0.4	0.8	0.56	50	4	2	●	1
DC2SBR0050	0.5	1	0.7	50	4	2	●	1
DC2SBR0075	0.75	1.5	1	50	4	2	●	1
DC2SBR0100	1	2	1.4	50	4	2	●	1
DC2SBR0150	1.5	3	2.1	60	6	2	●	1
DC2SBR0200	2	4	2.8	60	6	2	●	1
DC2SBR0250	2.5	5	3.5	60	6	2	●	1
DC2SBR0300	3	6	4.2	60	6	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Cemented carbide				Alumina Zirconia			
Dia. **DC** (mm)	R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.1	30000	100	0.01	0.01	30000	100	0.01	0.01
0.4	0.2	30000	150	0.02	0.08	30000	150	0.02	0.08
0.6	0.3	30000	200	0.03	0.14	30000	200	0.03	0.14
0.8	0.4	30000	250	0.04	0.19	30000	250	0.04	0.19
1	0.5	30000	300	0.05	0.25	30000	300	0.05	0.25
1.5	0.75	30000	300	0.075	0.275	30000	300	0.075	0.275
2	1	30000	300	0.1	0.3	30000	300	0.1	0.3
3	1.5	27500	275	0.125	0.33	27500	275	0.125	0.33
4	2	24000	240	0.15	0.35	24000	240	0.15	0.35
5	2.5	22000	220	0.175	0.37	22000	220	0.175	0.37
6	3	20000	200	0.2	0.4	20000	200	0.2	0.4
Depth of cut									

Work Material		Silicon carbide Silicon nitride				Quartz glass			
Dia. **DC** (mm)	R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.1	30000	50	0.005	0.005	30000	150	0.015	0.015
0.4	0.2	30000	75	0.01	0.04	30000	225	0.03	0.12
0.6	0.3	30000	100	0.015	0.07	30000	300	0.045	0.21
0.8	0.4	30000	125	0.02	0.095	30000	375	0.06	0.285
1	0.5	30000	150	0.025	0.125	30000	450	0.075	0.375
1.5	0.75	30000	150	0.038	0.138	30000	450	0.113	0.413
2	1	30000	150	0.05	0.15	30000	450	0.15	0.45
3	1.5	27500	138	0.063	0.165	27500	413	0.188	0.495
4	2	24000	120	0.075	0.175	24000	360	0.225	0.525
5	2.5	22000	110	0.088	0.185	22000	330	0.263	0.555
6	3	20000	100	0.1	0.2	20000	300	0.3	0.6
Depth of cut									

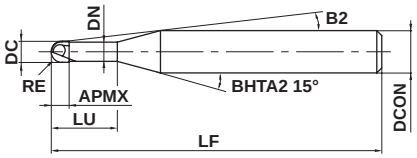
Note 1) The cemented carbide in the above mentioned cutting conditions table is based on CIS standard VM-40(90HRA).
Note 2) Air blow or dry machining is recommended with cemented carbide machining.
*Note: Using coolants or oil mists may decrease tool longevity.
Note 3) The use of a water soluble cutting oil is recommended with the processing of hard brittle materials other than the cemented carbide mentioned in the above table. Be sure to refuel the oil and eliminate any chip discharge that adheres to the tool.
Note 4) Cutting conditions may need adjustments depending on the type of work material.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 6) Implementation of special counter measures is recommended since fine chip discharge may enter gaps in the processing machinery.

DC2XLB

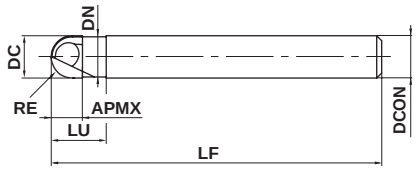
Ball nose, Short cut length, 2 flute, For hard brittle materials

TOOL NEWS

Cemented carbide	Alumina Zirconia	Silicon carbide Silicon nitride	Quartz glass
◎	○	○	○



Type1



Type2

0.1≤RE≤3				
±0.01				
4≤DCON≤6				
0 - 0.008				

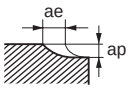
●Suitable DC long neck ball end mill for cemented carbide and other hard brittle materials processing.

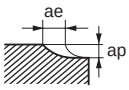
(mm)

Order Number	RE	DC	APMX	LU	DN	LF	B2	DCON	No. of Flutes	Stock	Type
DC2XLBR0010N005	0.1	0.2	0.12	0.5	0.18	50	11.5°	4	2	●	1
DC2XLBR0020N010	0.2	0.4	0.24	1	0.36	50	11°	4	2	●	1
DC2XLBR0030N015	0.3	0.6	0.36	1.5	0.56	50	10.4°	4	2	●	1
DC2XLBR0040N020	0.4	0.8	0.48	2	0.76	50	9.9	4	2	●	1
DC2XLBR0050N025	0.5	1	0.6	2.5	0.96	50	9.2	4	2	●	1
DC2XLBR0050N050	0.5	1	0.6	5	0.96	50	7.3°	4	2	●	1
DC2XLBR0075N038	0.75	1.5	0.9	3.8	1.44	50	7.8°	4	2	●	1
DC2XLBR0100N060	1	2	1.2	6	1.94	50	5.8°	4	2	●	1
DC2XLBR0100N100	1	2	1.2	10	1.94	50	4.2°	4	2	●	1
DC2XLBR0150N080	1.5	3	1.8	8	2.9	60	6.3°	6	2	●	1
DC2XLBR0200N100	2	4	2.4	10	3.9	60	4.5°	6	2	●	1
DC2XLBR0250N100	2.5	5	3	10	4.9	60	2.9°	6	2	●	1
DC2XLBR0300N100	3	6	3.6	10	5.85	60	—	6	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Cemented carbide				Alumina Zirconia			
Dia. **DC** (mm)	R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.1	0.5	30000	30	0.005	0.01	30000	30	0.005	0.01
0.4	0.2	1	30000	100	0.015	0.08	30000	100	0.015	0.08
0.6	0.3	1.5	30000	200	0.03	0.14	30000	200	0.03	0.14
0.8	0.4	2	30000	250	0.04	0.19	30000	250	0.04	0.19
1	0.5	2.5	30000	300	0.05	0.25	30000	300	0.05	0.25
1	0.5	5	30000	300	0.05	0.25	30000	300	0.05	0.25
1.5	0.75	3.8	30000	300	0.075	0.275	30000	300	0.075	0.275
2	1	6	30000	300	0.1	0.3	30000	300	0.1	0.3
2	1	10	30000	300	0.1	0.3	30000	300	0.1	0.3
3	1.5	8	27500	275	0.125	0.33	27500	275	0.125	0.33
4	2	10	24000	240	0.15	0.35	24000	240	0.15	0.35
5	2.5	10	22000	220	0.175	0.37	22000	220	0.175	0.37
6	3	10	20000	200	0.2	0.4	20000	200	0.2	0.4
Depth of cut										

Work Material			Silicon carbide Silicon nitride				Quartz glass			
Dia. **DC** (mm)	R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.1	0.5	30000	15	0.003	0.005	30000	45	0.008	0.015
0.4	0.2	1	30000	50	0.008	0.04	30000	150	0.023	0.12
0.6	0.3	1.5	30000	100	0.015	0.07	30000	300	0.045	0.21
0.8	0.4	2	30000	125	0.02	0.095	30000	375	0.06	0.285
1	0.5	2.5	30000	150	0.025	0.125	30000	450	0.075	0.375
1	0.5	5	30000	150	0.025	0.125	30000	450	0.075	0.375
1.5	0.75	3.8	30000	150	0.038	0.138	30000	450	0.113	0.413
2	1	6	30000	150	0.05	0.15	30000	450	0.15	0.45
2	1	10	30000	150	0.05	0.15	30000	450	0.15	0.45
3	1.5	8	27500	138	0.063	0.165	27500	413	0.188	0.495
4	2	10	24000	120	0.075	0.175	24000	360	0.225	0.525
5	2.5	10	22000	110	0.088	0.185	22000	330	0.263	0.555
6	3	10	20000	100	0.1	0.2	20000	300	0.3	0.6
Depth of cut										

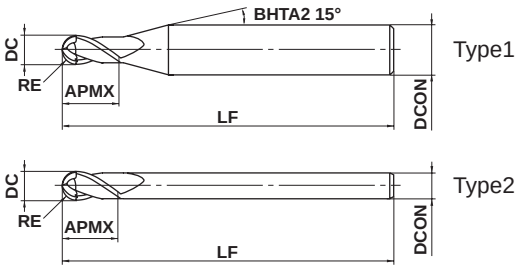
Note 1) The cemented carbide in the above mentioned cutting conditions table is based on CIS standard VM-40(90HRA).
Note 2) Air blow or dry machining is recommended with cemented carbide machining.
*Note: Using coolants or oil mists may decrease tool longevity.
Note 3) The use of a water soluble cutting oil is recommended with the processing of hard brittle materials other than the cemented carbide mentioned in the above table. Be sure to refuel the oil and eliminate any chip discharge that adheres to the tool.
Note 4) Cutting conditions may need adjustments depending on the type of work material.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 6) Implementation of special counter measures is recommended since fine chip discharge may enter gaps in the processing machinery.

DLC2MB

Ball nose, Medium cut length, 2 flute

TOOL NEWS

Copper Alloy	Aluminium Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎		○	



RE≤6	RE>6			
±0.01	±0.02			
DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

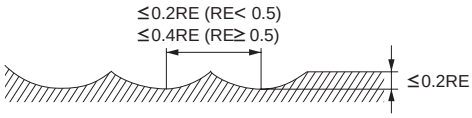
●2 flute ball nose end mill with new high welding resistance DLC coating, ideal for machining non-ferrous materials.

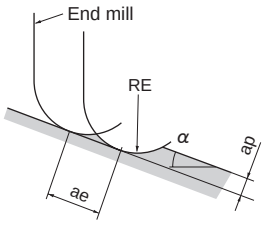
(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DLC2MBR0010	0.1	0.2	0.4	40	4	2	●	1
DLC2MBR0015	0.15	0.3	0.6	40	4	2	●	1
DLC2MBR0020	0.2	0.4	0.8	40	4	2	●	1
DLC2MBR0025	0.25	0.5	1	40	4	2	●	1
DLC2MBR0030	0.3	0.6	1.2	40	4	2	●	1
DLC2MBR0040	0.4	0.8	1.6	40	4	2	●	1
DLC2MBR0050	0.5	1	2.5	40	4	2	●	1
DLC2MBR0075	0.75	1.5	4	40	4	2	●	1
DLC2MBR0100	1	2	6	60	6	2	●	1
DLC2MBR0125	1.25	2.5	6	60	6	2	●	1
DLC2MBR0150	1.5	3	8	70	6	2	●	1
DLC2MBR0200	2	4	8	70	6	2	●	1
DLC2MBR0250	2.5	5	12	80	6	2	●	1
DLC2MBR0300	3	6	12	80	6	2	●	2
DLC2MBR0400	4	8	14	90	8	2	●	2
DLC2MBR0500	5	10	18	100	10	2	●	2
DLC2MBR0600	6	12	22	110	12	2	●	2
DLC2MBR0800	8	16	30	140	16	2	●	2
DLC2MBR1000	10	20	38	160	20	2	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Aluminium alloy				Aluminium alloy casting, Copper, Copper alloys			
R **RE** (mm)	α≤15°		α>15°		α≤15°		α>15°	
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
R 0.1	40000	350	40000	260	40000	280	40000	210
R 0.15	40000	480	40000	360	40000	380	40000	290
R 0.2	40000	600	40000	450	40000	480	40000	360
R 0.25	40000	800	40000	600	40000	640	40000	480
R 0.3	40000	1000	40000	750	40000	800	40000	600
R 0.4	40000	1500	40000	1100	40000	1200	40000	880
R 0.5	40000	2000	40000	1500	40000	1600	40000	1200
R 0.75	40000	2200	40000	1600	40000	1800	40000	1300
R 1	40000	2800	40000	2200	40000	2200	32000	1400
R 1.25	40000	3200	38000	2200	32000	2000	30000	1400
R 1.5	40000	4000	32000	2600	32000	2600	26000	1700
R 2	30000	4200	24000	2800	24000	2700	19000	1800
R 2.5	24000	4400	19000	2800	19000	2800	15000	1800
R 3	20000	4000	16000	2800	16000	2600	13000	1800
R 4	15000	3600	12000	2400	12000	2300	9600	1500
R 5	12000	3600	9500	2000	9600	2300	7600	1300
R 6	10000	3200	8000	2200	8000	2000	6400	1400
R 8	7500	2800	6000	1800	6000	1800	4800	1200
R10	6000	2500	4800	1600	4800	1600	3800	1000
Depth of cut	 RE:Radius							



ae:Pick Feed

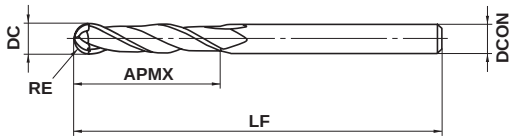
Note 1) α is the inclination angle of the machined surface.
Note 2) When cutting a very hard workpiece, reduce the feed rate.
Note 3) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

DF2MB

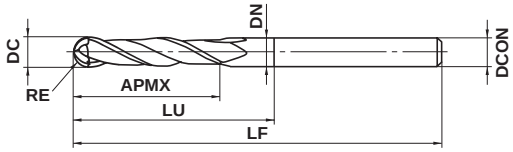
Ball nose, Medium cut length, 2 flute, For graphite

TOOL NEWS

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○



Type1



Type2

3≤RE≤6				
±0.01				
DCON=6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

●2 flute ball nose end mill with original diamond coating for graphite machining.

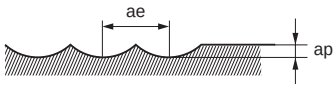
(mm)

Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
DF2MBR0300	3	6	30	—	—	100	6	2	●	1
DF2MBR0300A100	3	6	30	50	5.85	100	6	2	●	2
DF2MBR0300A150	3	6	30	50	5.85	150	6	2	●	2
DF2MBR0300N100A150	3	6	30	100	5.85	150	6	2	●	2
DF2MBR0400A110	4	8	40	60	7.85	110	8	2	●	2
DF2MBR0400A150	4	8	40	60	7.85	150	8	2	●	2
DF2MBR0500A120	5	10	50	70	9.7	120	10	2	●	2
DF2MBR0500A180	5	10	50	70	9.7	180	10	2	●	2
DF2MBR0500N140A180	5	10	50	140	9.7	180	10	2	●	2
DF2MBR0600A130	6	12	55	75	11.7	130	12	2	●	2
DF2MBR0600A200	6	12	55	75	11.7	200	12	2	●	2
DF2MBR0600N150A200	6	12	55	150	11.7	200	12	2	●	2

(Effective Coating Length : 1-1.5DC)

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Graphite				Copper, Copper alloys			
R **RE** (mm)	Overall Length **LF** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R3	100	16000	1900	0.6	1.5	16000	1500	0.6	1.5
	150	12000	1200	0.4	1.2	12000	960	0.4	1.2
R4	110	12000	2000	0.8	2.0	12000	1600	0.8	2.0
	150	9200	1400	0.6	1.6	9200	1100	0.6	1.6
R5	120	9500	2200	1.0	2.5	9500	1800	1.0	2.5
	180	7300	1500	0.8	2.0	7300	1200	0.8	2.0
R6	130	8000	1800	1.2	3.0	8000	1400	1.2	3.0
	200	6100	1200	1.0	2.5	6100	960	1.0	2.5
Depth of cut									

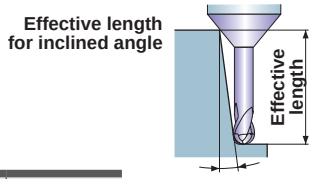
Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

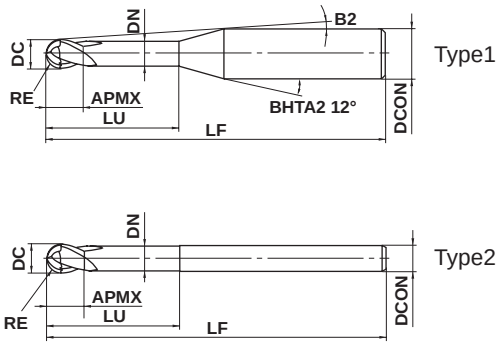
DF2XLB

Ball nose, Medium cut length, 2 flute, Long neck, For graphite

TOOL NEWS

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○





0.1≤RE≤3				
±0.01				
DCON=4,6				
0 / - 0.008				

●2 flute long neck ball nose end mill with Mitsubishi's unique diamond coating for graphite machining.

(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
DF2XLBR0010N005	0.1	0.2	0.2	0.5	0.18	11.5°	50	4	2	●	1	0.5	0.5	0.6	0.7
DF2XLBR0015N020	0.15	0.3	0.3	2	0.27	9.9°	50	4	2	●	1	2.1	2.2	2.4	2.6
DF2XLBR0015N030	0.15	0.3	0.3	3	0.27	9.1°	50	4	2	●	1	3.1	3.2	3.6	3.9
DF2XLBR0020N010	0.2	0.4	0.6	1	0.36	11°	50	4	2	●	1	1.0	1.0	1.1	1.2
DF2XLBR0020N020	0.2	0.4	0.6	2	0.36	10°	50	4	2	●	1	2.0	2.1	2.3	2.6
DF2XLBR0020N030	0.2	0.4	0.6	3	0.36	9.1°	50	4	2	●	1	3.1	3.2	3.5	3.9
DF2XLBR0020N040	0.2	0.4	0.6	4	0.36	8.4°	60	4	2	●	1	4.1	4.3	4.7	5.2
DF2XLBR0020N080	0.2	0.4	0.6	8	0.36	6.4°	60	4	2	●	1	8.3	8.7	9.5	10.5
DF2XLBR0020N120	0.2	0.4	0.6	12	0.36	5.1°	60	4	2	●	1	12.5	13.0	14.3	15.8
DF2XLBR0025N040	0.25	0.5	0.6	4	0.46	8.3°	60	4	2	●	1	4.1	4.3	4.7	5.2
DF2XLBR0025N050	0.25	0.5	0.6	5	0.46	7.7°	60	4	2	●	1	5.2	5.4	5.9	6.5
DF2XLBR0025N080	0.25	0.5	0.6	8	0.46	6.3°	60	4	2	●	1	8.3	8.7	9.5	10.5
DF2XLBR0030N020	0.3	0.6	0.9	2	0.56	9.9°	60	4	2	●	1	2.1	2.2	2.4	2.6
DF2XLBR0030N040	0.3	0.6	0.9	4	0.56	8.3°	60	4	2	●	1	4.2	4.4	4.8	5.2
DF2XLBR0030N050	0.3	0.6	0.9	5	0.56	7.6°	60	4	2	●	1	5.2	5.4	6.0	6.6
DF2XLBR0030N060	0.3	0.6	0.9	6	0.56	7.1°	60	4	2	●	1	6.3	6.5	7.1	7.9
DF2XLBR0030N080	0.3	0.6	0.9	8	0.56	6.2°	60	4	2	●	1	8.3	8.7	9.5	10.6
DF2XLBR0030N100	0.3	0.6	0.9	10	0.56	5.5°	60	4	2	●	1	10.4	10.9	11.9	13.2
DF2XLBR0030N160	0.3	0.6	0.9	16	0.56	4.1°	60	4	2	●	1	16.7	17.4	19.1	21.2
DF2XLBR0040N060	0.4	0.8	1.2	6	0.76	7°	60	4	2	●	1	6.3	6.5	7.1	7.9
DF2XLBR0040N080	0.4	0.8	1.2	8	0.76	6.1°	60	4	2	●	1	8.3	8.7	9.5	10.5
DF2XLBR0050N040	0.5	1	1.5	4	0.94	8°	60	4	2	●	1	4.2	4.4	4.8	5.3
DF2XLBR0050N060	0.5	1	1.5	6	0.94	6.8°	60	4	2	●	1	6.3	6.6	7.2	8.0
DF2XLBR0050N080	0.5	1	1.5	8	0.94	5.9°	60	4	2	●	1	8.4	8.8	9.6	10.6
DF2XLBR0050N100	0.5	1	1.5	10	0.94	5.2°	60	4	2	●	1	10.5	11.0	12.0	13.3
DF2XLBR0050N120	0.5	1	1.5	12	0.94	4.6°	60	4	2	●	1	12.6	13.2	14.4	15.9
NEW DF2XLBR0050N160	0.5	1	1.5	16	0.94	3.8°	80	4	2	●	1	16.8	17.5	19.2	21.3
DF2XLBR0050N200	0.5	1	1.5	20	0.94	3.3°	80	4	2	●	1	21.0	21.9	24.0	26.6
DF2XLBR0050N300	0.5	1	1.5	30	0.94	2.4°	80	4	2	●	1	31.4	32.8	36.0	*
DF2XLBR0050N400	0.5	1	1.5	40	0.94	1.9°	80	4	2	●	1	41.8	43.7	*	*
DF2XLBR0075N080	0.75	1.5	2.3	8	1.44	5.4°	60	4	2	●	1	8.4	8.8	9.6	10.6
DF2XLBR0075N100	0.75	1.5	2.3	10	1.44	4.7°	60	4	2	●	1	10.5	11.0	12.0	13.2
DF2XLBR0075N160	0.75	1.5	2.3	16	1.44	3.4°	80	4	2	●	1	16.8	17.5	19.2	21.2
NEW DF2XLBR0075N200	0.75	1.5	2.3	20	1.44	2.8°	80	4	2	●	1	21.0	21.9	23.9	26.5

* No interference

● : Inventory maintained in Japan.

(mm)

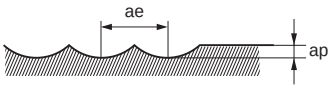
Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
DF2XLBR0075N300	0.75	1.5	2.3	30	1.44	2.1°	80	4	2	●	1	31.4	32.8	35.9	*
DF2XLBR0075N400	0.75	1.5	2.3	40	1.44	1.6°	80	4	2	●	1	41.8	43.7	*	*
DF2XLBR0100N080	1	2	3	8	1.9	4.9°	60	4	2	●	1	8.3	8.7	9.4	10.4
DF2XLBR0100N100	1	2	3	10	1.9	4.2°	60	4	2	●	1	10.4	10.9	11.8	13.0
DF2XLBR0100N120	1	2	3	12	1.9	3.7°	60	4	2	●	1	12.5	13.0	14.2	15.7
DF2XLBR0100N160	1	2	3	16	1.9	2.9°	80	4	2	●	1	16.7	17.4	19.0	*
DF2XLBR0100N200	1	2	3	20	1.9	2.5°	80	4	2	●	1	20.9	21.8	23.8	*
DF2XLBR0100N250	1	2	3	25	1.9	2°	80	4	2	●	1	26.1	27.2	*	*
DF2XLBR0100N400	1	2	3	40	1.9	1.4°	100	4	2	●	1	41.7	43.5	*	*
DF2XLBR0100N600	1	2	3	60	1.9	0.9°	100	4	2	●	1	62.6	*	*	*
DF2XLBR0150N160	1.5	3	4.5	16	2.9	1.7°	80	4	2	●	1	16.7	17.3	*	*
DF2XLBR0150N250	1.5	3	4.5	25	2.9	1.2°	80	4	2	●	1	26.1	27.2	*	*
DF2XLBR0150N400	1.5	3	4.5	40	2.9	0.7°	100	4	2	●	1	41.7	*	*	*
DF2XLBR0150N600	1.5	3	4.5	60	2.9	0.5°	100	4	2	●	1	*	*	*	*
DF2XLBR0200N080	2	4	6	8	3.9	–	80	4	2	●	2	*	*	*	*
DF2XLBR0200N200	2	4	6	20	3.9	–	80	4	2	●	2	*	*	*	*
DF2XLBR0200N300	2	4	6	30	3.9	–	80	4	2	●	2	*	*	*	*
DF2XLBR0200N400	2	4	6	40	3.9	–	100	4	2	●	2	*	*	*	*
DF2XLBR0200N600	2	4	6	60	3.9	–	100	4	2	●	2	*	*	*	*
DF2XLBR0300N120	3	6	9	12	5.85	–	100	6	2	●	2	*	*	*	*

* No interference

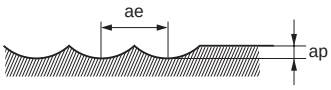
DF2XLB

Ball nose, Medium cut length, 2 flute, Long neck, For graphite

RECOMMENDED CUTTING CONDITIONS

Work Material		Graphite				Copper, Copper alloys			
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.1	0.5	40000	800	0.01	0.03	40000	800	0.003	0.02
R0.15	2	40000	1200	0.03	0.08	40000	800	0.003	0.03
	3	40000	1200	0.03	0.08	40000	600	0.002	0.03
R0.2	1	40000	1500	0.05	0.15	40000	2000	0.015	0.04
	2	40000	1500	0.05	0.12	40000	1300	0.01	0.04
	3	40000	1300	0.04	0.12	40000	800	0.005	0.04
	4	40000	1300	0.04	0.1	32000	600	0.004	0.04
	8	30000	800	0.03	0.1	—	—	—	—
	12	20000	450	0.03	0.08	—	—	—	—
R0.25	4	40000	1500	0.05	0.15	40000	800	0.01	0.05
	5	38000	1300	0.05	0.15	36000	700	0.008	0.05
	8	30000	1000	0.04	0.12	28000	500	0.002	0.05
R0.3	2	40000	1800	0.07	0.2	40000	1500	0.03	0.06
	4	40000	1500	0.06	0.18	40000	1200	0.02	0.06
	5	40000	1500	0.06	0.17	40000	1100	0.015	0.06
	6	40000	1500	0.06	0.15	40000	1000	0.008	0.06
	8	37000	1200	0.05	0.15	35000	800	0.005	0.06
	10	35000	1000	0.05	0.15	—	—	—	—
	16	22000	530	0.04	0.12	—	—	—	—
R0.4	6	40000	1700	0.08	0.2	40000	1500	0.02	0.08
	8	40000	1700	0.08	0.15	30000	1200	0.008	0.08
R0.5	4	40000	2500	0.12	0.3	40000	2000	0.05	0.1
	6	40000	2500	0.1	0.3	40000	2000	0.03	0.1
	8	40000	2000	0.1	0.25	40000	1800	0.02	0.1
	10	40000	2000	0.1	0.2	33000	1400	0.01	0.1
	12	40000	2000	0.1	0.2	30000	1000	0.007	0.1
	20	30000	1100	0.08	0.2	—	—	—	—
	30	20000	600	0.06	0.15	—	—	—	—
	40	15000	400	0.04	0.12	—	—	—	—
Depth of cut									

Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

Work Material		Graphite				Copper, Copper alloys			
R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.75	8	40000	2800	0.15	0.45	40000	2400	0.07	0.15
	10	40000	2800	0.15	0.45	32000	1800	0.05	0.15
	16	35000	2000	0.15	0.3	20000	900	0.03	0.15
	30	27000	1000	0.1	0.3	—	—	—	—
	40	21000	700	0.08	0.25	—	—	—	—
R1	8	40000	3000	0.23	0.7	40000	3000	0.1	0.2
	10	40000	3000	0.2	0.6	40000	2800	0.08	0.2
	12	35000	2500	0.2	0.6	35000	2300	0.08	0.2
	16	30000	2000	0.2	0.5	30000	1800	0.05	0.2
	20	30000	2000	0.2	0.5	20000	1200	0.04	0.2
	25	25000	1500	0.18	0.45	20000	1000	0.03	0.2
	40	20000	1000	0.15	0.4	—	—	—	—
	60	15000	500	0.1	0.3	—	—	—	—
R1.5	16	28000	3000	0.3	0.9	28000	3000	0.3	0.3
	25	20000	2000	0.25	0.75	20000	2000	0.25	0.3
	40	16000	1500	0.2	0.6	16000	1500	0.2	0.3
	60	14000	1000	0.17	0.45	—	—	—	—
R2	8	24000	3800	0.5	1.5	24000	3800	0.5	0.4
	20	21000	3300	0.5	1.5	21000	3300	0.4	0.4
	30	15000	2000	0.4	1.2	15000	2000	0.3	0.4
	40	13000	1600	0.35	1.0	13000	1600	0.25	0.4
	60	12000	1400	0.3	0.9	12000	1400	0.2	0.4
R3	12	17000	2800	0.6	2.0	17000	2800	0.6	0.6
Depth of cut									

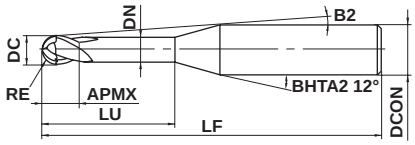
Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

DF2XLBF (For Finishing) NEW

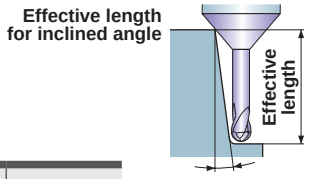
Ball nose, Medium cut length, 2 flute, Long neck, For graphite

TOOL NEWS

Aluminium Alloy	Copper Alloy	Graphite	Zirconia (Before Sintering)	Rigid Composite Resin (Composite Resin)	Machineable Ceramics
○	◎	◎	◎	◎	○



Type1



0.3≤RE≤1	1.5≤RE			
±0.005	±0.01			
DCON=4				
0 - 0.008				

h5

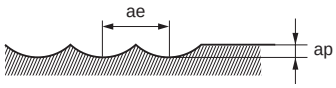
●DF long-neck ball end mills are ideal for finished surfaces of non-ferrous metals.

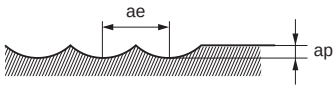
(mm)

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
DF2XLBFR0030N100	0.3	0.6	0.45	10	0.57	5.5°	50	4	2	●	1	10.4	10.9	11.9	13.2
DF2XLBFR0050N120	0.5	1	1.5	12	0.86	4.6°	50	4	2	●	1	12.6	13.2	14.4	15.9
DF2XLBFR0050N160	0.5	1	1.5	16	0.86	3.8°	50	4	2	●	1	16.8	17.5	19.2	21.3
DF2XLBFR0050N200	0.5	1	1.5	20	0.86	3.2°	50	4	2	●	1	21	21.9	24	26.6
DF2XLBFR0100N160	1	2	3	16	1.86	2.9°	50	4	2	●	1	16.7	17.4	19	*
DF2XLBFR0100N200	1	2	3	20	1.86	2.4°	50	4	2	●	1	20.9	21.8	23.9	*
DF2XLBFR0150N160	1.5	3	4.5	16	2.86	1.7°	50	4	2	●	1	16.7	17.3	18.9	20.8
DF2XLBFR0150N200	1.5	3	4.5	20	2.86	1.4°	50	4	2	●	1	20.8	21.7	23.7	26.1

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Graphite				Zirconia (Before Sintering)			
Dia. **DC** (mm)	R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.6	R0.3	10	35000	1000	0.05	0.015	26000	600	0.06	0.03
1	R0.5	10	40000	2000	0.10	0.200	26000	600	0.10	0.05
		16	35000	1500	0.09	0.200	26000	600	0.08	0.04
		20	30000	1100	0.08	0.200	26000	600	0.08	0.04
2	R1	16	30000	2000	0.20	0.500	18000	1400	0.06	0.80
		20	30000	2000	0.20	0.500	18000	1200	0.50	0.60
3	R1.5	16	28000	3000	0.30	0.900	15000	1600	0.90	0.90
		20	25000	2500	0.20	0.900	15000	1400	0.60	0.80
Depth of cut										

Work Material			Copper, Copper alloys				Rigid Composite Resin (Composite Resin)			
Dia. **DC** (mm)	R **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.6	R0.3	10	30000	600	0.005	0.040	28000	450	0.050	0.050
1	R0.5	10	33000	1400	0.010	0.100	25000	900	0.100	0.100
		16	25000	800	0.007	0.080	25000	700	0.080	0.080
		20	20000	500	0.005	0.050	25000	600	0.080	0.080
2	R1	16	30000	1800	0.050	0.200	25000	2100	0.800	0.800
		20	20000	1200	0.040	0.200	25000	1800	0.500	0.500
3	R1.5	16	28000	3000	0.300	0.300	25000	2400	1.000	1.000
		20	25000	2500	0.200	0.300	25000	2100	0.800	0.800
Depth of cut										

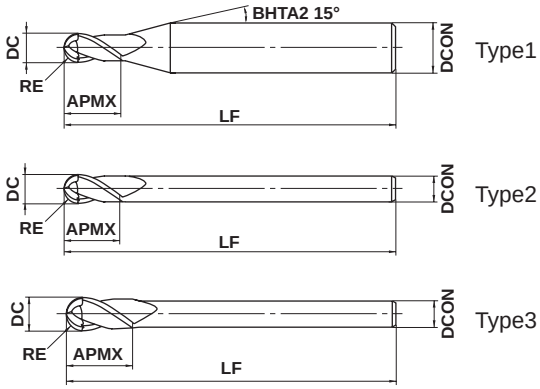
Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate and depth of cut.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
Note 3) When work on dry machining material that contain resin, be careful of tool breakage and mechanical problems (as there is a possibility of blockage caused by cutting chips).
Note 4) Use a milling machine dedicated for graphite.

C2MB

Ball nose end mill, Medium cut length, 2 flute

UWC γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○	○	○



RE≤6.5	RE>6.5			
±0.01	±0.02			
DC≤12	DC>12			
0 - 0.020	0 - 0.030			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

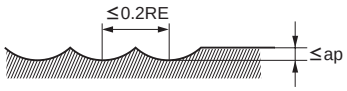
●2 flute ultra micro-grain carbide end mill for contour milling of alloy and hardened steels.

(mm)

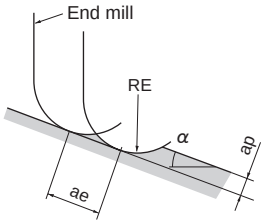
Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
C2MBR0050	0.5	1	2.5	40	4	2	▲	1
C2MBR0075	0.75	1.5	4	40	4	2	▲	1
C2MBR0100	1	2	6	60	6	2	▲	1
C2MBR0150	1.5	3	8	70	6	2	▲	1
C2MBR0200	2	4	8	70	6	2	▲	1
C2MBR0250	2.5	5	12	80	6	2	▲	1
C2MBR0300	3	6	12	80	6	2	▲	2
C2MBR0400	4	8	14	90	8	2	▲	2
C2MBR0500	5	10	18	100	10	2	▲	2
C2MBR0550	5.5	11	22	110	12	2	▲	1
C2MBR0650	6.5	13	26	120	12	2	▲	3
C2MBR0700	7	14	26	120	12	2	▲	3
C2MBR0750	7.5	15	30	140	16	2	▲	1

▲ : Product scheduled to be discontinued at the end of March 2020
CRN2MB(J230) are alternative for non-ferrous metal cutting such as aluminum alloys and copper alloys, and MP2MB(J198) is alternative for processing of other cutting materials.

RECOMMENDED CUTTING CONDITIONS

	Roughing (Depth of cut ap : ≤0.8RE)				Finishing (Depth of cut ap : ≤0.05RE)							
Work Material	Carbon steel, Alloy steel (−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI H13, AISI P21		Carbon steel, Alloy steel (−30HRC) AISI 1055, AISI P20				Alloy steel, Tool steel, Pre-hardened steel (30−45HRC) AISI H13, AISI P21			
R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	α≤15°		α>15°		α≤15°		α>15°	
					Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
R 0.5	—	—	—	—	14000	180	10000	120	12000	150	7000	80
R 1	4100	70	2800	40	10500	350	7300	210	8400	220	5500	130
R 2	2600	120	1650	85	7200	500	5100	300	5900	360	4300	210
R 3	1900	150	1200	95	5200	560	3600	350	4200	410	2900	240
R 4	1400	160	900	105	4000	640	2700	380	3100	440	2200	240
R 5	1100	140	710	95	3200	700	2200	380	2500	460	1750	250
R 6	940	130	600	85	2600	640	1750	350	2100	430	1450	250
R 8	700	100	450	60	1900	620	1300	330	1550	430	1100	250
R10	560	80	360	50	1500	590	1000	310	1250	410	860	250
Depth of cut	 RE:Radius											

Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.



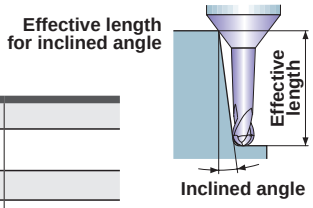
ae:Pick Feed

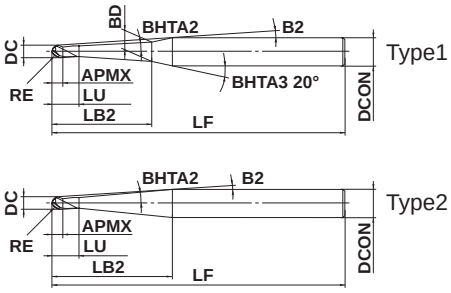
MP3XB

Ball nose, 3 flute, Taper neck

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





RE≤3	RE≥4			
±0.005	±0.010			
DCON=6	DCON=8			
0 / - 0.005	0 / - 0.006			
DCON=10	DCON≥12			
0 / - 0.009	0 / - 0.011			

h5
h6

- Ideal for rough milling of long overhang applications and semi-finishing of forging dies (40-52 HRC).
- Rigid, high helix, 3 flute design enables large depths of cut and high feed rates for increased machining efficiency.

(mm)

Order Number	RE	DC	BHTA2	APMX	LU	LB2	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
MP3XBR0050N008T05	0.5	1	0.5°	0.8	2.3	8	9.3°	1.04	60	6	3	●	1	8.5	8.8	9.3	9.8
MP3XBR0050N012T05	0.5	1	0.5°	0.8	2.3	12	7.5°	1.1	60	6	3	●	1	12.6	13	13.6	14.4
MP3XBR0050N016T05	0.5	1	0.5°	0.8	2.3	16	6.3°	1.18	60	6	3	●	1	16.6	17.1	18	18.9
MP3XBR0050N020T05	0.5	1	0.5°	0.8	2.3	20	5.4°	1.24	60	6	3	●	1	20.6	21.2	22.3	23.5
MP3XBR0050N025T05	0.5	1	0.5°	0.8	2.3	25	4.6°	1.34	70	6	3	●	1	25.7	26.3	27.7	29.3
MP3XBR0050N030T05	0.5	1	0.5°	0.8	2.3	30	4°	1.42	70	6	3	●	1	30.7	31.5	33.1	35
MP3XBR0050N050T05	0.5	1	0.5°	0.8	2.3	50	2.6°	1.78	90	6	3	●	1	50.8	52.1	54.8	*
MP3XBR0050N010T10	0.5	1	1°	0.8	2.3	10	8.4°	1.2	60	6	3	●	1	—	10.6	11.2	11.8
MP3XBR0050N016T10	0.5	1	1°	0.8	2.3	16	6.4°	1.42	60	6	3	●	1	—	16.7	17.6	18.5
MP3XBR0050N020T10	0.5	1	1°	0.8	2.3	20	5.5°	1.56	60	6	3	●	1	—	20.7	21.8	23
MP3XBR0050N025T10	0.5	1	1°	0.8	2.3	25	4.7°	1.74	70	6	3	●	1	—	25.7	27.1	28.6
MP3XBR0050N030T10	0.5	1	1°	0.8	2.3	30	4.1°	1.9	70	6	3	●	1	—	30.8	32.4	34.2
MP3XBR0050N035T10	0.5	1	1°	0.8	2.3	35	3.6°	2.08	90	6	3	●	1	—	35.8	37.7	39.8
MP3XBR0050N050T10	0.5	1	1°	0.8	2.3	50	2.7°	2.6	90	6	3	●	1	—	50.9	53.6	*
MP3XBR0050N010T15	0.5	1	1.5°	0.8	2.3	10	8.5°	1.34	60	6	3	●	1	—	—	11	11.6
MP3XBR0050N016T15	0.5	1	1.5°	0.8	2.3	16	6.5°	1.66	60	6	3	●	1	—	—	17.2	18.1
MP3XBR0050N020T15	0.5	1	1.5°	0.8	2.3	20	5.6°	1.86	60	6	3	●	1	—	—	21.3	22.5
MP3XBR0050N023T15	0.5	1	1.5°	0.8	2.3	23	5°	2.02	70	6	3	●	1	—	—	24.4	25.7
MP3XBR0050N025T15	0.5	1	1.5°	0.8	2.3	25	4.7°	2.12	70	6	3	●	1	—	—	26.5	27.9
MP3XBR0050N010T30	0.5	1	3°	0.8	2.3	10	8.8°	1.74	60	6	3	●	1	—	—	—	10.8
MP3XBR0050N020T30	0.5	1	3°	0.8	2.3	20	5.9°	2.8	60	6	3	●	1	—	—	—	20.9
MP3XBR0050N030T30	0.5	1	3°	0.8	2.3	30	4.4°	3.84	70	6	3	●	1	—	—	—	31
MP3XBR0050N042T30	0.5	1	3°	0.8	2.3	42	3.4°	5.1	90	6	3	●	1	—	—	—	43
MP3XBR0050N025T50	0.5	1	5°	0.8	2.3	25	5.4°	4.92	60	6	3	●	1	—	—	—	—
MP3XBR0075N010T05	0.75	1.5	0.5°	1.2	2.7	10	7.8°	1.56	60	6	3	●	1	10.6	10.9	11.4	12
MP3XBR0075N016T05	0.75	1.5	0.5°	1.2	2.7	16	5.8°	1.68	60	6	3	●	1	16.6	17.1	17.9	18.9
MP3XBR0075N020T05	0.75	1.5	0.5°	1.2	2.7	20	5°	1.74	60	6	3	●	1	20.6	21.2	22.3	23.5
MP3XBR0075N030T05	0.75	1.5	0.5°	1.2	2.7	30	3.7°	1.92	80	6	3	●	1	30.7	31.5	33.1	35
MP3XBR0075N010T10	0.75	1.5	1°	1.2	2.7	10	7.9°	1.7	60	6	3	●	1	—	10.6	11.2	11.8
MP3XBR0075N016T10	0.75	1.5	1°	1.2	2.7	16	5.9°	1.9	60	6	3	●	1	—	16.7	17.6	18.5
MP3XBR0075N020T10	0.75	1.5	1°	1.2	2.7	20	5.1°	2.04	60	6	3	●	1	—	20.7	21.8	23
MP3XBR0075N030T10	0.75	1.5	1°	1.2	2.7	30	3.7°	2.4	80	6	3	●	1	—	30.8	32.4	34.2

* No interference

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	BHTA2	APMX	LU	LB2	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
														0.5°	1°	2°	3°
MP3XBR0075N010T15	0.75	1.5	1.5°	1.2	2.7	10	8°	1.82	60	6	3	●	1	—	—	11	11.6
MP3XBR0075N016T15	0.75	1.5	1.5°	1.2	2.7	16	6°	2.14	60	6	3	●	1	—	—	17.2	18.1
MP3XBR0075N020T15	0.75	1.5	1.5°	1.2	2.7	20	5.1°	2.34	60	6	3	●	1	—	—	21.3	22.5
MP3XBR0075N025T15	0.75	1.5	1.5°	1.2	2.7	25	4.4°	2.6	80	6	3	●	1	—	—	26.5	27.9
MP3XBR0075N030T15	0.75	1.5	1.5°	1.2	2.7	30	3.8°	2.86	80	6	3	●	1	—	—	31.6	33.4
MP3XBR0075N046T30	0.75	1.5	3°	1.2	2.7	46	2.9°	—	80	6	3	●	2	—	—	—	*
MP3XBR0100N016T05	1	2	0.5°	1.6	3.6	16	5.2°	2.12	60	6	3	●	1	17	17.6	18.6	19.5
MP3XBR0100N020T05	1	2	0.5°	1.6	3.6	20	4.5°	2.18	60	6	3	●	1	21.1	21.8	22.9	24.1
MP3XBR0100N030T05	1	2	0.5°	1.6	3.6	30	3.3°	2.36	70	6	3	●	1	31.1	32.1	33.7	35.6
MP3XBR0100N035T05	1	2	0.5°	1.6	3.6	35	2.9°	2.44	80	6	3	●	1	36.2	37.2	39.2	*
MP3XBR0100N040T05	1	2	0.5°	1.6	3.6	40	2.6°	2.54	80	6	3	●	1	41.2	42.4	44.6	*
MP3XBR0100N016T10	1	2	1°	1.6	3.6	16	5.3°	2.34	60	6	3	●	1	—	17.1	18.2	19.1
MP3XBR0100N020T10	1	2	1°	1.6	3.6	20	4.5°	2.48	60	6	3	●	1	—	21.2	22.4	23.6
MP3XBR0100N025T10	1	2	1°	1.6	3.6	25	3.8°	2.64	70	6	3	●	1	—	26.2	27.7	29.2
MP3XBR0100N030T10	1	2	1°	1.6	3.6	30	3.3°	2.82	70	6	3	●	1	—	31.3	33	34.8
MP3XBR0100N035T10	1	2	1°	1.6	3.6	35	3°	3	80	6	3	●	1	—	36.3	38.3	40.4
MP3XBR0100N040T10	1	2	1°	1.6	3.6	40	2.7°	3.18	80	6	3	●	1	—	41.3	43.6	*
MP3XBR0100N050T10	1	2	1°	1.6	3.6	50	2.2°	3.52	110	6	3	●	1	—	51.4	54.2	*
MP3XBR0100N070T10	1	2	1°	1.6	3.6	70	1.7°	4.22	110	6	3	●	1	—	71.5	*	*
MP3XBR0100N016T15	1	2	1.5°	1.6	3.6	16	5.4°	2.54	60	6	3	●	1	—	—	22.8	18.7
MP3XBR0100N020T15	1	2	1.5°	1.6	3.6	20	4.6°	2.76	60	6	3	●	1	—	—	21.9	23.1
MP3XBR0100N025T15	1	2	1.5°	1.6	3.6	25	3.9°	3.02	70	6	3	●	1	—	—	27.1	28.5
MP3XBR0100N030T15	1	2	1.5°	1.6	3.6	30	3.4°	3.28	70	6	3	●	1	—	—	32.2	34
MP3XBR0100N035T15	1	2	1.5°	1.6	3.6	35	3°	3.54	80	6	3	●	1	—	—	37.4	39.4
MP3XBR0100N040T15	1	2	1.5°	1.6	3.6	40	2.7°	3.8	80	6	3	●	1	—	—	42.6	*
MP3XBR0100N020T30	1	2	3°	1.6	3.6	20	4.8°	3.62	60	6	3	●	1	—	—	—	20.5
MP3XBR0100N030T30	1	2	3°	1.6	3.6	30	3.6°	4.66	70	6	3	●	1	—	—	—	30.6
MP3XBR0100N042T30	1	2	3°	1.6	3.6	42	2.8°	—	80	6	3	●	2	—	—	—	*
MP3XBR0100N027T50	1	2	5°	1.6	3.6	27	4.3°	—	60	6	3	●	2	—	—	—	—
MP3XBR0150N010T05	1.5	3	0.5°	2.4	5.4	10	5.7°	2.98	60	6	3	●	1	11	11.4	12	12.6
MP3XBR0150N020T05	1.5	3	0.5°	2.4	5.4	20	3.5°	3.16	60	6	3	●	1	21.1	21.8	22.9	24.1
MP3XBR0150N030T05	1.5	3	0.5°	2.4	5.4	30	2.6°	3.32	70	6	3	●	1	31.2	32.1	33.7	*
MP3XBR0150N040T05	1.5	3	0.5°	2.4	5.4	40	2°	3.5	80	6	3	●	1	41.3	42.4	44.6	*
MP3XBR0150N050T05	1.5	3	0.5°	2.4	5.4	50	1.7°	3.68	90	6	3	●	1	51.3	52.7	*	*
MP3XBR0150N020T10	1.5	3	1°	2.4	5.4	20	3.6°	3.4	60	6	3	●	1	—	21.3	22.4	23.6
MP3XBR0150N030T10	1.5	3	1°	2.4	5.4	30	2.6°	3.76	70	6	3	●	1	—	31.3	33	*
MP3XBR0150N035T10	1.5	3	1°	2.4	5.4	35	2.3°	3.94	80	6	3	●	1	—	36.4	38.3	*
MP3XBR0150N040T10	1.5	3	1°	2.4	5.4	40	2.1°	4.1	80	6	3	●	1	—	41.4	43.6	*
MP3XBR0150N050T10	1.5	3	1°	2.4	5.4	50	1.7°	4.46	90	6	3	●	1	—	51.5	*	*
MP3XBR0150N060T10	1.5	3	1°	2.4	5.4	60	1.5°	4.8	110	6	3	●	1	—	61.5	*	*
MP3XBR0150N070T10	1.5	3	1°	2.4	5.4	70	1.3°	5.16	110	6	3	●	1	—	71.6	*	*
MP3XBR0150N020T15	1.5	3	1.5°	2.4	5.4	20	3.7°	3.66	60	6	3	●	1	—	—	22	23.2
MP3XBR0150N030T15	1.5	3	1.5°	2.4	5.4	30	2.7°	4.18	70	6	3	●	1	—	—	32.3	*
MP3XBR0150N035T15	1.5	3	1.5°	2.4	5.4	35	2.4°	4.46	70	6	3	●	1	—	—	37.5	*
MP3XBR0150N040T15	1.5	3	1.5°	2.4	5.4	40	2.1°	4.72	80	6	3	●	1	—	—	42.6	*
MP3XBR0150N045T15	1.5	3	1.5°	2.4	5.4	45	1.9°	4.98	80	6	3	●	1	—	—	*	*
MP3XBR0150N052T15	1.5	3	1.5°	2.4	5.4	52	1.7°	5.34	90	6	3	●	1	—	—	*	*
MP3XBR0150N064T15	1.5	3	1.5°	2.4	5.4	64	1.4°	—	110	6	3	●	2	—	—	*	*
MP3XBR0150N025T30	1.5	3	3°	2.4	5.4	25	3.3°	4.96	60	6	3	●	1	—	—	—	26.8
MP3XBR0150N034T30	1.5	3	3°	2.4	5.4	34	2.6°	—	70	6	3	●	2	—	—	—	*

* No interference

MP3XB

Ball nose, 3 flute, Taper neck

(mm)

Order Number	RE	DC	BHTA2	APMX	LU	LB2	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
														0.5°	1°	2°	3°
MP3XBR0150N040T30	1.5	3	3°	2.4	5.4	40	3.4°	6.52	90	8	3	●	1	—	—	—	41.9
MP3XBR0150N054T30	1.5	3	3°	2.4	5.4	54	2.7°	—	90	8	3	●	2	—	—	—	*
MP3XBR0200N030T05	2	4	0.5°	3.2	6.2	30	1.8°	4.32	70	6	3	●	1	31.2	32.1	*	*
MP3XBR0200N040T05	2	4	0.5°	3.2	6.2	40	1.4°	4.48	80	6	3	●	1	41.3	42.4	*	*
MP3XBR0200N060T05	2	4	0.5°	3.2	6.2	60	1°	4.84	100	6	3	●	1	61.4	63	*	*
MP3XBR0200N020T10	2	4	1°	3.2	6.2	20	2.6°	4.38	70	6	3	●	1	—	21.3	22.4	*
MP3XBR0200N030T10	2	4	1°	3.2	6.2	30	1.8°	4.74	70	6	3	●	1	—	31.4	*	*
MP3XBR0200N035T10	2	4	1°	3.2	6.2	35	1.6°	4.9	70	6	3	●	1	—	36.4	*	*
MP3XBR0200N040T10	2	4	1°	3.2	6.2	40	1.5°	5.08	80	6	3	●	1	—	41.4	*	*
MP3XBR0200N045T10	2	4	1°	3.2	6.2	45	1.3°	5.26	80	6	3	●	1	—	46.5	*	*
MP3XBR0200N066T10	2	4	1°	3.2	6.2	66	1°	—	100	6	3	●	2	—	*	*	*
MP3XBR0200N050T15	2	4	1.5°	3.2	6.2	50	2.2°	6.2	90	8	3	●	1	—	—	53	*
MP3XBR0200N084T15	2	4	1.5°	3.2	6.2	84	1.5°	—	120	8	3	●	2	—	—	*	*
MP3XBR0200N030T30	2	4	3°	3.2	6.2	30	3.6°	6.4	90	8	3	●	1	—	—	—	31.9
MP3XBR0200N045T30	2	4	3°	3.2	6.2	45	2.6°	—	90	8	3	●	2	—	—	—	*
MP3XBR0250N038T10	2.5	5	1°	4	7	38	0.8°	—	80	6	3	●	2	—	*	*	*
MP3XBR0250N050T10	2.5	5	1°	4	7	50	1.7°	6.4	90	8	3	●	1	—	51.5	*	*
MP3XBR0250N065T10	2.5	5	1°	4	7	65	1.4°	6.92	110	8	3	●	1	—	66.6	*	*
MP3XBR0250N066T15	2.5	5	1.5°	4	7	66	1.4°	—	110	8	3	●	2	—	—	*	*
MP3XBR0250N036T30	2.5	5	3°	4	7	36	2.4°	—	90	8	3	●	2	—	—	—	*
MP3XBR0300N040T10	3	6	1°	9	12	40	1.4°	6.82	80	8	3	●	1	—	41.8	*	*
MP3XBR0300N050T10	3	6	1°	9	12	50	1.2°	7.18	90	8	3	●	1	—	51.8	*	*
MP3XBR0300N073T10	3	6	1°	9	12	73	0.9°	—	110	8	3	●	2	—	*	*	*
MP3XBR0300N090T10	3	6	1°	9	12	90	1.3°	8.58	140	10	3	●	1	—	92	*	*
MP3XBR0300N053T15	3	6	1.5°	9	12	53	1.2°	—	90	8	3	●	2	—	—	*	*
MP3XBR0300N032T30	3	6	3°	9	12	32	1.9°	—	80	8	3	●	2	—	—	—	*
MP3XBR0400N050T10	4	8	1°	12	15	50	1.2°	9.08	110	10	3	●	1	—	51.9	*	*
MP3XBR0400N065T10	4	8	1°	12	15	65	1°	9.6	130	10	3	●	1	—	67	*	*
MP3XBR0400N076T10	4	8	1°	12	15	76	0.8°	—	130	10	3	●	2	—	*	*	*
MP3XBR0400N090T10	4	8	1°	12	15	90	1.3°	10.46	150	12	3	●	1	—	92.1	*	*
MP3XBR0400N040T15	4	8	1.5°	12	15	40	1.5°	9.16	90	10	3	●	1	—	—	*	*
MP3XBR0400N056T15	4	8	1.5°	12	15	56	1.1°	—	110	10	3	●	2	—	—	*	*
MP3XBR0400N035T30	4	8	3°	12	15	35	1.7°	—	90	10	3	●	2	—	—	—	*
MP3XBR0500N060T10	5	10	1°	15	25	60	1°	10.92	120	12	3	●	1	—	62.6	*	*
MP3XBR0500N070T10	5	10	1°	15	25	70	0.9°	11.28	120	12	3	●	1	—	*	*	*
MP3XBR0500N100T10	5	10	1°	15	25	100	1.7°	12.32	160	16	3	●	1	—	102.8	*	*
MP3XBR0500N050T15	5	10	1.5°	15	25	50	1.2°	11	100	12	3	●	1	—	—	*	*
MP3XBR0500N068T15	5	10	1.5°	15	25	68	0.9°	—	120	12	3	●	2	—	—	*	*
MP3XBR0500N046T30	5	10	3°	15	25	46	1.3°	—	100	12	3	●	2	—	—	—	*
MP3XBR0600N070T10	6	12	1°	18	28	70	1.6°	13.16	130	16	3	●	1	—	72.7	*	*
MP3XBR0600N100T10	6	12	1°	18	28	100	1.2°	14.22	160	16	3	●	1	—	102.9	*	*
MP3XBR0600N080T15	6	12	1.5°	18	28	80	1.5°	14.42	130	16	3	●	1	—	—	*	*
MP3XBR0600N069T30	6	12	3°	18	28	69	1.8°	—	130	16	3	●	2	—	—	—	*

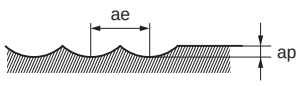
* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Carbon steel, Alloy steel (180−280HB) Alloy Tool Steel (≤350HB) Pre-hardened steel (35−45HRC) AISI 1045, AISI 4140, SKD, SKT, AISI 4140, AISI P21				Hardened steel (45−52HRC) AISI H13, AISI L6				Copper, Copper alloys			
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.5	0.5°	8	40000	1200	0.07	0.22	39000	1200	0.06	0.19	39000	1200	0.12	0.38
		12	40000	1200	0.06	0.19	39000	1200	0.05	0.16	39000	1200	0.1	0.32
		16	35000	1100	0.06	0.18	33000	900	0.04	0.14	33000	900	0.09	0.29
		20	32000	960	0.05	0.14	29000	800	0.04	0.11	29000	800	0.07	0.22
		25	28000	830	0.03	0.11	24000	600	0.02	0.07	24000	600	0.05	0.15
		30	24000	720	0.03	0.1	21000	450	0.02	0.06	21000	450	0.04	0.13
		50	10000	300	0.003	0.015	11000	150	0.003	0.015	11000	150	0.006	0.019
	1°	10	40000	1200	0.07	0.22	39000	1300	0.06	0.19	39000	1300	0.12	0.38
		16	35000	1100	0.06	0.18	33000	1000	0.05	0.14	33000	1000	0.09	0.29
		20	32000	960	0.05	0.14	29000	900	0.04	0.11	29000	900	0.07	0.22
		25	28000	830	0.04	0.11	24000	700	0.03	0.08	24000	700	0.05	0.16
		30	24000	720	0.03	0.1	21000	550	0.02	0.06	21000	550	0.04	0.13
		35	17000	500	0.03	0.08	13000	350	0.02	0.05	13000	350	0.03	0.1
		50	10000	300	0.003	0.015	11000	250	0.003	0.015	11000	250	0.006	0.019
	1.5°	10	40000	1200	0.07	0.22	39000	1400	0.06	0.19	39000	1400	0.12	0.38
		16	35000	1100	0.06	0.18	33000	1100	0.05	0.14	33000	1100	0.09	0.29
		20	32000	960	0.05	0.14	29000	1000	0.04	0.11	29000	1000	0.07	0.22
		23	27000	830	0.04	0.11	24000	800	0.03	0.08	24000	800	0.05	0.16
		25	27000	830	0.04	0.12	24000	800	0.03	0.09	24000	800	0.05	0.17
	3°	10	40000	1200	0.07	0.22	39000	1500	0.06	0.19	39000	1500	0.12	0.38
		20	32000	960	0.05	0.14	29000	1100	0.04	0.11	29000	1100	0.07	0.22
		30	22000	660	0.03	0.1	19000	700	0.02	0.06	19000	700	0.04	0.13
		42	13000	390	0.005	0.02	11000	390	0.005	0.02	11000	390	0.01	0.03
	5°	25	32000	960	0.04	0.11	29000	1000	0.03	0.08	29000	1000	0.05	0.16
R0.75	0.5°	10	30000	1800	0.11	0.34	28000	1500	0.1	0.3	28000	1500	0.19	0.61
		16	27000	1600	0.09	0.27	24000	1100	0.08	0.24	24000	1100	0.15	0.48
		20	26000	1500	0.08	0.24	24000	1100	0.07	0.21	24000	1100	0.13	0.42
		30	25000	1400	0.07	0.21	22000	1000	0.06	0.18	22000	1000	0.11	0.35
	1°	10	30000	1900	0.11	0.34	28000	1600	0.1	0.3	28000	1600	0.19	0.61
		16	26000	1600	0.09	0.27	24000	1200	0.08	0.24	24000	1200	0.15	0.48
		20	27000	1700	0.08	0.24	24000	1200	0.07	0.21	24000	1200	0.13	0.42
		30	25000	1500	0.07	0.21	22000	1100	0.06	0.18	22000	1100	0.11	0.35
	1.5°	10	30000	1900	0.11	0.34	28000	1700	0.1	0.3	28000	1700	0.19	0.61
		16	27500	1700	0.09	0.27	24000	1300	0.08	0.24	24000	1300	0.15	0.48
		20	26500	1700	0.08	0.24	24000	1300	0.07	0.21	24000	1300	0.13	0.42
		25	26000	1600	0.07	0.22	23000	1200	0.06	0.19	23000	1200	0.12	0.38
		30	25000	1500	0.07	0.21	22000	1100	0.06	0.18	22000	1100	0.11	0.35
	3°	46	15000	450	0.05	0.16	14000	800	0.04	0.13	14000	800	0.08	0.26

Depth of cut



Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

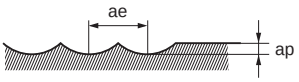
MP3XB

Ball nose, 3 flute, Taper neck

RECOMMENDED CUTTING CONDITIONS

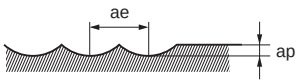
Work Material			Carbon steel, Alloy steel (180−280HB) Alloy Tool Steel (≤350HB) Pre-hardened steel (35−45HRC) AISI 1045, AISI 4140, SKD, SKT, AISI 4140, AISI P21				Hardened steel (45−52HRC) AISI H13, AISI L6				Copper, Copper alloys			
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R1.0	0.5°	16	25000	1500	0.14	0.45	22000	1600	0.13	0.42	22000	1600	0.26	0.83
		20	23000	1400	0.1	0.3	20000	1400	0.09	0.27	20000	1400	0.17	0.54
		30	20000	1200	0.05	0.17	18000	1100	0.06	0.18	18000	1100	0.13	0.42
		35	19000	1100	0.05	0.15	17000	1000	0.05	0.16	17000	1000	0.12	0.38
		40	19000	1100	0.04	0.14	16000	900	0.05	0.14	16000	900	0.11	0.35
	1°	16	25000	2300	0.14	0.45	22000	1700	0.13	0.42	22000	1700	0.26	0.83
		20	23000	2100	0.1	0.3	20000	1500	0.09	0.27	20000	1500	0.17	0.54
		25	23000	1400	0.06	0.19	20000	1300	0.07	0.21	20000	1300	0.16	0.5
		30	20000	1200	0.05	0.17	18000	1200	0.06	0.18	18000	1200	0.13	0.42
		35	19000	1100	0.05	0.15	17000	1100	0.05	0.15	17000	1100	0.12	0.37
		40	19000	1100	0.04	0.14	16000	1000	0.05	0.14	16000	1000	0.11	0.35
		50	17000	900	0.03	0.09	15000	900	0.03	0.08	15000	900	0.06	0.19
		70	13000	700	0.02	0.06	11000	650	0.02	0.05	11000	650	0.04	0.12
	1.5°	16	25000	2300	0.14	0.45	22000	1800	0.13	0.42	22000	1800	0.26	0.83
		20	23000	2100	0.1	0.3	20000	1600	0.09	0.27	20000	1600	0.17	0.54
		25	23000	1600	0.06	0.19	20000	1400	0.07	0.21	20000	1400	0.16	0.5
		30	20000	1200	0.05	0.17	18000	1300	0.06	0.18	18000	1300	0.13	0.42
		35	19000	1100	0.05	0.15	16000	1100	0.05	0.16	17000	1100	0.12	0.38
		40	19000	1100	0.04	0.14	16000	1000	0.05	0.14	16000	1000	0.11	0.35
	3°	20	23000	2100	0.1	0.3	20000	1700	0.09	0.27	20000	1700	0.17	0.54
		30	18000	1600	0.08	0.26	16000	1300	0.07	0.22	16500	1300	0.14	0.45
		42	16000	1400	0.07	0.21	13000	1000	0.06	0.18	13000	1000	0.11	0.35
	5°	27	18000	2200	0.09	0.29	17000	1900	0.08	0.26	17000	1900	0.16	0.51
R1.5	0.5°	10	20000	2400	0.22	0.7	17000	1900	0.21	0.67	17000	1900	0.42	1.34
		20	17000	2000	0.2	0.64	15000	1600	0.19	0.61	15000	1600	0.38	1.22
		30	16000	1700	0.14	0.45	13000	1400	0.13	0.42	13000	1400	0.26	0.83
		40	16000	1400	0.08	0.24	12000	1200	0.09	0.27	12000	1200	0.2	0.65
		50	13000	1100	0.06	0.2	11000	1100	0.07	0.22	11000	1100	0.17	0.54
	1°	20	17000	2000	0.2	0.64	15000	1800	0.19	0.61	15000	1800	0.38	1.22
		30	17000	1900	0.14	0.45	13000	1500	0.13	0.42	13000	1500	0.26	0.83
		35	16000	1700	0.08	0.26	13000	1500	0.09	0.29	13000	1500	0.22	0.69
		40	16000	1500	0.08	0.24	13000	1300	0.09	0.27	13000	1300	0.2	0.65
		50	13000	1200	0.06	0.2	11000	1100	0.07	0.22	11000	1100	0.17	0.54
		60	13000	1100	0.06	0.19	11000	1000	0.07	0.21	11000	1000	0.16	0.5
		70	10000	800	0.05	0.17	9000	700	0.06	0.18	9000	700	0.13	0.42
	1.5°	20	17000	2000	0.2	0.64	15000	1900	0.19	0.61	15000	1900	0.38	1.22
		30	16000	1800	0.14	0.45	13000	1600	0.13	0.42	13000	1600	0.26	0.83
		35	15000	1700	0.08	0.26	12000	1400	0.09	0.29	12000	1400	0.22	0.69
		40	15000	1600	0.08	0.24	12000	1300	0.09	0.27	12000	1300	0.2	0.65
		45	13000	1400	0.07	0.22	11000	1300	0.08	0.24	11000	1300	0.18	0.58
		52	13000	1300	0.06	0.2	11000	1100	0.07	0.22	11000	1100	0.17	0.54
		64	10000	900	0.06	0.18	9000	900	0.06	0.19	9000	900	0.14	0.46
	3°	25	16000	2400	0.16	0.51	13000	1900	0.15	0.48	13000	1900	0.3	0.96
		34	14000	2100	0.13	0.4	11000	1600	0.12	0.37	11000	1600	0.23	0.74
		40	14000	1700	0.12	0.37	11000	1400	0.11	0.34	11000	1400	0.21	0.67
		54	12000	1400	0.1	0.3	10000	1200	0.09	0.27	10000	1200	0.17	0.54

Depth of cut



Work Material			Carbon steel, Alloy steel (180−280HB) Alloy Tool Steel (≤350HB) Pre-hardened steel (35−45HRC) AISI 1045, AISI 4140, SKD, SKT, AISI 4140, AISI P21				Hardened steel (45−52HRC) AISI H13, AISI L6				Copper, Copper alloys			
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R2.0	0.5°	30	14000	2100	0.23	0.74	11000	1800	0.22	0.7	11000	1800	0.44	1.41
		40	12000	1800	0.19	0.61	10000	1600	0.18	0.58	10000	1600	0.36	1.15
		60	9000	1300	0.06	0.19	8500	1400	0.07	0.21	8500	1400	0.16	0.5
	1°	20	15000	2700	0.31	0.99	12000	2200	0.3	0.96	12000	2200	0.72	2.3
		30	14000	2100	0.23	0.74	11000	1800	0.22	0.7	11000	1800	0.53	1.69
		35	12000	1800	0.21	0.67	10000	1700	0.2	0.64	10000	1700	0.48	1.54
		40	12000	1700	0.19	0.61	10000	1600	0.18	0.58	10000	1600	0.43	1.38
		45	12000	1500	0.13	0.42	10000	1600	0.12	0.38	10000	1600	0.29	0.92
		66	9000	1100	0.08	0.24	8500	1300	0.07	0.21	8500	1300	0.16	0.5
	1.5°	50	12000	2200	0.11	0.35	10000	1700	0.1	0.32	10000	1700	0.24	0.77
		84	8000	1400	0.04	0.13	6500	900	0.03	0.1	6500	900	0.07	0.23
	3°	30	14000	2500	0.23	0.74	11000	2000	0.22	0.7	11000	2000	0.53	1.69
		45	11000	1900	0.16	0.51	9000	1600	0.15	0.48	9000	1600	0.36	1.15
R2.5	1°	38	10000	2200	0.28	0.9	8500	2000	0.27	0.86	8500	2000	0.65	2.07
		50	9000	1900	0.24	0.77	8000	1800	0.23	0.74	8000	1800	0.55	1.77
		65	8000	1600	0.16	0.51	6500	1400	0.15	0.48	6500	1400	0.36	1.15
	1.5°	66	8000	1600	0.16	0.51	6500	1500	0.15	0.48	6500	1500	0.36	1.15
	3°	36	10000	2700	0.31	0.99	8500	2300	0.3	0.96	8500	2300	0.72	2.3
R3.0	1°	40	8000	2200	0.28	0.9	7500	2100	0.27	0.86	7500	2100	0.65	2.07
		50	8000	2000	0.23	0.74	6500	1800	0.22	0.7	6500	1800	0.53	1.69
		73	7000	1700	0.15	0.48	6500	1700	0.14	0.45	6500	1700	0.34	1.07
		90	6500	1500	0.09	0.29	6000	1300	0.08	0.26	6000	1300	0.19	0.61
	1.5°	53	7000	2100	0.22	0.7	6500	1900	0.21	0.67	6500	1900	0.5	1.61
	3°	32	9000	2400	0.35	1.12	8000	2200	0.34	1.09	8000	2200	0.82	2.61
R4.0	1°	50	6000	2200	0.41	1.31	5500	2000	0.4	1.28	5500	2000	0.96	3.07
		65	6000	2000	0.36	1.15	5200	1700	0.35	1.12	5200	1700	0.84	2.69
		76	6000	1800	0.29	0.93	5000	1500	0.28	0.9	5000	1500	0.67	2.15
		90	5000	1400	0.19	0.61	4700	1200	0.18	0.58	4700	1200	0.43	1.38
	1.5°	40	6000	2300	0.46	1.47	5800	2200	0.45	1.44	5800	2200	1.08	3.46
		56	6000	2200	0.38	1.22	5500	2000	0.37	1.18	5500	2000	0.9	2.84
	3°	35	7000	2700	0.49	1.57	6000	2400	0.48	1.54	6000	2400	1.15	3.69
R5.0	1°	60	5500	2600	0.51	1.63	4500	2300	0.5	1.6	4500	2300	1.2	3.84
		70	5500	2600	0.46	1.47	4500	2200	0.45	1.44	4500	2200	1.08	3.46
		100	5000	2400	0.36	1.15	4000	1900	0.35	1.12	4000	1900	0.84	2.69
	1.5°	50	5000	2400	0.56	1.79	4600	2400	0.55	1.76	4600	2400	1.32	4.22
		68	5000	2400	0.49	1.57	4600	2300	0.48	1.54	4600	2300	1.15	3.69
	3°	46	5000	2400	0.69	2.21	4800	2500	0.68	2.18	4800	2500	1.63	5.22
R6.0	1°	70	4500	2600	0.81	2.59	4000	2100	0.8	2.56	4000	2100	1.92	6.14
		100	4000	2200	0.61	1.95	3500	1800	0.6	1.92	3500	1800	1.44	4.61
	1.5°	80	5000	2300	0.71	2.27	4000	2000	0.7	2.24	4000	2000	1.68	5.38
	3°	69	5000	2700	0.81	2.59	4000	2200	0.8	2.56	4000	2200	1.92	6.14

Depth of cut



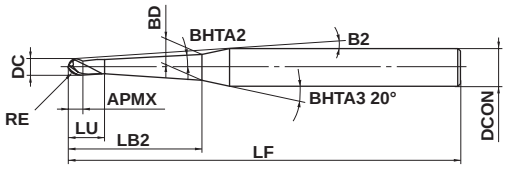
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VF3XB

Ball nose, Medium cut length, 3 flute, Taper neck

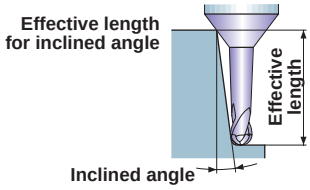
TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	◎				



Type1

0.4≤RE≤2.5				
±0.01				
0.8≤DC≤5				
0 / - 0.02				
4≤DCON≤6	DCON=8			
0 / - 0.008	0 / - 0.009			



●3 flute ball end mill, high rigidity taper neck type.

(mm)

Order Number	RE	DC	BHTA2	APMX	LB2	LU	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VF3XBR0040T0024L006	0.4	0.8	0.4°	0.5	6	1.5	8.9°	0.82	60	4	3	●	1	6.3	6.6	6.9	7.3
VF3XBR0040T0024L008	0.4	0.8	0.4°	0.5	8	1.5	7.5°	0.85	60	4	3	●	1	8.4	8.6	9.1	9.5
VF3XBR0040T0024L012	0.4	0.8	0.4°	0.5	12	1.5	5.7°	0.91	60	4	3	●	1	12.4	12.7	13.4	14.1
VF3XBR0040T0054L008	0.4	0.8	0.9°	0.5	8	1.5	7.6°	0.96	60	4	3	●	1	—	8.4	8.9	9.3
VF3XBR0040T0054L012	0.4	0.8	0.9°	0.5	12	1.5	5.8°	1.09	60	4	3	●	1	—	12.4	13.1	13.8
VF3XBR0040T0054L016	0.4	0.8	0.9°	0.5	16	1.5	4.7°	1.22	60	4	3	●	1	—	16.5	17.3	18.3
VF3XBR0050T0024L008	0.5	1	0.4°	0.8	8	2.3	9.6°	1.02	60	6	3	●	1	8.5	8.8	9.3	9.8
VF3XBR0050T0024L010	0.5	1	0.4°	0.8	10	2.3	8.5°	1.05	60	6	3	●	1	10.5	10.9	11.4	12.1
VF3XBR0050T0024L012	0.5	1	0.4°	0.8	12	2.3	7.6°	1.08	60	6	3	●	1	12.6	13.0	13.6	14.4
VF3XBR0050T0024L016	0.5	1	0.4°	0.8	16	2.3	6.3°	1.13	70	6	3	●	1	16.6	17.1	18.0	18.9
VF3XBR0050T0024L020	0.5	1	0.4°	0.8	20	2.3	5.4°	1.19	70	6	3	●	1	20.6	21.2	22.3	23.5
VF3XBR0050T0024L025	0.5	1	0.4°	0.8	25	2.3	4.6°	1.26	70	6	3	●	1	25.7	26.3	27.7	29.3
VF3XBR0050T0024L030	0.5	1	0.4°	0.8	30	2.3	4.0°	1.33	80	6	3	●	1	30.7	31.5	33.1	35.0
VF3XBR0050T0024L035	0.5	1	0.4°	0.8	35	2.3	3.5°	1.40	80	6	3	●	1	35.7	36.6	38.6	40.7
VF3XBR0050T0054L008	0.5	1	0.9°	0.8	8	2.3	9.7°	1.12	60	6	3	●	1	—	8.6	9.1	9.6
VF3XBR0050T0054L012	0.5	1	0.9°	0.8	12	2.3	7.7°	1.24	60	6	3	●	1	—	12.6	13.3	14.1
VF3XBR0050T0054L016	0.5	1	0.9°	0.8	16	2.3	6.4°	1.37	70	6	3	●	1	—	16.7	17.6	18.5
VF3XBR0050T0054L020	0.5	1	0.9°	0.8	20	2.3	5.5°	1.50	70	6	3	●	1	—	20.7	21.8	23.0
VF3XBR0050T0054L025	0.5	1	0.9°	0.8	25	2.3	4.7°	1.65	70	6	3	●	1	—	25.7	27.1	28.6
VF3XBR0050T0054L030	0.5	1	0.9°	0.8	30	2.3	4.0°	1.81	80	6	3	●	1	—	30.8	32.4	34.2
VF3XBR0050T0054L035	0.5	1	0.9°	0.8	35	2.3	3.6°	1.97	80	6	3	●	1	—	35.8	37.7	39.8
VF3XBR0050T0054L040	0.5	1	0.9°	0.8	40	2.3	3.2°	2.12	80	6	3	●	1	—	40.8	43.0	45.4
VF3XBR0050T0054L050	0.5	1	0.9°	0.8	50	2.3	2.7°	2.44	110	6	3	●	1	—	50.9	53.6	*
VF3XBR0050T0054L060	0.5	1	0.9°	0.8	60	2.3	2.3°	2.75	110	6	3	●	1	—	60.9	64.1	*
VF3XBR0050T0054L070	0.5	1	0.9°	0.8	70	2.3	2.0°	3.07	110	6	3	●	1	—	71.0	74.7	*
VF3XBR0050T0130L012	0.5	1	1.5°	0.8	12	2.3	7.9°	1.45	60	6	3	●	1	—	—	13.0	13.7
VF3XBR0050T0130L016	0.5	1	1.5°	0.8	16	2.3	6.5°	1.66	70	6	3	●	1	—	—	17.1	18.0
VF3XBR0050T0130L020	0.5	1	1.5°	0.8	20	2.3	5.6°	1.87	70	6	3	●	1	—	—	21.2	22.4
VF3XBR0050T0130L025	0.5	1	1.5°	0.8	25	2.3	4.8°	2.13	70	6	3	●	1	—	—	26.3	27.8
VF3XBR0050T0130L030	0.5	1	1.5°	0.8	30	2.3	4.1°	2.39	80	6	3	●	1	—	—	31.5	33.2
VF3XBR0050T0130L035	0.5	1	1.5°	0.8	35	2.3	3.7°	2.65	80	6	3	●	1	—	—	36.6	38.6
VF3XBR0075T0024L010	0.75	1.5	0.4°	1.3	10	2.8	8.1°	1.54	60	6	3	●	1	10.6	10.9	11.4	12.0
VF3XBR0075T0024L015	0.75	1.5	0.4°	1.3	15	2.8	6.2°	1.61	60	6	3	●	1	15.6	16.0	16.9	17.8
VF3XBR0075T0024L020	0.75	1.5	0.4°	1.3	20	2.8	5.0°	1.68	70	6	3	●	1	20.6	21.2	22.3	23.5

* No interference

● : Inventory maintained in Japan.

(mm)

Order Number	RE	DC	BHTA2	APMX	LB2	LU	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
														0.5°	1°	2°	3°
VF3XBR0075T0024L030	0.75	1.5	0.4°	1.3	30	2.8	3.7°	1.82	80	6	3	●	1	30.7	31.5	33.1	35.0
VF3XBR0075T0054L015	0.75	1.5	0.9°	1.3	15	2.8	6.3°	1.82	60	6	3	●	1	—	15.7	16.5	17.4
VF3XBR0075T0054L020	0.75	1.5	0.9°	1.3	20	2.8	5.1°	1.98	70	6	3	●	1	—	20.7	21.8	23.0
VF3XBR0075T0054L030	0.75	1.5	0.9°	1.3	30	2.8	3.7°	2.29	80	6	3	●	1	—	30.8	32.4	34.2
VF3XBR0075T0054L040	0.75	1.5	0.9°	1.3	40	2.8	3.0°	2.61	80	6	3	●	1	—	40.8	43.0	45.3
VF3XBR0075T0130L015	0.75	1.5	1.5°	1.3	15	2.8	6.4°	2.08	60	6	3	●	1	—	—	16.1	17.0
VF3XBR0075T0130L020	0.75	1.5	1.5°	1.3	20	2.8	5.2°	2.34	70	6	3	●	1	—	—	21.2	22.4
VF3XBR0075T0130L030	0.75	1.5	1.5°	1.3	30	2.8	3.8°	2.86	80	6	3	●	1	—	—	31.5	33.2
VF3XBR0100T0024L016	1	2	0.4°	1.6	16	3.6	5.5°	2.07	70	6	3	●	1	16.7	17.1	18.0	19.0
VF3XBR0100T0024L020	1	2	0.4°	1.6	20	3.6	4.6°	2.13	70	6	3	●	1	20.7	21.3	22.3	23.5
VF3XBR0100T0024L025	1	2	0.4°	1.6	25	3.6	3.9°	2.20	70	6	3	●	1	25.8	26.4	27.8	29.3
VF3XBR0100T0024L030	1	2	0.4°	1.6	30	3.6	3.4°	2.27	80	6	3	●	1	30.8	31.6	33.2	35.0
VF3XBR0100T0024L035	1	2	0.4°	1.6	35	3.6	2.9°	2.34	80	6	3	●	1	35.8	36.7	38.6	*
VF3XBR0100T0024L040	1	2	0.4°	1.6	40	3.6	2.6°	2.41	80	6	3	●	1	40.8	41.9	44.0	*
VF3XBR0100T0054L020	1	2	0.9°	1.6	20	3.6	4.7°	2.42	70	6	3	●	1	—	20.8	21.9	23.0
VF3XBR0100T0054L025	1	2	0.9°	1.6	25	3.6	4.0°	2.57	70	6	3	●	1	—	25.8	27.2	28.6
VF3XBR0100T0054L030	1	2	0.9°	1.6	30	3.6	3.4°	2.73	80	6	3	●	1	—	30.9	32.5	34.2
VF3XBR0100T0054L035	1	2	0.9°	1.6	35	3.6	3.0°	2.89	80	6	3	●	1	—	35.9	37.7	39.8
VF3XBR0100T0054L040	1	2	0.9°	1.6	40	3.6	2.7°	3.04	80	6	3	●	1	—	40.9	43.0	*
VF3XBR0100T0054L050	1	2	0.9°	1.6	50	3.6	2.2°	3.36	110	6	3	●	1	—	51.0	53.6	*
VF3XBR0100T0054L060	1	2	0.9°	1.6	60	3.6	1.9°	3.67	110	6	3	●	1	—	61.0	*	*
VF3XBR0100T0054L070	1	2	0.9°	1.6	70	3.6	1.6°	3.99	110	6	3	●	1	—	71.1	*	*
VF3XBR0100T0130L025	1	2	1.5°	1.6	25	3.6	4.1°	3.02	70	6	3	●	1	—	—	26.4	27.9
VF3XBR0100T0130L030	1	2	1.5°	1.6	30	3.6	3.5°	3.28	80	6	3	●	1	—	—	31.6	33.3
VF3XBR0100T0130L035	1	2	1.5°	1.6	35	3.6	3.1°	3.54	80	6	3	●	1	—	—	36.7	38.7
VF3XBR0100T0130L040	1	2	1.5°	1.6	40	3.6	2.7°	3.81	80	6	3	●	1	—	—	41.8	*
VF3XBR0125T0054L020	1.25	2.5	0.9°	2	20	4.5	4.3°	2.89	60	6	3	●	1	—	20.8	21.9	23.1
VF3XBR0125T0054L030	1.25	2.5	0.9°	2	30	4.5	3.1°	3.20	80	6	3	●	1	—	30.9	32.5	34.2
VF3XBR0125T0054L040	1.25	2.5	0.9°	2	40	4.5	2.4°	3.52	80	6	3	●	1	—	40.9	43.1	*
VF3XBR0125T0130L020	1.25	2.5	1.5°	2	20	4.5	4.4°	3.21	60	6	3	●	1	—	—	21.4	22.5
VF3XBR0125T0130L030	1.25	2.5	1.5°	2	30	4.5	3.1°	3.74	80	6	3	●	1	—	—	31.6	33.3
VF3XBR0125T0130L040	1.25	2.5	1.5°	2	40	4.5	2.5°	4.26	80	6	3	●	1	—	—	41.9	*
VF3XBR0150T0024L020	1.5	3	0.4°	2	20	5	3.8°	3.11	60	6	3	●	1	20.7	21.3	22.3	23.5
VF3XBR0150T0024L025	1.5	3	0.4°	2	25	5	3.1°	3.18	80	6	3	●	1	25.8	26.4	27.7	29.2
VF3XBR0150T0024L030	1.5	3	0.4°	2	30	5	2.7°	3.25	80	6	3	●	1	30.8	31.6	33.2	*
VF3XBR0150T0024L040	1.5	3	0.4°	2	40	5	2.1°	3.39	80	6	3	●	1	40.9	41.9	44.0	*
VF3XBR0150T0024L050	1.5	3	0.4°	2	50	5	1.7°	3.53	100	6	3	●	1	50.9	52.2	*	*
VF3XBR0150T0054L020	1.5	3	0.9°	2	20	5	3.8°	3.37	60	6	3	●	1	—	20.9	21.9	23.0
VF3XBR0150T0054L030	1.5	3	0.9°	2	30	5	2.7°	3.69	80	6	3	●	1	—	30.9	32.5	*
VF3XBR0150T0054L040	1.5	3	0.9°	2	40	5	2.1°	4.00	80	6	3	●	1	—	41.0	43.1	*
VF3XBR0150T0054L050	1.5	3	0.9°	2	50	5	1.7°	4.31	100	6	3	●	1	—	51.0	*	*
VF3XBR0150T0054L060	1.5	3	0.9°	2	60	5	2.3°	4.63	110	8	3	●	1	—	61.1	64.2	*
VF3XBR0150T0054L070	1.5	3	0.9°	2	70	5	2.0°	4.94	120	8	3	●	1	—	71.1	74.8	*
VF3XBR0150T0130L040	1.5	3	1.5°	2	40	5	2.2°	4.73	80	6	3	●	1	—	—	41.9	*
VF3XBR0150T0130L050	1.5	3	1.5°	2	50	5	2.8°	5.26	110	8	3	●	1	—	—	52.2	*
VF3XBR0150T0130L060	1.5	3	1.5°	2	60	5	2.4°	5.78	110	8	3	●	1	—	—	62.4	*
VF3XBR0150T0130L070	1.5	3	1.5°	2	70	5	2.1°	6.30	120	8	3	●	1	—	—	72.7	*
VF3XBR0200T0054L030	2	4	0.9°	3	30	6	3.5°	4.65	90	8	3	●	1	—	30.9	32.5	34.2
VF3XBR0200T0054L040	2	4	0.9°	3	40	6	2.7°	4.97	90	8	3	●	1	—	41.0	43.0	*
VF3XBR0200T0054L050	2	4	0.9°	3	50	6	2.2°	5.28	110	8	3	●	1	—	51.0	53.6	*
VF3XBR0200T0054L060	2	4	0.9°	3	60	6	1.9°	5.60	110	8	3	●	1	—	61.1	*	*
VF3XBR0250T0054L035	2.5	5	0.9°	3.5	35	6.5	2.4°	5.80	90	8	3	●	1	—	35.9	37.7	*

* No interference

VF3XB

Ball nose, Medium cut length, 3 flute, Taper neck

(mm)

Order Number	RE	DC	BHTA2	APMX	LB2	LU	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
														0.5°	1°	2°	3°
VF3XBR0250T0054L040	2.5	5	0.9°	3.5	40	6.5	2.2°	5.95	90	8	3	●	1	–	41.0	43.0	*
VF3XBR0250T0054L050	2.5	5	0.9°	3.5	50	6.5	1.8°	6.27	110	8	3	●	1	–	51.0	*	*
VF3XBR0250T0054L060	2.5	5	0.9°	3.5	60	6.5	1.5°	6.58	110	8	3	●	1	–	61.1	*	*

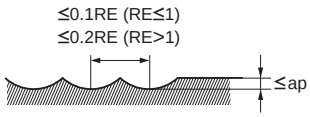
* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R0.4	0.4°	6	34000	2700	0.03	31000	2200	0.025	24000	1700	0.02	19000	1400	0.015
		8	31000	2100	0.02	29000	1700	0.02	22000	1300	0.015	18000	1000	0.01
		12	28000	2000	0.015	26000	1600	0.01	20000	1200	0.01	16000	960	0.007
	0.9°	8	31000	2200	0.02	29000	1800	0.02	22000	1400	0.015	18000	1100	0.01
		12	28000	2100	0.015	26000	1700	0.01	20000	1300	0.01	16000	1000	0.007
		16	25000	1100	0.01	23000	910	0.01	18000	700	0.008	14000	560	0.006
R0.5	0.4°	8	27000	2700	0.04	25000	2200	0.04	19000	1700	0.03	15000	1400	0.02
		10	24000	2200	0.03	22000	1800	0.025	17000	1400	0.02	14000	1100	0.015
		12	24000	2200	0.03	22000	1800	0.025	17000	1400	0.02	14000	1100	0.015
		16	22000	2100	0.03	21000	1700	0.025	16000	1300	0.02	13000	1000	0.015
		20	20000	1400	0.015	18000	1200	0.01	14000	900	0.01	11000	720	0.007
		25	18000	1300	0.015	17000	1000	0.01	13000	800	0.009	10000	640	0.006
		30	15000	960	0.01	14000	780	0.01	11000	600	0.008	8800	480	0.006
		35	14000	800	0.008	13000	650	0.007	10000	500	0.006	8000	400	0.004
	0.9°	8	27000	2900	0.04	25000	2300	0.04	19000	1800	0.03	15000	1400	0.02
		12	24000	2400	0.03	22000	2000	0.025	17000	1500	0.02	14000	1200	0.015
		16	22000	2200	0.03	21000	1800	0.025	16000	1400	0.02	13000	1100	0.015
		20	20000	1600	0.015	18000	1300	0.01	14000	1000	0.01	11000	800	0.007
		25	18000	1400	0.015	17000	1200	0.01	13000	900	0.009	10000	720	0.006
		30	15000	1100	0.01	14000	910	0.009	11000	700	0.008	8800	560	0.006
		35	14000	960	0.008	13000	780	0.007	10000	600	0.006	8000	480	0.004
		40	11000	800	0.007	11000	650	0.006	8000	500	0.005	6400	400	0.003
		50	8400	610	0.006	7800	490	0.005	6000	380	0.004	4800	300	0.003
		60	7000	510	0.004	6500	400	0.004	5000	320	0.003	4000	260	0.002
		70	7000	480	0.003	6500	390	0.002	5000	300	0.002	4000	240	0.001
	1.5°	12	24000	2600	0.03	22000	2100	0.025	17000	1600	0.02	14000	1300	0.015
		16	22000	2400	0.03	21000	2000	0.025	16000	1500	0.02	13000	1200	0.015
		20	20000	1800	0.015	18000	1400	0.01	14000	1100	0.01	11000	880	0.007
		25	18000	1600	0.015	17000	1300	0.01	13000	1000	0.009	11000	800	0.006
		30	15000	1300	0.01	14000	1000	0.01	11000	800	0.008	8800	640	0.006
		35	14000	1100	0.008	13000	910	0.007	10000	700	0.006	8000	560	0.004

Depth of cut



RE:Radius

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

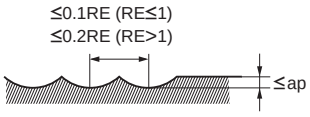
VF3XB

Ball nose, Medium cut length, 3 flute, Taper neck

RECOMMENDED CUTTING CONDITIONS

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R0.75	0.4°	10	18000	2700	0.06	17000	2200	0.05	13000	1700	0.04	10000	1400	0.03
		15	17000	2200	0.04	16000	1800	0.04	12000	1400	0.03	9600	1100	0.02
		20	17000	2100	0.03	16000	1700	0.025	12000	1300	0.02	9600	1000	0.015
		30	14000	1600	0.015	13000	1300	0.01	10000	1000	0.01	8000	800	0.007
	0.9°	15	17000	2400	0.04	16000	2000	0.04	12000	1500	0.03	9600	1200	0.02
		20	17000	2200	0.03	16000	1800	0.025	12000	1400	0.02	9600	1100	0.015
		30	14000	1800	0.015	13000	1400	0.01	10000	1100	0.01	8000	880	0.007
		40	13000	1300	0.01	12000	1000	0.01	9000	800	0.008	7200	640	0.006
	1.5°	15	17000	2600	0.04	16000	2100	0.04	12000	1600	0.03	9600	1300	0.02
		20	17000	2400	0.03	16000	2000	0.025	12000	1500	0.02	9600	1200	0.015
		30	14000	2000	0.015	13000	1600	0.01	10000	1200	0.01	8000	960	0.007
R1	0.4°	16	15000	3200	0.07	14000	2600	0.06	11000	2000	0.05	8800	1600	0.03
		20	14000	2400	0.06	13000	2000	0.05	10000	1500	0.04	8000	1200	0.03
		25	14000	2100	0.04	13000	1700	0.04	10000	1300	0.03	8000	1000	0.02
		30	13000	1800	0.03	12000	1400	0.03	9000	1100	0.025	7200	880	0.02
		35	13000	1600	0.03	12000	1300	0.025	9000	1000	0.02	7200	800	0.015
		40	12000	1400	0.015	11000	1200	0.01	8500	900	0.01	6800	720	0.007
	0.9°	20	14000	2600	0.06	13000	2100	0.05	10000	1600	0.04	8000	1300	0.03
		25	14000	2200	0.05	13000	1800	0.04	10000	1400	0.03	8000	1100	0.025
		30	13000	1900	0.04	12000	1600	0.04	9000	1200	0.03	7200	960	0.02
		35	13000	1800	0.04	12000	1400	0.03	9000	1100	0.025	7200	880	0.02
		40	12000	1600	0.03	11000	1300	0.025	8500	1000	0.02	6800	800	0.015
		50	11000	1400	0.015	10000	1200	0.01	8000	900	0.01	6400	720	0.007
		60	9800	1100	0.007	9100	910	0.006	7000	700	0.005	5600	560	0.003
		70	8400	960	0.004	7800	780	0.004	6000	600	0.003	4800	480	0.002
	1.5°	25	14000	2400	0.05	13000	2000	0.04	10000	1500	0.03	8000	1200	0.025
		30	12600	2100	0.04	12000	1700	0.04	9000	1300	0.03	7200	1000	0.02
		35	13000	1900	0.04	12000	1600	0.03	9000	1200	0.025	7200	960	0.02
		40	12000	1800	0.03	11000	1400	0.025	8500	1100	0.02	6800	880	0.015

Depth of cut

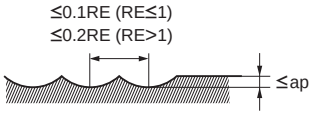


RE:Radius

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
R **RE** (mm)	Taper angle one side **BHTA2**	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R1.25	0.9°	20	13000	2900	0.06	12000	2300	0.05	9000	1800	0.04	7200	1400	0.03
		30	12000	2600	0.05	11000	2100	0.04	8500	1600	0.03	6800	1300	0.025
		40	11000	2200	0.04	9800	1800	0.04	7500	1400	0.03	6000	1100	0.02
	1.5°	20	13000	3000	0.06	12000	2500	0.05	9000	1900	0.04	7200	1500	0.03
		30	12000	2700	0.05	11050	2200	0.04	8500	1700	0.03	6800	1400	0.025
		40	11000	2400	0.04	9800	2000	0.04	7500	1500	0.03	6000	1200	0.02
R1.5	0.4°	20	12000	3700	0.13	11000	3000	0.1	8500	2300	0.09	6800	1800	0.06
		30	11000	2900	0.07	10000	2300	0.06	8000	1800	0.05	6400	1400	0.03
		40	11000	2400	0.06	10000	2000	0.05	8000	1500	0.04	6400	1200	0.03
		50	11000	2000	0.04	9800	1600	0.04	7500	1200	0.03	6000	960	0.02
	0.9°	20	12000	3800	0.13	11000	3100	0.1	8500	2400	0.09	6800	1900	0.06
		30	11000	3000	0.07	10000	2500	0.06	8000	1900	0.05	6400	1500	0.03
		40	11000	2600	0.06	10000	2100	0.05	8000	1600	0.04	6400	1300	0.03
		50	11000	2100	0.04	9800	1700	0.04	7500	1300	0.03	6000	1000	0.02
		60	9800	2000	0.03	9100	1600	0.025	7000	1200	0.02	5600	960	0.015
		70	9800	1800	0.015	9100	1400	0.01	7000	1100	0.01	5600	880	0.007
	1.5°	50	11000	2200	0.04	9800	1800	0.04	7500	1400	0.03	6000	1100	0.02
		60	9800	2100	0.03	9100	1700	0.025	7000	1300	0.02	5600	1000	0.015
		70	9800	2000	0.015	9100	1600	0.01	7000	1200	0.01	5600	960	0.007
R2	0.9°	30	10000	3200	0.3	9400	2600	0.25	7200	2000	0.2	5800	1600	0.15
		40	9500	2400	0.15	8800	2000	0.12	6800	1500	0.1	5400	1200	0.07
		50	9500	2100	0.1	8800	1700	0.1	6800	1300	0.08	5400	1000	0.06
		60	9000	1900	0.07	8300	1600	0.06	6400	1200	0.05	5100	960	0.03
R2.5	0.9°	35	8000	3500	0.3	7400	2900	0.25	5700	2200	0.2	4600	1800	0.15
		40	8000	3200	0.2	7400	2600	0.18	5700	2000	0.15	4600	1600	0.1
		60	7600	2400	0.15	7000	2000	0.12	5400	1500	0.1	4300	1200	0.07

Depth of cut



RE:Radius

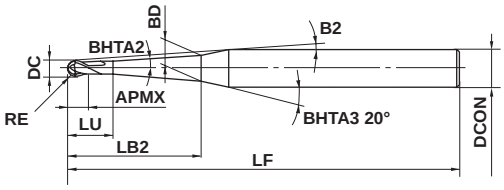
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

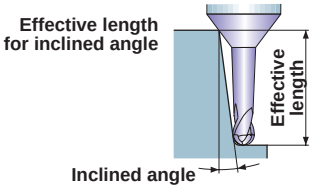
DF3XB

Ball nose, Medium cut length, 3 flute, Taper neck, For graphite

TOOL NEWS

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○





0.5≤RE≤2				
±0.01				
DCON=6				
0 / - 0.008				

●Ball nose taper end mill with Mitsubishi's unique diamond coating for graphite machining.

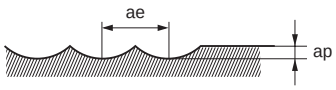
(mm)

Order Number	RE	DC	BHTA2	APMX	LU	LB2	B2	BD	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
DF3XBR0050L030	0.5	1	0.5°	1.5	3	30	4.0°	1.42	100	6	3	●	1	30.4	32.1	32.8	34.6
DF3XBR0050L040	0.5	1	0.5°	1.5	3	40	3.2°	1.60	100	6	3	●	1	40.4	41.4	43.6	46.0
DF3XBR0050L050	0.5	1	0.5°	1.5	3	50	2.6°	1.77	100	6	3	●	1	50.4	51.7	54.4	*
DF3XBR0100L040	1	2	0.5°	3	5	40	2.6°	2.52	100	6	3	●	1	40.7	41.7	43.9	*
DF3XBR0100L060	1	2	0.5°	3	5	60	1.8°	2.86	130	6	3	●	1	60.7	62.2	*	*
DF3XBR0100L080	1	2	0.5°	3	5	80	1.4°	3.21	130	6	3	●	1	80.7	82.7	*	*
DF3XBR0150L060	1.5	3	0.5°	4.5	7.5	60	1.4°	3.82	130	6	3	●	1	60.8	62.2	*	*
DF3XBR0150L080	1.5	3	0.5°	4.5	7.5	80	1.1°	4.17	130	6	3	●	1	80.8	82.8	*	*
DF3XBR0200L100	2	4	0.5°	6	9	100	0.6°	5.49	160	6	3	●	1	100.8	*	*	*

* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Graphite				Copper, Copper alloys			
R **RE** (mm)	Neck length **LB2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.5	30	20000	1100	0.05	0.13	16000	700	0.04	0.13
	40	15000	750	0.04	0.11	12000	480	0.03	0.11
	50	12000	500	0.03	0.10	9600	320	0.02	0.10
R1	40	20000	1800	0.13	0.40	16000	1100	0.10	0.40
	60	15000	900	0.09	0.27	12000	580	0.07	0.27
	80	12000	600	0.07	0.20	9600	380	0.06	0.20
R1.5	60	14000	1700	0.15	0.45	11000	1100	0.12	0.45
	80	12000	1200	0.12	0.35	9600	770	0.10	0.35
R2	100	10000	1100	0.20	0.50	8000	700	0.16	0.50
Depth of cut									

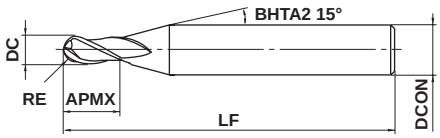
Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VC3MB

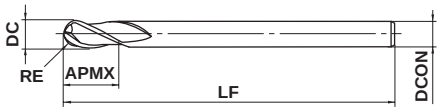
Ball nose end mill, Medium cut length, 3 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



Type1



Type2

RE≤6	RE>6			
±0.01	±0.02			
DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

●3 flute ball nose end mill for efficient machining.

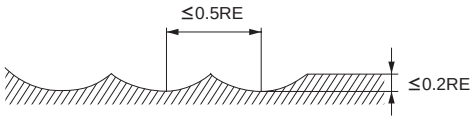
(mm)

Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VC3MBR0100	1	2	6	60	6	3	●	1
VC3MBR0150	1.5	3	8	70	6	3	●	1
VC3MBR0200	2	4	8	70	6	3	●	1
VC3MBR0250	2.5	5	12	80	6	3	●	1
VC3MBR0300	3	6	12	80	6	3	●	2
VC3MBR0400	4	8	14	90	8	3	●	2
VC3MBR0500	5	10	18	100	10	3	●	2
VC3MBR0600	6	12	22	110	12	3	●	2
VC3MBR0800	8	16	30	140	16	3	●	2
VC3MBR1000	10	20	38	160	20	3	●	2

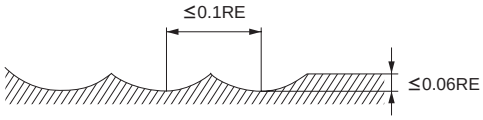
● : Inventory maintained in Japan.

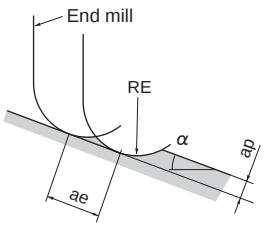
RECOMMENDED CUTTING CONDITIONS

■Roughing

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21				Hardened steel (45－55HRC) AISI H13			
R **RE** (mm)	α≤15°		α>15°		α≤15°		α>15°	
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
R 1	32000	3000	25000	1170	18000	1440	16000	640
R 2	18500	3700	14500	1460	11000	1760	9200	740
R 3	13000	4000	10000	1500	7700	1920	6400	800
R 4	10000	5000	8000	2000	6000	2300	4800	920
R 5	8000	5000	6500	2000	4800	2200	3800	870
R 6	6600	4600	5300	1800	4000	2100	3200	840
R 8	5000	4000	4000	1600	3000	1700	2400	680
R10	4000	3600	3200	1440	2400	1400	1900	550
Depth of cut	 RE:Radius							

■Finishing

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21				Hardened steel (45－55HRC) AISI H13			
R **RE** (mm)	α≤15°		α>15°		α≤15°		α>15°	
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
R 1	32000	3200	32000	1500	25000	2000	20000	800
R 2	25500	5000	20000	2000	17000	2700	13000	1000
R 3	20000	6100	15000	2200	13000	3200	10000	1200
R 4	15000	7500	11000	2700	10000	3800	7500	1400
R 5	12000	7500	9000	2700	8000	3700	6000	1400
R 6	10000	7000	7500	2500	6600	3500	5000	1300
R 8	7500	6000	5600	2200	5000	2800	3700	1000
R10	6000	5400	4500	2000	4000	2300	3000	900
Depth of cut	 RE:Radius							



ae:Pick Feed

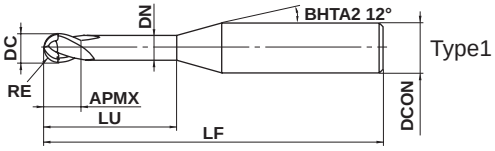
Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

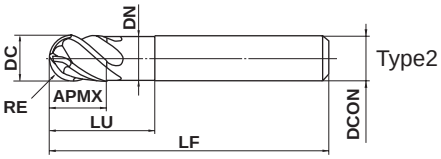
VQ4SVB

Ball nose, Medium cutting length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	





1≤RE≤6				
±0.01				
DC≤12				
0 / - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

- 4 flute ball nose end mill
- With the special substrate, suitable for finishing of heat resistance alloy, etc.

(mm)

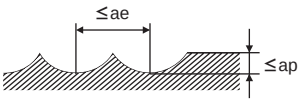
Order Number	RE	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VQ4SVBR0100	1	2	3	5	1.9	50	6	4	●	1
VQ4SVBR0150	1.5	3	4.5	7.5	2.9	50	6	4	●	1
VQ4SVBR0200	2	4	6	10	3.9	50	6	4	●	1
VQ4SVBR0250	2.5	5	7.5	12.5	4.9	50	6	4	●	1
VQ4SVBR0300	3	6	9	15	5.85	50	6	4	●	2
VQ4SVBR0400	4	8	12	20	7.85	60	8	4	●	2
VQ4SVBR0500	5	10	15	25	9.7	70	10	4	●	2
VQ4SVBR0600	6	12	18	30	11.7	75	12	4	●	2

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

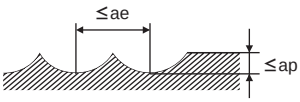
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Shoulder milling(Slotting)

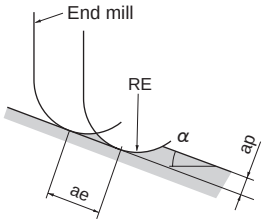
Work Material	Carbon steel, Alloy steel, Mild steel, Pre-hardened steel AISI 1045, AISI 4140, ASTM A36, AISI 1010, AISI P21, AISI P20, AISI 4340								Austenitic stainless steel, Titanium alloy, Precipitation hardeningstainless steel, Cobalt chromium alloy, Ferritic, Precipitation hardeningstainless steel AISI 304, AISI 316, Ti-6Al-4V, AISI 630, AISI 631, 15-5PH, 17-4PH, AISI 431, AISI 420							
R **RE** (mm)	α≤15°			α>15°			Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°			α>15°			Depth of cut ap (mm)	Depth of cut ae (mm)
	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)			Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 1	250	40000	8000	200	32000	3800	0.17	0.5	230	36000	6500	150	24000	2900	0.17	0.5
R 1.5	300	32000	7700	200	21000	3200	0.25	0.75	230	24000	4800	150	16000	1900	0.25	0.75
R 2	300	24000	5800	200	16000	2800	0.33	1	230	18000	4000	150	12000	1700	0.33	1
R 2.5	300	19000	5300	200	12700	2600	0.42	1.25	230	14400	3500	150	9600	1500	0.42	1.25
R 3	300	16000	4800	200	10600	2100	0.5	1.5	230	12000	3200	150	8000	1400	0.5	1.5
R 4	300	12000	4300	200	8000	1900	0.8	2	230	9000	3200	150	6000	1400	0.8	2
R 5	300	9600	4100	200	6400	1800	1	2.5	230	7200	3000	150	4800	1300	1	2.5
R 6	300	8000	4000	200	5300	1800	1.2	3	230	6000	3000	150	4000	1300	1.2	3
Depth of cut																

RE:Radius

Work Material	Copper, Copper alloy								Heat Resistant Alloy Inconel718							
R **RE** (mm)	α≤15°			α>15°			Depth of cut ap (mm)	Depth of cut ae (mm)	α≤15°			α>15°			Depth of cut ap (mm)	Depth of cut ae (mm)
	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)			Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)		
R 1	250	40000	8000	240	38000	4500	0.17	0.5	60	9600	960	40	6400	510	0.08	0.2
R 1.5	360	38000	9100	240	25000	3800	0.25	0.7	60	6400	640	40	4200	340	0.13	0.3
R 2	360	29000	7000	240	19000	3300	0.33	1	60	4800	580	40	3200	260	0.17	0.4
R 2.5	360	23000	6400	240	15000	3100	0.42	1.2	60	3800	530	39	2500	250	0.21	0.5
R 3	360	19000	5700	240	13000	2600	0.5	1.5	60	3200	500	40	2100	210	0.25	0.6
R 4	360	14000	5000	240	9600	2300	0.8	2	60	2400	430	40	1600	190	0.4	0.8
R 5	360	12000	5100	240	7700	2200	1	2.5	63	2000	420	41	1300	180	0.5	1
R 6	360	9600	4800	240	6400	2200	1.2	3	64	1700	350	41	1100	150	0.6	1.2
Depth of cut																

RE:Radius

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 5) α is the inclination angle of the machined surface.



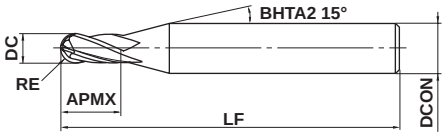
ae:Pick Feed

VF4MB

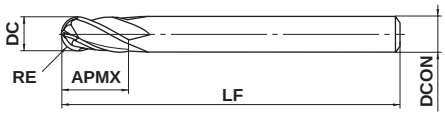
Ball nose, Medium cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

0.5≤RE≤6				
±0.01				
1≤DC≤12				
0 / - 0.020				
DCON=6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

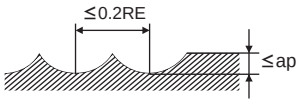
●4 flute ball nose end mill for high-speed machining of hardened steel.

(mm)

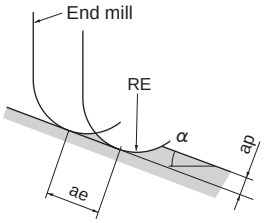
Order Number	RE	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF4MBR0050	0.5	1	2.5	50	6	4	●	1
VF4MBR0100	1	2	6	60	6	4	●	1
VF4MBR0150	1.5	3	8	70	6	4	●	1
VF4MBR0200	2	4	8	70	6	4	●	1
VF4MBR0250	2.5	5	12	80	6	4	●	1
VF4MBR0300	3	6	12	80	6	4	●	2
VF4MBR0400	4	8	14	90	8	4	●	2
VF4MBR0500	5	10	18	100	10	4	●	2
VF4MBR0600	6	12	22	110	12	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45－55HRC) AISI H13					Hardened steel (55－62HRC) AISI D2					Hardened steel (62－70HRC) AISI W1, AISI M2				
R **RE** (mm)	α≤15°		α>15°		Depth of cut ap(mm)	α≤15°		α>15°		Depth of cut ap(mm)	α≤15°		α>15°		Depth of cut ap(mm)
	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)		Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	
R0.5	40000	8000	40000	3800	0.06	40000	5600	40000	3100	0.05	40000	4700	32000	1700	0.03
R1	40000	9600	40000	5600	0.11	40000	8000	28000	3100	0.10	24000	5000	16000	1200	0.06
R1.5	40000	12000	32000	5600	0.13	32000	7700	19000	2900	0.12	16000	4200	11000	1100	0.07
R2	32000	11000	24000	4700	0.15	24000	6200	14000	2500	0.13	12000	3100	8000	1000	0.08
R2.5	25000	9000	19000	3800	0.20	19000	5300	12000	2200	0.15	9600	2700	6000	780	0.08
R3	21000	8400	15000	3400	0.25	16000	4800	9600	2000	0.20	8000	2300	5000	780	0.09
R4	16000	6400	12000	2600	0.30	12000	3600	7200	1600	0.20	6000	1900	4000	620	0.09
R5	13000	5200	9600	2200	0.50	10000	3200	5800	1300	0.20	4800	1500	3000	550	0.10
R6	9000	3600	7200	1700	0.50	7000	2200	4300	940	0.30	3600	1100	2200	400	0.10
Depth of cut	 RE:Radius														

Note 1) α is the inclination angle of the machined surface.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.



ae:Pick Feed

MS2MRB

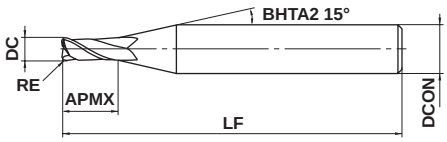
Corner radius end mill, Medium cut length, 2 flute

TOOL NEWS

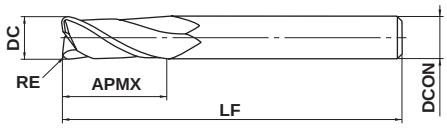
30°

DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

1≤DC≤12				
0 / - 0.020				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

h6

●2 flute corner radius end mill for general use.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2MRBD0100R010	1	0.1	2	40	4	2	●	1
MS2MRBD0100R020	1	0.2	2	40	4	2	●	1
MS2MRBD0100R030	1	0.3	2	40	4	2	●	1
MS2MRBD0150R010	1.5	0.1	3	40	4	2	●	1
MS2MRBD0150R020	1.5	0.2	3	40	4	2	●	1
MS2MRBD0150R030	1.5	0.3	3	40	4	2	●	1
MS2MRBD0150R050	1.5	0.5	3	40	4	2	●	1
MS2MRBD0200R010	2	0.1	4	40	4	2	●	1
MS2MRBD0200R020	2	0.2	4	40	4	2	●	1
MS2MRBD0200R030	2	0.3	4	40	4	2	●	1
MS2MRBD0200R050	2	0.5	4	40	4	2	●	1
MS2MRBD0250R010	2.5	0.1	5	40	4	2	●	1
MS2MRBD0250R020	2.5	0.2	5	40	4	2	●	1
MS2MRBD0250R030	2.5	0.3	5	40	4	2	●	1
MS2MRBD0250R050	2.5	0.5	5	40	4	2	●	1
MS2MRBD0300R010	3	0.1	6	50	6	2	●	1
MS2MRBD0300R020	3	0.2	6	50	6	2	●	1
MS2MRBD0300R030	3	0.3	6	50	6	2	●	1
MS2MRBD0300R050	3	0.5	6	50	6	2	●	1
MS2MRBD0300R100	3	1	6	50	6	2	●	1
MS2MRBD0400R010	4	0.1	8	50	6	2	●	1
MS2MRBD0400R020	4	0.2	8	50	6	2	●	1
MS2MRBD0400R030	4	0.3	8	50	6	2	●	1
MS2MRBD0400R050	4	0.5	8	50	6	2	●	1
MS2MRBD0400R100	4	1	8	50	6	2	●	1
MS2MRBD0500R010	5	0.1	10	50	6	2	●	1
MS2MRBD0500R020	5	0.2	10	50	6	2	●	1
MS2MRBD0500R030	5	0.3	10	50	6	2	●	1
MS2MRBD0500R050	5	0.5	10	50	6	2	●	1
MS2MRBD0500R100	5	1	10	50	6	2	●	1
MS2MRBD0600R010	6	0.1	12	50	6	2	●	2
MS2MRBD0600R020	6	0.2	12	50	6	2	●	2
MS2MRBD0600R030	6	0.3	12	50	6	2	●	2
MS2MRBD0600R050	6	0.5	12	50	6	2	●	2

● : Inventory maintained in Japan.

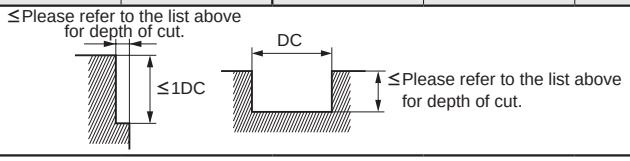
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MS2MRBD0600R100	6	1	12	50	6	2	●	2
MS2MRBD0600R150	6	1.5	12	50	6	2	●	2
MS2MRBD0600R200	6	2	12	50	6	2	●	2
MS2MRBD0800R020	8	0.2	16	60	8	2	●	2
MS2MRBD0800R030	8	0.3	16	60	8	2	●	2
MS2MRBD0800R050	8	0.5	16	60	8	2	●	2
MS2MRBD0800R100	8	1	16	60	8	2	●	2
MS2MRBD0800R150	8	1.5	16	60	8	2	●	2
MS2MRBD0800R200	8	2	16	60	8	2	●	2
MS2MRBD0800R250	8	2.5	16	60	8	2	●	2
MS2MRBD0800R300	8	3	16	60	8	2	●	2
MS2MRBD1000R020	10	0.2	20	70	10	2	●	2
MS2MRBD1000R030	10	0.3	20	70	10	2	●	2
MS2MRBD1000R050	10	0.5	20	70	10	2	●	2
MS2MRBD1000R100	10	1	20	70	10	2	●	2
MS2MRBD1000R150	10	1.5	20	70	10	2	●	2
MS2MRBD1000R200	10	2	20	70	10	2	●	2
MS2MRBD1000R250	10	2.5	20	70	10	2	●	2
MS2MRBD1000R300	10	3	20	70	10	2	●	2
MS2MRBD1200R020	12	0.2	24	75	12	2	●	2
MS2MRBD1200R030	12	0.3	24	75	12	2	●	2
MS2MRBD1200R050	12	0.5	24	75	12	2	●	2
MS2MRBD1200R100	12	1	24	75	12	2	●	2
MS2MRBD1200R150	12	1.5	24	75	12	2	●	2
MS2MRBD1200R200	12	2	24	75	12	2	●	2
MS2MRBD1200R250	12	2.5	24	75	12	2	●	2
MS2MRBD1200R300	12	3	24	75	12	2	●	2

MS2MRB

Corner radius end mill, Medium cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45−55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
0.1	40000	40	0.001	40000	40	0.001
0.2	40000	100	0.002	40000	100	0.002
0.3	40000	200	0.005	40000	200	0.005
0.4	40000	600	0.01	40000	600	0.01
0.5	40000	1000	0.015	40000	960	0.015
0.6	40000	1200	0.02	40000	1200	0.02
0.7	40000	1400	0.02	40000	1400	0.02
0.8	40000	1600	0.03	40000	1600	0.03
0.9	40000	1800	0.04	40000	1600	0.04
1	40000	2000	0.06	32000	1600	0.06
1.5	40000	3000	0.12	32000	1900	0.08
2	30000	3000	0.18	24000	1900	0.10
2.5	24000	2600	0.25	19000	1600	0.13
3	20000	2300	0.30	16000	1400	0.15
4	15000	2000	0.40	12000	1200	0.20
5	12000	1600	0.50	9000	900	0.25
6	10000	1400	0.60	7000	700	0.30
8	8000	1000	0.80	5600	550	0.40
10	6400	900	1.00	4500	500	0.50
12	5400	820	1.00	3800	450	0.50
16	2400	380	3.00	1200	100	0.80
20	1900	320	4.00	1000	80	1.00
Depth of cut	 DC:Dia.					

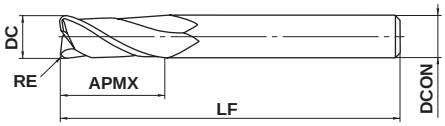
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50−70% and the feed rate to 40−60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

CRN2MRB

Corner radius, Medium cut length, 2 flute, For copper electrodes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○



Type1

6≤DC≤12				
0 / - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 / - 0.008	0 / - 0.009	0 / - 0.011		

h6

●2 flute corner radius end mill with CRN coating for copper electrode machining.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
CRN2MRBD0600R020	6	0.2	13	50	6	2	●	1
CRN2MRBD0600R030	6	0.3	13	50	6	2	●	1
CRN2MRBD0600R050	6	0.5	13	50	6	2	●	1
CRN2MRBD0600R100	6	1	13	50	6	2	●	1
CRN2MRBD0800R030	8	0.3	19	60	8	2	●	1
CRN2MRBD0800R050	8	0.5	19	60	8	2	●	1
CRN2MRBD0800R100	8	1	19	60	8	2	●	1
CRN2MRBD1000R030	10	0.3	22	70	10	2	●	1
CRN2MRBD1000R050	10	0.5	22	70	10	2	●	1
CRN2MRBD1000R100	10	1	22	70	10	2	●	1
CRN2MRBD1200R030	12	0.3	26	75	12	2	●	1
CRN2MRBD1200R050	12	0.5	26	75	12	2	●	1
CRN2MRBD1200R100	12	1	26	75	12	2	●	1

RECOMMENDED CUTTING CONDITIONS

Work Material		Copper, Copper alloys			
Dia. DC (mm)	Corner radius RE (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
6	R0.2, R0.3, R0.5	10000	1400	6	0.6
	R1	10000	1700	6	0.6
8	R0.3, R0.5	8000	1000	8	0.8
	R1	8000	1200	8	0.8
10	R0.3, R0.5	6400	900	10	1.0
	R1	6400	1100	10	1.0
12	R0.3, R0.5	5400	800	12	1.0
	R1	5400	1000	12	1.0
Depth of cut		≤ae ≤ap DC:Dia.			

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : **Inventory maintained in Japan.**

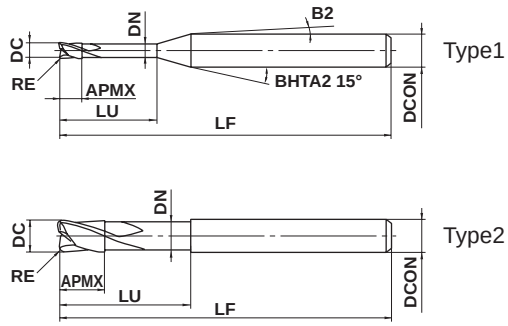
CRN2XLRB

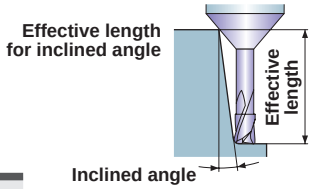
Corner radius, Medium cut length, 2 flute, For copper electrodes

TOOL NEWS

UWC CRN 30° DC<3 DC≥3

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						◎	○





0.5≤DC≤6			
0 / - 0.02			
4≤DCON≤6			
0 / - 0.008			

●2 flute long neck corner radius end mill with CRN coating for copper electrode machining.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
CRN2XLRBD0050R005N04	0.5	0.05	0.5	4	0.46	9.5°	50	4	2	●	1	4.1	4.3	4.6	5
CRN2XLRBD0050R010N04	0.5	0.1	0.5	4	0.46	9.5°	50	4	2	●	1	4.1	4.3	4.6	5
CRN2XLRBD0050R005N06	0.5	0.05	0.5	6	0.46	8°	50	4	2	●	1	6.2	6.4	6.9	7.5
CRN2XLRBD0050R010N06	0.5	0.1	0.5	6	0.46	8°	50	4	2	●	1	6.2	6.4	6.9	7.5
CRN2XLRBD0080R005N06	0.8	0.05	0.8	6	0.76	7.6°	50	4	2	●	1	6.3	6.5	7	7.6
CRN2XLRBD0080R010N06	0.8	0.1	0.8	6	0.76	7.6°	50	4	2	●	1	6.3	6.5	7	7.5
CRN2XLRBD0080R005N08	0.8	0.05	0.8	8	0.76	6.5°	50	4	2	●	1	8.3	8.6	9.3	10
CRN2XLRBD0080R010N08	0.8	0.1	0.8	8	0.76	6.6°	50	4	2	●	1	8.3	8.6	9.3	10
CRN2XLRBD0100R010N08	1	0.1	1	8	0.94	6.3°	50	4	2	●	1	8.5	8.8	9.5	10.2
CRN2XLRBD0100R030N08	1	0.3	1	8	0.94	6.3°	50	4	2	●	1	8.5	8.8	9.5	10.2
CRN2XLRBD0100R010N10	1	0.1	1	10	0.94	5.5°	55	4	2	●	1	10.6	11	11.8	12.7
CRN2XLRBD0100R030N10	1	0.3	1	10	0.94	5.5°	55	4	2	●	1	10.5	10.9	11.8	12.7
CRN2XLRBD0100R010N12	1	0.1	1	12	0.94	4.9°	55	4	2	●	1	12.6	13.1	14.1	15.2
CRN2XLRBD0100R030N12	1	0.3	1	12	0.94	4.9°	55	4	2	●	1	12.6	13.1	14.1	15.2
CRN2XLRBD0150R010N12	1.5	0.1	1.5	12	1.44	4.3°	55	4	2	●	1	12.6	13.1	14.1	15.2
CRN2XLRBD0150R020N12	1.5	0.2	1.5	12	1.44	4.3°	55	4	2	●	1	12.6	13.1	14.1	15.2
CRN2XLRBD0150R030N12	1.5	0.3	1.5	12	1.44	4.3°	55	4	2	●	1	12.6	13.1	14.1	15.2
CRN2XLRBD0150R010N20	1.5	0.1	1.5	20	1.44	2.9°	60	4	2	●	1	20.9	21.7	23.3	*
CRN2XLRBD0150R020N20	1.5	0.2	1.5	20	1.44	2.9°	60	4	2	●	1	20.9	21.7	23.3	*
CRN2XLRBD0150R030N20	1.5	0.3	1.5	20	1.44	3°	60	4	2	●	1	20.9	21.6	23.3	*
CRN2XLRBD0200R010N12	2	0.1	2	12	1.9	3.7°	55	4	2	●	1	12.5	13	14	15.1
CRN2XLRBD0200R020N12	2	0.2	2	12	1.9	3.7°	55	4	2	●	1	12.5	13	14	15.1
CRN2XLRBD0200R030N12	2	0.3	2	12	1.9	3.7°	55	4	2	●	1	12.5	13	13.9	15
CRN2XLRBD0200R050N12	2	0.5	2	12	1.9	3.8°	55	4	2	●	1	12.5	13	13.9	15
CRN2XLRBD0200R010N16	2	0.1	2	16	1.9	2.9°	55	4	2	●	1	16.7	17.3	18.6	*
CRN2XLRBD0200R020N16	2	0.2	2	16	1.9	2.9°	55	4	2	●	1	16.7	17.3	18.6	*
CRN2XLRBD0200R030N16	2	0.3	2	16	1.9	3°	55	4	2	●	1	16.7	17.3	18.5	*
CRN2XLRBD0200R050N16	2	0.5	2	16	1.9	3°	55	4	2	●	1	16.7	17.2	18.5	*
CRN2XLRBD0200R010N20	2	0.1	2	20	1.9	2.5°	60	4	2	●	1	20.8	21.6	23.2	*
CRN2XLRBD0200R020N20	2	0.2	2	20	1.9	2.5°	60	4	2	●	1	20.8	21.5	23.2	*
CRN2XLRBD0200R030N20	2	0.3	2	20	1.9	2.5°	60	4	2	●	1	20.8	21.5	23.1	*
CRN2XLRBD0200R050N20	2	0.5	2	20	1.9	2.5°	60	4	2	●	1	20.8	21.5	23.1	*
CRN2XLRBD0300R020N20	3	0.2	3	20	2.9	3.4°	65	6	2	●	1	20.8	21.5	23.2	25
CRN2XLRBD0300R030N20	3	0.3	3	20	2.9	3.4°	65	6	2	●	1	20.8	21.5	23.1	25

* No interference

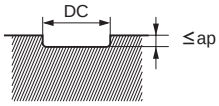
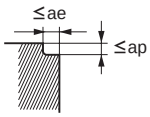
● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
CRN2XLRBD0300R050N20	3	0.5	3	20	2.9	3.4°	65	6	2	●	1	20.8	21.5	23.1	24.9
CRN2XLRBD0400R020N20	4	0.2	4	20	3.9	2.5°	65	6	2	●	1	20.8	21.5	23.2	*
CRN2XLRBD0400R030N20	4	0.3	4	20	3.9	2.5°	65	6	2	●	1	20.8	21.5	23.1	*
CRN2XLRBD0400R050N20	4	0.5	4	20	3.9	2.5°	65	6	2	●	1	20.8	21.5	23.1	*
CRN2XLRBD0500R020N25	5	0.2	5	25	4.9	1.1°	65	6	2	●	1	26	26.9	*	*
CRN2XLRBD0500R030N25	5	0.3	5	25	4.9	1.1°	65	6	2	●	1	26	26.9	*	*
CRN2XLRBD0500R050N25	5	0.5	5	25	4.9	1.1°	65	6	2	●	1	26	26.9	*	*
CRN2XLRBD0600R020N30	6	0.2	6	30	5.85	—	70	6	2	●	2	*	*	*	*
CRN2XLRBD0600R030N30	6	0.3	6	30	5.85	—	70	6	2	●	2	*	*	*	*
CRN2XLRBD0600R050N30	6	0.5	6	30	5.85	—	70	6	2	●	2	*	*	*	*
CRN2XLRBD0600R100N30	6	1	6	30	5.85	—	70	6	2	●	2	*	*	*	*

* No interference

RECOMMENDED CUTTING CONDITIONS

Work Material			Slotting: Copper, Copper alloys			Contour Cutting: Copper, Copper alloys			
Dia. **DC** (mm)	Corner radius **RE** (mm)	Neck length (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.5	R0.05, R0.1	4	40000	800	0.005	40000	1500	0.01	0.1
		6	40000	700	0.003	40000	1000	0.005	0.1
0.8	R0.05, R0.1	6	40000	1200	0.02	40000	2500	0.02	0.15
		8	40000	1200	0.015	40000	1600	0.01	0.15
1	R0.1, R0.3	8	40000	2000	0.03	40000	3000	0.03	0.2
		10	35000	1600	0.025	35000	2000	0.025	0.2
		12	30000	1200	0.02	30000	1800	0.02	0.2
1.5	R0.1, R0.2, R0.3	12	30000	1500	0.05	40000	4500	0.04	0.3
		20	20000	1000	0.02	20000	2000	0.02	0.3
2	R0.1, R0.2 R0.3, R0.5	12	30000	1500	0.1	40000	4500	0.08	0.4
		16	30000	1000	0.06	30000	3000	0.05	0.4
		20	20000	600	0.04	20000	2000	0.04	0.4
3	R0.2, R0.3	20	20000	2000	0.12	35000	6000	0.1	0.6
	R0.5	20	20000	2200	0.12	35000	8000	0.1	0.6
4	R0.2, R0.3	20	15000	2000	0.25	32000	5000	0.15	0.8
	R0.5	20	15000	2200	0.25	32000	7000	0.15	0.8
5	R0.2, R0.3	25	12000	1500	0.3	22000	5000	0.2	1.0
	R0.5	25	12000	1700	0.3	22000	7000	0.2	1.0
6	R0.2, R0.3, R0.5	30	10000	1200	0.4	20000	5000	0.25	1.2
	R1	30	10000	1500	0.4	20000	7000	0.25	1.2
Depth of cut			 DC:Dia.			 DC:Dia.			

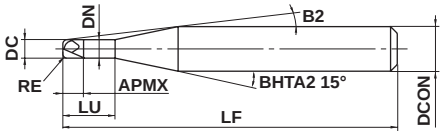
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Water-soluble cutting fluid is recommended.
Note 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

CBN2XLRB

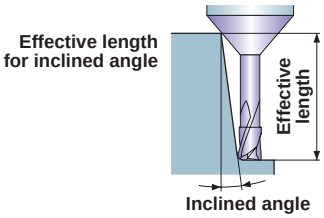
Corner radius end mill, Medium cut length, 2 flute, Long neck

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	◎	◎	◎				



Type1



0.05≤RE≤0.5				
±0.005				
0.5≤DC≤2				
0 / - 0.010				
DCON=4				
0 / - 0.005				

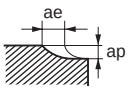
●CBN long neck radius end mill. A wide variation of neck lengths available.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
CBN2XLRBD0050R005N02	0.5	0.05	0.3	2	0.46	11.6°	51	4	2	●	1	2.1	2.1	2.3	2.5
CBN2XLRBD0050R005N03	0.5	0.05	0.3	3	0.46	10.4°	51	4	2	●	1	3.1	3.2	3.5	3.7
CBN2XLRBD0050R010N02	0.5	0.1	0.3	2	0.46	11.7°	51	4	2	●	1	2.1	2.1	2.3	2.5
CBN2XLRBD0050R010N03	0.5	0.1	0.3	3	0.46	10.5°	51	4	2	●	1	3.1	3.2	3.4	3.7
CBN2XLRBD0100R005N03	1	0.05	0.6	3	0.94	9.7°	51	4	2	●	1	3.2	3.4	3.7	4
CBN2XLRBD0100R005N05	1	0.05	0.6	5	0.94	7.9°	51	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0100R010N03	1	0.1	0.6	3	0.94	9.7°	51	4	2	●	1	3.2	3.4	3.6	4
CBN2XLRBD0100R010N05	1	0.1	0.6	5	0.94	8°	51	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0100R020N03	1	0.2	0.6	3	0.94	9.8°	51	4	2	●	1	3.2	3.4	3.5	4
CBN2XLRBD0100R020N05	1	0.2	0.6	5	0.94	8°	51	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0100R030N03	1	0.3	0.6	3	0.94	9.9°	51	4	2	●	1	3.2	3.4	3.4	4
CBN2XLRBD0100R030N05	1	0.3	0.6	5	0.94	8.1°	51	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0150R010N05	1.5	0.1	0.9	5	1.44	7.3°	52	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0150R010N08	1.5	0.1	0.9	8	1.44	5.6°	52	4	2	●	1	8.5	8.8	9.5	10.2
CBN2XLRBD0150R020N05	1.5	0.2	0.9	5	1.44	7.3°	52	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0150R020N08	1.5	0.2	0.9	8	1.44	5.6°	52	4	2	●	1	8.5	8.8	9.5	10.2
CBN2XLRBD0150R030N05	1.5	0.3	0.9	5	1.44	7.4°	52	4	2	●	1	5.3	5.6	6	6.5
CBN2XLRBD0150R030N08	1.5	0.3	0.9	8	1.44	5.7°	52	4	2	●	1	8.5	8.8	9.5	10.2
CBN2XLRBD0200R010N06	2	0.1	1.2	6	1.9	5.9°	52	4	2	●	1	6.3	6.6	7.1	7.6
CBN2XLRBD0200R010N10	2	0.1	1.2	10	1.9	4.2°	52	4	2	●	1	10.5	10.9	11.7	12.6
CBN2XLRBD0200R020N06	2	0.2	1.2	6	1.9	5.9°	52	4	2	●	1	6.3	6.6	7.1	7.6
CBN2XLRBD0200R020N10	2	0.2	1.2	10	1.9	4.2°	52	4	2	●	1	10.5	10.9	11.7	12.6
CBN2XLRBD0200R030N06	2	0.3	1.2	6	1.9	6°	52	4	2	●	1	6.3	6.6	7	7.6
CBN2XLRBD0200R030N10	2	0.3	1.2	10	1.9	4.2°	52	4	2	●	1	10.5	10.8	11.6	12.6
CBN2XLRBD0200R050N06	2	0.5	1.2	6	1.9	6.1°	52	4	2	●	1	6.3	6.5	7	7.5
CBN2XLRBD0200R050N10	2	0.5	1.2	10	1.9	4.3°	52	4	2	●	1	10.5	10.8	11.6	12.5

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2				Hardened steel (62−70HRC) AISI W1, AISI M2			
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.5	50000	750	0.01	0.2	50000	600	0.01	0.1	40000	400	0.005	0.06
1	38000	1100	0.02	0.3	38000	760	0.01	0.2	25000	400	0.01	0.1
1.5	25000	900	0.03	0.5	25000	700	0.02	0.4	17000	340	0.02	0.2
2	20000	800	0.04	0.7	20000	600	0.03	0.6	12000	300	0.02	0.3
Depth of cut												

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Oil mist coolant is recommended.
Note 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.

C3SARB

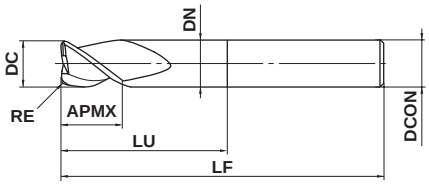
Corner radius, Short cut length, 3 flute, For aluminium alloy

TOOL NEWS

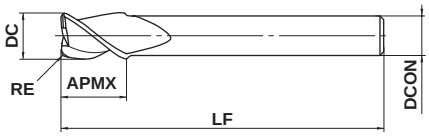
UWC

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
12≤DCON≤16	20≤DCON≤25			
0 - 0.011	0 - 0.013			

h6

●High efficiency machining for aluminium alloys.

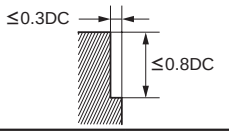
(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
C3SARBD1200N0300R100	12	1	15	30	11.4	75	12	3	●	1
C3SARBD1200N0300R320	12	3.2	15	30	11.4	75	12	3	●	1
C3SARBD1200N0400R100	12	1	15	40	11.4	125	12	3	●	1
C3SARBD1200N0400R320	12	3.2	15	40	11.4	125	12	3	●	1
C3SARBD1600N0450R100	16	1	15	45	15.4	125	16	3	●	1
C3SARBD1600N0450R320	16	3.2	15	45	15.4	125	16	3	●	1
C3SARBD1600N0700R100	16	1	15	70	15.4	150	16	3	●	1
C3SARBD1600N0700R320	16	3.2	15	70	15.4	150	16	3	●	1
C3SARBD1800R100	18	1	18	—	—	150	16	3	●	2
C3SARBD1800R320	18	3.2	18	—	—	150	16	3	●	2
C3SARBD2000N0600R100	20	1	20	60	18.0	125	20	3	●	1
C3SARBD2000N0600R320	20	3.2	20	60	18.0	125	20	3	●	1
C3SARBD2000N0600R400	20	4	20	60	18.0	125	20	3	●	1
C3SARBD2000N0850R100	20	1	20	85	18.0	150	20	3	●	1
C3SARBD2000N0850R320	20	3.2	20	85	18.0	150	20	3	●	1
C3SARBD2000N0850R400	20	4	20	85	18.0	150	20	3	●	1
C3SARBD2500N0650R320	25	3.2	20	65	23.0	125	25	3	●	1
C3SARBD2500N0650R400	25	4	20	65	23.0	125	25	3	●	1
C3SARBD2500N0650R500	25	5	20	65	23.0	125	25	3	●	1
C3SARBD2500N0900R320	25	3.2	20	90	23.0	150	25	3	●	1
C3SARBD2500N0900R400	25	4	20	90	23.0	150	25	3	●	1
C3SARBD2500N0900R500	25	5	20	90	23.0	150	25	3	●	1

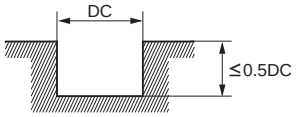
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
12	13000	5400
16	10000	5400
18	9000	5000
20	8000	5000
25	6000	4500
Depth of cut	 DC:Dia.	

■Slotting

Work Material	Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
12	13000	3200
16	10000	3200
18	9000	3000
20	8000	3000
25	6000	2800
Depth of cut	 DC:Dia.	

Note 1) Water-soluble cutting fluid is recommended.
Note 2) Climb cutting is recommended for side milling.
Note 3) This table shows the cutting condition with less than 4D overhang length. If more than 4D, spindle speed, feed rate and depth of cut should be reduced.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

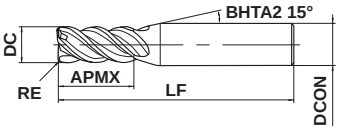
MPMHVRB

End mill, Medium cut length, 4 flute, Irregular helix flutes

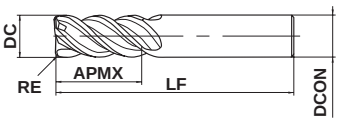
TOOL NEWS

37°
40°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		◎	◎	○	



Type1



Type2

0.1≤RE≤5				
±0.015				
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=4	DCON=6	DCON=8		
0 - 0.005	0 - 0.005	0 - 0.006		
DCON=8(DC=10)	DCON=10(DC=12)	DCON=10	12≤DCON≤16	DCON=20
0 - 0.009	0 - 0.009	0 - 0.009	0 - 0.011	0 - 0.013

h5

h6

●Irregular helix flutes end mill for reduced vibration when machining stainless steels and carbon steels.

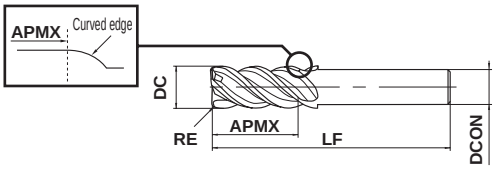
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MPMHVRBD0100R010	1	0.1	2.5	45	4	4	●	1
MPMHVRBD0100R020	1	0.2	2.5	45	4	4	●	1
MPMHVRBD0200R010	2	0.1	5	45	4	4	●	1
MPMHVRBD0200R020	2	0.2	5	45	4	4	●	1
MPMHVRBD0200R030	2	0.3	5	45	4	4	●	1
MPMHVRBD0200R050	2	0.5	5	45	4	4	●	1
MPMHVRBD0300R010	3	0.1	7.5	45	6	4	●	1
MPMHVRBD0300R020	3	0.2	7.5	45	6	4	●	1
MPMHVRBD0300R030	3	0.3	7.5	45	6	4	●	1
MPMHVRBD0300R050	3	0.5	7.5	45	6	4	●	1
MPMHVRBD0400R010	4	0.1	10	45	6	4	●	1
MPMHVRBD0400R020	4	0.2	10	45	6	4	●	1
MPMHVRBD0400R030	4	0.3	10	45	6	4	●	1
MPMHVRBD0400R050	4	0.5	10	45	6	4	●	1
MPMHVRBD0400R100	4	1	10	45	6	4	●	1
MPMHVRBD0500R010	5	0.1	12.5	50	6	4	●	1
MPMHVRBD0500R020	5	0.2	12.5	50	6	4	●	1
MPMHVRBD0500R030	5	0.3	12.5	50	6	4	●	1
MPMHVRBD0500R050	5	0.5	12.5	50	6	4	●	1
MPMHVRBD0500R100	5	1	12.5	50	6	4	●	1
MPMHVRBD0600R010	6	0.1	15	60	6	4	●	2
MPMHVRBD0600R020	6	0.2	15	60	6	4	●	2
MPMHVRBD0600R030	6	0.3	15	60	6	4	●	2
MPMHVRBD0600R050	6	0.5	15	60	6	4	●	2
MPMHVRBD0600R100	6	1	15	60	6	4	●	2
MPMHVRBD0800R020	8	0.2	20	70	8	4	●	2
MPMHVRBD0800R030	8	0.3	20	70	8	4	●	2
MPMHVRBD0800R050	8	0.5	20	70	8	4	●	2
MPMHVRBD0800R100	8	1	20	70	8	4	●	2
MPMHVRBD0800R150	8	1.5	20	70	8	4	●	2
MPMHVRBD0800R200	8	2	20	70	8	4	●	2
MPMHVRBD0800R250	8	2.5	20	70	8	4	●	2

● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MPMHVRBD0800R300	8	3	20	70	8	4	●	2
MPMHVRBD1000R020	10	0.2	25	80	10	4	●	2
MPMHVRBD1000R030	10	0.3	25	80	10	4	●	2
MPMHVRBD1000R050	10	0.5	25	80	10	4	●	2
MPMHVRBD1000R100	10	1	25	80	10	4	●	2
MPMHVRBD1000R150	10	1.5	25	80	10	4	●	2
MPMHVRBD1000R200	10	2	25	80	10	4	●	2
MPMHVRBD1000R250	10	2.5	25	80	10	4	●	2
MPMHVRBD1000R300	10	3	25	80	10	4	●	2
MPMHVRBD1200R030	12	0.3	30	100	12	4	●	2
MPMHVRBD1200R050	12	0.5	30	100	12	4	●	2
MPMHVRBD1200R100	12	1	30	100	12	4	●	2
MPMHVRBD1200R150	12	1.5	30	100	12	4	●	2
MPMHVRBD1200R200	12	2	30	100	12	4	●	2
MPMHVRBD1200R300	12	3	30	100	12	4	●	2
MPMHVRBD1600R030	16	0.3	40	110	16	4	●	2
MPMHVRBD1600R050	16	0.5	40	110	16	4	●	2
MPMHVRBD1600R100	16	1	40	110	16	4	●	2
MPMHVRBD1600R200	16	2	40	110	16	4	●	2
MPMHVRBD1600R300	16	3	40	110	16	4	●	2
MPMHVRBD1600R500	16	5	40	110	16	4	●	2
MPMHVRBD2000R030	20	0.3	50	125	20	4	●	2
MPMHVRBD2000R050	20	0.5	50	125	20	4	●	2
MPMHVRBD2000R100	20	1	50	125	20	4	●	2
MPMHVRBD2000R200	20	2	50	125	20	4	●	2
MPMHVRBD2000R300	20	3	50	125	20	4	●	2
MPMHVRBD2000R500	20	5	50	125	20	4	●	2



Type3

Slim Shank

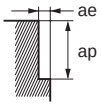
Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MPMHVRBD1000R030S08	10	0.3	25	100	8	4	●	3
MPMHVRBD1000R050S08	10	0.5	25	100	8	4	●	3
MPMHVRBD1000R100S08	10	1	25	100	8	4	●	3
MPMHVRBD1000R200S08	10	2	25	100	8	4	●	3
MPMHVRBD1200R030S10	12	0.3	30	110	10	4	●	3
MPMHVRBD1200R050S10	12	0.5	30	110	10	4	●	3
MPMHVRBD1200R100S10	12	1	30	110	10	4	●	3
MPMHVRBD1200R200S10	12	2	30	110	10	4	●	3
MPMHVRBD1200R300S10	12	3	30	110	10	4	●	3

MPMHVRB

End mill, Medium cut length, 4 flute, Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Alloy steel (180－280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450				Carbon steel, Alloy steel (280－350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT				Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V				Hardened steel (45－55HRC) AISI H13, AISI L6			
Dia. DC	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	38000	910	1.7	0.2	31000	500	1.7	0.2	25000	500	1.7	0.2	18000	290	1.7	0.05
2	21000	1500	3.5	0.4	17000	820	3.5	0.4	14000	640	3.5	0.4	10000	320	3.5	0.1
3	16000	1800	5	0.6	13000	940	5	0.6	11000	880	5	0.6	7400	380	5	0.15
4	12000	1700	7	0.8	9500	950	7	0.8	8000	900	7	0.8	5600	400	7	0.2
5	9500	1800	8.5	1	7600	1100	8.5	1	6400	900	8.5	1	4500	430	8.5	0.25
6	8000	2100	10	1.2	6400	1300	10	1.2	5300	1100	10	1.2	3700	440	10	0.3
8	6000	2000	13.5	1.6	4800	1400	13.5	1.6	4000	1200	13.5	1.6	2800	450	13.5	0.4
10	4800	2100	17	2	3800	1500	17	2	3200	1100	17	2	2200	440	17	0.5
12	4000	1900	20.5	2.4	3200	1400	20.5	2.4	2700	1100	20.5	2.4	1900	380	20.5	0.6
16	3000	1400	27.2	3.2	2400	1100	27.2	3.2	2000	840	27.2	3.2	1400	340	27.2	0.8
20	2400	1200	34	4	1900	840	34	4	1600	670	34	4	1100	260	34	1
Depth of cut																

Note 1) When using a slim shank with DC=10 or 12, reduce the cutting speed by 60%, the feed rate by 80%, and the depth of cutting ae by 50% from the above conditions.

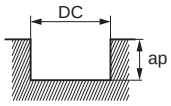
Note 2) Wet cutting mode is recommended for cutting stainless steels and titanium alloys, and air blow is recommended for carbon steels.

Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

Slotting

Work Material	Carbon steel, Alloy steel (180－280HB) Ductile cast iron AISI 1045, AISI 4140, FCD450			Carbon steel, Alloy steel (280－350HB) Pre-hardened steel, Alloy tool steel AISI 4340, AISI P21, AISI P20, SKD, SKT			Austenitic stainless steel (≤200HB) Titanium alloy AISI 304, AISI 306, Ti-6Al-4V			Hardened steel (45－55HRC) AISI H13, AISI L6		
Dia. **DC**	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	31000	620	0.5	24000	380	0.5	20000	320	0.5	9500	110	0.2
2	17000	650	2	14000	450	2	11000	350	2	4800	130	0.4
3	13000	940	3	10000	660	3	8500	510	3	3200	140	0.6
4	9500	820	4	7600	600	4	6400	460	4	2400	150	0.8
5	7600	910	5	6100	670	5	5100	510	5	1900	170	1
6	6400	860	6	5100	630	6	4200	470	6	1600	190	1.2
8	4800	1000	8	3800	750	8	3200	580	8	1200	190	1.6
10	3800	910	10	3100	680	10	2500	500	10	950	150	2
12	3200	920	12	2500	660	12	2100	500	12	800	160	2.4
16	2400	690	16	1900	500	16	1600	380	16	600	120	3.2
20	1900	550	20	1500	400	20	1300	310	20	480	96	4

Depth of cut



DC:Dia.

Note 4) Slim shank type is not recommended for slotting.

MPXLRB

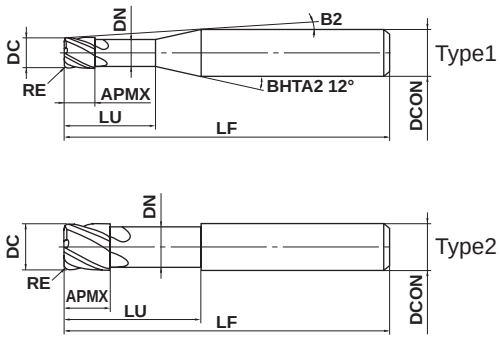
Corner radius, short cut length, long neck

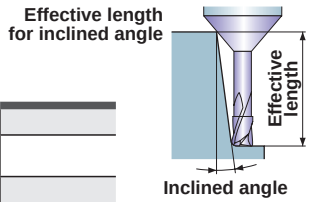
TOOL NEWS

30°

DC≤0.3 DC≥0.4

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		○	○	○	





0.05≤RE≤0.5				
±0.005				
0.2≤DC≤6				
0 - 0.01				
4≤DCON≤6				
0 - 0.005				

h5

●Suitable for high precision and high efficient machining of die & mold.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
MPXLRBD0020R005N005	0.2	0.05	0.2	0.5	0.18	11.4°	50	4	2	●	1	0.5	0.5	0.6	0.7
MPXLRBD0020R005N010	0.2	0.05	0.2	1	0.18	10.8°	50	4	2	●	1	1.0	1.1	1.2	1.3
MPXLRBD0030R005N010	0.3	0.05	0.3	1	0.28	10.8°	50	4	2	●	1	1.0	1.1	1.2	1.3
MPXLRBD0030R005N020	0.3	0.05	0.3	2	0.28	9.8°	50	4	2	●	1	2.1	2.2	2.4	2.7
MPXLRBD0040R005N020	0.4	0.05	0.4	2	0.37	9.8°	50	4	4	●	1	2.1	2.2	2.4	2.6
MPXLRBD0040R005N030	0.4	0.05	0.4	3	0.37	8.9°	50	4	4	●	1	3.1	3.3	3.6	4.0
MPXLRBD0040R005N040	0.4	0.05	0.4	4	0.37	8.2°	50	4	4	●	1	4.2	4.3	4.8	5.3
MPXLRBD0050R005N020	0.5	0.05	0.5	2	0.47	9.7°	50	4	4	●	1	2.1	2.2	2.4	2.6
MPXLRBD0050R005N030	0.5	0.05	0.5	3	0.47	8.9°	50	4	4	●	1	3.1	3.3	3.6	4.0
MPXLRBD0050R005N040	0.5	0.05	0.5	4	0.47	8.1°	50	4	4	●	1	4.2	4.3	4.8	5.3
MPXLRBD0050R005N050	0.5	0.05	0.5	5	0.47	7.5°	50	4	4	●	1	5.2	5.4	6.0	6.6
MPXLRBD0060R005N020	0.6	0.05	0.6	2	0.57	9.7°	50	4	4	●	1	2.1	2.2	2.4	2.6
MPXLRBD0060R005N040	0.6	0.05	0.6	4	0.57	8.1°	50	4	4	●	1	4.2	4.3	4.8	5.3
MPXLRBD0060R005N060	0.6	0.05	0.6	6	0.57	6.9°	50	4	4	●	1	6.2	6.5	7.2	7.9
MPXLRBD0080R005N040	0.8	0.05	0.8	4	0.77	7.9°	50	4	4	●	1	4.2	4.3	4.8	5.3
MPXLRBD0080R005N060	0.8	0.05	0.8	6	0.77	6.8°	50	4	4	●	1	6.2	6.5	7.2	7.9
MPXLRBD0100R005N030	1	0.05	1	3	0.96	8.3°	50	4	4	●	1	3.2	3.4	3.8	4.2
MPXLRBD0100R005N040	1	0.05	1	4	0.96	7.6°	50	4	4	●	1	4.3	4.5	5.0	5.6
MPXLRBD0100R005N050	1	0.05	1	5	0.96	7.0°	50	4	4	●	1	5.4	5.6	6.2	6.9
MPXLRBD0100R005N060	1	0.05	1	6	0.96	6.5°	50	4	4	●	1	6.4	6.7	7.4	8.2
MPXLRBD0100R005N080	1	0.05	1	8	0.96	5.6°	50	4	4	●	1	8.5	8.9	9.8	10.9
MPXLRBD0100R005N100	1	0.05	1	10	0.96	5.0°	50	4	4	●	1	10.6	11.1	12.2	13.5
MPXLRBD0100R005N120	1	0.05	1	12	0.96	4.5°	50	4	4	●	1	12.7	13.3	14.6	16.2
MPXLRBD0100R010N030	1	0.1	1	3	0.96	8.4°	50	4	4	●	1	3.2	3.4	3.8	4.2
MPXLRBD0100R010N040	1	0.1	1	4	0.96	7.6°	50	4	4	●	1	4.3	4.5	5.0	5.5
MPXLRBD0100R010N050	1	0.1	1	5	0.96	7.0°	50	4	4	●	1	5.3	5.6	6.2	6.9
MPXLRBD0100R010N060	1	0.1	1	6	0.96	6.5°	50	4	4	●	1	6.4	6.7	7.4	8.2
MPXLRBD0100R010N080	1	0.1	1	8	0.96	5.6°	50	4	4	●	1	8.5	8.9	9.8	10.8
MPXLRBD0100R010N100	1	0.1	1	10	0.96	5.0°	50	4	4	●	1	10.6	11.1	12.2	13.5
MPXLRBD0100R010N120	1	0.1	1	12	0.96	4.5°	50	4	4	●	1	12.7	13.3	14.6	16.2
MPXLRBD0120R010N100	1.2	0.1	1.2	10	1.16	4.8°	50	4	4	●	1	10.6	11.1	12.2	13.5
MPXLRBD0120R020N100	1.2	0.2	1.2	10	1.16	4.8°	50	4	4	●	1	10.6	11.1	12.2	13.5
MPXLRBD0150R010N060	1.5	0.1	1.5	6	1.44	6.0°	50	4	4	●	1	6.4	6.7	7.3	8.1
MPXLRBD0150R010N120	1.5	0.1	1.5	12	1.44	4.0°	50	4	4	●	1	12.6	13.2	14.5	16.1

● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MPXLRBD0150R010N180	1.5	0.1	1.5	18	1.44	3.0°	60	4	4	●	1	18.9	19.7	21.7	24.0
MPXLRBD0150R020N060	1.5	0.2	1.5	6	1.44	6.0°	50	4	4	●	1	6.4	6.7	7.3	8.1
MPXLRBD0150R020N120	1.5	0.2	1.5	12	1.44	4.0°	50	4	4	●	1	12.6	13.2	14.5	16.0
MPXLRBD0150R020N180	1.5	0.2	1.5	18	1.44	3.0°	60	4	4	●	1	18.9	19.7	21.7	*
MPXLRBD0150R030N060	1.5	0.3	1.5	6	1.44	6.1°	50	4	4	●	1	6.3	6.6	7.3	8.0
MPXLRBD0150R030N120	1.5	0.3	1.5	12	1.44	4.0°	50	4	4	●	1	12.6	13.2	14.5	16.0
MPXLRBD0150R030N180	1.5	0.3	1.5	18	1.44	3.0°	60	4	4	●	1	18.9	19.7	21.6	*
MPXLRBD0200R010N080	2	0.1	2	8	1.94	4.5°	50	4	4	●	1	8.5	8.8	9.7	10.8
MPXLRBD0200R010N120	2	0.1	2	12	1.94	3.4°	50	4	4	●	1	12.6	13.2	14.5	16.1
MPXLRBD0200R010N160	2	0.1	2	16	1.94	2.8°	60	4	4	●	1	16.8	17.6	19.3	*
MPXLRBD0200R010N200	2	0.1	2	20	1.94	2.3°	60	4	4	●	1	21.0	21.9	24.1	*
MPXLRBD0200R010N240	2	0.1	2	24	1.94	2.0°	70	4	4	●	1	25.2	26.3	*	*
MPXLRBD0200R020N080	2	0.2	2	8	1.94	4.5°	50	4	4	●	1	8.5	8.8	9.7	10.7
MPXLRBD0200R020N120	2	0.2	2	12	1.94	3.4°	50	4	4	●	1	12.6	13.2	14.5	*
MPXLRBD0200R020N160	2	0.2	2	16	1.94	2.8°	60	4	4	●	1	16.8	17.6	19.3	*
MPXLRBD0200R020N200	2	0.2	2	20	1.94	2.3°	60	4	4	●	1	21.0	21.9	24.0	*
MPXLRBD0200R020N240	2	0.2	2	24	1.94	2.0°	70	4	4	●	1	25.1	26.3	*	*
MPXLRBD0200R030N080	2	0.3	2	8	1.94	4.5°	50	4	4	●	1	8.5	8.8	9.7	10.7
MPXLRBD0200R030N120	2	0.3	2	12	1.94	3.5°	50	4	4	●	1	12.6	13.2	14.5	16.0
MPXLRBD0200R030N160	2	0.3	2	16	1.94	2.8°	60	4	4	●	1	16.8	17.5	19.2	*
MPXLRBD0200R030N200	2	0.3	2	20	1.94	2.3°	60	4	4	●	1	21.0	21.9	24.0	*
MPXLRBD0200R030N240	2	0.3	2	24	1.94	2.0°	70	4	4	●	1	25.1	26.3	*	*
MPXLRBD0300R010N080	3	0.1	3	8	2.9	5.7°	60	6	4	●	1	8.4	8.8	9.6	10.7
MPXLRBD0300R010N120	3	0.1	3	12	2.9	4.5°	60	6	4	●	1	12.6	13.1	14.4	16.0
MPXLRBD0300R010N180	3	0.1	3	18	2.9	3.4°	70	6	4	●	1	18.8	19.7	21.6	23.9
MPXLRBD0300R010N240	3	0.1	3	24	2.9	2.8°	70	6	4	●	1	25.1	26.2	28.8	*
MPXLRBD0300R010N300	3	0.1	3	30	2.9	2.3°	70	6	4	●	1	31.3	32.7	35.9	*
MPXLRBD0300R010N360	3	0.1	3	36	2.9	2.0°	90	6	4	●	1	37.6	39.3	*	*
MPXLRBD0300R020N120	3	0.2	3	12	2.9	4.5°	60	6	4	●	1	12.6	13.1	14.4	15.9
MPXLRBD0300R020N180	3	0.2	3	18	2.9	3.4°	60	6	4	●	1	18.8	19.6	21.6	23.9
MPXLRBD0300R020N240	3	0.2	3	24	2.9	2.8°	70	6	4	●	1	25.1	26.2	28.7	*
MPXLRBD0300R020N300	3	0.2	3	30	2.9	2.3°	70	6	4	●	1	31.3	32.7	35.9	*
MPXLRBD0300R020N360	3	0.2	3	36	2.9	2.0°	90	6	4	●	1	37.6	39.3	43.1	*
MPXLRBD0300R030N120	3	0.3	3	12	2.9	4.5°	60	6	4	●	1	12.5	13.1	14.4	15.9
MPXLRBD0300R030N180	3	0.3	3	18	2.9	3.5°	60	6	4	●	1	18.8	19.6	21.5	23.9
MPXLRBD0300R030N240	3	0.3	3	24	2.9	2.8°	70	6	4	●	1	25.1	26.2	28.7	*
MPXLRBD0300R030N300	3	0.3	3	30	2.9	2.3°	70	6	4	●	1	31.3	32.7	35.9	*
MPXLRBD0300R030N360	3	0.3	3	36	2.9	2.0°	90	6	4	●	1	37.6	39.2	*	*
MPXLRBD0300R050N120	3	0.5	3	12	2.9	4.6°	60	6	4	●	1	12.5	13.1	14.3	15.8
MPXLRBD0300R050N180	3	0.5	3	18	2.9	3.5°	60	6	4	●	1	18.8	19.6	21.5	23.8
MPXLRBD0300R050N240	3	0.5	3	24	2.9	2.8°	70	6	4	●	1	25.1	26.2	28.7	*
MPXLRBD0300R050N300	3	0.5	3	30	2.9	2.3°	70	6	4	●	1	31.3	32.7	35.9	*
MPXLRBD0300R050N360	3	0.5	3	36	2.9	2.0°	90	6	4	●	1	37.6	39.2	*	*
MPXLRBD0400R010N160	4	0.1	4	16	3.9	2.8°	70	6	4	●	1	16.7	17.5	19.2	*
MPXLRBD0400R010N240	4	0.1	4	24	3.9	2.0°	70	6	4	●	1	25.1	26.2	*	*
MPXLRBD0400R010N320	4	0.1	4	32	3.9	1.6°	70	6	4	●	1	33.4	34.9	*	*
MPXLRBD0400R010N480	4	0.1	4	48	3.9	1.1°	90	6	4	●	1	50.1	52.3	*	*
MPXLRBD0400R020N160	4	0.2	4	16	3.9	2.8°	70	6	4	●	1	16.7	17.5	19.2	*
MPXLRBD0400R020N240	4	0.2	4	24	3.9	2.0°	70	6	4	●	1	25.1	26.2	*	*
MPXLRBD0400R020N320	4	0.2	4	32	3.9	1.6°	70	6	4	●	1	33.4	34.9	*	*
MPXLRBD0400R020N480	4	0.2	4	48	3.9	1.1°	90	6	4	●	1	50.1	52.3	*	*
MPXLRBD0400R030N160	4	0.3	4	16	3.9	2.8°	70	6	4	●	1	16.7	17.5	19.1	*

* No interference

MPXLRB

Corner radius, short cut length, long neck

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
MPXLRBD0400R030N240	4	0.3	4	24	3.9	2.0°	70	6	4	●	1	25.1	26.2	*	*
MPXLRBD0400R030N320	4	0.3	4	32	3.9	1.6°	70	6	4	●	1	33.4	34.9	*	*
MPXLRBD0400R030N480	4	0.3	4	48	3.9	1.1°	90	6	4	●	1	50.1	52.3	*	*
MPXLRBD0400R050N160	4	0.5	4	16	3.9	2.8°	70	6	4	●	1	16.7	17.4	19.1	*
MPXLRBD0400R050N240	4	0.5	4	24	3.9	2.0°	70	6	4	●	1	25.1	26.2	*	*
MPXLRBD0400R050N320	4	0.5	4	32	3.9	1.6°	70	6	4	●	1	33.4	34.9	*	*
MPXLRBD0400R050N480	4	0.5	4	48	3.9	1.1°	90	6	4	●	1	50.1	52.3	*	*
MPXLRBD0600R010N240	6	0.1	6	24	5.85	–	70	6	4	●	2	*	*	*	*
MPXLRBD0600R010N480	6	0.1	6	48	5.85	–	100	6	4	●	2	*	*	*	*
MPXLRBD0600R020N240	6	0.2	6	24	5.85	–	70	6	4	●	2	*	*	*	*
MPXLRBD0600R020N480	6	0.2	6	48	5.85	–	100	6	4	●	2	*	*	*	*
MPXLRBD0600R030N240	6	0.3	6	24	5.85	–	70	6	4	●	2	*	*	*	*
MPXLRBD0600R030N480	6	0.3	6	48	5.85	–	100	6	4	●	2	*	*	*	*
MPXLRBD0600R050N240	6	0.5	6	24	5.85	–	70	6	4	●	2	*	*	*	*
MPXLRBD0600R050N480	6	0.5	6	48	5.85	–	100	6	4	●	2	*	*	*	*

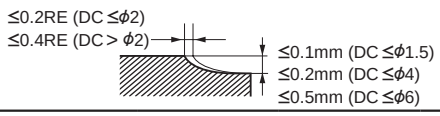
* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel, Alloy steel (180−280HB) Pre-hardened steel, Alloy Tool Steel, Precipitation hardeningstainless steel (<450HB) AISI 1045, AISI 4140, AISI P21, AISI P20, SKD, SKT, AISI 431, AISI 420				Hardened steel (45−52HRC) AISI H13, AISI L6			
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.5	30000	180	0.003	0.04	30000	150	0.003	0.04
	1	30000	120	0.003	0.04	30000	100	0.003	0.04
0.3	1	30000	210	0.003	0.08	30000	180	0.003	0.08
	2	30000	120	0.003	0.08	30000	100	0.003	0.08
0.4	2	31000	970	0.005	0.10	31000	810	0.005	0.10
	3	31000	790	0.004	0.10	31000	660	0.004	0.10
	4	31000	540	0.003	0.10	31000	450	0.003	0.10
0.5	2	31000	1500	0.006	0.12	31000	1300	0.006	0.12
	3	31000	1300	0.005	0.12	31000	1100	0.005	0.12
	4	31000	970	0.004	0.12	31000	810	0.004	0.12
	5	25000	790	0.004	0.12	25000	660	0.004	0.12
0.6	2	31000	2100	0.020	0.13	31000	1800	0.020	0.13
	4	25000	1300	0.015	0.13	25000	1100	0.015	0.13
	6	20000	790	0.008	0.13	20000	660	0.008	0.13
0.8	4	25000	3200	0.025	0.20	25000	2700	0.025	0.20
	6	20000	2100	0.020	0.20	20000	1800	0.020	0.20
1	3	24000	2400	0.045	0.30	20000	2000	0.045	0.30
	4	24000	1900	0.040	0.30	20000	1600	0.040	0.30
	5	24000	1800	0.035	0.25	20000	1500	0.035	0.25
	6	20000	1400	0.030	0.25	17000	1200	0.030	0.25
	8	20000	1000	0.020	0.20	17000	880	0.020	0.20
	10	15000	800	0.015	0.10	13000	670	0.015	0.10
	12	15000	370	0.010	0.01	13000	310	0.010	0.01
1.2	10	18000	1500	0.030	0.25	15000	1300	0.030	0.25
1.5	6	20000	2400	0.050	0.40	17000	2000	0.050	0.40
	12	15000	1400	0.040	0.30	13000	1200	0.040	0.30
	18	12000	670	0.010	0.15	10000	560	0.010	0.15
2	8	15000	2600	0.050	0.50	13000	2200	0.050	0.50
	12	15000	2100	0.045	0.50	13000	1800	0.045	0.50
	16	14000	1900	0.040	0.35	12000	1600	0.040	0.35
	20	14000	1100	0.015	0.25	12000	960	0.015	0.25
	24	9300	930	0.010	0.20	7800	780	0.010	0.20
3	8	12000	3300	0.100	0.80	10000	2800	0.100	0.80
	12	12000	3100	0.080	0.80	10000	2600	0.080	0.80
	18	11000	3100	0.070	0.70	9600	2600	0.070	0.70
	24	11000	2600	0.060	0.50	9300	2200	0.060	0.50
	30	9000	1300	0.030	0.40	7500	1100	0.030	0.40
	36	6200	910	0.010	0.30	5200	760	0.010	0.30
4	16	9000	3200	0.100	1.00	7500	2700	0.100	1.00
	24	7900	2500	0.085	0.80	6600	2100	0.085	0.80
	32	6900	1600	0.040	0.70	5800	1400	0.040	0.70
	48	4800	740	0.010	0.35	4000	620	0.010	0.35
6	24	5500	2700	0.120	1.50	4600	2263	0.120	1.50
	48	3800	1200	0.050	1.20	3200	1000	0.050	1.20

Depth of cut



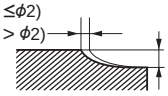
DC:Dia.

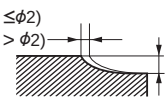
Note 1) The cutting conditions above are a guide only to machining with cutting edges with a corner radius. When machining with peripheral cutting edges, use the minimum feed rate as a guide.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

MPXLRB

Corner radius, short cut length, long neck

RECOMMENDED CUTTING CONDITIONS

Work Material		Austenitic stainless steel (≤200HB) Titanium alloy (<450HB) AISI 304, AISI 306, Ti-6Al-4V			
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.5	33000	170	0.003	0.04
	1	30000	110	0.003	0.04
0.3	1	30000	200	0.003	0.08
	2	30000	110	0.003	0.08
0.4	2	31000	930	0.005	0.10
	3	31000	750	0.004	0.10
	4	31000	510	0.003	0.10
0.5	2	31000	1400	0.006	0.12
	3	31000	1200	0.005	0.12
	4	31000	930	0.004	0.12
	5	25000	750	0.004	0.12
0.6	2	31000	2000	0.020	0.13
	4	25000	1200	0.015	0.13
	6	20000	750	0.008	0.13
0.8	4	25000	3100	0.025	0.20
	6	20000	2000	0.020	0.20
1	3	23000	2300	0.045	0.30
	4	23000	1800	0.040	0.30
	5	23000	1700	0.035	0.25
	6	19000	1300	0.030	0.25
	8	19000	1000	0.020	0.20
	10	14000	770	0.015	0.10
	12	14000	350	0.010	0.01
1.2	10	17000	1400	0.030	0.25
1.5	6	19000	2300	0.050	0.40
	12	14000	1300	0.040	0.30
	18	11000	640	0.010	0.15
2	8	14000	2500	0.050	0.50
	12	14000	2000	0.045	0.50
	16	13000	1800	0.040	0.35
	20	13000	1100	0.015	0.25
	24	8900	890	0.010	0.20
3	8	11000	3200	0.100	0.80
	12	11000	2900	0.080	0.80
	18	11000	2900	0.070	0.70
	24	10000	2500	0.060	0.50
	30	8600	1200	0.030	0.40
	36	5900	870	0.010	0.30
4	16	8600	3100	0.100	1.00
	24	7500	2400	0.085	0.80
	32	6600	1600	0.040	0.70
	48	4600	710	0.010	0.35
6	24	5200	2600	0.120	1.50
	48	3600	1100	0.050	1.20
Depth of cut		≤0.2RE (DC ≤ϕ2) ≤0.4RE (DC > ϕ2)  ≤0.1mm (DC ≤ϕ1.5) ≤0.2mm (DC ≤ϕ4) ≤0.5mm (DC ≤ϕ6) DC:Dia.			

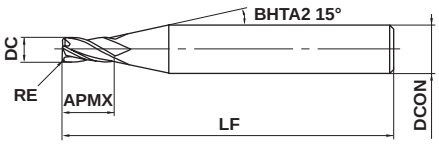
Work Material		Copper, Copper alloys			
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.2	0.5	30000	150	0.003	0.08
	1	30000	100	0.003	0.08
0.3	1	30000	180	0.003	0.16
	2	30000	100	0.003	0.16
0.4	2	31000	810	0.005	0.20
	3	31000	660	0.004	0.20
	4	31000	450	0.003	0.20
0.5	2	31000	1300	0.006	0.24
	3	31000	1100	0.005	0.24
	4	31000	810	0.004	0.24
	5	25000	660	0.004	0.24
0.6	2	31000	1800	0.020	0.26
	4	25000	1100	0.015	0.26
	6	20000	660	0.008	0.26
0.8	4	25000	2700	0.025	0.40
	6	20000	1800	0.020	0.40
1	3	20000	2000	0.045	0.60
	4	20000	1600	0.040	0.60
	5	20000	1500	0.035	0.50
	6	17000	1200	0.030	0.50
	8	17000	880	0.020	0.40
	10	13000	670	0.015	0.20
	12	13000	310	0.010	0.02
1.2	10	15000	1300	0.030	0.50
1.5	6	14700	1700	0.050	0.80
	12	11000	1000	0.040	0.60
	18	8600	480	0.010	0.30
2	8	11000	1900	0.050	1.00
	12	11000	1500	0.045	1.00
	16	10000	1300	0.040	0.70
	20	10000	830	0.015	0.50
	24	6700	670	0.010	0.40
3	8	8600	2400	0.100	1.60
	12	8600	2200	0.080	1.60
	18	8300	2200	0.070	1.40
	24	8000	1900	0.060	1.00
	30	6500	950	0.030	0.80
	36	4500	660	0.010	0.60
4	16	6500	2300	0.100	2.00
	24	5700	1800	0.085	1.60
	32	5000	1200	0.040	1.40
	48	3400	530	0.010	0.70
6	24	4000	1900	0.120	3.00
	48	2700	870	0.050	2.40
Depth of cut		≤0.2RE (DC ≤ϕ2) ≤0.4RE (DC > ϕ2)  ≤0.1mm (DC ≤ϕ1.5) ≤0.2mm (DC ≤ϕ4) ≤0.5mm (DC ≤ϕ6)			DC:Dia.

MS4MRB

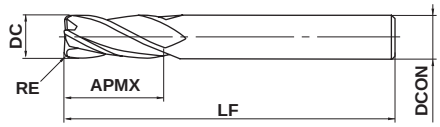
Corner radius end mill, Medium cut length, 4 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	○		○	○	○	



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute corner radius end mill for general use.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4MRBD0300R010	3	0.1	8	45	6	4	●	1
MS4MRBD0300R020	3	0.2	8	45	6	4	●	1
MS4MRBD0300R030	3	0.3	8	45	6	4	●	1
MS4MRBD0300R050	3	0.5	8	45	6	4	●	1
MS4MRBD0300R100	3	1	8	45	6	4	●	1
MS4MRBD0400R010	4	0.1	11	45	6	4	●	1
MS4MRBD0400R020	4	0.2	11	45	6	4	●	1
MS4MRBD0400R030	4	0.3	11	45	6	4	●	1
MS4MRBD0400R050	4	0.5	11	45	6	4	●	1
MS4MRBD0400R100	4	1	11	45	6	4	●	1
MS4MRBD0500R010	5	0.1	13	50	6	4	●	1
MS4MRBD0500R020	5	0.2	13	50	6	4	●	1
MS4MRBD0500R030	5	0.3	13	50	6	4	●	1
MS4MRBD0500R050	5	0.5	13	50	6	4	●	1
MS4MRBD0500R100	5	1	13	50	6	4	●	1
MS4MRBD0600R010	6	0.1	13	50	6	4	●	2
MS4MRBD0600R020	6	0.2	13	50	6	4	●	2
MS4MRBD0600R030	6	0.3	13	50	6	4	●	2
MS4MRBD0600R050	6	0.5	13	50	6	4	●	2
MS4MRBD0600R100	6	1	13	50	6	4	●	2
MS4MRBD0600R150	6	1.5	13	50	6	4	●	2
MS4MRBD0600R200	6	2	13	50	6	4	●	2
MS4MRBD0800R020	8	0.2	19	60	8	4	●	2
MS4MRBD0800R030	8	0.3	19	60	8	4	●	2
MS4MRBD0800R050	8	0.5	19	60	8	4	●	2
MS4MRBD0800R100	8	1	19	60	8	4	●	2
MS4MRBD0800R150	8	1.5	19	60	8	4	●	2
MS4MRBD0800R200	8	2	19	60	8	4	●	2
MS4MRBD0800R250	8	2.5	19	60	8	4	●	2
MS4MRBD0800R300	8	3	19	60	8	4	●	2
MS4MRBD1000R020	10	0.2	22	70	10	4	●	2
MS4MRBD1000R030	10	0.3	22	70	10	4	●	2
MS4MRBD1000R050	10	0.5	22	70	10	4	●	2
MS4MRBD1000R100	10	1	22	70	10	4	●	2

● : Inventory maintained in Japan.

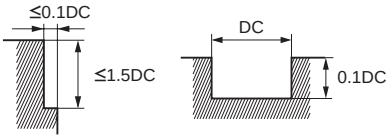
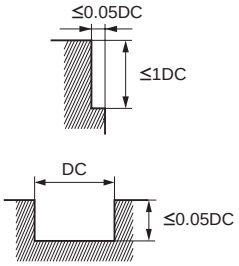
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
MS4MRBD1000R150	10	1.5	22	70	10	4	●	2
MS4MRBD1000R200	10	2	22	70	10	4	●	2
MS4MRBD1000R250	10	2.5	22	70	10	4	●	2
MS4MRBD1000R300	10	3	22	70	10	4	●	2
MS4MRBD1200R020	12	0.2	26	75	12	4	●	2
MS4MRBD1200R030	12	0.3	26	75	12	4	●	2
MS4MRBD1200R050	12	0.5	26	75	12	4	●	2
MS4MRBD1200R100	12	1	26	75	12	4	●	2
MS4MRBD1200R150	12	1.5	26	75	12	4	●	2
MS4MRBD1200R200	12	2	26	75	12	4	●	2
MS4MRBD1200R250	12	2.5	26	75	12	4	●	2
MS4MRBD1200R300	12	3	26	75	12	4	●	2
MS4MRBD1600R050	16	0.5	32	90	16	4	●	2
MS4MRBD1600R100	16	1	32	90	16	4	●	2
MS4MRBD1600R150	16	1.5	32	90	16	4	●	2
MS4MRBD1600R200	16	2	32	90	16	4	●	2
MS4MRBD1600R250	16	2.5	32	90	16	4	●	2
MS4MRBD1600R300	16	3	32	90	16	4	●	2
MS4MRBD2000R050	20	0.5	38	100	20	4	●	2
MS4MRBD2000R100	20	1	38	100	20	4	●	2
MS4MRBD2000R150	20	1.5	38	100	20	4	●	2
MS4MRBD2000R200	20	2	38	100	20	4	●	2
MS4MRBD2000R250	20	2.5	38	100	20	4	●	2
MS4MRBD2000R300	20	3	38	100	20	4	●	2

MS4MRB

Corner radius end mill, Medium cut length, 4 flute

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	16000	1500	10000	800	7400	480	8000	240
4	12000	1800	8000	1000	5600	600	6000	240
5	9600	1800	6400	1000	4400	600	4800	240
6	8000	1800	5300	1000	3700	600	4000	240
8	6000	1600	4000	900	2800	560	3000	240
10	4800	1400	3200	800	2200	500	2400	240
12	4000	1200	2700	700	1800	430	2000	230
16	3000	960	2000	560	1400	360	1500	190
20	2400	800	1600	480	1100	300	1200	170
Depth of cut								

DC:Dia.

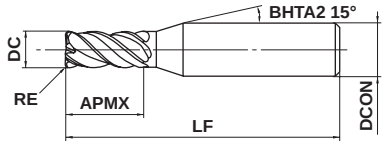
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VQMHVRB

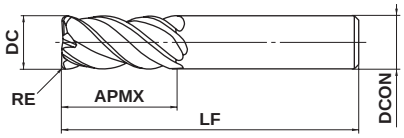
Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



Type1



Type2

0.2≤RE≤6.35				
±0.015				
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

● Smart Miracle vibration control end mill achieving stable machining of difficult-to-cut materials and for long overhang applications.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHVRBD0200R020	2	0.2	4	45	4	4	●	1
VQMHVRBD0200R030	2	0.3	4	45	4	4	●	1
VQMHVRBD0300R020	3	0.2	8	45	6	4	●	1
VQMHVRBD0300R030	3	0.3	8	45	6	4	●	1
VQMHVRBD0300R050	3	0.5	8	45	6	4	●	1
VQMHVRBD0400R020	4	0.2	11	45	6	4	●	1
VQMHVRBD0400R030	4	0.3	11	45	6	4	●	1
VQMHVRBD0400R050	4	0.5	11	45	6	4	●	1
VQMHVRBD0500R020	5	0.2	13	50	6	4	●	1
VQMHVRBD0500R030	5	0.3	13	50	6	4	●	1
VQMHVRBD0500R050	5	0.5	13	50	6	4	●	1
VQMHVRBD0500R100	5	1	13	50	6	4	●	1
VQMHVRBD0600R030	6	0.3	13	50	6	4	●	2
VQMHVRBD0600R050	6	0.5	13	50	6	4	●	2
VQMHVRBD0600R100	6	1	13	50	6	4	●	2
VQMHVRBD0800R030	8	0.3	19	60	8	4	●	2
VQMHVRBD0800R050	8	0.5	19	60	8	4	●	2
VQMHVRBD0800R100	8	1	19	60	8	4	●	2
VQMHVRBD0800R150	8	1.5	19	60	8	4	●	2
VQMHVRBD1000R030	10	0.3	22	70	10	4	●	2
VQMHVRBD1000R050	10	0.5	22	70	10	4	●	2
VQMHVRBD1000R100	10	1	22	70	10	4	●	2
VQMHVRBD1000R150	10	1.5	22	70	10	4	●	2
VQMHVRBD1000R200	10	2	22	70	10	4	●	2
VQMHVRBD1200R050	12	0.5	26	75	12	4	●	2
VQMHVRBD1200R100	12	1	26	75	12	4	●	2
VQMHVRBD1200R150	12	1.5	26	75	12	4	●	2
VQMHVRBD1200R200	12	2	26	75	12	4	●	2
VQMHVRBD1200R250	12	2.5	26	75	12	4	●	2
VQMHVRBD1200R300	12	3	26	75	12	4	●	2
VQMHVRBD1600R100	16	1	35	90	16	4	●	2
VQMHVRBD1600R150	16	1.5	35	90	16	4	●	2

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

● : **Inventory maintained in Japan.**

VQMHVRB

Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHVRBD1600R200	16	2	35	90	16	4	●	2
VQMHVRBD1600R250	16	2.5	35	90	16	4	●	2
VQMHVRBD1600R300	16	3	35	90	16	4	●	2
VQMHVRBD1600R400	16	4	35	90	16	4	●	2
VQMHVRBD1600R500	16	5	35	90	16	4	●	2
VQMHVRBD2000R100	20	1	45	110	20	4	●	2
VQMHVRBD2000R150	20	1.5	45	110	20	4	●	2
VQMHVRBD2000R200	20	2	45	110	20	4	●	2
VQMHVRBD2000R250	20	2.5	45	110	20	4	●	2
VQMHVRBD2000R300	20	3	45	110	20	4	●	2
VQMHVRBD2000R400	20	4	45	110	20	4	●	2
VQMHVRBD2000R500	20	5	45	110	20	4	●	2
VQMHVRBD2000R635	20	6.35	45	110	20	4	●	2

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

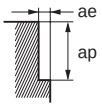
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

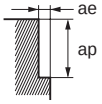
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH,17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	150	24000	2400	3	0.6	120	19000	1100	3	0.6	100	16000	830	3	0.6	75	12000	720	3	0.4
3	150	16000	2600	4.5	0.9	120	13000	1200	4.5	0.9	100	11000	880	4.5	0.9	75	8000	770	4.5	0.6
4	150	12000	2600	6	1.2	120	9500	1300	6	1.2	100	8000	900	6	1.2	75	6000	790	6	0.8
5	150	9500	2600	7.5	1.5	120	7600	1300	7.5	1.5	100	6400	900	7.5	1.5	75	4800	810	7.5	1
6	150	8000	2600	9	1.8	120	6400	1300	9	1.8	100	5300	1100	9	1.8	75	4000	810	9	1.2
8	150	6000	2500	12	2.4	120	4800	1300	12	2.4	100	4000	1200	12	2.4	75	3000	840	12	1.6
10	150	4800	2300	15	3	120	3800	1200	15	3	100	3200	1300	15	3	75	2400	770	15	2
12	150	4000	1900	18	3.6	120	3200	1200	18	3.6	100	2700	1200	18	3.6	75	2000	720	18	2.4
16	150	3000	1600	24	4.8	120	2400	960	24	4.8	100	2000	960	24	4.8	75	1500	600	24	3.2
20	150	2400	1300	30	6	120	1900	760	30	6	100	1600	770	30	6	75	1200	480	30	4
25	150	1900	1100	37.5	7.5	120	1500	600	37.5	7.5	100	1300	620	37.5	7.5	75	950	380	37.5	5
Depth of cut																				

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH,17-4PH				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	120	19000	1300	3	0.6	100	16000	630	3	0.6	80	13000	450	1.5	0.2	70	11000	440	3	0.4
3	120	13000	1400	4.5	0.9	100	11000	700	4.5	0.9	80	8500	450	2.2	0.3	70	7400	470	4.5	0.6
4	120	9500	1400	6	1.2	100	8000	700	6	1.2	80	6400	470	3	0.6	70	5600	490	6	0.8
5	120	7600	1400	7.5	1.5	100	6400	710	7.5	1.5	80	5100	470	4.5	0.9	70	4500	500	7.5	1
6	120	6400	1400	9	1.8	100	5300	710	9	1.8	80	4200	580	6	1.2	70	3700	500	9	1.2
8	120	4800	1300	12	2.4	100	4000	740	12	2.4	80	3200	630	7.5	1.5	70	2800	520	12	1.6
10	120	3800	1200	15	3	100	3200	680	15	3	80	2500	660	9	1.8	70	2200	460	15	2
12	120	3200	1000	18	3.6	100	2700	640	18	3.6	80	2100	610	12	2.4	70	1900	450	18	2.4
16	120	2400	860	24	4.8	100	2000	530	24	4.8	80	1600	510	15	3	70	1400	370	24	3.2
20	120	1900	680	30	6	100	1600	420	30	6	80	1300	410	18	3.6	70	1100	290	30	4
25	120	1500	390	37.5	7.5	100	1300	340	37.5	7.5	80	1000	210	24	4.8	70	890	230	37.5	5
Depth of cut																				

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

VQMHVRB

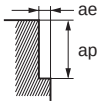
Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

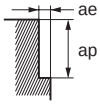
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	180	29000	2900	3	0.6	40	6400	230	3	0.2
3	180	19000	3000	4.5	0.9	40	4200	240	4.5	0.3
4	180	14000	3000	6	1.2	40	3200	240	6	0.4
5	180	11000	3000	7.5	1.5	40	2500	240	7.5	0.5
6	180	9500	3000	9	1.8	40	2100	250	9	0.6
8	180	7200	3000	12	2.4	40	1600	260	12	0.8
10	180	5700	2700	15	3	40	1300	290	15	1
12	180	4800	2300	18	3.6	40	1100	280	18	1.2
16	180	3600	1900	24	4.8	40	800	200	24	1.6
20	180	2900	1600	30	6	40	640	160	30	2
25	180	2300	1300	37	7.5	40	510	130	37.5	2.5
Depth of cut										

General-purpose conditions

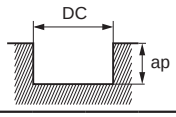
Work Material	Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	140	22000	1500	3	0.6	30	4800	110	3	0.2
3	140	15000	1600	4.5	0.9	30	3200	120	4.5	0.3
4	140	11000	1600	6	1.2	30	2400	120	6	0.4
5	140	8900	1600	7.5	1.5	30	1900	120	7.5	0.5
6	140	7400	1600	9	1.8	30	1600	130	9	0.6
8	140	5600	1600	12	2.4	30	1200	130	12	0.8
10	140	4500	1400	15	3	30	950	140	15	1
12	140	3700	1200	18	3.6	30	800	140	18	1.2
16	140	2800	1000	24	4.8	30	600	100	24	1.6
20	140	2200	780	30	6	30	480	81	30	2
25	140	1800	670	37.5	7.5	30	380	64	37.5	2.5
Depth of cut										

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

■Slotting

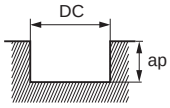
The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
2	150	24000	1200	2	120	19000	610	2	100	16000	640	2	60	9500	300	1	180	29000	1500	2	30	4800	130	0.6
3	150	16000	1500	3	120	13000	730	3	100	11000	660	3	60	6400	360	1.5	180	19000	1700	3	30	3200	150	0.9
4	150	12000	1900	4	120	9500	910	4	100	8000	700	4	60	4800	460	2	180	14000	2200	4	30	2400	170	1.2
5	150	9500	1900	5	120	7600	910	5	100	6400	720	5	60	3800	460	2.5	180	11000	2200	5	30	1900	170	1.5
6	150	8000	1900	6	120	6400	1000	6	100	5300	740	6	60	3200	510	3	180	9500	2300	6	30	1600	180	1.8
8	150	6000	1700	8	120	4800	960	8	100	4000	800	8	60	2400	480	4	180	7200	2000	8	30	1200	190	2.4
10	150	4800	1500	10	120	3800	840	10	100	3200	900	10	60	1900	420	5	180	5700	1800	10	30	950	210	3
12	150	4000	1300	12	120	3200	770	12	100	2700	860	12	60	1600	380	6	180	4800	1500	12	30	800	200	3.6
16	150	3000	1100	12	120	2400	670	12	100	2000	640	12	60	1200	340	8	180	3600	1300	12	30	600	150	4.8
20	150	2400	860	12	120	1900	530	12	100	1600	510	12	60	950	270	10	180	2900	1000	12	30	480	120	6
25	150	1900	760	12	120	1500	420	12	100	1300	420	12	60	760	210	12	180	2300	920	12	30	380	100	7.5
Depth of cut																								

DC:Dia.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631 15-5PH, 17-4PH				Copper, Copper alloy				Heat resistant alloys Inconel718			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed rate (mm/min)	Depth of cut ap (mm)
2	100	16000	550	2	80	13000	270	2	60	9500	250	2	50	8000	170	1	120	19000	650	2	25	4000	74	0.6
3	100	11000	670	3	80	8500	310	3	60	6400	250	3	50	5300	200	1.5	120	13000	790	3	25	2700	86	0.9
4	100	8000	840	4	80	6400	410	4	60	4800	280	4	50	4000	250	2	120	9500	1000	4	25	2000	93	1.2
5	100	6400	840	5	80	5100	410	5	60	3800	280	5	50	3200	250	2.5	120	7600	1000	5	25	1600	95	1.5
6	100	5300	840	6	80	4200	440	6	60	3200	300	6	50	2700	290	3	120	6400	1000	6	25	1300	96	1.8
8	100	4000	740	8	80	3200	420	8	60	2400	320	8	50	2000	260	4	120	4800	890	8	25	990	100	2.4
10	100	3200	680	10	80	2500	360	10	60	1900	350	10	50	1600	230	5	120	3800	800	10	25	800	120	3
12	100	2700	570	12	80	2100	330	12	60	1600	340	12	50	1300	210	6	120	3200	680	12	25	660	110	3.6
16	100	2000	480	12	80	1600	300	12	60	1200	250	12	50	990	180	8	120	2400	570	12	25	500	84	4.8
20	100	1600	380	12	80	1300	240	12	60	950	200	12	50	800	150	10	120	1900	450	12	25	400	68	6
25	100	1300	340	12	80	1000	180	12	60	760	160	12	50	640	120	12	120	1500	400	12	25	320	50	7.5
Depth of cut																								

DC:Dia.

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Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
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In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the feed rate can be increased.

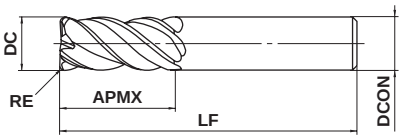
VQMHVRBF

Corner radius end mill, Medium cutting length, 4 flute, Irregular helix flutes (for finishing)

TOOL NEWS

UWC VQ 37° 40°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



Type1

0.3≤RE≤3				
±0.015				
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

- Smart Miracle vibration control end mill achieving stable machining of difficult-to-cut materials.
- With the special substrate, suitable for finishing of heat resistance alloy, etc.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VQMHVRBFD0600R030	6	0.3	13	50	6	4	●	1
VQMHVRBFD0600R050	6	0.5	13	50	6	4	●	1
VQMHVRBFD0600R100	6	1	13	50	6	4	●	1
VQMHVRBFD0800R050	8	0.5	19	60	8	4	●	1
VQMHVRBFD0800R100	8	1	19	60	8	4	●	1
VQMHVRBFD1000R030	10	0.3	22	70	10	4	●	1
VQMHVRBFD1000R050	10	0.5	22	70	10	4	●	1
VQMHVRBFD1000R100	10	1	22	70	10	4	●	1
VQMHVRBFD1000R200	10	2	22	70	10	4	●	1
VQMHVRBFD1200R100	12	1	26	75	12	4	●	1
VQMHVRBFD1200R200	12	2	26	75	12	4	●	1
VQMHVRBFD1200R300	12	3	26	75	12	4	●	1
VQMHVRBFD1600R100	16	1	35	90	16	4	●	1
VQMHVRBFD1600R200	16	2	35	90	16	4	●	1

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

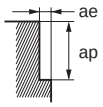
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH					Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
6	150	8000	2600	9	0.3	120	6400	1300	9	0.3	75	4000	800	9	0.3	180	9500	3000	9	0.3	40	2100	250	9	0.18
8	150	6000	2500	12	0.4	120	4800	1300	12	0.4	75	3000	840	12	0.4	180	7200	3000	12	0.4	40	1600	260	12	0.24
10	150	4800	2300	15	0.5	120	3800	1200	15	0.5	75	2400	770	15	0.5	180	5700	2700	15	0.5	41	1300	290	15	0.3
12	150	4000	1900	18	0.6	120	3200	1200	18	0.6	75	2000	720	18	0.6	180	4800	2300	18	0.6	41	1100	280	18	0.36
16	150	3000	1600	24	0.8	120	2400	960	24	0.8	75	1500	600	24	0.8	180	3600	1900	24	0.8	40	800	200	24	0.48

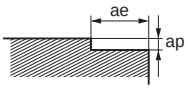
Depth of cut



■Bottom face milling

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH					Copper, Copper alloy					Heat resistant alloys Inconel718				
Dia. DC (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting speed (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
6	110	5800	1400	0.3	4.8	90	4800	770	0.3	4.8	55	2900	460	0.3	4.8	130	6900	1700	0.3	4.8	30	1600	180	0.18	4.8
8	110	4400	1200	0.4	6.4	90	3600	720	0.4	6.4	55	2200	440	0.4	6.4	130	5200	1500	0.4	6.4	30	1200	190	0.24	6.4
10	110	3500	1100	0.5	8	90	2900	640	0.5	8	55	1800	400	0.5	8	130	4100	1300	0.5	8	30	950	210	0.3	8
12	110	2900	930	0.6	9.6	90	2400	580	0.6	9.6	55	1500	360	0.6	9.6	130	3400	1100	0.6	9.6	30	800	200	0.36	9.6
16	110	2200	790	0.8	12.8	90	1800	500	0.8	12.8	55	1100	310	0.8	12.8	130	2600	940	0.8	12.8	30	600	150	0.48	12.8

Depth of cut



Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the feed rate can be increased.

VFMHVRBCH

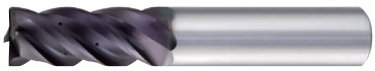
Corner radius end mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes

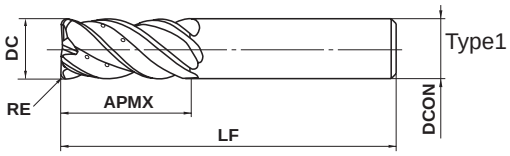
TOOL NEWS

UWC VF 42° 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS





1≤RE≤3				
±0.015				
16≤DC≤20				
0 / - 0.03				
DCON=16	DCON=20			
0 / - 0.011	0 / - 0.013			

● Vibration control corner radius end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

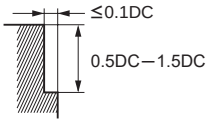
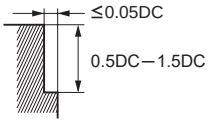
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VFMHVRBCHD1600R100	16	1	35	90	16	4	●	1
VFMHVRBCHD1600R300	16	3	35	90	16	4	●	1
VFMHVRBCHD2000R100	20	1	45	110	20	4	●	1
VFMHVRBCHD2000R300	20	3	45	110	20	4	●	1

● : Inventory maintained in Japan.

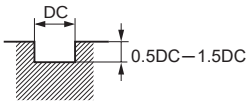
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1140	2000	560	800	110
20	2400	860	1600	510	600	100
Depth of cut						

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	2400	670	1400	380	1400	170
20	1900	610	1100	350	1100	130
Depth of cut						

DC:Dia.

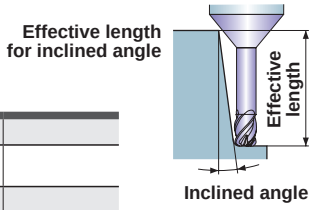
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

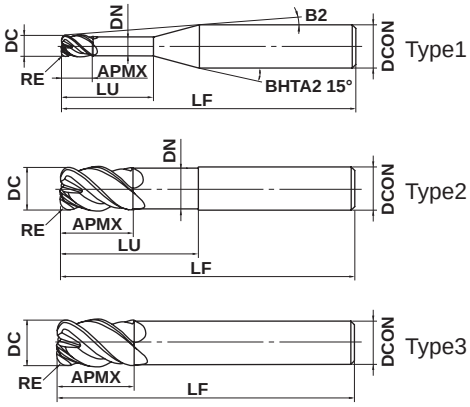
VFHVRB

4 flute, Corner radius, Short cut length,Irregular helix flutes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎	○	○	○		





DC≤10	DC>10			
±0.007	±0.01			
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

● Impact Miracle corner radius end mill for high feed and efficient machining.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VFHVRBD0100R02N004	1	0.2	1	4	0.94	10.6°	60	6	4	●	1	4.2	4.5	4.7	5.3
VFHVRBD0100R02N006	1	0.2	1	6	0.94	9.2°	60	6	4	●	1	6.4	6.7	7.2	7.7
VFHVRBD0100R02N008	1	0.2	1	8	0.94	8.2°	60	6	4	●	1	8.5	8.8	9.5	10.2
VFHVRBD0100R02N010	1	0.2	1	10	0.94	7.4°	60	6	4	●	1	10.5	11	11.8	12.7
VFHVRBD0100R02N015	1	0.2	1	15	0.94	5.9°	60	6	4	●	1	15.8	16.3	17.5	18.9
VFHVRBD0100R02N020	1	0.2	1	20	0.94	4.9°	80	6	4	●	1	20.9	21.7	23.3	25.1
VFHVRBD0150R03N004	1.5	0.3	1.5	4	1.44	10.3°	60	6	4	●	1	4.2	4.5	4.6	5.2
VFHVRBD0150R03N006	1.5	0.3	1.5	6	1.44	8.9°	60	6	4	●	1	6.3	6.6	7.2	7.7
VFHVRBD0150R03N010	1.5	0.3	1.5	10	1.44	7°	60	6	4	●	1	10.5	10.9	11.8	12.7
VFHVRBD0150R03N015	1.5	0.3	1.5	15	1.44	5.5°	60	6	4	●	1	15.7	16.3	17.5	18.9
VFHVRBD0150R03N020	1.5	0.3	1.5	20	1.44	4.6°	80	6	4	●	1	20.9	21.6	23.3	25.1
VFHVRBD0150R03N025	1.5	0.3	1.5	25	1.44	3.9°	80	6	4	●	1	26.1	27	29	31.3
VFHVRBD0150R03N030	1.5	0.3	1.5	30	1.44	3.4°	80	6	4	●	1	31.3	32.3	34.7	37.5
VFHVRBD0200R05N006	2	0.5	2	6	1.9	8.7°	60	6	4	●	1	6.3	6.5	7	7.5
VFHVRBD0200R05N010	2	0.5	2	10	1.9	6.7°	60	6	4	●	1	10.5	10.8	11.6	12.5
VFHVRBD0200R05N015	2	0.5	2	15	1.9	5.2°	60	6	4	●	1	15.6	16.2	17.4	18.7
VFHVRBD0200R05N020	2	0.5	2	20	1.9	4.3°	80	6	4	●	1	20.8	21.5	23.1	24.9
VFHVRBD0200R05N025	2	0.5	2	25	1.9	3.6°	80	6	4	●	1	26	26.9	28.9	31.2
VFHVRBD0200R05N030	2	0.5	2	30	1.9	3.1°	80	6	4	●	1	31.2	32.2	34.6	37.4
VFHVRBD0200R05N035	2	0.5	2	35	1.9	2.8°	90	6	4	●	1	36.3	37.6	40.4	*
VFHVRBD0200R05N040	2	0.5	2	40	1.9	2.5°	90	6	4	●	1	41.5	42.9	46.1	*
VFHVRBD0300R05N010	3	0.5	3	10	2.9	5.6°	60	6	4	●	1	10.5	10.8	11.6	12.5
VFHVRBD0300R05N015	3	0.5	3	15	2.9	4.3°	60	6	4	●	1	15.6	16.2	17.4	18.7
VFHVRBD0300R05N020	3	0.5	3	20	2.9	3.4°	80	6	4	●	1	20.8	21.5	23.1	24.9
VFHVRBD0300R05N030	3	0.5	3	30	2.9	2.5°	80	6	4	●	1	31.2	32.2	34.6	*
VFHVRBD0300R08N010	3	0.8	3	10	2.9	5.7°	60	6	4	●	1	10.4	10.8	11.6	12.4
VFHVRBD0300R08N015	3	0.8	3	15	2.9	4.3°	60	6	4	●	1	15.6	16.2	17.3	18.7
VFHVRBD0300R08N020	3	0.8	3	20	2.9	3.5°	80	6	4	●	1	20.8	21.5	23.1	24.9
VFHVRBD0300R08N030	3	0.8	3	30	2.9	2.5°	80	6	4	●	1	31.1	32.2	34.6	*
VFHVRBD0300R08N040	3	0.8	3	40	2.9	2°	90	6	4	●	1	41.5	42.9	*	*
VFHVRBD0300R08N050	3	0.8	3	50	2.9	1.6°	90	6	4	●	1	51.8	53.6	*	*
VFHVRBD0400R05N012	4	0.5	4	12	3.9	3.8°	60	6	4	●	1	12.5	13	13.9	15
VFHVRBD0400R05N020	4	0.5	4	20	3.9	2.5°	80	6	4	●	1	20.8	21.5	23.1	*
VFHVRBD0400R05N030	4	0.5	4	30	3.9	1.8°	80	6	4	●	1	31.2	32.2	*	*

* No interference

● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VFHVRBD0400R05N048	4	0.5	4	48	3.9	1.2°	90	6	4	●	1	49.8	51.5	*	*
VFHVRBD0400R10N012	4	1	4	12	3.9	3.9°	60	6	4	●	1	12.5	12.9	13.8	14.9
VFHVRBD0400R10N020	4	1	4	20	3.9	2.5°	80	6	4	●	1	20.8	21.5	23	*
VFHVRBD0400R10N030	4	1	4	30	3.9	1.8°	80	6	4	●	1	31.1	32.2	*	*
VFHVRBD0600R05N018	6	0.5	9	18	5.85	–	60	6	4	●	2	*	*	*	*
VFHVRBD0600R05N030	6	0.5	9	30	5.85	–	80	6	4	●	2	*	*	*	*
VFHVRBD0600R10N018	6	1	9	18	5.85	–	60	6	4	●	2	*	*	*	*
VFHVRBD0600R10N030	6	1	9	30	5.85	–	80	6	4	●	2	*	*	*	*
VFHVRBD0600R10N054	6	1	9	54	5.85	–	90	6	4	●	2	*	*	*	*
VFHVRBD0600R15N018	6	1.5	9	18	5.85	–	60	6	4	●	2	*	*	*	*
VFHVRBD0600R15N030	6	1.5	9	30	5.85	–	80	6	4	●	2	*	*	*	*
VFHVRBD0600R15N042	6	1.5	9	42	5.85	–	90	6	4	●	2	*	*	*	*
VFHVRBD0600R15N054	6	1.5	9	54	5.85	–	90	6	4	●	2	*	*	*	*
VFHVRBD0600R20N018	6	2	9	18	5.85	–	60	6	4	●	2	*	*	*	*
VFHVRBD0600R20N030	6	2	9	30	5.85	–	80	6	4	●	2	*	*	*	*
VFHVRBD0700R15	7	1.5	11	–	–	–	80	6	4	●	3	*	*	*	*
VFHVRBD0800R05N024	8	0.5	12	24	7.85	–	60	8	4	●	2	*	*	*	*
VFHVRBD0800R05N040	8	0.5	12	40	7.85	–	100	8	4	●	2	*	*	*	*
VFHVRBD0800R10N024	8	1	12	24	7.85	–	60	8	4	●	2	*	*	*	*
VFHVRBD0800R10N040	8	1	12	40	7.85	–	100	8	4	●	2	*	*	*	*
VFHVRBD0800R20N024	8	2	12	24	7.85	–	60	8	4	●	2	*	*	*	*
VFHVRBD0800R20N040	8	2	12	40	7.85	–	100	8	4	●	2	*	*	*	*
VFHVRBD0800R20N056	8	2	12	56	7.85	–	120	8	4	●	2	*	*	*	*
VFHVRBD0800R20N072	8	2	12	72	7.85	–	120	8	4	●	2	*	*	*	*
VFHVRBD0900R20	9	2	13.5	–	–	–	100	8	4	●	3	*	*	*	*
VFHVRBD1000R05N030	10	0.5	15	30	9.7	–	70	10	4	●	2	*	*	*	*
VFHVRBD1000R05N050	10	0.5	15	50	9.7	–	110	10	4	●	2	*	*	*	*
VFHVRBD1000R10N030	10	1	15	30	9.7	–	70	10	4	●	2	*	*	*	*
VFHVRBD1000R10N050	10	1	15	50	9.7	–	110	10	4	●	2	*	*	*	*
VFHVRBD1000R20N030	10	2	15	30	9.7	–	70	10	4	●	2	*	*	*	*
VFHVRBD1000R20N050	10	2	15	50	9.7	–	110	10	4	●	2	*	*	*	*
VFHVRBD1000R20N070	10	2	15	70	9.7	–	150	10	4	●	2	*	*	*	*
VFHVRBD1000R20N090	10	2	15	90	9.7	–	150	10	4	●	2	*	*	*	*
VFHVRBD1100R20	11	2	16.5	–	–	–	110	10	4	●	3	*	*	*	*
VFHVRBD1200R05N036	12	0.5	18	36	11.7	–	80	12	4	●	2	*	*	*	*
VFHVRBD1200R05N060	12	0.5	18	60	11.7	–	120	12	4	●	2	*	*	*	*
VFHVRBD1200R10N036	12	1	18	36	11.7	–	80	12	4	●	2	*	*	*	*
VFHVRBD1200R10N060	12	1	18	60	11.7	–	120	12	4	●	2	*	*	*	*
VFHVRBD1200R20N036	12	2	18	36	11.7	–	80	12	4	●	2	*	*	*	*
VFHVRBD1200R20N060	12	2	18	60	11.7	–	120	12	4	●	2	*	*	*	*
VFHVRBD1200R20N084	12	2	18	84	11.7	–	160	12	4	●	2	*	*	*	*
VFHVRBD1200R20N108	12	2	18	108	11.7	–	160	12	4	●	2	*	*	*	*
VFHVRBD1200R30N036	12	3	18	36	11.7	–	80	12	4	●	2	*	*	*	*
VFHVRBD1200R30N060	12	3	18	60	11.7	–	120	12	4	●	2	*	*	*	*
VFHVRBD1300R30	13	3	19.5	–	–	–	120	12	4	●	3	*	*	*	*
VFHVRBD1600R05N042	16	0.5	24	42	15.5	–	100	16	4	●	2	*	*	*	*
VFHVRBD1600R20N042	16	2	24	42	15.5	–	100	16	4	●	2	*	*	*	*
VFHVRBD1600R30N042	16	3	24	42	15.5	–	100	16	4	●	2	*	*	*	*
VFHVRBD1600R30N080	16	3	24	80	15.5	–	140	16	4	●	2	*	*	*	*
VFHVRBD1600R30N120	16	3	24	120	15.5	–	175	16	4	●	2	*	*	*	*

* No interference

VFHVRB

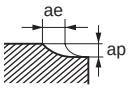
4 flute, Corner radius, Short cut length,Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

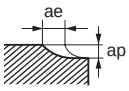
■High speed milling

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	0.2	4	40000	7200	0.04	0.45	33000	5100	0.03	0.45	27000	4100	0.025	0.45	20000	1800	0.013	0.45
1	0.2	6	40000	6500	0.03	0.45	33000	4600	0.022	0.45	27000	3700	0.018	0.45	20000	1600	0.01	0.45
1	0.2	8	32000	4500	0.022	0.45	27000	3200	0.018	0.45	21000	2600	0.012	0.45	16000	1100	0.008	0.45
1	0.2	10	24000	2700	0.015	0.45	20000	1900	0.01	0.45	16000	1500	0.008	0.45	12000	700	0.006	0.45
1	0.2	15	16000	1200	0.008	0.45	14000	700	0.005	0.45	12000	500	0.003	0.45	10000	400	0.003	0.45
1	0.2	20	14000	1000	0.005	0.45	12000	600	0.004	0.45	10000	400	0.002	0.45	9000	300	0.002	0.45
1.5	0.3	4	32000	10000	0.1	0.65	27000	7100	0.08	0.65	21000	5700	0.06	0.65	16000	2500	0.03	0.65
1.5	0.3	6	32000	7800	0.08	0.65	27000	5500	0.06	0.65	21000	4200	0.05	0.65	16000	2000	0.025	0.65
1.5	0.3	10	27000	5700	0.05	0.65	22000	4000	0.035	0.65	18000	3000	0.03	0.65	14000	1400	0.014	0.65
1.5	0.3	15	22000	3200	0.03	0.65	18000	2300	0.025	0.65	15000	1700	0.018	0.65	11000	1000	0.009	0.65
1.5	0.3	20	16000	1400	0.02	0.65	14000	1200	0.016	0.65	13000	1000	0.012	0.65	9000	700	0.007	0.65
1.5	0.3	25	13000	1000	0.015	0.65	11000	800	0.012	0.65	10000	700	0.009	0.65	7500	500	0.005	0.65
1.5	0.3	30	13000	900	0.01	0.65	11000	700	0.008	0.65	10000	600	0.006	0.65	7500	400	0.004	0.65
2	0.5	6	24000	10000	0.1	0.75	20000	7100	0.08	0.75	16000	5700	0.06	0.75	12000	2500	0.03	0.75
2	0.5	10	24000	10000	0.08	0.75	20000	7100	0.06	0.75	16000	5700	0.05	0.75	12000	2500	0.025	0.75
2	0.5	15	20000	7000	0.05	0.75	17000	5000	0.04	0.75	13000	3200	0.03	0.75	10000	1800	0.016	0.75
2	0.5	20	20000	3600	0.04	0.75	17000	2600	0.03	0.75	13000	1800	0.025	0.75	10000	900	0.012	0.75
2	0.5	25	16000	1800	0.03	0.75	14000	1400	0.025	0.75	12000	1100	0.02	0.75	9000	720	0.01	0.75
2	0.5	30	16000	1400	0.025	0.75	14000	1200	0.02	0.75	12000	900	0.016	0.75	9000	650	0.008	0.75
2	0.5	35	13000	1100	0.02	0.75	11000	800	0.018	0.75	10000	700	0.014	0.75	7000	500	0.007	0.75
2	0.5	40	13000	1000	0.02	0.75	11000	700	0.015	0.75	10000	600	0.012	0.75	7000	400	0.006	0.75
3	0.5	10	16000	11000	0.12	1.5	13000	7800	0.09	1.5	11000	6300	0.07	1.5	8000	2800	0.04	1.5
3	0.5	15	16000	9000	0.11	1.5	13000	6400	0.08	1.5	11000	5100	0.06	1.5	8000	2300	0.04	1.5
3	0.5	20	13000	7200	0.09	1.5	11000	5100	0.07	1.5	8700	4000	0.05	1.5	6500	1800	0.03	1.5
3	0.5	30	13000	5700	0.06	1.5	11000	4000	0.05	1.5	8700	3000	0.04	1.5	6500	1400	0.02	1.5
3	0.8	10	16000	11000	0.24	1	13000	7800	0.19	1	11000	6300	0.14	1	8000	2800	0.07	1
3	0.8	15	16000	9000	0.22	1	13000	6400	0.17	1	11000	5100	0.13	1	8000	2300	0.07	1
3	0.8	20	13000	7200	0.19	1	11000	5100	0.15	1	8700	4000	0.11	1	6500	1800	0.06	1
3	0.8	30	13000	5700	0.12	1	11000	4000	0.09	1	8700	3000	0.07	1	6500	1400	0.04	1
3	0.8	40	11000	3600	0.08	1	9100	2600	0.06	1	7400	2000	0.05	1	5500	1000	0.025	1
3	0.8	50	8000	2600	0.07	1	6600	1800	0.05	1	5800	1500	0.04	1	4600	800	0.02	1
4	0.5	12	8400	6000	0.15	2	7000	4300	0.12	2	5600	3400	0.09	2	4200	1500	0.05	2
4	0.5	20	8400	6000	0.14	2	7000	4300	0.11	2	5600	3400	0.08	2	4200	1500	0.04	2
4	0.5	30	6900	4900	0.12	2	5700	3500	0.09	2	4600	2800	0.07	2	3500	1200	0.03	2
4	0.5	48	5600	2000	0.07	2	4600	1400	0.05	2	3800	1100	0.04	2	2800	500	0.02	2
4	1	12	12000	12000	0.3	1.5	10000	8500	0.23	1.5	8000	6800	0.18	1.5	6000	3000	0.1	1.5
4	1	20	12000	12000	0.27	1.5	10000	8500	0.21	1.5	8000	6800	0.16	1.5	6000	3000	0.08	1.5
4	1	30	10000	9900	0.24	1.5	8300	7000	0.19	1.5	6700	5600	0.14	1.5	5000	2500	0.07	1.5
6	0.5	18	4000	3900	0.15	3.5	3300	2800	0.12	3.5	2700	2200	0.09	3.5	2000	1000	0.05	3.5
6	0.5	30	4000	3900	0.14	3.5	3300	2800	0.11	3.5	2700	2200	0.08	3.5	2000	1000	0.04	3.5
6	1	18	8000	13000	0.5	3	6600	9200	0.4	3	5400	7400	0.3	3	4000	3300	0.15	3
6	1	30	8000	13000	0.45	3	6600	9200	0.35	3	5400	7400	0.27	3	4000	3300	0.14	3
6	1	54	6600	11000	0.25	3	5500	7800	0.2	3	4400	6300	0.15	3	3300	2800	0.08	3
6	1.5	18	8000	13000	0.5	2	6600	9200	0.4	2	5400	7400	0.3	2	4000	3300	0.15	2
6	1.5	30	8000	13000	0.45	2	6600	9200	0.35	2	5400	7400	0.27	2	4000	3300	0.14	2
6	1.5	42	6600	11000	0.4	2	5500	7800	0.3	2	4400	6300	0.24	2	3300	2800	0.12	2
6	1.5	54	6600	11000	0.25	2	5500	7800	0.2	2	4400	6300	0.15	2	3300	2800	0.08	2
6	2	18	8000	13000	0.5	1.5	6600	9200	0.4	1.5	5400	7400	0.3	1.5	4000	3300	0.15	1.5
6	2	30	8000	13000	0.45	1.5	6600	9200	0.35	1.5	5400	7400	0.27	1.5	4000	3300	0.14	1.5

Depth of cut



Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Air blow or oil mist is recommended for good chip evacuation.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
7	1.5	—	6800	13000	0.5	3	5600	9200	0.4	3	4600	7400	0.3	3	3400	3300	0.15	3
8	0.5	24	3000	3900	0.18	5	2500	2800	0.14	5	2000	2200	0.11	5	1500	1000	0.05	5
8	0.5	40	3000	3900	0.16	5	2500	2800	0.12	5	2000	2200	0.1	5	1500	1000	0.05	5
8	1	24	4200	6500	0.3	4.5	3500	4600	0.23	4.5	2800	3700	0.18	4.5	2100	1600	0.09	4.5
8	1	40	4200	6500	0.27	4.5	3500	4600	0.21	4.5	2800	3700	0.16	4.5	2100	1600	0.08	4.5
8	2	24	6000	13000	0.6	3	5000	9200	0.46	3	4000	7400	0.36	3	3000	3300	0.18	3
8	2	40	6000	13000	0.54	3	5000	9200	0.42	3	4000	7400	0.32	3	3000	3300	0.16	3
8	2	56	5000	11000	0.48	3	4200	7800	0.37	3	3400	6300	0.3	3	2500	2800	0.14	3
8	2	72	5000	11000	0.3	3	4200	7800	0.23	3	3400	6300	0.2	3	2500	2800	0.09	3
9	2	—	5300	13000	0.6	3.5	4400	9200	0.46	3.5	3600	7400	0.36	3.5	2700	3300	0.18	3.5
10	0.5	30	2400	3900	0.18	6.5	2000	2800	0.14	6.5	1600	2200	0.11	6.5	1200	1000	0.05	6.5
10	0.5	50	2400	3900	0.16	6.5	2000	2800	0.12	6.5	1600	2200	0.1	6.5	1200	1000	0.05	6.5
10	1	30	3300	6500	0.3	6	2700	4600	0.23	6	2200	3700	0.18	6	1700	1600	0.09	6
10	1	50	3300	6500	0.27	6	2700	4600	0.21	6	2200	3700	0.16	6	1700	1600	0.08	6
10	2	30	4800	13000	0.6	4.5	4000	9200	0.46	4.5	3200	7400	0.36	4.5	2400	3300	0.18	4.5
10	2	50	4800	13000	0.54	4.5	4000	9200	0.42	4.5	3200	7400	0.32	4.5	2400	3300	0.16	4.5
10	2	70	4000	11000	0.48	4.5	3300	7800	0.37	4.5	2700	6300	0.3	4.5	2000	2800	0.14	4.5
10	2	90	4000	11000	0.48	4.5	3300	7800	0.37	4.5	2700	6300	0.3	4.5	2000	2800	0.14	4.5
11	2	—	4300	12000	0.6	5	3600	8500	0.46	5	2900	6800	0.36	5	2200	3000	0.18	5
12	0.5	36	2000	3600	0.27	8	1700	2600	0.21	8	1300	2100	0.14	8	1000	900	0.07	8
12	0.5	60	2000	3600	0.24	8	1700	2600	0.18	8	1300	2100	0.12	8	1000	900	0.06	8
12	1	36	2400	4800	0.36	7.5	2000	3400	0.28	7.5	1600	2700	0.18	7.5	1200	1200	0.09	7.5
12	1	60	2400	4800	0.32	7.5	2000	3400	0.25	7.5	1600	2700	0.16	7.5	1200	1200	0.08	7.5
12	2	36	4000	12000	0.9	6	3300	8500	0.7	6	2700	6800	0.45	6	2000	3000	0.23	6
12	2	60	4000	12000	0.8	6	3300	8500	0.6	6	2700	6800	0.4	6	2000	3000	0.2	6
12	2	84	3300	9900	0.7	6	2700	7000	0.55	6	2200	5600	0.36	6	1700	2500	0.18	6
12	2	108	3300	9900	0.45	6	2700	7000	0.35	6	2200	5600	0.23	6	1700	2500	0.11	6
12	3	36	4000	12000	0.9	4.5	3300	8500	0.7	4.5	2700	6800	0.45	4.5	2000	3000	0.23	4.5
12	3	60	4000	12000	0.8	4.5	3300	8500	0.6	4.5	2700	6800	0.4	4.5	2000	3000	0.2	4.5
13	3	—	3700	12000	0.9	5	3100	8500	0.7	5	2500	6800	0.45	5	1900	3000	0.23	5
16	0.5	42	1500	3000	0.27	11	1200	2100	0.21	11	1000	1700	0.12	11	750	750	0.05	11
16	2	42	2100	5000	0.45	9	1700	3600	0.35	9	1400	2900	0.2	9	1100	1300	0.08	9
16	3	42	3000	10000	0.9	7.5	2500	7100	0.7	7.5	2000	5700	0.4	7.5	1500	2500	0.15	7.5
16	3	80	3000	10000	0.8	7.5	2500	7100	0.6	7.5	2000	5700	0.37	7.5	1500	2500	0.14	7.5
16	3	120	2500	8300	0.7	7.5	2100	5900	0.55	7.5	1700	4700	0.32	7.5	1300	2100	0.12	7.5
Depth of cut																		

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Air blow or oil mist is recommended for good chip evacuation.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
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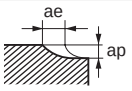
VFHVRB

4 flute, Corner radius, Short cut length,Irregular helix flutes

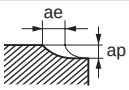
■High depth of cut conditions

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	0.2	4	24000	2200	0.08	0.45	20000	1500	0.07	0.45	16000	1200	0.05	0.45	12000	550	0.025	0.45
1	0.2	6	24000	2000	0.07	0.45	20000	1400	0.05	0.45	16000	1100	0.04	0.45	12000	500	0.02	0.45
1	0.2	8	19000	1400	0.05	0.45	16000	1000	0.04	0.45	13000	800	0.03	0.45	9500	350	0.016	0.45
1	0.2	10	14000	800	0.04	0.45	12000	600	0.03	0.45	9000	400	0.025	0.45	7000	200	0.012	0.45
1	0.2	15	16000	1200	0.008	0.45	14000	700	0.005	0.45	12000	500	0.003	0.45	10000	400	0.003	0.45
1	0.2	20	14000	1000	0.005	0.45	12000	600	0.004	0.45	10000	400	0.002	0.45	9000	300	0.002	0.45
1.5	0.3	4	19000	3000	0.2	0.65	16000	2100	0.16	0.65	13000	1700	0.12	0.65	9500	750	0.06	0.65
1.5	0.3	6	19000	2300	0.16	0.65	16000	1600	0.13	0.65	13000	1300	0.1	0.65	9500	580	0.05	0.65
1.5	0.3	10	16000	1700	0.1	0.65	13000	1200	0.07	0.65	11000	1000	0.05	0.65	8000	430	0.03	0.65
1.5	0.3	15	13000	1000	0.06	0.65	11000	700	0.05	0.65	9000	600	0.04	0.65	6500	250	0.018	0.65
1.5	0.3	20	16000	1400	0.02	0.65	14000	1200	0.016	0.65	13000	1000	0.012	0.65	9000	700	0.007	0.65
1.5	0.3	25	13000	1000	0.015	0.65	11000	800	0.012	0.65	10000	700	0.009	0.65	7500	500	0.005	0.65
1.5	0.3	30	13000	900	0.01	0.65	11000	700	0.008	0.65	10000	600	0.006	0.65	7500	400	0.004	0.65
2	0.5	6	14000	3000	0.2	0.75	12000	2100	0.16	0.75	9400	1700	0.12	0.75	7000	750	0.06	0.75
2	0.5	10	14000	3000	0.16	0.75	12000	2100	0.13	0.75	9400	1700	0.1	0.75	7000	750	0.05	0.75
2	0.5	15	12000	2100	0.1	0.75	10000	1500	0.08	0.75	8000	1200	0.06	0.75	6000	530	0.03	0.75
2	0.5	20	12000	1100	0.08	0.75	10000	800	0.06	0.75	8000	600	0.05	0.75	6000	280	0.025	0.75
2	0.5	25	16000	1800	0.03	0.75	14000	1400	0.025	0.75	12000	1100	0.02	0.75	9000	720	0.01	0.75
2	0.5	30	16000	1400	0.025	0.75	14000	1200	0.02	0.75	12000	900	0.016	0.75	9000	650	0.008	0.75
2	0.5	35	13000	1100	0.02	0.75	11000	800	0.018	0.75	10000	700	0.014	0.75	7000	500	0.007	0.75
2	0.5	40	13000	1000	0.02	0.75	11000	700	0.015	0.75	10000	600	0.012	0.75	7000	400	0.006	0.75
3	0.5	10	9600	3300	0.24	1.5	8000	2300	0.2	1.5	6400	1800	0.14	1.5	4800	830	0.07	1.5
3	0.5	15	9600	2700	0.22	1.5	8000	1900	0.17	1.5	6400	1500	0.13	1.5	4800	680	0.06	1.5
3	0.5	20	7800	2200	0.18	1.5	6500	1500	0.14	1.5	5200	1200	0.11	1.5	3900	550	0.05	1.5
3	0.5	30	7800	1700	0.12	1.5	6500	1200	0.1	1.5	5200	1000	0.07	1.5	3900	430	0.04	1.5
3	0.8	10	9600	3300	0.5	1	8000	2300	0.4	1	6400	1800	0.3	1	4800	830	0.14	1
3	0.8	15	9600	2700	0.5	1	8000	1900	0.35	1	6400	1500	0.25	1	4800	680	0.13	1
3	0.8	20	7800	2200	0.4	1	6500	1500	0.3	1	5200	1200	0.23	1	3900	550	0.11	1
3	0.8	30	7800	1700	0.24	1	6500	1200	0.2	1	5200	1000	0.14	1	3900	430	0.05	1
3	0.8	40	11000	3600	0.08	1	9100	2600	0.06	1	7400	2000	0.05	1	5500	1000	0.025	1
3	0.8	50	8000	2600	0.07	1	6600	1800	0.05	1	5800	1500	0.04	1	4600	800	0.02	1
4	0.5	12	5000	1800	0.3	2	4200	1300	0.24	2	3400	1000	0.18	2	2500	450	0.06	2
4	0.5	20	5000	1800	0.3	2	4200	1300	0.22	2	3400	1000	0.17	2	2500	450	0.06	2
4	0.5	30	4100	1500	0.24	2	3400	1100	0.19	2	2700	840	0.14	2	2100	380	0.05	2
4	0.5	48	5600	2000	0.07	2	4600	1400	0.05	2	3800	1100	0.04	2	2800	500	0.02	2
4	1	12	7200	3600	0.6	1.5	6000	2500	0.5	1.5	4800	2000	0.36	1.5	3600	900	0.12	1.5
4	1	20	7200	3600	0.6	1.5	6000	2500	0.4	1.5	4800	2000	0.32	1.5	3600	900	0.11	1.5
4	1	30	6000	3000	0.5	1.5	5000	2100	0.4	1.5	4000	1700	0.3	1.5	3000	750	0.1	1.5
6	0.5	18	2400	1200	0.3	3.5	2000	840	0.24	3.5	1600	670	0.18	3.5	1200	300	0.06	3.5
6	0.5	30	2400	1200	0.3	3.5	2000	840	0.22	3.5	1600	670	0.17	3.5	1200	300	0.06	3.5
6	1	18	4800	3900	1	3	4000	2700	0.8	3	3200	2200	0.6	3	2400	980	0.2	3
6	1	30	4800	3900	0.9	3	4000	2700	0.7	3	3200	2200	0.5	3	2400	980	0.18	3
6	1	54	4000	3300	0.5	3	3300	2300	0.4	3	2700	1800	0.3	3	2000	830	0.1	3
6	1.5	18	4800	3900	1	2	4000	2700	0.8	2	3200	2200	0.6	2	2400	980	0.2	2
6	1.5	30	4800	3900	0.9	2	4000	2700	0.7	2	3200	2200	0.5	2	2400	980	0.18	2
6	1.5	42	4000	3300	0.8	2	3300	2300	0.6	2	2700	1800	0.5	2	2000	830	0.16	2
6	1.5	54	4000	3300	0.5	2	3300	2300	0.4	2	2700	1800	0.3	2	2000	830	0.1	2
6	2	18	4800	3900	1	1.5	4000	2700	0.8	1.5	3200	2200	0.6	1.5	2400	980	0.2	1.5
6	2	30	4800	3900	0.9	1.5	4000	2700	0.7	1.5	3200	2200	0.5	1.5	2400	980	0.18	1.5

Depth of cut



Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Air blow or oil mist is recommended for good chip evacuation.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

Work Material			Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
7	1.5	—	4100	3900	1	3	3400	2700	0.8	3	2700	2200	0.6	3	2100	980	0.2	3
8	0.5	24	1800	1200	0.35	5	1500	840	0.3	5	1200	670	0.2	5	900	300	0.07	5
8	0.5	40	1800	1200	0.3	5	1500	840	0.25	5	1200	670	0.2	5	900	300	0.06	5
8	1	24	2500	2000	0.6	4.5	2100	1400	0.5	4.5	1700	1100	0.4	4.5	1300	500	0.12	4.5
8	1	40	2500	2000	0.5	4.5	2100	1400	0.4	4.5	1700	1100	0.3	4.5	1300	500	0.11	4.5
8	2	24	3600	3900	1.2	3	3000	2700	1	3	2400	2200	0.7	3	1800	980	0.24	3
8	2	40	3600	3900	1.1	3	3000	2700	0.9	3	2400	2200	0.7	3	1800	980	0.22	3
8	2	56	3000	3300	1	3	2500	2300	0.8	3	2000	1800	0.6	3	1500	830	0.2	3
8	2	72	3000	3300	0.6	3	2500	2300	0.5	3	2000	1800	0.4	3	1500	830	0.12	3
9	2	—	3200	3900	1.2	3.5	2700	2700	1	3.5	2100	2200	0.7	3.5	1600	980	0.24	3.5
10	0.5	30	1400	1200	0.35	6.5	1200	840	0.3	6.5	940	670	0.2	6.5	700	300	0.07	6.5
10	0.5	50	1400	1200	0.3	6.5	1200	840	0.25	6.5	940	670	0.2	6.5	700	300	0.06	6.5
10	1	30	2000	2000	0.6	6	1700	1400	0.5	6	1300	1100	0.4	6	1000	500	0.12	6
10	1	50	2000	2000	0.5	6	1700	1400	0.4	6	1300	1100	0.3	6	1000	500	0.11	6
10	2	30	2900	3900	1.2	4.5	2400	2700	1	4.5	1900	2200	0.7	4.5	1500	980	0.24	4.5
10	2	50	2900	3900	1.1	4.5	2400	2700	0.9	4.5	1900	2200	0.7	4.5	1500	980	0.22	4.5
10	2	70	2400	3300	1	4.5	2000	2300	0.8	4.5	1600	1800	0.6	4.5	1200	830	0.2	4.5
10	2	90	2400	3300	1	4.5	2000	2300	0.8	4.5	1600	1800	0.6	4.5	1200	830	0.2	4.5
11	2	—	2600	3600	1.2	5	2200	2500	1	5	1700	2000	0.7	5	1300	900	0.24	5
12	0.5	36	1200	1100	0.5	8	1000	770	0.4	8	800	620	0.3	8	600	280	0.11	8
12	0.5	60	1200	1100	0.5	8	1000	770	0.4	8	800	620	0.3	8	600	280	0.1	8
12	1	36	1400	1400	0.7	7.5	1200	1000	0.6	7.5	940	780	0.4	7.5	700	350	0.14	7.5
12	1	60	1400	1400	0.6	7.5	1200	1000	0.5	7.5	940	780	0.4	7.5	700	350	0.13	7.5
12	2	36	2400	3600	1.8	6	2000	2500	1.4	6	1600	2000	1.1	6	1200	900	0.4	6
12	2	60	2400	3600	1.6	6	2000	2500	1.3	6	1600	2000	1	6	1200	900	0.3	6
12	2	84	2000	3000	1.4	6	1700	2100	1.1	6	1300	1700	0.8	6	1000	750	0.3	6
12	2	108	2000	3000	0.9	6	1700	2100	0.7	6	1300	1700	0.5	6	1000	750	0.2	6
12	3	36	2400	3600	1.8	4.5	2000	2500	1.4	4.5	1600	2000	1.1	4.5	1200	900	0.4	4.5
12	3	60	2400	3600	1.6	4.5	2000	2500	1.3	4.5	1600	2000	1	4.5	1200	900	0.3	4.5
13	3	—	2200	3600	1.8	5	1800	2500	1.4	5	1500	2000	1.1	5	1100	900	0.4	5
16	0.5	42	900	900	0.5	11	750	630	0.4	11	600	500	0.3	11	450	230	0.1	11
16	2	42	1300	1500	0.9	9	1100	1100	0.7	9	870	840	0.5	9	650	380	0.2	9
16	3	42	1800	3000	1.8	7.5	1500	2100	1.4	7.5	1200	1700	0.9	7.5	900	750	0.4	7.5
16	3	80	1800	3000	1.6	7.5	1500	2100	1.3	7.5	1200	1700	0.8	7.5	900	750	0.3	7.5
16	3	120	1500	2500	1.4	7.5	1200	1800	1.1	7.5	1000	1400	0.7	7.5	750	630	0.3	7.5
Depth of cut																		

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
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Note 4) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

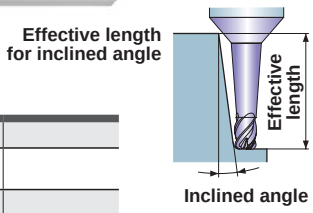
VFHVRB

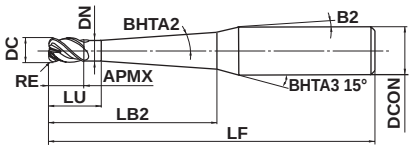
4 flute, Corner radius, Short cut length,Irregular helix flutes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎	○	○	○		

Taper neck type





DC≤10	DC>10			
±0.007	±0.01			
DC≤12				
0 - 0.02				
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●Impact Miracle corner radius end mill for high feed and efficient machining.

(mm)

Order Number	DC	RE	BHTA2	APMX	LU	LB2	DN	B2	LF	DCON	No. of Flutes	Stock	Effective length for inclined angle 0.5°	1°	2°	3°
VFHVRBD010R02N006T09	1	0.2	0.9°	1	2.5	6	0.94	9.3°	60	6	4	●	—	6.6	7.1	7.6
VFHVRBD010R02N010T09	1	0.2	0.9°	1	2.5	10	0.94	7.5°	60	6	4	●	—	10.6	11.4	12.3
VFHVRBD010R02N015T09	1	0.2	0.9°	1	2.5	15	0.94	6.1°	60	6	4	●	—	15.6	16.8	18.1
VFHVRBD010R02N020T09	1	0.2	0.9°	1	2.5	20	0.94	5.1°	80	6	4	●	—	20.6	22.1	23.9
VFHVRBD010R02N025T09	1	0.2	0.9°	1	2.5	25	0.94	4.4°	80	6	4	●	—	25.6	27.5	29.7
VFHVRBD010R02N030T09	1	0.2	0.9°	1	2.5	30	0.94	3.8°	80	6	4	●	—	30.6	32.9	35.5
VFHVRBD010R02N035T09	1	0.2	0.9°	1	2.5	35	0.94	3.4°	90	6	4	●	—	35.6	38.3	41.3
VFHVRBD010R02N040T09	1	0.2	0.9°	1	2.5	40	0.94	3.1°	90	6	4	●	—	40.6	43.6	47.2
VFHVRBD010R02N045T09	1	0.2	0.9°	1	2.5	45	0.94	2.8°	90	6	4	●	—	45.6	49	*
VFHVRBD010R02N050T09	1	0.2	0.9°	1	2.5	50	0.94	2.6°	90	6	4	●	—	50.6	54.4	*
VFHVRBD015R03N010T09	1.5	0.3	0.9°	1.5	3	10	1.44	7.1°	60	6	4	●	—	10.6	11.4	12.3
VFHVRBD015R03N015T09	1.5	0.3	0.9°	1.5	3	15	1.44	5.7°	60	6	4	●	—	15.6	16.8	18.1
VFHVRBD015R03N020T09	1.5	0.3	0.9°	1.5	3	20	1.44	4.7°	80	6	4	●	—	20.6	22.2	23.9
VFHVRBD015R03N030T09	1.5	0.3	0.9°	1.5	3	30	1.44	3.5°	80	6	4	●	—	30.6	32.9	35.6
VFHVRBD015R03N040T09	1.5	0.3	0.9°	1.5	3	40	1.44	2.8°	90	6	4	●	—	40.6	43.7	*
VFHVRBD015R03N050T09	1.5	0.3	0.9°	1.5	3	50	1.44	2.4°	90	6	4	●	—	50.6	54.4	*
VFHVRBD020R05N015T04	2	0.5	0.4°	2	4	15	1.9	5.2°	60	6	4	●	15.6	16.2	17.4	18.7
VFHVRBD020R05N020T04	2	0.5	0.4°	2	4	20	1.9	4.3°	80	6	4	●	20.6	21.3	22.9	24.7
VFHVRBD020R05N025T04	2	0.5	0.4°	2	4	25	1.9	3.6°	80	6	4	●	25.6	26.5	28.5	30.8
VFHVRBD020R05N030T04	2	0.5	0.4°	2	4	30	1.9	3.2°	80	6	4	●	30.6	31.7	34	36.8
VFHVRBD020R05N035T04	2	0.5	0.4°	2	4	35	1.9	2.8°	80	6	4	●	35.6	36.9	39.6	*
VFHVRBD020R05N040T04	2	0.5	0.4°	2	4	40	1.9	2.5°	80	6	4	●	40.6	42	45.2	*
VFHVRBD020R05N020T09	2	0.5	0.9°	2	4	20	1.9	4.4°	80	6	4	●	—	20.8	22.3	24.1
VFHVRBD020R05N025T09	2	0.5	0.9°	2	4	25	1.9	3.7°	90	6	4	●	—	25.8	27.7	29.9
VFHVRBD020R05N030T09	2	0.5	0.9°	2	4	30	1.9	3.2°	90	6	4	●	—	30.8	33	35.7
VFHVRBD020R05N035T09	2	0.5	0.9°	2	4	35	1.9	2.9°	90	6	4	●	—	35.8	38.4	*
VFHVRBD020R05N040T09	2	0.5	0.9°	2	4	40	1.9	2.6°	90	6	4	●	—	40.8	43.8	*
VFHVRBD020R05N045T09	2	0.5	0.9°	2	4	45	1.9	2.3°	90	6	4	●	—	45.8	49.2	*
VFHVRBD020R05N050T09	2	0.5	0.9°	2	4	50	1.9	2.2°	100	6	4	●	—	50.8	54.5	*
VFHVRBD020R05N055T09	2	0.5	0.9°	2	4	55	1.9	2°	100	6	4	●	—	55.8	59.9	*
VFHVRBD020R05N060T09	2	0.5	0.9°	2	4	60	1.9	1.8°	100	6	4	●	—	60.8	*	*
VFHVRBD030R08N020T09	3	0.8	0.9°	3	6	20	2.9	3.6°	80	6	4	●	—	20.9	22.4	24.1
VFHVRBD030R08N025T09	3	0.8	0.9°	3	6	25	2.9	3°	80	6	4	●	—	25.9	27.8	30
VFHVRBD030R08N030T09	3	0.8	0.9°	3	6	30	2.9	2.6°	80	6	4	●	—	30.9	33.1	*

* No interference

● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	BHTA2	APMX	LU	LB2	DN	B2	LF	DCON	No. of Flutes	Stock	Effective length for inclined angle			
													0.5°	1°	2°	3°
VFHVRBD030R08N040T09	3	0.8	0.9°	3	6	40	2.9	2°	90	6	4	●	—	40.9	43.9	*
VFHVRBD030R08N050T09	3	0.8	0.9°	3	6	50	2.9	1.7°	90	6	4	●	—	50.9	*	*
VFHVRBD030R08N060T09	3	0.8	0.9°	3	6	60	2.9	1.4°	100	6	4	●	—	60.9	*	*
VFHVRBD040R10N025T04	4	1	0.4°	4	7	25	3.9	2.1°	80	6	4	●	25.7	26.6	28.5	*
VFHVRBD040R10N030T04	4	1	0.4°	4	7	30	3.9	1.8°	80	6	4	●	30.7	31.8	*	*
VFHVRBD040R10N035T04	4	1	0.4°	4	7	35	3.9	1.6°	80	6	4	●	35.7	36.9	*	*
VFHVRBD040R10N040T04	4	1	0.4°	4	7	40	3.9	1.4°	80	6	4	●	40.7	42.1	*	*
VFHVRBD040R10N045T04	4	1	0.4°	4	7	45	3.9	1.3°	90	6	4	●	45.7	47.3	*	*
VFHVRBD040R10N050T04	4	1	0.4°	4	7	50	3.9	1.2°	90	6	4	●	50.7	52.5	*	*
VFHVRBD040R10N025T09	4	1	0.9°	4	7	25	3.9	2.2°	90	6	4	●	—	25.9	27.8	*
VFHVRBD040R10N030T09	4	1	0.9°	4	7	30	3.9	1.9°	90	6	4	●	—	30.9	*	*
VFHVRBD040R10N040T09	4	1	0.9°	4	7	40	3.9	1.4°	100	6	4	●	—	40.9	*	*
VFHVRBD040R10N050T09	4	1	0.9°	4	7	50	3.9	1.2°	100	6	4	●	—	50.9	*	*
VFHVRBD040R10N060T09	4	1	0.9°	4	7	60	3.9	1°	100	6	4	●	—	60.9	*	*
VFHVRBD060R15N040T09	6	1.5	0.9°	9	12	40	5.85	1.4°	110	8	4	●	—	41.4	*	*
VFHVRBD060R15N050T09	6	1.5	0.9°	9	12	50	5.85	1.2°	110	8	4	●	—	51.4	*	*
VFHVRBD060R15N060T09	6	1.5	0.9°	9	12	60	5.85	1°	110	8	4	●	—	61.4	*	*
VFHVRBD060R15N070T09	6	1.5	0.9°	9	12	70	5.85	0.9°	110	8	4	●	—	*	*	*
VFHVRBD080R20N060T09	8	2	0.9°	12	15	60	7.85	1°	150	10	4	●	—	61.5	*	*
VFHVRBD080R20N080T09	8	2	0.9°	12	15	80	7.85	0.8°	150	10	4	●	—	*	*	*
VFHVRBD100R20N080T09	10	2	0.9°	15	18	80	9.7	2°	130	16	4	●	—	82	88	*
VFHVRBD100R20N120T09	10	2	0.9°	15	18	120	9.7	1.4°	180	16	4	●	—	122	*	*
VFHVRBD120R20N080T09	12	2	0.9°	18	21	80	11.7	1.4°	130	16	4	●	—	82.2	*	*
VFHVRBD120R20N120T09	12	2	0.9°	18	21	120	11.7	1°	180	16	4	●	—	122.2	*	*

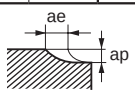
* No interference

VFHVRB

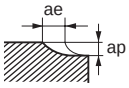
4 flute, Corner radius, Short cut length,Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

■High depth of cut conditions

Work Material				Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Taper angle one side BHTA	Neck length LU (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
1	0.2	0.9°	6	40000	6500	0.03	0.45	33000	4600	0.022	0.45	27000	3700	0.018	0.45	20000	1600	0.01	0.45
1	0.2	0.9°	10	24000	2700	0.015	0.45	20000	1900	0.01	0.45	16000	1500	0.008	0.45	12000	700	0.006	0.45
1	0.2	0.9°	15	16000	1200	0.013	0.45	14000	700	0.008	0.45	12000	500	0.007	0.45	10000	400	0.003	0.45
1	0.2	0.9°	20	14000	1000	0.01	0.45	12000	600	0.006	0.45	10000	400	0.005	0.45	9000	300	0.002	0.45
1	0.2	0.9°	25	9500	610	0.008	0.45	8000	440	0.005	0.45	6000	320	0.004	0.45	4800	160	0.002	0.45
1	0.2	0.9°	30	4900	320	0.007	0.45	4100	220	0.004	0.45	3000	160	0.003	0.45	2500	80	0.002	0.45
1	0.2	0.9°	35	4000	260	0.006	0.45	3400	190	0.003	0.45	3000	160	0.003	0.45	2000	70	0.001	0.45
1	0.2	0.9°	40	3500	180	0.005	0.45	2900	130	0.003	0.45	2000	90	0.003	0.45	1700	50	0.001	0.45
1	0.2	0.9°	45	2900	150	0.004	0.45	2400	100	0.002	0.45	2000	90	0.002	0.45	1400	40	0.001	0.45
1	0.2	0.9°	50	2900	110	0.003	0.45	2400	80	0.002	0.45	2000	60	0.002	0.45	1400	30	0.001	0.45
1.5	0.3	0.9°	10	27000	5700	0.05	0.65	22000	4000	0.035	0.65	18000	3000	0.03	0.65	14000	1400	0.014	0.65
1.5	0.3	0.9°	15	22000	3200	0.03	0.65	18000	2300	0.025	0.65	15000	1700	0.018	0.65	11000	1000	0.009	0.65
1.5	0.3	0.9°	20	16000	1400	0.02	0.65	14000	1200	0.016	0.65	13000	1000	0.012	0.65	9000	700	0.007	0.65
1.5	0.3	0.9°	30	13000	900	0.01	0.65	11000	700	0.008	0.65	10000	600	0.006	0.65	7500	400	0.004	0.65
1.5	0.3	0.9°	40	4500	230	0.008	0.65	3700	160	0.007	0.65	3000	120	0.005	0.65	2300	70	0.003	0.65
1.5	0.3	0.9°	50	3700	190	0.007	0.65	3000	130	0.006	0.65	3000	120	0.004	0.65	1900	60	0.002	0.65
2	0.5	0.4°	15	20000	7000	0.05	0.75	17000	5000	0.04	0.75	13000	3200	0.03	0.75	10000	1800	0.016	0.75
2	0.5	0.4°	20	20000	3600	0.04	0.75	17000	2600	0.03	0.75	13000	1800	0.025	0.75	10000	900	0.012	0.75
2	0.5	0.4°	25	16000	1800	0.03	0.75	14000	1400	0.025	0.75	12000	1100	0.02	0.75	9000	720	0.01	0.75
2	0.5	0.4°	30	16000	1400	0.025	0.75	14000	1200	0.02	0.75	12000	900	0.016	0.75	9000	650	0.008	0.75
2	0.5	0.4°	35	13000	1100	0.02	0.75	11000	800	0.018	0.75	10000	700	0.014	0.75	7000	500	0.007	0.75
2	0.5	0.4°	40	13000	1000	0.02	0.75	11000	700	0.015	0.75	10000	600	0.012	0.75	7000	400	0.006	0.75
2	0.5	0.9°	20	20000	3600	0.04	0.75	17000	2600	0.03	0.75	13000	1800	0.025	0.75	10000	900	0.012	0.75
2	0.5	0.9°	25	16000	1800	0.03	0.75	14000	1400	0.025	0.75	12000	1100	0.02	0.75	9000	720	0.01	0.75
2	0.5	0.9°	30	16000	1400	0.025	0.75	14000	1200	0.02	0.75	12000	900	0.016	0.75	9000	650	0.008	0.75
2	0.5	0.9°	35	13000	1100	0.02	0.75	11000	800	0.018	0.75	10000	700	0.014	0.75	7000	500	0.007	0.75
2	0.5	0.9°	40	13000	1000	0.02	0.75	11000	700	0.015	0.75	10000	600	0.012	0.75	7000	400	0.006	0.75
2	0.5	0.9°	45	8000	500	0.016	0.75	6800	360	0.012	0.75	5200	250	0.01	0.75	4000	120	0.005	0.75
2	0.5	0.9°	50	8000	500	0.016	0.75	6800	360	0.012	0.75	5200	250	0.01	0.75	4000	120	0.005	0.75
2	0.5	0.9°	55	4100	230	0.012	0.75	3500	170	0.009	0.75	2700	120	0.008	0.75	2000	60	0.004	0.75
2	0.5	0.9°	60	4100	230	0.012	0.75	3500	170	0.009	0.75	2700	120	0.008	0.75	2000	60	0.004	0.75
3	0.8	0.9°	20	13000	7200	0.19	1	11000	5100	0.15	1	8700	4000	0.11	1	6500	1800	0.06	1
3	0.8	0.9°	25	13000	7200	0.19	1	11000	5100	0.15	1	8700	4000	0.11	1	6500	1800	0.06	1
3	0.8	0.9°	30	13000	5700	0.12	1	11000	4000	0.09	1	8700	3000	0.07	1	6500	1400	0.04	1
3	0.8	0.9°	40	11000	3600	0.08	1	9100	2600	0.06	1	7400	2000	0.05	1	5500	1000	0.025	1
3	0.8	0.9°	50	8000	2600	0.07	1	6600	1800	0.05	1	5800	1500	0.04	1	4600	800	0.02	1
3	0.8	0.9°	60	7800	2480	0.06	1	6600	1740	0.05	1	5000	1250	0.04	1	3900	610	0.02	1
Depth of cut																			

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Air blow or oil mist is recommended for good chip evacuation.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

Work Material				Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. DC (mm)	Corner R RE (mm)	Taper angle one side BHTA2	Neck length LB2 (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
4	1	0.4°	25	10000	9900	0.24	1.5	8300	7000	0.19	1.5	6700	5600	0.14	1.5	5000	2500	0.07	1.5
4	1	0.4°	30	10000	9900	0.24	1.5	8300	7000	0.19	1.5	6700	5600	0.14	1.5	5000	2500	0.07	1.5
4	1	0.4°	35	10000	9900	0.15	1.5	8300	7000	0.12	1.5	6700	5600	0.09	1.5	5000	2500	0.04	1.5
4	1	0.4°	40	10000	9900	0.15	1.5	8300	7000	0.12	1.5	6700	5600	0.09	1.5	5000	2500	0.04	1.5
4	1	0.4°	45	10000	9900	0.15	1.5	8300	7000	0.12	1.5	6700	5600	0.09	1.5	5000	2500	0.04	1.5
4	1	0.4°	50	8100	6300	0.14	1.5	6700	4420	0.11	1.5	5400	3500	0.08	1.5	4000	1600	0.04	1.5
4	1	0.9°	25	10000	9900	0.24	1.5	8300	7000	0.19	1.5	6700	5600	0.14	1.5	5000	2500	0.07	1.5
4	1	0.9°	30	10000	9900	0.15	1.5	8300	7000	0.12	1.5	6700	5600	0.09	1.5	5000	2500	0.04	1.5
4	1	0.9°	40	10000	9900	0.15	1.5	8300	7000	0.12	1.5	6700	5600	0.09	1.5	5000	2500	0.04	1.5
4	1	0.9°	50	8100	6300	0.14	1.5	6700	4420	0.11	1.5	5400	3500	0.08	1.5	4000	1600	0.04	1.5
4	1	0.9°	60	8100	6300	0.11	1.5	6700	4420	0.08	1.5	5400	3500	0.06	1.5	4000	1600	0.03	1.5
6	1.5	0.9°	40	6600	11000	0.4	2	5500	7600	0.32	2	4500	6100	0.24	2	3300	2700	0.12	2
6	1.5	0.9°	50	6600	11000	0.4	2	5500	7600	0.32	2	4500	6100	0.24	2	3300	2700	0.12	2
6	1.5	0.9°	60	6600	11000	0.25	2	5500	7600	0.2	2	4500	6100	0.15	2	3300	2700	0.08	2
6	1.5	0.9°	70	5400	8700	0.23	2	4400	6200	0.18	2	3600	5000	0.14	2	2700	2200	0.07	2
8	2	0.9°	60	5000	11000	0.48	3	4200	7600	0.37	3	3300	6100	0.29	3	2500	2700	0.14	3
8	2	0.9°	80	5000	11000	0.3	3	4200	7600	0.23	3	3300	6100	0.18	3	2500	2700	0.09	3
10	2	0.9°	80	4000	11000	0.48	4.5	3300	7600	0.37	4.5	2700	6100	0.29	4.5	2000	2700	0.14	4.5
10	2	0.9°	120	3200	8700	0.27	4.5	2700	6200	0.21	4.5	2100	5000	0.16	4.5	1600	2200	0.08	4.5
12	2	0.9°	80	3300	10000	0.72	6	2700	7100	0.56	6	2200	5600	0.36	6	1700	2500	0.18	6
12	2	0.9°	120	3300	10000	0.45	6	2700	7100	0.35	6	2200	5600	0.23	6	1700	2500	0.12	6
Depth of cut																			

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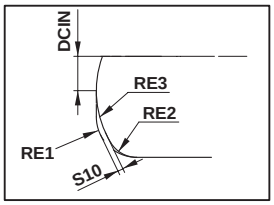
VFFDRB

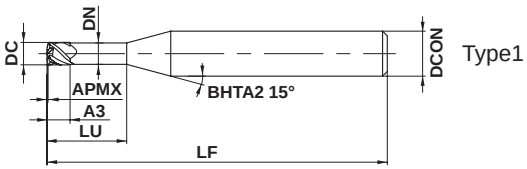
Multi-task corner radius end mill for impact miracle high speed cutting

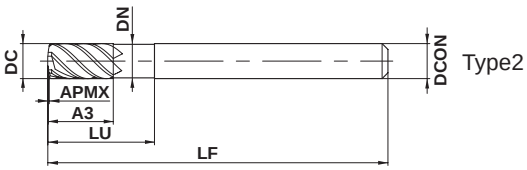
TOOL NEWS

UWC VF 40° DC≤6 DC≥8

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				







DC≤12				
0 - 0.020				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

- Multi-task corner radius type allows more efficient high feed.
- Adoption of multiple cuttings realized high feed cutting.

(mm)

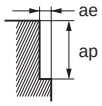
Order Number	DC	RE1 *1	APMX	A3 *3	LU	DN	LF	DCON	No. of Flutes	Multi-task radius part				RMPX *2	Stock	Type
										S10	DCIN	RE2	RE3			
VFFDRBD0300	3	0.64	0.18	3	10	2.8	60	6	4	0.08	0.75	0.5	2	2.1°	●	1
VFFDRBD0400	4	0.71	0.25	4	12	3.8	60	6	4	0.13	1	0.5	3	1.9°	●	1
VFFDRBD0600	6	0.92	0.36	9	18	5.6	80	6	4	0.21	1.5	0.6	5	1.7°	●	2
VFFDRBD0800	8	1.16	0.44	12	24	7.6	90	8	6	0.22	3.2	0.8	4.5	1.7°	●	2
VFFDRBD1000	10	1.47	0.57	15	30	9.4	100	10	6	0.28	4	1	5.5	1.7°	●	2
VFFDRBD1200	12	1.77	0.7	18	36	11.4	110	12	6	0.34	4.8	1.2	6.5	1.8°	●	2

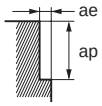
*1 RE1 : Approx. R
*2 RMPX : Max. Ramping Angle
*3 A3 : Cutting Edge Effective Length

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS FOR IMPACT MIRACLE END MILLS

■ Side milling

Work Material	Carbon steel, Alloy steel (180—280HB), Alloy tool steel (≤350HB), Mild steel (≤180HB) AISI 1045, AISI 4140, ASTM A36, AISI 1010						Prehardened steel (35—45HRC) AISI P21, AISI P20, AISI 4340					
Dia. **DC** (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min^{-1})	Feed per Tooth (mm/t.)	Table Feed per Min. (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min^{-1})	Feed per Tooth (mm/t.)	Table Feed per Min. (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
3	80	8500	0.07	2400	0.12	1.5	100	11000	0.07	3100	0.12	1.5
4	80	6400	0.1	2600	0.16	2	100	8000	0.1	3200	0.16	2
6	80	4200	0.17	2900	0.24	3	100	5300	0.17	3600	0.24	3
8	80	3200	0.17	3300	0.32	4.8	100	4000	0.17	4100	0.32	4.8
10	80	2500	0.2	3000	0.4	6	100	3200	0.2	3800	0.4	6
12	80	2100	0.22	2800	0.48	7.2	100	2700	0.22	3600	0.48	7.2
Depth of cut												

Work Material	Hardened steel (40—55HRC), Ferritic and martensitic stainless steel (>200HB), Precipitation hardening stainless steel (<450HB), AISI H13, L6, AISI 431, AISI 420, 15-5PH, 17-4PH etc.						Hardened steel (55—62HRC) AISI D2 etc.					
Dia. **DC** (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min^{-1})	Feed per Tooth (mm/t.)	Table Feed per Min. (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min^{-1})	Feed per Tooth (mm/t.)	Table Feed per Min. (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
3	80	8500	0.07	2400	0.12	1.5	40	4200	0.05	840	0.12	1.5
4	80	6400	0.1	2600	0.16	2	40	3200	0.07	960	0.16	2
6	80	4200	0.17	2900	0.24	3	40	2100	0.15	1300	0.24	3
8	80	3200	0.17	3300	0.32	4.8	40	1600	0.15	1400	0.32	4.8
10	80	2500	0.2	3000	0.4	6	40	1300	0.17	1300	0.4	6
12	80	2100	0.22	2800	0.48	7.2	40	1100	0.2	1300	0.48	7.2
Depth of cut												

Note 1) When ramping process set the feedrate at 50%. A ramping angle of 1˚ is recommended.
Note 2) Use at a revolution of 70% and feedrate of 50% when the tool overhang exceeds 5D.

DC:Dia.

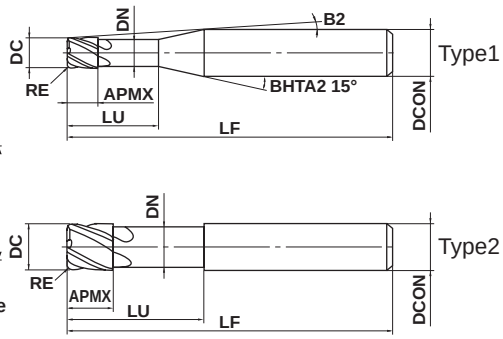
VCPSRB MIRACLE ORBIT

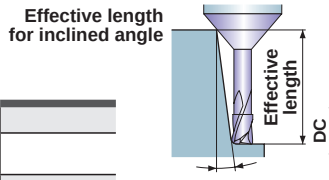
Corner radius end mill, Short cut length, 2−4 flute, High precision

TOOL NEWS

UWC VC 30° DC≤1.5 DC≥2

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○	○	○		





0.05≤RE≤5				
±0.01				
0.6≤DC≤12				
0 - 0.01				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.005	0 - 0.006	0 - 0.008		

h5

●±0.01mm corner radius tolerance, 0−-0.01mm outer diameter tolerance.
End mill with corner radius for precise and efficient machining.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VCPSRBD0060N02R005	0.6	0.05	0.6	2	0.56	12.6°	50	6	2	●	1	2.1	2.2	2.4	2.6
VCPSRBD0060N02R01	0.6	0.1	0.6	2	0.56	12.6°	50	6	2	●	1	2.1	2.2	2.3	2.6
VCPSRBD0060N02R02	0.6	0.2	0.6	2	0.56	12.7°	50	6	2	●	1	2.1	2.2	2.2	2.5
VCPSRBD0060N04R01	0.6	0.1	0.6	4	0.56	10.9°	50	6	2	●	1	4.2	4.4	4.7	5.1
VCPSRBD0060N04R02	0.6	0.2	0.6	4	0.56	11°	50	6	2	●	1	4.2	4.3	4.7	5
VCPSRBD0080N04R005	0.8	0.05	0.8	4	0.76	10.7°	50	6	2	●	1	4.2	4.4	4.7	5.1
VCPSRBD0080N04R01	0.8	0.1	0.8	4	0.76	10.8°	50	6	2	●	1	4.2	4.4	4.7	5.1
VCPSRBD0080N04R02	0.8	0.2	0.8	4	0.76	10.8°	50	6	2	●	1	4.2	4.3	4.7	5
VCPSRBD0080N04R03	0.8	0.3	0.8	4	0.76	10.9°	50	6	2	●	1	4.2	4.3	4.6	5
VCPSRBD0080N06R01	0.8	0.1	0.8	6	0.76	9.4°	50	6	2	●	1	6.3	6.5	7	7.5
VCPSRBD0080N06R02	0.8	0.2	0.8	6	0.76	9.5°	50	6	2	●	1	6.3	6.5	7	7.5
VCPSRBD0080N06R03	0.8	0.3	0.8	6	0.76	9.5°	50	6	2	●	1	6.3	6.5	6.9	7.5
VCPSRBD0080N08R03	0.8	0.3	0.8	8	0.76	8.5°	50	6	2	●	1	8.3	8.6	9.2	10
VCPSRBD0100N04R005	1	0.05	1	4	0.94	10.5°	50	6	2	●	1	4.2	4.5	4.8	5.3
VCPSRBD0100N04R01	1	0.1	1	4	0.94	10.5°	50	6	2	●	1	4.2	4.5	4.8	5.3
VCPSRBD0100N04R02	1	0.2	1	4	0.94	10.6°	50	6	2	●	1	4.2	4.5	4.7	5.3
VCPSRBD0100N04R03	1	0.3	1	4	0.94	10.6°	50	6	2	●	1	4.2	4.5	4.6	5.2
VCPSRBD0100N04R04	1	0.4	1	4	0.94	10.7°	50	6	2	●	1	4.2	4.5	4.4	5.2
VCPSRBD0100N06R01	1	0.1	1	6	0.94	9.2°	50	6	2	●	1	6.4	6.7	7.2	7.8
VCPSRBD0100N06R02	1	0.2	1	6	0.94	9.2°	50	6	2	●	1	6.4	6.7	7.2	7.7
VCPSRBD0100N06R03	1	0.3	1	6	0.94	9.3°	50	6	2	●	1	6.3	6.6	7.2	7.7
VCPSRBD0100N06R04	1	0.4	1	6	0.94	9.4°	50	6	2	●	1	6.3	6.6	7.1	7.7
VCPSRBD0100N10R03	1	0.3	1	10	0.94	7.4°	50	6	2	●	1	10.5	10.9	11.8	12.7
VCPSRBD0100N10R04	1	0.4	1	10	0.94	7.4°	50	6	2	●	1	10.5	10.9	11.7	12.7
VCPSRBD0120N06R05	1.2	0.5	1.2	6	1.14	9.3°	50	6	2	●	1	6.3	6.6	7.1	7.7
VCPSRBD0120N10R05	1.2	0.5	1.2	10	1.14	7.3°	50	6	2	●	1	10.5	10.9	11.7	12.6
VCPSRBD0120N15R05	1.2	0.5	1.2	15	1.14	5.8°	50	6	2	●	1	15.7	16.3	17.5	18.9
VCPSRBD0150N04R01	1.5	0.1	1.5	4	1.44	10.2°	50	6	2	●	1	4.2	4.5	4.8	5.3
VCPSRBD0150N04R02	1.5	0.2	1.5	4	1.44	10.2°	50	6	2	●	1	4.2	4.5	4.7	5.3
VCPSRBD0150N04R03	1.5	0.3	1.5	4	1.44	10.3°	50	6	2	●	1	4.2	4.5	4.6	5.2
VCPSRBD0150N04R05	1.5	0.5	1.5	4	1.44	10.5°	50	6	2	●	1	4.2	4.4	4.3	5.2
VCPSRBD0150N06R01	1.5	0.1	1.5	6	1.44	8.8°	50	6	2	●	1	6.4	6.7	7.2	7.8
VCPSRBD0150N06R02	1.5	0.2	1.5	6	1.44	8.9°	50	6	2	●	1	6.4	6.7	7.2	7.7
VCPSRBD0150N06R03	1.5	0.3	1.5	6	1.44	8.9°	50	6	2	●	1	6.3	6.6	7.2	7.7

● : Inventory maintained in Japan.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
VCPSRBD0150N06R05	1.5	0.5	1.5	6	1.44	9°	50	6	2	●	1	6.3	6.6	7.1	7.7
VCPSRBD0150N10R01	1.5	0.1	1.5	10	1.44	6.9°	50	6	2	●	1	10.6	11	11.8	12.7
VCPSRBD0150N10R02	1.5	0.2	1.5	10	1.44	7°	50	6	2	●	1	10.5	11	11.8	12.7
VCPSRBD0150N10R03	1.5	0.3	1.5	10	1.44	7°	50	6	2	●	1	10.5	10.9	11.8	12.7
VCPSRBD0150N10R05	1.5	0.5	1.5	10	1.44	7.1°	50	6	2	●	1	10.5	10.9	11.7	12.6
VCPSRBD0150N15R01	1.5	0.1	1.5	15	1.44	5.5°	50	6	2	●	1	15.8	16.3	17.5	18.9
VCPSRBD0150N15R02	1.5	0.2	1.5	15	1.44	5.5°	50	6	2	●	1	15.8	16.3	17.5	18.9
VCPSRBD0150N15R03	1.5	0.3	1.5	15	1.44	5.5°	50	6	2	●	1	15.7	16.3	17.5	18.9
VCPSRBD0150N15R05	1.5	0.5	1.5	15	1.44	5.7°	50	6	2	●	1	15.7	16.3	17.4	18.6
VCPSRBD0150N20R03	1.5	0.3	1.5	20	1.44	4.7°	60	6	2	●	1	20.9	21.6	22.9	24.5
VCPSRBD0150N20R05	1.5	0.5	1.5	20	1.44	4.8°	60	6	2	●	1	20.9	21.5	22.8	24.2
VCPSRBD0200N06R01	2	0.1	2	6	1.9	9.4°	50	6	4	●	1	6.3	6.6	6.9	7.5
VCPSRBD0200N06R02	2	0.2	2	6	1.9	9.7°	50	6	4	●	1	6.3	6.6	6.8	7.4
VCPSRBD0200N06R03	2	0.3	2	6	1.9	10°	50	6	4	●	1	6.3	6.6	6.7	7.4
VCPSRBD0200N06R05	2	0.5	2	6	1.9	10.3°	50	6	4	●	1	6.3	6.5	6.5	7.4
VCPSRBD0200N10R01	2	0.1	2	10	1.9	7.6°	50	6	4	●	1	10.5	10.9	11.4	12
VCPSRBD0200N10R02	2	0.2	2	10	1.9	7.7°	50	6	4	●	1	10.5	10.8	11.2	12
VCPSRBD0200N10R03	2	0.3	2	10	1.9	7.8°	50	6	4	●	1	10.5	10.8	11.1	11.9
VCPSRBD0200N10R05	2	0.5	2	10	1.9	8°	50	6	4	●	1	10.5	10.8	10.9	11.9
VCPSRBD0200N15R01	2	0.1	2	15	1.9	5.9°	50	6	4	●	1	15.7	16.1	16.8	17.5
VCPSRBD0200N15R02	2	0.2	2	15	1.9	5.9°	50	6	4	●	1	15.7	16.1	16.7	17.5
VCPSRBD0200N15R03	2	0.3	2	15	1.9	6°	50	6	4	●	1	15.7	16.1	16.6	17.4
VCPSRBD0200N15R05	2	0.5	2	15	1.9	6.1°	50	6	4	●	1	15.6	16.1	16.3	17.4
VCPSRBD0200N20R03	2	0.3	2	20	1.9	4.8°	60	6	4	●	1	20.8	21.4	21.9	22.9
VCPSRBD0200N20R05	2	0.5	2	20	1.9	4.9°	60	6	4	●	1	20.8	21.4	21.7	22.9
VCPSRBD0200N25R03	2	0.3	2	25	1.9	4°	60	6	4	●	1	26	26.6	27.5	28.3
VCPSRBD0200N25R05	2	0.5	2	25	1.9	4°	60	6	4	●	1	26	26.6	27	28.2
VCPSRBD0250N08R01	2.5	0.1	2.5	8	2.4	8.6°	50	6	4	●	1	8.4	8.7	9.2	9.9
VCPSRBD0250N08R02	2.5	0.2	2.5	8	2.4	8.7°	50	6	4	●	1	8.4	8.7	9	9.9
VCPSRBD0250N08R03	2.5	0.3	2.5	8	2.4	8.8°	50	6	4	●	1	8.4	8.7	8.9	9.9
VCPSRBD0250N08R05	2.5	0.5	2.5	8	2.4	9°	50	6	4	●	1	8.4	8.7	8.7	9.9
VCPSRBD0250N08R10	2.5	1	2.5	8	2.4	9.4°	50	6	4	●	1	8.3	8.7	8.2	9.9
VCPSRBD0250N15R03	2.5	0.3	2.5	15	2.4	5.5°	50	6	4	●	1	15.7	16.1	16.6	17.5
VCPSRBD0250N15R05	2.5	0.5	2.5	15	2.4	5.6°	50	6	4	●	1	15.6	16.1	16.3	17.5
VCPSRBD0250N15R10	2.5	1	2.5	15	2.4	5.7°	50	6	4	●	1	15.6	16.1	15.8	17.5
VCPSRBD0300N10R01	3	0.1	3	10	2.9	6.6°	60	6	4	●	1	10.5	10.9	11.4	12.3
VCPSRBD0300N10R02	3	0.2	3	10	2.9	6.6°	60	6	4	●	1	10.5	10.8	11.2	12.3
VCPSRBD0300N10R03	3	0.3	3	10	2.9	6.6°	60	6	4	●	1	10.5	10.8	11.1	12.3
VCPSRBD0300N10R05	3	0.5	3	10	2.9	6.7°	60	6	4	●	1	10.5	10.8	10.9	12.4
VCPSRBD0300N10R10	3	1	3	10	2.9	7°	60	6	4	●	1	10.4	10.8	10.4	12.4
VCPSRBD0300N15R01	3	0.1	3	15	2.9	4.8°	60	6	4	●	1	15.7	16.1	16.8	17.7
VCPSRBD0300N15R02	3	0.2	3	15	2.9	4.8°	60	6	4	●	1	15.7	16.1	16.7	17.8
VCPSRBD0300N15R03	3	0.3	3	15	2.9	4.8°	60	6	4	●	1	15.7	16.1	16.6	17.8
VCPSRBD0300N15R05	3	0.5	3	15	2.9	4.8°	60	6	4	●	1	15.6	16.1	16.3	17.8
VCPSRBD0300N15R10	3	1	3	15	2.9	5°	60	6	4	●	1	15.6	16.1	15.8	17.8
VCPSRBD0300N20R01	3	0.1	3	20	2.9	3.7°	60	6	4	●	1	20.8	21.4	22.1	23.1
VCPSRBD0300N20R02	3	0.2	3	20	2.9	3.7°	60	6	4	●	1	20.8	21.4	22	23.1
VCPSRBD0300N20R03	3	0.3	3	20	2.9	3.8°	60	6	4	●	1	20.8	21.4	21.9	23.2
VCPSRBD0300N20R05	3	0.5	3	20	2.9	3.8°	60	6	4	●	1	20.8	21.4	21.7	23.2
VCPSRBD0300N20R10	3	1	3	20	2.9	3.9°	60	6	4	●	1	20.8	21.3	21.2	23.2
VCPSRBD0300N30R03	3	0.3	3	30	2.9	2.6°	70	6	4	●	1	31.1	31.8	32.5	*
VCPSRBD0300N30R05	3	0.5	3	30	2.9	2.6°	70	6	4	●	1	31.1	31.8	32.2	*

* No interference

VCPSRB MIRACLE ORBIT

Corner radius end mill, Short cut length, 2—4 flute, High precision

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VCPSRBD0400N12R01	4	0.1	4	12	3.9	3.8°	60	6	4	●	1	12.5	13	13.5	15.1
VCPSRBD0400N12R02	4	0.2	4	12	3.9	3.8°	60	6	4	●	1	12.5	13	13.4	15.2
VCPSRBD0400N12R03	4	0.3	4	12	3.9	3.8°	60	6	4	●	1	12.5	13	13.3	15.2
VCPSRBD0400N12R05	4	0.5	4	12	3.9	3.9°	60	6	4	●	1	12.5	13	13.1	15.3
VCPSRBD0400N12R10	4	1	4	12	3.9	4°	60	6	4	●	1	12.5	12.9	12.6	15.3
VCPSRBD0400N20R01	4	0.1	4	20	3.9	2.5°	60	6	4	●	1	20.8	21.4	22.1	*
VCPSRBD0400N20R02	4	0.2	4	20	3.9	2.5°	60	6	4	●	1	20.8	21.4	22	*
VCPSRBD0400N20R03	4	0.3	4	20	3.9	2.5°	60	6	4	●	1	20.8	21.4	21.9	*
VCPSRBD0400N20R05	4	0.5	4	20	3.9	2.5°	60	6	4	●	1	20.8	21.4	21.7	*
VCPSRBD0400N20R10	4	1	4	20	3.9	2.6°	60	6	4	●	1	20.8	21.3	21.2	*
VCPSRBD0400N30R03	4	0.3	4	30	3.9	1.8°	70	6	4	●	1	31.1	31.8	*	*
VCPSRBD0400N30R05	4	0.5	4	30	3.9	1.8°	70	6	4	●	1	31.1	31.8	*	*
VCPSRBD0400N30R10	4	1	4	30	3.9	1.8°	70	6	4	●	1	31.1	31.8	*	*
VCPSRBD0500N15R05	5	0.5	5	15	4.9	1.6°	60	6	4	●	1	15.6	16.1	*	*
VCPSRBD0500N15R10	5	1	5	15	4.9	1.6°	60	6	4	●	1	15.6	16.1	*	*
VCPSRBD0500N30R05	5	0.5	5	30	4.9	0.9°	70	6	4	●	1	31.1	*	*	*
VCPSRBD0500N30R10	5	1	5	30	4.9	0.9°	70	6	4	●	1	31.1	*	*	*
VCPSRBD0600N18R01	6	0.1	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N18R02	6	0.2	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N18R03	6	0.3	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N18R05	6	0.5	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N18R10	6	1	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N18R20	6	2	6	18	5.85	—	70	6	4	●	2	*	*	*	*
VCPSRBD0600N41R05	6	0.5	6	41	5.85	—	90	6	4	●	2	*	*	*	*
VCPSRBD0600N50R10	6	1	6	50	5.85	—	90	6	4	●	2	*	*	*	*
VCPSRBD0800N24R01	8	0.1	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R02	8	0.2	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R03	8	0.3	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R05	8	0.5	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R10	8	1	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R20	8	2	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N24R30	8	3	8	24	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N50R10	8	1	8	50	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD0800N50R30	8	3	8	50	7.85	—	90	8	4	●	2	*	*	*	*
VCPSRBD1000N30R03	10	0.3	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N30R05	10	0.5	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N30R10	10	1	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N30R20	10	2	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N30R30	10	3	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N30R40	10	4	10	30	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N50R10	10	1	10	50	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1000N50R30	10	3	10	50	9.7	—	100	10	4	●	2	*	*	*	*
VCPSRBD1200N36R03	12	0.3	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R05	12	0.5	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R10	12	1	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R20	12	2	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R30	12	3	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R40	12	4	12	36	11.7	—	110	12	4	●	2	*	*	*	*
VCPSRBD1200N36R50	12	5	12	36	11.7	—	110	12	4	●	2	*	*	*	*

* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45－55HRC) AISI H13		Hardened steel (55－62HRC) AISI D2	
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.6	2	48000	200－ 600	40000	160－ 500	22000	80－ 250
	4	48000	160－ 500	40000	100－ 300	22000	50－ 150
0.8	4	48000	240－ 750	32000	160－ 500	19000	80－ 250
	6	38000	190－ 600	26000	130－ 400	16000	70－ 200
	8	29000	150－ 450	19000	100－ 300	12000	50－ 150
1	4	48000	270－ 900	32000	180－ 600	19000	90－ 300
	6	38000	220－ 720	26000	150－ 480	16000	70－ 240
	10	29000	160－ 540	19000	110－ 360	12000	60－ 180
1.2	6	48000	300－ 900	32000	200－ 600	19000	100－ 300
	10	38000	240－ 720	26000	160－ 480	15000	80－ 240
	15	29000	180－ 540	19000	120－ 360	12000	60－ 180
1.5	4	41000	300－ 900	27000	200－ 600	16000	100－ 300
	6	32000	240－ 720	22000	160－ 480	13000	80－ 240
	10	24000	180－ 540	16000	120－ 360	10000	60－ 180
2	6	36000	600－2000	24000	400－1300	14000	200－ 650
	10	29000	480－1600	19000	320－1000	12000	160－ 520
	15	22000	360－1200	14000	240－ 780	9000	120－ 390
2.5	8	33000	750－2400	22000	500－1600	13000	250－ 800
	15	20000	450－1400	13000	300－ 960	8000	150－ 480
3	10	30000	900－3000	20000	600－2000	12000	300－1000
	15	24000	720－2400	16000	480－1600	10000	240－ 800
	20	18000	540－1800	12000	360－1200	7000	180－ 600
4	12	26000	1200－4500	17000	800－3000	10000	400－1500
	20	20000	960－2000	14000	640－2000	8000	320－2000
	30	15000	720－1000	10000	480－1000	6000	240－1000
5	15	20000	1200－4800	13000	780－3120	10000	520－2000
	30	12000	720－1900	8000	480－1600	7000	360－1120
6	18	20000	1600－7500	13000	1100－5000	8000	550－2500
	41	15000	900－2400	12000	720－1600	10000	600－1200
	50	10000	600－1200	8000	480－ 800	6000	360－ 530
8	24	15000	1900－7500	10000	1300－5000	6000	650－2500
	50	10000	1300－2400	8000	1000－2200	3000	320－ 600
10	30	12000	1600－7500	8000	1100－5000	5000	550－2500
	50	10000	1300－3200	7000	950－2200	2500	280－ 600
12	36	10000	1500－7500	7000	1000－5000	4000	500－2500
Depth of cut		≤0.2RE (DC≤ϕ2) ≤0.4RE (DC＞ϕ2) ≤0.1mm (DC≤ϕ1.5) ≤0.2mm (DC≤ϕ4) ≤0.5mm (DC≤ϕ6)		≤0.1RE (DC≤ϕ2) ≤0.2RE (DC＞ϕ2) ≤0.05mm (DC≤ϕ1.5) ≤0.1mm (DC≤ϕ4) ≤0.3mm (DC≤ϕ6)			

DC:Dia.

Note 1) The cutting conditions above are a guide only to machining with cutting edges with a corner radius. When machining with peripheral cutting edges, use the minimum feed rate as a guide.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VCPSRB MIRACLE ORBIT

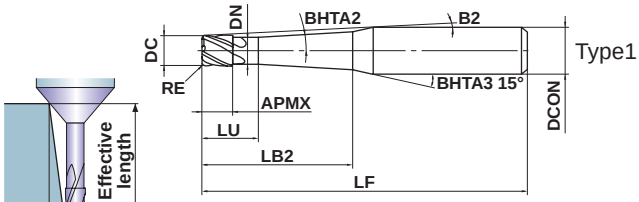
Corner radius end mill, Short cut length, 2−4 flute, High precision

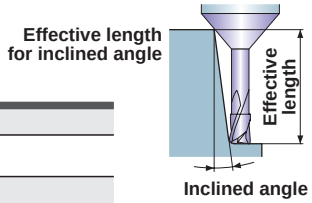
TOOL NEWS

UWC VC γ 30° DC≤1.5 DC≥2

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○	○	○		

Taper neck type





0.5≤RE≤3				
±0.01				
1.5≤DC≤12				
0 - 0.01				
DCON=6	8≤DCON≤10	12≤DCON≤16		
0 - 0.005	0 - 0.006	0 - 0.008		

●±0.01mm corner radius tolerance, 0−-0.01mm outer diameter tolerance.
End mill with corner radius for precise and efficient machining.

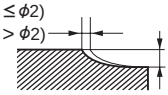
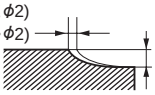
(mm)

Order Number	DC	RE	BHTA2	APMX	LB2	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 1°	2°	3°
VCPSRBD0150N03L06R05	1.5	0.5	1.5°	1.5	6	3	1.44	9°	50	6	2	●	1	–	7.1	7.7
VCPSRBD0150N03L10R05	1.5	0.5	1.5°	1.5	10	3	1.44	7.2°	50	6	2	●	1	–	11.3	12.2
VCPSRBD0200N04L10R05	2	0.5	1.5°	2	10	4	1.9	6.7°	60	6	4	●	1	–	11.5	12.4
VCPSRBD0200N04L15R05	2	0.5	1.5°	2	15	4	1.9	5.3°	60	6	4	●	1	–	16.7	18
VCPSRBD0250N05L12R10	2.5	1	1.5°	2.5	12	5	2.4	5.6°	60	6	4	●	1	–	14.2	15.3
VCPSRBD0250N05L20R10	2.5	1	1.5°	2.5	20	5	2.4	4°	60	6	4	●	1	–	22.5	24.2
VCPSRBD0300N06L15R05	3	0.5	1.5°	3	15	6	2.9	4.4°	60	6	4	●	1	–	16.9	18.2
VCPSRBD0300N06L15R10	3	1	1.5°	3	15	6	2.9	4.4°	60	6	4	●	1	–	17.4	18.7
VCPSRBD0300N06L20R05	3	0.5	1.5°	3	20	6	2.9	3.6°	60	6	4	●	1	–	22.1	23.8
VCPSRBD0300N06L20R10	3	1	1.5°	3	20	6	2.9	3.6°	60	6	4	●	1	–	22.6	24.4
VCPSRBD0400N08L20R10	4	1	1.5°	4	20	8	3.9	2.6°	60	6	4	●	1	–	22.8	*
VCPSRBD0400N08L30R10	4	1	1.5°	4	30	8	3.9	1.9°	70	6	4	●	1	–	*	*
VCPSRBD0500N08L40R05	5	0.5	1°	5	40	8	4.9	2°	90	8	4	●	1	41.2	*	*
VCPSRBD0500N08L40R10	5	1	1°	5	40	8	4.9	2°	90	8	4	●	1	41.7	*	*
VCPSRBD0500N08L60R05	5	0.5	1°	5	60	8	4.9	1.4°	110	8	4	●	1	61.2	*	*
VCPSRBD0500N08L60R10	5	1	1°	5	60	8	4.9	1.4°	110	8	4	●	1	61.7	*	*
VCPSRBD0600N08L40R20	6	2	1°	6	40	8	5.85	1.4°	70	8	4	●	1	42.8	*	*
VCPSRBD0600N08L60R20	6	2	1°	6	60	8	5.85	1°	100	8	4	●	1	*	*	*
VCPSRBD0800N10L53R20	8	2	1°	8	53	10	7.85	1.1°	90	10	4	●	1	55.9	*	*
VCPSRBD0800N10L70R20	8	2	1°	8	70	10	7.85	1.6°	130	12	4	●	1	72.9	*	*
VCPSRBD1000N12L55R30	10	3	1°	10	55	12	9.7	1.1°	100	12	4	●	1	59.4	*	*
VCPSRBD1000N12L70R30	10	3	1°	10	70	12	9.7	0.9°	130	12	4	●	1	*	*	*
VCPSRBD1200N24L70R30	12	3	1°	12	70	24	11.7	1.6°	130	16	4	●	1	75.2	*	*

* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45－55HRC) AISI H13		Hardened steel (55－62HRC) AISI D2	
Dia. **DC** (mm)	Taper angle one side **DHTA**	Neck length **LU_2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1.5	1.5°	6	36000	270－ 810	24000	180－ 540	15000	90－ 270
	1.5°	10	28000	210－ 630	19000	140－ 420	11000	70－ 210
2	1.5°	10	32000	540－1800	22000	360－1200	13000	180－ 590
	1.5°	15	25000	420－1400	17000	280－ 910	10000	140－ 460
2.5	1.5°	12	26000	600－1900	18000	400－1300	11000	200－ 640
	1.5°	20	20000	450－ 140	13000	300－ 960	8000	150－ 480
3	1.5°	15	27000	810－2700	18000	540－1800	11000	270－ 900
	1.5°	20	21000	630－2100	14000	420－1400	8000	210－ 700
4	1.5°	20	23000	1080－3000	15000	720－3000	9000	360－3000
	1.5°	30	18000	840－1500	12000	560－1500	7000	280－1500
5	1°	40	10000	520－1400	7000	420－ 840	5000	260－ 600
	1°	60	7000	360－ 840	5000	300－ 500	4000	210－ 400
6	1°	40	20000	1650－4500	13000	1100－3000	8000	550－1500
8	1°	53	15000	1950－4500	10000	1300－3000	6000	650－1500
10	1°	55	12000	1650－4500	8000	1100－3000	5000	550－1500
Depth of cut			≤0.2RE (DC≤ϕ2) ≤0.4RE (DC＞ϕ2)  ≤0.1mm (DC≤ϕ1.5) ≤0.2mm (DC≤ϕ4) ≤0.5mm (DC≤ϕ6)		≤0.1RE (DC≤ϕ2) ≤0.2RE (DC＞ϕ2)  ≤0.05mm (DC≤ϕ1.5) ≤0.1mm (DC≤ϕ4) ≤0.3mm (DC≤ϕ6)			

DC:Dia.

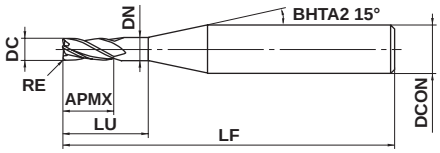
Note 1) The cutting conditions above are a guide only to machining with cutting edges with a corner radius. When machining with peripheral cutting edges, use the minimum feed rate as a guide.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VC4SRB

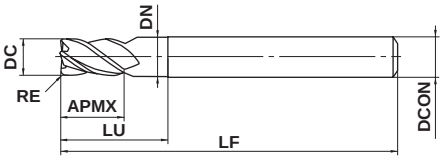
Corner radius end mill, Short cut length, 4 flute

UWC VC γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



Type1



Type2

4≤DC≤12				
0 - 0.020				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

h6

●4 flute corner radius end mill with relieved neck for 3×D length of reach.

(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VC4SRBD0400R0050	4	0.5	4	12	3.8	45	6	4	●	1
VC4SRBD0600R0050	6	0.5	6	18	5.8	50	6	4	●	2
VC4SRBD0600R0100	6	1	6	18	5.8	50	6	4	●	2
VC4SRBD0800R0050	8	0.5	8	24	7.8	60	8	4	●	2
VC4SRBD0800R0100	8	1	8	24	7.8	60	8	4	●	2
VC4SRBD1000R0100	10	1	10	30	9.7	70	10	4	●	2
VC4SRBD1000R0200	10	2	10	30	9.7	70	10	4	●	2
VC4SRBD1200R0100	12	1	12	36	11.7	75	12	4	●	2
VC4SRBD1200R0200	12	2	12	36	11.7	75	12	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

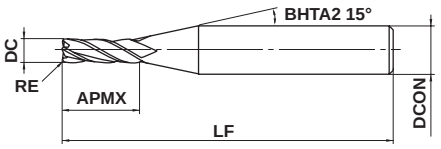
Work Material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45－55HRC) AISI H13		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
2	30000	4500	0.18	24000	3600	0.10
2.5	24000	3900	0.25	19000	3000	0.13
3	20000	3500	0.30	16000	2700	0.15
4	15000	3000	0.40	12000	2400	0.20
5	12000	2400	0.50	9000	1800	0.25
6	10000	2100	0.60	7000	1470	0.30
8	8000	1500	0.80	5600	1050	0.40
10	6400	1400	1.00	4500	950	0.50
12	5400	1200	1.00	3800	860	0.50
16	2400	550	2.00	1200	120	0.80
20	1900	480	3.00	1000	100	1.00
Depth of cut	≤Please refer to the list above for depth of cut. ≤DC DC ≤Please refer to the list above for depth of cut. DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50－70% and the feed rate to 40－60%.
Note 3) When drilling, please set the feed rate at 1/3 or below the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

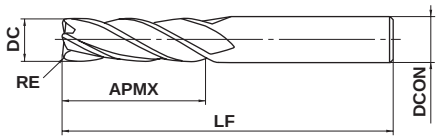
VC4JRB

Corner radius end mill, Semi long cut length, 4 flute

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	○		○	○		



Type1



Type2

DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	**8≤DCON≤10**	**12≤DCON≤16**	**DCON=20**	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

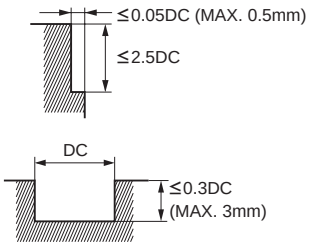
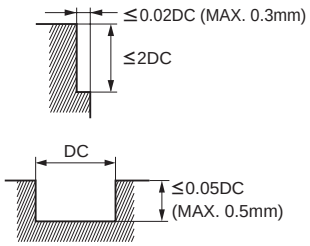
●4 flute corner radius end mill for general use.
●4 flute corner radius end mill for longer reach applications.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VC4JRBD0300R0030	3	0.3	12	50	6	4	●	1
VC4JRBD0400R0030	4	0.3	15	50	6	4	●	1
VC4JRBD0400R0050	4	0.5	15	50	6	4	●	1
VC4JRBD0500R0030	5	0.3	20	60	6	4	●	1
VC4JRBD0500R0050	5	0.5	20	60	6	4	●	1
VC4JRBD0600R0030	6	0.3	20	60	6	4	●	2
VC4JRBD0600R0050	6	0.5	20	60	6	4	●	2
VC4JRBD0600R0100	6	1	20	60	6	4	●	2
VC4JRBD0800R0030	8	0.3	25	70	8	4	●	2
VC4JRBD0800R0050	8	0.5	25	70	8	4	●	2
VC4JRBD0800R0100	8	1	25	70	8	4	●	2
VC4JRBD0800R0150	8	1.5	25	70	8	4	●	2
VC4JRBD0800R0200	8	2	25	70	8	4	●	2
VC4JRBD1000R0030	10	0.3	30	90	10	4	●	2
VC4JRBD1000R0050	10	0.5	30	90	10	4	●	2
VC4JRBD1000R0100	10	1	30	90	10	4	●	2
VC4JRBD1000R0150	10	1.5	30	90	10	4	●	2
VC4JRBD1000R0200	10	2	30	90	10	4	●	2
VC4JRBD1200R0050	12	0.5	30	90	12	4	●	2
VC4JRBD1200R0100	12	1	30	90	12	4	●	2
VC4JRBD1200R0150	12	1.5	30	90	12	4	●	2
VC4JRBD1200R0200	12	2	30	90	12	4	●	2
VC4JRBD1600R0050	16	0.5	50	110	16	4	●	2
VC4JRBD1600R0100	16	1	50	110	16	4	●	2
VC4JRBD1600R0150	16	1.5	50	110	16	4	●	2
VC4JRBD1600R0200	16	2	50	110	16	4	●	2
VC4JRBD2000R0050	20	0.5	55	110	20	4	●	2
VC4JRBD2000R0100	20	1	55	110	20	4	●	2
VC4JRBD2000R0150	20	1.5	55	110	20	4	●	2
VC4JRBD2000R0200	20	2	55	110	20	4	●	2

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	4200	110	3400	95	2600	70	2100	50
4	3400	140	2700	110	2100	85	1700	60
5	2900	170	2300	140	1800	100	1500	70
6	2500	200	2000	170	1500	130	1300	85
8	1900	220	1500	170	1200	150	1000	85
10	1600	220	1300	170	950	130	800	85
12	1300	170	1100	150	800	100	670	70
16	1000	140	820	110	600	80	500	50
20	800	110	650	85	480	70	400	40
25	650	85	520	70	380	50	320	35
Depth of cut								

DC:Dia.

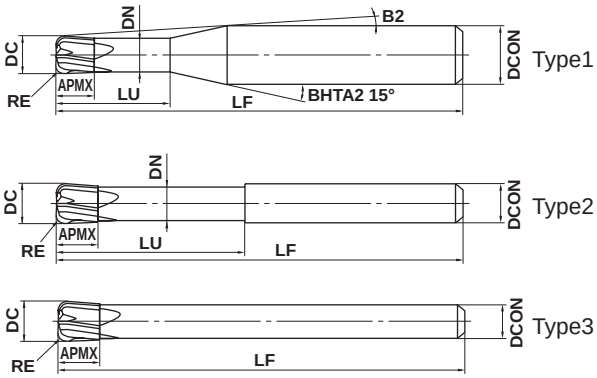
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The above table shows cutting conditions for standard side milling. For slotting, please reduce the feed rate only to 50% of the table figure. Please set the revolution rate at 60% and the feed rate at 40% when slotting austenitic stainless steels.
Note 4) When drilling, please set the feed rate at 1/3 or below the values above.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

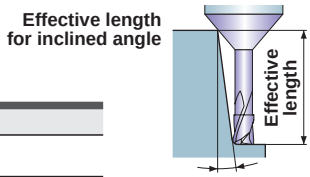
VCHFRB

Corner radius, Short flute length, 4 flute, High feed machining

UWC VC γ 20° γ 10°
DC≤5 DC≥6

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○				





0.5≤RE≤3			
±0.015			
DC≤12	DC>12		
0 - 0.02	0 - 0.03		
DCON=6	8≤DCON≤10	12≤DCON≤16	
0 - 0.008	0 - 0.009	0 - 0.011	

h6

●Suitable for high feed and efficient machining of die & mould.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
VCHFRBD0200R050N06	2	0.5	2	6	1.9	8.7°	50	6	4	▲	1	6.2	6.5	6.9	7.5
VCHFRBD0200R050N10	2	0.5	2	10	1.9	6.7°	70	6	4	▲	1	10.4	10.8	11.5	12.4
VCHFRBD0300R075N09	3	0.75	3	9	2.9	6.2°	50	6	4	▲	1	9.4	9.7	10.4	11.1
VCHFRBD0300R075N15	3	0.75	3	15	2.9	4.3°	70	6	4	▲	1	15.6	16.1	17.3	18.6
VCHFRBD0400R100N12	4	1	4	12	3.9	3.9°	50	6	4	▲	1	12.4	12.8	13.7	14.7
VCHFRBD0400R100N20	4	1	4	20	3.9	2.6°	70	6	4	▲	1	20.7	21.4	22.9	*
VCHFRBD0500R120N15	5	1.2	5	15	4.9	1.9°	70	6	4	▲	1	15.5	16.0	*	*
VCHFRBD0600R150N18	6	1.5	6	18	5.85	—	50	6	4	▲	2	*	*	*	*
VCHFRBD0600R150N30	6	1.5	6	30	5.85	—	90	6	4	▲	2	*	*	*	*
VCHFRBD0700R150A050	7	1.5	7	—	—	—	50	6	4	▲	3	*	*	*	*
VCHFRBD0700R150A080	7	1.5	7	—	—	—	80	6	4	▲	3	*	*	*	*
VCHFRBD0800R200N24	8	2	8	24	7.85	—	60	8	4	▲	2	*	*	*	*
VCHFRBD0800R200N40	8	2	8	40	7.85	—	90	8	4	▲	2	*	*	*	*
VCHFRBD0900R200A065	9	2	9	—	—	—	65	8	4	▲	3	*	*	*	*
VCHFRBD0900R200A100	9	2	9	—	—	—	100	8	4	▲	3	*	*	*	*
VCHFRBD1000R200N30	10	2	10	30	9.7	—	70	10	4	▲	2	*	*	*	*
VCHFRBD1000R200N50	10	2	10	50	9.7	—	100	10	4	▲	2	*	*	*	*
VCHFRBD1100R200A070	11	2	11	—	—	—	70	10	4	▲	3	*	*	*	*
VCHFRBD1100R200A110	11	2	11	—	—	—	110	10	4	▲	3	*	*	*	*
VCHFRBD1200R300N36	12	3	12	36	11.7	—	75	12	4	▲	2	*	*	*	*
VCHFRBD1200R300N60	12	3	12	60	11.7	—	110	12	4	▲	2	*	*	*	*
VCHFRBD1300R300A075	13	3	13	—	—	—	75	12	4	▲	3	*	*	*	*
VCHFRBD1300R300A120	13	3	13	—	—	—	120	12	4	▲	3	*	*	*	*
VCHFRBD1600R300N80	16	3	16	80	15.5	—	140	16	4	▲	2	*	*	*	*

* No interference

▲ : Product scheduled to be discontinued at the end of March 2020
VFHVRB(J306) is alternative product.

VCHFRB

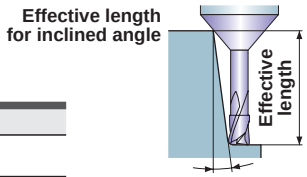
Corner radius, Short flute length, 4 flute, High feed machining

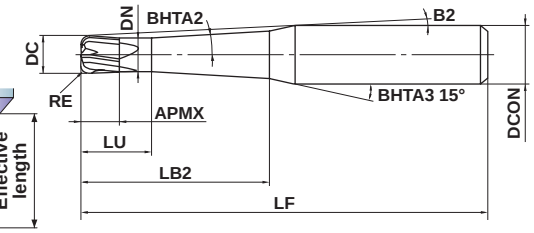
UWC VC γ 20° γ 10°

DC≤5 DC≥6

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎	○				

Taper neck type





Type4

0.5≤RE≤3			
±0.015			
DC≤12	DC>12		
0 - 0.02	0 - 0.03		
DCON=6	8≤DCON≤10	12≤DCON≤16	
0 - 0.008	0 - 0.009	0 - 0.011	

h6

●Suitable for high feed and efficient machining of die & mould.

(mm)

Order Number	DC	RE	BHTA2	APMX	LB2	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 1°	2°	3°
VCHFRBD0200R050N12	2	0.5	1°	2	12	4	1.9	6°	70	6	4	▲	4	12.9	13.9	15
VCHFRBD0200R050N16	2	0.5	1°	2	16	4	1.9	5°	70	6	4	▲	4	16.9	18.2	19.6
VCHFRBD0200R050N20	2	0.5	1°	2	20	4	1.9	4.3°	70	6	4	▲	4	20.9	22.5	24.3
VCHFRBD0300R075N18	3	0.75	1°	3	18	6	2.9	3.8°	80	6	4	▲	4	19.3	20.7	22.3
VCHFRBD0300R075N24	3	0.75	1°	3	24	6	2.9	3°	80	6	4	▲	4	25.3	27.2	*
VCHFRBD0300R075N30	3	0.75	1°	3	30	6	2.9	2.6°	80	6	4	▲	4	31.3	33.6	*
VCHFRBD0400R100N24	4	1	1°	4	24	8	3.9	2.2°	90	6	4	▲	4	25.7	27.6	*
VCHFRBD0400R100N32	4	1	1°	4	32	8	3.9	1.7°	90	6	4	▲	4	33.7	*	*
VCHFRBD0400R100N40	4	1	1°	4	40	8	3.9	1.4°	90	6	4	▲	4	41.7	*	*
VCHFRBD0500R120N30	5	1.2	1°	5	30	8	4.9	1°	90	6	4	▲	4	*	*	*
VCHFRBD0500R120N40	5	1.2	1°	5	40	8	4.9	2°	90	8	4	▲	4	41.9	*	*
VCHFRBD0500R120N50	5	1.2	1°	5	50	8	4.9	1.7°	110	8	4	▲	4	51.9	*	*
VCHFRBD0600R150N50	6	1.5	1°	6	50	16	5.85	1.2°	110	8	4	▲	4	52.9	*	*
VCHFRBD0600R150N67	6	1.5	1°	6	67	16	5.85	0.9°	130	8	4	▲	4	*	*	*
VCHFRBD0800R200N70	8	2	1°	8	70	18	7.85	0.9°	120	10	4	▲	4	*	*	*
VCHFRBD0800R200N90	8	2	1°	8	90	18	7.85	1.3°	150	12	4	▲	4	93.5	*	*
VCHFRBD1000R200N80	10	2	1°	10	80	20	9.7	2°	140	16	4	▲	4	83.9	*	*
VCHFRBD1000R200N110	10	2	1°	10	110	20	9.7	1.5°	160	16	4	▲	4	113.9	*	*
VCHFRBD1200R300N110	12	3	1°	12	110	24	11.7	1.1°	160	16	4	▲	4	115.2	*	*

* No interference

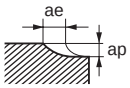
▲ : **Product scheduled to be discontinued at the end of March 2020**

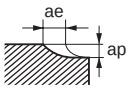
VFHVRB(J312) is alternative product.

VCHFRB

Corner radius, Short flute length, 4 flute, High feed machining

RECOMMENDED CUTTING CONDITIONS

Work Material		Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20				Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21			
Dia. **DC** (mm)	Corner radius **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	R 0.5	33000	10000	0.08	0.8	27000	8400	0.05	0.8
3	R 0.75	22000	11000	0.12	1.2	18000	9000	0.08	1.2
4	R 1	17000	12000	0.15	1.5	14000	9500	0.12	1.5
5	R 1.2	13000	13000	0.20	2.0	11000	11000	0.15	2.0
6	R 1.5	11000	13000	0.25	2.5	9000	11000	0.15	2.5
7	R 1.5	9400	13000	0.25	3.0	7800	11000	0.15	3.0
8	R 2	8200	13000	0.30	3.0	7000	11000	0.20	3.0
9	R 2	7300	13000	0.30	4.0	6000	11000	0.20	4.0
10	R 2	6500	13000	0.30	4.5	5500	11000	0.20	4.5
11	R 2	6000	12000	0.30	5.5	5000	10000	0.20	5.5
12	R 3	5500	12000	0.45	4.5	4600	10000	0.30	4.5
13	R 3	5000	12000	0.45	5.5	4200	10000	0.30	5.5
16	R 3	4100	10000	0.45	7.5	3400	8800	0.30	7.5
Depth of cut									

Work Material		Hardened steel (45−55HRC) AISI H13				Hardened steel (55−62HRC) AISI D2			
Dia. **DC** (mm)	Corner radius **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
2	R 0.5	24000	7500	0.04	0.8	16000	3000	0.03	0.8
3	R 0.75	16000	8500	0.06	1.2	11000	3300	0.05	1.2
4	R 1	12000	8800	0.08	1.5	8000	3500	0.07	1.5
5	R 1.2	9600	9500	0.10	2.0	6400	3800	0.08	2.0
6	R 1.5	8000	9600	0.10	2.5	5300	3800	0.10	2.5
7	R 1.5	6900	9600	0.10	3.0	4600	3800	0.10	3.0
8	R 2	6000	9600	0.15	3.0	4000	3800	0.13	3.0
9	R 2	5300	9500	0.15	4.0	3800	3800	0.13	4.0
10	R 2	4800	9500	0.15	4.5	3200	3800	0.13	4.5
11	R 2	4500	9000	0.15	5.5	2900	3500	0.13	5.5
12	R 3	4100	9000	0.25	4.5	2700	3500	0.20	4.5
13	R 3	3700	8900	0.25	5.5	2500	3500	0.20	5.5
16	R 3	3000	7800	0.25	7.5	2000	3200	0.20	7.5
Depth of cut									

■Coefficients respective of tool overhang

Type	Overhang	Revolution	Feed rate	Depth of cut ap
Straight	L/D≤5	100%	100%	100%
	L/D=6	90%	80%	80%
	L/D=7	80%	70%	70%
Taper neck	L/D=6	100%	100%	100%
	L/D=8	90%	80%	80%
	L/D≥10	80%	70%	70%

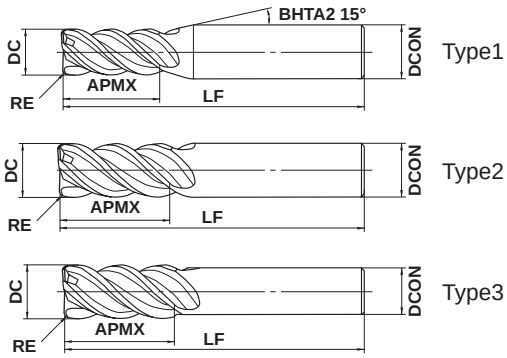
Note 1) The above table shows cutting conditions when machining with the corner radius cutting edge.
Note 2) This table shows the cutting conditions with less than 5D overhang length.
In the case of longer overhangs, the revolution and the feed rate should be reduced proportionately.
Note 3) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 4) Air blow or oil mist is recommended for good chip evacuation.
Note 5) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 6) When machining inclinations in the Z direction, set the inclination angle at 2° and reduce the feed rate by 50%.
Note 7) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VCMHDRB

Corner radius end mill, Medium cut length, 4 flute, High helix angle

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	◎	◎		○	○		



0.2≤RE≤6.35				
±0.020				
DC≤12	DC>12			
0 - 0.02	0 - 0.03			
4≤DCON≤6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

h6

●4 flute corner radius end mill with high helix angle and newly designed corner radius, for milling carbon steels to stainless steels materials.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VCMHDRBD0200R020S04	2	0.2	6	40	4	4	▲	1
VCMHDRBD0200R030S04	2	0.3	6	40	4	4	▲	1
VCMHDRBD0300R020S06	3	0.2	8	50	6	4	▲	1
VCMHDRBD0300R030S06	3	0.3	8	50	6	4	▲	1
VCMHDRBD0300R050S06	3	0.5	8	50	6	4	▲	1
VCMHDRBD0400R020S06	4	0.2	11	50	6	4	▲	1
VCMHDRBD0400R030S06	4	0.3	11	50	6	4	▲	1
VCMHDRBD0400R050S06	4	0.5	11	50	6	4	▲	1
VCMHDRBD0500R020S06	5	0.2	13	60	6	4	▲	1
VCMHDRBD0500R030S06	5	0.3	13	60	6	4	▲	1
VCMHDRBD0500R050S06	5	0.5	13	60	6	4	▲	1
VCMHDRBD0500R100S06	5	1	13	60	6	4	▲	1
VCMHDRBD0600R030S06	6	0.3	13	60	6	4	▲	2
VCMHDRBD0600R050S06	6	0.5	13	60	6	4	▲	2
VCMHDRBD0600R100S06	6	1	13	60	6	4	▲	2
VCMHDRBD0800R030S08	8	0.3	19	70	8	4	▲	2
VCMHDRBD0800R050S08	8	0.5	19	70	8	4	▲	2
VCMHDRBD0800R100S08	8	1	19	70	8	4	▲	2
VCMHDRBD0800R150S08	8	1.5	19	70	8	4	▲	2
VCMHDRBD1000R030S08	10	0.3	22	90	8	4	▲	3
VCMHDRBD1000R050S08	10	0.5	22	90	8	4	▲	3
VCMHDRBD1000R100S08	10	1	22	90	8	4	▲	3
VCMHDRBD1000R150S08	10	1.5	22	90	8	4	▲	3
VCMHDRBD1000R200S08	10	2	22	90	8	4	▲	3
VCMHDRBD1000R030S10	10	0.3	22	90	10	4	▲	2
VCMHDRBD1000R050S10	10	0.5	22	90	10	4	▲	2
VCMHDRBD1000R100S10	10	1	22	90	10	4	▲	2
VCMHDRBD1000R150S10	10	1.5	22	90	10	4	▲	2
VCMHDRBD1000R200S10	10	2	22	90	10	4	▲	2
VCMHDRBD1200R050S10	12	0.5	26	90	10	4	▲	3
VCMHDRBD1200R100S10	12	1	26	90	10	4	▲	3
VCMHDRBD1200R150S10	12	1.5	26	90	10	4	▲	3
VCMHDRBD1200R200S10	12	2	26	90	10	4	▲	3
VCMHDRBD1200R300S10	12	3	26	90	10	4	▲	3

▲ : Product scheduled to be discontinued at the end of March 2020
MPMHVRB(J284) is alternative product.

(mm)

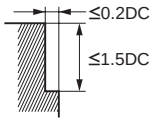
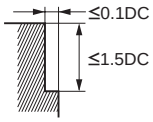
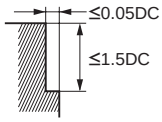
Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VCMHDRBD1200R050S12	12	0.5	26	90	12	4	▲	2
VCMHDRBD1200R100S12	12	1	26	90	12	4	▲	2
VCMHDRBD1200R150S12	12	1.5	26	90	12	4	▲	2
VCMHDRBD1200R200S12	12	2	26	90	12	4	▲	2
VCMHDRBD1200R300S12	12	3	26	90	12	4	▲	2
VCMHDRBD1600R100S16	16	1	32	110	16	4	▲	2
VCMHDRBD1600R150S16	16	1.5	32	110	16	4	▲	2
VCMHDRBD1600R200S16	16	2	32	110	16	4	▲	2
VCMHDRBD1600R300S16	16	3	32	110	16	4	▲	2
VCMHDRBD1800R100S16	18	1	32	110	16	4	▲	3
VCMHDRBD1800R150S16	18	1.5	32	110	16	4	▲	3
VCMHDRBD1800R200S16	18	2	32	110	16	4	▲	3
VCMHDRBD1800R300S16	18	3	32	110	16	4	▲	3
VCMHDRBD2000R100S20	20	1	38	110	20	4	▲	2
VCMHDRBD2000R150S20	20	1.5	38	110	20	4	▲	2
VCMHDRBD2000R200S20	20	2	38	110	20	4	▲	2
VCMHDRBD2000R300S20	20	3	38	110	20	4	▲	2
VCMHDRBD2200R100S20	22	1	38	140	20	4	▲	3
VCMHDRBD2200R150S20	22	1.5	38	140	20	4	▲	3
VCMHDRBD2200R200S20	22	2	38	140	20	4	▲	3
VCMHDRBD2200R300S20	22	3	38	140	20	4	▲	3
VCMHDRBD2500R100S25	25	1	45	140	25	4	▲	2
VCMHDRBD2500R150S25	25	1.5	45	140	25	4	▲	2
VCMHDRBD2500R200S25	25	2	45	140	25	4	▲	2
VCMHDRBD2500R300S25	25	3	45	140	25	4	▲	2

VCMHDRB

Corner radius end mill, Medium cut length, 4 flute, High helix angle

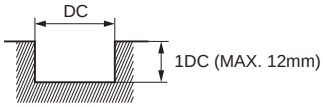
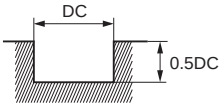
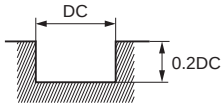
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	15000	550	10000	340	10000	320	6400	160	4800	100
3	11000	800	7400	500	7400	480	4800	250	4000	170
4	8000	900	5600	540	5600	520	3600	270	3200	240
5	6400	1000	4500	600	4500	580	2900	300	2600	240
6	5900	1100	3700	640	3700	600	2400	320	2100	230
8	4400	1100	2800	660	2800	600	1800	330	1600	220
10	3500	1000	2300	640	2300	560	1400	320	1300	200
12	2900	1000	1900	640	1900	530	1200	320	1100	170
16	2200	800	1400	500	1400	450	900	250	800	130
20	1800	750	1100	460	1100	440	720	230	640	100
25	1400	600	900	400	900	380	570	200	510	80
Depth of cut										

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	12000	400	7000	200	7000	100	4200	80	2300	40
3	9000	600	5300	300	5300	150	3200	130	1900	70
4	7200	720	4000	360	4000	180	2400	140	1400	95
5	5800	720	3200	360	3200	180	1900	150	1100	95
6	5000	800	2700	400	2700	200	1600	160	950	95
8	3700	800	2000	400	2000	200	1200	170	720	90
10	3000	720	1600	360	1600	180	960	160	570	80
12	2500	720	1300	360	1300	180	800	160	480	70
16	2000	600	1000	280	1000	150	600	130	360	50
20	1600	540	800	250	800	130	480	120	290	40
25	1300	480	640	220	640	120	380	100	230	35
Depth of cut										

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

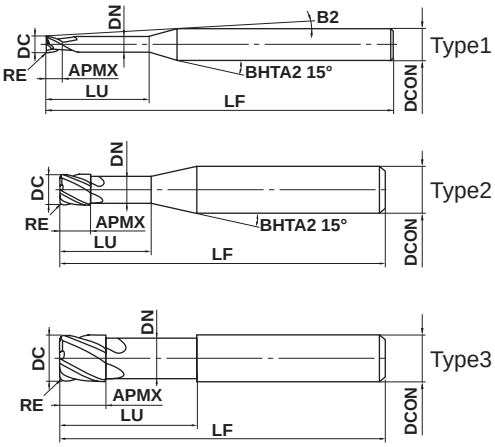
DFPSRB

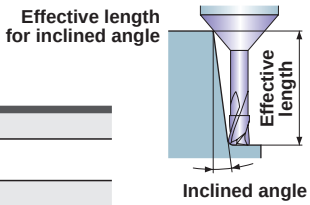
Corner radius end mill, Short cut length, 2−4 flute, High precision, For graphite

TOOL NEWS

UWC DF γ 30° DC≤1.5 DC≥2

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	◎	○	○





0.1≤RE≤1				
±0.01				
0.5≤DC≤12				
0 - 0.02				
4≤DCON≤6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

●±0.01mm corner radius tolerance, 0−-0.02mm outer diameter tolerance.
Corner radius end mill with original diamond coating for precise and efficient graphite machining.

(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle 0.5°	1°	2°	3°
DFPSRBD0050R010N04	0.5	0.1	0.75	4	0.46	9.5°	60	4	2	●	1	4.1	4.3	4.6	5.0
DFPSRBD0050R010N05	0.5	0.1	0.75	5	0.46	8.7°	60	4	2	●	1	5.2	5.4	5.7	6.2
DFPSRBD0050R010N06	0.5	0.1	0.75	6	0.46	8.0°	60	4	2	●	1	6.2	6.4	6.9	7.5
DFPSRBD0050R010N10	0.5	0.1	0.75	10	0.46	6.1°	60	4	2	●	1	10.3	10.7	11.5	12.4
DFPSRBD0050R010N15	0.5	0.1	0.75	15	0.46	4.7°	60	4	2	●	1	15.5	16.0	17.2	18.6
DFPSRBD0080R010N06	0.8	0.1	1	6	0.76	7.7°	60	4	2	●	1	6.2	6.4	6.9	7.5
DFPSRBD0080R010N08	0.8	0.1	1	8	0.76	6.6°	60	4	2	●	1	8.3	8.6	9.2	9.9
DFPSRBD0100R010N08	1	0.1	1.5	8	0.94	6.3°	60	4	2	●	1	8.5	8.8	9.5	10.2
DFPSRBD0100R010N12	1	0.1	1.5	12	0.94	4.9°	60	4	2	●	1	12.6	13.1	14.1	15.2
DFPSRBD0100R020N08	1	0.2	1.5	8	0.94	6.3°	60	4	2	●	1	8.5	8.8	9.5	10.2
DFPSRBD0100R020N12	1	0.2	1.5	12	0.94	4.9°	60	4	2	●	1	12.6	13.1	14.1	15.2
DFPSRBD0100R020N16	1	0.2	1.5	16	0.94	4.0°	70	4	2	●	1	16.8	17.4	18.7	20.2
DFPSRBD0100R020N20	1	0.2	1.5	20	0.94	3.4°	70	4	2	●	1	20.9	21.7	23.3	25.1
DFPSRBD0100R020N30	1	0.2	1.5	30	0.94	2.5°	70	4	2	●	1	31.3	32.4	34.8	*
DFPSRBD0150R020N10	1.5	0.2	2.3	10	1.44	4.9°	70	4	2	●	1	10.5	11.0	11.8	12.7
DFPSRBD0150R020N20	1.5	0.2	2.3	20	1.44	2.9°	70	4	2	●	1	20.9	21.7	23.3	*
DFPSRBD0200R010N08	2	0.1	3	8	1.9	4.9°	70	4	4	●	2	8.4	8.7	9.4	10.1
DFPSRBD0200R020N12	2	0.2	3	12	1.9	3.7°	70	4	4	●	2	12.5	13.0	14.0	15.1
DFPSRBD0200R020N16	2	0.2	3	16	1.9	2.9°	70	4	4	●	2	16.7	17.3	18.6	*
DFPSRBD0200R020N20	2	0.2	3	20	1.9	2.5°	80	4	4	●	2	20.8	21.5	23.2	*
DFPSRBD0200R020N30	2	0.2	3	30	1.9	1.7°	80	4	4	●	2	31.2	32.2	*	*
DFPSRBD0200R020N40	2	0.2	3	40	1.9	1.4°	80	4	4	●	2	41.5	42.9	*	*
DFPSRBD0200R030N08	2	0.3	3	8	1.9	5.0°	70	4	4	●	2	8.4	8.7	9.3	10.1
DFPSRBD0300R020N20	3	0.2	4.5	20	2.9	1.4°	80	4	4	●	2	20.8	21.5	*	*
DFPSRBD0300R020N40	3	0.2	4.5	40	2.9	0.7°	80	4	4	●	2	41.5	*	*	*
DFPSRBD0300R030N12	3	0.3	4.5	12	2.9	2.1°	80	4	4	●	2	12.5	13.0	13.9	*
DFPSRBD0300R050N20	3	0.5	4.5	20	2.9	1.4°	80	4	4	●	2	20.8	21.5	*	*
DFPSRBD0400R020N20	4	0.2	6	20	3.9	—	80	4	4	●	3	*	*	*	*
DFPSRBD0400R020N40	4	0.2	6	40	3.9	—	80	4	4	●	3	*	*	*	*
DFPSRBD0400R050N20	4	0.5	6	20	3.9	—	80	4	4	●	3	*	*	*	*
DFPSRBD0400R050N40	4	0.5	6	40	3.9	—	80	4	4	●	3	*	*	*	*
DFPSRBD0600R010N24	6	0.1	9	24	5.85	—	90	6	4	●	3	*	*	*	*
DFPSRBD0600R030N24	6	0.3	9	24	5.85	—	90	6	4	●	3	*	*	*	*

* No interference

DFPSRB

Corner radius end mill, Short cut length, 2—4 flute, High precision, For graphite

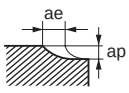
(mm)

Order Number	DC	RE	APMX	LU	DN	B2	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
												0.5°	1°	2°	3°
DFPSRBD0600R050N24	6	0.5	9	24	5.85	—	90	6	4	●	3	*	*	*	*
DFPSRBD0600R050N30	6	0.5	9	30	5.85	—	90	6	4	●	3	*	*	*	*
DFPSRBD0600R100N30	6	1	9	30	5.85	—	90	6	4	●	3	*	*	*	*
DFPSRBD0800R050N30	8	0.5	12	30	7.85	—	90	8	4	●	3	*	*	*	*
DFPSRBD0800R100N30	8	1	12	30	7.85	—	90	8	4	●	3	*	*	*	*
DFPSRBD1000R050N40	10	0.5	15	40	9.7	—	130	10	4	●	3	*	*	*	*
DFPSRBD1000R100N40	10	1	15	40	9.7	—	130	10	4	●	3	*	*	*	*
DFPSRBD1200R050N40	12	0.5	18	40	11.7	—	130	12	4	●	3	*	*	*	*

* No interference

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material			Graphite				Copper, Copper alloys			
Dia. **DC** (mm)	Corner radius **RE** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.5	0.1	4	30000	1100	0.05	0.23	24000	700	0.04	0.23
	0.1	5	28000	960	0.05	0.23	22000	600	0.04	0.23
	0.1	6	25000	850	0.05	0.23	20000	540	0.04	0.23
	0.1	10	22000	600	0.04	0.21	—	—	—	—
	0.1	15	20000	500	0.03	0.18	—	—	—	—
0.8	0.1	6	28000	1300	0.08	0.45	22000	830	0.06	0.45
	0.1	8	22000	900	0.08	0.45	18000	580	0.06	0.45
1	0.1	8	25000	1500	0.1	0.6	20000	960	0.08	0.6
	0.1	12	22000	1300	0.1	0.6	18000	830	0.08	0.6
	0.2	8	25000	1500	0.1	0.45	20000	960	0.08	0.45
	0.2	12	22000	1300	0.1	0.45	18000	830	0.08	0.45
	0.2	16	18000	1000	0.08	0.4	14000	640	0.06	0.4
	0.2	20	15000	800	0.08	0.4	—	—	—	—
	0.2	30	12000	600	0.07	0.35	—	—	—	—
1.5	0.2	10	18000	1400	0.15	0.8	14000	900	0.12	0.8
	0.2	20	12000	900	0.12	0.65	9600	580	0.1	0.65
2	0.1	8	24000	3300	0.2	1.2	19000	2100	0.16	1.2
	0.2	12	22000	3000	0.2	1.2	18000	1900	0.16	1.2
	0.2	16	19000	2500	0.2	1.2	15000	1600	0.16	1.2
	0.2	20	16000	2000	0.2	1.2	13000	1300	0.16	1.2
	0.2	30	13000	1600	0.16	1.0	—	—	—	—
	0.2	40	11000	1200	0.14	0.8	—	—	—	—
	0.3	8	24000	3300	0.3	1.2	19000	2100	0.24	1.2
3	0.2	20	18000	3000	0.3	2.0	14000	1900	0.24	2.0
	0.2	40	12000	1800	0.25	1.7	9600	1100	0.2	1.7
	0.5	20	18000	3000	0.3	1.5	14000	1900	0.24	1.5
	0.3	12	20000	4500	0.3	1.5	16000	2900	0.24	1.5
4	0.2	20	18000	4200	0.4	2.7	14000	2700	0.3	2.7
	0.2	40	13000	2800	0.4	2.7	10000	1800	0.3	2.7
	0.5	20	18000	4200	0.4	2.3	14000	2700	0.3	2.3
	0.5	40	13000	2800	0.4	2.3	10000	1800	0.3	2.3
6	0.1	24	14000	4600	0.6	3.8	11000	2900	0.5	3.8
	0.3	24	14000	4600	0.6	3.8	11000	2900	0.5	3.8
	0.5	24	14000	4600	0.6	3.8	11000	2900	0.5	3.8
	0.5	30	14000	4600	0.6	3.8	11000	2900	0.5	3.8
	1	30	14000	4600	0.6	3.0	11000	2900	0.5	3.0
8	0.5	30	10500	4000	0.8	5.3	8400	2600	0.6	5.3
	1	30	10500	4000	0.8	4.5	8400	2600	0.6	4.5
10	0.5	40	8700	3500	1.0	6.8	7000	2200	0.8	6.8
	1	40	8700	3500	1.0	6.0	7000	2200	0.8	6.0
12	0.5	40	7200	3000	1.2	8.0	5800	1900	1.0	8.0
Depth of cut										

Note 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
Note 2) Use a milling machine dedicated for graphite.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

CE4SRB/CE6SRB

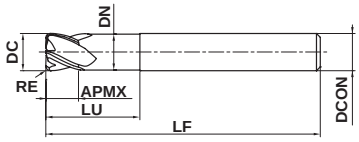
Corner radius end mill, short cut length, 4-6 flute

TOOL NEWS

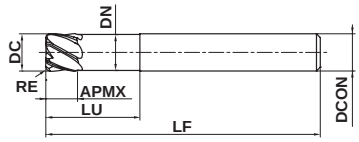
CERAMIC

30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
					◎		



Type1



Type2

DC≤12				
±0.02				
DC=6	DC=8,10	DC=12		
- 0.008 - 0.028	- 0.009 - 0.029	- 0.011 - 0.031		
DC=6	DC=8,10	DC=12		
0 - 0.008	0 - 0.009	0 - 0.011		

- Ceramic corner radius end mill with high heat resistance.
- Capable of softening Ni based alloys by generating heat during machining

(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
CE4SRBD0600R050	6	0.5	4.5	12	5.85	50	6	4	●	1
CE4SRBD0800R100	8	1.0	6.0	16	7.85	60	8	4	●	1
CE4SRBD1000R100	10	1.0	7.5	20	9.70	65	10	4	●	1
CE4SRBD1200R150	12	1.5	9.0	24	11.70	70	12	4	●	1
CE6SRBD0600R050	6	0.5	4.5	12	5.85	50	6	6	●	2
CE6SRBD0800R100	8	1.0	6.0	16	7.85	60	8	6	●	2
CE6SRBD1000R100	10	1.0	7.5	20	9.70	65	10	6	●	2
CE6SRBD1200R150	12	1.5	9.0	24	11.70	70	12	6	●	2

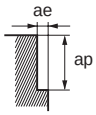
Note 1) Never use ceramic end mills to cut titanium alloys.
Doing so will cause a risk of ignition and can be extremely dangerous.

● : Inventory maintained in Japan.

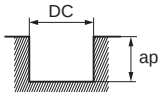
RECOMMENDED CUTTING CONDITIONS

CE4SRB

■ Side milling

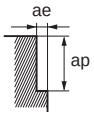
Work Material	Heat resistant alloys Inconel718			
Dia. **DC** (mm)	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Depth of cut ap (mm)	Cutting Width ae (mm)
6	≥350	≤0.06	≤4.5	≤1.2
8	≥350	≤0.06	≤6.0	≤1.6
10	≥350	≤0.06	≤7.5	≤2.0
12	≥350	≤0.06	≤9.0	≤2.4
Depth of cut	 DC:Dia.			

■ Slotting

Work Material	Heat resistant alloys Inconel718		
Dia. **DC** (mm)	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Depth of cut ap (mm)
6	≥350	≤0.03	≤1.0
8	≥350	≤0.03	≤1.5
10	≥350	≤0.03	≤2.0
12	≥350	≤0.03	≤2.5
Depth of cut	 DC:Dia.		

CE6SRB

■ Side milling

Work Material	Heat resistant alloys Inconel718			
Dia. **DC** (mm)	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Depth of cut ap (mm)	Cutting Width ae (mm)
6	≥350	≤0.06	≤4.5	≤1.2
8	≥350	≤0.06	≤6.0	≤1.6
10	≥350	≤0.06	≤7.5	≤2.0
12	≥350	≤0.06	≤9.0	≤2.4
Depth of cut	 DC:Dia.			

Note 1) The outermost layer of the material may be affected by heat.
Ensure a minimum of 0.3mm final machining allowance remains.
Note 2) The recommended ramping angle is 1.5 degree. By Shoulder milling=25% and Slot milling=50% from the cutting conditions shown.
Note 3) Gradually increase the depth of cut (Shoulder milling=ae and Slot milling=ap) starting from 0.05DC.

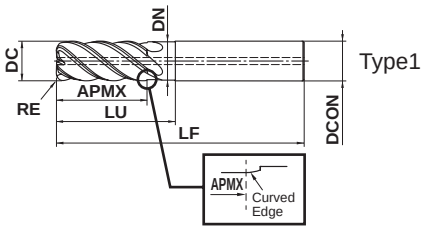
VQT5MVRB NEW

Corner radius, Medium cut length, 5 flute, Irregular helix flutes, With coolant hole

TOOL NEWS

UWC VQ γ 40° 41.5° 43°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
				◎	◎		



RE				
±0.02				
DC≤16	20≤DC≤25			
0 / - 0.03	0 / - 0.04			
DCON=16	20≤DCON≤25			
0 / - 0.011	0 / - 0.013			

- Flute geometry suitable for slot milling.
- The sharp corner R edges provide long tool life in machining of titanium alloys.

(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VQT5MVRB160R300N048C	16	3	34	48	15.5	100	16	5	●	1
VQT5MVRB200R400N060C	20	4	44	60	19.5	120	20	5	●	1
VQT5MVRB250R400N075C	25	4	54	75	24.5	140	25	5	●	1

Note 1) SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work.
When measuring the tool length, please use an internal contact type (non-electricity type) or a laser tool setter.
Note 2) Non-standard corner R sizes are available by special orders. Contact us for details.

Special Corner R Size Range

(mm)

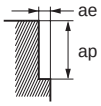
DC	RE
16	1–5
20, 25	1–6

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

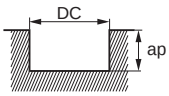
■Shoulder Milling

Overhang Length DC×3 (DC=Dia.)

Work Material	Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Width of cut ae (mm)
16	70	1400	700	32	2.4
20	70	1100	550	40	3
25	70	890	440	50	3.8
Depth of Cut					

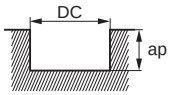
■Slot Milling

Depth of Cut DC×1

Work Material	Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
16	60	1200	420	16
20	60	950	330	20
25	50	640	220	25
Depth of Cut				

DC:Dia.

Depth of Cut DC×2

Work Material	Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
16	60	1200	240	32
20	60	950	190	40
25	50	640	130	50
Depth of Cut				

DC:Dia.

Note 1) SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work.
When measuring the tool length, please use an internal contact type (non-electricity type) or a laser tool setter.
Note 2) When cutting titanium alloys, the use of water-soluble cutting fluid is effective.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the work material installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.
Note 4) If the depth of cut is smaller, the revolution and the feed rate can be increased.
Note 5) For slot milling, use a chuck with high clamping force.

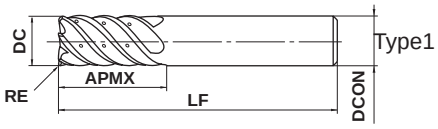
VQ6MHVRBCH NEW

Corner radius end mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple internal through coolant

UWC VQ 43.5° 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎	○	

CoolStar
END MILLS



0.5≤RE≤4				
±0.015				
DC≤12	DC>12			
0 / - 0.020	0 / - 0.030			
DCON=10	DCON=12	DCON=16	DCON=20	
0 / - 0.009	0 / - 0.011	0 / - 0.011	0 / - 0.013	

h6

● Vibration control corner radius end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

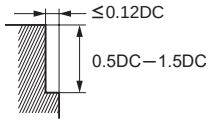
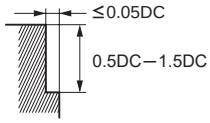
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VQ6MHVRBCHD1000R050	10	0.5	22	70	10	6	●	1
VQ6MHVRBCHD1000R100	10	1	22	70	10	6	●	1
VQ6MHVRBCHD1200R050	12	0.5	26	75	12	6	●	1
VQ6MHVRBCHD1200R100	12	1	26	75	12	6	●	1
VQ6MHVRBCHD1600R100	16	1	32	90	16	6	●	1
VQ6MHVRBCHD1600R300	16	3	32	90	16	6	●	1
VQ6MHVRBCHD1600R400	16	4	32	90	16	6	●	1
VQ6MHVRBCHD2000R100	20	1	38	100	20	6	●	1
VQ6MHVRBCHD2000R300	20	3	38	100	20	6	●	1
VQ6MHVRBCHD2000R400	20	4	38	100	20	6	●	1

● : Inventory maintained in Japan.

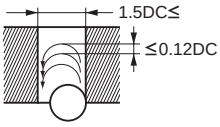
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic Stainless Steel (≤200HB), Titanium Alloy AISI 304, AISI 316, Ti-6Al-4V		Copper, Copper alloy		Heat Resistant Alloys Inconel 718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	—	—	4800	2000	—	—	1300	260
12	—	—	4000	2000	—	—	1100	230
16	4000	2200	3000	1600	2400	1400	800	180
20	3200	1900	2400	1400	1900	1100	640	150
Depth of Cut								

DC:Dia.

■Trochoidal slotting

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel (≤200HB), Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	—	—	4800	1400
12	—	—	4000	1200
16	4000	1600	3000	1100
20	3200	1400	2400	900
Depth of cut				

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

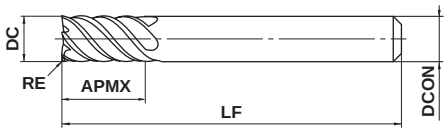
VF6MHVRB

Corner radius, Medium cut length, 6 flute, Irregular helix flutes

TOOL NEWS

43.5°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		



Type1

0.5≤RE≤2				
±0.015				
DC≤12	DC>12			
0 - 0.020	0 - 0.030			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

- Irregular helix 6 flute geometry reduces vibrations and achieves high efficiency machining.
- Suitable for machining of difficult-to-cut materials such as stainless steel, titanium alloy and inconel.

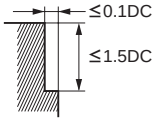
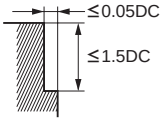
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VF6MHVRBD0600R050	6	0.5	13	50	6	6	●	1
VF6MHVRBD0600R100	6	1	13	50	6	6	●	1
VF6MHVRBD0800R050	8	0.5	19	60	8	6	●	1
VF6MHVRBD0800R100	8	1	19	60	8	6	●	1
VF6MHVRBD1000R050	10	0.5	22	70	10	6	●	1
VF6MHVRBD1000R100	10	1	22	70	10	6	●	1
VF6MHVRBD1200R050	12	0.5	26	75	12	6	●	1
VF6MHVRBD1200R100	12	1	26	75	12	6	●	1
VF6MHVRBD1600R100	16	1	32	90	16	6	●	1
VF6MHVRBD1600R200	16	2	32	90	16	6	●	1
VF6MHVRBD2000R100	20	1	38	100	20	6	●	1
VF6MHVRBD2000R200	20	2	38	100	20	6	●	1

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
6	10600	2900	8000	2000	2100	320
8	8000	2900	6000	2000	1600	300
10	6400	2700	4800	2000	1300	260
12	5300	2700	4000	2000	1100	230
16	4000	2200	3000	1600	800	180
20	3200	1900	2400	1400	640	150
Depth of cut						

DC:Dia.

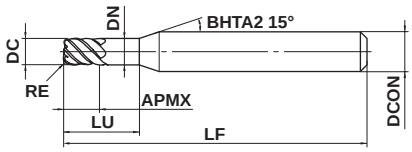
Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

VFSDRB

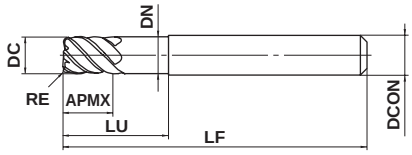
IMPACT MIRACLE Corner radius end mill, 6 flute (S)

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



Type1



Type2

3≤DC≤12				
0 - 0.02				
DCON=6	8≤DCON≤10	DCON=12		
0 - 0.008	0 - 0.009	0 - 0.011		

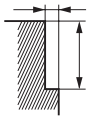
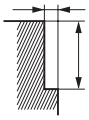
●6 flute end mill with Impact Miracle coating for high hardened materials.

(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
VFSDRBD0300R030	3	0.3	3	9	2.9	45	6	6	●	1
VFSDRBD0400R030	4	0.3	4	12	3.9	45	6	6	●	1
VFSDRBD0500R030	5	0.3	5	15	4.9	50	6	6	●	1
VFSDRBD0600R030	6	0.3	6	18	5.85	50	6	6	●	2
VFSDRBD0600R050	6	0.5	6	18	5.85	50	6	6	●	2
VFSDRBD0600R100	6	1	6	18	5.85	50	6	6	●	2
VFSDRBD0800R030	8	0.3	8	24	7.85	60	8	6	●	2
VFSDRBD0800R050	8	0.5	8	24	7.85	60	8	6	●	2
VFSDRBD0800R100	8	1	8	24	7.85	60	8	6	●	2
VFSDRBD1000R050	10	0.5	10	30	9.7	70	10	6	●	2
VFSDRBD1000R100	10	1	10	30	9.7	70	10	6	●	2
VFSDRBD1200R050	12	0.5	12	36	11.7	75	12	6	●	2
VFSDRBD1200R100	12	1	12	36	11.7	75	12	6	●	2

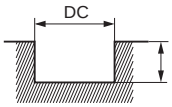
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2			Hardened steel (62−70HRC) AISI W1, AISI M2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	1200	0.05	40000	800	0.03	32000	500	0.02
2	40000	2000	0.1	24000	1000	0.05	16000	600	0.05
3	32000	3800	0.2	16000	1900	0.1	11000	1200	0.05
4	24000	4400	0.2	12000	2200	0.1	8000	1300	0.05
6	16000	5800	0.3	8000	2900	0.2	5300	1800	0.1
8	12000	5800	0.4	6000	2900	0.2	4000	1800	0.1
10	9600	5800	0.5	4800	2900	0.3	3200	1800	0.2
12	8000	4800	0.6	4000	2400	0.3	2700	1500	0.2
16	6000	3600	0.8	3000	1800	0.5	2000	1100	0.3
20	4800	2900	1.0	2400	1400	0.5	1600	880	0.3
25	3800	2300	1.0	1900	1100	0.5	1300	720	0.3
Depth of cut	 Please refer to the list above for depth of cut. ≤1.5DC			 Please refer to the list above for depth of cut. ≤1.0DC					

DC:Dia.

■Slot milling with small diameter tools

Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	15000	300	0.1	9500	110	0.05
2	8000	320	0.2	4800	190	0.1
Depth of cut	 Please refer to the list above for depth of cut. DC:Dia.					

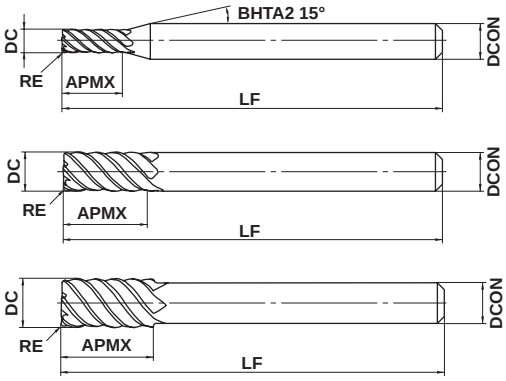
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VFMDRB

Corner radius, Medium cut length, 6 flute, For hardened materials

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎				



DC≤12	DC>12			
0 - 0.02	0 - 0.03			
DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20	
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013	

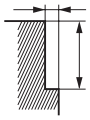
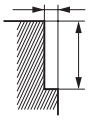
●6 flute corner radius end mill with Impact Miracle coating for high hardened materials.

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VFMDRBD0300R030	3	0.3	10	60	6	6	●	1
VFMDRBD0400R030	4	0.3	12	60	6	6	●	1
VFMDRBD0500R030	5	0.3	15	60	6	6	●	1
VFMDRBD0600R030	6	0.3	15	60	6	6	●	2
VFMDRBD0600R050	6	0.5	15	60	6	6	●	2
VFMDRBD0600R100	6	1	15	60	6	6	●	2
VFMDRBD0800R030	8	0.3	20	75	8	6	●	2
VFMDRBD0800R050	8	0.5	20	75	8	6	●	2
VFMDRBD0800R100	8	1	20	75	8	6	●	2
VFMDRBD1000R030	10	0.3	25	80	10	6	●	2
VFMDRBD1000R050	10	0.5	25	80	10	6	●	2
VFMDRBD1000R100	10	1	25	80	10	6	●	2
VFMDRBD1200R050	12	0.5	30	100	12	6	●	2
VFMDRBD1200R100	12	1	30	100	12	6	●	2
VFMDRBD1600R100	16	1	40	110	16	6	●	2
VFMDRBD1600R150	16	1.5	40	110	16	6	●	2
VFMDRBD1800R100	18	1	40	120	16	6	●	3
VFMDRBD1800R150	18	1.5	40	120	16	6	●	3
VFMDRBD2000R100	20	1	45	125	20	6	●	2
VFMDRBD2000R150	20	1.5	45	125	20	6	●	2
VFMDRBD2000R200	20	2	45	125	20	6	●	2

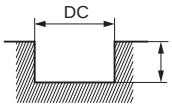
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2			Hardened steel (62−70HRC) AISI W1, AISI M2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	40000	1200	0.05	40000	800	0.03	32000	500	0.02
2	40000	2000	0.1	24000	1000	0.05	16000	600	0.05
3	32000	3800	0.2	16000	1900	0.1	11000	1200	0.05
4	24000	4400	0.2	12000	2200	0.1	8000	1300	0.05
6	16000	5800	0.3	8000	2900	0.2	5300	1800	0.1
8	12000	5800	0.4	6000	2900	0.2	4000	1800	0.1
10	9600	5800	0.5	4800	2900	0.3	3200	1800	0.2
12	8000	4800	0.6	4000	2400	0.3	2700	1500	0.2
16	6000	3600	0.8	3000	1800	0.5	2000	1100	0.3
20	4800	2900	1.0	2400	1400	0.5	1600	880	0.3
25	3800	2300	1.0	1900	1100	0.5	1300	720	0.3
Depth of cut	 Please refer to the list above for depth of cut. ≤1.5DC			 Please refer to the list above for depth of cut. ≤1.0DC					

DC:Dia.

■Slot milling with small diameter tools

Work Material	Hardened steel (45−55HRC) AISI H13			Hardened steel (55−62HRC) AISI D2		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut (mm)
1	15000	300	0.1	9500	110	0.05
2	8000	320	0.2	4800	190	0.1
Depth of cut	 Please refer to the list above for depth of cut. DC:Dia.					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VF8MHVRBCH

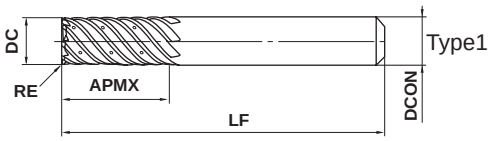
Corner radius end mill, Medium cut length, 8 flute, Irregular helix flutes, with multiple internal through coolant holes

TOOL NEWS

UWC VF 44° 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS



1≤RE≤3				
±0.015				
16≤DC≤20				
0 - 0.03				
DCON=16	DCON=20			
0 - 0.011	0 - 0.013			

●Vibration control corner radius end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

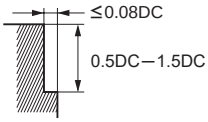
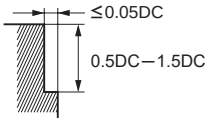
(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VF8MHVRBCHD1600R100	16	1	32	90	16	8	●	1
VF8MHVRBCHD1600R300	16	3	32	90	16	8	●	1
VF8MHVRBCHD2000R100	20	1	38	100	20	8	●	1
VF8MHVRBCHD2000R300	20	3	38	100	20	8	●	1

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	4000	2400	3000	2100	800	240
20	3200	1900	2400	1900	640	200
Depth of cut						

DC:Dia.

■Trochoidal slotting

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	4000	1900	3000	1400
20	3200	1500	2400	1200
Depth of cut				

DC:Dia.

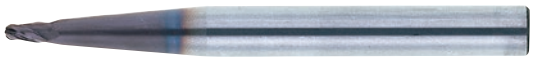
Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

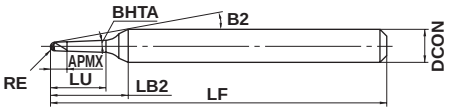
VC4STB

Ball nose taper end mill, Short cut length, 4 flute

UWC VC 30° RE<0.5 RE≥0.5

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	○	◎	◎	○	○		





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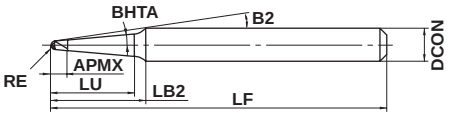

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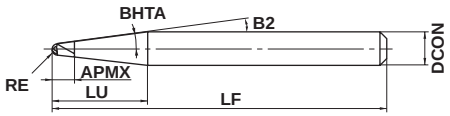


Type3

*Relief Neck type.

0.3≤RE≤4				
±0.01				
DCON=6	8≤DCON≤10			
0 / - 0.008	0 / - 0.009			

h6

●4 flute taper end mill with taper neck for maximum rigidity and high performance.

(mm)

Order Number	RE	BHTA	APMX	LU	LB2	B2	LF	DCON	No. of Flutes	Stock	Type
VC4STBR0030T0130N05	0.3	1.5°	1	5	9.0	17.2°	60	6	4	●	1
VC4STBR0030T0200N05	0.3	2°	1	5	9.0	17.2°	60	6	4	●	1
VC4STBR0030T0500N05	0.3	5°	1	5	8.8	17.6°	60	6	4	●	1
VC4STBR0030T1000N15	0.3	10°	1	15	—	10.4°	60	6	4	●	3
VC4STBR0040T0130N10	0.4	1.5°	2	10	14.0	10.8°	60	6	4	●	1
VC4STBR0040T0130N15	0.4	1.5°	2	15	19.0	8.0°	60	6	4	●	1
VC4STBR0040T0200N10	0.4	2°	2	10	14.0	10.8°	60	6	4	●	1
VC4STBR0040T0500N10	0.4	5°	2	10	13.5	11.2°	60	6	4	●	1
VC4STBR0040T0700N10	0.4	7°	7	10	12.2	12.4°	60	6	4	●	2
VC4STBR0040T1000N15	0.4	10°	3	15	—	10.1°	60	6	4	●	3
VC4STBR0050T0130N10	0.5	1.5°	2	10	14.0	10.5°	60	6	4	●	1
VC4STBR0050T0130N15	0.5	1.5°	2	15	19.0	7.7°	60	6	4	●	1
VC4STBR0050T0130N20	0.5	1.5°	2	20	24.0	6.1°	60	6	4	●	1
VC4STBR0050T0200N10	0.5	2°	2	10	14.0	10.5°	60	6	4	●	1
VC4STBR0050T0200N15	0.5	2°	2	15	18.9	7.8°	60	6	4	●	1
VC4STBR0050T0200N20	0.5	2°	3	20	24.0	6.1°	60	6	4	●	1
VC4STBR0050T0500N10	0.5	5°	3	10	13.6	10.8°	60	6	4	●	1
VC4STBR0050T0500N15	0.5	5°	3	15	17.2	8.5°	60	6	4	●	2
VC4STBR0050T0500N20	0.5	5°	3	20	21.8	6.7°	60	6	4	●	2
VC4STBR0050T0700N10	0.5	7°	7	10	12.1	12.2°	60	6	4	●	2
VC4STBR0050T0700N15	0.5	7°	7	15	16.6	8.9°	60	6	4	●	2
VC4STBR0050T0700N20	0.5	7°	7	20	—	7.3°	60	6	4	●	3
VC4STBR0050T1000N14	0.5	10°	3	14	—	10.5°	60	6	4	●	3
VC4STBR0075T0200N10	0.75	2°	3	10	14.0	9.6°	60	6	4	●	1
VC4STBR0075T0500N15	0.75	5°	3	15	17.0	7.9°	60	6	4	●	2
VC4STBR0100T0130N10	1	1.5°	4	10	13.5	9.1°	60	6	4	●	1
VC4STBR0100T0130N15	1	1.5°	4	15	18.5	6.5°	60	6	4	●	1
VC4STBR0100T0130N20	1	1.5°	4	20	23.5	5.1°	60	6	4	●	1
VC4STBR0100T0200N06	1	2°	4	6	8.7	14.4°	60	6	4	●	2
VC4STBR0100T0200N10	1	2°	4	10	13.8	8.9°	60	6	4	●	1
VC4STBR0100T0200N15	1	2°	4	15	17.5	6.9°	60	6	4	●	2
VC4STBR0100T0500N10	1	5°	4	10	12.2	10.1°	60	6	4	●	2
VC4STBR0100T0500N15	1	5°	4	15	16.8	7.2°	60	6	4	●	2
VC4STBR0100T0500N23	1	5°	4	23	—	5.2°	60	6	4	●	3

● : Inventory maintained in Japan.

(mm)

Order Number	RE	BHTA	APMX	LU	LB2	B2	LF	DCON	No. of Flutes	Stock	Type
VC4STBR0100T0700N17	1	7°	7	17	–	7.1°	60	6	4	●	3
VC4STBR0100T1000N12	1	10°	4	12	–	10.3°	60	6	4	●	3
VC4STBR0125T0500N15	1.25	5°	4	15	16.5	6.6°	60	6	4	●	2
VC4STBR0150T0130N15	1.5	1.5°	4	15	17.3	5.4°	60	6	4	●	2
VC4STBR0150T0130N20	1.5	1.5°	4	20	22.2	4.2°	60	6	4	●	2
VC4STBR0150T0300N15	1.5	3°	4	15	16.9	5.6°	60	6	4	●	2
VC4STBR0150T0500N10	1.5	5°	4	10	11.7	8.3°	60	6	4	●	2
VC4STBR0150T0500N18	1.5	5°	4	18	–	5.2°	60	6	4	●	3
VC4STBR0175T0500N15	1.75	5°	4	15	–	5.4°	60	6	4	●	3
VC4STBR0200T0130N15	2	1.5°	5	15	16.8	3.9°	60	6	4	●	2
VC4STBR0200T0130N20	2	1.5°	5	20	21.6	3.0°	60	6	4	●	2
VC4STBR0200T0300N21	2	3°	4	21	–	3.1°	60	6	4	●	3
VC4STBR0200T0500N13	2	5°	4	13	–	5.2°	60	6	4	●	3
VC4STBR0200T0700N18	2	7°	7	18	–	7.1°	60	8	4	●	3
VC4STBR0300T0130N15	3	1.5°	6	15	16.8	4.2°	90	8	4	●	2
VC4STBR0300T0130N20	3	1.5°	6	20	21.7	3.1°	90	8	4	●	2
VC4STBR0300T0300N22	3	3°	6	22	–	3.1°	90	8	4	●	3
VC4STBR0400T0130N15	4	1.5°	8	15	16.9	4.4°	90	10	4	●	2
VC4STBR0400T0300N22	4	3°	8	22	–	3.2°	90	10	4	●	3

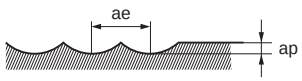
VC4STB

Ball nose taper end mill, Short cut length, 4 flute

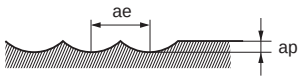
RECOMMENDED CUTTING CONDITIONS

Work Material			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45－55HRC) AISI H13				Hardened steel (55－62HRC) AISI D2			
R **RE** (mm)	Taper angle one side **BHTA**	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R 0.3	1.5°	5	40000	1600	0.08	0.12	40000	1200	0.06	0.10	40000	700	0.04	0.06
	2°	5	40000	1600	0.08	0.12	40000	1200	0.06	0.10	40000	700	0.04	0.06
	5°	5	40000	1600	0.08	0.12	40000	1200	0.06	0.10	40000	700	0.04	0.06
	10°	15	40000	1600	0.05	0.08	40000	1200	0.04	0.06	40000	700	0.03	0.04
R 0.4	1.5°	10	40000	2000	0.07	0.11	40000	1500	0.06	0.08	30000	700	0.04	0.05
	1.5°	15	40000	2000	0.05	0.08	40000	1500	0.04	0.06	30000	800	0.03	0.04
	2°	10	40000	2000	0.07	0.11	40000	1500	0.06	0.08	30000	800	0.04	0.05
	5°	10	40000	2000	0.07	0.11	40000	1500	0.06	0.08	30000	800	0.04	0.05
	7°	10	40000	2000	0.07	0.11	40000	1500	0.06	0.08	30000	800	0.04	0.05
	10°	15	40000	2000	0.06	0.09	40000	1500	0.05	0.07	30000	800	0.03	0.05
R 0.5	1.5°	10	38000	2500	0.11	0.16	35000	1600	0.08	0.13	25000	800	0.05	0.08
	1.5°	15	38000	2500	0.09	0.14	35000	1600	0.07	0.11	25000	800	0.05	0.07
	1.5°	20	38000	2500	0.06	0.09	35000	1600	0.05	0.07	25000	800	0.03	0.05
	2°	10	38000	2500	0.11	0.16	35000	1600	0.08	0.13	25000	800	0.05	0.08
	2°	15	38000	2500	0.09	0.14	35000	1600	0.07	0.11	25000	800	0.05	0.07
	2°	20	38000	2500	0.06	0.09	35000	1600	0.05	0.07	25000	800	0.03	0.05
	5°	10	38000	2500	0.12	0.18	35000	1600	0.10	0.14	25000	800	0.06	0.09
	5°	15	38000	2500	0.09	0.14	35000	1600	0.07	0.11	25000	800	0.05	0.07
	5°	20	38000	2500	0.08	0.11	35000	1600	0.06	0.09	25000	800	0.04	0.06
	7°	10	38000	2500	0.12	0.18	35000	1600	0.10	0.14	25000	800	0.06	0.09
	7°	15	38000	2500	0.11	0.16	35000	1600	0.08	0.13	25000	800	0.05	0.08
	7°	20	38000	2500	0.08	0.11	35000	1600	0.06	0.09	25000	800	0.04	0.06
	10°	14	38000	2500	0.11	0.16	35000	1600	0.08	0.13	25000	800	0.05	0.08
R 0.75	2°	10	38000	2500	0.18	0.27	35000	1600	0.14	0.22	18000	800	0.09	0.14
	5°	15	38000	2500	0.16	0.24	35000	1600	0.13	0.19	18000	800	0.08	0.12
R 1	1.5°	10	35000	2800	0.18	0.27	30000	1800	0.14	0.22	15000	1000	0.09	0.14
	1.5°	15	35000	2800	0.16	0.24	30000	1800	0.13	0.19	15000	1000	0.08	0.12
	1.5°	20	35000	2800	0.14	0.21	30000	1800	0.11	0.17	15000	1000	0.07	0.11
	2°	6	35000	2800	0.20	0.30	30000	1800	0.16	0.24	15000	1000	0.10	0.15
	2°	10	35000	2800	0.18	0.27	30000	1800	0.14	0.22	15000	1000	0.09	0.14
	2°	15	35000	2800	0.16	0.24	30000	1800	0.13	0.19	15000	1000	0.08	0.12
	5°	10	35000	2800	0.18	0.27	30000	1800	0.14	0.22	15000	1000	0.09	0.14
	5°	15	35000	2800	0.18	0.27	30000	1800	0.14	0.22	15000	1000	0.09	0.14
	5°	23	35000	2800	0.14	0.21	30000	1800	0.11	0.17	15000	1000	0.07	0.11
	7°	17	35000	2800	0.16	0.24	30000	1800	0.13	0.19	15000	1000	0.08	0.12
	10°	12	35000	2800	0.18	0.27	30000	1800	0.14	0.22	15000	1000	0.09	0.14
R 1.25	5°	15	35000	2800	0.23	0.34	30000	1800	0.18	0.27	15000	1000	0.11	0.17
R 1.5	1.5°	15	32000	3000	0.23	0.34	27000	2000	0.18	0.27	16000	1200	0.11	0.17
	1.5°	20	32000	3000	0.23	0.34	27000	2000	0.18	0.27	16000	1200	0.11	0.17
	3°	15	32000	3000	0.23	0.34	27000	2000	0.18	0.27	16000	1200	0.11	0.17
	5°	10	32000	3000	0.25	0.38	27000	2000	0.20	0.30	16000	1200	0.13	0.19
	5°	18	32000	3000	0.23	0.34	27000	2000	0.18	0.27	16000	1200	0.11	0.17
R 1.75	5°	15	27500	3500	0.23	0.34	23000	2500	0.18	0.27	14000	1500	0.11	0.17

Depth of cut



Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

Work Material			Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21				Hardened steel (45－55HRC) AISI H13				Hardened steel (55－62HRC) AISI D2			
R **RE** (mm)	Taper angle one side **BHTA**	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R 2	1.5°	15	24000	3500	0.23	0.34	20000	2500	0.18	0.27	12000	1500	0.11	0.17
	1.5°	20	24000	3500	0.23	0.34	20000	2500	0.18	0.27	12000	1500	0.11	0.17
	3°	21	24000	3500	0.23	0.34	20000	2500	0.18	0.27	12000	1500	0.11	0.17
	5°	13	24000	3500	0.25	0.38	20000	2500	0.20	0.30	12000	1500	0.13	0.19
	7°	18	24000	3500	0.23	0.34	20000	2500	0.18	0.27	12000	1500	0.11	0.17
R 3	1.5°	15	16000	3500	0.30	0.45	13500	2500	0.24	0.36	8000	1500	0.15	0.23
	1.5°	20	16000	3500	0.30	0.45	13500	2500	0.24	0.36	8000	1500	0.15	0.23
	3°	22	16000	3500	0.30	0.45	13500	2500	0.24	0.36	8000	1500	0.15	0.23
R 4	1.5°	15	12000	3500	0.30	0.45	10000	2500	0.24	0.36	6000	1500	0.15	0.23
	3°	22	12000	3500	0.30	0.45	10000	2500	0.24	0.36	6000	1500	0.15	0.23
Depth of cut														

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

C4LATB

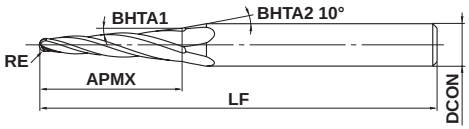
Ball nose taper end mill, Long cut length, 4 flute, For aluminum impellers

TOOL NEWS

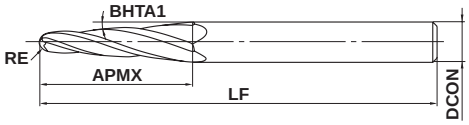
UWC

γ 20°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

RE≤2				
± 0.010				
±5'				
DCON=6	DCON=8			
0 - 0.008	0 - 0.009			

h6

●High-efficiency roughing for aluminum impellers.

(mm)

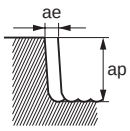
Order Number	RE	BHTA1	APMX	LF	DCON	No. of Flutes	Stock	Type
C4LATBR050T040AP20	0.5	4°	20	70	6	4	●	1
C4LATBR100T040AP20	1	4°	20	70	6	4	●	1
C4LATBR150T040AP20	1.5	4°	20	75	8	4	●	1
C4LATBR200T040AP30	2	4°	30	75	8	4	●	2

Note 1) Please inquire with us regarding non-standard special shapes
(ex.: RE sizes starting from a minimum of R0.3, half included taper angles) or coatings.

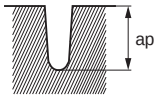
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

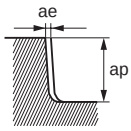
■Side milling

Work Material	Aluminium alloy			
R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.5	20000	2000	15	0.75
R1	20000	4000	15	1.5
R1.5	20000	5200	15	2.25
R2	20000	5200	23	3
Depth of cut				

■Slotting

Work Material	Aluminium alloy		
R **RE**	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
R0.5	20000	600	10
R1	20000	2800	10
R1.5	20000	4000	10
R2	20000	4000	15
Depth of cut			

■Side milling (Finishing)

Work Material	Aluminium alloy			
R **RE** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R0.5	20000	800	18	0.1
R1	20000	2000	18	0.2
R1.5	20000	2400	18	0.3
R2	20000	2400	27	0.3
Depth of cut				

Note 1) Water-soluble cutting fluid is recommended.
Note 2) Climb cutting is recommended for side milling.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

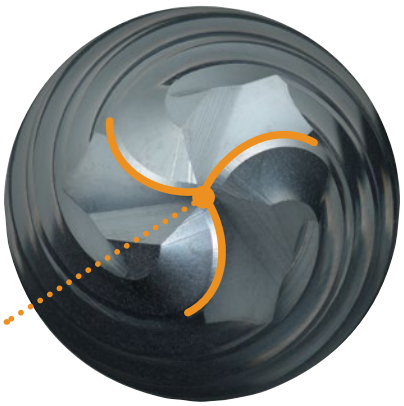
VQT6UR

Nose radius suitable for fillet milling, also tangential form radius fit composite blade surface machining.

Radial Accuracy

RE1 and RE2 ±0.010mm

Optimum Cutting Edge Design



6-flute Peripheral Cutting Edge (Irregular pitch)

Multi cutting edge design achieve high efficiency machining.
Irregular pitch design prevents chattering.

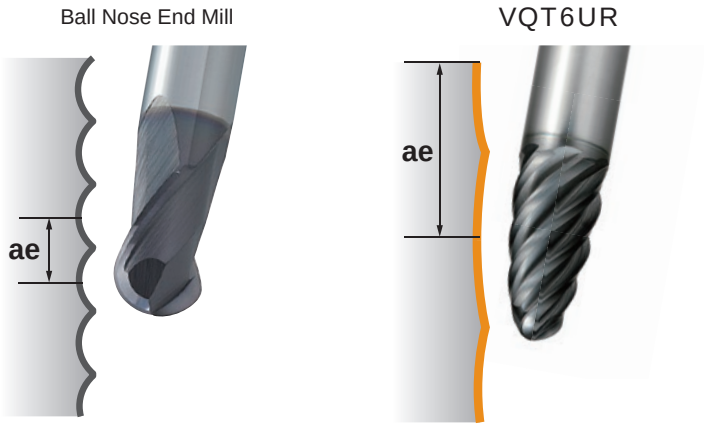
3-flute End Cutting Edge

A wide flute improves chip evacuation.

Ideal Shape

Compared with ball nose end mill, an tangential form radius is larger and cusp height is controllable. This design makes highly efficient machining with larger pick feed.

Nose and tangential form part has two different radius.



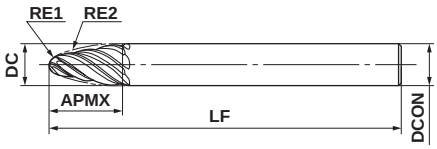
Shorter cutting distance contribute to longer tool life.

VQT6UR NEW

Barrel, Medium cut length, 6 flute

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
				○	◎		○



Type1

RE1≤4	RE2≤100			
±0.01	±0.01			
DCON≤10	DCON=12			
0 - 0.009	0 - 0.011			

- Nose and tangential form part has two different radius.
- Irregular pitch design prevents chattering and achieves high efficiency and high quality machining surface.

(mm)

Order Number	DC	RE1	RE2	APMX	LF	DCON	No. of Flutes	Stock	Type
VQT6URR020R075S08	8	2	75	21	90	8	6	●	1
VQT6URR020R085S10	10	2	85	26	100	10	6	●	1
VQT6URR030R075S10	10	3	75	22	100	10	6	●	1
VQT6URR040R100S12	12	4	100	25	110	12	6	●	1

Note 1) SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work.
When measuring the tool length, please use an internal contact type (non-electricity type) or a laser tool setter.

● : **Inventory maintained in Japan.**

VQT6UR NEW

Barrel, Medium cut length, 6 flute

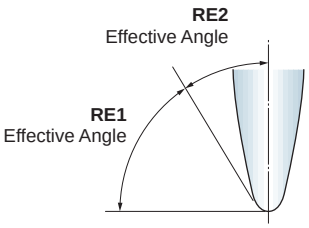
RECOMMENDED CUTTING CONDITIONS

■Effective Angle

Please refer to the table below for the use of the nose radius (RE1) and tangential form radius (RE2).

(mm)

Order Number	Nose Radius		Tangential Form Radius	
	RE1	Effective Angle	**RE2**	Effective Angle
VQT6URR020R075S08	2	76.6°	75	13.4°
VQT6URR020R085S10	2	74.5°	85	15.5°
VQT6URR030R075S10	3	76.4°	75	13.6°
VQT6URR040R100S12	4	78.3°	100	11.7°



■Side Milling with the Use of the Tangential Form Radius (RE2)

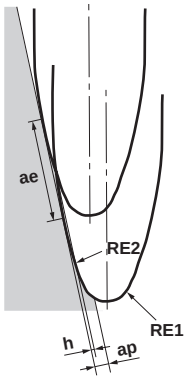
Work Material		Mild Steels (≤180HB) Carbon Steels, Cast Irons (180−280HB)			Austenitic Stainless Steels (≤200HB) Titanium Alloys			Aluminum Alloys (Si<5%)		
DC (mm)	**RE2** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
8	75	8000	2400	0.05−0.3	3200	770	0.05−0.3	16000	4800	0.05−0.3
10	85	6400	1900	0.05−0.3	2500	600	0.05−0.3	13000	3900	0.05−0.3
10	75	6400	1900	0.05−0.3	2500	600	0.05−0.3	13000	3900	0.05−0.3
12	100	5300	1600	0.05−0.3	2100	500	0.05−0.3	11000	3300	0.05−0.3

■Depth of Cut Calculation Table Based on Tangential Form Radius (RE2) and Cusp Height (h)

(mm)

Work Material	**RE2**	Cusp Height **h**	0.0001	0.0003	0.0005	0.0008	0.001	0.003	0.005	0.008
VQT6URR020R075S08	75	Depth of Cut **ap**	0.245	0.424	0.548	0.693	0.775	1.342	1.732	2.191
VQT6URR030R075S10	75		0.245	0.424	0.548	0.693	0.775	1.342	1.732	2.191
VQT6URR020R085S10	85		0.261	0.452	0.583	0.738	0.825	1.428	1.844	2.332
VQT6URR040R100S12	100		0.283	0.49	0.632	0.8	0.894	1.549	2	2.53

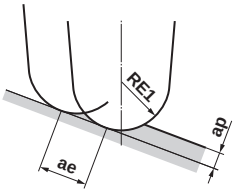
Note 1) SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work.
When measuring the tool length, please use an internal contact type (non-electricity type) or a laser tool setter.
Note 2) It is recommended to use this tool only for finish cutting.
Note 3) The tool contact part differs between the nose radius and tangential form radius depending on machining geometries and tilt angles.
Select suitable cutting conditions according to tool contact parts.



■Milling with the Use of the Nose Radius (RE1)

Work Material		Mild Steels (≤180HB) Carbon Steels, Cast Irons (180−280HB)				Austenitic Stainless Steels (≤200HB) Titanium Alloys				Aluminum Alloys (Si<5%)			
DC (mm)	**RE1** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
8	2	16000	2400	0.4	1	6400	580	0.4	1	32000	4800	0.4	1
10	2	16000	2400	0.4	1	6400	580	0.4	1	32000	4800	0.4	1
10	3	11000	1700	0.6	1.5	4200	380	0.6	1.5	21000	3200	0.6	1.5
12	4	8000	1200	0.8	2	3200	290	0.8	2	16000	2400	0.8	2

Note 1) SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work.
When measuring the tool length, please use an internal contact type (non-electricity type) or a laser tool setter.
Note 2) It is recommended to use this tool only for finish cutting.
Note 3) The tool contact part differs between the nose radius and tangential form radius depending on machining geometries and tilt angles.
Select suitable cutting conditions according to tool contact parts.



ae:Pick Feed

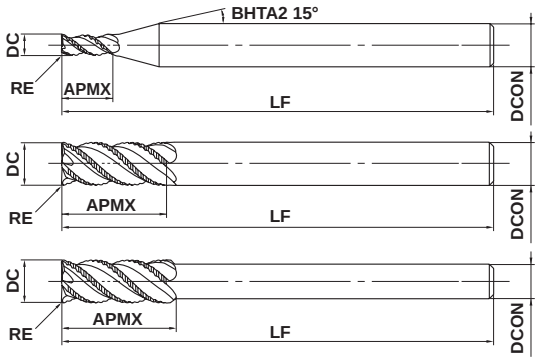
VQSVR

Roughing end mill, Short cut length, 4 flute, Irregular helix flutes

TOOL NEWS

UWC VQ 43° 44° 45° DC<8 43° 45° DC≥8 DC<8 DC≥8

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎	○	



h6	DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20
	0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013

- Achieving an excellent vibration resistance due to the adoption of irregular helix.
- Use of an asymmetric chip breaker improves fracture resistance substantially. (Compared to a conventional roughing end mill)

(mm)

Order Number	DC	RE	APMX	LF	DCON	No. of Flutes	Stock	Type
VQSVRD0300	3	0.2	6	60	6	3	●	1
VQSVRD0400	4	0.2	8	60	6	3	●	1
VQSVRD0500	5	0.3	10	60	6	3	●	1
VQSVRD0600	6	0.3	12	70	6	3	●	2
VQSVRD0700	7	0.3	17	80	8	3	●	1
VQSVRD0800	8	0.5	17	80	8	4	●	2
VQSVRD0900	9	0.5	22	90	10	4	●	1
VQSVRD1000	10	0.5	22	90	10	4	●	2
VQSVRD1000S08	10	0.5	22	90	8	4	●	3
VQSVRD1200	12	0.5	27	100	12	4	●	2
VQSVRD1200S10	12	0.5	27	100	10	4	●	3
VQSVRD1400	14	0.5	27	130	12	4	●	3
VQSVRD1600	16	0.5	33	125	16	4	●	2
VQSVRD1800	18	0.5	33	150	16	4	●	3
VQSVRD2000	20	0.5	38	140	20	4	●	2

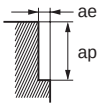
Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.

RECOMMENDED CUTTING CONDITIONS

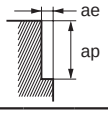
■Side milling

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH					Copper, Copper alloy				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)
3	150	16000	960	4.5	1.5	120	13000	640	4.5	1.5	100	11000	450	4.5	1.5	75	8000	330	4.5	0.9	180	19000	1100	4.5	1.5
4	150	12000	960	6	2	120	9500	640	6	2	100	8000	430	6	2	75	6000	330	6	1.2	180	14000	1100	6	2
5	150	9500	960	7.5	2.5	120	7600	640	7.5	2.5	100	6400	440	7.5	2.5	75	4800	330	7.5	1.5	180	11000	1100	7.5	2.5
6	150	8000	960	9	3	120	6400	680	9	3	100	5300	480	9	3	75	4000	360	9	1.8	180	9500	1100	9	3
7	150	6800	950	10.5	3.5	120	5500	700	10.5	3.5	100	4500	500	10.5	3.5	75	3400	380	10.5	2.1	180	8200	1100	10.5	3.5
8	150	6000	1100	12	4	120	4800	800	12	4	100	4000	570	12	4	75	3000	430	12	2.4	180	7200	1300	12	4
9	150	5300	1100	13.5	4.5	120	4200	760	13.5	4.5	100	3500	570	13.5	4.5	75	2700	430	13.5	2.7	180	6400	1300	13.5	4.5
10	150	4800	1100	15	5	120	3800	760	15	5	100	3200	570	15	5	75	2400	430	15	3	180	5700	1200	15	5
12	150	4000	960	18	6	120	3200	700	18	6	100	2700	540	18	6	75	2000	400	18	3.6	180	4800	1200	18	6
14	150	3400	880	21	7	120	2700	650	21	7	100	2300	510	21	7	75	1700	380	21	4.2	180	4100	1100	21	7
16	150	3000	840	24	8	120	2400	620	24	8	100	2000	500	24	8	75	1500	380	24	4.8	180	3600	1000	24	8
18	150	2700	810	27	9	120	2100	590	27	9	100	1800	500	27	9	75	1300	360	27	5.4	180	3200	960	27	9
20	150	2400	760	30	10	120	1900	560	30	10	100	1600	500	30	10	75	1200	360	30	6	180	2900	920	30	10
Depth of cut																									

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340					Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 306, Ti-6Al-4V					Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH					Copper, Copper alloy				
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Hole Depth ap (mm)	Hole Depth ae (mm)
3	120	13000	610	4.5	1.5	100	11000	430	4.5	1.5	80	8500	280	4.5	1.5	70	7400	240	4.5	0.9	140	15000	700	4.5	1.5
4	120	9500	610	6	2	100	8000	430	6	2	80	6400	280	6	2	70	5600	240	6	1.2	140	11000	700	6	2
5	120	7600	610	7.5	2.5	100	6400	430	7.5	2.5	80	5100	280	7.5	2.5	70	4500	250	7.5	1.5	140	8900	720	7.5	2.5
6	120	6400	610	9	3	100	5300	450	9	3	80	4200	300	9	3	70	3700	270	9	1.8	140	7400	720	9	3
7	120	5500	620	10.5	3.5	100	4500	480	10.5	3.5	80	3600	320	10.5	3.5	70	3200	290	10.5	2.1	140	6400	720	10.5	3.5
8	120	4800	720	12	4	100	4000	570	12	4	80	3200	380	12	4	70	2800	340	12	2.4	140	5600	840	12	4
9	120	4200	670	13.5	4.5	100	3500	510	13.5	4.5	80	2800	360	13.5	4.5	70	2500	320	13.5	2.7	140	5000	800	13.5	4.5
10	120	3800	670	15	5	100	3200	510	15	5	80	2500	360	15	5	70	2200	310	15	3	140	4500	790	15	5
12	120	3200	610	18	6	100	2700	470	18	6	80	2100	340	18	6	70	1900	300	18	3.6	140	3700	710	18	6
14	120	2700	560	21	7	100	2300	440	21	7	80	1800	320	21	7	70	1600	280	21	4.2	140	3200	670	21	7
16	120	2400	540	24	8	100	2000	410	24	8	80	1600	320	24	8	70	1400	280	24	4.8	140	2800	630	24	8
18	120	2100	500	27	9	100	1800	400	27	9	80	1400	310	27	9	70	1200	270	27	5.4	140	2500	600	27	9
20	120	1900	480	30	10	100	1600	380	30	10	80	1300	310	30	10	70	1100	270	30	6	140	2200	560	30	10
Depth of cut																									

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) When the depth of cut is smaller than shown the revolution and feed rate can be increased.

VQSVR

Roughing end mill, Short cut length, 4 flute, Irregular helix flutes

RECOMMENDED CUTTING CONDITIONS

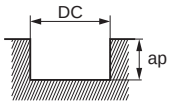
■Slotting

The rigidity of the machine or workpiece and chip discharge are sufficient at high efficiency conditions.
The rigidity of the machine or workpiece or chip discharge is insufficient at general-purpose conditions.

High efficiency conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 306, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH				Copper, Copper alloy			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
3	120	13000	720	3	100	11000	440	3	80	8500	340	3	60	6400	250	1.5	150	16000	890	3
4	120	9500	720	4	100	8000	450	4	80	6400	340	4	60	4800	250	2	150	12000	900	4
5	120	7600	720	5	100	6400	460	5	80	5100	300	5	60	3800	230	2.5	150	9500	900	5
6	120	6400	720	6	100	5300	460	6	80	4200	310	6	60	3200	240	3	150	8000	900	6
7	120	5500	730	7	100	4500	470	7	80	3600	330	7	60	2700	250	3.5	150	6800	950	7
8	120	4800	840	8	100	4000	560	8	80	3200	400	8	60	2400	300	4	150	6000	1100	8
9	120	4200	810	9	100	3500	540	9	80	2800	350	9	60	2100	260	4.5	150	5300	1000	9
10	120	3800	800	10	100	3200	520	10	80	2500	340	10	60	1900	260	5	150	4800	1000	10
12	120	3200	750	12	100	2700	480	12	80	2100	340	12	60	1600	260	6	150	4000	940	12
14	120	2700	670	14	100	2300	420	14	80	1800	300	14	60	1400	240	7	150	3400	840	14
16	120	2400	620	16	100	2000	380	16	80	1600	290	16	60	1200	220	8	150	3000	780	16
18	120	2100	570	18	100	1800	380	18	80	1400	260	18	60	1100	210	9	150	2700	730	18
20	120	1900	540	20	100	1600	350	20	80	1300	260	20	60	950	190	10	150	2400	680	20

Depth of cut

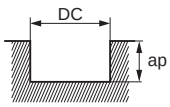


DC:Dia.

General-purpose conditions

Work Material	Carbon steel, Alloy steel, Mild steel AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340				Austenitic, Ferritic and Martensitic stainless steels, Titanium alloys AISI 304, AISI 306, Ti-6Al-4V				Hardened stainless steels, Cobaly chromium alloy AISI 630, AISI 631, 15-5PH, 17-4PH				Copper, Copper alloy			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
3	100	11000	490	3	80	8500	300	3	60	6400	200	3	50	5300	170	1.5	120	13000	580	3
4	100	8000	490	4	80	6400	310	4	60	4800	200	4	50	4000	170	2	120	9500	580	4
5	100	6400	490	5	80	5100	310	5	60	3800	200	5	50	3200	170	2.5	120	7600	580	5
6	100	5300	490	6	80	4200	310	6	60	3200	200	6	50	2700	170	3	120	6400	580	6
7	100	4500	500	7	80	3600	320	7	60	2700	200	7	50	2300	170	3.5	120	5500	620	7
8	100	4000	600	8	80	3200	380	8	60	2400	240	8	50	2000	200	4	120	4800	720	8
9	100	3500	540	9	80	2800	330	9	60	2100	210	9	50	1800	180	4.5	120	4200	650	9
10	100	3200	540	10	80	2500	330	10	60	1900	210	10	50	1600	180	5	120	3800	640	10
12	100	2700	510	12	80	2100	320	12	60	1600	210	12	50	1300	170	6	120	3200	600	12
14	100	2300	460	14	80	1800	300	14	60	1400	190	14	50	1100	150	7	120	2700	540	14
16	100	2000	410	16	80	1600	290	16	60	1200	170	16	50	990	140	8	120	2400	500	16
18	100	1800	390	18	80	1400	260	18	60	1100	170	18	50	880	130	9	120	2100	460	18
20	100	1600	360	20	80	1300	260	20	60	950	150	20	50	800	130	10	120	1900	430	20

Depth of cut



DC:Dia.

Note 1) SMART MIRACLE Coating is not energized because of its nature. Therefore, an external contact (voltaic type) tool setter cannot be used. An internal contact (non-voltaic) type or laser type tool setter is recommended to measure the length of the tool.
Note 2) Effective cutting of stainless steel, titanium alloys and heat-resistant alloys etc. can be achieved with the use of emulsion.
Note 3) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 4) Finishing at a faster feedrate is possible when the depth of cut is small.

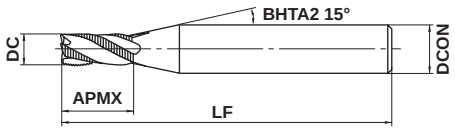
VFSFPR

Roughing end mill, Short cut length, 3—4 flute

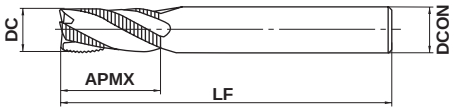
TOOL NEWS

UWC VF γ 30° DC<8 DC≥8

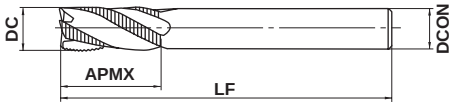
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎			◎	◎		



Type1



Type2



Type3

h6

DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013

● Impact Miracle roughing end mills for a wide range of work materials from carbon and alloy steel through to difficult-to-cut materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFSFPRD0300	3	6	50	6	3	●	1
VFSFPRD0400	4	8	50	6	3	●	1
VFSFPRD0500	5	10	50	6	3	●	1
VFSFPRD0600	6	12	50	6	3	●	2
VFSFPRD0700	7	17	60	8	3	●	1
VFSFPRD0800	8	17	60	8	4	●	2
VFSFPRD0900	9	22	70	10	4	●	1
VFSFPRD1000	10	22	70	10	4	●	2
VFSFPRD1000S08	10	22	90	8	4	●	3
VFSFPRD1200	12	27	75	12	4	●	2
VFSFPRD1200S10	12	27	100	10	4	●	3
VFSFPRD1400	14	27	75	12	4	●	3
VFSFPRD1600	16	33	90	16	4	●	2
VFSFPRD1800	18	33	90	16	4	●	3
VFSFPRD2000	20	38	100	20	4	●	2

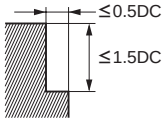
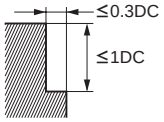
● : Inventory maintained in Japan.

VFSFPR

Roughing end mill, Short cut length, 3—4 flute

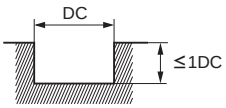
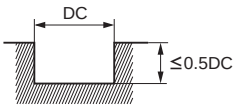
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (—30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45—55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	16000	960	13000	640	6400	260	5300	320	4200	70
4	12000	960	9500	640	4800	260	4000	320	3200	70
5	9500	960	7600	640	3800	260	3200	320	2500	70
6	8000	960	6400	680	3200	290	2700	340	2100	75
8	6000	1050	4800	760	2400	340	2000	400	1600	95
10	4800	1050	3800	760	1900	340	1600	400	1300	105
12	4000	960	3200	700	1600	320	1300	400	1100	110
16	3000	840	2400	620	1200	300	1000	360	800	110
20	2400	760	1900	560	1000	300	800	320	600	100
Depth of cut										

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (—30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45—55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	13000	720	11000	480	4800	190	3200	190	2100	25
4	9500	720	8000	480	3600	190	2400	190	1600	25
5	7600	720	6400	480	3200	190	1900	190	1300	25
6	6400	720	5300	480	2700	200	1600	200	1100	30
8	4800	800	4000	520	2000	220	1200	220	800	35
10	3800	800	3200	520	1600	220	1000	220	600	35
12	3200	750	2700	520	1300	210	800	210	500	40
16	2400	620	2000	450	1000	180	600	180	400	45
20	1900	540	1600	400	800	160	500	160	300	40
Depth of cut										

DC:Dia.

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

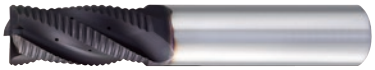
VFSFPRCH

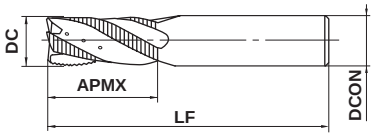
Roughing end mill, Short cut length, 4 flute, with multiple internal through coolant holes

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS





Type1

h6	DCON=16	DCON=20			
	0 - 0.011	0 - 0.013			

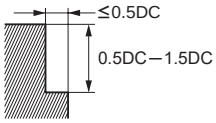
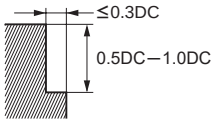
●Roughing end mill with multiple internal through coolant holes suitable for difficult-to-cut materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFSFPRCHD1600	16	33	90	16	4	●	1
VFSFPRCHD2000	20	38	100	20	4	●	1

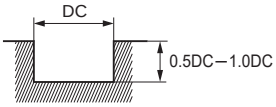
RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	840	2400	620	1200	300	800	110
20	2400	760	1900	560	1000	300	600	100
Depth of cut								

DC:Dia.

■Slotting

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (−45HRC) AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	2400	620	2000	450	800	100
20	1900	540	1600	400	600	80
Depth of cut						

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : **Inventory maintained in Japan.**

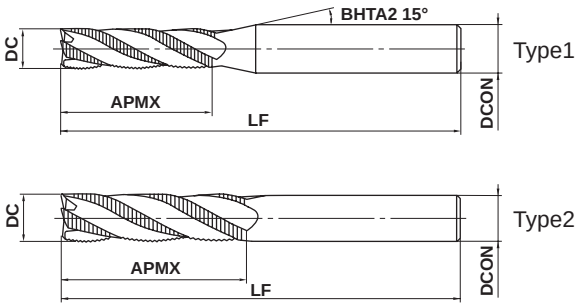
VFMFPR

Roughing end mill, Medium cut length, 4 flute

TOOL NEWS

UWC VF γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		



h6

DCON=6	8≤DCON≤10	12≤DCON≤16	DCON=20
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013

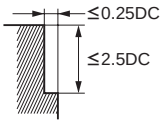
●Impact Miracle roughing end mills suitable for the machining of deep walled components.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFMFPRD0500	5	15	60	6	4	●	1
VFMFPRD0600	6	17	60	6	4	●	2
VFMFPRD0700	7	22	75	8	4	●	1
VFMFPRD0800	8	28	75	8	4	●	2
VFMFPRD0900	9	28	100	10	4	●	1
VFMFPRD1000	10	34	100	10	4	●	2
VFMFPRD1200	12	40	110	12	4	●	2
VFMFPRD1600	16	48	125	16	4	●	2
VFMFPRD2000	20	57	140	20	4	●	2

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Carbon steel, Cast iron, Alloy steel (−30HRC) AISI 1050, AISI No 35 B, AISI P20		Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Hardened steel (45−55HRC) AISI H13		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	3800	360	3200	290	2500	150	2500	150	1900	50
6	3200	360	2700	290	2100	160	2100	160	1600	60
8	2400	450	2000	360	1600	160	1600	160	1200	70
10	1900	450	1600	360	1300	180	1300	180	1000	75
12	1600	400	1300	320	1100	180	1100	180	800	80
16	1200	360	1000	290	800	160	800	160	600	80
20	1000	340	800	270	600	150	600	150	500	80
Depth of cut	 DC:Dia.									

Note 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : Inventory maintained in Japan.

VF6SVRCH

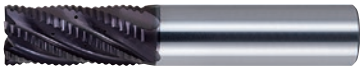
Roughing end mill, Short cut length, 6 flute, Irregular helix flutes, with multiple internal through coolant holes

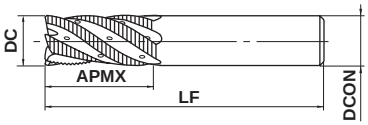
TOOL NEWS

28.5°
30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
○	○			◎	◎		

CoolStar
END MILLS





Type1

DCON=16	DCON=20			
0 - 0.011	0 - 0.013			

h6

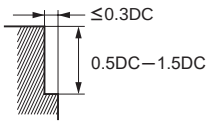
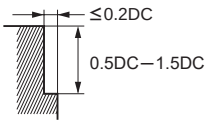
●Roughing end mill with multiple internal through coolant holes suitable for difficult-to-cut materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF6SVRCHD1600	16	33	90	16	6	●	1
VF6SVRCHD2000	20	38	100	20	6	●	1

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1500	2400	1200	800	160
20	2400	1200	2000	1000	640	140
Depth of cut						

DC:Dia.

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

CSRARB

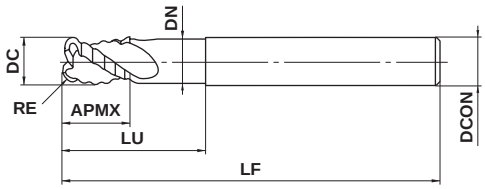
Corner radius roughing end mill, Short cut length, 3 flute, For aluminium alloy

TOOL NEWS

UWC

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1

h6	DCON=10	12≤DCON≤16	20≤DCON≤25		
	0 - 0.009	0 - 0.011	0 - 0.013		

●3 flute uncoated end mill for roughing aluminium alloy.

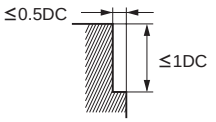
(mm)

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
CSRARBD1000R100	10	1	12	25	9.4	75	10	3	●	1
CSRARBD1000R200	10	2	12	25	9.4	75	10	3	●	1
CSRARBD1200R100	12	1	15	30	11.4	75	12	3	●	1
CSRARBD1200R200	12	2	15	30	11.4	75	12	3	●	1
CSRARBD1600R200	16	2	18	35	15.4	100	16	3	●	1
CSRARBD1600R300	16	3	18	35	15.4	100	16	3	●	1
CSRARBD2000R200	20	2	25	50	18.0	125	20	3	●	1
CSRARBD2000R300	20	3	25	50	18.0	125	20	3	●	1
CSRARBD2500R300	25	3	30	60	23.0	125	25	3	●	1
CSRARBD2500R400	25	4	30	60	23.0	125	25	3	●	1
CSRARBD2500R500	25	5	30	60	23.0	125	25	3	●	1

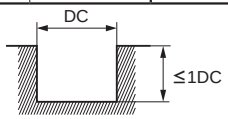
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	19000	8600	9500	3400
12	16000	8200	8000	3200
16	12000	7600	6000	3100
18	10500	7200	5300	2900
20	9500	7100	4800	2900
22	8500	6900	4300	2800
25	7500	6800	3800	2700
Depth of cut	 DC:Dia.			

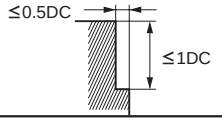
■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	19000	6800	9500	2700
12	16000	6500	8000	2600
16	12000	6100	6000	2400
18	10500	5800	5300	2400
20	9500	5700	4800	2300
22	8500	5500	4300	2200
25	7500	5400	3800	2200
Depth of cut	 DC:Dia.			

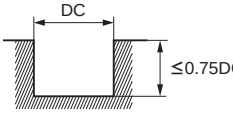
Note 1) Water-soluble cutting fluid is recommended.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Climb cutting is recommended for side milling.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

Using a high-speed and high-rigidity machining center

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	30000	11000	19000	5400
12	30000	12000	16000	5300
16	24000	12000	12000	4900
18	21000	12000	10500	4700
20	19000	11000	9500	4600
22	17000	11000	8500	4300
25	15000	11000	7500	4300
Depth of cut	 DC:Dia.			

■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	30000	8600	19000	4300
12	30000	9900	16000	4300
16	24000	9700	12000	4000
18	21000	9500	10500	3800
20	19000	9100	9500	3700
22	17000	8700	8500	3400
25	15000	8600	7500	3400
Depth of cut	 DC:Dia.			

Note 1) Water-soluble cutting fluid is recommended.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Climb cutting is recommended for side milling.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

CSRA

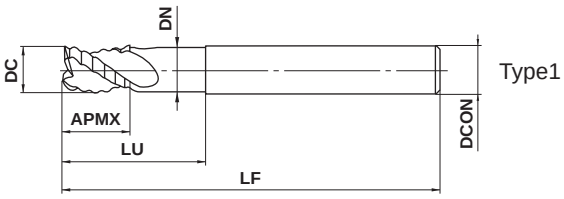
Roughing end mill, Short cut length, 3 flute, For aluminium alloy

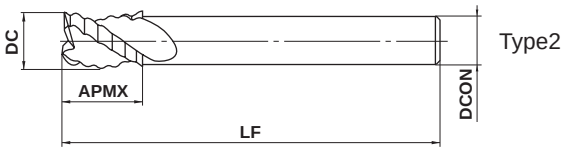
TOOL NEWS

UWC

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎





h6

DCON=10	12≤DCON≤16	20≤DCON≤25		
0 - 0.009	0 - 0.011	0 - 0.013		

●3 flute uncoated end mill for roughing aluminium alloy.

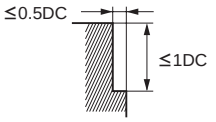
(mm)

Order Number	DC	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type
CSRAD1000	10	12	25	9.4	75	10	3	●	1
CSRAD1200	12	15	30	11.4	75	12	3	●	1
CSRAD1600	16	18	35	15.4	100	16	3	●	1
CSRAD1800	18	22	—	—	100	16	3	●	2
CSRAD2000	20	25	50	18.0	125	20	3	●	1
CSRAD2200	22	25	—	—	125	20	3	●	2
CSRAD2500	25	30	60	23.0	125	25	3	●	1

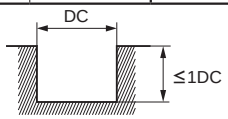
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	19000	8600	9500	3400
12	16000	8200	8000	3200
16	12000	7600	6000	3100
18	10500	7200	5300	2900
20	9500	7100	4800	2900
22	8500	6900	4300	2800
25	7500	6800	3800	2700
Depth of cut	 DC:Dia.			

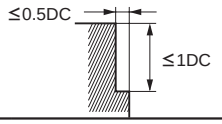
■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	19000	6800	9500	2700
12	16000	6500	8000	2600
16	12000	6100	6000	2400
18	10500	5800	5300	2400
20	9500	5700	4800	2300
22	8500	5500	4300	2200
25	7500	5400	3800	2200
Depth of cut	 DC:Dia.			

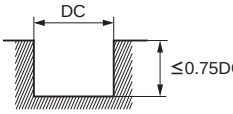
Note 1) Water-soluble cutting fluid is recommended.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Climb cutting is recommended for side milling.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

Using a high-speed and high-rigidity machining center

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	30000	11000	19000	5400
12	30000	12000	16000	5300
16	24000	12000	12000	4900
18	21000	12000	10500	4700
20	19000	11000	9500	4600
22	17000	11000	8500	4300
25	15000	11000	7500	4300
Depth of cut	 DC:Dia.			

■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
10	30000	8600	19000	4300
12	30000	9900	16000	4300
16	24000	9700	12000	4000
18	21000	9500	10500	3800
20	19000	9100	9500	3700
22	17000	8700	8500	3400
25	15000	8600	7500	3400
Depth of cut	 DC:Dia.			

Note 1) Water-soluble cutting fluid is recommended.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Climb cutting is recommended for side milling.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

CMRA

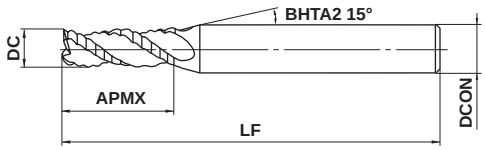
Roughing end mill, Medium cut length, 3 flute, For aluminium alloy

TOOL NEWS

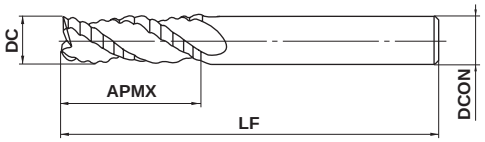
UWC

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

h6

DCON=6	8≤DCON≤10	12≤DCON≤16	20≤DCON≤25
0 - 0.008	0 - 0.009	0 - 0.011	0 - 0.013

●3 flute uncoated end mill for roughing aluminium alloy.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
CMRAD0300	3	8	50	6	3	●	1
CMRAD0400	4	11	50	6	3	●	1
CMRAD0500	5	13	50	6	3	●	1
CMRAD0600	6	13	50	6	3	●	2
CMRAD0800	8	19	60	8	3	●	2
CMRAD1000	10	22	75	10	3	●	2
CMRAD1200	12	26	75	12	3	●	2
CMRAD1600	16	32	100	16	3	●	2
CMRAD2000	20	38	125	20	3	●	2
CMRAD2500	25	45	125	25	3	●	2

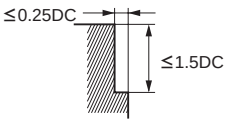
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	40000	2700	25000	1100
4	36000	2700	20000	1100
5	30000	5400	16000	2200
6	27000	6100	13000	2300
8	20000	6000	10000	2400
10	16000	5800	8000	2300
12	13000	5300	6500	2100
16	10000	5100	5000	2000
20	8000	4800	4000	1900
25	6400	4600	3200	1800

Depth of cut

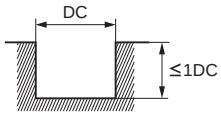


DC:Dia.

■Slotting

Work Material	Aluminium alloy		Aluminium alloy casting	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	30000	1800	16000	700
4	24000	2200	12000	900
5	19000	2300	10000	900
6	16000	2400	8000	1000
8	12000	2500	6000	1000
10	9500	2600	5000	1100
12	8000	2300	4000	900
16	6000	2100	3000	800
20	4800	2000	2400	800
25	3800	2000	1900	700

DCepth of cut



DC:Dia.

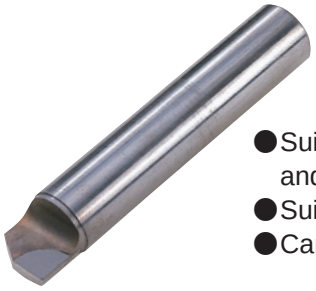
Note 1) Water-soluble cutting fluid is recommended.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Climb cutting is recommended for side milling.
Note 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
Note 5) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.

GBE

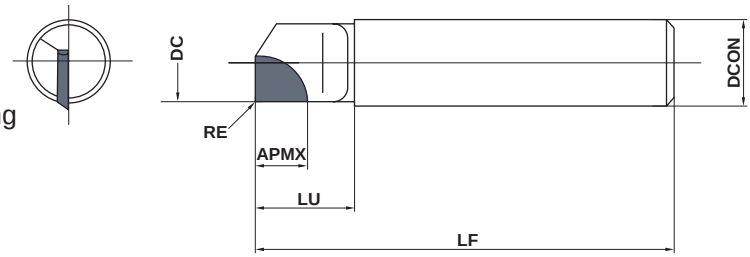
CBN end mill, Single flute

0°

Light Alloy	Cast Iron	Carbon Steel • Alloy Steel	Stainless Steel	Hardened Steel
				◎



- Suitable for shoulder milling and die machining.
- Suitable for re-grinding.
- Carbide shank.



Right hand tool holder only.

Order Number	Number of Flutes	Stock	Dimensions (mm)					
		MB730	DC	RE	LF	DCON	LU	APMX
GBE06S0640	1	●	6	0.5	40	6	8	3.5
GBE08S0845	1	●	8	0.5	45	8	13	6
GBE10S1050	1	●	10	0.5	50	10	13	6
GBE12S1255	1	●	12	0.5	55	12	13	6

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
H	Hardened Steel	45–68HRC	MB730	140 (80–200)	0.08 (0.02–0.15)	≤0.5
	Hardened Steel	45–68HRC	MB730	100 (60–150)	0.06 (0.02–0.10)	≤0.5

● : Inventory maintained in Japan.

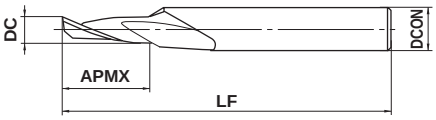
Memo

1MA

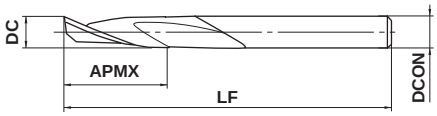
End mill, Medium cut length, 1 flute

HSS 25°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

3≤DC≤8				
0 - 0.050				

●Single flute end mill for aluminium channel and wood working.

(mm)

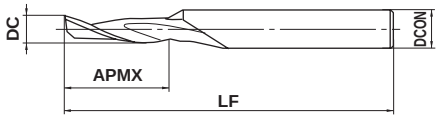
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
1MAD0300	3	10	60	8	1	●	1
1MAD0400	4	12	60	8	1	●	1
1MAD0500	5	15	65	8	1	●	1
1MAD0600	6	15	65	8	1	●	1
1MAD0800	8	20	75	8	1	●	2

● : Inventory maintained in Japan.

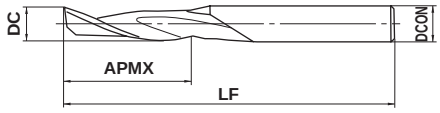
1LA

End mill, Long cut length, 1 flute

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



Type1



Type2

4≤DC≤12				
0 - 0.050				

●Single flute end mill with longer cut length and overall length than standard for deeper machining.

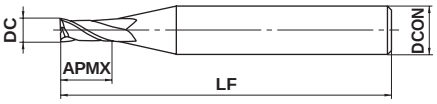
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
1LAD0400	4	18	70	8	1	●	1
1LAD0500	5	20	70	8	1	●	1
1LAD0600	6	20	70	8	1	●	1
1LAD0800	8	30	80	8	1	●	2
1LAD1000	10	35	90	10	1	●	2
1LAD1200	12	45	100	12	1	●	2

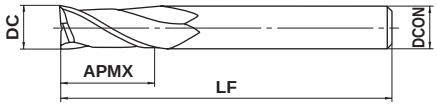
VA2SS

End mill, Short cut length, 2 flute

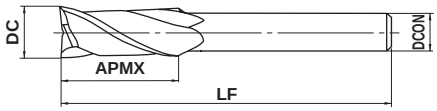
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		



Type1



Type2



Type3

3≤DC≤20				
0 / - 0.030				

●2 flute end mill with high grade HSS substrate and Violet coating for general use.

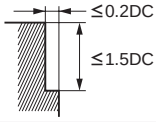
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VA2SSD0300	3	8	50	6	2	●	1
VA2SSD0400	4	8	60	8	2	●	1
VA2SSD0500	5	10	60	8	2	●	1
VA2SSD0600	6	12	60	8	2	●	1
VA2SSD0700	7	15	65	10	2	●	1
VA2SSD0800	8	15	65	10	2	●	1
VA2SSD0900	9	20	75	10	2	●	1
VA2SSD1000	10	20	75	12	2	●	1
VA2SSD1100	11	22	85	12	2	●	1
VA2SSD1200	12	22	85	12	2	●	2
VA2SSD1300	13	26	90	12	2	●	3
VA2SSD1400	14	26	95	16	2	●	1
VA2SSD1500	15	30	100	16	2	●	1
VA2SSD1600	16	32	100	16	2	●	2
VA2SSD1700	17	34	100	16	2	●	3
VA2SSD1800	18	34	100	16	2	●	3
VA2SSD1900	19	38	120	20	2	●	1
VA2SSD2000	20	38	120	20	2	●	2

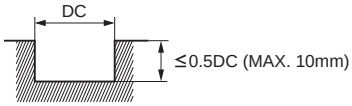
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	5400	170	4000	125	2700	85	2200	65
4	4300	200	3200	150	2100	100	1800	75
5	3600	210	2700	160	1800	105	1500	80
6	3200	220	2400	165	1600	110	1300	85
8	2400	240	1800	180	1200	120	1000	90
10	1900	260	1400	190	950	130	800	100
12	1600	240	1200	180	800	120	660	90
16	1200	210	900	160	600	105	500	80
20	950	180	720	135	480	90	400	70
25	760	150	570	115	380	75	320	60
30	640	130	480	100	320	65	270	50
40	470	100	350	75	240	50	200	40
Depth of cut	 DC:Dia.							

■Slotting

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	3700	110	3000	95	2100	65	1600	50
4	3200	140	2800	130	1800	75	1400	60
5	2900	160	2400	145	1500	80	1200	60
6	2600	170	2100	150	1300	85	1000	70
8	2000	190	1600	160	1000	90	800	70
10	1600	210	1300	180	800	100	640	80
12	1300	190	1100	165	660	90	530	70
16	1000	170	800	140	500	80	400	65
20	720	130	640	120	400	70	320	55
25	570	110	450	90	320	60	230	40
30	480	90	370	75	270	50	190	35
40	360	70	280	60	200	40	140	25
Depth of cut	 DC:Dia.							

Note 1) Supply cutting fluid sufficiently during slotting. When dry cut, slotting decrease the revolution and feed rate by 20−30% proportionately.
Note 2) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

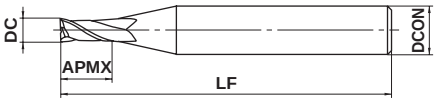
VA2MS

End mill, Medium cut length, 2 flute

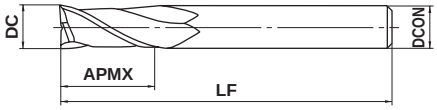
30°

DC<3 DC≥3

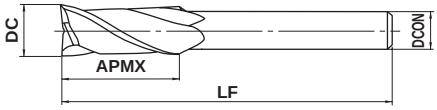
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		



Type1



Type2



Type3

DC≤20	DC>20			
0 - 0.030	0 - 0.040			

●2 flute end mill with high grade HSS substrate and Violet coating for general use.

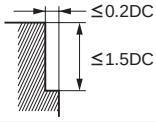
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VA2MSD0300	3	10	50	6	2	●	1
VA2MSD0400	4	12	60	8	2	●	1
VA2MSD0500	5	15	60	8	2	●	1
VA2MSD0600	6	15	60	8	2	●	1
VA2MSD0700	7	20	65	10	2	●	1
VA2MSD0800	8	20	65	10	2	●	1
VA2MSD0900	9	25	75	10	2	●	1
VA2MSD1000	10	25	75	10	2	●	2
VA2MSD1100	11	30	85	12	2	●	1
VA2MSD1200	12	30	85	12	2	●	2
VA2MSD1300	13	35	90	12	2	●	3
VA2MSD1400	14	35	95	16	2	●	1
VA2MSD1500	15	40	100	16	2	●	1
VA2MSD1600	16	40	100	16	2	●	2
VA2MSD1700	17	40	100	16	2	●	3
VA2MSD1800	18	40	100	16	2	●	3
VA2MSD1900	19	45	120	20	2	●	1
VA2MSD2000	20	45	120	20	2	●	2
VA2MSD2200	22	45	120	20	2	●	3
VA2MSD2400	24	50	140	25	2	●	1
VA2MSD2500	25	50	140	25	2	●	2
VA2MSD2600	26	50	140	25	2	●	3
VA2MSD2800	28	55	145	25	2	●	3
VA2MSD3000	30	55	145	25	2	●	3
VA2MSD3200	32	60	160	32	2	●	2
VA2MSD3500	35	60	160	32	2	●	3
VA2MSD4000	40	65	165	32	2	●	3

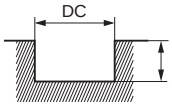
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	5400	170	4000	125	2700	85	2200	65
4	4300	200	3200	150	2100	100	1800	75
5	3600	210	2700	160	1800	105	1500	80
6	3200	220	2400	165	1600	110	1300	85
8	2400	240	1800	180	1200	120	1000	90
10	1900	260	1400	190	950	130	800	100
12	1600	240	1200	180	800	120	660	90
16	1200	210	900	160	600	105	500	80
20	950	180	720	135	480	90	400	70
25	760	150	570	115	380	75	320	60
30	640	130	480	100	320	65	270	50
40	470	100	350	75	240	50	200	40
Depth of cut	 DC:Dia.							

■Slotting

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	3700	110	3000	95	2100	65	1600	50
4	3200	140	2800	130	1800	75	1400	60
5	2900	160	2400	145	1500	80	1200	60
6	2600	170	2100	150	1300	85	1000	70
8	2000	190	1600	160	1000	90	800	70
10	1600	210	1300	180	800	100	640	80
12	1300	190	1100	165	660	90	530	70
16	1000	170	800	140	500	80	400	65
20	720	130	640	120	400	70	320	55
25	570	110	450	90	320	60	230	40
30	480	90	370	75	270	50	190	35
40	360	70	280	60	200	40	140	25
Depth of cut	 DC:Dia.							

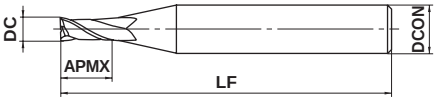
Note 1) Supply cutting fluid sufficiently during slotting. When dry cut, slotting decrease the revolution and feed rate by 20−30% proportionately.
Note 2) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

2SS

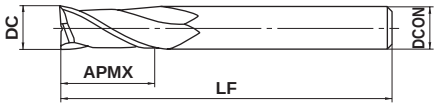
End mill, Short cut length, 2 flute

CO HSS 30° DC<3 DC≥3

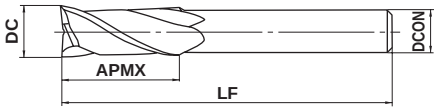
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

DC≤3	DC>3			
0 - 0.020	0 - 0.030			

●2 flute HSS end mill with rigid design.

(mm)

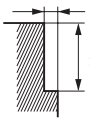
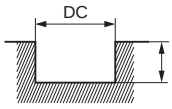
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2SSD0050	0.5	0.8	50	6	2	●	1
2SSD0100	1	2	50	6	2	●	1
2SSD0150	1.5	3.5	50	6	2	●	1
2SSD0200	2	5	50	6	2	●	1
2SSD0250	2.5	6	50	6	2	●	1
2SSD0300	3	8	50	6	2	●	1
2SSD0350	3.5	8	60	8	2	●	1
2SSD0400	4	8	60	8	2	●	1
2SSD0450	4.5	10	60	8	2	●	1
2SSD0500	5	10	60	8	2	●	1
2SSD0550	5.5	12	60	8	2	●	1
2SSD0600	6	12	60	8	2	●	1
2SSD0650	6.5	15	65	10	2	●	1
2SSD0700	7	15	65	10	2	●	1
2SSD0750	7.5	15	65	10	2	●	1
2SSD0800	8	15	65	10	2	●	1
2SSD0850	8.5	20	75	10	2	●	1
2SSD0900	9	20	75	10	2	●	1
2SSD0950S10	9.5	20	75	10	2	●	1
2SSD0950S12	9.5	20	75	12	2	●	1
2SSD1000S10	10	20	75	10	2	●	2
2SSD1000S12	10	20	75	12	2	●	1
2SSD1050	10.5	22	85	12	2	●	1
2SSD1100	11	22	85	12	2	●	1
2SSD1150	11.5	22	85	12	2	●	1
2SSD1200	12	22	85	12	2	●	2
2SSD1250	12.5	26	90	12	2	●	3
2SSD1300	13	26	90	12	2	●	3
2SSD1350	13.5	26	90	16	2	●	1
2SSD1400	14	26	90	16	2	●	1
2SSD1450	14.5	26	100	16	2	●	1
2SSD1500	15	30	100	16	2	●	1
2SSD1550	15.5	32	100	16	2	●	1
2SSD1600	16	32	100	16	2	●	2

● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2SSD1650	16.5	32	100	16	2	●	3
2SSD1700	17	34	100	16	2	●	3
2SSD1750	17.5	34	100	16	2	●	3
2SSD1800	18	34	100	16	2	●	3
2SSD1850	18.5	38	115	20	2	●	1
2SSD1900	19	38	115	20	2	●	1
2SSD1950	19.5	38	115	20	2	●	1
2SSD2000	20	38	115	20	2	●	2

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural steel, Carbon steel AISI 1045, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13		Austenitic stainless steel AISI 304, AISI 316		Cast iron AISI No 35 B		Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
0.5	8000	60 (50)	7000	40 (35)	4500	30 (25)	3500	25 (20)	7500	65 (55)	16000	120 (100)
1	5300	80 (65)	4200	50 (40)	3000	35 (30)	2400	27 (22)	4500	85 (70)	11000	170 (140)
2	3100	85 (70)	2600	60 (50)	1800	50 (40)	1400	30 (25)	2700	90 (75)	6800	190 (150)
3	2300	90 (75)	1800	65 (55)	1400	55 (45)	1100	35 (30)	2000	95 (80)	4800	240 (190)
4	1800	100 (85)	1400	70 (60)	1100	55 (45)	850	35 (30)	1600	110 (90)	3800	310 (250)
5	1600	110 (95)	1200	90 (75)	900	60 (50)	710	40 (35)	1300	120 (100)	3200	360 (290)
6	1400	120 (100)	1000	90 (75)	780	65 (55)	610	50 (40)	1100	130 (110)	2800	400 (320)
8	1100	130 (110)	800	95 (80)	580	65 (55)	470	50 (40)	850	140 (120)	2200	460 (370)
10	860	140 (120)	640	100 (80)	470	65 (55)	380	55 (45)	700	160 (130)	1800	440 (350)
12	720	130 (110)	530	95 (80)	390	60 (50)	310	50 (40)	580	140 (120)	1600	420 (340)
16	540	110 (95)	400	85 (70)	300	55 (45)	230	40 (35)	440	120 (100)	1200	350 (280)
20	430	100 (80)	320	70 (60)	240	45 (38)	190	35 (30)	350	100 (85)	960	300 (240)
Depth of cut	≤0.1DC (DC≤ϕ3) ≤0.2DC (DC>ϕ3)  ≤1.5DC								 DC ≤0.1DC (DC<ϕ2) ≤0.3DC (ϕ2≤DC≤ϕ3) ≤0.5DC (DC>ϕ3)					DC:Dia.		

( ) : Indicates standard feed rate for slotting.

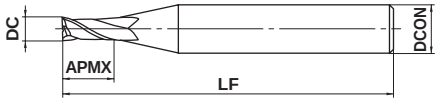
Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

2MS

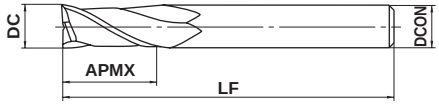
End mill, Medium cut length, 2 flute

CO HSS 30° DC<3 DC≥3

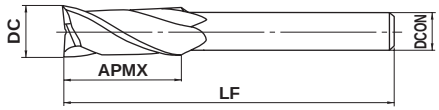
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

DC≤3	3<DC≤20	DC>20		
0 - 0.020	0 - 0.030	0 - 0.040		

●2 flute end mill with high grade HSS substrate for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2MSD0100	1	3	50	6	2	●	1
2MSD0150	1.5	4.5	50	6	2	●	1
2MSD0200	2	6	50	6	2	●	1
2MSD0250	2.5	7.5	50	6	2	●	1
2MSD0300	3	10	50	6	2	●	1
2MSD0350	3.5	12	50	6	2	●	1
2MSD0400	4	12	50	6	2	●	1
2MSD0450	4.5	15	55	6	2	●	1
2MSD0500	5	15	55	6	2	●	1
2MSD0550	5.5	15	55	6	2	●	1
2MSD0600	6	15	55	6	2	●	2
2MSD0650	6.5	20	65	8	2	●	1
2MSD0700	7	20	65	8	2	●	1
2MSD0750	7.5	20	65	8	2	●	1
2MSD0800	8	20	65	8	2	●	2
2MSD0850	8.5	25	75	10	2	●	1
2MSD0900	9	25	75	10	2	●	1
2MSD0950	9.5	25	75	10	2	●	1
2MSD1000	10	25	75	10	2	●	2
2MSD1100	11	30	85	12	2	●	1
2MSD1200	12	30	85	12	2	●	2
2MSD1300	13	35	90	12	2	●	3
2MSD1400	14	35	95	16	2	●	1
2MSD1500	15	40	100	16	2	●	1
2MSD1600	16	40	100	16	2	●	2
2MSD1700	17	40	100	16	2	●	3
2MSD1800	18	40	100	16	2	●	3
2MSD1900	19	45	115	20	2	●	1
2MSD2000	20	45	115	20	2	●	2
2MSD2100	21	45	115	20	2	●	3
2MSD2200	22	45	115	20	2	●	3
2MSD2300	23	50	120	25	2	●	1
2MSD2400	24	50	120	25	2	●	1
2MSD2500	25	50	120	25	2	●	2

● : Inventory maintained in Japan.

(mm)

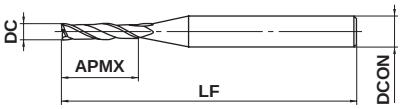
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2MSD2600	26	50	120	25	2	●	3
2MSD2700	27	55	125	25	2	●	3
2MSD2800	28	55	125	25	2	●	3
2MSD2900	29	55	125	25	2	●	3
2MSD3000	30	55	125	25	2	●	3
2MSD3100	31	60	145	25	2	●	3
2MSD3200	32	60	145	32	2	●	2
2MSD3300	33	60	145	32	2	●	3
2MSD3400	34	60	145	32	2	●	3
2MSD3500	35	60	145	32	2	●	3
2MSD3600	36	65	150	32	2	●	3
2MSD3700	37	65	150	32	2	●	3
2MSD3800	38	65	150	32	2	●	3
2MSD3900	39	65	150	32	2	●	3
2MSD4000	40	65	150	32	2	●	3
2MSD4100	41	70	155	32	2	●	3
2MSD4200S32	42	70	155	32	2	●	3
2MSD4200S42	42	70	155	42	2	●	2
2MSD4500S32	45	70	155	32	2	●	3
2MSD4500S42	45	70	155	42	2	●	3
2MSD4600S32	46	70	155	32	2	●	3
2MSD4600S42	46	70	155	42	2	●	3
2MSD5000S32	50	70	155	32	2	●	3
2MSD5000S42	50	70	155	42	2	●	3
2MSD5500	55	80	175	42	2	●	3
2MSD6000	60	85	185	42	2	●	3

2LS

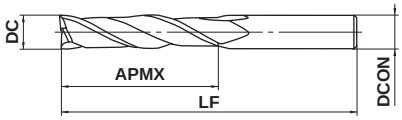
End mill, Long cut length, 2 flute

CO HSS 30° DC<3 DC≥3

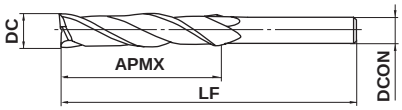
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

DC≤3	3<DC≤20	DC>20		
0 - 0.020	0 - 0.030	0 - 0.040		

●2 flute end mill with high grade HSS substrate for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2LSD0100	1	6	50	6	2	●	1
2LSD0150	1.5	7.5	50	6	2	●	1
2LSD0200	2	10	55	6	2	●	1
2LSD0250	2.5	15	55	6	2	●	1
2LSD0300	3	15	55	6	2	●	1
2LSD0350	3.5	15	55	6	2	●	1
2LSD0400	4	20	55	6	2	●	1
2LSD0450	4.5	20	55	6	2	●	1
2LSD0500	5	25	60	6	2	●	1
2LSD0550	5.5	25	60	6	2	●	1
2LSD0600	6	25	60	6	2	●	2
2LSD0650	6.5	35	75	8	2	●	1
2LSD0700	7	35	75	8	2	●	1
2LSD0750	7.5	35	75	8	2	●	1
2LSD0800	8	35	75	8	2	●	2
2LSD0850	8.5	35	75	10	2	●	1
2LSD0900	9	45	90	10	2	●	1
2LSD0950	9.5	45	90	10	2	●	1
2LSD1000	10	45	90	10	2	●	2
2LSD1050	10.5	55	105	12	2	●	1
2LSD1100	11	55	105	12	2	●	1
2LSD1150	11.5	55	105	12	2	●	1
2LSD1200	12	55	105	12	2	●	2
2LSD1250	12.5	55	105	12	2	●	3
2LSD1300	13	55	105	12	2	●	3
2LSD1350	13.5	55	110	16	2	●	1
2LSD1400	14	55	110	16	2	●	1
2LSD1450	14.5	65	120	16	2	●	1
2LSD1500	15	65	120	16	2	●	1
2LSD1550	15.5	65	120	16	2	●	1
2LSD1600	16	65	120	16	2	●	2
2LSD1650	16.5	65	120	16	2	●	3
2LSD1700	17	65	120	16	2	●	3
2LSD1750	17.5	65	120	16	2	●	3

● : Inventory maintained in Japan.

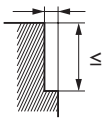
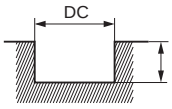
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2LSD1800	18	65	120	16	2	●	3
2LSD1850	18.5	75	140	20	2	●	1
2LSD1900	19	75	140	20	2	●	1
2LSD1950	19.5	75	140	20	2	●	1
2LSD2000	20	75	140	20	2	●	2
2LSD2100	21	75	140	20	2	●	3
2LSD2200	22	75	140	20	2	●	3
2LSD2300	23	90	160	25	2	●	1
2LSD2400	24	90	160	25	2	●	1
2LSD2500	25	90	160	25	2	●	2
2LSD2600	26	90	160	25	2	●	3
2LSD2700	27	90	160	25	2	●	3
2LSD2800	28	90	160	25	2	●	3
2LSD2900	29	90	160	25	2	●	3
2LSD3000	30	90	160	25	2	●	3
2LSD3100	31	95	180	25	2	●	3
2LSD3200	32	95	180	32	2	●	2
2LSD3300	33	95	180	32	2	●	3
2LSD3400	34	100	185	32	2	●	3
2LSD3500	35	100	185	32	2	●	3
2LSD3600	36	105	190	32	2	●	3
2LSD3700	37	105	190	32	2	●	3
2LSD3800	38	105	190	32	2	●	3
2LSD3900	39	110	195	32	2	●	3
2LSD4000	40	110	195	32	2	●	3

2MS
End mill, Medium cut length, 2 flute

2LS
End mill, Long cut length, 2 flute

RECOMMENDED CUTTING CONDITIONS(2MS)

Work Material	Structural steel, Carbon steel AISI 1045, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13		Austenitic stainless steel AISI 304, AISI 316		Cast iron AISI No 35 B		Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	5300	65 (50)	4200	40 (30)	3000	30 (25)	2400	22 (18)	4500	70 (55)	11000	140 (110)
2	3100	70 (55)	2600	50 (40)	1800	40 (30)	1400	25 (20)	2700	75 (60)	6800	160 (130)
3	2300	75 (60)	1800	55 (45)	1400	45 (35)	1100	30 (25)	2000	80 (65)	4800	200 (160)
4	1800	85 (70)	1400	60 (50)	1100	45 (35)	850	30 (25)	1600	90 (70)	3800	260 (210)
5	1600	95 (75)	1200	75 (60)	900	50 (40)	710	35 (25)	1300	100 (80)	3200	300 (240)
6	1400	100 (80)	1000	75 (60)	780	55 (45)	610	40 (30)	1100	110 (90)	2800	330 (260)
8	1100	110 (90)	800	80 (65)	580	55 (45)	470	40 (30)	850	115 (90)	2200	380 (300)
10	860	120 (95)	640	85 (70)	470	55 (45)	380	45 (35)	700	130 (105)	1800	360 (290)
12	720	110 (90)	530	80 (65)	390	50 (40)	310	40 (30)	580	115 (90)	1600	350 (280)
16	540	95 (75)	400	75 (60)	300	45 (35)	230	35 (28)	440	100 (80)	1200	290 (230)
20	430	80 (65)	320	60 (50)	240	38 (30)	190	30 (25)	350	85 (70)	960	250 (200)
25	350	70 (55)	250	50 (40)	190	32 (25)	150	25 (20)	285	75 (60)	760	220 (180)
30	290	65 (50)	210	45 (35)	160	28 (22)	120	22 (18)	240	70 (55)	640	200 (160)
40	210	50 (40)	150	30 (25)	120	22 (18)	90	18 (15)	180	55 (45)	480	160 (130)
50	160	40 (30)	115	28 (22)	90	20 (15)	70	15 (12)	140	45 (35)	380	130 (105)
60	130	35 (28)	95	25 (20)	75	18 (15)	55	12 (10)	115	40 (30)	310	110 (90)
Depth of cut	≤0.1DC (DC≤φ3) ≤0.2DC (DC>φ3)  ≤1.5DC						 ≤0.1DC (DC<φ2) ≤0.3DC (φ2≤DC≤φ3) ≤0.5DC (DC>φ3)				DC:Dia.	

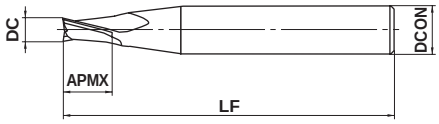
( ) : Indicates standard feed rate for slotting.

Note 1) Decrease the revolution by 20−30% and the feed rate by 40−50% for 2LS.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

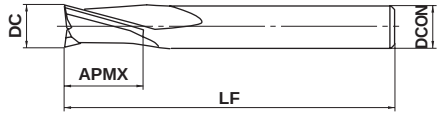
2MK

End mill, Short cut length, 2 flute, For key ways

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○			○



Type1



Type2

2MKP	2MKN	2MKNN		
+ 0.02 0	0 - 0.02	- 0.02 - 0.04		

●2 flute end mill for NN (JIS) standards and plus or minus tolerance diameters.

(mm)

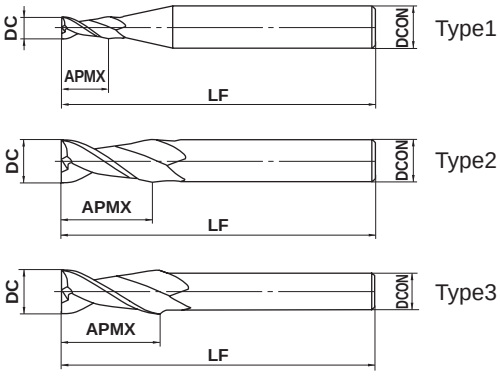
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
2MKPD0300	3	5	50	6	2	●	1
2MKPD0400	4	6	60	8	2	●	1
2MKPD0500	5	8	60	8	2	●	1
2MKPD0600	6	8	60	8	2	●	1
2MKPD0700	7	10	65	10	2	●	1
2MKPD0800	8	10	65	10	2	●	1
2MKPD1000	10	15	75	12	2	●	1
2MKPD1200	12	18	75	12	2	●	2
2MKPD1500	15	22	75	16	2	●	1
2MKPD1800	18	22	80	20	2	●	1
2MKPD2000	20	22	85	20	2	●	2
2MKNND0300	3	5	50	6	2	●	1
2MKNND0400	4	6	60	8	2	●	1
2MKNND0500	5	8	60	8	2	●	1
2MKNND0600	6	8	60	8	2	●	1
2MKNND0700	7	10	65	10	2	●	1
2MKNND0800	8	10	65	10	2	●	1
2MKNND1000	10	15	75	12	2	●	1
2MKNND1200	12	18	75	12	2	●	2
2MKNND1500	15	22	75	16	2	●	1
2MKNND1800	18	22	80	20	2	●	1
2MKNND2000	20	22	85	20	2	●	2
2MKND0300	3	5	50	6	2	●	1
2MKND0400	4	6	60	8	2	●	1
2MKND0500	5	8	60	8	2	●	1
2MKND0600	6	8	60	8	2	●	1
2MKND0700	7	10	65	10	2	●	1
2MKND0800	8	10	65	10	2	●	1
2MKND1000	10	15	75	12	2	●	1
2MKND1200	12	18	75	12	2	●	2
2MKND1500	15	22	75	16	2	●	1

● : Inventory maintained in Japan.

S2SDA

End mill, Short cut length, 2 flute, For aluminium alloy

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						○	◎



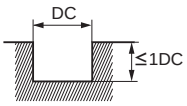
DC=3	DC>3			
0 - 0.020	0 - 0.030			

●2 flute end mill for aluminium alloy and soft materials.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
S2SDAD0300	3	8	50	6	2	●	1
S2SDAD0400	4	8	60	8	2	●	1
S2SDAD0500	5	10	60	8	2	●	1
S2SDAD0600	6	12	60	8	2	●	1
S2SDAD0800	8	15	65	10	2	●	1
S2SDAD1000	10	20	75	10	2	●	2
S2SDAD1200	12	22	85	12	2	●	2
S2SDAD1400	14	26	90	16	2	●	1
S2SDAD1600	16	32	100	16	2	●	2
S2SDAD1800	18	34	100	16	2	●	3
S2SDAD2000	20	38	115	20	2	●	2

RECOMMENDED CUTTING CONDITIONS

Work Material	Cast aluminium, Rolled aluminium, Magnesium alloy resin AC, ADC, A5052, A7075	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
3	8200	410
4	6500	530
6	4800	680
8	3800	780
10	3200	750
12	2700	710
16	2000	600
20	1600	510
Depth of cut	 DC:Dia.	

Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

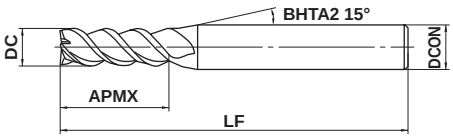
● : **Inventory maintained in Japan.**

VAMH

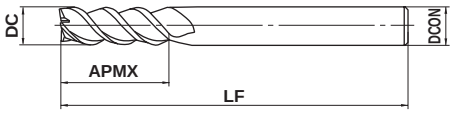
End mill, Medium cut length, 2—4 flute

45° DC=5 50° DC≥6 DC=5 DC≤20 DC≥21

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	○		



Type1



Type2

5≤DC≤30				
0 - 0.040				

●2—4 flute end mill with high grade HSS substrate and Violet coating for general use.

(mm)

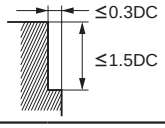
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VAMHD0500	5	12	65	8	2	●	1
VAMHD0600	6	15	65	8	3	●	1
VAMHD0700	7	20	75	10	3	●	1
VAMHD0800	8	20	75	10	3	●	1
VAMHD0900	9	25	90	10	3	●	1
VAMHD1000	10	25	90	12	3	●	1
VAMHD1100	11	30	95	12	3	●	1
VAMHD1200	12	30	95	12	3	●	2
VAMHD1300	13	35	105	16	3	●	1
VAMHD1400	14	35	105	16	3	●	1
VAMHD1500	15	40	115	16	3	●	1
VAMHD1600	16	40	115	16	3	●	2
VAMHD1800	18	40	125	20	3	●	1
VAMHD2000	20	45	130	20	3	●	2
VAMHD2100	21	45	135	25	4	●	1
VAMHD2200	22	45	135	25	4	●	1
VAMHD2300	23	50	140	25	4	●	1
VAMHD2400	24	50	140	25	4	●	1
VAMHD2500	25	50	140	25	4	●	2
VAMHD2800	28	55	150	32	4	●	1
VAMHD3000	30	55	150	32	4	●	1

VAMH

End mill, Medium cut length, 2—4 flute

RECOMMENDED CUTTING CONDITIONS

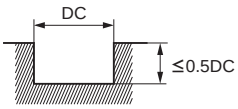
■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20—30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30—35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35—40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	3600	140	2700	100	1800	70	1500	60
6	3200	200	2400	150	1600	100	1300	80
8	2400	220	1800	160	1200	110	1000	90
10	1900	230	1400	170	960	120	800	100
12	1600	240	1200	180	800	120	660	100
16	1200	220	900	160	600	110	500	90
20	950	200	720	150	480	100	400	85
25	760	220	570	170	380	110	320	95
30	640	200	480	150	320	100	270	85
Depth of cut	 DC:Dia.							

Note 1) Supply cutting fluid sufficiently during slotting. When slotting with dry cut, decrease the revolution and feed rate proportionately by 20—30%.

Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

Slotting

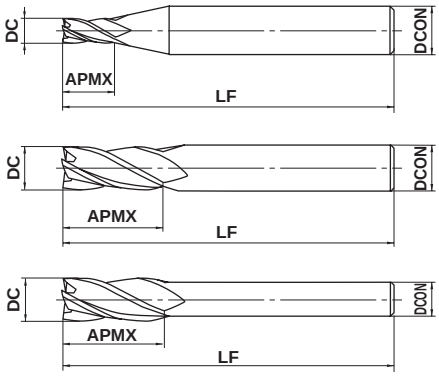
Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	2900	105	2400	75	1500	50	1200	45
6	2600	150	2100	110	1300	75	1000	60
8	2000	165	1600	120	1000	80	800	70
10	1600	170	1300	130	800	90	640	75
12	1300	180	1100	135	660	90	530	75
16	1000	165	800	120	500	80	400	70
20	720	150	640	110	400	75	320	65
25	570	165	450	130	320	80	230	70
30	480	150	370	110	270	75	190	65
Depth of cut	 DC:Dia.							

Note 1) Supply cutting fluid sufficiently during slotting. When slotting with dry cut, decrease the revolution and feed rate proportionately by 20−30%.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VA4MC

End mill, Medium cut length, 4 flute

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		



DC≤20	DC>20			
0 / + 0.030	0 / + 0.040			

●4 flute end mill with high grade HSS substrate and Violet coating for general use.

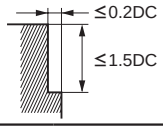
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VA4MCD0300	3	10	50	6	4	●	1
VA4MCD0400	4	12	60	8	4	●	1
VA4MCD0500	5	15	60	8	4	●	1
VA4MCD0600	6	15	60	8	4	●	1
VA4MCD0700	7	20	65	10	4	●	1
VA4MCD0800	8	20	65	10	4	●	1
VA4MCD0900	9	25	75	10	4	●	1
VA4MCD1000	10	25	75	10	4	●	2
VA4MCD1100	11	30	85	12	4	●	1
VA4MCD1200	12	30	85	12	4	●	2
VA4MCD1300	13	35	90	12	4	●	3
VA4MCD1400	14	35	95	16	4	●	1
VA4MCD1500	15	40	100	16	4	●	1
VA4MCD1600	16	40	100	16	4	●	2
VA4MCD1700	17	40	100	16	4	●	3
VA4MCD1800	18	40	100	16	4	●	3
VA4MCD1900	19	45	115	20	4	●	1
VA4MCD2000	20	45	115	20	4	●	2
VA4MCD2200	22	45	115	20	4	●	3
VA4MCD2400	24	50	120	25	4	●	1
VA4MCD2500	25	50	120	25	4	●	2
VA4MCD2800	28	55	125	25	4	●	3
VA4MCD3000	30	55	125	25	4	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	5400	270	4000	200	2700	140	2200	100
4	4300	320	3200	240	2100	160	1800	120
5	3600	340	2700	250	1800	170	1500	130
6	3200	350	2400	260	1600	180	1300	140
8	2400	380	1800	290	1200	190	1000	145
10	1900	420	1400	300	950	210	800	160
12	1600	380	1200	290	800	190	660	145
16	1200	340	900	260	600	170	500	130
20	950	290	720	220	480	140	400	110
25	760	240	570	180	380	120	320	100
30	640	210	480	160	320	100	270	80
Depth of cut	 DC:Dia.							

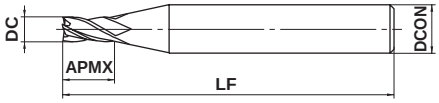
Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

4MC

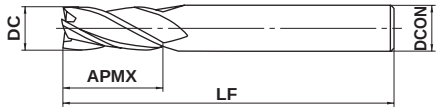
End mill, Medium cut length, 4 flute, Center cutting

CO HSS 30°

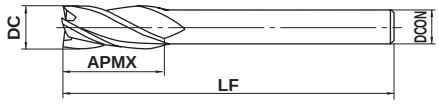
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

DC≤20	DC>20			
0 +0.020	0 +0.030			

●4 flute end mill for general use.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
4MCD0250	2.5	10	50	6	4	●	1
4MCD0300	3	10	50	6	4	●	1
4MCD0350	3.5	12	60	8	4	●	1
4MCD0400	4	12	60	8	4	●	1
4MCD0450	4.5	15	60	8	4	●	1
4MCD0500	5	15	60	8	4	●	1
4MCD0550	5.5	15	60	8	4	●	1
4MCD0600	6	15	60	8	4	●	1
4MCD0650	6.5	20	65	10	4	●	1
4MCD0700	7	20	65	10	4	●	1
4MCD0750	7.5	20	65	10	4	●	1
4MCD0800	8	20	65	10	4	●	1
4MCD0850	8.5	25	75	10	4	●	1
4MCD0900	9	25	75	10	4	●	1
4MCD0950	9.5	25	75	10	4	●	1
4MCD1000	10	25	75	10	4	●	2
4MCD1100	11	30	85	12	4	●	1
4MCD1200	12	30	85	12	4	●	2
4MCD1300	13	35	90	12	4	●	3
4MCD1400	14	35	95	16	4	●	1
4MCD1500	15	40	100	16	4	●	1
4MCD1600	16	40	100	16	4	●	2
4MCD1700	17	40	100	16	4	●	3
4MCD1800	18	40	100	16	4	●	3
4MCD1900	19	45	115	20	4	●	1
4MCD2000	20	45	115	20	4	●	2
4MCD2100	21	45	115	20	4	●	3
4MCD2200	22	45	115	20	4	●	3
4MCD2300	23	50	120	25	4	●	1
4MCD2400	24	50	120	25	4	●	1
4MCD2500	25	50	120	25	4	●	2
4MCD2600	26	50	120	25	4	●	3
4MCD2700	27	55	125	25	4	●	3
4MCD2800	28	55	125	25	4	●	3

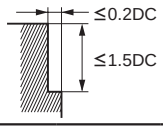
● : Inventory maintained in Japan.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
4MCD2900	29	55	125	25	4	●	3
4MCD3000	30	55	125	25	4	●	3
4MCD3100	31	60	145	25	4	●	3
4MCD3200	32	60	145	32	4	●	2
4MCD3300	33	60	145	32	4	●	3
4MCD3400	34	60	145	32	4	●	3
4MCD3500	35	60	145	32	4	●	3
4MCD3600	36	65	150	32	4	●	3
4MCD3700	37	65	150	32	4	●	3
4MCD3800	38	65	150	32	4	●	3
4MCD3900	39	65	150	32	4	●	3
4MCD4000	40	65	150	32	4	●	3

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Carbon steel AISI 1045, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13		Austenitic stainless steel AISI 304, AISI 316		Cast iron AISI No 35 B		Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	2300	105	1800	80	1400	65	1100	45	2000	110	4800	280
4	1800	120	1400	85	1100	65	850	45	1600	125	3800	370
5	1600	135	1200	105	900	70	710	50	1300	140	3200	420
6	1400	140	1000	105	780	80	610	55	1100	155	2800	460
8	1100	155	800	110	580	80	470	55	850	160	2200	530
10	860	170	640	120	470	80	380	65	700	180	1800	500
12	720	155	530	110	390	70	310	55	580	160	1600	490
16	540	135	400	105	300	65	230	50	440	140	1200	410
20	430	110	320	85	240	55	190	45	350	120	960	350
25	350	100	250	70	190	45	150	35	285	105	760	310
30	290	90	210	65	160	40	120	30	240	100	640	280
40	210	70	150	40	120	30	90	25	180	80	480	220
Depth of cut	 ≤0.2DC ≤1.5DC DC:Dia.											

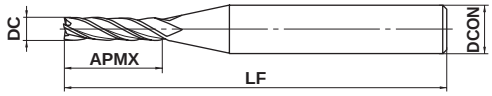
Note 1) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

4LC

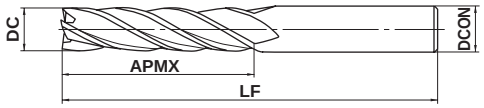
End mill, Long cut length, 4 flute, Center cutting

CO HSS γ 30°

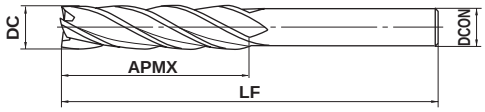
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

DC≤20	DC>20			
0 +0.020	0 +0.030			

●4 flute end mill with long flute for deep cutting applications.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
4LCD0300	3	15	55	6	4	●	1
4LCD0400	4	20	55	8	4	●	1
4LCD0500	5	25	60	8	4	●	1
4LCD0600	6	25	60	8	4	●	1
4LCD0700	7	35	75	10	4	●	1
4LCD0800	8	35	75	10	4	●	1
4LCD0900	9	45	90	10	4	●	1
4LCD1000	10	45	90	10	4	●	2
4LCD1100	11	55	105	12	4	●	1
4LCD1200	12	55	105	12	4	●	2
4LCD1300	13	55	105	12	4	●	3
4LCD1400	14	55	110	16	4	●	1
4LCD1500	15	65	120	16	4	●	1
4LCD1600	16	65	120	16	4	●	2
4LCD1700	17	65	120	16	4	●	3
4LCD1800	18	65	120	16	4	●	3
4LCD1900	19	75	140	20	4	●	1
4LCD2000	20	75	140	20	4	●	2
4LCD2100	21	75	140	20	4	●	3
4LCD2200	22	75	140	20	4	●	3
4LCD2300	23	90	160	25	4	●	1
4LCD2400	24	90	160	25	4	●	1
4LCD2500	25	90	160	25	4	●	2
4LCD2600	26	90	160	25	4	●	3
4LCD2700	27	90	160	25	4	●	3
4LCD2800	28	90	160	25	4	●	3
4LCD2900	29	90	160	25	4	●	3
4LCD3000	30	90	160	25	4	●	3
4LCD3100	31	95	180	25	4	●	3
4LCD3200	32	95	180	32	4	●	2
4LCD3300	33	95	180	32	4	●	3
4LCD3400	34	100	185	32	4	●	3
4LCD3500	35	100	185	32	4	●	3
4LCD3600	36	105	190	32	4	●	3

● : Inventory maintained in Japan.

(mm)

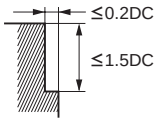
Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
4LCD3700	37	105	190	32	4	●	3
4LCD3800	38	105	190	32	4	●	3
4LCD3900	39	110	195	32	4	●	3
4LCD4000	40	110	195	32	4	●	3

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Carbon steel AISI 1045, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13		Austenitic stainless steel AISI 304, AISI 316		Cast iron AISI No 35 B		Aluminium alloy	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	2300	105	1800	80	1400	65	1100	45	2000	110	4800	280
4	1800	120	1400	85	1100	65	850	45	1600	125	3800	370
5	1600	135	1200	105	900	70	710	50	1300	140	3200	420
6	1400	140	1000	105	780	80	610	55	1100	155	2800	460
8	1100	155	800	110	580	80	470	55	850	160	2200	530
10	860	170	640	120	470	80	380	65	700	180	1800	500
12	720	155	530	110	390	70	310	55	580	160	1600	490
16	540	135	400	105	300	65	230	50	440	140	1200	410
20	430	110	320	85	240	55	190	45	350	120	960	350
25	350	100	250	70	190	45	150	35	285	105	760	310
30	290	90	210	65	160	40	120	30	240	100	640	280
40	210	70	150	40	120	30	90	25	180	80	480	220

Depth of cut



DC:Dia.

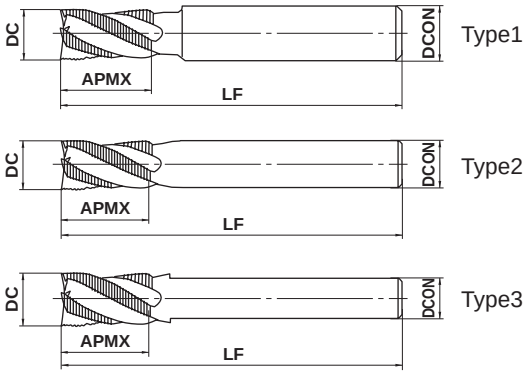
Note 1) Use the milling by reducing the revolution in the table shown above by 20−30% and the feedrate 40−50% to match the cutting type.
Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

VASFPR

Roughing end mill, Short cut length, 4—6 flute, Fine pitch form

KHA S V γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	○		



●Roughing 4—6 flute end mill with high grade HSS substrate and Violet coating for general use.

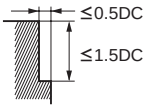
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VASFPRD0500	5	10	80	6	4	●	1
VASFPRD0600	6	12	80	6	4	●	2
VASFPRD0700	7	17	80	8	4	●	1
VASFPRD0800	8	17	85	8	4	●	2
VASFPRD0900	9	22	100	10	4	●	1
VASFPRD1000	10	22	100	10	4	●	2
VASFPRD1200	12	27	110	12	4	●	2
VASFPRD1400	14	27	110	12	4	●	3
VASFPRD1500	15	27	125	16	4	●	1
VASFPRD1600	16	33	125	16	4	●	2
VASFPRD1800	18	33	125	16	4	●	3
VASFPRD2000	20	38	145	20	4	●	2
VASFPRD2200	22	38	145	20	4	●	3
VASFPRD2400	24	43	150	25	4	●	1
VASFPRD2500	25	43	150	25	5	●	2
VASFPRD2800	28	43	160	25	5	●	3
VASFPRD3000	30	48	165	25	5	●	3
VASFPRD3200	32	55	175	25	5	●	3
VASFPRD3500	35	55	175	32	6	●	3
VASFPRD4000	40	65	185	32	6	●	3
VASFPRD4500	45	65	200	42	6	●	3
VASFPRD5000	50	75	200	42	6	●	3

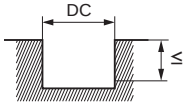
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	2800	140	2200	120	1500	80	1300	70
6	2600	180	2000	140	1400	90	1200	80
8	2200	230	1700	180	1200	130	990	100
10	1750	330	1350	250	950	160	800	130
12	1450	330	1100	260	800	180	660	140
16	1100	330	850	260	600	180	500	140
20	880	340	680	260	480	180	400	140
25	700	330	540	250	380	170	320	140
30	580	300	450	230	320	170	270	140
40	350	210	270	170	190	120	160	100
50	250	170	190	130	130	90	110	75
Depth of cut	 ≤0.5DC ≤1.5DC DC:Dia.							

■Slotting

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	2100	100	1650	80	1150	50	960	35
6	2000	130	1550	100	1050	60	900	45
8	1600	160	1300	130	920	90	760	60
10	1300	220	1000	175	730	110	610	80
12	1050	230	850	190	610	130	500	85
16	800	230	640	190	460	130	380	85
20	640	230	510	180	370	130	300	85
25	510	200	410	160	290	110	240	80
30	420	190	320	140	210	90	180	75
40	280	140	210	110	140	70	120	60
50	190	110	150	90	95	55	85	45
Depth of cut	 DC ≤1DC (MAX. 30mm) DC:Dia.							

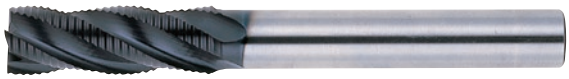
Note 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20−50%.
Note 2) For smaller depths and widths of cut, the revolution may be increased by 10−20% and the feed rate by 10−40%.
Note 3) When drilling, please set the feed rate at 1/3 or below of the values above.
Note 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

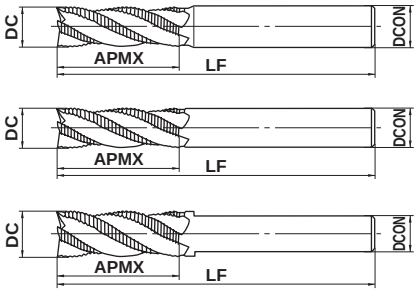
VAMFPR

Roughing end mill, Medium cut length, 4−6 flute, Fine pitch form

KHA S V γ 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	○		





●4−6 flute end mill with medium cut length.

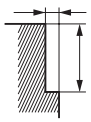
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VAMFPRD0500	5	15	80	6	4	●	1
VAMFPRD0600	6	17	80	6	4	●	2
VAMFPRD0700	7	22	80	8	4	●	1
VAMFPRD0800	8	28	85	8	4	●	2
VAMFPRD0900	9	28	95	10	4	●	1
VAMFPRD1000	10	34	100	10	4	●	2
VAMFPRD1200	12	40	110	12	4	●	2
VAMFPRD1400	14	40	110	12	4	●	3
VAMFPRD1500	15	40	120	16	4	●	1
VAMFPRD1600	16	48	125	16	4	●	2
VAMFPRD1800	18	48	125	16	4	●	3
VAMFPRD2000	20	57	145	20	4	●	2
VAMFPRD2200	22	57	145	20	5	●	3
VAMFPRD2400	24	68	150	25	5	●	1
VAMFPRD2500	25	68	150	25	5	●	2
VAMFPRD2800	28	68	160	25	5	●	3
VAMFPRD3000	30	68	165	25	6	●	3
VAMFPRD3200	32	80	175	32	6	●	2
VAMFPRD3500	35	80	175	32	6	●	3
VAMFPRD4000	40	94	185	32	6	●	3
VAMFPRD4500	45	94	200	42	6	●	3
VAMFPRD5000	50	113	200	42	6	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	2600	90	2000	70	1400	50	1200	40
6	2500	100	1900	90	1300	50	1100	50
8	2000	170	1600	130	1100	90	930	80
10	1650	220	1300	170	900	100	750	90
12	1400	260	1000	210	750	140	620	120
16	1000	290	800	230	560	160	470	130
20	830	300	640	230	450	160	380	130
25	660	290	510	220	360	160	300	130
30	550	270	420	210	300	140	250	130
40	330	180	250	140	180	100	150	90
50	240	160	180	120	120	80	100	70
Depth of cut	 ≤0.25DC (MAX. 10mm) ≤2.5DC (DC≤ϕ25) ≤2DC (DC>ϕ25) DC:Dia.							

Note 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20−50%.
Note 2) When the diameter exceeds 30 and the metal removal is less than the quantity shown in the table, the revolution and feed rate may be increased proportionately by 10−40%.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

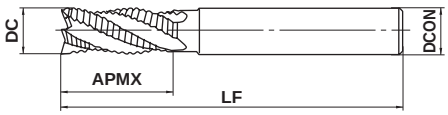
VAMR

Roughing end mill, Medium cut length, 4—6 flute

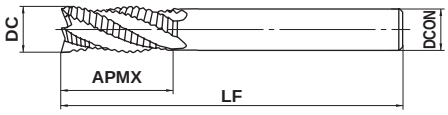
KHA S V γ 30°

DC≤15 16≤DC≤26 28≤DC≤32 DC≥35

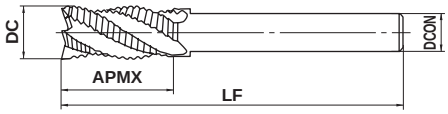
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	○		



Type1



Type2



Type3

●Roughing 4—6 flute end mill with high grade HSS substrate and Violet coating for general use.

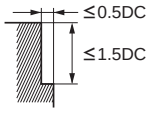
(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VAMRD0500	5	15	60	6	4	●	1
VAMRD0600	6	15	60	6	4	●	2
VAMRD0700	7	20	70	8	4	●	1
VAMRD0800	8	20	70	8	4	●	2
VAMRD0900	9	25	80	10	4	●	1
VAMRD1000	10	25	80	10	4	●	2
VAMRD1100	11	30	110	12	4	●	1
VAMRD1200	12	30	110	12	4	●	2
VAMRD1300	13	35	115	12	4	●	3
VAMRD1400	14	35	135	16	4	●	1
VAMRD1500	15	40	140	16	4	●	1
VAMRD1600	16	40	140	16	4	●	2
VAMRD1700	17	40	140	16	4	●	3
VAMRD1800	18	40	140	16	4	●	3
VAMRD1900	19	45	145	20	4	●	1
VAMRD2000	20	45	145	20	4	●	2
VAMRD2200	22	45	145	20	4	●	3
VAMRD2400	24	50	150	25	4	●	1
VAMRD2500	25	50	150	25	4	●	2
VAMRD2600	26	50	150	25	4	●	3
VAMRD2800	28	55	160	25	5	●	3
VAMRD3000	30	55	165	25	5	●	3
VAMRD3200	32	60	175	32	5	●	2
VAMRD3500	35	60	175	32	6	●	3
VAMRD4000	40	65	185	32	6	●	3
VAMRD4500	45	70	200	42	6	●	3
VAMRD5000	50	70	200	42	6	●	3

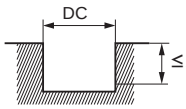
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■Side milling

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	2400	120	1800	90	1200	60	1000	50
6	2200	155	1700	120	1100	70	930	65
8	1800	200	1400	140	950	100	780	85
10	1500	250	1100	200	810	125	680	100
12	1250	270	960	220	680	160	560	120
16	930	270	720	220	510	160	430	120
20	750	290	580	220	410	160	340	120
25	600	270	460	210	320	140	270	120
30	490	250	380	200	270	140	230	120
40	300	180	230	140	160	105	140	90
50	210	140	160	110	110	80	90	65
Depth of cut	 DC:Dia.							

■Slotting

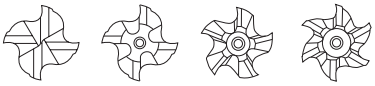
Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35−40HRC) AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	1800	85	1350	60	920	40	740	25
6	1700	110	1300	85	830	45	700	35
8	1300	140	1050	100	730	70	600	50
10	1100	170	810	140	620	85	520	60
12	900	190	740	160	520	115	420	75
16	680	190	540	160	390	115	330	75
20	550	195	440	150	320	115	260	75
25	440	170	350	135	240	90	200	70
30	350	160	270	120	180	75	155	65
40	240	120	180	90	120	60	105	55
50	260	90	125	75	80	50	70	40
Depth of cut	 DC:Dia.							

Note 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20−50%.
Note 2) When the diameter exceeds 30 and the metal removal is less than the quantity shown in the table, the revolution and feed rate may be increased proportionately by 10−40%.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

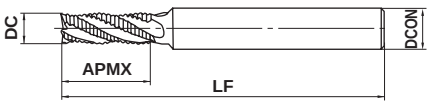
MR

Roughing end mill, Medium cut length, 4—6 flute

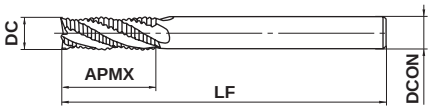
CO HSS γ 30°



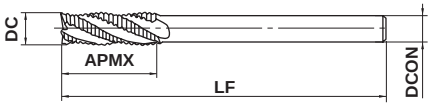
Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			○	○		○



Type1



Type2



Type3

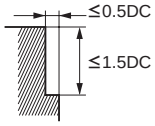
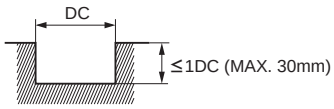
●4—6 flute roughing end mill with full radius cutting edge profile for heavy cutting.

(mm)

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
MRD0500	5	15	60	6	4	●	1
MRD0600	6	15	60	6	4	●	2
MRD0700	7	20	70	8	4	●	1
MRD0800	8	20	70	8	4	●	2
MRD0900	9	25	80	10	4	●	1
MRD1000	10	25	80	10	4	●	2
MRD1100	11	30	110	12	4	●	1
MRD1200	12	30	110	12	4	●	2
MRD1300	13	35	115	12	4	●	3
MRD1400	14	35	135	16	4	●	1
MRD1500	15	40	140	16	4	●	1
MRD1600	16	40	140	16	4	●	2
MRD1700	17	40	140	16	4	●	3
MRD1800	18	40	140	16	4	●	3
MRD1900	19	45	145	20	4	●	1
MRD2000	20	45	145	20	4	●	2
MRD2200	22	45	145	20	4	●	3
MRD2400	24	50	150	25	4	●	1
MRD2500	25	50	150	25	4	●	2
MRD2600	26	50	150	25	4	●	3
MRD2800	28	55	160	25	5	●	3
MRD3000S25	30	55	165	25	5	●	3
MRD3000S32	30	55	165	32	5	●	1
MRD3200	32	60	175	32	5	●	2
MRD3500	35	60	175	32	6	●	3
MRD4000S32	40	65	185	32	6	●	3
MRD4000S42	40	65	185	42	6	●	1
MRD4500	45	70	200	42	6	●	3
MRD5000	50	70	200	42	6	●	3

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20−30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30−35HRC) AISI H13, AISI D2		Austenitic stainless steel AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
5	1000 (750)	40 (30)	760 (570)	30 (25)	610 (460)	25 (20)	510 (380)	20 (15)
6	960 (720)	50 (40)	720 (540)	40 (30)	570 (430)	30 (25)	480 (360)	25 (20)
8	800 (600)	65 (50)	600 (450)	50 (40)	500 (380)	40 (30)	400 (300)	30 (25)
10	640 (480)	90 (70)	480 (360)	70 (55)	380 (290)	50 (40)	320 (240)	40 (30)
12	530 (400)	90 (70)	400 (300)	70 (55)	320 (240)	55 (40)	270 (200)	45 (35)
16	400 (300)	90 (70)	300 (230)	70 (55)	240 (180)	55 (40)	200 (150)	45 (35)
20	320 (240)	95 (70)	240 (180)	70 (55)	190 (140)	55 (40)	160 (120)	45 (35)
25	250 (190)	90 (70)	190 (140)	65 (50)	150 (110)	50 (40)	130 (100)	45 (35)
30	210 (160)	85 (65)	160 (120)	65 (50)	130 (100)	50 (40)	110 (85)	45 (35)
40	135 (100)	60 (45)	100 (75)	45 (40)	80 (60)	35 (26)	70 (55)	30 (25)
50	100 (75)	50 (40)	75 (55)	40 (30)	60 (45)	30 (23)	50 (40)	25 (20)
Depth of cut	  DC:Dia.							

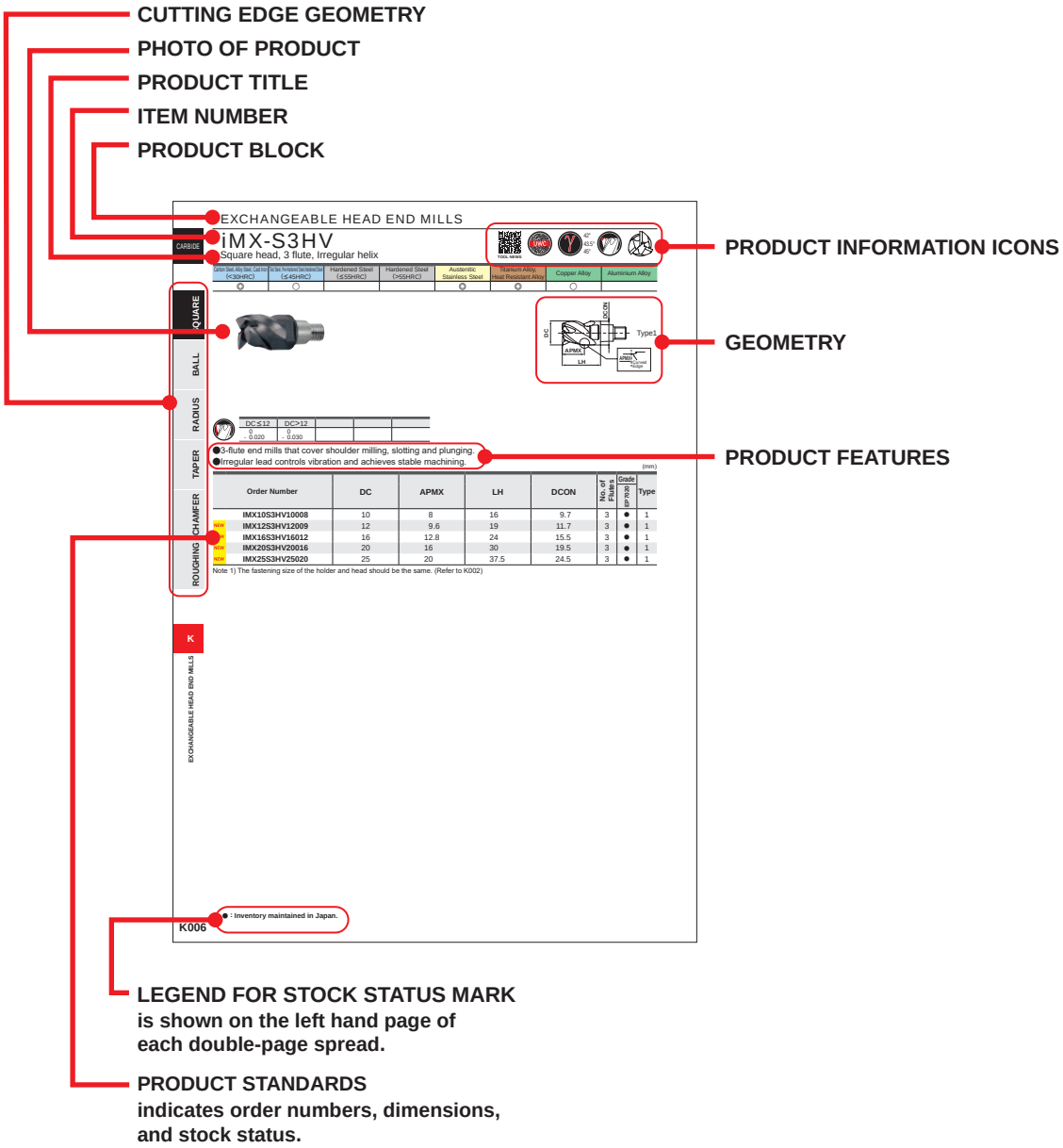
( ) : Indicates standard revolution and feed rate for slotting.

Note 1) Supply cutting fluid sufficiently during cutting.
Note 2) When the diameter exceeds 30 and the metal removal is less than the quantity shown in the table, the revolution and feed rate may be increased by 10−40%.
Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

HOW TO READ THE STANDARD OF EXCHANGEABLE HEAD END MILLS

●How this section page is organised

①Organised according to cutting mode for milling. (Refer to END MILL LIST.)



●To Order:
Please specify ①order number.

MILLING TOOLS

EXCHANGEABLE HEAD END MILLS

IDENTIFICATION K002
SYMBOL DESCRIPTIONS K003
CORRECTION FACTOR BY OVERHANG LENGTH (SHOULDER MILLING) K003
CLASSIFICATION K004

INDEXABLE HEAD END MILLS STANDARDS
- CARBIDE
  - SQUARE K006
  - ROUGHING K020
  - BALL K022
  - RADIUS K032
  - TAPER RADIUS K049
  - CHAMFER K050
- HOLDER
  - CARBIDE K054
  - STEEL K055

*Arranged by Alphabetical order

K022	**iMX-B2S**
K024	**iMX-B3FV**
K026	**iMX-B4HV**
K027	**iMX-B4HV-E**
K023	**iMX-B4S**
K030	**iMX-B6HV**
K046	**iMX-C3A**
K042	**iMX-C4FD-C**
K044	**iMX-C4FV**
K032	**iMX-C4HV**
K034	**iMX-C4HV-S**
K040	**iMX-C6HV**
K049	**iMX-C8T-C**
K040	**iMX-C10HV**
K049	**iMX-C10T-C**
K040	**iMX-C12HV**
K049	**iMX-C12T-C**
K049	**iMX-C15T-C**
K050	**iMX-CH3L**
K052	**iMX-CH6V**
K054	**iMX○○-○○○○○○○○L○○○C**
K055	**iMX○○-○○○○○○○○L○○○S**
K020	**iMX-R4F**
K017	**iMX-S3A**
K006	**iMX-S3HV**
K010	**iMX-S4HV**
K011	**iMX-S4HV-S**

IDENTIFICATION

iMX End Mill Series

■HEAD

② Basic Configurations

S	Square
C	Corner radius
B	Ball nose
R	Roughing
CH	Chamfer

④ Specifications

H	High Helix
V	Vibration Control
F	For High Efficiency Machining
S	For Finish Machining
A	For Aluminium Alloys
D	Duplex Corner Radius
F	Fine Pitch (Roughing)
T	Taper
L	Inclined

⑥ Corner R.

ex.
R050 → 0.5mm
R100 → 1mm

⑧ Coolant Hole

S	Peripheral(Side)
E	End
C	End cutting edge(Center)
None	Without hole

IMX12	C	4	HV	120	R100	12	S
①	②	③	④	⑤	⑥	⑦	⑧

① Series Description•Fastening Size

The fastening size of the holder should be the same.

③ No. of Flutes

ex.
4 → 4 flute

⑤ Dia.

ex.
120 → 12mm

⑦ Flute Length,Chamfer Angle

ex.
12 → 12.*mm
(Truncate Decimal Places)
A45 → Chamfer Angle 45°

■HOLDER

②

—

③ Figure

U	Undercut
S	Straight
G	Straight Oversize
A	1° Taper Neck

⑥ Overall Length

ex.
L080 → 80mm

IMX12	-	U	12	N017	L080	C
①	②	③	④	⑤	⑥	⑦

① Series Description•Fastening Size

The fastening size of the head should be the same.

④ Shank Diameter

ex.
12 → 12mm

⑤ Neck Length

ex.
N017 → 17.*mm
(Truncate decimal places)

⑦ Tool Material

C	Carbide
S	Steel

■RUN-OUT ACCURACY AND HEAD EXCHANGE ACCURACY

(mm)

Dia. DC	Run-out accuracy for the peripheral cutting edge *	Head exchange accuracy (Axial)
<ϕ25	0.015	±0.02
≥ϕ25	0.020	

* Use the carbide holder. (Except iMX-R4F roughing head)

SYMBOL DESCRIPTIONS

Tool Material

Ultra Micro Grain Carbide
Ultra micro grain carbide is used as the substrate material.

Angle, Coolant hole, Sharp corner edge and Gash land

Helix Angle
Indicates the helix angle of the end mill.

End Cutting Edge with Coolant Hole

Peripheral Cutting Edge with Coolant Hole

Sharp Corner Edge
Indicates the end mill has a sharp corner edge.

Gash Land
Indicates the end mill cutting edge has a gash land.

Tolerances

Outside Diameter Tolerance
Indicates diameter tolerance of end mill.

R Tolerance
Indicates the radial tolerance of a ball nose end mill.

R Tolerance
Indicates the radial tolerance of an end mill with a corner radius.

Tolerance of Point Angle
Indicates the tolerance of the point angle.

Shank Diameter Tolerance
Indicates the shank diameter tolerance of end mill.

Correction factor by overhang length (Shoulder Milling)

Use by multiplying the recommended cutting condition by the correction factor by overhang length.
Refer to each recommended condition for the long cutting and offset type.

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010				Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT				Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V			
L/D	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Width of Cut ae
2	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
3	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
4	80%	80%	90%	70%	80%	80%	90%	70%	80%	80%	90%	70%
5	60%	60%	80%	40%	60%	60%	80%	40%	60%	60%	80%	40%
6	50%	50%	70%	30%	50%	50%	70%	30%	50%	50%	70%	30%
7	40%	40%	70%	20%	40%	40%	70%	20%	30%	30%	60%	20%
8	40%	40%	60%	10%	40%	40%	60%	10%	30%	30%	50%	10%
9	30%	30%	60%	10%	30%	30%	60%	10%	20%	20%	50%	10%

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631				Heat resistant alloys Inconel718			
L/D	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Width of Cut ae
2	100%	100%	100%	100%	100%	100%	100%	100%
3	100%	100%	100%	100%	100%	100%	100%	100%
4	80%	80%	90%	70%	80%	80%	90%	70%
5	60%	60%	80%	40%	60%	60%	80%	40%
6	50%	50%	70%	30%	50%	50%	70%	30%
7	30%	30%	60%	20%	30%	30%	60%	20%
8	30%	30%	50%	10%	30%	30%	50%	10%
9	20%	20%	50%	10%	20%	20%	50%	10%

CLASSIFICATION

HEAD

(mm)

Type	Applications, Features	No. of Flutes	Product Code	Shape	Dia. DC	Coolant	Long Cutting Edge	Work Material P: Carbon Steel	P: Tool Steel	H: -55HRC	H: 55HRC-	M: Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
SQUARE																
	For Difficult-to-cut Materials	3	iMX-S3HV	Square head, 3 flute, Irregular helix	10—25			◎	○			◎	◎	○		K006
	For Difficult-to-cut Materials	4	iMX-S4HV	Square head, 4 flute, Irregular helix	10—32			◎	○			◎	◎	○		K010
	For Difficult-to-cut Materials	4	iMX-S4HV	Square head, 4 flute, Irregular helix, Long cutting edge type	16, 20		●	◎	○			◎	◎	○		K010
	For Difficult-to-cut Materials	4	iMX-S4HV-S	Square head with coolant hole, 4 flute, Irregular helix	10—25	●		◎	○			◎	◎	○		K011
	For Aluminium Alloys	3	iMX-S3A	Square head, 3 flute, For aluminium alloy	10—28										◎	K017
RADIUS																
	For Difficult-to-cut Materials	4	iMX-C4HV	Corner radius head, 4 flute, Irregular helix	10—28			◎	○			◎	◎	○		K032
	For Difficult-to-cut Materials	4	iMX-C4HV	Corner radius head, 4 flute, Irregular helix, Long cutting edge type	16, 20		●	◎	○			◎	◎	○		K033
	For Difficult-to-cut Materials	4	iMX-C4HV-S	Corner radius head, 4 flute, Irregular helix, With coolant hole	10—25	●		◎	○			◎	◎	○		K034
	For Difficult-to-cut Materials	6	iMX-C6HV	Corner radius head, Multi-flute, Irregular helix	10, 12			◎	○			◎	◎			K040
	For Difficult-to-cut Materials	10	iMX-C10HV		16			◎	○			◎	◎			K040
	For Difficult-to-cut Materials	12	iMX-C12HV		20, 25			◎	○			◎	◎			K040
	For High Feed Machining	4	iMX-C4FD-C	With coolant hole Multi-task corner radius end mill for high feed cutting	10—25	●		◎	◎	◎		◎	◎	○		K042
	For High Efficiency Machining	4	iMX-C4FV	Corner radius head for high efficiency machining, 4 flute, Irregular helix	10—25			◎	◎	◎						K044
	For Aluminium Alloys	3	iMX-C3A	Corner radius head, 3 flute, For aluminium alloy	10—28										◎	K046
	For Blade	8	iMX-C8T-C	Corner radius, Taper head, Multi-flute, With coolant hole	8	●						◎	◎			K049
	For Blade	10	iMX-C10T-C		10	●						◎	◎			K049
	For Blade	12	iMX-C12T-C		15, 19	●						◎	◎			K049
	For Blade	15	iMX-C15T-C		15, 19	●						◎	◎			K049

(mm)

Type	Applications, Features	No. of Flutes	Product Code	Shape	Dia. DC	Coolant	Long Cutting Edge	Work Material P: Carbon Steel	P: Tool Steel	H: -55HRC	H: 55HRC-	M: Stainless Steel	S: Titanium Alloy, Heat Resistant Alloy	N: Copper Alloy	N: Aluminium Alloy	Page
ROUGHING																
	For Difficult-to-cut Materials	4	iMX-R4F	Roughing head, 4 flute	10—25			◎	○			◎	◎	○		K020
BALL																
	For Hardened Steels	2	NEW iMX-B2S	Ball nose head, 2 flute, For hardened steels	16—20						◎					K022
		4	NEW iMX-B4S	Ball nose head, 4 flute, For hardened steels	16—20						◎					K023
	For High Efficiency Machining	3	NEW iMX-B3FV	Ball nose head, 3 flute, Irregular curve, For high efficiency machining	10—20				◎	◎						K024
	For Difficult-to-cut Materials	4	iMX-B4HV	Ball nose head, 4 flute, Irregular helix	10—25			◎	○			◎	◎	○		K026
		4	iMX-B4HV-E	Ball nose head with coolant hole, 4 flute, Irregular helix	10—25	●		◎	○			◎	◎	○		K027
		6	iMX-B6HV	Ball nose head, 6 flute, Irregular helix	10—25			◎	○			◎	◎			K030
CHAMFER																
	For Chamfer Materials	3	iMX-CH3L	Chamfer head, 3 flute	10—20			◎	○	○		◎	◎			K050
		6	iMX-CH6V	Chamfer head, 6 flute	12—20			◎	○	○		◎	◎			K052

HOLDERS

The undercut type is available in medium, semi-long, and long lengths.

Figure		Length	Taper angle one side	Tool material	Page
Undercut		Medium Semi-long Long	—	Carbide	K054
				Steel	K055
Straight	Straight	Semi-long Long	—	Carbide	K054
	Straight Oversize	Medium	—	Steel	K055
Taper neck		Long	1°	Carbide	K054

K

EXCHANGEABLE HEAD END MILLS

iMX-S3HV

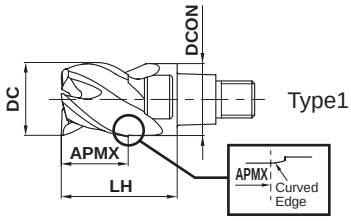
Square head, 3 flute, Irregular helix

TOOL NEWS

UWC

42°
43.5°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			

●3-flute end mills that cover shoulder milling, slotting and plunging.
●Irregular lead controls vibration and achieves stable machining.

(mm)

	Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX10S3HV10008	10	8	16	9.7	3	●	1
NEW	IMX12S3HV12009	12	9.6	19	11.7	3	●	1
NEW	IMX16S3HV16012	16	12.8	24	15.5	3	●	1
NEW	IMX20S3HV20016	20	16	30	19.5	3	●	1
NEW	IMX25S3HV25020	25	20	37.5	24.5	3	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

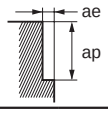
● : Inventory maintained in Japan.

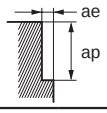
RECOMMENDED CUTTING CONDITIONS

■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	150	4800	0.09	1300	8	2	120	3800	0.06	680	8	2	100	3200	0.075	720	8	2
12	150	4000	0.09	1100	9.6	2.4	120	3200	0.065	620	9.6	2.4	100	2700	0.08	650	9.6	2.4
16	150	3000	0.1	900	12.8	3.2	120	2400	0.075	540	12.8	3.2	100	2000	0.09	540	12.8	3.2
20	150	2400	0.1	720	16	4	120	1900	0.075	430	16	4	100	1600	0.09	430	16	4
25	150	1900	0.12	680	20	5	120	1500	0.075	340	20	5	100	1300	0.09	350	20	5
Depth of cut																		

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	75	2400	0.06	430	8	2	40	1300	0.04	160	8	1
12	75	2000	0.065	390	9.6	2.4	40	1100	0.045	150	9.6	1.2
16	75	1500	0.075	340	12.8	3.2	40	800	0.05	120	12.8	1.6
20	75	1200	0.075	270	16	4	40	640	0.05	96	16	2
25	75	950	0.075	210	20	5	40	510	0.05	77	20	2.5
Depth of cut												

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-S3HV

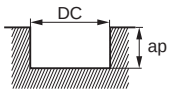
Square head, 3 flute, Irregular helix

■Slot milling

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	100	3200	0.04	380	5	80	2500	0.03	230	5	75	2400	0.03	200	5
12	100	2700	0.05	410	6	80	2100	0.04	250	6	75	2000	0.04	240	6
16	100	2000	0.07	420	8	80	1600	0.05	240	8	75	1500	0.06	270	8
20	100	1600	0.07	340	10	80	1300	0.05	200	10	75	1200	0.06	220	10
25	100	1300	0.08	310	12	80	1000	0.05	150	12	75	950	0.06	170	12

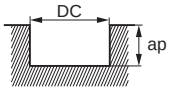
Depth of cut



DC:Dia.

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631					Heat resistant alloys Inconel718				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	60	1900	0.025	140	5	30	950	0.02	57	2
12	60	1600	0.035	170	6	30	800	0.03	72	2.4
16	60	1200	0.05	180	8	30	600	0.05	90	3.2
20	60	950	0.05	140	10	30	480	0.05	72	4
25	60	760	0.05	110	12	30	380	0.05	57	5

Depth of cut

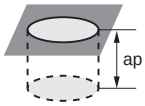


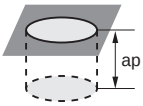
DC:Dia.

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

■Plunging

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2
10	100	3200	0.14	450	5	2.5	70	2200	0.09	200	5	2	60	1900	0.03	57	5	0.6
12	100	2700	0.14	380	6	2.5	70	1900	0.09	170	6	2	60	1600	0.03	48	6	0.6
16	100	2000	0.14	280	8	2.5	70	1400	0.09	130	8	2	60	1200	0.03	36	8	0.6
20	100	1600	0.14	220	10	2.5	70	1100	0.09	99	10	2	60	950	0.03	29	10	0.6
25	100	1300	0.14	180	12.5	2.5	70	890	0.09	80	12.5	2	60	760	0.03	23	12.5	0.6
Depth of cut																		

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2
10	40	1300	0.03	39	5	0.6
12	40	1100	0.03	33	6	0.6
16	40	800	0.03	24	8	0.6
20	40	640	0.03	19	10	0.6
25	40	510	0.03	15	12.5	0.6
Depth of cut						

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. If the depth of cut is shallow, the revolution and feed rate can be increased.

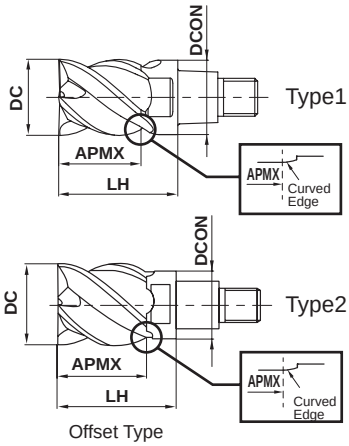
iMX-S4HV

Square head, 4 flute, Irregular helix

TOOL NEWS

42°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	

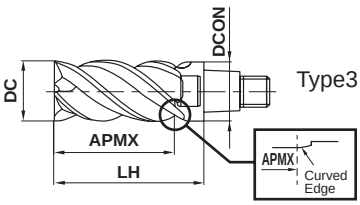


DC≤12	DC>12			
0 - 0.020	0 - 0.030			

● Irregular lead controls vibration and achieves stable machining.

(mm)

	Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX10S4HV10010	10	10	16	9.7	4	●	1
	IMX10S4HV12012	12	12.5	19	9.7	4	●	2
	IMX12S4HV12012	12	12	19	11.7	4	●	1
	IMX12S4HV14014	14	14.5	22.5	11.7	4	●	2
	IMX16S4HV16016	16	16	24	15.5	4	●	1
	IMX16S4HV18018	18	18.5	27	15.5	4	●	2
NEW	IMX20S4HV20020	20	20	30	19.5	4	●	1
	IMX20S4HV22023	22	23	33	19.5	4	●	2
NEW	IMX25S4HV25025	25	25	37.5	24.5	4	●	1
	IMX25S4HV28029	28	29	41.5	24.5	4	●	2
	IMX25S4HV30031	30	31	43.5	24.5	4	●	2
	IMX25S4HV32033	32	33	45.5	24.5	4	●	2



■ Long cutting edge type

(mm)

Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX16S4HV16032	16	32	40	15.5	4	●	3
IMX20S4HV20040	20	40	50	19.5	4	●	3

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

iMX-S4HV-S

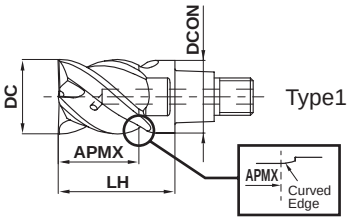
Square head with coolant hole, 4 flute, Irregular helix

TOOL NEWS

UWC

42°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- Coolant holes for each cutting edge enables a stable coolant supply.
- Irregular helix controls vibration and achieves stable machining.

(mm)

	Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX10S4HV10010S	10	10	16	9.7	4	●	1
	IMX12S4HV12012S	12	12	19	11.7	4	●	1
	IMX16S4HV16016S	16	16	24	15.5	4	●	1
NEW	**IMX20S4HV20020S**	20	20	30	19.5	4	●	1
NEW	**IMX25S4HV25025S**	25	25	37.5	24.5	4	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

iMX-S4HV/iMX-S4HV-S

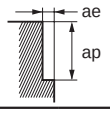
Square head, 4 flute, Irregular helix (With/Without coolant hole)

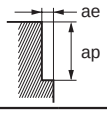
RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

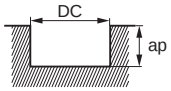
Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut 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
25	150	1900	0.12	910	25	5	120	1500	0.075	450	25	5	100	1300	0.09	470	25	5
Depth of cut																		

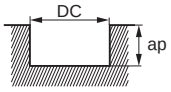
Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut 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
25	75	950	0.075	290	25	5	40	510	0.05	100	25	2.5
Depth of cut												

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

■ Slot milling

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	100	1300	0.08	420	12	80	1000	0.05	200	12	75	950	0.06	230	12
Depth of cut	 DC:Dia.														

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631					Heat resistant alloys Inconel718				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	60	760	0.05	150	12	30	380	0.05	76	5
Depth of cut	 DC:Dia.									

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

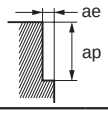
iMX-S4HV

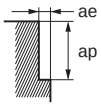
Square head, 4 flute, Irregular helix, Long cutting edge type

RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling

(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
4	16	100	2000	0.09	720	32	0.8	80	1600	0.07	450	32	0.8	60	1200	0.08	380	32	0.8
	20	100	1600	0.09	580	40	1	80	1300	0.07	360	40	1	60	950	0.08	300	40	1
6	16	60	1200	0.07	340	32	0.8	50	990	0.05	200	32	0.8	40	800	0.06	190	32	0.8
	20	60	950	0.07	270	40	1	50	800	0.05	160	40	1	40	640	0.06	150	40	1
Depth of cut																			

Work Material		Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
4	16	50	990	0.07	280	32	0.8	30	600	0.05	120	32	0.4
	20	50	800	0.07	220	40	1	30	480	0.05	96	40	0.5
6	16	30	600	0.05	120	32	0.8	20	400	0.04	64	32	0.4
	20	30	480	0.05	96	40	1	20	320	0.04	51	40	0.5
Depth of cut													

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) The length of the long cutting type is 2 times that of the standard head. L/D demonstrates +1 when installed to a holder of the same size.

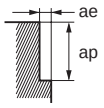
iMX-S4HV

Square head, 4 flute, Irregular helix, Offset type

RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling

(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	11	150	4300	0.09	1500	11	1.1	120	3500	0.06	840	11	1.1	100	2900	0.075	870	11	1.1
	12	150	4000	0.09	1400	12	1.2	120	3200	0.06	770	12	1.2	100	2700	0.075	810	12	1.2
	13	150	3700	0.09	1300	13	1.3	120	2900	0.065	750	13	1.3	100	2400	0.08	770	13	1.3
	14	150	3400	0.09	1200	14	1.4	120	2700	0.065	700	14	1.4	100	2300	0.08	740	14	1.4
	17	150	2800	0.1	1100	17	1.7	120	2200	0.075	660	17	1.7	100	1900	0.08	610	17	1.7
	18	150	2700	0.1	1100	18	1.8	120	2100	0.075	630	18	1.8	100	1800	0.09	650	18	1.8
	22	150	2200	0.1	880	22	2.2	120	1700	0.075	510	22	2.2	100	1400	0.09	500	22	2.2
	28	150	1700	0.12	820	28	2.8	120	1400	0.075	420	28	2.8	100	1100	0.09	400	28	2.8
	30	150	1600	0.12	770	30	3	120	1300	0.075	390	30	3	100	1100	0.09	400	30	3
	32	150	1500	0.12	720	32	3.2	120	1200	0.075	360	32	3.2	100	990	0.09	360	32	3.2
5	11	90	2600	0.07	730	11	0.4	70	2000	0.05	400	11	0.4	60	1700	0.06	410	11	0.4
	12	90	2400	0.07	670	12	0.5	70	1900	0.05	380	12	0.5	60	1600	0.06	380	12	0.5
	13	90	2200	0.07	620	13	0.5	70	1700	0.05	340	13	0.5	60	1500	0.06	360	13	0.5
	14	90	2000	0.07	560	14	0.6	70	1600	0.05	320	14	0.6	60	1400	0.06	340	14	0.6
	17	90	1700	0.08	540	17	0.7	70	1300	0.06	310	17	0.7	60	1100	0.07	310	17	0.7
	18	90	1600	0.08	510	18	0.7	70	1200	0.06	290	18	0.7	60	1100	0.07	310	18	0.7
	22	90	1300	0.08	420	22	0.9	70	1000	0.06	240	22	0.9	60	870	0.07	240	22	0.9
	28	90	1000	0.1	400	28	1.1	70	800	0.06	190	28	1.1	60	680	0.07	190	28	1.1
	30	90	950	0.1	380	30	1.2	70	740	0.06	180	30	1.2	60	640	0.07	180	30	1.2
	32	90	900	0.1	360	32	1.3	70	700	0.06	170	32	1.3	60	600	0.07	170	32	1.3
7	11	60	1700	0.06	410	11	0.2	50	1400	0.04	220	11	0.2	32	930	0.05	190	11	0.2
	12	60	1600	0.06	380	12	0.2	50	1300	0.04	210	12	0.2	32	850	0.05	170	12	0.2
	13	60	1500	0.06	360	13	0.3	50	1200	0.05	240	13	0.3	32	780	0.06	190	13	0.3
	14	60	1400	0.06	340	14	0.3	50	1100	0.05	220	14	0.3	32	730	0.06	180	14	0.3
	17	60	1100	0.07	310	17	0.3	50	940	0.05	190	17	0.3	32	600	0.06	140	17	0.3
	18	60	1100	0.07	310	18	0.4	50	880	0.05	180	18	0.4	32	570	0.06	140	18	0.4
	22	60	870	0.07	240	22	0.4	50	720	0.05	140	22	0.4	32	460	0.06	110	22	0.4
	28	60	680	0.08	220	28	0.6	50	570	0.05	110	28	0.6	32	360	0.06	86	28	0.6
	30	60	640	0.08	200	30	0.6	50	530	0.05	110	30	0.6	32	340	0.06	82	30	0.6
	32	60	600	0.08	190	32	0.6	50	500	0.05	100	32	0.6	32	320	0.06	77	32	0.6
Depth of cut																			

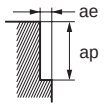
Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-S4HV

Square head, 4 flute, Irregular helix, Offset type

■ Shoulder milling

(mm)

Work Material		Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	11	75	2200	0.06	530	11	1.1	30	870	0.04	140	11	0.8
	12	75	2000	0.06	480	12	1.2	30	800	0.04	130	12	0.9
	13	75	1800	0.065	470	13	1.3	30	730	0.045	130	13	1
	14	75	1700	0.065	440	14	1.4	30	680	0.045	120	14	1.1
	17	75	1400	0.065	360	17	1.7	40	750	0.045	140	17	1.3
	18	75	1300	0.075	390	18	1.8	40	710	0.05	140	18	1.4
	22	75	1100	0.075	330	22	2.2	40	580	0.05	120	22	1.7
	28	75	850	0.075	260	28	2.8	40	450	0.05	90	28	2.1
	30	75	800	0.075	240	30	3	40	420	0.05	84	30	2.3
	32	75	750	0.075	230	32	3.2	40	400	0.05	80	32	2.4
5	11	50	1400	0.05	280	11	0.4	10	290	0.03	35	11	0.3
	12	50	1300	0.05	260	12	0.5	10	270	0.03	32	12	0.4
	13	50	1200	0.05	240	13	0.5	10	240	0.04	38	13	0.4
	14	50	1100	0.05	220	14	0.6	10	230	0.04	37	14	0.4
	17	50	940	0.06	230	17	0.7	19	360	0.04	58	17	0.5
	18	50	880	0.06	210	18	0.7	19	340	0.04	54	18	0.6
	22	50	720	0.06	170	22	0.9	19	270	0.04	43	22	0.7
	28	50	570	0.06	140	28	1.1	19	220	0.04	35	28	0.8
	30	50	530	0.06	130	30	1.2	19	200	0.04	32	30	0.9
	32	50	500	0.06	120	32	1.3	19	190	0.04	30	32	1
7	11	24	690	0.04	110	11	0.2	–	–	–	–	–	–
	12	24	640	0.04	100	12	0.2	–	–	–	–	–	–
	13	24	590	0.05	120	13	0.3	–	–	–	–	–	–
	14	24	550	0.05	110	14	0.3	–	–	–	–	–	–
	17	24	450	0.05	90	17	0.3	–	–	–	–	–	–
	18	24	420	0.05	84	18	0.4	–	–	–	–	–	–
	22	24	350	0.05	70	22	0.4	–	–	–	–	–	–
	28	24	270	0.05	54	28	0.6	–	–	–	–	–	–
	30	24	250	0.05	50	30	0.6	–	–	–	–	–	–
	32	24	240	0.05	48	32	0.6	–	–	–	–	–	–
Depth of cut													

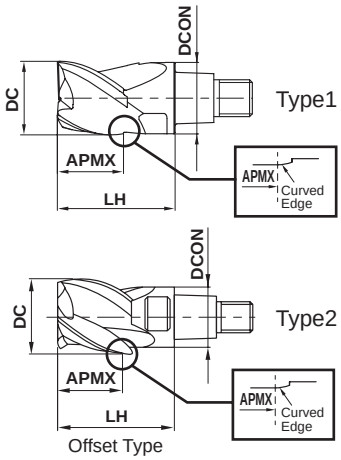
Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-S3A

Square head, 3 flute, For aluminium alloy

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎



DC≤12	DC>12			
0 - 0.020	0 - 0.030			

● High efficiency machining due to the sharp cutting edge suitable for aluminium alloy machining and polished rake face.

(mm)

	Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade ET2020	Type
	IMX10S3A10008	10	8	16	9.7	3	●	1
	IMX10S3A12010	12	10.1	19	9.7	3	●	2
NEW	IMX12S3A12009	12	9.6	19	11.7	3	●	1
	IMX12S3A14011	14	11.7	22.5	11.7	3	●	2
NEW	IMX16S3A16012	16	12.8	24	15.5	3	●	1
	IMX16S3A18014	18	14.9	27	15.5	3	●	2
NEW	IMX20S3A20016	20	16	30	19.5	3	●	1
	IMX20S3A22018	22	18.6	33	19.5	3	●	2
NEW	IMX25S3A25020	25	20	37.5	24.5	3	●	1
	IMX25S3A28023	28	23.4	41.5	24.5	3	●	2

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

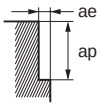
iMX-S3A

Square head, 3 flute, For aluminium alloy

RECOMMENDED CUTTING CONDITIONS

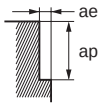
Shoulder milling (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	500	16000	0.117	5600	8	3
12	500	13000	0.118	4600	9.6	3.6
16	500	9900	0.153	4500	12.8	4.8
20	500	8000	0.175	4200	16	6
25	500	6400	0.211	4100	20	7.5
Depth of Cut						

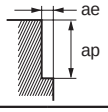
Shoulder milling (L/D=5)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	300	9500	0.09	2600	8	1.2
12	300	8000	0.09	2200	9.6	1.44
16	300	6000	0.12	2200	12.8	1.92
20	300	4800	0.14	2000	16	2.4
25	300	3800	0.17	1900	20	3
Depth of Cut						

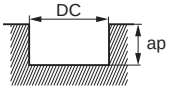
Shoulder milling (L/D=7)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	200	6400	0.08	1500	8	0.6
12	200	5300	0.08	1300	9.6	0.72
16	200	4000	0.11	1300	12.8	0.96
20	200	3200	0.12	1200	16	1.2
25	200	2500	0.15	1100	20	1.5
Depth of Cut						

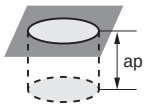
Slot milling (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075				
DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	500	16000	0.068	3300	5
12	500	13000	0.072	2800	6
16	500	9900	0.093	2800	8
20	500	8000	0.108	2600	10
25	500	6400	0.127	2400	12.5
Depth of Cut	 DC:Dia.				

Plunging (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075					
DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2
10	300	9500	0.1	950	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
25	300	3800	0.1	380	12.5	2.5
Depth of Cut						

Note 1) The use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or work material is low.
In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.

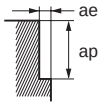
iMX-S3A

Square head, 3 flute, For aluminium alloy, Offset type

RECOMMENDED CUTTING CONDITIONS

■Side milling

(mm)

Work Material		Aluminium alloy A6061, A7075					
L/D	Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	12	500	13000	0.117	4600	9.6	2.4
	14	500	11000	0.118	3900	11.2	2.8
	18	500	8800	0.153	4000	14.4	3.6
	22	500	7200	0.175	3800	17.6	4.4
	28	500	5700	0.211	3600	22.4	5.6
5	12	300	8000	0.09	2200	9.6	1.0
	14	300	6800	0.09	1800	11.2	1.1
	18	300	5300	0.12	1900	14.4	1.4
	22	300	4300	0.14	1800	17.6	1.8
	28	300	3400	0.17	1700	22.4	2.2
Depth of cut							

Note 1) The use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or workpiece is low.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-R4F

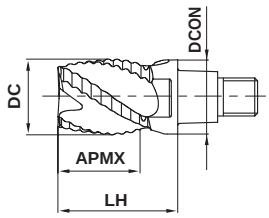
Roughing head, 4 flute

TOOL NEWS

UWC

35°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



Type1

●The roughing edge geometry reduces cutting resistance.
Effective when rigidity of the machine or work material is low.

(mm)

Order Number	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10R4F10010	10	10.5	16	9.7	4	●	1
IMX12R4F12012	12	12.5	19	11.7	4	●	1
IMX16R4F16016	16	16.5	24	15.5	4	●	1
IMX20R4F20021	20	21	30	19.5	4	●	1
IMX25R4F25026	25	26	37.5	24.5	4	●	1

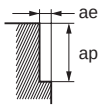
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

RECOMMENDED CUTTING CONDITIONS

■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	150	4800	0.045	860	8	4	120	3800	0.03	460	8	4	100	3200	0.038	490	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
25	150	1900	0.06	460	20	10	120	1500	0.038	230	20	10	100	1300	0.045	230	20	10
Depth of cut																		

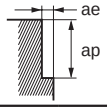
Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Vibration may occur if the rigidity of machine or workpiece is low.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

● : **Inventory maintained in Japan.**

■ Shoulder milling (L/D=3)

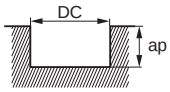
Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

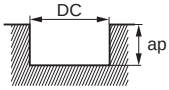
(mm)

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut 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
25	75	950	0.038	140	20	10	40	510	0.05	100	20	2.5
Depth of cut												

■ Slot milling

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	100	1300	0.06	310	12	80	1000	0.038	150	12	60	760	0.034	100	10
Depth of cut	 DC:Dia.														

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	40	510	0.027	55	10
Depth of cut	 DC:Dia.				

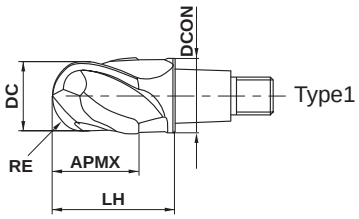
Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Vibration may occur if the rigidity of machine or workpiece is low.In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-B2S NEW

Ball nose head, 2 flute, For hardened steels

TOOL NEWS UWC 30°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
			◎				



RE≥8				
±0.020				

●Ideal for machining with long overhangs.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP8110	Type
IMX16B2S16016	8	16	16	24	15.5	2	●	1
IMX20B2S20020	10	20	20	30	19.5	2	●	1

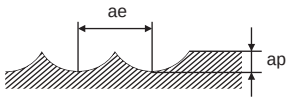
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

Recommended Cutting Conditions

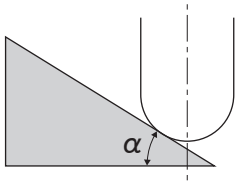
■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Hardened steels (55–65HRC) AISI D2									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
16	8	300	6000	0.14	1700	150	3000	0.08	480	0.3	1.6
20	10	300	4800	0.14	1300	150	2400	0.08	380	0.3	2
Depth of cut											

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) α is the inclination angle of the machined surface.



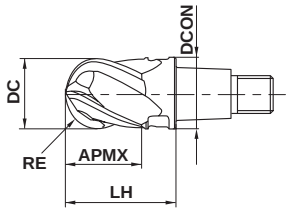
● : Inventory maintained in Japan.

iMX-B4S NEW

Ball nose head, 4 flute, For hardened steels

TOOL NEWS

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
			◎				



Type1

RE≥8				
±0.020				

●High efficiency machining is realized even with machining using the tip.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP8110	Type
IMX16B4S16016	8	16	16	24	15.5	4	●	1
IMX20B4S20020	10	20	20	30	19.5	4	●	1

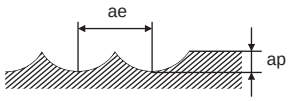
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

Recommended Cutting Conditions

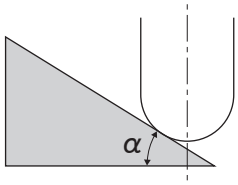
■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Hardened steels (55–65HRC) AISI D2									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
16	8	300	6000	0.07	1700	150	3000	0.06	720	0.3	1.6
20	10	300	4800	0.07	1300	150	2400	0.06	580	0.3	2
Depth of cut											

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) α is the inclination angle of the machined surface.

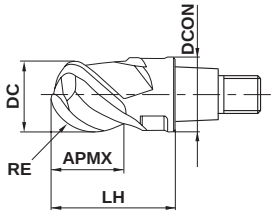


iMX-B3FV NEW

Ball nose head, 3 flute, Irregular curve, For high efficiency machining

TOOL NEWS UWC 45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
	◎	◎					



Type1

RE≤6	RE>6			
±0.010	±0.020			

- High efficiency machining is possible in deep engraving processing(DCx5)
- High wear resistance and high chip evacuation is achieved in roughing.
- High vibration control effect enables high efficiency machining in finishing.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP8120	Type
IMX10B3FV10008	5	10	8	16	9.7	3	●	1
IMX12B3FV12009	6	12	9.6	19	11.7	3	●	1
IMX16B3FV16012	8	16	12.8	24	15.5	3	●	1
IMX20B3FV20016	10	20	16	30	19.5	3	●	1

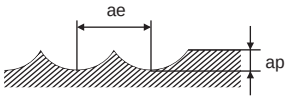
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

Recommended Cutting Conditions

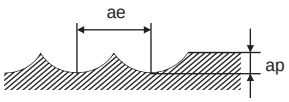
■Shoulder milling (L/D=5)

(mm)

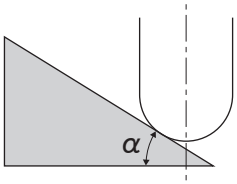
Work Material		Pre-hardened steels, Alloy tool steels										Hardened steels (40−55HRC)									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae	α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)			Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
10	5	175	5600	0.22	3700	115	3700	0.15	1700	0.7	2.6	150	4800	0.18	2600	100	3200	0.12	1200	0.5	2
12	6	175	4600	0.22	3000	115	3100	0.15	1400	1	3.2	150	4000	0.18	2200	100	2700	0.12	970	0.7	2.5
16	8	175	3500	0.22	2300	115	2300	0.15	1000	1.1	3.8	150	3000	0.18	1600	100	2000	0.12	720	0.9	3.5
20	10	175	2800	0.22	1800	115	1800	0.15	810	1.2	4.8	150	2400	0.18	1300	100	1600	0.12	580	1.1	4.2
Depth of Cut																					

■Shoulder milling (L/D=7)

(mm)

Work Material		Pre-hardened steels, Alloy tool steels AISI P21, AISI P20、AISI D2、AISI H13、AISI L6										Hardened steels (40−55HRC) AISI H13, AISI L6									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae	α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)			Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
10	5	120	3800	0.2	2300	80	2500	0.13	980	0.5	1.3	100	3200	0.13	1200	65	2100	0.085	540	0.4	1
12	6	120	3200	0.2	1900	80	2100	0.13	820	0.7	1.6	100	2700	0.13	1100	65	1700	0.085	430	0.6	1.3
16	8	120	2400	0.2	1400	80	1600	0.13	620	0.8	1.9	100	2000	0.13	780	65	1300	0.085	330	0.7	1.8
20	10	120	1900	0.2	1100	80	1300	0.13	510	0.9	2.4	100	1600	0.13	620	65	1000	0.085	260	0.8	2.1
Depth of Cut																					

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 3) α is the inclination angle of the machined surface.



iMX-B4HV

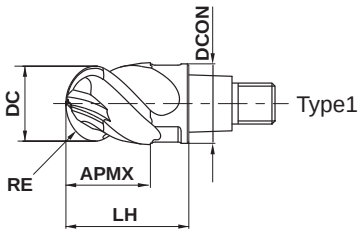
Ball nose head, 4 flute, Irregular helix

TOOL NEWS

UWC

45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



DC≤12	RE>6			
±0.010	±0.020			

DC≤12	DC>12			
0 - 0.020	0 - 0.030			

●Irregular curve cutting edge controls vibration and achieves stable machining.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10B4HV10010	5	10	10.5	16	9.7	4	●	1
IMX12B4HV12012	6	12	12.5	19	11.7	4	●	1
IMX16B4HV16016	8	16	16.5	24	15.5	4	●	1
IMX20B4HV20021	10	20	21	30	19.5	4	●	1
IMX25B4HV25026	12.5	25	26	37.5	24.5	4	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

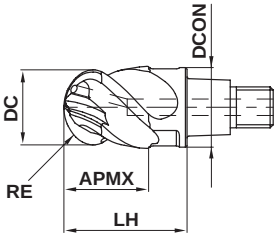
iMX-B4HV-E

Ball nose head with coolant hole, 4 flute, Irregular helix

TOOL NEWS

45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



Type1

DC≤12	RE>6			
±0.010	±0.020			

DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- Coolant holes for each cutting edge enable stable coolant supply.
- The variable curve cutting edge controls vibration and achieves stable machining of difficult-to-cut materials and for long overhang applications.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10B4HV10010E	5	10	10.5	16	9.7	4	●	1
IMX12B4HV12012E	6	12	12.5	19	11.7	4	●	1
IMX16B4HV16016E	8	16	16.5	24	15.5	4	●	1
IMX20B4HV20021E	10	20	21	30	19.5	4	●	1
IMX25B4HV25026E	12.5	25	26	37.5	24.5	4	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

iMX-B4HV/iMX-B4HV-E

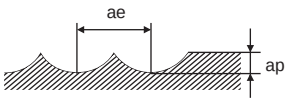
Ball nose head, 4 flute, Irregular helix (With/Without coolant hole)

RECOMMENDED CUTTING CONDITIONS

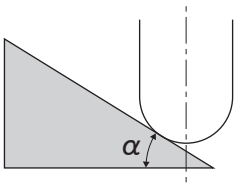
■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Pre-hardened steel AISI 1045, AISI 4140, AISI 4340, ASTM A36, AISI 1010, AISI P21, AISI P20										Austenitic stainless steel, Ferritic and Martensitic stainless steels, Cobalt chromium alloy, Titanium alloy AISI 304, AISI 316, AISI 431, AISI 420J2, AISI 630, AISI 631, Ti-6Al-4V									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae	α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)			Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
10	5	300	9500	0.106	4000	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
25	12.5	300	3800	0.16	2400	200	2500	0.1	1000	2.5	6	225	2900	0.16	1900	150	1900	0.105	800	2.5	6
Depth of cut																					

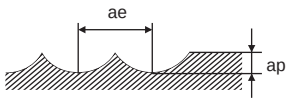
Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) α is the inclination angle of the machined surface.



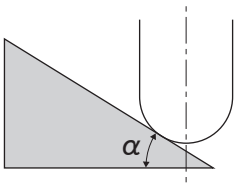
■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Heat resistant alloys Inconel718									
Inclination angle		α ≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia **DC**	Radius of Ball Nose **RE**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
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	950	0.062	240	40	640	0.04	100	1	2
25	12.5	60	760	0.062	190	40	510	0.04	82	1.2	2.5
Depth of cut											

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) α is the inclination angle of the machined surface.



iMX-B6HV

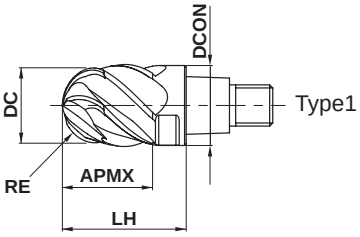
Ball nose head, 6 flute, Irregular helix

TOOL NEWS

UWC

45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎		



RE≤6	RE>6			
±0.010	±0.020			
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

● The variable curve cutting edge controls vibration and achieves stable machining of difficult-to-cut materials and for long overhang applications.

● 6 flutes enable high machining efficiency.

(mm)

Order Number	RE	DC	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10B6HV10010	5	10	10.5	16	9.7	6	●	1
IMX12B6HV12012	6	12	12.5	19	11.7	6	●	1
IMX16B6HV16016	8	16	16.5	24	15.5	6	●	1
IMX20B6HV20021	10	20	21	30	19.5	6	●	1
IMX25B6HV25026	12.5	25	26	37.5	24.5	6	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

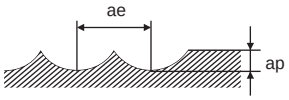
● : Inventory maintained in Japan.

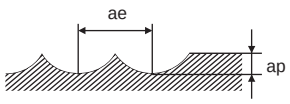
RECOMMENDED CUTTING CONDITIONS

■Shoulder milling (L/D=3)

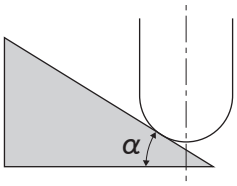
Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Pre-hardened steel AISI 1045, AISI 4140, AISI 4340, ASTM A36, AISI 1010, AISI P21, AISI P20										Austenitic stainless steel, Ferritic and Martensitic stainless steels, Cobalt chromium alloy, Titanium alloy AISI 304, AISI 316, AISI 431, AISI 420J2, AISI 630, AISI 631, Ti-6Al-4V									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae	α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)			Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
10	5	300	9500	0.106	6000	200	6400	0.07	2700	0.5	2	225	7200	0.105	4500	150	4800	0.067	1900	0.5	2
12	6	300	8000	0.125	6000	200	5300	0.085	2700	0.6	2.4	225	6000	0.125	4500	150	4000	0.08	1900	0.6	2.4
16	8	300	6000	0.134	4800	200	4000	0.088	2100	0.8	3.2	225	4500	0.14	3800	150	3000	0.09	1600	0.8	3.2
20	10	300	4800	0.156	4500	200	3200	0.1	1900	1	4	225	3600	0.16	3500	150	2400	0.105	1500	1	4
25	12.5	300	3800	0.16	3600	200	2500	0.1	1500	1.2	5	225	2900	0.16	2800	150	1900	0.105	1200	1.2	5
Depth of cut																					

Work Material		Heat resistant alloys Inconel718									
Inclination angle		α≤15°				α>15°				Depth of Cut ap	Width of Cut ae
Dia DC	Radius of Ball Nose RE	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)		
10	5	60	1900	0.055	630	40	1300	0.035	270	0.5	1
12	6	60	1600	0.055	530	40	1100	0.035	230	0.6	1.2
16	8	60	1200	0.062	450	40	800	0.04	190	0.8	1.6
20	10	60	950	0.062	350	40	640	0.04	150	1	2
25	12.5	60	760	0.062	280	40	510	0.04	120	1.2	2.5
Depth of cut											

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) α is the inclination angle of the machined surface.



iMX-C4HV

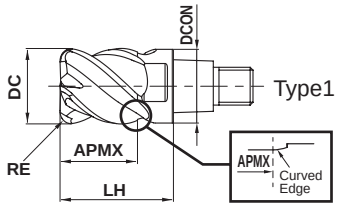
Corner radius head, 4 flute, Irregular helix

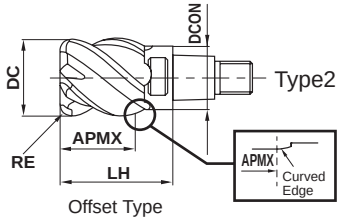
TOOL NEWS

UWC

42°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	





Offset Type

RE≤6.35				
±0.020				
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

●Irregular lead controls vibration and achieves stable machining.

(mm)

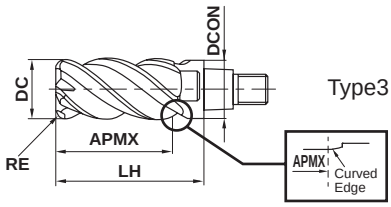
Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10C4HV100R03010	10	0.3	10	16	9.7	4	●	1
IMX10C4HV100R05010	10	0.5	10	16	9.7	4	●	1
IMX10C4HV100R10010	10	1	10	16	9.7	4	●	1
IMX10C4HV100R15010	10	1.5	10	16	9.7	4	●	1
IMX10C4HV100R20010	10	2	10	16	9.7	4	●	1
IMX10C4HV100R25010	10	2.5	10	16	9.7	4	●	1
IMX10C4HV100R30010	10	3	10	16	9.7	4	●	1
IMX10C4HV110R05011	11	0.5	11.5	18	9.7	4	●	2
IMX10C4HV110R10011	11	1	11.5	18	9.7	4	●	2
IMX10C4HV120R03012	12	0.3	12.5	19	9.7	4	●	2
IMX10C4HV120R05012	12	0.5	12.5	19	9.7	4	●	2
IMX10C4HV120R10012	12	1	12.5	19	9.7	4	●	2
IMX10C4HV120R20012	12	2	12.5	19	9.7	4	●	2
IMX12C4HV120R03012	12	0.3	12	19	11.7	4	●	1
IMX12C4HV120R05012	12	0.5	12	19	11.7	4	●	1
IMX12C4HV120R10012	12	1	12	19	11.7	4	●	1
IMX12C4HV120R15012	12	1.5	12	19	11.7	4	●	1
IMX12C4HV120R20012	12	2	12	19	11.7	4	●	1
IMX12C4HV120R25012	12	2.5	12	19	11.7	4	●	1
IMX12C4HV120R30012	12	3	12	19	11.7	4	●	1
IMX12C4HV120R40012	12	4	12	19	11.7	4	●	1
IMX12C4HV130R05013	13	0.5	13.5	21.5	11.7	4	●	2
IMX12C4HV130R10013	13	1	13.5	21.5	11.7	4	●	2
IMX12C4HV140R03014	14	0.3	14.5	22.5	11.7	4	●	2
IMX12C4HV140R05014	14	0.5	14.5	22.5	11.7	4	●	2
IMX12C4HV140R10014	14	1	14.5	22.5	11.7	4	●	2
IMX12C4HV140R20014	14	2	14.5	22.5	11.7	4	●	2
IMX16C4HV160R03016	16	0.3	16	24	15.5	4	●	1
IMX16C4HV160R05016	16	0.5	16	24	15.5	4	●	1
IMX16C4HV160R10016	16	1	16	24	15.5	4	●	1
IMX16C4HV160R15016	16	1.5	16	24	15.5	4	●	1
IMX16C4HV160R20016	16	2	16	24	15.5	4	●	1
IMX16C4HV160R25016	16	2.5	16	24	15.5	4	●	1
IMX16C4HV160R30016	16	3	16	24	15.5	4	●	1

● : Inventory maintained in Japan.

(mm)

	Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX16C4HV160R40016	16	4	16	24	15.5	4	●	1
	IMX16C4HV160R50016	16	5	16	24	15.5	4	●	1
	IMX16C4HV170R05017	17	0.5	17	26	15.5	4	●	2
	IMX16C4HV170R10017	17	1	17	26	15.5	4	●	2
	IMX16C4HV180R03018	18	0.3	18	27	15.5	4	●	2
	IMX16C4HV180R05018	18	0.5	18.5	27	15.5	4	●	2
	IMX16C4HV180R10018	18	1	18.5	27	15.5	4	●	2
	IMX16C4HV180R20018	18	2	18.5	27	15.5	4	●	2
	IMX16C4HV180R30018	18	3	18.5	27	15.5	4	●	2
	IMX20C4HV200R03020	20	0.3	20	30	19.5	4	●	1
NEW	IMX20C4HV200R05020	20	0.5	20	30	19.5	4	●	1
NEW	IMX20C4HV200R10020	20	1	20	30	19.5	4	●	1
NEW	IMX20C4HV200R15020	20	1.5	20	30	19.5	4	●	1
NEW	IMX20C4HV200R20020	20	2	20	30	19.5	4	●	1
NEW	IMX20C4HV200R25020	20	2.5	20	30	19.5	4	●	1
NEW	IMX20C4HV200R30020	20	3	20	30	19.5	4	●	1
NEW	IMX20C4HV200R40020	20	4	20	30	19.5	4	●	1
NEW	IMX20C4HV200R50020	20	5	20	30	19.5	4	●	1
	IMX20C4HV200R60020	20	6	20	30	19.5	4	●	1
NEW	IMX20C4HV200R63520	20	6.35	20	30	19.5	4	●	1
	IMX20C4HV220R05023	22	0.5	23	33	19.5	4	●	2
	IMX20C4HV220R10023	22	1	23	33	19.5	4	●	2
	IMX20C4HV220R20023	22	2	23	33	19.5	4	●	2
	IMX20C4HV220R30023	22	3	23	33	19.5	4	●	2
NEW	IMX25C4HV250R10025	25	1	25	37.5	24.5	4	●	1
NEW	IMX25C4HV250R20025	25	2	25	37.5	24.5	4	●	1
NEW	IMX25C4HV250R30025	25	3	25	37.5	24.5	4	●	1
NEW	IMX25C4HV250R40025	25	4	25	37.5	24.5	4	●	1
NEW	IMX25C4HV250R50025	25	5	25	37.5	24.5	4	●	1
	IMX25C4HV250R60025	25	6	25	37.5	24.5	4	●	1
NEW	IMX25C4HV250R63525	25	6.35	25	37.5	24.5	4	●	1
	IMX25C4HV280R10029	28	1	29	41.5	24.5	4	●	2
	IMX25C4HV280R30029	28	3	29	41.5	24.5	4	●	2

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)



Type3

■ Long cutting edge type

(mm)

Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX16C4HV160R10032	16	1	32	40	15.5	4	●	3
IMX16C4HV160R30032	16	3	32	40	15.5	4	●	3
IMX20C4HV200R10040	20	1	40	50	19.5	4	●	3
IMX20C4HV200R30040	20	3	40	50	19.5	4	●	3

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

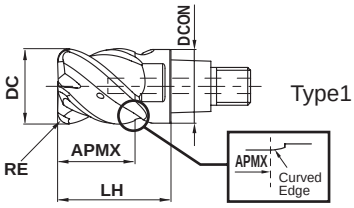
iMX-C4HV-S

Corner radius head, 4 flute, Irregular helix, with coolant hole

TOOL NEWS

42°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎	○	



Type1

RE≤6.35				
±0.020				
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- Coolant holes for each cutting edge enable stable coolant supply.
- Irregular lead controls vibration and achieves stable machining even on difficult-to-cut materials and long overhang applications.

(mm)

	Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX10C4HV100R03010S	10	0.3	10	16	9.7	4	●	1
	IMX10C4HV100R05010S	10	0.5	10	16	9.7	4	●	1
	IMX10C4HV100R10010S	10	1	10	16	9.7	4	●	1
	IMX10C4HV100R15010S	10	1.5	10	16	9.7	4	●	1
	IMX10C4HV100R20010S	10	2	10	16	9.7	4	●	1
	IMX10C4HV100R30010S	10	3	10	16	9.7	4	●	1
	IMX12C4HV120R03012S	12	0.3	12	19	11.7	4	●	1
	IMX12C4HV120R05012S	12	0.5	12	19	11.7	4	●	1
	IMX12C4HV120R10012S	12	1	12	19	11.7	4	●	1
	IMX12C4HV120R15012S	12	1.5	12	19	11.7	4	●	1
	IMX12C4HV120R20012S	12	2	12	19	11.7	4	●	1
	IMX12C4HV120R30012S	12	3	12	19	11.7	4	●	1
	IMX12C4HV120R40012S	12	4	12	19	11.7	4	●	1
	IMX16C4HV160R05016S	16	0.5	16	24	15.5	4	●	1
	IMX16C4HV160R10016S	16	1	16	24	15.5	4	●	1
	IMX16C4HV160R15016S	16	1.5	16	24	15.5	4	●	1
	IMX16C4HV160R20016S	16	2	16	24	15.5	4	●	1
	IMX16C4HV160R30016S	16	3	16	24	15.5	4	●	1
	IMX16C4HV160R40016S	16	4	16	24	15.5	4	●	1
	IMX20C4HV200R05020S	20	0.5	20	30	19.5	4	●	1
NEW	IMX20C4HV200R10020S	20	1	20	30	19.5	4	●	1
	IMX20C4HV200R15020S	20	1.5	20	30	19.5	4	●	1
	IMX20C4HV200R20020S	20	2	20	30	19.5	4	●	1
	IMX20C4HV200R30020S	20	3	20	30	19.5	4	●	1
	IMX20C4HV200R40020S	20	4	20	30	19.5	4	●	1
	IMX20C4HV200R60020S	20	6	20	30	19.5	4	●	1
	IMX20C4HV200R63520S	20	6.35	20	30	19.5	4	●	1
NEW	IMX25C4HV250R10025S	25	1	25	37.5	24.5	4	●	1
	IMX25C4HV250R15025S	25	1.5	25	37.5	24.5	4	●	1
	IMX25C4HV250R20025S	25	2	25	37.5	24.5	4	●	1
	IMX25C4HV250R30025S	25	3	25	37.5	24.5	4	●	1
	IMX25C4HV250R40025S	25	4	25	37.5	24.5	4	●	1
	IMX25C4HV250R60025S	25	6	25	37.5	24.5	4	●	1
	IMX25C4HV250R63525S	25	6.35	25	37.5	24.5	4	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : **Inventory maintained in Japan.**

iMX-C4HV/iMX-C4HV-S

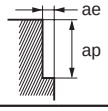
Corner radius head, 4 flute, Irregular helix (With/Without coolant hole)

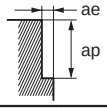
RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut 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
25	150	1900	0.12	910	25	5	120	1500	0.075	450	25	5	100	1300	0.09	470	25	5
Depth of cut																		

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut 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
25	75	950	0.075	290	25	5	40	510	0.05	100	25	2.5
Depth of cut												

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-C4HV/iMX-C4HV-S

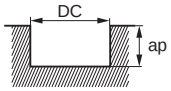
Corner radius head, 4 flute, Irregular helix (With/Without coolant hole)

■ Slot milling

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010					Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT					Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	100	1300	0.08	420	12	80	1000	0.05	200	12	75	950	0.06	230	12

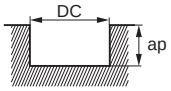
Depth of cut



DC:Dia.

Work Material	Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631					Heat resistant alloys Inconel718				
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
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
25	60	760	0.05	150	12	30	380	0.05	76	5

Depth of cut



DC:Dia.

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

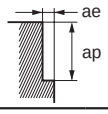
iMX-C4HV

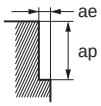
Corner radius head, 4 flute, Irregular helix, Long cutting edge type

RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling

(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
4	16	100	2000	0.09	720	32	0.8	80	1600	0.07	450	32	0.8	60	1200	0.08	380	32	0.8
	20	100	1600	0.09	580	40	1	80	1300	0.07	360	40	1	60	950	0.08	300	40	1
6	16	60	1200	0.07	340	32	0.8	50	990	0.05	200	32	0.8	40	800	0.06	190	32	0.8
	20	60	950	0.07	270	40	1	50	800	0.05	160	40	1	40	640	0.06	150	40	1
Depth of cut																			

Work Material		Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
4	16	50	990	0.07	280	32	0.8	30	600	0.05	120	32	0.4
	20	50	800	0.07	220	40	1	30	480	0.05	96	40	0.5
6	16	30	600	0.05	120	32	0.8	20	400	0.04	64	32	0.4
	20	30	480	0.05	96	40	1	20	320	0.04	51	40	0.5
Depth of cut													

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) The length of the long cutting type is 2 times that of the standard head. L/D demonstrates +1 when installed to a holder of the same size.

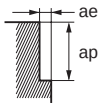
iMX-C4HV

Corner radius head, 4 flute, Irregular helix, Offset type

RECOMMENDED CUTTING CONDITIONS

■ Shoulder milling

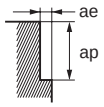
(mm)

Work Material		Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	11	150	4300	0.09	1500	11	1.1	120	3500	0.06	840	11	1.1	100	2900	0.075	870	11	1.1
	12	150	4000	0.09	1400	12	1.2	120	3200	0.06	770	12	1.2	100	2700	0.075	810	12	1.2
	13	150	3700	0.09	1300	13	1.3	120	2900	0.065	750	13	1.3	100	2400	0.08	770	13	1.3
	14	150	3400	0.09	1200	14	1.4	120	2700	0.065	700	14	1.4	100	2300	0.08	740	14	1.4
	17	150	2800	0.1	1100	17	1.7	120	2200	0.075	660	17	1.7	100	1900	0.08	610	17	1.7
	18	150	2700	0.1	1100	18	1.8	120	2100	0.075	630	18	1.8	100	1800	0.09	650	18	1.8
	22	150	2200	0.1	880	22	2.2	120	1700	0.075	510	22	2.2	100	1400	0.09	500	22	2.2
	28	150	1700	0.12	820	28	2.8	120	1400	0.075	420	28	2.8	100	1100	0.09	400	28	2.8
	30	150	1600	0.12	770	30	3	120	1300	0.075	390	30	3	100	1100	0.09	400	30	3
	32	150	1500	0.12	720	32	3.2	120	1200	0.075	360	32	3.2	100	990	0.09	360	32	3.2
5	11	90	2600	0.07	730	11	0.4	70	2000	0.05	400	11	0.4	60	1700	0.06	410	11	0.4
	12	90	2400	0.07	670	12	0.5	70	1900	0.05	380	12	0.5	60	1600	0.06	380	12	0.5
	13	90	2200	0.07	620	13	0.5	70	1700	0.05	340	13	0.5	60	1500	0.06	360	13	0.5
	14	90	2000	0.07	560	14	0.6	70	1600	0.05	320	14	0.6	60	1400	0.06	340	14	0.6
	17	90	1700	0.08	540	17	0.7	70	1300	0.06	310	17	0.7	60	1100	0.07	310	17	0.7
	18	90	1600	0.08	510	18	0.7	70	1200	0.06	290	18	0.7	60	1100	0.07	310	18	0.7
	22	90	1300	0.08	420	22	0.9	70	1000	0.06	240	22	0.9	60	870	0.07	240	22	0.9
	28	90	1000	0.1	400	28	1.1	70	800	0.06	190	28	1.1	60	680	0.07	190	28	1.1
	30	90	950	0.1	380	30	1.2	70	740	0.06	180	30	1.2	60	640	0.07	180	30	1.2
	32	90	900	0.1	360	32	1.3	70	700	0.06	170	32	1.3	60	600	0.07	170	32	1.3
7	11	60	1700	0.06	410	11	0.2	50	1400	0.04	220	11	0.2	32	930	0.05	190	11	0.2
	12	60	1600	0.06	380	12	0.2	50	1300	0.04	210	12	0.2	32	850	0.05	170	12	0.2
	13	60	1500	0.06	360	13	0.3	50	1200	0.05	240	13	0.3	32	780	0.06	190	13	0.3
	14	60	1400	0.06	340	14	0.3	50	1100	0.05	220	14	0.3	32	730	0.06	180	14	0.3
	17	60	1100	0.07	310	17	0.3	50	940	0.05	190	17	0.3	32	600	0.06	140	17	0.3
	18	60	1100	0.07	310	18	0.4	50	880	0.05	180	18	0.4	32	570	0.06	140	18	0.4
	22	60	870	0.07	240	22	0.4	50	720	0.05	140	22	0.4	32	460	0.06	110	22	0.4
	28	60	680	0.08	220	28	0.6	50	570	0.05	110	28	0.6	32	360	0.06	86	28	0.6
	30	60	640	0.08	200	30	0.6	50	530	0.05	110	30	0.6	32	340	0.06	82	30	0.6
	32	60	600	0.08	190	32	0.6	50	500	0.05	100	32	0.6	32	320	0.06	77	32	0.6
Depth of cut																			

Note 1) For stainless steels, titanium alloys and heat resistant alloys, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is smaller, the revolution and the feed rate can be increased.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the work material installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.

■ Shoulder milling

(mm)

Work Material		Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631						Heat resistant alloys Inconel718					
L/D	Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	11	75	2200	0.06	530	11	1.1	30	870	0.04	140	11	0.8
	12	75	2000	0.06	480	12	1.2	30	800	0.04	130	12	0.9
	13	75	1800	0.065	470	13	1.3	30	730	0.045	130	13	1
	14	75	1700	0.065	440	14	1.4	30	680	0.045	120	14	1.1
	17	75	1400	0.065	360	17	1.7	40	750	0.045	140	17	1.3
	18	75	1300	0.075	390	18	1.8	40	710	0.05	140	18	1.4
	22	75	1100	0.075	330	22	2.2	40	580	0.05	120	22	1.7
	28	75	850	0.075	260	28	2.8	40	450	0.05	90	28	2.1
	30	75	800	0.075	240	30	3	40	420	0.05	84	30	2.3
	32	75	750	0.075	230	32	3.2	40	400	0.05	80	32	2.4
5	11	50	1400	0.05	280	11	0.4	10	290	0.03	35	11	0.3
	12	50	1300	0.05	260	12	0.5	10	270	0.03	32	12	0.4
	13	50	1200	0.05	240	13	0.5	10	240	0.04	38	13	0.4
	14	50	1100	0.05	220	14	0.6	10	230	0.04	37	14	0.4
	17	50	940	0.06	230	17	0.7	19	360	0.04	58	17	0.5
	18	50	880	0.06	210	18	0.7	19	340	0.04	54	18	0.6
	22	50	720	0.06	170	22	0.9	19	270	0.04	43	22	0.7
	28	50	570	0.06	140	28	1.1	19	220	0.04	35	28	0.8
	30	50	530	0.06	130	30	1.2	19	200	0.04	32	30	0.9
	32	50	500	0.06	120	32	1.3	19	190	0.04	30	32	1
7	11	24	690	0.04	110	11	0.2	–	–	–	–	–	–
	12	24	640	0.04	100	12	0.2	–	–	–	–	–	–
	13	24	590	0.05	120	13	0.3	–	–	–	–	–	–
	14	24	550	0.05	110	14	0.3	–	–	–	–	–	–
	17	24	450	0.05	90	17	0.3	–	–	–	–	–	–
	18	24	420	0.05	84	18	0.4	–	–	–	–	–	–
	22	24	350	0.05	70	22	0.4	–	–	–	–	–	–
	28	24	270	0.05	54	28	0.6	–	–	–	–	–	–
	30	24	250	0.05	50	30	0.6	–	–	–	–	–	–
	32	24	240	0.05	48	32	0.6	–	–	–	–	–	–
Depth of cut													

Note 1) For stainless steels, titanium alloys and heat resistant alloys, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is smaller, the revolution and the feed rate can be increased.
Note 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the work material installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.

iMX-C6HV/C10HV/C12HV

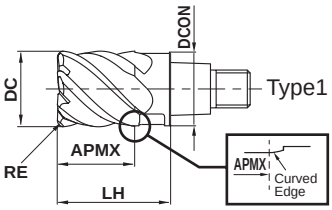
Corner radius head, Multi-flute, Irregular helix

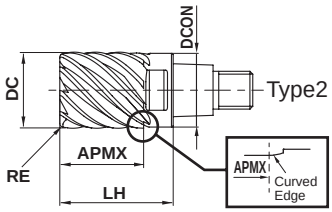
TOOL NEWS

UWC

43.5° 45° DC ≤12 | 44.5° 45° DC>12 | DC ≤12 | DC>12

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○			◎	◎		





RE≤1				
±0.020				
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- High machining efficiency due to the multi-flute design.
- Irregular lead controls vibration and achieves stable machining.

(mm)

	Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP7020	Type
	IMX10C6HV100R05010	10	0.5	10	16	9.7	6	●	1
	IMX10C6HV100R10010	10	1	10	16	9.7	6	●	1
	IMX12C6HV120R10012	12	1	12	19	11.7	6	●	1
	IMX16C10HV160R10016	16	1	16	24	15.5	10	●	2
NEW	IMX20C12HV200R10020	20	1	20	30	19.5	12	●	2
NEW	IMX25C12HV250R10025	25	1	25	37.5	24.5	12	●	2

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

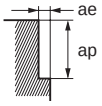
● : Inventory maintained in Japan.

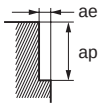
RECOMMENDED CUTTING CONDITIONS

■Shoulder milling (L/D=3)

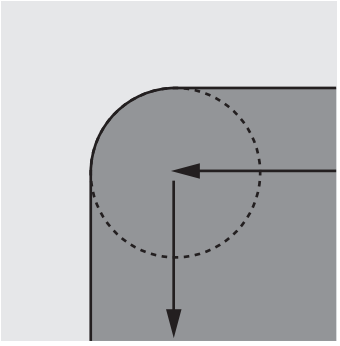
Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material	Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Austenitic stainless steel, Ferritic and Martensitic stainless steels, Titanium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2, Ti-6Al-4V						Precipitation hardening stainless steel, Cobalt chromium alloy AISI 630, AISI 631					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	200	6400	0.07	2700	10	1	150	4800	0.07	2000	10	1	100	3200	0.07	1300	10	1
12	200	5300	0.085	2700	12	1.2	150	4000	0.085	2000	12	1.2	100	2700	0.085	1400	12	1.2
16	200	4000	0.088	3500	16	0.6	150	3000	0.088	2600	16	0.64	100	2000	0.088	1800	16	0.6
20	200	3200	0.1	3800	20	0.8	150	2400	0.1	2900	20	0.8	100	1600	0.1	1900	20	0.8
25	200	2500	0.1	3000	25	1	150	1900	0.1	2300	25	1	100	1300	0.1	1600	25	1
Depth of cut																		

Work Material	Heat resistant alloys Inconel718					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	40	1300	0.033	260	10	0.5
12	40	1100	0.035	230	12	0.6
16	40	800	0.038	300	16	0.6
20	40	640	0.04	310	20	0.8
25	40	510	0.04	240	25	1
Depth of cut						

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) If the machining radius at the corner is the same as the tool radius when using the head with more than 10 flutes, please set the depth of cut and feed rate to half of the above.



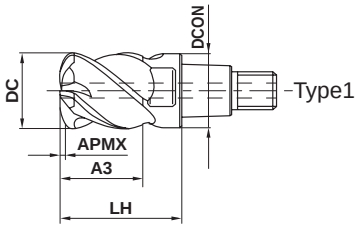
iMX-C4FD-C

With coolant hole Multi-task corner radius end mill for high feed cutting

TOOL NEWS

45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎		◎	◎	○	



DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- Multi-task corner radius type and 4 flutes offer high feed and high efficiency.
- Coolant hole with the end cutting edge as the center provides a stable supply of coolant.

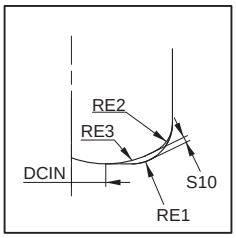
(mm)

Order Number	DC	RE1*1	APMX	A3	LH	DCON	No. of Flutes	RMPX*2	Grade EP7020	Type
IMX10C4FD10010C	10	1.99	0.7	10.5	16	9.7	4	2.1°	●	1
IMX12C4FD12012C	12	2.1	0.8	12.5	19	11.7	4	2.8°	●	1
IMX16C4FD16016C	16	2.75	1	16.5	24	15.5	4	3°	●	1
IMX20C4FD20021C	20	3.07	1.3	21	30	19.5	4	3.3°	●	1
IMX25C4FD25026C	25	4.21	1.6	26	37.5	24.5	4	4.5°	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)
Note 2) Multi-task corner radius is not suitable for corner radius milling that transfers an R-shape because cutting at R is incomplete.
*1 RE1 : Approx. R
*2 RMPX : Max. Ramping Angle

(mm)

Order Number	RE1*1	Multi-task Radius Part			
		S10	DCIN	RE2	RE3
IMX10C4FD10010C	1.99	0.27	3.4	1.5	5
IMX12C4FD12012C	2.1	0.33	4.5	1.5	6
IMX16C4FD16016C	2.75	0.42	6.2	2	8
IMX20C4FD20021C	3.07	0.59	8	2	10
IMX25C4FD25026C	4.21	0.67	10	3	12



Please programme CAM as an R2 cutter radius, when using the iMX.
The approximate uncut portions for the programme are as follows.

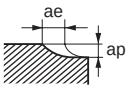
● : Inventory maintained in Japan.

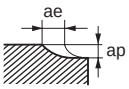
RECOMMENDED CUTTING CONDITIONS

■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material	Carbon steel, Alloy steel, Mild steel, Copper, Copper alloys AISI 1045, AISI 4140, ASTM A36, AISI 1010						Pre-hardened steel, Carbon steel, Alloy steel, Alloy tool steel AISI P21, AISI P20, AISI 4340, SKD, SKT						Hardened steel, Precipitation hardening stainless steel, Ferritic and Martensitic stainless steels, AISI H13, AISI L6, AISI 431, AISI 420J2, AISI 630, AISI 631					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	150	4800	0.4	7700	0.5	6	135	4300	0.4	6900	0.5	6	120	3800	0.3	4600	0.5	6
12	150	4000	0.45	7200	0.6	7.2	135	3600	0.45	6500	0.6	7.2	120	3200	0.3	3800	0.6	7.2
16	150	3000	0.5	6000	0.8	9.6	135	2700	0.5	5400	0.8	9.6	120	2400	0.4	3800	0.8	9.6
20	150	2400	0.5	4800	1	12	135	2100	0.5	4200	1	12	120	1900	0.4	3000	1	12
25	150	1900	0.5	3800	1.25	15	135	1700	0.5	3400	1.25	15	120	1500	0.4	2400	1.25	15
Depth of cut																		

Work Material	Austenitic stainless steel, Titanium alloy, Cobalt chromium alloy AISI 304, AISI 316, AISI 304LN, AISI 316LN, Ti-6Al-4V						Heat resistant alloys Inconel718					
Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	40	1300	0.2	1000	0.5	6	25	800	0.1	320	0.5	6
12	40	1100	0.2	880	0.6	7.2	25	660	0.1	260	0.6	7.2
16	40	800	0.3	960	0.8	9.6	25	500	0.15	300	0.8	9.6
20	40	640	0.3	770	1	12	25	400	0.15	240	1	12
25	40	510	0.3	610	1.25	15	25	320	0.15	190	1.25	15
Depth of cut												

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills.
However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.
Note 4) Reduce the feed by 1/2 for ramping process.

iMX-C4FV

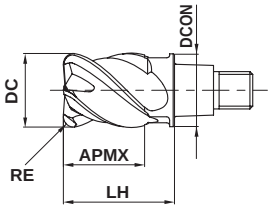
Corner radius head for high efficiency machining, 4 flute, Irregular helix

TOOL NEWS

UWC

43°
45°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	◎	◎					



Type1

RE≤3	RE=4			
±0.010	±0.020			
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

- Corner radius end mill for high efficiency machining
- Irregular lead controls vibration and achieves stable machining.

(mm)

Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade EP6120	Type
IMX10C4FV100R20010	10	2	10.5	16	9.7	4	●	1
IMX12C4FV120R20012	12	2	12.5	19	11.7	4	●	1
IMX16C4FV160R30016	16	3	16.5	24	15.5	4	●	1
IMX20C4FV200R30021	20	3	21	30	19.5	4	●	1
IMX25C4FV250R40026	25	4	26	37.5	24.5	4	●	1

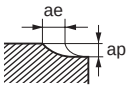
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

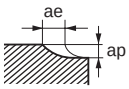
■High depth of cut conditions

(mm)

Work Material		Carbon steel, Alloy steel, Gray cast iron AISI 1045, AISI 4140, AISI No 45 B						Pre-hardened steel, Alloy tool steel AISI P21, AISI P20, SKD, SKT						Hardened steel (45－55HRC) AISI H13, AISI L6					
Dia. **DC**	Corner R **RE**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	2	90	2900	0.25	2900	1.2	4.5	75	2400	0.23	2200	1	4.5	60	1900	0.22	1700	0.7	4.5
12	2	90	2400	0.25	2400	1.8	6	75	2000	0.23	1800	1.4	6	60	1600	0.22	1400	0.9	6
16	3	90	1800	0.25	1800	1.8	7.5	75	1500	0.23	1400	1.4	7.5	60	1200	0.22	1100	0.9	7.5
20	3	90	1400	0.25	1400	1.8	9	75	1200	0.23	1100	1.4	9	60	950	0.22	840	0.9	9
25	4	90	1100	0.25	1100	2.4	11.5	75	950	0.23	870	1.8	11.5	60	760	0.22	670	1.2	11.5
Depth of cut																			

■High speed milling

(mm)

Work Material		Carbon steel, Alloy steel, Gray cast iron AISI 1045, AISI 4140, AISI No 45 B						Pre-hardened steel, Alloy tool steel AISI P21, AISI P20, SKD, SKT						Hardened steel (45－55HRC) AISI H13, AISI L6					
Dia. **DC**	Corner R **RE**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	2	150	4800	0.4	7700	0.6	4.5	125	4000	0.35	5600	0.46	4.5	100	3200	0.3	3800	0.36	4.5
12	2	150	4000	0.45	7200	0.9	6	125	3300	0.4	5300	0.7	6	100	2700	0.3	3200	0.45	6
16	3	150	3000	0.5	6000	0.9	7.5	125	2500	0.45	4500	0.7	7.5	100	2000	0.3	2400	0.45	7.5
20	3	150	2400	0.5	4800	0.9	9	125	2000	0.45	3600	0.7	9	100	1600	0.35	2200	0.45	9
25	4	150	1900	0.5	3800	1.2	11.5	125	1600	0.45	2900	0.9	11.5	100	1300	0.35	1800	0.6	11.5
Depth of cut																			

Note 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 2) Air blow or oil mist is recommended for good chip evacuation.
Note 3) For profile machining such as moulds, machining conditions may differ considerably depending on the workpiece geometry, machining methods and depth of cut. Reduce the feed rate especially when machining the corner sections of a workpiece.
Note 4) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

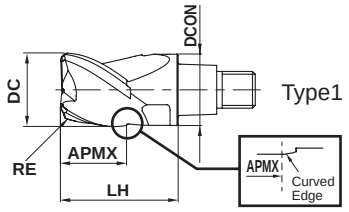
iMX-C3A

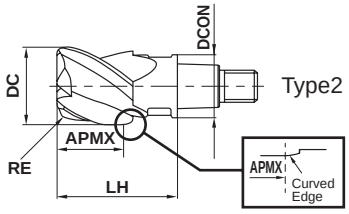
Corner radius head, 3 flute, For aluminium alloy

TOOL NEWS

37.5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
							◎





Offset Type

RE≤5				
±0.020				
DC≤12	DC>12			
0 - 0.020	0 - 0.030			

●High efficiency machining due to the sharp cutting edge suitable for aluminium alloy machining and polished rake face.

(mm)

	Order Number	DC	RE	APMX	LH	DCON	No. of Flutes	Grade ET2020	Type
	IMX10C3A100R10008	10	1	8	16	9.7	3	●	1
	IMX10C3A100R25008	10	2.5	8	16	9.7	3	●	1
	IMX10C3A120R10010	12	1	10.1	19	9.7	3	●	2
NEW	IMX12C3A120R10009	12	1	9.6	19	11.7	3	●	1
NEW	IMX12C3A120R32009	12	3.2	9.6	19	11.7	3	●	1
	IMX12C3A140R10011	14	1	11.7	22.5	11.7	3	●	2
NEW	IMX16C3A160R10012	16	1	12.8	24	15.5	3	●	1
NEW	IMX16C3A160R32012	16	3.2	12.8	24	15.5	3	●	1
	IMX16C3A180R32014	18	3.2	14.9	27	15.5	3	●	2
NEW	IMX20C3A200R10016	20	1	16	30	19.5	3	●	1
NEW	IMX20C3A200R32016	20	3.2	16	30	19.5	3	●	1
	IMX20C3A220R32018	22	3.2	18.6	33	19.5	3	●	2
	IMX25C3A250R10020	25	1	20	37.5	24.5	3	●	1
NEW	IMX25C3A250R32020	25	3.2	20	37.5	24.5	3	●	1
NEW	IMX25C3A250R50020	25	5	20	37.5	24.5	3	●	1
	IMX25C3A280R32023	28	3.2	23.4	41.5	24.5	3	●	2

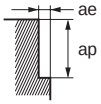
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

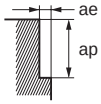
■Shoulder milling (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	500	16000	0.117	5600	8	3
12	500	13000	0.118	4600	9.6	3.6
16	500	9900	0.153	4500	12.8	4.8
20	500	8000	0.175	4200	16	6
25	500	6400	0.211	4100	20	7.5
Depth of Cut						

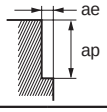
■Shoulder milling (L/D=5)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	300	9500	0.09	2600	8	1.2
12	300	8000	0.09	2200	9.6	1.44
16	300	6000	0.12	2200	12.8	1.92
20	300	4800	0.14	2000	16	2.4
25	300	3800	0.17	1900	20	3
Depth of Cut						

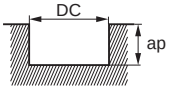
■Shoulder milling (L/D=7)

(mm)

Work Material	Aluminium alloy A6061, A7075					
Dia. DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	200	6400	0.08	1500	8	0.6
12	200	5300	0.08	1300	9.6	0.72
16	200	4000	0.11	1300	12.8	0.96
20	200	3200	0.12	1200	16	1.2
25	200	2500	0.15	1100	20	1.5
Depth of Cut						

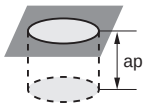
■Slot milling (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075				
DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	500	16000	0.068	3300	5
12	500	13000	0.072	2800	6
16	500	9900	0.093	2800	8
20	500	8000	0.108	2600	10
25	500	6400	0.127	2400	12.5
Depth of Cut	 DC:Dia.				

■Plunging (L/D=3)

(mm)

Work Material	Aluminium alloy A6061, A7075					
DC	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Rev. (mm/rev)	Feed rate (mm/min)	Drilled Depth ap	Step ap2
10	300	9500	0.1	950	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
25	300	3800	0.1	380	12.5	2.5
Depth of Cut						

Note 1) The use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or work material is low.
In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.

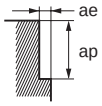
iMX-C3A

Corner radius head, 3 flute, For aluminium alloy, Offset type

RECOMMENDED CUTTING CONDITIONS

■Side milling

(mm)

Work Material		Aluminium alloy A6061, A7075					
L/D	Dia. **DC**	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
3	12	500	13000	0.117	4600	9.6	2.4
	14	500	11000	0.118	3900	11.2	2.8
	18	500	8800	0.153	4000	14.4	3.6
	22	500	7200	0.175	3800	17.6	4.4
	28	500	5700	0.211	3600	22.4	5.6
5	12	300	8000	0.09	2200	9.6	1.0
	14	300	6800	0.09	1800	11.2	1.1
	18	300	5300	0.12	1900	14.4	1.4
	22	300	4300	0.14	1800	17.6	1.8
	28	300	3400	0.17	1700	22.4	2.2
Depth of cut							

Note 1) The use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or workpiece is low.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

iMX-C8T/C10T/C12T/C15T-C

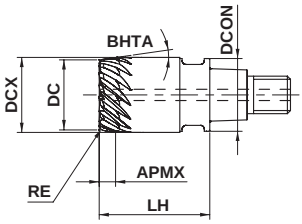
Corner radius, Taper head, Multi-flute, With coolant hole

TOOL NEWS

UWC

35°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
				◎	◎		



Type1

RE ≤2				
±0.015				
DC ≤12	DC>12			
0 - 0.020	0 - 0.030			

- Suitable for 3-dimensional free-form surface cutting such as blades.
- High feed cutting is possible due to multiple cutting edges.

(mm)

Order Number	DC	RE	APMX	DCX	LH	DCON	BHTA	No. of Flutes	Grade EP7020	Type
IMX10C8T080R05T080C	8	0.5	7.12	10	16	9.7	8°	8	●	1
IMX10C8T080R10T080C	8	1	7.12	10	16	9.7	8°	8	●	1
IMX12C10T100R05T080C	10	0.5	7.12	12	19	11.7	8°	10	●	1
IMX12C10T100R10T080C	10	1	7.12	12	19	11.7	8°	10	●	1
IMX16C15T150R05T080C	15	0.5	3.56	16	24	15.5	8°	15	●	1
IMX16C15T150R10T080C	15	1	3.56	16	24	15.5	8°	15	●	1
IMX16C12T150R20T080C	15	2	3.56	16	24	15.5	8°	12	●	1
IMX20C15T190R05T080C	19	0.5	3.56	20	30	19.5	8°	15	●	1
IMX20C15T190R10T080C	19	1	3.56	20	30	19.5	8°	15	●	1
IMX20C12T190R20T080C	19	2	3.56	20	30	19.5	8°	12	●	1

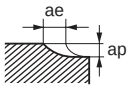
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

Recommended Cutting Conditions

■Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the K003 page correction factor by overhang length.

(mm)

Work Material		Austenitic stainless steels, Ferritic and Martensitic stainless steels AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2						Precipitation hardening stainless steels, Titanium alloys AISI 630, AISI 631, Ti-6Al-4V						Heat resistant alloys Inconel718					
Dia. DC	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
8	8	300	12000	0.1	9600	0.3	1.2	200	8000	0.1	6400	0.3	1.2	60	2400	0.08	1500	0.3	0.8
10	10	300	9500	0.1	9500	0.3	1.5	200	6400	0.1	6400	0.3	1.5	60	1900	0.08	1500	0.3	1
15	12	300	6400	0.12	9200	0.3	2.2	200	4200	0.12	6000	0.3	2.2	60	1300	0.1	1600	0.3	1.5
15	15	300	6400	0.1	9600	0.3	2.2	200	4200	0.1	6300	0.3	2.2	60	1300	0.08	1600	0.3	1.5
19	12	300	5000	0.12	7200	0.3	2.8	200	3400	0.12	4900	0.3	2.8	60	1000	0.1	1200	0.3	1.9
19	15	300	5000	0.1	7500	0.3	2.8	200	3400	0.1	5100	0.3	2.8	60	1000	0.08	1200	0.3	1.9
Depth of Cut																			

Note 1) The use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or workpiece is low.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

● : **Inventory maintained in Japan.**

iMX-CH3L

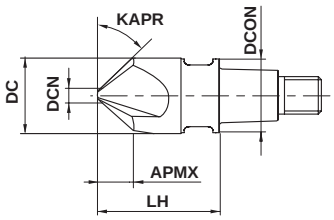
Chamfer head, 3 flute

TOOL NEWS

UWC

γ 5°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○	○		◎	◎		



Type1

DCN=1.5				
±0.020				

- Chamfered cutting head suitable for inner and outer circumference.
- Anti-vibration priority design.

(mm)

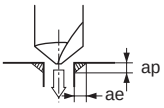
Order Number	DC	APMX	KAPR	DCN	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX10CH3L100A45	10	4.2	45°	1.5	16	9.7	3	●	1
IMX12CH3L120A45	12	5.2	45°	1.5	19	11.7	3	●	1
IMX16CH3L160A45	16	7.2	45°	1.5	24	15.5	3	●	1
IMX20CH3L200A45	20	9.2	45°	1.5	30	19.5	3	●	1

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

RECOMMENDED CUTTING CONDITIONS

■Chamfer milling (Hole circumference)

(mm)

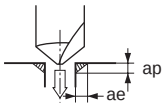
Work Material		Carbon steels, Alloy steels, Gray cast irons AISI 1045, AISI 4140, AISI No 45 B						Alloy tool steels, Carbon steels, Alloy steels, Pre-hardened steels SKD, SKT, AISI 4340, AISI P21, AISI P20						Austenitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V					
Dia. DC	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	3	40	1300	0.04	160	1.8	1.8	40	1300	0.03	120	1.8	1.8	30	950	0.03	86	1.8	1.8
12	3	40	1100	0.04	130	2.2	2.2	40	1100	0.03	99	2.2	2.2	30	800	0.03	72	2.2	2.2
16	3	40	800	0.04	96	2.4	2.4	40	800	0.03	72	2.4	2.4	30	600	0.03	54	2.4	2.4
20	3	40	640	0.04	77	2.6	2.6	40	640	0.03	58	2.6	2.6	30	480	0.03	43	2.6	2.6
Depth of Cut																			

Note 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or work material is low.
In this case, please reduce the revolution and the feed rate proportionately.

● : **Inventory maintained in Japan.**

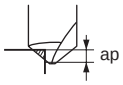
Chamfer milling (Hole circumference)

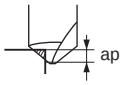
(mm)

Work Material		Hardenned steels (40-55HRC) AISI H13, AISI L6						Heat resistant alloys Inconel718					
Dia. DC	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
10	3	30	950	0.02	57	1.8	1.8	30	950	0.04	110	1.8	1.8
12	3	30	800	0.02	48	2.2	2.2	30	800	0.04	96	2.2	2.2
16	3	30	600	0.02	36	2.4	2.4	30	600	0.04	72	2.4	2.4
20	3	30	480	0.02	29	2.6	2.6	30	480	0.04	58	2.6	2.6
Depth of Cut													

Chamfer milling (Shape circumference)

(mm)

Work Material		Carbon steels, Alloy steels, Gray cast irons AISI 1045, AISI 4140, AISI No 45 B					Alloy tool steels, Carbon steels, Alloy steels, Pre-hardened steels SKD, SKT, AISI 4340, AISI P21, AISI P20					Austenitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				
Dia. DC	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	3	100	3200	0.05	480	2	70	2200	0.05	300	2	60	1900	0.04	230	2
12	3	100	2700	0.05	410	2.4	70	1900	0.05	260	2.4	60	1600	0.04	190	2.4
16	3	100	2000	0.05	300	2.7	70	1400	0.05	190	2.7	60	1200	0.04	140	2.7
20	3	100	1600	0.05	240	3.2	70	1100	0.05	150	3.2	60	950	0.04	110	3.2
Depth of Cut																

Work Material		Hardenned steels (40-55HRC) AISI H13, AISI L6					Heat resistant alloys Inconel718				
Dia. DC	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
10	3	50	1600	0.03	140	2	30	950	0.04	110	2
12	3	50	1300	0.03	120	2.4	30	800	0.04	96	2.4
16	3	50	990	0.03	89	2.7	30	600	0.04	72	2.7
20	3	50	800	0.03	72	3.2	30	480	0.04	58	3.2
Depth of Cut											

Note 1) For stainless steels, titanium alloys and heat resistant alloys, the use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or work material is low.
In this case, please reduce the revolution and the feed rate proportionately.

iMX-CH6V

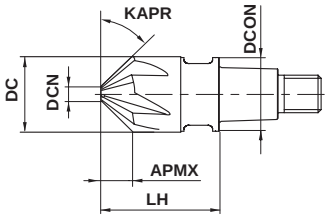
Chamfer head, 6 flute

TOOL NEWS

UWC

1°
3°

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel,Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
◎	○	○		◎	◎		



Type1

DCN=3				
±0.020				

- Suitable for outer circumference.
- Multiple cutting design for extended tool life.

(mm)

Order Number	DC	APMX	KAPR	DCN	LH	DCON	No. of Flutes	Grade EP7020	Type
IMX12CH6V120A45	12	4.5	45°	3	19	11.7	6	●	1
IMX16CH6V160A45	16	6.5	45°	3	24	15.5	6	●	1
IMX20CH6V200A45	20	8.5	45°	3	30	19.5	6	●	1

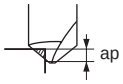
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

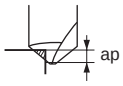
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

■ Chamfer milling (Shape circumference)

(mm)

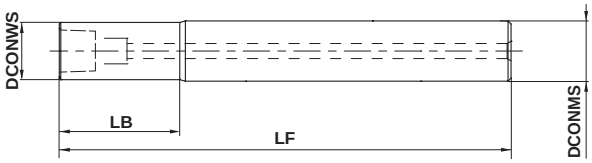
Work Material		Carbon steels, Alloy steels, Gray cast irons AISI 1045, AISI 4140, AISI No 45 B					Alloy tool steels, Carbon steels, Alloy steels, Pre-hardened steels SKD, SKT, AISI 4340, AISI P21, AISI P20					Austenitic stainless steels, Titanium alloys AISI 304, AISI 316, Ti-6Al-4V				
Dia. **DC**	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
12	6	100	2700	0.05	810	2.4	70	1900	0.045	510	2.4	60	1600	0.04	380	2.4
16	6	100	2000	0.05	600	2.7	70	1400	0.045	380	2.7	60	1200	0.04	290	2.7
20	6	100	1600	0.05	480	3.2	70	1100	0.045	300	3.2	60	950	0.04	230	3.2
Depth of Cut																

Work Material		Hardenned steels (40-55HRC) AISI H13, AISI L6					Heat resistant alloys Inconel718				
Dia. **DC**	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t.)	Feed rate (mm/min)	Depth of cut ap
12	6	50	1300	0.03	230	2.4	30	800	0.04	190	2.4
16	6	50	990	0.03	180	2.7	30	600	0.04	140	2.7
20	6	50	800	0.03	140	3.2	30	480	0.04	120	3.2
Depth of Cut											

Note 1) For stainless steels, titanium alloys and heat resistant alloys, the use of water-soluble coolant is effective.
Note 2) Vibration may occur if the rigidity of machine or work material is low.
In this case, please reduce the revolution and the feed rate proportionately.

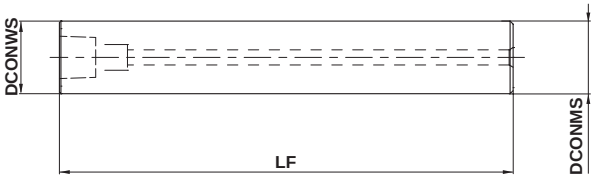
iMX
Carbide Holder

■Undercut



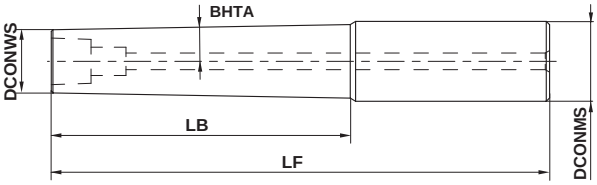
Type1

■Straight



Type2

■Taper Neck Type



Type3

h6

DCONMS=10	12 ≤DCONMS ≤16	20 ≤DCONMS ≤25		
0 - 0.009	0 - 0.011	0 - 0.013		

■Carbide Holder

(mm)

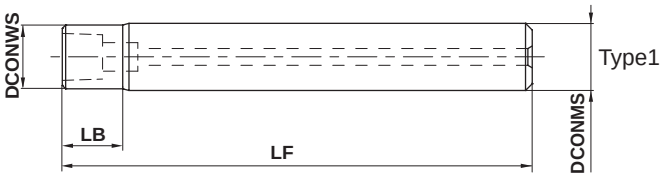
Order Number	BHTA	LB	DCONWS	LF	DCONMS	Stock	Type	Suitable Head	Wrench
IMX10-U10N014L070C	—	14	9.7	70	10	●	1	IMX10	IMX10-WR
IMX10-S10L090C	—	—	10	90	10	●	2	IMX10	IMX10-WR
IMX10-U10N034L090C	—	34	9.7	90	10	●	1	IMX10	IMX10-WR
IMX10-S10L110C	—	—	10	110	10	●	2	IMX10	IMX10-WR
IMX10-U10N054L110C	—	54	9.7	110	10	●	1	IMX10	IMX10-WR
IMX10-A12N054L110C	1°	54	9.7	110	12	●	3	IMX10	IMX10-WR
IMX12-U12N017L080C	—	17	11.7	80	12	●	1	IMX12	IMX12-WR
IMX12-S12L100C	—	—	12	100	12	●	2	IMX12	IMX12-WR
IMX12-U12N041L100C	—	41	11.7	100	12	●	1	IMX12	IMX12-WR
IMX12-S12L130C	—	—	12	130	12	●	2	IMX12	IMX12-WR
IMX12-U12N065L130C	—	65	11.7	130	12	●	1	IMX12	IMX12-WR
IMX12-A16N065L130C	1°	65	11.7	130	16	●	3	IMX12	IMX12-WR
IMX16-U16N024L080C	—	24	15.5	80	16	●	1	IMX16	IMX16-WR
IMX16-S16L110C	—	—	16	110	16	●	2	IMX16	IMX16-WR
IMX16-U16N056L110C	—	56	15.5	110	16	●	1	IMX16	IMX16-WR
IMX16-S16L150C	—	—	16	150	16	●	2	IMX16	IMX16-WR
IMX16-U16N088L150C	—	88	15.5	150	16	●	1	IMX16	IMX16-WR
IMX16-A20N088L150C	1°	88	15.5	150	20	●	3	IMX16	IMX16-WR
IMX20-U20N030L090C	—	30	19.5	90	20	●	1	IMX20	IMX20-WR
IMX20-S20L130C	—	—	20	130	20	●	2	IMX20	IMX20-WR
IMX20-U20N070L130C	—	70	19.5	130	20	●	1	IMX20	IMX20-WR
IMX20-S20L180C	—	—	20	180	20	●	2	IMX20	IMX20-WR
IMX20-U20N110L180C	—	110	19.5	180	20	●	1	IMX20	IMX20-WR
IMX20-A25N110L180C	1°	110	19.5	180	25	●	3	IMX20	IMX20-WR
IMX25-U25N037L110C	—	37.5	24.5	110	25	●	1	IMX25	IMX25-WR
IMX25-S25L160C	—	—	25	160	25	●	2	IMX25	IMX25-WR
IMX25-U25N087L160C	—	87.5	24.5	160	25	●	1	IMX25	IMX25-WR
IMX25-S25L210C	—	—	25	210	25	●	2	IMX25	IMX25-WR

Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

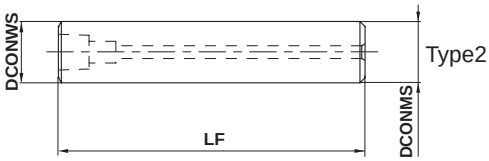
● : Inventory maintained in Japan.

iMX
Steel Holder

■Undercut



■Highly Rigid Straight



h6

DCONMS=10	12 ≤DCONMS ≤16	20 ≤DCONMS ≤25	DCONMS=32
0 - 0.009	0 - 0.011	0 - 0.013	0 - 0.016

■Steel Holder

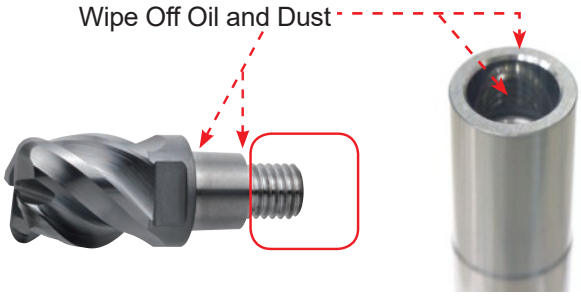
(mm)

Order Number	LB	DCONWS	LF	DCONMS	Stock	Type	Suitable Head	Wrench
IMX10-U10N009L070S	9	9.7	70	10	●	1	IMX10□	IMX10-WR
IMX10-G12L060S	—	12	60	12	●	2	IMX10□	IMX10-WR
IMX12-U12N011L080S	11	11.7	80	12	●	1	IMX12□	IMX12-WR
IMX12-G16L070S	—	16	70	16	●	2	IMX12□	IMX12-WR
IMX16-U16N016L080S	16	15.5	80	16	●	1	IMX16□	IMX16-WR
IMX16-G20L070S	—	20	70	20	●	2	IMX16□	IMX16-WR
IMX20-U20N020L090S	20	19.5	90	20	●	1	IMX20□	IMX20-WR
IMX20-G25L080S	—	25	80	25	●	2	IMX20□	IMX20-WR
IMX25-U25N025L110S	25	24.5	110	25	●	1	IMX25□	IMX25-WR
IMX25-G32L100S	—	32	100	32	●	2	IMX25□	IMX25-WR

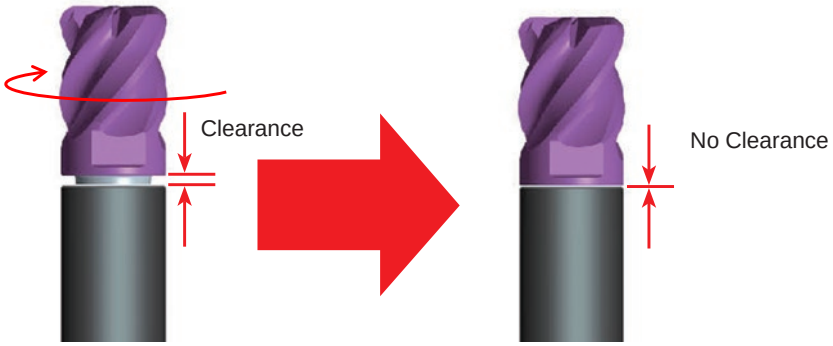
Note 1) The fastening size of the holder and head should be the same. (Refer to K002)

How to Install the Head

1 Using a clean cloth, wipe away oil and dust from the taper and end surfaces of the head and holder.

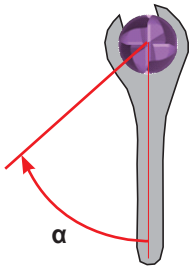


2 Be careful to avoid the possibility of cutting hands when fastening with bare hands directly near the blade tip.
Securely fasten the head and holder end surfaces using the enclosed wrench to close off any remaining gap.



3 Refer to the table at below regarding angles for recommended torque when necessary.
For stricter usage, refer to the table below for torque wrench fastening.

Suitable Head	Reference Tightening Angle α	Recommended Clamping Torque (N·m)
IMX10□	50°	10
IMX12□	50°	15
IMX16□	50°	30
IMX20□	40°	50
IMX25□	35°	75

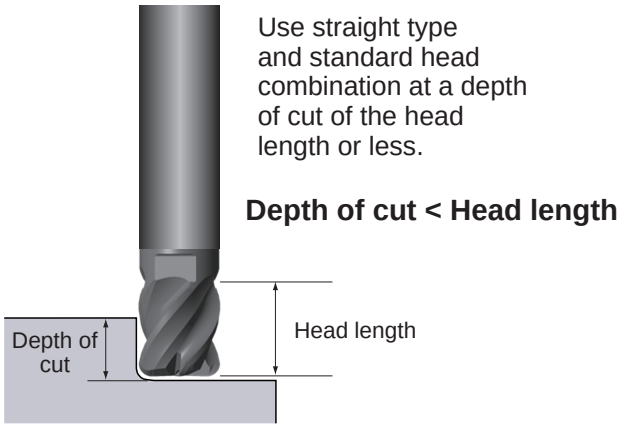


Note 1) Use the enclosed wrench only.
(Typical wrenches differ in thickness.)

iMX holder application

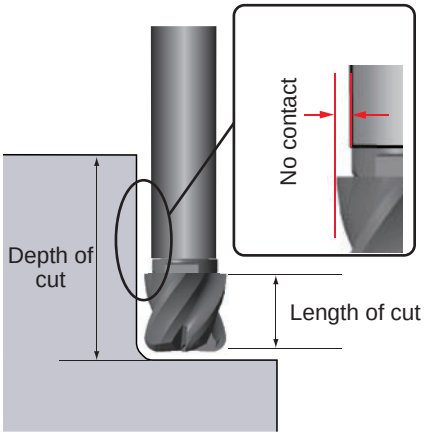
- Combination of the straight type and standard head causes interference when the depth of cut is head length or more. (Because holder diameter = head diameter)
- Combination of the straight type and offset head may make the depth of cutting length or more. (Because holder diameter < head diameter)

Straight + Standard head



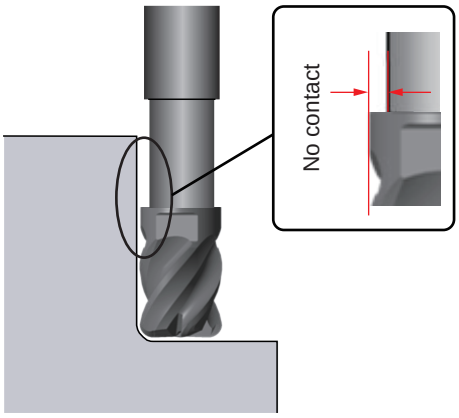
Installation at an overhang of DC×3 or less is also possible, if the depth of cut < head length is assumed.

Straight + Offset head

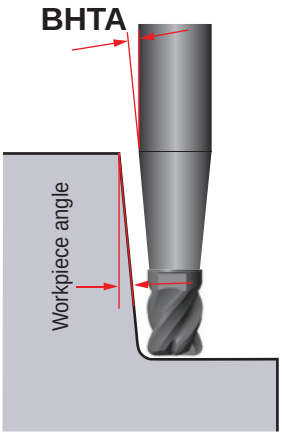


- It is suitable for vertical wall machining, because the undercut type has a relief neck.
- A taper neck with thick relief has high rigidity. Especially a stable cutting is demonstrated at deeper machining.
- Perform straight shank additional grinding together with customer application for undercut taper neck type. (Refer to the cutting edge diameter (DC) of each type for the minimum machining diameter.)

Undercut + Standard head



Taper neck + Standard head



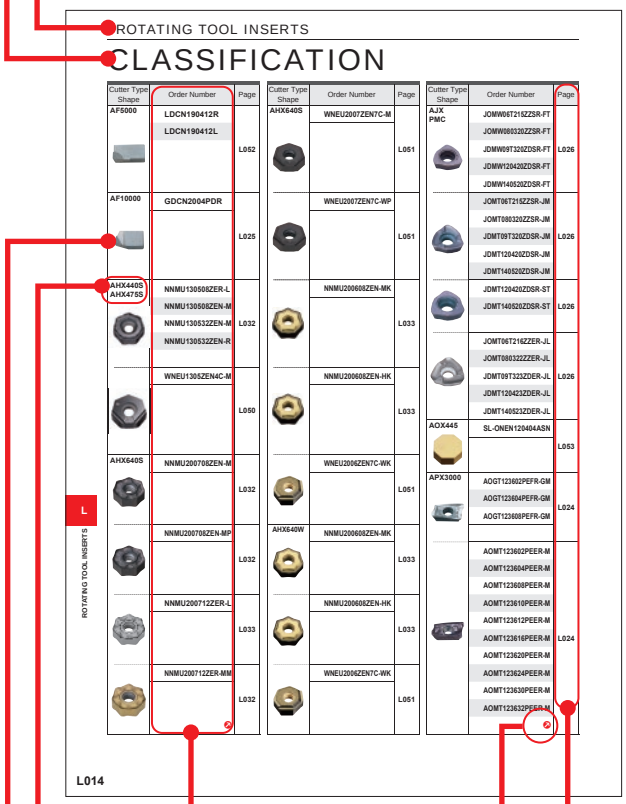
HOW TO READ THE STANDARD OF ROTATING TOOL INSERTS

●How the section of rotating tool inserts is organised

①Organised according to cutter type.
②Cutters are arranged in alphabetical order.

●How the standards for rotating tool inserts are organised

①Classified into rotating tool inserts, wiper inserts and drilling inserts.
②Arranged in order of alphabet of order number.



PAGE TITLE

PRODUCT SECTION

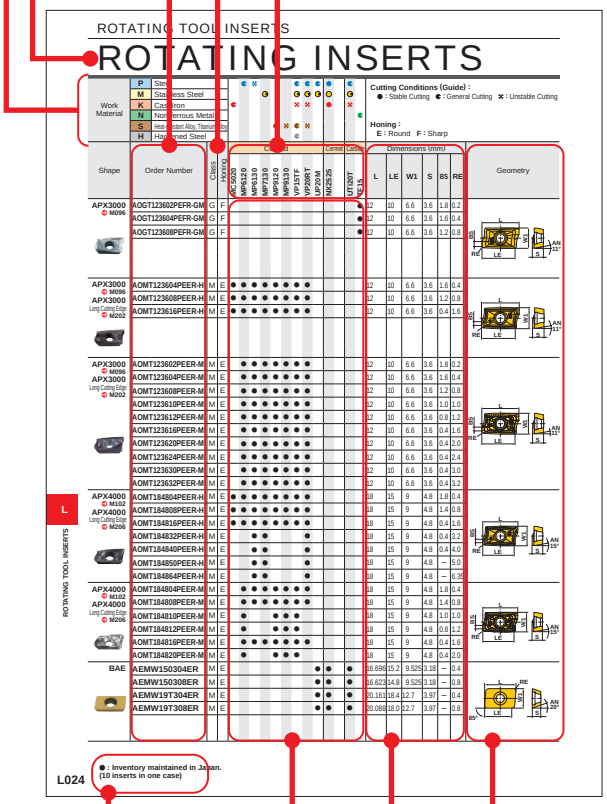
INSERT NUMBER

CUTTER TYPE

CONT. IN NEXT COLUMN
indicates that the description of a specific cutter is continued in the next column.

PHOTO OF INSERT

PAGE TO GO TO
indicates the reference pages for detailed standards of specific inserts.



GRADE APPLICATION RECOMMENDED FOR EACH WORK MATERIAL
cutting conditions suitable for each work materials are shown as a general guide to select grade.
●:Stable Cutting ◐:General Cutting ✠:Unstable Cutting

PAGE TITLE BY TOOL APPLICATION

INSERT NUMBER

INSERT TOLERANCE ▪ HONING

INSERT GRADE

INSERT GEOMETRY

INSERT DIMENSIONS

STOCK STATUS

LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

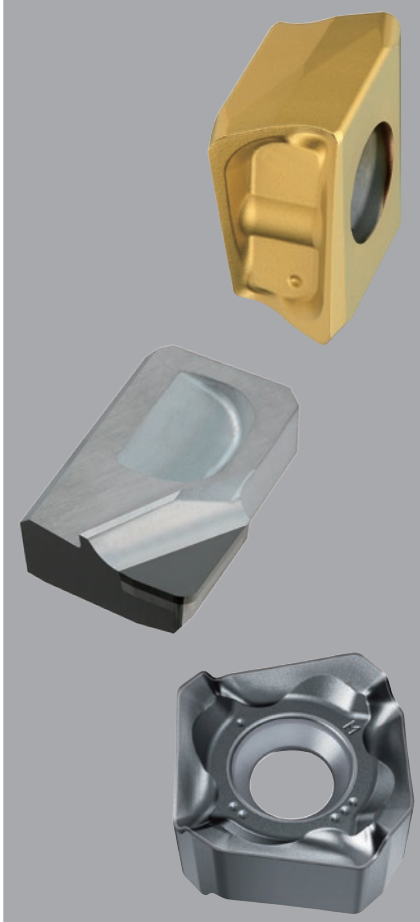
●To Order : Please specify
①insert number and grade.

MILLING TOOLS

INSERT STANDARDS
CBN & PCD INSERT STANDARDS
INSERT GRADES

IDENTIFICATION L002
GRADES FOR MILLING L004
MILLING APPLICATION RANGE L005
COATED CARBIDE(CVD & PVD) L008
CERMET L010
CEMENTED CARBIDE L011
CBN(SINTERED CBN) L012
PCD(SINTERED DIAMOND) L013
CLASSIFICATION L014

STANDARD ROTATING TOOL INSERTS
- ROTATING INSERTS L024
- WIPER INSERTS L050
- CBN & PCD INSERTS L052
- CBN & PCD INSERTS WITH WIPER L055
- DRILLING INSERTS L056



IDENTIFICATION

Symbol	Insert Shape
N	Heptagonal
O	Octagonal
S	Square
T	Triangular
C	Rhombic80°
M	Rhombic86°
A	Parallelogram85°
R	Round
X	Special Design
W	Wiper

① Insert Shape

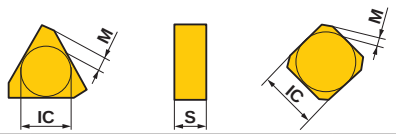
Symbol	Normal Clearance AN
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Other Normal Clearance
X	Other Normal Clearance

② Normal Clearance

① ② ③ ④

S E E R

③ Tolerance Class



Symbol	Tolerance of Nose Height M (mm)	Tolerance of Inscribed Circle IC (mm)	Tolerance of Thickness S (mm)
A	±0.005	±0.025	±0.025
C	±0.013	±0.025	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
K*	±0.013	±0.05−±0.15	±0.025
M*	±0.08−±0.18	±0.05−±0.15	±0.13
N*	±0.08−±0.18	±0.05−±0.15	±0.025

The surface of insert with * mark is sintered.

④ Fixing and/or for Chip Breaker

Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole + One Countersink (40°−60°)	No	
T	With Hole		Single Sided	
B	With Hole	Cylindrical Hole + One Countersink (70°−90°)	No	
N	Without Hole	–	No	
R	Without Hole	–	Single Sided	
X	–	–	–	Special Design

Symbol R	Symbol C	Symbol S	Symbol T	Diameter of Inscribed Circle
	06	06	11	6.35
	08	07	13	7.94
	09	09	16	9.525
10				10.00
12				12.00
	12	12	22	12.70
	16	15	27	15.875
20				20.00

⑤ **Insert Size**

Symbol	Insert Thickness (mm)
03	3.18
T3	3.97
04	4.76

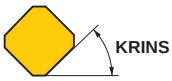
⑥ **Insert Thickness**

Symbol	Honing
F	Sharp
E	Round
T	Chamfer
S	Chamfer+Hone
Z	Chamfer (Strong Cutting Edge Type)

⑨ **Cutting Edge Condition**

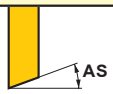
⑤	⑥			⑨				
12	03	A	F	E	R	1	-	JS
		⑦	⑧		⑩	⑪		⑫

⑦ **Wiper Insert Cutting Angle**



Symbol	Wiper Insert Cutting Angle
A	45°
E	75°
P	90°
Z	Other Angle

⑧ **Clearance of Wiper Insert**

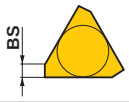


Symbol	Clearance Angle
D	15°
E	20°
F	25°
G	30°

⑩ **Hand Tool Holder**

Symbol	Hand Tool Holder
L	Left Hand Tool Holder
N	For Both Right and Left Hand Tool Holder
R	Right Hand Tool Holder

⑪ **Width of Wiper Insert**



Symbol	Width of Wiper Insert
1	1.4 (1.94 only for TEKN)

⑫ **Chip Breaker**

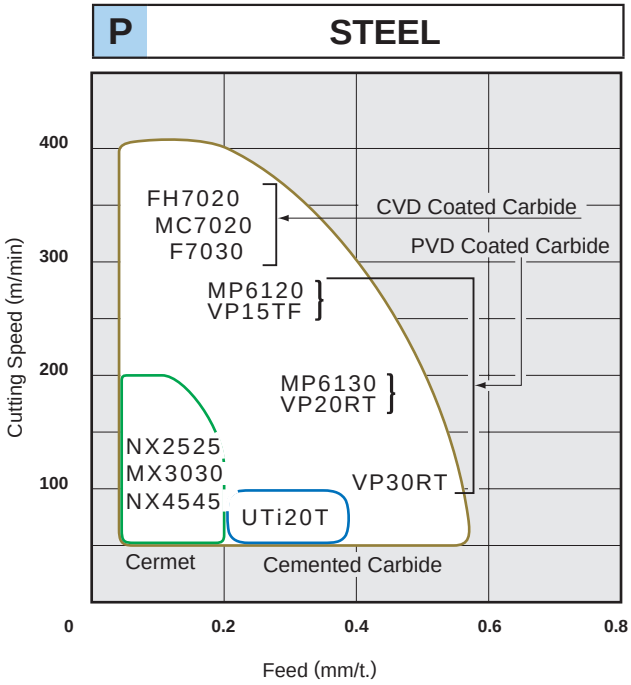
Symbol	Name
FT	FT Breaker
HS	HS Breaker
JH	JH Breaker
JM	JM Breaker
JP	JP Breaker
JS	JS Breaker
LS	LS Breaker
MM	MM Breaker
MS	MS Breaker

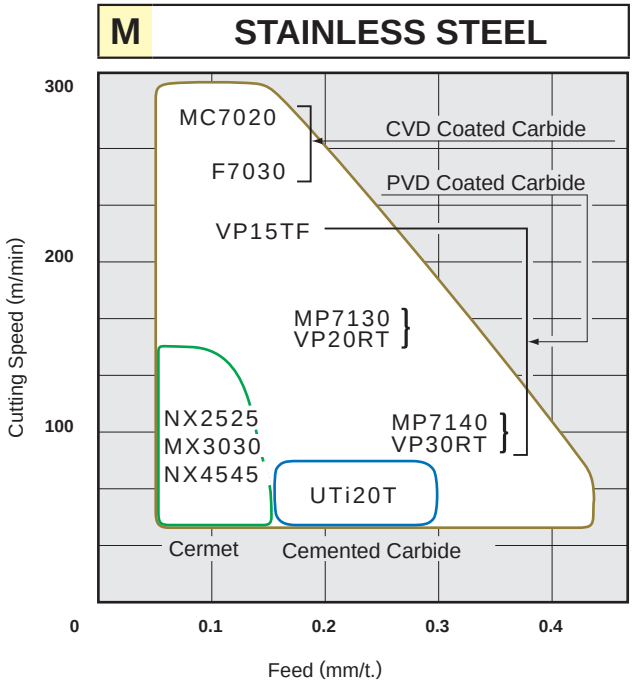
GRADES FOR MILLING

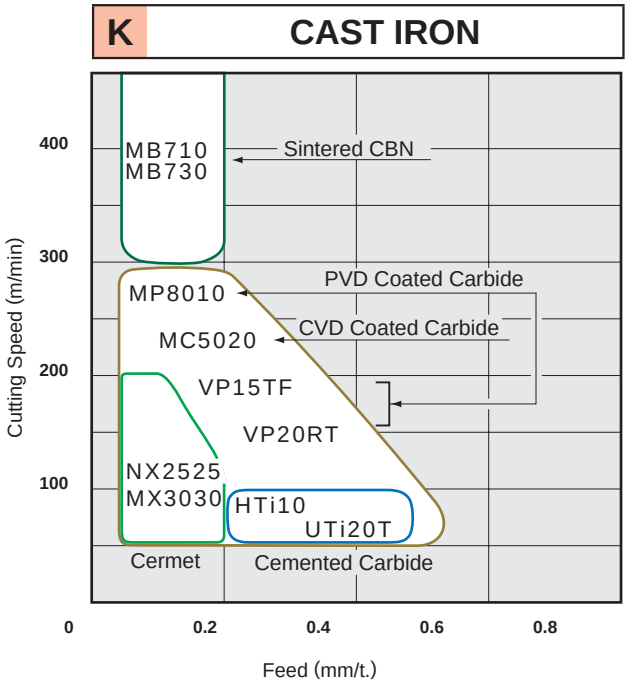
●INDEXABLE INSERT GRADES FOR MILLING

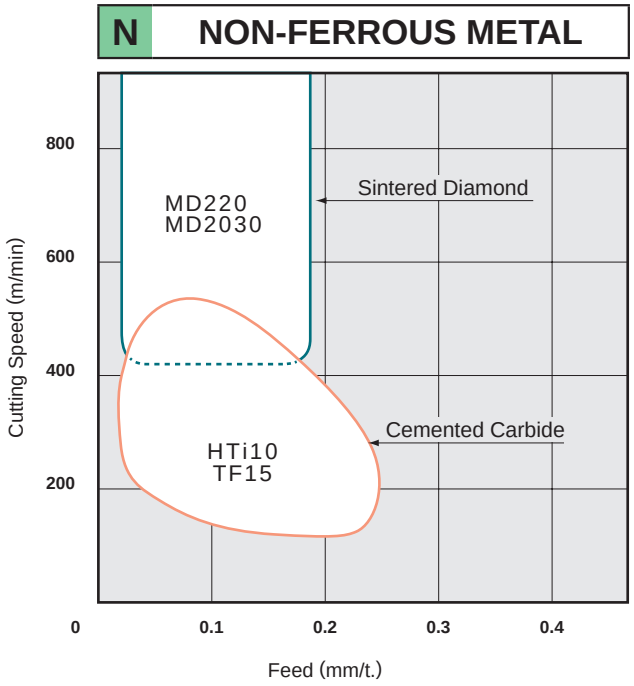
ISO			Coated Carbide CVD	Coated Carbide PVD	Coated Cermet	Cermet	Cemented Carbide	CBN (Sintered CBN)	PCD (Sintered Diamond)
Steel	P	10	MC7020	MP6120	VP25N	NX2525	UTi20T		
		20	FH7020	VP15TF		MX3020 NEW			
		30	F7030	MP6130		MX3030			
		40		UP20M		NX4545			
				VP20RT					
				VP30RT					
Stainless Steel	M	10	MC7020	VP15TF	VP25N	NX2525	UTi20T		
		20	F7030	MP7130		MX3020 NEW			
		30		MP7030		MX3030			
		40		UP20M		NX4545			
				VP20RT					
				MP7140					
				VP30RT					
Cast Iron	K	10	MC5020	MP8010	VP25N	NX2525	HTi05T	MB710	
		20		VP15TF		MX3020 NEW	HTi10	MB730	
		30		VP20RT		MX3030	UTi20T		
Non-Ferrous Metal	N	10					HTi10		MD205
		20		LC15TF					MD220
		30					TF15		MD230
									MD2030
Heat Resistant Alloy • Ti Alloy	S	10		MP9120				MB730	
		20		VP15TF					
		30		MP9130					
		40		MP9140 NEW					
				MP9030					
Hardened Materials	H	10		MP8010					
		20		VP15TF					
		30							

MILLING APPLICATION RANGE





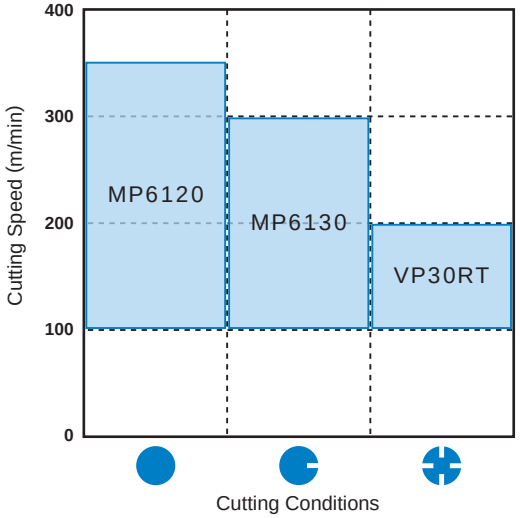




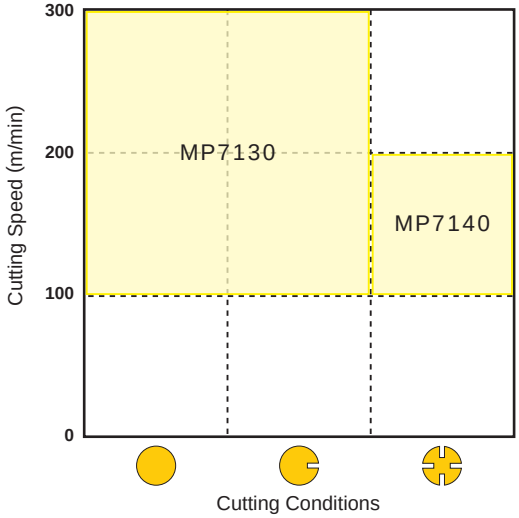
MILLING APPLICATION RANGE

●Recommendation of the insert grade based on cutting speed and conditions for each workpiece.

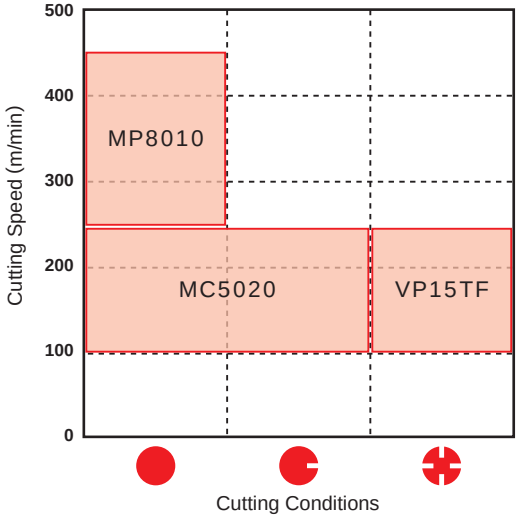
P STEEL (Medium to Rough Cutting)



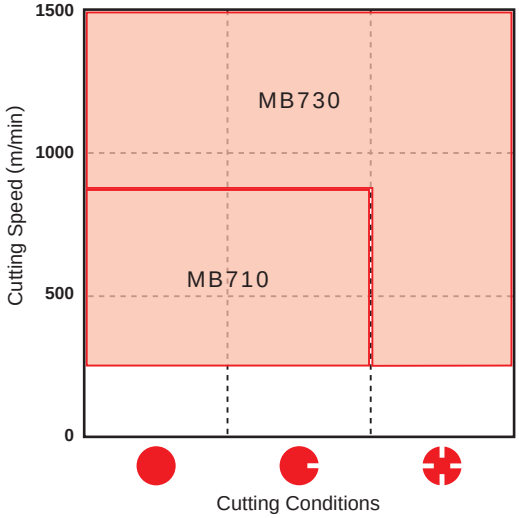
M STAINLESS STEEL



K CAST IRON



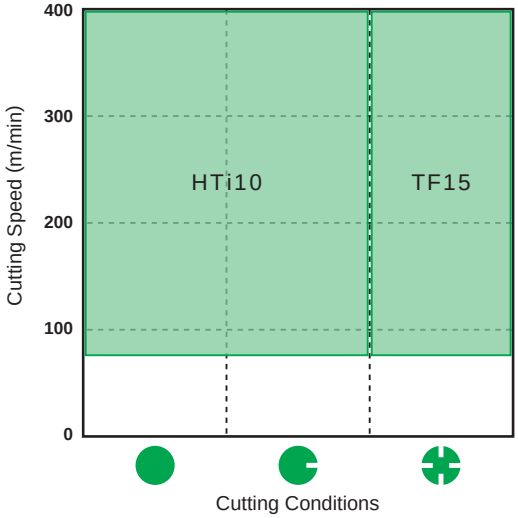
K CAST IRON (CBN)



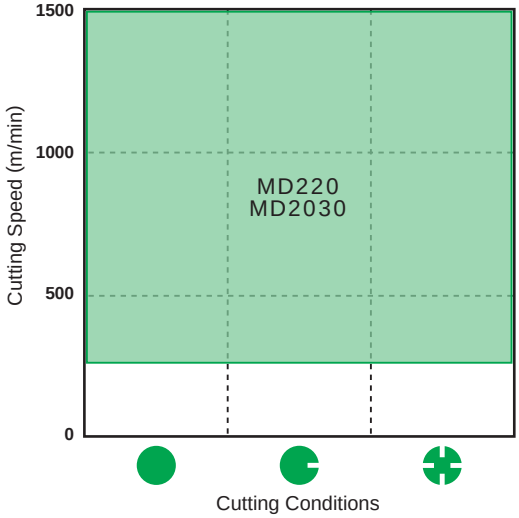
■CUTTING CONDITIONS

●	Stable Cutting	Plane Cutting Constant Depth of Cut Pre-Machined Securely Clamped Component Cutting
◐	General Cutting	
✚	Unstable Cutting	Heavy Interrupted Cutting Irregular Depth of Cut Low Clamping Rigidity Cutting

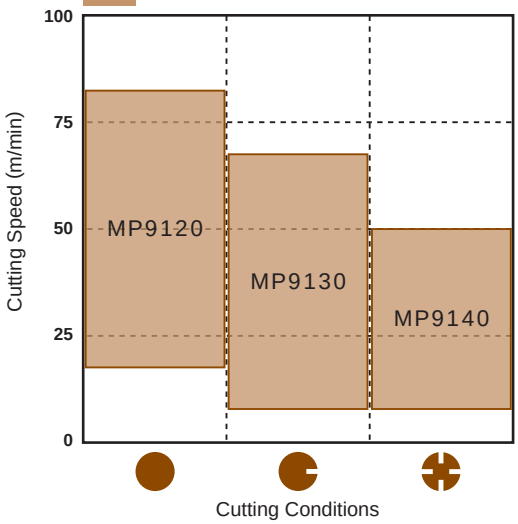
N NON-FERROUS METAL



N NON-FERROUS METAL (PCD)



S HEAT RESISTANT ALLOY, TITANIUM ALLOY



COATED CARBIDE (CVD&PVD)

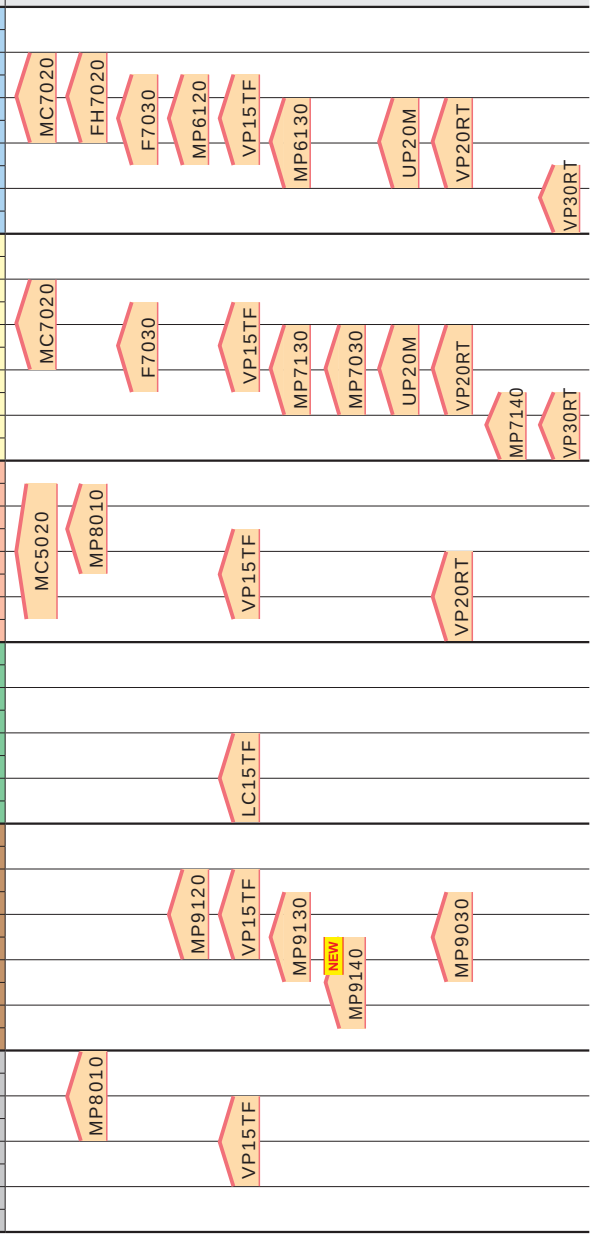
<CVD>
- Special tough fibrous structure improves wear and fracture resistance.
- It covers a wide application range and reduces the number of tools required.

<PVD>
- PVD coating prolongs tool life when compared to cemented carbide under the same cutting conditions.
- Coating of tools with sharp edges is possible without softening or changing the quality of the subsrate.

■SELECTION STANDARD

MILLING

Work Material		Recommended Grade	Recommended Cutting Speed (m/min)
P	Steel	F7030	200 (150 – 250)
		MC7020	200 (150 – 250)
		MP6120	150 (100 – 200)
		MP6130	150 (100 – 200)
		VP15TF	150 (100 – 200)
M	Stainless Steel	F7030	200 (150 – 250)
		MC7020	220 (170 – 270)
		MP7030	150 (100 – 200)
		MP7130	150 (100 – 200)
		MP7140	150 (100 – 200)
		VP15TF	150 (100 – 200)
K	Cast Iron	MC5020	180 (100 – 250)
		VP15TF	150 (100 – 200)
N	Aluminium Alloy	LC15TF	1000 (200 – 3000)
S	Heat Resistant Alloy Ti Alloy	MP9120	30 (20 – 40)
		VP15TF	30 (20 – 40)
		MP9030	40 (25 – 60)
		MP9130	25 (20 – 35)
		NEW MP9140	20 (15 – 30)
H	Hardened Materials	MP8010	80 (50 – 120)
		VP15TF	80 (50 – 120)



L

ROTATING TOOL INSERTS

■GRADE CHARACTERISTICS

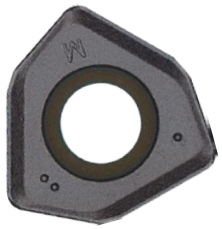
Grade	Substrate	Coating Layer	
	Hardness (HRA)	Composition	Thickness
MC5020	91.0	TiCN-Al_2O_3-Ti Compound	Thick
MC7020	88.8	TiCN-Al_2O_3 Compound	Thick
FH7020	88.8	TiCN-Al_2O_3-Ti Compound	Thick
F7030	88.8	TiCN-Al_2O_3-TiN	Thin
MP6120	91.5	(Al,Ti,Cr)N	Thin
MP6130	90.5	(Al,Ti,Cr)N	Thin
MP7030	90.5	(Al,Ti)N-Ti Compound	Thin
MP7130	90.5	(Al,Ti)N-Ti Compound	Thin
MP7140	88.8	(Al,Ti)N-Ti Compound	Thin

Grade	Substrate	Coating Layer	
	Hardness (HRA)	Composition	Thickness
MP8010	93.5	(Al,Ti,Si)N	Thin
MP9120	91.5	(Al,Ti,Cr)N	Thin
MP9030	90.5	(Al,Ti)N-Ti Compound	Thin
MP9130	90.5	(Al,Ti,Cr)N	Thin
NEW **MP9140**	89.0	Al-(Al,Ti)N	Thin
VP15TF	91.5	(Al,Ti)N	Thin
VP20RT	90.5	(Al,Ti)N	Thin
VP30RT	88.8	(Al,Ti)N	Thin
UP20M	90.5	Ti Compound	Thin

Note 1) Internal hardness represent typical values shown as hardness.

For machining of steels and stainless steels

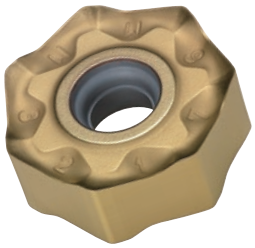
MC7020



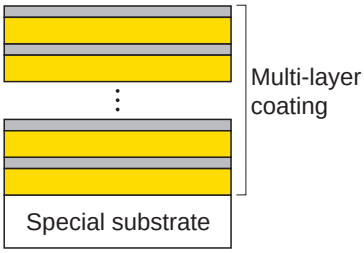
The micro-grain wear resistant Al_2O_3 and fibrous TiCN layers deliver excellent wear resistance in high speed cutting. Use of a specially developed cemented carbide that provides superior resistance to fracture and thermal cracking prevents the cutting edge from sudden fracturing.

For machining of stainless steel

MP7030



MP7030 has a multi-layer coating based on newly developed Ti-compound. It provides superior wear and fracture resistance in stainless steel machining. A special tough cemented carbide substrate gives excellent performance in machining of difficult-to-cut materials such as stainless steel.



Heat-resistant Alloy, Cutting For Titanium Alloy

MP9130

An enhanced super fine cemented carbide substrate has increased toughness while maintaining hardness. The Al-Ti-Cr-N accumulating coating ensures optimum heat and wear resistance. The combination of these properties gives excellent fracture resistance and welding resistance because of low coefficient of friction when machining titanium alloy.

NEW

MP9140

The new technology Al-(Al, Ti)N coating provides stabilisation of the high hardness phase and succeeds in dramatically improving wear, crater and welding resistance.

CERMET

- **NX2525 for high speed milling.**
- **NX4545, MX3030 for general milling.**

■SELECTION STANDARD

MILLING

	Work Material	Recommended Grade	Recommended Cutting Speed (m/min)	ISO	Application Range
P–M	Steel Stainless Steel	**NX2525**	250 (150 — 350)	P–M 10–30	NX2525
		MX3030 **NX4545**	150 (120 — 180)		MX3030, NX4545
K	Cast Iron	**NX2525**	200 (150 — 300)	K 10–20	NX2525
		MX3030	150 (120 — 180)		MX3030

Note 1) In case of wet cutting, please use coated carbide VP15TF for steel cutting and coated carbide MC5020 for cast iron cutting.

■GRADE CHARACTERISTICS

Grade	Hardness (HRA)
NX2525	92.2
MX3030	90.0
NX4545	90.0

Note 1) Internal hardness represent typical values shown as hardness.

CEMENTED CARBIDE

● **Available grade series are UTi20T for steel and cast iron, and HTi10 for cast iron, non-ferrous metal and non-metal.**

■SELECTION STANDARD

MILLING

	Work Material	Recommended Grade	Recommended Cutting Speed (m/min)	ISO	Application Range
P	Steel	**UTi20T**	120 (50 — 180)	P 10 20 30	UTi20T
M	Stainless Steel	**UTi20T**	120 (50 — 180)	M 10 20 30	UTi20T
K	Cast Iron	**HTi10**	100 (50 — 150)	K 10 20 30	HTi10
		UTi20T	120 (50 — 180)		UTi20T
N	Non-Ferrous Metal	**HTi10** **TF15**	400 (300 — 500)	N 10 20 30	HTi10 TF15

■MAIN COMPONENT AND APPLICATION

ISO	Main Component	Characteristics	Work Material
P M	WC-TiC-TaC-Co	Heat / Deformation resistance.	Carbon steel, Alloy steel, Stainless steel and Cast iron
K N	WC-Co	High rigidity and wear resistance.	Cast iron, Non-Ferrous metals and Non-metal

■GRADE CHARACTERISTICS

ISO	Grade	Hardness (HRA)
P M	**UTi20T**	90.5
K N	**HTi05T**	92.5
	HTi10	92.0
N	**TF15**	91.5

Note 1) Internal hardness represent typical values shown as hardness.

CBN (SINTERED CBN)

- **MB710 and MB730 for cast iron cutting.**
- **BC5030 for high speed machining of cast irons available.**
- **Due to the combination of the BC5030 insert geometry and the AOX allows the use of up to 16 corners per insert, enabling cost effective high efficiency machining.**

■SELECTION STANDARD / RECOMMENDED CUTTING CONDITIONS

FINISHING

Work Material		Structure	Cutting Speed (m/min) 250 500 750 1000 1250	Feed (mm/t.)	Depth of Cut (mm)	Coolant
Grey Cast Iron	JIS FC250	Ferritic + Pearilitic	MB710 / MB730	—0.3	—0.5	Dry
	JIS FC300	Pearilitic				

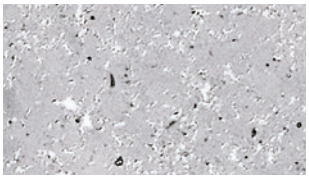
ROUGHING

Work Material		Structure	Cutting Speed (m/min) 250 500 1000 1500 2000	Feed (mm/t.)	Depth of Cut (mm)	Coolant
Grey Cast Iron	JIS FC250	Pearilitic	BC5030	—0.15	—3.0	Dry

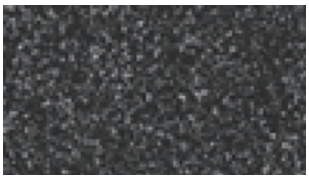
■FEATURES AND BASE

Grade	Application	Features	Main Component	Coating Layer
MB710	For General Cutting	General purpose grade with well balanced wear and fracture resistance.	CBN TiC Al_2O_3	—
MB730	For High Speed Cutting For interrupted Cutting	Has the largest CBN content and therefore displays good thermal conductivity. It is suitable for the high temperatures that are generated in high speed cutting.	CBN (High Content) Co Base Alloy	—
BC5030	For high-speed machining at large depths of cut High-speed interrupted machining at large depths of cut	High CBN content and high thermal conductivity. The whole insert is composed of sintered CBN. This enables high speed, high efficiency machining at larger depths of cut. The coated grade for easy recognition of used corners.	CBN AlN	TiN

PCD (SINTERED DIAMOND)



Micro-Structure of **MD220**



Micro-Structure of **MD2030**

- **Suitable for non-ferrous metals cutting such as aluminium alloy.**
- **Suitable for extremely high speed finishing.**

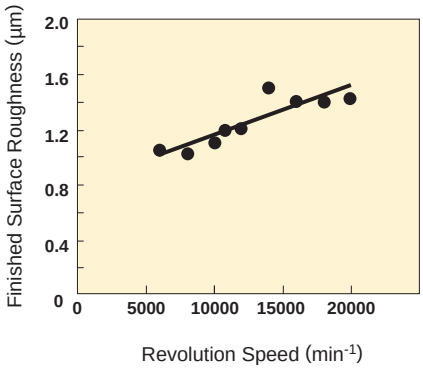
■GRADE FEATURES

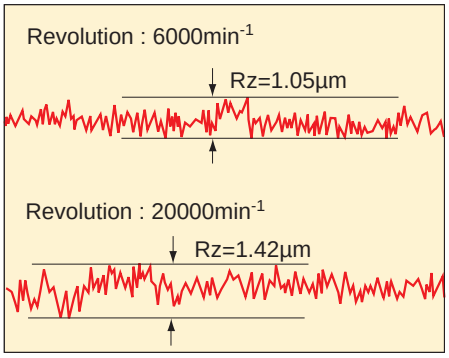
Grade	Features
MD220	Excellent in the balance between wear resistance and fracture resistance. For a wide range of tooling applications.
MD2030	Improved fracture resistance when used in unstable applications. The stability of the cutting edge can meet a wide variety of work material and cutting conditions.

■RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Speed (m/min)	Grade	Feed per Tooth (mm/t.)	Depth of Cut (mm)
Aluminium Alloy (Si ≤12%)	1000—6000	**MD220** **MD2030**	—0.3	—0.5
Aluminium Alloy (Si ≥13%)	200—800			

■CUTTING PERFORMANCE





<Cutting Conditions>
Workpiece : JIS A7075-T6
Insert : NP-GDCW1240PDFR2
Grade : MD220
Tool : V10000R0406D
Feed : 0.2mm/t.
Depth of Cut : 0.5mm
Width of Cut : 80mm
Dry Cutting

CLASSIFICATION

Cutter Type Shape	Order Number	Page
AF5000	LDCN190412R	L052
	LDCN190412L	
AF10000	GDCN2004PDR	L052
AHX440S AHX475S	NNMU130508ZER-L	L032
	NNMU130508ZEN-M	
	NNMU130532ZEN-M	
	NNMU130532ZEN-R	
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AHX640S	NNMU200708ZEN-M	L032
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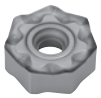	NNMU200712ZER-L	L033
	NNMU200712ZER-MM	L032

Cutter Type Shape	Order Number	Page
AHX640S	WNEU2007ZEN7C-M	L051
	WNEU2007ZEN7C-WP	L051
	NNMU200608ZEN-MK	L033
	NNMU200608ZEN-HK	L033
	WNEU2006ZEN7C-WK	L051
AHX640W	NNMU200608ZEN-MK	L033
	NNMU200608ZEN-HK	L033
	WNEU2006ZEN7C-WK	L051

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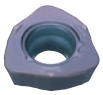
	JOMW080320ZZSR-FT	
	JDMW09T320ZDSR-FT	
	JDMW120420ZDSR-FT	
	JDMW140520ZDSR-FT	
	JOMT06T215ZZSR-JM	L026
	JOMT080320ZZSR-JM	
	JDMT09T320ZDSR-JM	
	JDMT120420ZDSR-JM	
	JDMT140520ZDSR-JM	
	JDMT120420ZDSR-ST	L026
	JDMT140520ZDSR-ST	
	JOMT06T216ZZER-JL	L026
	JOMT080322ZZER-JL	
	JDMT09T323ZDER-JL	
	JDMT120423ZDER-JL	
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AOX445	SL-ONEN120404ASN	L053
APX3000	AOGT123602PEFR-GM	L024
	AOGT123604PEFR-GM	
	AOGT123608PEFR-GM	
	AOMT123602PEER-M	L024
	AOMT123604PEER-M	
	AOMT123608PEER-M	
	AOMT123610PEER-M	
	AOMT123612PEER-M	
	AOMT123616PEER-M	
	AOMT123620PEER-M	
	AOMT123624PEER-M	
	AOMT123630PEER-M	
	AOMT123632PEER-M	

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APX3000	AOMT123604PEER-H	L024
	AOMT123608PEER-H	
	AOMT123616PEER-H	
APX4000	AOMT184804PEER-H	L024
	AOMT184808PEER-H	
	AOMT184816PEER-H	
	AOMT184832PEER-H	
	AOMT184840PEER-H	
	AOMT184850PEER-H	
	AOMT184864PEER-H	
	AOMT184804PEER-M	L024
	AOMT184808PEER-M	
	AOMT184810PEER-M	
	AOMT184812PEER-M	
	AOMT184816PEER-M	
	AOMT184820PEER-M	
AQX	QOMT0830R-M2	L034
	QOMT1035R-M2	
	QOMT1342R-M2	
	QOMT1651R-M2	
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	QOMT2062R-M2	
	QOMT2576R-M2	
	QOGT0830R-G1	L034
	QOGT1035R-G1	
	QOGT1342R-G1	
	QOGT1651R-G1	
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	QOGT2576R-G1	

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	RPHT1040M0E4-R	
	RPHT1248M0E4-L	
	RPHT1248M0E4-M	
	RPHT1248M0E4-R	
	RPMT1040M0E4-L	
	RPMT1040M0E4-M	
	RPMT1040M0E4-R	
	RPMT1248M0E4-L	
	RPMT1248M0E4-M	
	RPMT1248M0E4-R	
ARX	RDMW0517M0E	L034
	RDMW0620M0E	
	RDMW0724M0E	
ASX400 ASX400 Side Cutter	SOET12T308PEER-JL	L038
	SOMT12T308PEER-JM	L039
	SOMT12T308PEEL-JM	
	SOMT12T308PEER-JH	L038
	SOMT12T320PEER-FT	L039
	SOGT12T308PEFR-JP	L038
	WOEW12T308PEER8C	L051
	WOEW12T308PETR8C	

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ASX445	SEET13T3AGEN-JL	L037
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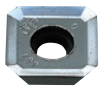
	SEMT13T3AGSN-FT	L037
	SEGT13T3AGFN-JP	L037
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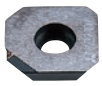	WEEW13T3AGFR3C	L055
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	XDGX175008PDFR-GL	
	XDGX175012PDFR-GL	
	XDGX175016PDFR-GL	
	XDGX175020PDFR-GL	
	XDGX175024PDFR-GL	
	XDGX175030PDFR-GL	
	XDGX175032PDFR-GL	
	XDGX175040PDFR-GL	
	XDGX175050PDFR-GL	
	XDGX175004PDER-GM	L046
	XDGX175008PDER-GM	
	XDGX175012PDER-GM	
	XDGX175016PDER-GM	
	XDGX175020PDER-GM	
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	XDGX175030PDER-GM	
	XDGX175032PDER-GM	
	XDGX175040PDER-GM	
	XDGX175050PDER-GM	
	XDGX175004PDFR-GM	L046
	XDGX175008PDFR-GM	
	XDGX175012PDFR-GM	
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	XDGX175024PDFR-GM	
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	XDGX175032PDFR-GM	
	XDGX175040PDFR-GM	
	XDGX175050PDFR-GM	

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AXD7000	XDGX227008PDFR-GL	L047
	XDGX227016PDFR-GL	
	XDGX227020PDFR-GL	
	XDGX227030PDFR-GL	
	XDGX227032PDFR-GL	
	XDGX227040PDFR-GL	
	XDGX227050PDFR-GL	
	XDGX227008PDER-GLA	L047
	XDGX227016PDER-GLA	
	XDGX227020PDER-GLA	
	XDGX227024PDER-GLA	
	XDGX227030PDER-GLA	
	XDGX227032PDER-GLA	
	XDGX227040PDER-GLA	
	XDGX227050PDER-GLA	
BAE	AEMW150304ER	L024
	AEMW150308ER	
	AEMW19T304ER	
	AEMW19T308ER	
BAP300 SRM2	APMT1135PDER-H1	L025
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	APMT1135PDER-H3	
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	APMT1135PDER-H6	
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	APMT1135PDER-M2	
	APGT1135PDFR-G2	L025

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	XPMT13T3PDER-M2	
	XPMT13T3PDER-M6	
	XPMT13T3PDER-M75	
	XPMT13T3PDER-M8	
	XPGT13T3PDFR-G1	L049
	XPGT13T3PDFR-G2	
	XPGT13T3PDFR-G6	
	XPGT13T3PDFR-G75	
	XPGT13T3PDFR-G8	
	XPGT13T3PDER-G1	L049
	XPGT13T3PDER-G2	
	XPGT13T3PDER-G6	
	XPGT13T3PDER-G75	
	XPGT13T3PDER-G8	
BAP400 SRM2	APMT1604PDER-H1	L025
	APMT1604PDER-H2	
	APMT1604PDER-H4	
	APMT1604PDER-H6	
	APMT1604PDER-H8	
	APMT1604PDER-M2	L025
	APGT1604PDFR-G2	L025

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	SFAN1203ZFFL2	
	SFCN1203ZFFR2	
	SFCN1203ZFFL2	
	SFCN1203ZFFR2	L053
	WFC42ZFER2	L055
	NP-WFC42ZFER2	L055
BMR	HNMX1206EN06-R	L026
	HNMX1206ER12-R	L026
BN425 DN	SNC43B2G	L038
	SNC43B2S	
	SNK43B2G	
	SNK43B2S	
	SNKF43B2S	L038
	SNMF43B2G	

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	RPMW10T3M0E	
	RPMW10T3M0T	
	RPMW1204M0E	
	RPMW1204M0T	
	RPMW1606M0E	
	RPMW1606M0T	
	RPMT08T2M0E-JS	L035
	RPMT10T3M0E-JS	
	RPMT1204M0E-JS	
	RPMT1606M0E-JS	
BSP	SPMB1204APT	L040
BXD4000	XDGT1550PDER-G04	L045
	XDGT1550PDER-G08	
	XDGT1550PDER-G12	
	XDGT1550PDER-G16	
	XDGT1550PDER-G20	
	XDGT1550PDER-G30	
	XDGT1550PDER-G32	
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	SPMW120304	
	SPMW120308	
DCCC	CCMX083508EN-A	L025
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	ZCMX083508ER-A	L049
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	SPNN1203EEER1	
	SPNN1203EEEL1	
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FF3000	SPCA53Z	L039
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FMAX	GOER1404PXFR2	L052
	GOER1408PXFR2	
	NEW GOER1408PXFR2-8	L052
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FMSD	SDEN1203AEN	L035
	SDKN1203AEN	
	SDKN1203AETN	
	SDKN1504AETN	

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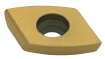
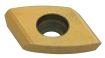
NF10000	GDCN2004PDFR3	L052
NF10000	NP-GDCN2004PDSR3	L053
NR10000	GDCN2004ZDTR1	L052
MG200	MGEEW1035PFTR	L031
MG300 	MGEEW1242PFTR	L031
MG400	MGEEW1650PFTR	L031
MG245	MGEEW1035AFTR	L031
MG345 	MGEEW1242AFTR	L031
MG445	MGEEW1650AFTR	L031

Cutter Type Shape	Order Number	Page
MVX	NEW SOMX052704-UM	L056
	SOMX063005-UM	L056
	SOMX073505-UM	
	SOMX084005-UM	
	SOMX094506-UM	
	SOMX115506-UM	
	SOMX136008-UM	
	SOMX166508-UM	
	SOMX187008-UM	
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	SOMX084005-US	
	SOMX094506-US	
	SOMX115506-US	
	SOMX136008-US	
	SOMX166508-US	
	SOMX187008-US	
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	SOMX083905-UH	
	SOMX094406-UH	
	SOMX115406-UH	
	SOMX135908-UH	
	SOMX166408-UH	
	SOMX186908-UH	
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	SOGX084005-UN	
	SOGX094506-UN	
	SOGX115506-UN	
	SOGX136008-UN	
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	TEEN1603PEER1	
	TEEN1603PETR1	
	TEEN1603PESR1	
	TECN1603PEFR1W	L044
	TECN1603PEER1W	
	TECN1603PETR1W	
	TEER1603PEER-JS	L044
	TECN1603PEFR1	L054
NSE400 SE400	TECN2204PEFR1	L044
	TECN2204PEER1	
	TECN2204PETR1	
	TEEN2204PEFR1	
	TEEN2204PEER1	
	TEEN2204PETR1	
	TEEN2204PESR1	
	TEKN2204PEER1	
	TEKN2204PESR1	
	TEKN2204PETR1	
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	TEER2204PEER-JS	L044
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	OEMX1705ESR1	
	OEMX1705ETR1	
	OEMX12T3ETR1	L053
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	OEMX1705EER1-JS	
	OEMX1705ETR1-JS	
	REMX1705SN	L034
	REMX12T3EN-JS	L034
	REMX1705EN-JS	
PMF	TPEW1303ZPER2	L044
	TPEW1303ZPTR2	L054
PMR	CPMT1205ZPEN-M2	L026
	CPMT1205ZPEN-M3	
	CPMT1906ZPEN-M2	
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S400	SPMN120304	L040
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	SPMN120308	
	SPMN120312	
	SPMN120408	
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	SPGN120312	
S500	SPMN150408	L040
	SPMN150412	
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	SPGN150408	
SE415 QSE415	SEEN1203EFFR1	L036
	SEEN1203EFER1	
	SEEN1203EFTR1	
	SEEN1203EFSR1	
	SEKN1203EFSR1	L036
	SEKN1203EFTR1	
	SEKN1203EFTR	
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	WEC42EFER5C	L050
	WEC42EFTR5C	

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	SEEN1203AFEN1	
	SEEN1203AFTN1	
	SEEN1203AFSN1	
	SEKN1203AFSN1	
	SEKN1203AFTN1	
	SEKN1203AFTN	
	SEER1203AFEN-JS	L036
	SECN1203AFFR1	L053
	WEC42AFTR5C	L050
SE515	SECN1504EFTR1	L036
	SEEN1504EFER1	
	SEEN1504EFSR1	
	SEEN1504EFTR1	
	SEKN1504EFSR1	
	SEKN1504EFTR1	
	WEC53EFTR5C	L050
SE545	SEEN1504AFEN1	L036
	SEEN1504AFSN1	
	SEEN1504AFTN1	
	SEKN1504AFSN1	
	SEKN1504AFTN1	
	SEER1504AFEN-JS	L036

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SG20	RGEN2004M0EN	L035
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SPX	JPMX140412-JM	L027
	JPMX190412-JM	
	JPMX140412-WH	L027
	JPMX190412-WH	
	MPMX120412-JM	L032
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	SRBT30	
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SRF	SRFT10	L041
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	SRM32C-M	
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	SRM30E-M	
	SRM32E-M	
	SRG16C	L042
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	SRG30C	
	SRG32C	
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	SRG25E	
	SRG30E	
	SRG32E	
SRM2 ϕ40 ϕ50	SRG40C	L042
	SRG50C	
	SRG40E	L042
	SRG50E	
	APMT1135PDER-H2	L025
	APMT1604PDER-H2	
	APMT1135PDER-M2	L025
	APMT1604PDER-M2	

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	STAWN○○○○○T	L062
	STAWN○○○○○TH	
SUF	SUFT10R05	L043
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Cutter Type Shape	Order Number	Page
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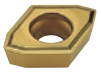
	GCMT040204-U2	L056
	GPMT060204-U1	L056
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	GPMT090304-U1	
	GPMT11T308-U1	
	GPMT140408-U1	
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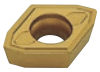
	GPMT070204-U2	
	GPMT090304-U2	
	GPMT11T308-U2	
	GPMT140408-U2	
	GPMT060204-U3	L056
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	GPMT090304-U3	
	GPMT11T308-U3	
	GPMT140408-U3	
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	TAWKH○○○○○TG	L060
	TAWBH○○○○○T	L059
	TAWC12T301-45GM	L061

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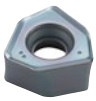
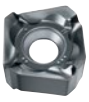
TSMP	MPMW070308	L031
	MPMW090308	
	MPMW120408	
V10000	NP-GDCW1240PDFR2	L053
VAS400 Side Cutter	LNGU130804PNER-M	L028
	LNGU130804PNEL-M	
	LNGU130808PNER-M	
	LNGU130808PNEL-M	
	LNGU130812PNER-M	
	LNGU130812PNEL-M	
	LNGU130816PNER-M	
	LNGU130816PNEL-M	
	LNGU130820PNER-M	
	LNGU130820PNEL-M	
	LNGU130824PNER-M	
	LNGU130824PNEL-M	
	LNGU130830PNER-M	
	LNGU130830PNEL-M	
	LNGU130840PNER-M	
	LNGU130840PNEL-M	
	LNGU130850PNER-M	
	LNGU130850PNEL-M	

CLASSIFICATION

Cutter Type Shape	Order Number	Page
VAS400 Side Cutter NEW	LNGU130804PNER-R	L028
	LNGU130804PNEL-R	
	LNGU130808PNER-R	
	LNGU130808PNEL-R	
	LNGU130812PNER-R	
	LNGU130812PNEL-R	
	LNGU130816PNER-R	
	LNGU130816PNEL-R	
	LNGU130820PNER-R	
	LNGU130820PNEL-R	
	LNGU130824PNER-R	
	LNGU130824PNEL-R	
	LNGU130830PNER-R	
	LNGU130830PNEL-R	
	LNGU130840PNER-R	
	LNGU130840PNEL-R	
	LNGU130850PNER-R	
	LNGU130850PNEL-R	
VAS500 Side Cutter NEW	LNGU171004PNER-R	L029
	LNGU171004PNEL-R	
	LNGU171008PNER-R	
	LNGU171008PNEL-R	
	LNGU171012PNER-R	
	LNGU171012PNEL-R	
	LNGU171016PNER-R	
	LNGU171016PNEL-R	
	LNGU171020PNER-R	
	LNGU171020PNEL-R	
	LNGU171024PNER-R	
	LNGU171024PNEL-R	
	LNGU171030PNER-R	
	LNGU171030PNEL-R	
	LNGU171040PNER-R	
	LNGU171040PNEL-R	
	LNGU171050PNER-R	

Cutter Type Shape	Order Number	Page
VAS500 Side Cutter NEW	LNGU171050PNEL-R	L029
	LNGU171060PNER-R	
	LNGU171060PNEL-R	
	LNGU171070PNER-R	
	LNGU171070PNEL-R	
VFX5	XNMU160708R-MS	L048
	XNMU160712R-MS	
	XNMU160716R-MS	
	XNMU160724R-MS	
	XNMU160732R-MS	
	XNMU160740R-MS	
	XNMU160708R-HS	L048
	XNMU160708R-LS	L048
VFX6	XNMU190912R-MS	L048
	XNMU190916R-MS	
	XNMU190924R-MS	
	XNMU190932R-MS	
	XNMU190940R-MS	
	XNMU190950R-MS	
	XNMU190912R-HS	L048
	XNMU190912R-LS	L048

Cutter Type Shape	Order Number	Page
VOX400 VOS400 Side Cutter	SONX1206PER	L039
	SONX1206PEL	
	WOEX1206PER5C	L051
VIPER	TPNX1605N	L045
VPX200 NEW	LOGU0904020PNER-L	L030
	LOGU0904040PNER-L	
	LOGU0904080PNER-L	
	LOGU0904100PNER-L	
	LOGU0904120PNER-L	
	LOGU0904160PNER-L	
	LOGU0904020PNFR-L	
	LOGU0904040PNFR-L	
	LOGU0904080PNFR-L	
	LOGU0904100PNFR-L	
	LOGU0904120PNFR-L	
	LOGU0904160PNFR-L	
NEW	LOGU0904020PNER-M	L030
	LOGU0904040PNER-M	
	LOGU0904080PNER-M	
	LOGU0904100PNER-M	
	LOGU0904120PNER-M	
	LOGU0904160PNER-M	
	LOGU0904020PNFR-M	
	LOGU0904040PNFR-M	
	LOGU0904080PNFR-M	
	LOGU0904100PNFR-M	
	LOGU0904120PNFR-M	
	LOGU0904160PNFR-M	

Cutter Type Shape	Order Number	Page
VPX300 NEW	LOGU1207020PNER-M	L030
	LOGU1207040PNER-M	
	LOGU1207080PNER-M	
	LOGU1207100PNER-M	
	LOGU1207120PNER-M	
	LOGU1207160PNER-M	
	LOGU1207200PNER-M	
	LOGU1207240PNER-M	
	LOGU1207300PNER-M	
	LOGU1207320PNER-M	
NEW	LOGU1207020PNFR-M	L030
	LOGU1207040PNFR-M	
	LOGU1207080PNFR-M	
	LOGU1207100PNFR-M	
	LOGU1207120PNFR-M	
	LOGU1207160PNFR-M	
	LOGU1207200PNFR-M	
	LOGU1207240PNFR-M	
	LOGU1207300PNFR-M	
	LOGU1207320PNFR-M	
WJX NEW 	JOMU140715ZZER-M	L027
WSX445 	SNGU140812ANFR-L	L038
	SNGU140812ANER-L	
	SNGU140812ANER-M	
	SNMU140812ANER-M	
	SNMU140812ANER-R	
	SNMU140812ANER-H	
	NEW SNGU140812ANFL-L	
	NEW SNGU140812ANEL-L	
	SNGU140812ANEL-M	
	SNMU140812ANEL-M	
	SNMU140812ANEL-R	

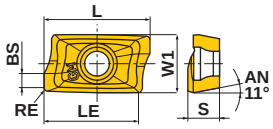
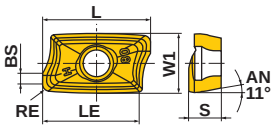
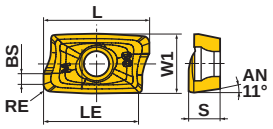
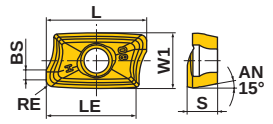
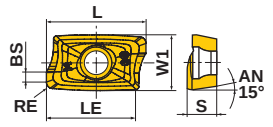
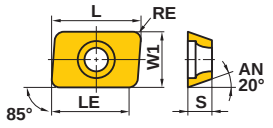
Cutter Type Shape	Order Number	Page
WSX445	WNGU1406ANEN8C-M	L051
Corner Angle 0° 11° Positive	TPEN1603PPR	L044
	TPEN2204PDR	
	TPKN1603PPR	
	TPKN2204PDR	
Corner Angle 15° 11° Positive	SPKN1203EDR	L040
	SPKN1504EDR	
	SPEN1203EDR	
Corner Angle 45° 20° Positive	SEKN1203AGTN	L037
Negative	SNMN120408	L038
	SNMN120412	
11° Positive	TPMN160304	L045
	TPMN160308	
	TPMN160312	
	TPMN220404	
	TPMN220408	
	TPMN220412	

ROTATING INSERTS

Work Material		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	UP20M	NX2525	UTi20T	TF15
P	Steel		◐	✠				◐	◐	◐	●	◐	
M	Stainless Steel				◔			◔	◔	◔	◯	◔	
K	Cast Iron	◐						✠	✠		●	✠	
N	Non-ferrous Metal												◐
S	Heat-resistant Alloy, Titanium Alloy					◐	✠	◐	✠				
H	Hardened Steel							◐					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

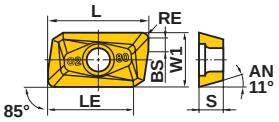
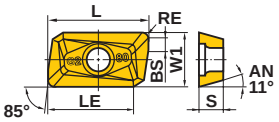
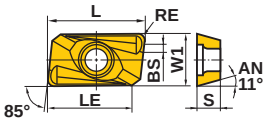
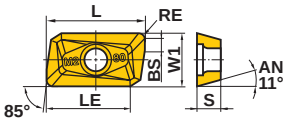
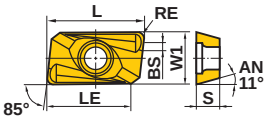
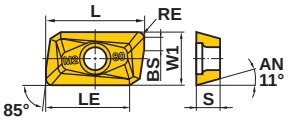
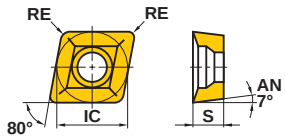
Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	UP20M	NX2525	UTi20T	TF15	L	LE	W1	S	BS	RE	Geometry
				Coated									Cermet	Carbide		Dimensions (mm)						
APX3000 ➲ M096	AOGT123602PEFR-GM	G	F												●	12	10	6.6	3.6	1.8	0.2	
	AOGT123604PEFR-GM	G	F												●	12	10	6.6	3.6	1.6	0.4	
	AOGT123608PEFR-GM	G	F												●	12	10	6.6	3.6	1.2	0.8	
APX3000 ➲ M096 APX3000 Long Cutting Edge ➲ M202	AOMT123604PEER-H	M	E	●	●	●	●	●	●	●	●					12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-H	M	E	●	●	●	●	●	●	●	●					12	10	6.6	3.6	1.2	0.8	
	AOMT123616PEER-H	M	E	●	●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	1.6	
APX3000 ➲ M096 APX3000 Long Cutting Edge ➲ M202	AOMT123602PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	1.8	0.2	
	AOMT123604PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	1.2	0.8	
	AOMT123610PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	1.0	1.0	
	AOMT123612PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.8	1.2	
	AOMT123616PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	1.6	
	AOMT123620PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	2.0	
	AOMT123624PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	2.4	
	AOMT123630PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	3.0	
	AOMT123632PEER-M	M	E		●	●	●	●	●	●	●					12	10	6.6	3.6	0.4	3.2	
APX4000 ➲ M102 APX4000 Long Cutting Edge ➲ M206	AOMT184804PEER-H	M	E	●	●	●	●	●	●	●	●					18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-H	M	E	●	●	●	●	●	●	●	●					18	15	9	4.8	1.4	0.8	
	AOMT184816PEER-H	M	E	●	●	●	●	●	●	●	●					18	15	9	4.8	0.4	1.6	
	AOMT184832PEER-H	M	E			●	●				●					18	15	9	4.8	0.4	3.2	
	AOMT184840PEER-H	M	E			●	●				●					18	15	9	4.8	0.4	4.0	
	AOMT184850PEER-H	M	E			●	●				●					18	15	9	4.8	–	5.0	
	AOMT184864PEER-H	M	E			●	●				●					18	15	9	4.8	–	6.35	
APX4000 ➲ M102 APX4000 Long Cutting Edge ➲ M206	AOMT184804PEER-M	M	E		●	●	●	●	●	●	●					18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-M	M	E		●	●	●	●	●	●	●					18	15	9	4.8	1.4	0.8	
	AOMT184810PEER-M	M	E		●			●	●	●						18	15	9	4.8	1.0	1.0	
	AOMT184812PEER-M	M	E		●			●	●	●						18	15	9	4.8	0.8	1.2	
	AOMT184816PEER-M	M	E		●	●	●	●	●	●	●					18	15	9	4.8	0.4	1.6	
	AOMT184820PEER-M	M	E		●			●	●	●						18	15	9	4.8	0.4	2.0	
BAE	AEMW150304ER	M	E									●	●	●		16.696	15.2	9.525	3.18	–	0.4	
	AEMW150308ER	M	E									●	●	●		16.623	14.8	9.525	3.18	–	0.8	
	AEMW19T304ER	M	E									●	●	●		20.161	18.4	12.7	3.97	–	0.4	
	AEMW19T308ER	M	E									●	●	●		20.088	18.0	12.7	3.97	–	0.8	

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			F7030	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10
	P	Steel	◐	◐	◐	●	◐	◐	
	M	Stainless Steel	◔	◔	◔	○	◔	◔	
	K	Cast Iron		✠		●		✠	◐
	N	Non-ferrous Metal							◐
	S	Heat-resistant Alloy, Titanium Alloy		◐					
	H	Hardened Steel		◔					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	Coated			Cermet		Carbide		Dimensions (mm)							Geometry
				F7030	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10	IC	L	LE	W1	S	BS	RE	
BAP300 ➲ M086	**APGT1135PDFR-G2**	G	F							●	—	11.3	9.7	6.35	3.5	1.2	0.8	
BAP400	**APGT1604PDFR-G2**	G	F							●	—	17.02	14	9.525	4.76	1.4	0.8	
BAP300 ➲ M086 ➲ M210 **SRM2** ➲ M236 **SRM2ϕ40 ϕ50** ➲ M244	**APMT1135PDER-H1**	M	E	●	●		●	●		●	—	11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-H2	M	E	●	●		●	●		●	—	11.25	9	6.35	3.5	1.2	0.8	
	APMT1135PDER-H3	M	E	●							—	11.26	9	6.35	3.5	0.8	1.2	
	APMT1135PDER-H4	M	E	●							—	11.24	9	6.35	3.5	0.4	1.6	
	APMT1135PDER-H6	M	E	●							—	11.10	9	6.35	3.5	0.4	2.4	
BAP300 ➲ M086 ➲ M210 **SRM2** ➲ M236 **SRM2ϕ40 ϕ50** ➲ M244	**APMT1135PDER-M0**	M	E	●							—	11.25	9	6.35	3.5	1.8	0.2	
	APMT1135PDER-M1	M	E	●							—	11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-M2	M	E	●	●			●			—	11.18	9	6.35	3.5	1.2	0.8	
BAP400 **SRM2** ➲ M236 **SRM2ϕ40 ϕ50** ➲ M244	**APMT1604PDER-H1**	M	E	●							—	17.02	14	9.525	4.76	1.7	0.4	
	APMT1604PDER-H2	M	E	●	●		●	●		●	—	17.11	14	9.525	4.76	1.4	0.8	
	APMT1604PDER-H4	M	E	●							—	17.06	14	9.525	4.76	0.4	1.6	
	APMT1604PDER-H6	M	E	●							—	16.93	14	9.525	4.76	0.4	2.4	
	APMT1604PDER-H8	M	E	●							—	16.79	14	9.525	4.76	0.4	3.2	
BAP400 **SRM2** ➲ M236 **SRM2ϕ40 ϕ50** ➲ M244	**APMT1604PDER-M2**	M	E	●	●			●			—	17.10	14	9.525	4.76	1.4	0.8	
DCCC ➲ M212	**CCMX083508EN-A**	M	E	●		●			●		7.94	—	—	—	3.5	—	0.8	
	CCMX09T308EN-A	M	E	●	●	●			●		9.525	—	—	—	3.97	—	0.8	

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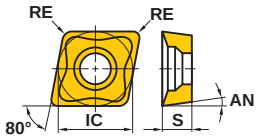
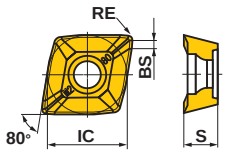
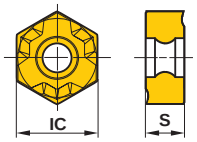
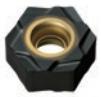
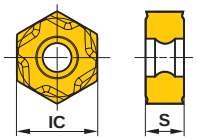
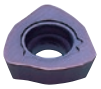
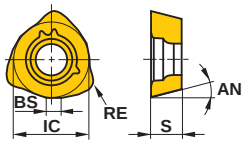
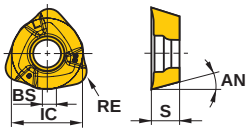
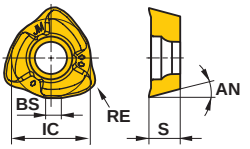
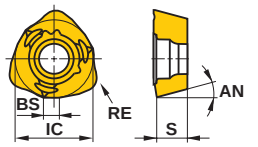
ROTATING TOOL INSERTS

ROTATING INSERTS

Work Material		F7030	FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140 (NEW)	MC5015	VP15TF	VP30RT	UTi20T
P	Steel	◐	◐	◐	✠							◐	✠	◐
M	Stainless Steel	◔				◔	✠					◔	✠	◔
K	Cast Iron		◐								●	✠	✠	✠
N	Non-ferrous Metal													
S	Heat-resistant Alloy, Titanium Alloy							◐	✠	✠		◐	✠	
H	Hardened Steel											◔		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✠ : Unstable Cutting

Honing :
E : Round **S :** Chamfer + Hone

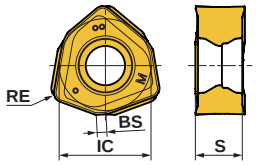
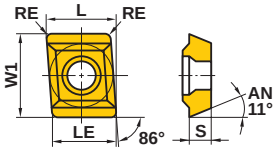
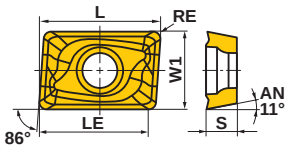
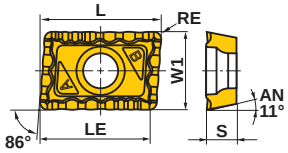
Shape	Order Number	Class	Honing	F7030	FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140 (NEW)	MC5015	VP15TF	VP30RT	UTi20T	IC	S	BS	RE	AN	Geometry
				Coated												Carbide	Dimensions (mm)					
DCCC ➲ M212	CCMX09T308EN-B	M	E	●												●	9.525	3.97	–	0.8	7°	
PMR ➲ M258	CPMT1205ZPEN-M2	M	E											●			12.7	5.56	1.4	0.8	–	
	CPMT1205ZPEN-M3	M	E											●			12.7	5.56	1.4	1.2	–	
	CPMT1906ZPEN-M2	M	E											●			19.05	6.35	1.4	0.8	–	
	CPMT1906ZPEN-M3	M	E											●			19.05	6.35	1.4	1.2	–	
BMR ➲ M260	HNMX1206EN06-R	M	E										●				12.7	6	–	–	–	
BMR ➲ M260 	HNMX1206ER12-R	M	E										●				12.7	6	–	–	–	
AJX ➲ M162 PMC ➲ M254 	JOMW06T215ZZSR-FT	M	S		●	●	●	●	●	●	●			●	●		6.35	2.78	1.2	1.5	13°	
	JOMW080320ZZSR-FT	M	S		●	●	●	●	●	●	●			●	●		8	3.18	1.4	2	13°	
	JDMW09T320ZDSR-FT	M	S		●	●	●	●	●	●	●			●	●		9.525	3.97	1.8	2	15°	
	JDMW120420ZDSR-FT	M	S		●	●	●	●	●	●	●			●	●		12	4.76	2.5	2	15°	
	JDMW140520ZDSR-FT	M	S		●	●	●	●	●	●	●			●	●		14	5.56	2.8	2	15°	
AJX ➲ M162	JOMT06T216ZZER-JL	M	E					●	●	●	●	●					6.35	2.78	1.2	1.6	13°	
	JOMT080322ZZER-JL	M	E					●	●	●	●	●					8	3.18	1.4	2.2	13°	
	JDMT09T323ZDER-JL	M	E					●	●	●	●	●					9.525	3.97	1.8	2.3	15°	
	JDMT120423ZDER-JL	M	E					●	●	●	●	●					12	4.76	2.5	2.3	15°	
	JDMT140523ZDER-JL	M	E					●	●	●	●	●					14	5.56	2.8	2.3	15°	
AJX ➲ M162 PMC ➲ M254	JOMT06T215ZZSR-JM	M	S		●	●	●	●	●	●	●			●	●		6.35	2.78	1.2	1.5	13°	
	JOMT080320ZZSR-JM	M	S		●	●	●	●	●	●	●			●	●		8	3.18	1.4	2	13°	
	JDMT09T320ZDSR-JM	M	S		●	●	●	●	●	●	●			●	●		9.525	3.97	1.8	2	15°	
	JDMT120420ZDSR-JM	M	S		●	●	●	●	●	●	●			●	●		12	4.76	2.5	2	15°	
	JDMT140520ZDSR-JM	M	S		●	●	●	●	●	●	●			●	●		14	5.56	2.8	2	15°	
AJX ➲ M162 PMC ➲ M254	JDMT120420ZDSR-ST	M	S		●	●	●	●	●					●	●		12	4.76	2.5	2	15°	
	JDMT140520ZDSR-ST	M	S		●	●	●	●	●					●	●		14	5.56	2.8	2	15°	

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	VP30RT	UP20M	UTi20T
	P	Steel	◐	◐	✠					◐	◐	✠	◐	◐
	M	Stainless Steel	◔			◔	✠			◔	◔	✠	◔	◔
	K	Cast Iron								✠	✠	✠		✠
	N	Non-ferrous Metal												
	S	Heat-resistant Alloy, Titanium Alloy						◐	✠	◐	✠	✠		
	H	Hardened Steel								◐				

Cutting Conditions (Guide) :
● : Stable Cutting
◐ : General Cutting
✠ : Unstable Cutting
Honing :
E : Round

Shape	Order Number	Class	Honing	MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	VP30RT	UP20M	UTi20T	IC	L	LE	W1	S	BS	RE	Geometry
				Coated											Carbide	Dimensions (mm)							
WJX ➲ M172 NEW	**JOMU140715ZZER-M**	M	E	●	●	●	●	●	●	●	●		●			14	–	–	–	6.63	1.3	1.5	 Right hand insert shown.
CBJP TAB ➲ M250	**JPMT060204-E**	M	E								●			●	●	–	7.0	6.0	7.94	2.38	–	0.4	
SPX ➲ M215	**JPMX140412-JM**	M	E								●	●				–	15.04	12.9	12.7	4.79	–	1.2	
	JPMX190412-JM	M	E								●	●				–	19.81	17.6	12.7	4.83	–	1.2	
SPX ➲ M215	**JPMX140412-WH**	M	E								●	●				–	15.04	12.9	12.7	4.76	–	1.2	
	JPMX190412-WH	M	E								●	●				–	19.81	17.6	12.7	4.76	–	1.2	

● = NEW

L

ROTATING TOOL INSERTS

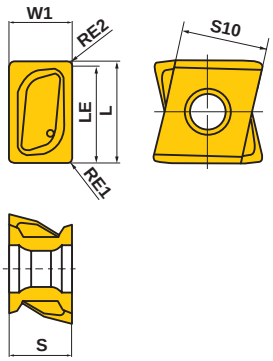
ROTATING INSERTS

Work Material			MP6120	VP15TF
	P	Steel	◐	◐
	M	Stainless Steel		
	K	Cast Iron		✠
	N	Non-ferrous Metal		
	S	Heat-resistant Alloy, Titanium Alloy		◐
	H	Hardened Steel		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

Shape	Order Number	Hand	Class	Honing	Coated MP6120	Coated VP15TF	L	LE	S	S10	RE1	RE2	W1	Geometry
VAS400 Side Cutter ➲ **M090**	**LNGU130804PNER-M**	R	G	E		●	13.0	12.2	8.0	11.0	0.4	0.8	8.0	
	LNGU130804PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	0.4	0.8	8.0	
	LNGU130808PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	0.8	0.8	8.0	
	LNGU130808PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	0.8	0.8	8.0	
	LNGU130812PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	1.2	0.8	8.0	
	LNGU130812PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	1.2	0.8	8.0	
	LNGU130816PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	1.6	0.8	8.0	
	LNGU130816PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	1.6	0.8	8.0	
	LNGU130820PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	2.0	0.8	8.0	
	LNGU130820PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	2.0	0.8	8.0	
	LNGU130824PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	2.4	0.8	8.0	
	LNGU130824PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	2.4	0.8	8.0	
	LNGU130830PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	3.0	1.6	8.0	
	LNGU130830PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	3.0	1.6	8.0	
	LNGU130840PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	4.0	1.6	8.0	
	LNGU130840PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	4.0	1.6	8.0	
	LNGU130850PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	5.0	1.6	8.0	
	LNGU130850PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	5.0	1.6	8.0	
	NEW **LNGU130804PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	0.4	0.8	8.0	
	NEW **LNGU130804PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	0.4	0.8	8.0	
	NEW **LNGU130808PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	0.8	0.8	8.0	
	NEW **LNGU130808PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	0.8	0.8	8.0	
	NEW **LNGU130812PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	1.2	0.8	8.0	
	NEW **LNGU130812PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	1.2	0.8	8.0	
	NEW **LNGU130816PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	1.6	0.8	8.0	
	NEW **LNGU130816PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	1.6	0.8	8.0	
	NEW **LNGU130820PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	2.0	0.8	8.0	
	NEW **LNGU130820PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	2.0	0.8	8.0	
	NEW **LNGU130824PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	2.4	0.8	8.0	
	NEW **LNGU130824PNEL-R**	L	G	E	●	●	13.0	12.2	8.0	11.0	2.4	0.8	8.0	
	NEW **LNGU130830PNER-R**	R	G	E	●	●	13.0	11.4	8.0	11.0	3.0	1.6	8.0	
	NEW **LNGU130830PNEL-R**	L	G	E	●	●	13.0	11.4	8.0	11.0	3.0	1.6	8.0	
	NEW **LNGU130840PNER-R**	R	G	E	●	●	13.0	11.4	8.0	11.0	4.0	1.6	8.0	
	NEW **LNGU130840PNEL-R**	L	G	E	●	●	13.0	11.4	8.0	11.0	4.0	1.6	8.0	
	NEW **LNGU130850PNER-R**	R	G	E	●	●	13.0	11.4	8.0	11.0	5.0	1.6	8.0	
	NEW **LNGU130850PNEL-R**	L	G	E	●	●	13.0	11.4	8.0	11.0	5.0	1.6	8.0	Right hand insert shown.



● = NEW

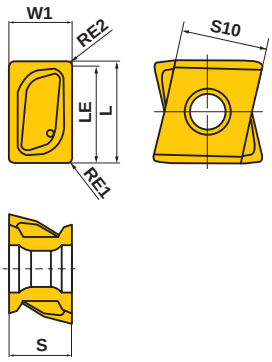
● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			MP6120	VP15TF
	P	Steel	◐	◐
	M	Stainless Steel		
	K	Cast Iron		✠
	N	Non-ferrous Metal		
	S	Heat-resistant Alloy, Titanium Alloy		◐
	H	Hardened Steel		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

Shape	Order Number	Hand	Class	Honing	Coated MP6120	Coated VP15TF	L	LE	S	S10	RE1	RE2	W1	Geometry
VAS500 Side Cutter ➲ **M092**	**LNGU171004PNER-R**	R	G	E	●	●	17.0	16.2	10.0	13.0	0.4	0.8	10.0	
	LNGU171004PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	0.4	0.8	10.0	
	LNGU171008PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	0.8	0.8	10.0	
	LNGU171008PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	0.8	0.8	10.0	
	LNGU171012PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	1.2	0.8	10.0	
	LNGU171012PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	1.2	0.8	10.0	
	LNGU171016PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	1.6	0.8	10.0	
NEW	**LNGU171016PNEL-R**	L	G	E	●	●	17.0	16.2	10.0	13.0	1.6	0.8	10.0	
	LNGU171020PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	2.0	0.8	10.0	
	LNGU171020PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	2.0	0.8	10.0	
	LNGU171024PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	2.4	0.8	10.0	
	LNGU171024PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	2.4	0.8	10.0	
	LNGU171030PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	3.0	1.6	10.0	
	LNGU171030PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	3.0	1.6	10.0	
	LNGU171040PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	4.0	1.6	10.0	
	LNGU171040PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	4.0	1.6	10.0	
	LNGU171050PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	5.0	1.6	10.0	
	LNGU171050PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	5.0	1.6	10.0	
	LNGU171060PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	6.0	1.6	10.0	
	LNGU171060PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	6.0	1.6	10.0	
	LNGU171070PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	7.0	1.6	10.0	
	LNGU171070PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	7.0	1.6	10.0	Right hand insert shown.



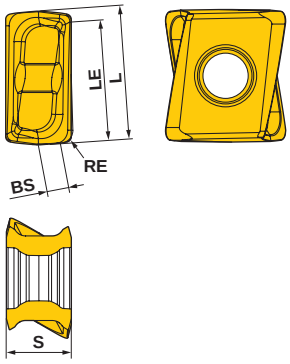
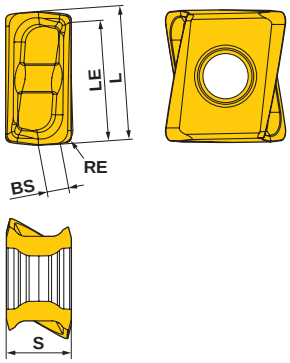
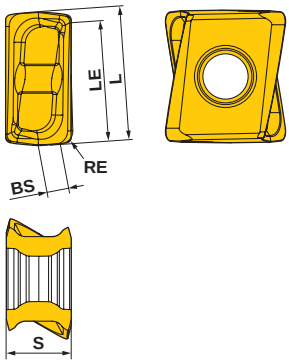
● = NEW

ROTATING INSERTS

Work Material		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	TF15
P	Steel		◐	✠				◐	
M	Stainless Steel				◔			◔	
K	Cast Iron	◐						✠	
N	Non-ferrous Metal								◐
S	Heat-resistant Alloy, Titanium Alloy					◐	✠	◐	
H	Hardened Steel							◔	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

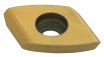
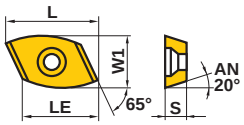
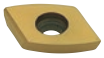
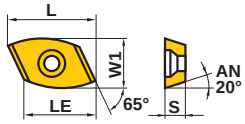
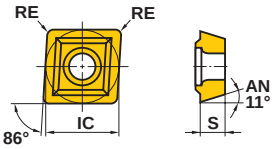
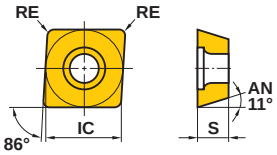
Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	TF15	L	RE	LE	S	BS	Geometry
VPX200 ➲ M110	LOGU0904020PNER-L	G	E	●	●	●	●	●	●	●		8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNER-L	G	E	●	●	●	●	●	●	●		8.7	0.4	7.6	4.3	1.5	
	LOGU0904080PNER-L	G	E	●	●	●	●	●	●	●		8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNER-L	G	E	●	●	●	●	●	●	●		8.7	1	7.6	4.3	1	
NEW	LOGU0904120PNER-L	G	E	●	●	●	●	●	●	●		8.7	1.2	7.6	4.3	0.8	
	LOGU0904160PNER-L	G	E	●	●	●	●	●	●	●		8.7	1.6	7.6	4.3	0.5	
	LOGU0904020PNFR-L	G	F								●	8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNFR-L	G	F								●	8.7	0.4	7.6	4.3	1.5	
	LOGU0904080PNFR-L	G	F								●	8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNFR-L	G	F								●	8.7	1	7.6	4.3	1	
	LOGU0904120PNFR-L	G	F								●	8.7	1.2	7.6	4.3	0.8	
	LOGU0904160PNFR-L	G	F								●	8.7	1.6	7.6	4.3	0.5	Right hand insert only.
VPX200 ➲ M110	LOGU0904020PNER-M	G	E	●	●	●	●	●	●	●		8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNER-M	G	E	●	●	●	●	●	●	●		8.7	0.4	7.6	4.3	1.6	
	LOGU0904080PNER-M	G	E	●	●	●	●	●	●	●		8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNER-M	G	E	●	●	●	●	●	●	●		8.7	1	7.6	4.3	1	
NEW	LOGU0904120PNER-M	G	E	●	●	●	●	●	●	●		8.7	1.2	7.6	4.3	0.9	
	LOGU0904160PNER-M	G	E	●	●	●	●	●	●	●		8.7	1.6	7.6	4.3	0.5	
	LOGU0904020PNFR-M	G	F								●	8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNFR-M	G	F								●	8.7	0.4	7.6	4.3	1.6	
	LOGU0904080PNFR-M	G	F								●	8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNFR-M	G	F								●	8.7	1	7.6	4.3	1	
	LOGU0904120PNFR-M	G	F								●	8.7	1.2	7.6	4.3	0.9	
	LOGU0904160PNFR-M	G	F								●	8.7	1.6	7.6	4.3	0.5	Right hand insert only.
VPX300 ➲ M122	LOGU1207020PNER-M	G	E	●	●	●	●	●	●	●		12.4	0.2	11.3	7.0	3.0	
	LOGU1207040PNER-M	G	E	●	●	●	●	●	●	●		12.4	0.4	11.3	7.0	2.8	
	LOGU1207080PNER-M	G	E	●	●	●	●	●	●	●		12.4	0.8	11.3	7.0	2.4	
	LOGU1207100PNER-M	G	E	●	●	●	●	●	●	●		12.4	1.0	11.3	7.0	2.3	
	LOGU1207120PNER-M	G	E	●	●	●	●	●	●	●		12.4	1.2	11.3	7.0	2.1	
	LOGU1207160PNER-M	G	E	●	●	●	●	●	●	●		12.4	1.6	11.3	7.0	1.7	
	LOGU1207200PNER-M	G	E	●	●	●	●	●	●	●		12.4	2.0	11.3	7.0	1.4	
	LOGU1207240PNER-M	G	E	●	●	●	●	●	●	●		12.4	2.4	11.3	7.0	1.0	
NEW	LOGU1207300PNER-M	G	E	●	●	●	●	●	●	●		12.4	3.0	11.3	7.0	0.5	
	LOGU1207320PNER-M	G	E	●	●	●	●	●	●	●		12.4	3.2	11.3	7.0	0.3	
	LOGU1207020PNFR-M	G	F								●	12.4	0.2	11.3	7.0	3.0	
	LOGU1207040PNFR-M	G	F								●	12.4	0.4	11.3	7.0	2.8	
	LOGU1207080PNFR-M	G	F								●	12.4	0.8	11.3	7.0	2.4	
	LOGU1207100PNFR-M	G	F								●	12.4	1.0	11.3	7.0	2.3	
	LOGU1207120PNFR-M	G	F								●	12.4	1.2	11.3	7.0	2.1	
	LOGU1207160PNFR-M	G	F								●	12.4	1.6	11.3	7.0	1.7	
	LOGU1207200PNFR-M	G	F								●	12.4	2.0	11.3	7.0	1.4	
	LOGU1207240PNFR-M	G	F								●	12.4	2.4	11.3	7.0	1.0	
	LOGU1207300PNFR-M	G	F								●	12.4	3.0	11.3	7.0	0.5	
	LOGU1207320PNFR-M	G	F								●	12.4	3.2	11.3	7.0	0.3	Right hand insert only.

● = NEW

Work Material			VP15TF	UP20M	NX2525	UTi20T	HTi10
	P	Steel	◐	◐	●	◐	
	M	Stainless Steel	◔	◔	○	◔	
	K	Cast Iron	✠		●	✠	◐
	N	Non-ferrous Metal					◐
	S	Heat-resistant Alloy, Titanium Alloy	◐				
	H	Hardened Steel	◔				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **T :** Chamfer

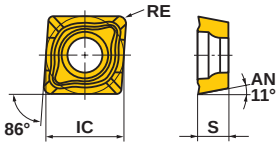
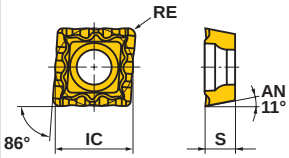
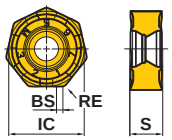
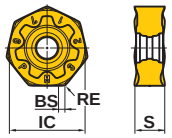
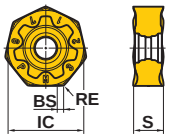
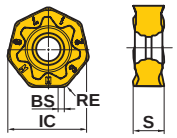
Shape	Order Number	Class	Honing	Coated VP15TF	Coated UP20M	Cermet NX2525	Carbide UTi20T	Carbide HTi10	L	LE	W1	IC	S	RE	Geometry
MG245 MG345 MG445 	**MGEEW1035AFTR**	E	T		●	●	●	●	14.3	9.3	9	—	3.5	—	 This figure is for outer insert (E).
	MGEEW1242AFTR	E	T		●	●	●	●	17.0	11.2	10.5	—	4.2	—	
	MGEEW1650AFTR	E	T		●	●	●	●	21.8	14.9	13	—	5	—	
MG200 MG300 MG400 	**MGEEW1035PFTR**	E	T		●	●	●	●	14.3	9.3	9	—	3.5	—	
	MGEEW1242PFTR	E	T		●	●	●	●	17.0	11.2	10.5	—	4.2	—	
	MGEEW1650PFTR	E	T		●		●	●	21.8	14.9	13	—	5	—	
CBMP ➲ M250 **ECMP TAB**	**MPMT070308**	M	E		●		●		—	—	—	7.94	3.18	0.8	
	MPMT090308	M	E	●	●		●		—	—	—	9.525	3.18	0.8	
	MPMT120408	M	E		●		●		—	—	—	12.7	4.76	0.8	
TSMP ➲ M248	**MPMW070308**	M	E				●		—	—	—	7.94	3.18	0.8	
	MPMW090308	M	E				●		—	—	—	9.525	3.18	0.8	
	MPMW120408	M	E				●		—	—	—	12.7	4.76	0.8	

ROTATING INSERTS

Work Material			MP6120	MP6130	MP7130	MP7140	MC5020	VP15TF	VP20RT	MP7030
	P	Steel	◐	✣				◐	◐	
	M	Stainless Steel			◔	✣		◔	◔	◔
	K	Cast Iron					◐	◐	✣	
	N	Non-ferrous Metal								
	S	Heat-resistant Alloy, Titanium Alloy						◐		
	H	Hardened Steel						◔		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✣ : Unstable Cutting

Honing :
E : Round

Shape	Order Number	Class	Honing	MP6120	MP6130	MP7130	MP7140	MC5020	VP15TF	VP20RT	MP7030	IC	S	BS	RE	Geometry
				Coated								Dimensions (mm)				
SPX ➲ M215	**MPMX120412-JM**	M	E						●	●		12.7	4.79	—	1.2	
SPX ➲ M215	**MPMX120412-WH**	M	E						●	●		12.7	4.76	—	1.2	
AHX440S ➲ M038 **AHX475S** ➲ M043	**NNMU130508ZER-L**	M	E	●	●	●	●	●	●			13.4	5.77	1	0.8	
	NNMU130508ZEN-M	M	E	●	●	●	●	●	●			13.4	5.57	1	0.8	
	NNMU130532ZEN-M	M	E	●	●	●	●	●	●			13.4	5.57	—	3.2	
	NNMU130532ZEN-R	M	E	●	●	●	●	●	●			13.4	5.47	—	3.2	
AHX640S ➲ M046	**NNMU200708ZEN-M**	M	E	●	●							20	8	1	0.8	
AHX640S ➲ M046	**NNMU200708ZEN-MP**	M	E						●			20	8	1	0.8	
AHX640S ➲ M046	**NNMU200712ZER-MM**	M	E								●	20	8	1	1.2	

L

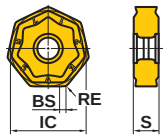
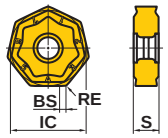
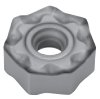
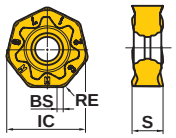
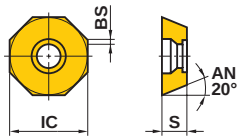
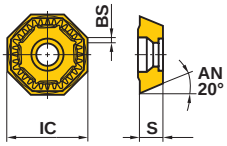
ROTATING TOOL INSERTS

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			F7030	MP9120	MP9130	MC5020	VP15TF	VP20RT	NX4545
	P	Steel	◐				◐	◐	◐
	M	Stainless Steel	◔				◔	◔	◔
	K	Cast Iron				◐	✠	✠	
	N	Non-ferrous Metal							
	S	Heat-resistant Alloy, Titanium Alloy		◐	✠		◐	✠	
	H	Hardened Steel					◔		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✠ : Unstable Cutting

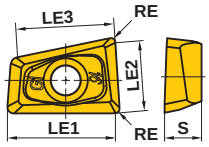
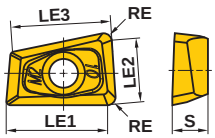
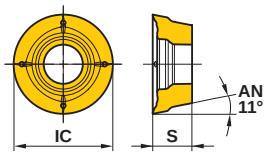
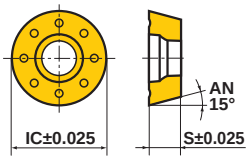
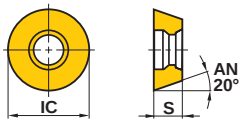
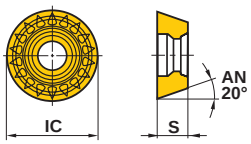
Honing :
E : Round **S :** Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	F7030	MP9120	MP9130	MC5020	VP15TF	VP20RT	NX4545	IC	S	BS	RE	Geometry
				Coated						Cermet	Dimensions (mm)				
AHX640S ➲ M046 AHX640W ➲ M054	NNMU200608ZEN-MK	M	E				●	●	●		20	6.55	1	0.8	
AHX640S ➲ M046 AHX640W ➲ M054	NNMU200608ZEN-HK	M	E				●	●	●		20	6.55	1	0.8	
AHX640S ➲ M046 	NNMU200712ZER-L	M	E		●	●					20	8	1	1.2	
OCTACUT ➲ M180	OEMX12T3ETR1	M	T							●	12.7	3.97	1	–	
	OEMX12T3ESR1	M	S	●							12.7	3.97	1	–	
	OEMX1705ETR1	M	T					●		●	17	5	1.4	–	
	OEMX1705ESR1	M	S	●							17	5	1.4	–	
OCTACUT ➲ M180	OEMX12T3EER1-JS	M	E	●							12.7	3.97	1	–	
	OEMX1705EER1-JS	M	E	●							17	5	1.4	–	
	OEMX1705ETR1-JS	M	T					●			17	5	1.4	–	

ROTATING INSERTS

Work Material		F7030	MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	MP8010	HTi10
P	Steel	◐	◐	◐	✠					◐	✠		
M	Stainless Steel	◔	◔			◔	⊕			◔	⊕		
K	Cast Iron									✠	✠	●	◐
N	Non-ferrous Metal												◐
S	Heat-resistant Alloy, Titanium Alloy							◐	✠	◐	✠		
H	Hardened Steel									◐		●	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✠ : Unstable Cutting
Honing :
E : Round **F :** Sharp **S :** Chamfer + Hone

Shape	Order Number	Class	Honing	F7030	MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	MP8010	HTi10	LE1	LE2	LE3	IC	S	RE	Geometry
				Coated											Carbide	Dimensions (mm)						
AQX ➲ M154	QOGT0830R-G1	G	E *1			●				●		●			●	7.7	4.9	7.3	—	3	0.4	
	QOGT1035R-G1	G	E *1			●				●		●			●	9.9	6.4	9.3	—	3.5	0.4	
	QOGT1342R-G1	G	E *1			●				●		●			●	12.4	8.1	11.6	—	4.2	0.4	
	QOGT1651R-G1	G	E *1			●				●		●			●	15.8	10.4	14.6	—	5.1	0.4	
	QOGT1856R-G1	G	E *1			●				●		●			●	17.3	11.4	16	—	5.6	0.4	
	QOGT2062R-G1	G	E *1			●				●		●			●	19.8	13.1	18.1	—	6.2	0.4	
	QOGT2576R-G1	G	E *1			●				●		●			●	25.2	16.6	23.1	—	7.6	0.4	
AQX ➲ M154	QOMT0830R-M2	M	E			●	●	●	●	●		●	●			7.3	4.4	7.3	—	3	0.8	
	QOMT1035R-M2	M	E			●	●	●	●	●		●	●			9.5	5.9	9.3	—	3.5	0.8	
	QOMT1342R-M2	M	E			●	●	●	●	●		●	●			12	7.6	11.6	—	4.2	0.8	
	QOMT1651R-M2	M	E			●	●	●	●	●		●	●			15.4	9.9	14.6	—	5.1	0.8	
	QOMT1856R-M2	M	E			●	●	●	●	●		●	●			16.9	10.9	16	—	5.6	0.8	
	QOMT2062R-M2	M	E			●	●	●	●	●		●	●			19.4	12.6	18.1	—	6.2	0.8	
	QOMT2576R-M2	M	E			●	●	●	●	●		●	●			24.8	16.1	23.1	—	7.6	0.8	
ARP ➲ M186	RPHT1040M0E4-L	H	E		●			●			●					—	—	—	10	3.97	—	
	RPHT1040M0E4-M	H	E		●			●			●					—	—	—	10	3.97	—	
	RPHT1040M0E4-R	H	E		●			●			●					—	—	—	10	3.97	—	
	RPHT1248M0E4-L	H	E		●			●			●					—	—	—	12	4.76	—	
	RPHT1248M0E4-M	H	E		●			●			●					—	—	—	12	4.76	—	
	RPHT1248M0E4-R	H	E		●			●			●					—	—	—	12	4.76	—	
	RPMT1040M0E4-L	M	E		●			●			●					—	—	—	10	3.97	—	
	RPMT1040M0E4-M	M	E		●			●			●					—	—	—	10	3.97	—	
	RPMT1040M0E4-R	M	E		●			●			●					—	—	—	10	3.97	—	
	RPMT1248M0E4-L	M	E		●			●			●					—	—	—	12	4.76	—	
	RPMT1248M0E4-M	M	E		●			●			●					—	—	—	12	4.76	—	
	RPMT1248M0E4-R	M	E		●			●			●					—	—	—	12	4.76	—	
ARX ➲ M192	RDMW0517M0E	M	E									●		●		—	—	—	5	1.70	—	
	RDMW0620M0E	M	E									●		●		—	—	—	6	1.99	—	
	RDMW0724M0E	M	E									●		●		—	—	—	7	2.38	—	
OCTACUT ➲ M180	REMX1705SN	M	S	●												—	—	—	17.25	5.2	—	
OCTACUT ➲ M180	REMX12T3EN-JS	M	E	●												—	—	—	12.95	4.17	—	
	REMX1705EN-JS	M	E	●												—	—	—	17.25	5.2	—	

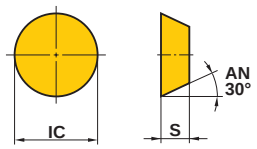
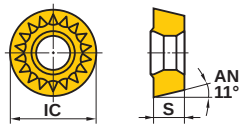
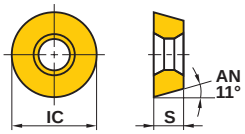
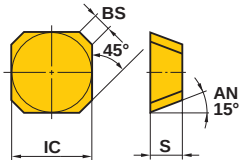
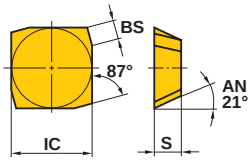
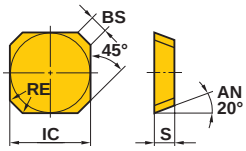
*1 Grade HTi10 is "F".

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Work Material			F7030	MC5020	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10
	P	Steel	◐		◐	◐	●	◐	◐	
	M	Stainless Steel	◔		◔	◔	○	◔	◔	
	K	Cast Iron		◐	✠		●		✠	◐
	N	Non-ferrous Metal								◐
	S	Heat-resistant Alloy, Titanium Alloy			◐					
	H	Hardened Steel			◐					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp **S :** Chamfer + Hone **T :** Chamfer

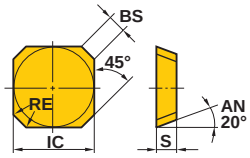
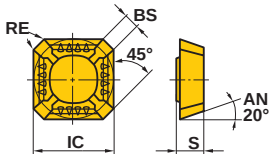
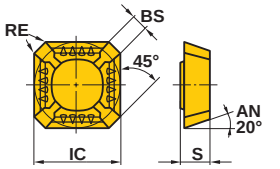
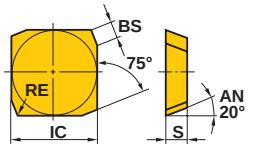
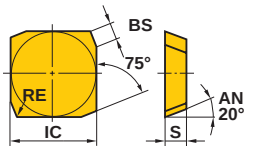
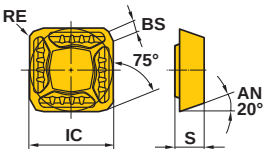
Shape	Order Number	Class	Honing	Coated				Cermet		Carbide		Dimensions (mm)				Geometry
				F7030	MC5020	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10	IC	S	BS	RE	
SG20 ➲ M064	**RGEN2004M0EN**	E	E			●						20	4.76	—	—	
	RGEN2004M0SN	E	S	●			●			●	●	20	4.76	—	—	
BRP ➲ M196	**RPMT08T2M0E-JS**	M	E	●		●						8	2.78	—	—	
	RPMT10T3M0E-JS	M	E	●		●						10	3.97	—	—	
	RPMT1204M0E-JS	M	E	●		●				●		12	4.76	—	—	
	RPMT1606M0E-JS	M	E	●		●						16	6.35	—	—	
BRP ➲ M196	**RPMW08T2M0T**	M	T			●						8	2.78	—	—	
	RPMW10T3M0E	M	E	●					●			10	3.97	—	—	
	RPMW10T3M0T	M	T			●						10	3.97	—	—	
	RPMW1204M0E	M	E	●					●	●		12	4.76	—	—	
	RPMW1204M0T	M	T			●						12	4.76	—	—	
	RPMW1606M0E	M	E	●						●		16	6.35	—	—	
	RPMW1606M0T	M	T			●						16	6.35	—	—	
FMSD	**SDEN1203AEN**	E	T						▲			12.7	3.18	1.2	—	
	SDKN1203AEN	K	T	▲		●		▲		▲		12.7	3.18	1.2	—	
	SDKN1203AETN	K	T						▲			12.7	3.18	1.7	—	
	SDKN1504AETN	K	T						▲			15.875	4.76	1.7	—	
FE404 ➲ M266 **E404**	**SEA42C10GR**	A	F								▲	12.7	3.18	2.4	—	
	SEA42C10GL	A	F								▲	12.7	3.18	2.4	—	
SE445 **LSE445**	**SECN1203AFTN1**	C	T						●			12.7	3.18	1.4	1.0	
	SEEN1203AFFN1	E	F								●	12.7	3.18	1.4	1.0	
	SEEN1203AFEN1	E	E			●						12.7	3.18	1.4	1.0	
	SEEN1203AFTN1	E	T					●	●			12.7	3.18	1.4	1.0	
	SEEN1203AFSN1	E	S	●	●							12.7	3.18	1.4	1.0	
	SEKN1203AFSN1	K	S	●								12.7	3.18	1.4	—	
	SEKN1203AFTN1	K	T							●		12.7	3.18	1.4	—	
	SEKN1203AFTN	K	T						●			12.7	3.18	1.7	1.0	

ROTATING INSERTS

Work Material		F7030	MC5020	VP15TF	NX2525	NX4545	UTi20T	HTi10
P	Steel	◐		◐	◐	◐	◐	
M	Stainless Steel	◔		◔	◔	◔	◔	
K	Cast Iron		◐	✠	◐		✠	◐
N	Non-ferrous Metal							◐
S	Heat-resistant Alloy, Titanium Alloy			◐				
H	Hardened Steel			◔				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp **S :** Chamfer + Hone **T :** Chamfer

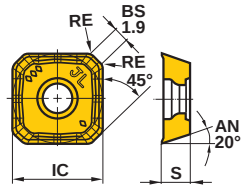
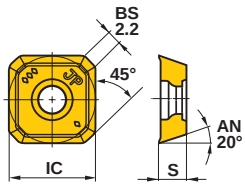
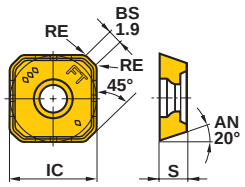
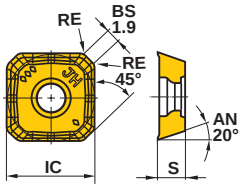
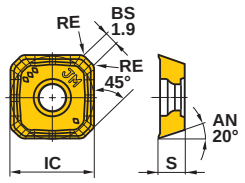
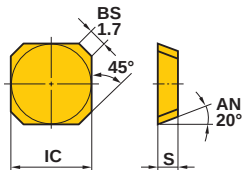
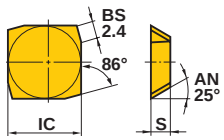
Shape	Order Number	Class	Honing	Coated F7030	Coated MC5020	Coated VP15TF	Cermet NX2525	Cermet NX4545	Carbide UTi20T	Carbide HTi10	Dimensions (mm) IC	S	BS	RE	Geometry
SE545	SEEN1504AFEN1	E	E			●					15.875	4.76	1.4	1.0	
	SEEN1504AFTN1	E	T				●	●			15.875	4.76	1.4	1.0	
	SEEN1504AFSN1	E	S	●	●						15.875	4.76	1.4	1.0	
	SEKN1504AFSN1	K	S	●							15.875	4.76	1.4	—	
	SEKN1504AFTN1	K	T						●		15.875	4.76	1.4	—	
SE445 LSE445	SEER1203AFEN-JS	E	E	●	●	●					12.7	3.18	1.4	1.0	
SE545	SEER1504AFEN-JS	E	E	●	●						15.875	4.76	1.4	1.0	
SE415 QSE415	SEEN1203EFFR1	E	F							●	12.7	3.18	1.4	1.0	
	SEEN1203EFER1	E	E			●					12.7	3.18	1.4	1.0	
	SEEN1203EFTR1	E	T				●	●			12.7	3.18	1.4	1.0	
	SEEN1203EFSR1	E	S	●	●						12.7	3.18	1.4	1.0	
	SEKN1203EFSR1	K	S	●							12.7	3.18	1.4	—	
	SEKN1203EFTR1	K	T						●		12.7	3.18	1.4	—	
	SEKN1203EFTR	K	T					●			12.7	3.18	1.8	1.0	Right hand insert shown.
SE515 ➲ M062	SECN1504EFTR1	C	T					●			15.875	4.76	1.4	1.0	
	SEEN1504EFER1	E	E			●					15.875	4.76	1.4	1.0	
	SEEN1504EFTR1	E	T					●			15.875	4.76	1.4	1.0	
	SEEN1504EFSR1	E	S	●							15.875	4.76	1.4	1.0	
	SEKN1504EFSR1	K	S	●							15.875	4.76	1.4	—	
	SEKN1504EFTR1	K	T						●		15.875	4.76	1.4	—	Right hand insert shown.
SE415 QSE415	SEER1203EFER-JS	E	E	●	●						12.7	3.18	1.4	1.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Work Material			F7030	MC5020	MP6130	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545	HTi10
	P	Steel	◐		◐	✠					◐	✠	◐	
	M	Stainless Steel	◔				◔	✠			◔	✠	◔	
	K	Cast Iron		◐							✠	✠		◐
	N	Non-ferrous Metal												◐
	S	Heat-resistant Alloy, Titanium Alloy							◐	✠	◐	✠		
	H	Hardened Steel									◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp
S : Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	F7030	MC5020	MP6130	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545	HTi10	IC	S	RE	Geometry
				Coated										Cermet	Carbide	Dimensions (mm)			
ASX445 ➲ M030	SEET13T3AGEN-JL	E	E	●		●	●	●	●	●	●	●	●	●		13.4	3.97	1.5	
ASX445 ➲ M030	SEGT13T3AGFN-JP	G	F												●	13.4	3.97	—	
ASX445 ➲ M030	SEMT13T3AGSN-FT	M	S		●											13.4	3.97	1.5	
ASX445 ➲ M030	SEMT13T3AGSN-JH	M	S	●	●	●	●	●	●	●	●	●	●			13.4	3.97	1.5	
ASX445 ➲ M030	SEMT13T3AGSN-JM	M	S	●	●	●	●	●	●	●	●	●	●	●		13.4	3.97	1.5	
Corner Angle 45°	SEKN1203AGTN	K	T											▲		12.7	3.18	—	
BF407 QBF407	SFAN1203ZFFR2	A	F												●	12.7	3.175	—	
	SFAN1203ZFFL2	A	F												●	12.7	3.175	—	
	SFCN1203ZFFR2	C	F												●	12.7	3.175	—	
	SFCN1203ZFFL2	C	F												□	12.7	3.175	—	

ROTATING INSERTS

Work Material			F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	VP30RT	MX3030	NX2525	NX4545	UTi20T	HTi10	TF15
	P	Steel	◐		◐	✣					◐	◐	✣	◐	●	◐	◐		
	M	Stainless Steel	◑				◑	✣			◑	◑	✣	◑	◑	◑	◑		
	K	Cast Iron		◐							✣	✣		◐	●		✣	◐	
	N	Non-ferrous Metal																◐	✣
	S	Heat-resistant Alloy, Titanium Alloy							◐	✣	◐	✣	✣						
	H	Hardened Steel									◐								

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● : Stable Cutting ◐ : General Cutting
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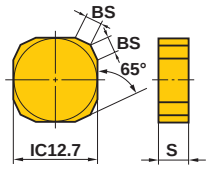
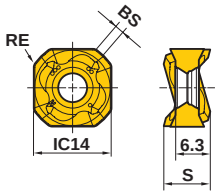
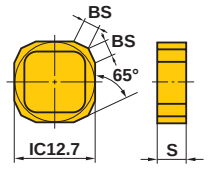
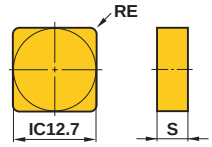
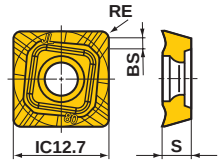
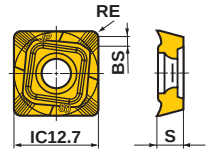
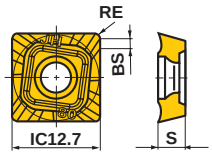
Honing :
E : Round **F** : Sharp **T** : Chamfer

Shape	Order Number	Class	Honing	Coated											Cermet			Carbide			Dimensions (mm) S	BS	RE	Geometry
				F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	VP30RT	MX3030	NX2525	NX4545	UTi20T	HTi10	TF15				
BN425 DN	SNC43B2G	C	F																●		4.8	2	—	
	SNC43B2S	C	T *1														●	●			4.8	2	—	
	SNK43B2G	K	F															●	●		4.8	2	—	
	SNK43B2S	K	T *1													●	●	●			4.8	2	—	
WSX445 ➲ M018	SNGU140812ANFR-L	G	F																	●	8.4	1.5	1.2	
	SNGU140812ANER-L	G	E		●	●	●	●	●	●	●	●	●		●						8.4	1.5	1.2	
	SNGU140812ANER-M	G	E		●	●	●	●	●	●	●	●	●		●						8.4	1.5	1.2	
	SNMU140812ANER-M	M	E		●	●	●	●	●	●	●	●	●		●						8.4	1.5	1.2	
	SNMU140812ANER-R	M	E		●	●	●					●	●								8.4	1.5	1.2	
	SNMU140812ANER-H	M	E		●	●	●					●	●								8.4	1.5	1.2	
	NEW SNGU140812ANFL-L	G	F																	●	8.4	1.5	1.2	
	NEW SNGU140812ANEL-L	G	E		●	●	●					●			●						8.4	1.5	1.2	
	SNGU140812ANEL-M	G	E		●	●	●					●			●						8.4	1.5	1.2	
	SNMU140812ANEL-M	M	E		●	●	●					●			●						8.4	1.5	1.2	
	SNMU140812ANEL-R	M	E		●	●	●					●									8.4	1.5	1.2	Right hand insert shown.
BN425 DN	SNKF43B2S	K	T														●				4.8	2	—	
	SNMF43B2G	M	E		●																4.8	2	—	
	SNMN120408	M	E		●																4.76	—	0.8	
	SNMN120412	M	E		●																4.76	—	1.2	
ASX400 ➲ M080	SOET12T308PEER-JL	E	E	●		●	●	●	●	●	●	●		●			●				3.97	1.4	0.8	
ASX400 ➲ M080	SOGT12T308PEFR-JP	G	F																●		3.97	1.4	0.8	
ASX400 ➲ M080	SOMT12T308PEER-JH	M	E	●	●	●	●	●	●	●	●	●		●							3.97	1.4	0.8	

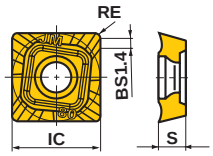
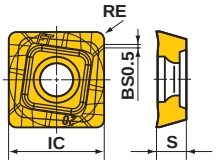
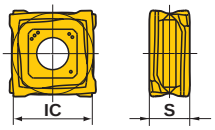
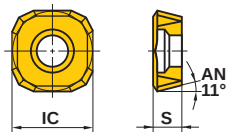
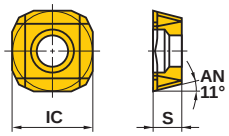
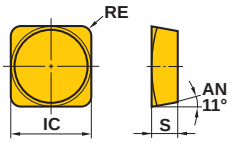
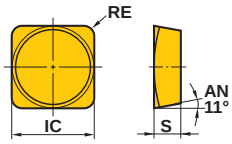
*1 Grade UTi20T is "E".

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			F7030	MC5020	MP6130	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX2525	NX4545	HTi10	HTi05T
	P	Steel	◐		◐	✠					◐	✠	◐	◐		
	M	Stainless Steel	◔				◔	✠			◔	✠	◔	◔		
	K	Cast Iron		◐							✠	✠	●		◐	●
	N	Non-ferrous Metal													◐	●
	S	Heat-resistant Alloy, Titanium Alloy							◐	✠	◐	✠				
	H	Hardened Steel									◐					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

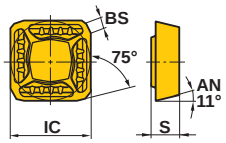
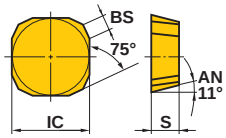
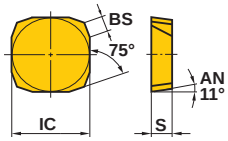
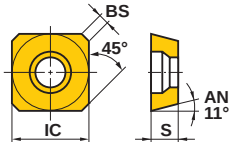
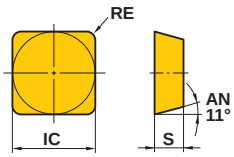
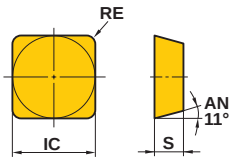
Shape	Order Number	Class	Honing	F7030	MC5020	MP6130	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX2525	NX4545	HTi10	HTi05T	IC	S	RE	Geometry
				Coated										Cermet		Carbide		Dimensions (mm)			
ASX400 ➲ M080 **ASX400** Side Cutter ➲ M095	**SOMT12T308PEER-JM**	M	E	●	●	●	●	●	●	●	●	●	●		●			12.7	3.97	0.8	 Right hand insert shown.
	SOMT12T308PEEL-JM	M	E									●						12.7	3.97	0.8	
ASX400 ➲ M080	**SOMT12T320PEER-FT**	M	E		●	●				●	●	●						12.7	3.97	2.0	
VOX400 ➲ M076 **VOS400** Side Cutter ➲ M094	**SONX1206PER**	N	E		●							●						12.7	6.3	—	 Right hand insert shown.
	SONX1206PEL	N	E									●						12.7	6.3	—	
FF3000 ➲ M074	**SPCA53Z**	C	E											●				15.88	4.8	—	
FF3000 ➲ M074	**SPCG53Z**	C	F											●			●	15.88	4.8	—	
FP490 ➲ M262	**SPEN424A**	E	F													●	●	12.7	3.18	1.6	
FP590 ➲ M264	**SPEN535A**	E	F														●	15.875	4.76	2.0	

ROTATING INSERTS

Work Material		F7030	MC5020	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10
P	Steel	◐		◐	◐	●	◐	◐	
M	Stainless Steel	◑		◑	◑	◑	◑	◑	
K	Cast Iron		◐	✱		●		✱	◐
N	Non-ferrous Metal								◐
S	Heat-resistant Alloy, Titanium Alloy			◐					
H	Hardened Steel			◐					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing :
E : Round **F :** Sharp **T :** Chamfer

Shape	Order Number	Class	Honing	F7030	MC5020	VP15TF	UP20M	NX2525	NX4545	UTi20T	HTi10	IC	S	BS	RE	Geometry
				Coated				Cermet		Carbide		Dimensions (mm)				
FBP415	**SPER1203EEER-JS**	E	E		●							12.7	3.18	1.4	—	
Corner Angle 15°	**SPEN1203EDR**	E	T	▲				▲	▲			12.7	3.18	1.4	—	 Right hand insert shown.
	SPKN1203EDR	K	T✱1	▲	●	●		▲		▲	▲	12.7	3.18	1.4	—	
	SPKN1504EDR	K	T✱1			●	▲	▲		▲	▲	15.875	4.76	1.4	—	
FBP415	**SPEN1203EEER1**	E	E		●						●	12.7	3.175	1.4	—	 Right hand insert shown.
	SPEN1203EEEL1	E	E		●						●	12.7	3.175	1.4	—	
	SPNN1203EEER1	N	E		●						●	12.7	3.18	1.3	—	
	SPNN1203EEEL1	N	E								●	12.7	3.18	1.3	—	
BSP	**SPMB1204APT**	M	T				●			●		12.7	4.76	1.4	—	
S400	**SPMN120304**	M	E✱1			●				●	●	12.7	3.18	—	0.4	
	SPMN120304T	M	T					●				12.7	3.18	—	0.4	
	SPMN120308	M	E	●		●	●			●	●	12.7	3.18	—	0.8	
	SPMN120312	M	E✱1	●		●				●	●	12.7	3.18	—	1.2	
	SPMN120408	M	E		●					●	●	12.7	4.76	—	0.8	
	SPMN120412	M	E		●					●		12.7	4.76	—	1.2	
	SPGN120304	G	E✱1					●		●	●	12.7	3.18	—	0.4	
	SPGN120308	G	E✱1				●	●		●	●	12.7	3.18	—	0.8	
	SPGN120312	G	F								●	12.7	3.18	—	1.2	
S500	**SPMN150408**	M	E							●		15.875	4.76	—	0.8	
	SPMN150412	M	E							●		15.875	4.76	—	1.2	
	SPGN150404	G	E							●		15.875	4.76	—	0.4	
	SPGN150408	G	F								●	15.875	4.76	—	0.8	

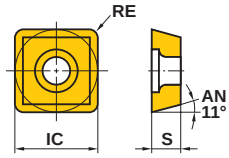
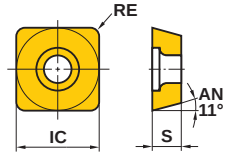
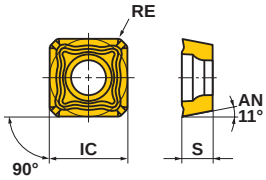
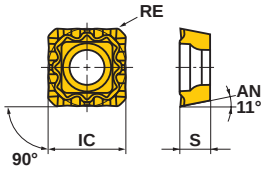
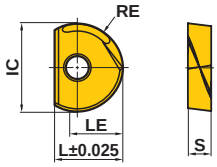
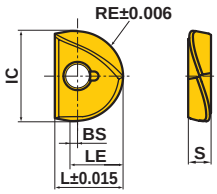
✱1 Grade HTi10 is "F".

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Work Material			EP6120	VP15TF	VP20RT	UP20M	MP8010	NX2525	NX4545	UTi20T	HTi10
	P	Steel	◐	◐	◐	◐		●	◐	◐	
	M	Stainless Steel		◔	◔	◔		○	◔	◔	
	K	Cast Iron		✠	✠			●		✠	◐
	N	Non-ferrous Metal	◐								◐
	S	Heat-resistant Alloy, Titanium Alloy		◐	✠						
	H	Hardened Steel	◔	◔			●				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp **T :** chamfer

Shape	Order Number	Class	Honing	Coated					Cermet		Carbide		Dimensions (mm)						Geometry
				EP6120	VP15TF	VP20RT	UP20M	MP8010	NX2525	NX4545	UTi20T	HTi10	L	LE	IC	S	BS	RE	
TBE1	SPMT120408-A	M	E				▲				▲		—	—	12.7	4.76	—	0.8	
CESP CFSP CGSP ➲ M246	SPMW090304	M	E ★1		●		●		●	●	●	●	—	—	9.525	3.18	—	0.4	
	SPMW090308	M	E ★1		●		●		●	●	●	●	—	—	9.525	3.18	—	0.8	
	SPMW120304	M	E ★1		●		●		●	●	●	●	—	—	12.7	3.18	—	0.4	
	SPMW120308	M	E ★1		●		●		●	●	●	●	—	—	12.7	3.18	—	0.8	
SPX ➲ M215	SPMX120408-JM	M	E		●	●							—	—	12.7	4.80	—	0.8	
SPX ➲ M215	SPMX120408-WH	M	E		●	●							—	—	12.7	4.76	—	0.8	
SRB ➲ M228	★2 SRBT10	—	F		●								8.5	5	10	2.6	—	5	
	★2 SRBT12	—	F		●								10	6	12	3	—	6	
	★2 SRBT16	—	F		●								12	8	16	4	—	8	
	★2 SRBT20	—	F		●								15	10	20	5	—	10	
	★2 SRBT25	—	F		●								18.5	12.5	25	6	—	12.5	
	★2 SRBT30	—	F		●								22.5	15	30	7	—	15	
	★2 SRBT32	—	F		●								23.5	16	32	7	—	16	
SRF ➲ M228	★2 SRFT10	—	F	●	●			●					8.5	5.5	10	2.6	0.5	5	
	★2 SRFT12	—	F	●	●			●					10	6.5	12	3	0.5	6	
	★2 SRFT16	—	F	●	●			●					12	9	16	4	1	8	
	★2 SRFT20	—	F	●	●			●					15	11	20	5	1	10	
	★2 SRFT25	—	F	●	●			●					18.5	13.5	25	6	1	12.5	
	★2 SRFT30	—	F	●	●			●					22.5	16	30	7	1	15	
	★2 SRFT32	—	F	●	●			●					23.5	17	32	7	1	16	

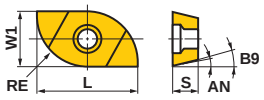
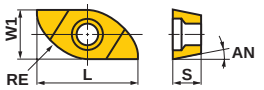
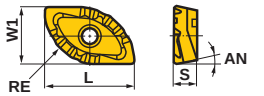
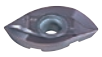
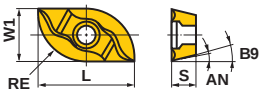
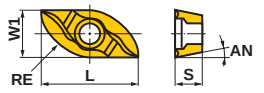
★1 Grade NX2525 and NX4545 are "T".
★2 2 inserts in one case.

ROTATING INSERTS

Work Material		MP6120	MP9120	VP15TF	VP20RT	VP30RT
P	Steel	◐		◐	◐	✠
M	Stainless Steel			◔	◔	✠
K	Cast Iron			✠	✠	✠
N	Non-ferrous Metal					
S	Heat-resistant Alloy, Titanium Alloy		◐	◐	✠	✠
H	Hardened Steel			◐		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

Shape	Order Number	Class	Honing	MP6120	MP9120	VP15TF	VP20RT	VP30RT	RE	L	W1	S	AN	B9	Geometry
				Coated					Dimensions (mm)						
SRM2 ➲ M236	**SRG16C**	G	E	●	●	●			8	16	8.2	3.5	11°	–	
	SRG20C	G	E	●	●	●			10	19	10.2	4.6	10°	18°	
	SRG25C	G	E	●	●	●			12.5	24	12.8	5.5	10°	18°	
	SRG30C	G	E	●	●	●			15	28	15.3	7	10°	18°	
	SRG32C	G	E	●	●	●			16	28	16.3	7	10°	18°	
SRM2 ➲ M236	**SRG16E**	G	E	●	●	●			8	13.5	6.7	3.5	11°	–	
	SRG20E	G	E	●	●	●			10	15.5	8.5	4.6	9°	–	
	SRG25E	G	E	●	●	●			12.5	20.5	10.2	5.5	9°	–	
	SRG30E	G	E	●	●	●			15	25.2	12.2	7	9°	–	
	SRG32E	G	E	●	●	●			16	26.1	13.1	7	9°	–	
SRM2ϕ40 ϕ50 ➲ M244	⁎ **SRG40C**	G	E			●	●	●	20	36	20.5	8.0	11°	–	
	⁎ **SRG50C**	G	E			●	●	●	25	40	26	8.5	11°	–	
SRM2ϕ40 ϕ50 ➲ M244	⁎ **SRG40E**	G	E			●	●	●	20	32	16.6	8.0	11°	–	
	⁎ **SRG50E**	G	E			●	●	●	25	35.8	20	8.5	11°	–	
SRM2 ➲ M236 	**SRM16C-M**	M	E	●	●	●			8	16	8.2	3.5	11°	–	
	SRM20C-M	M	E	●	●	●			10	19	10.2	4.6	10°	18°	
	SRM25C-M	M	E	●	●	●			12.5	24	12.8	5.5	10°	18°	
	SRM30C-M	M	E	●	●	●			15	28	15.3	7	10°	18°	
	SRM32C-M	M	E	●	●	●			16	28	16.3	7	10°	18°	
SRM2 ➲ M236	**SRM16E-M**	M	E	●	●	●			8	13.5	6.7	3.5	11°	–	
	SRM20E-M	M	E	●	●	●			10	15.5	8.5	4.6	9°	–	
	SRM25E-M	M	E	●	●	●			12.5	20.5	10.2	5.5	9°	–	
	SRM30E-M	M	E	●	●	●			15	25.2	12.2	7	9°	–	
	SRM32E-M	M	E	●	●	●			16	26.1	13.1	7	9°	–	

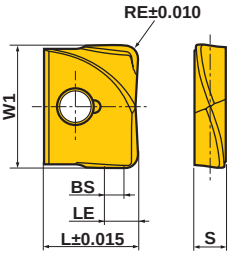
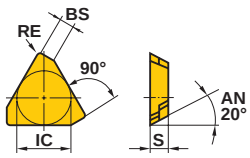
⁎ 2 inserts in one case.

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			F7030	MC5020	VP15TF	UP20M	MP8010	NX2525	NX4545	UTi20T	HTi10
	P	Steel	◐		◐	◐		●	◐	◐	
	M	Stainless Steel	◔		◔	◔		○	◔	◔	
	K	Cast Iron		◐	✱		●	●		✱	◐
	N	Non-ferrous Metal									◐
	S	Heat-resistant Alloy, Titanium Alloy			◐						
	H	Hardened Steel			◔		●				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing :
E : Round **F :** Sharp **S :** Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	Coated					Cermet		Carbide		Dimensions (mm)							Geometry
				F7030	MC5020	VP15TF	UP20M	MP8010	NX2525	NX4545	UTi20T	HTi10	W1	LE	IC	L	S	BS	RE	
SUF ➲ M232	✱ **SUFT10R05**	–	F			●		●					10	1.5	–	8.5	2.6	1	0.5	
	✱ **SUFT10R10**	–	F			●		●					10	2	–	8.5	2.6	1	1	
	✱ **SUFT10R20**	–	F			●		●					10	3	–	8.5	2.6	1	2	
	✱ **SUFT12R05**	–	F			●		●					12	1.7	–	10	3	1.2	0.5	
	✱ **SUFT12R10**	–	F			●		●					12	2.2	–	10	3	1.2	1	
	✱ **SUFT12R20**	–	F			●		●					12	3.2	–	10	3	1.2	2	
	✱ **SUFT12R30**	–	F			●		●					12	4.2	–	10	3	1.2	3	
	✱ **SUFT16R05**	–	F			●		●					16	2.1	–	12	4	1.6	0.5	
	✱ **SUFT16R10**	–	F			●		●					16	2.6	–	12	4	1.6	1	
	✱ **SUFT16R15**	–	F			●		●					16	3.1	–	12	4	1.6	1.5	
	✱ **SUFT16R20**	–	F			●		●					16	3.6	–	12	4	1.6	2	
	✱ **SUFT16R30**	–	F			●		●					16	4.6	–	12	4	1.6	3	
	✱ **SUFT20R05**	–	F			●		●					20	2.5	–	15	5	2	0.5	
	✱ **SUFT20R10**	–	F			●		●					20	3	–	15	5	2	1	
	✱ **SUFT20R15**	–	F			●		●					20	3.5	–	15	5	2	1.5	
	✱ **SUFT20R20**	–	F			●		●					20	4	–	15	5	2	2	
	✱ **SUFT20R30**	–	F			●		●					20	5	–	15	5	2	3	
	✱ **SUFT25R05**	–	F			●		●					25	3	–	18.5	6	2.5	0.5	
	✱ **SUFT25R10**	–	F			●		●					25	3.5	–	18.5	6	2.5	1	
	✱ **SUFT25R20**	–	F			●		●					25	4.5	–	18.5	6	2.5	2	
	✱ **SUFT25R30**	–	F			●		●					25	5.5	–	18.5	6	2.5	3	
	✱ **SUFT30R05**	–	F			●		●					30	3.5	–	22.5	7	3	0.5	
	✱ **SUFT30R10**	–	F			●		●					30	4	–	22.5	7	3	1	
	✱ **SUFT30R20**	–	F			●		●					30	5	–	22.5	7	3	2	
	✱ **SUFT30R30**	–	F			●		●					30	6	–	22.5	7	3	3	
	✱ **SUFT32R05**	–	F			●		●					32	3.7	–	23.5	7	3.2	0.5	
	✱ **SUFT32R10**	–	F			●		●					32	4.2	–	23.5	7	3.2	1	
	✱ **SUFT32R20**	–	F			●		●					32	5.2	–	23.5	7	3.2	2	
NSE300 **SE300**	**TEEN1603PEFR1**	E	F									●	–	–	9.525	–	3.175	1.4	0.4	
	TEEN1603PEER1	E	E			●						●	–	–	9.525	–	3.175	1.4	0.4	
	TEEN1603PETR1	E	T				●		●	●	●		–	–	9.525	–	3.175	1.4	0.4	
	TEEN1603PESR1	E	S	●	●								–	–	9.525	–	3.175	1.4	0.4	

✱ 2 inserts in one case.

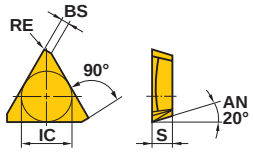
ROTATING INSERTS

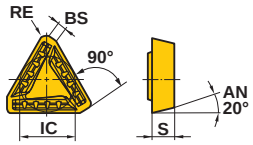
Work Material		F7030	MC5020	VP15TF	UP20M	AP10H	NX2525	NX4545	UTi20T	HTi10
	P Steel	◐		◐	◐	◐	●	◐	◐	
	M Stainless Steel	◔		◔	◔		○	◔	◔	
	K Cast Iron		◐	✠		◐	●		✠	◐
	N Non-ferrous Metal									◐
	S Heat-resistant Alloy, Titanium Alloy			◐						
	H Hardened Steel			◔						

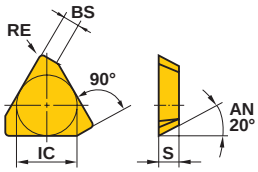
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

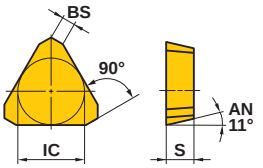
Honing :
E : Round **F :** Sharp **S :** Chamfer + Hone **T :** Chamfer

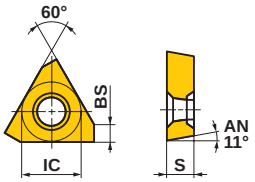
Shape	Order Number	Class	Honing	Coated					Cermet		Carbide		Dimensions (mm)				Geometry
				F7030	MC5020	VP15TF	UP20M	AP10H	NX2525	NX4545	UTi20T	HTi10	IC	S	BS	RE	
NSE300 SE300	TECN1603PEFR1W	C	F									●	9.525	3.175	1.4	0.4	Wall face finishing.
	TECN1603PEER1W	C	E									●	9.525	3.175	1.4	0.4	
	TECN1603PETR1W	C	T						●	●	●		9.525	3.175	1.4	0.4	
NSE300 NSE400	TEER1603PEER-JS	E	E	●							●		9.525	3.175	1.4	0.4	
	TEER2204PEER-JS	E	E	●							●		12.7	4.76	1.4	1.0	
NSE400 SE400	TECN2204PEFR1	C	F									●	12.7	4.76	1.4	1.0	
	TECN2204PEER1	C	E									●	12.7	4.76	1.4	1.0	
	TECN2204PETR1	C	T						●	●	●		12.7	4.76	1.4	1.0	
	TEEN2204PEFR1	E	F									●	12.7	4.76	1.4	1.0	
	TEEN2204PEER1	E	E			●						●	12.7	4.76	1.4	1.0	
	TEEN2204PETR1	E	T				●		●	●	●		12.7	4.76	1.4	1.0	
	TEEN2204PESR1	E	S	●	●								12.7	4.76	1.4	1.0	
	TEKN2204PEER1	K	E									●	12.7	4.76	1.94	—	
	TEKN2204PESR1	K	S	●									12.7	4.76	1.94	—	
	TEKN2204PETR1	K	T				●		●		●		12.7	4.76	1.94	—	
	TEKN2204PETR	K	T							●			12.7	4.76	1.94	—	Right hand insert shown.
	TPEN1603PPR	E	T	▲					▲				9.525	3.18	1.2	—	
	TPKN1603PPR	K	T *1	▲		●	▲		▲	▲	▲	▲	9.525	3.18	1.2	—	
	TPEN2204PDR	E	T *1	▲									12.7	4.76	1.4	—	
	TPKN2204PDR	K	T *1	▲		●	▲		▲	▲	▲	▲	12.7	4.76	1.4	—	
PMF ➲ M256	TPEW1303ZPER2	E	E			●		●					7.94	3.18	2	—	











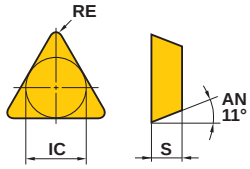
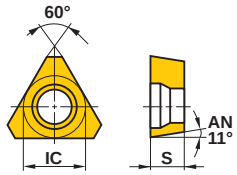
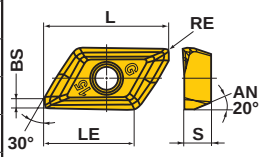
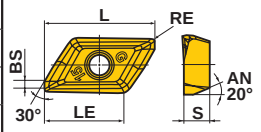
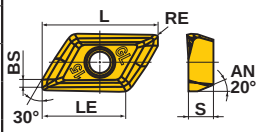
*1 Grade F7030 is "E".

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

Work Material			F7030	VP15TF	LC15TF	UP20M	NX2525	UTi20T	HTi10	TF15
	P	Steel	◐	◐		◐	●	◐		
	M	Stainless Steel	◔	◔		◔	○	◔		
	K	Cast Iron		✣			●	✣	◐	
	N	Non-ferrous Metal			◐				◐	◐
	S	Heat-resistant Alloy, Titanium Alloy		◐						
	H	Hardened Steel		◔						

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp **T :** chamfer

Shape	Order Number	Class	Honing	Coated				Cermet	Carbide			Dimensions (mm)						Geometry
				F7030	VP15TF	LC15TF	UP20M	NX2525	UTi20T	HTi10	TF15	L	LE	IC	S	BS	RE	
11°Positive	TPMN160304	M	E*1	●	●		●	●	●	●		—	—	9.525	3.18	—	0.4	
	TPMN160308	M	E*2	●	●		●	●	●	●		—	—	9.525	3.18	—	0.8	
	TPMN160312	M	E*1				●			●		—	—	9.525	3.18	—	1.2	
	TPMN220404	M	E						●			—	—	12.7	4.76	—	0.4	
	TPMN220408	M	E*1	●	●		●		●	●		—	—	12.7	4.76	—	0.8	
	TPMN220412	M	E*1	●	●				●	●		—	—	12.7	4.76	—	1.2	
VIPER	TPNX1605N	N	E						●			—	—	9.525	5	—	—	
BXD4000 ➲ M150	XDGT1550PDER-G04	G	E		●							22	15.5	—	5	1.5	0.4	
	XDGT1550PDER-G08	G	E		●							22	15.5	—	5	1.1	0.8	
	XDGT1550PDER-G12	G	E		●							22	15.5	—	5	0.7	1.2	
	XDGT1550PDER-G16	G	E		●							22	15.6	—	5	0.5	1.6	
	XDGT1550PDER-G20	G	E		●							21.7	15.6	—	5	0.2	2.0	
	XDGT1550PDER-G30	G	E		●							20	14.8	—	5	0.6	3.0	
	XDGT1550PDER-G32	G	E		●							20	14.8	—	5	0.4	3.2	
	XDGT1550PDER-G40	G	E		●							19	14.4	—	5	0.5	4.0	
	XDGT1550PDER-G50	G	E		●							18	14	—	5	0.4	5.0	
BXD4000 ➲ M150	XDGT1550PDFR-G04	G	F			●					●	22	15.5	—	5	1.5	0.4	
	XDGT1550PDFR-G08	G	F			●					●	22	15.5	—	5	1.1	0.8	
	XDGT1550PDFR-G12	G	F			●					●	22	15.5	—	5	0.7	1.2	
	XDGT1550PDFR-G16	G	F			●					●	22	15.6	—	5	0.3	1.6	
	XDGT1550PDFR-G20	G	F			●					●	21.7	15.6	—	5	0.2	2.0	
	XDGT1550PDFR-G30	G	F			●					●	20	14.8	—	5	0.6	3.0	
	XDGT1550PDFR-G32	G	F			●					●	20	14.8	—	5	0.4	3.2	
	XDGT1550PDFR-G40	G	F			●					●	19	14.4	—	5	0.5	4.0	
	XDGT1550PDFR-G50	G	F			●					●	18	14	—	5	0.4	5.0	
BXD4000 ➲ M150	XDGT1550PDFR-GL04	G	F								●	22	15.5	—	5	1.5	0.4	
	XDGT1550PDFR-GL08	G	F								●	22	15.5	—	5	1.1	0.8	

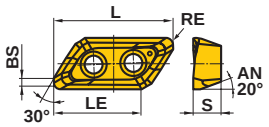
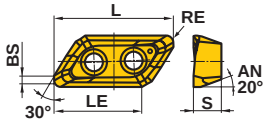
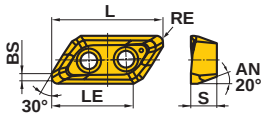
*1 Grade HTi10 is "F".
*2 Grade HTi10 is "F", Grade NX2525 is "T".

ROTATING INSERTS

Work Material			LC15TF	MP6120	MP9120	TF15
	P	Steel		◐		
	M	Stainless Steel				
	K	Cast Iron				
	N	Non-ferrous Metal	◐			✠
	S	Heat-resistant Alloy, Titanium Alloy			◐	
	H	Hardened Steel				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

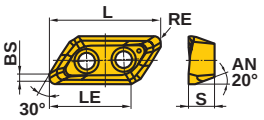
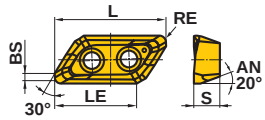
Shape	Order Number	Class	Honing	Coated LC15TF	Coated MP6120	Coated MP9120	Carbide TF15	L	LE	S	BS	RE	Geometry
AXD4000 ➲ M134	**XDGX175004PDFR-GL**	G	F	●			●	23	16.9	5	1.7	0.4	
	XDGX175008PDFR-GL	G	F	●			●	23	17	5	1.3	0.8	
	XDGX175012PDFR-GL	G	F	●			●	23	17	5	0.9	1.2	
	XDGX175016PDFR-GL	G	F	●			●	22	16.4	5	1.4	1.6	
	XDGX175020PDFR-GL	G	F	●			●	22	16.4	5	1	2.0	
	XDGX175024PDFR-GL	G	F	●			●	22	16.4	5	0.6	2.4	
	XDGX175030PDFR-GL	G	F	●			●	21.1	16.1	5	0.8	3.0	
	XDGX175032PDFR-GL	G	F	●			●	21.1	16.1	5	0.6	3.2	
	XDGX175040PDFR-GL	G	F	●			●	20	15.6	5	0.8	4.0	
	XDGX175050PDFR-GL	G	F	●			●	19.4	15.3	5	0.4	5.0	
AXD4000 ➲ M134	**XDGX175004PDER-GM**	G	E		●	●		23	17	5	1.7	0.4	
	XDGX175008PDER-GM	G	E		●	●		23	17	5	1.2	0.8	
	XDGX175012PDER-GM	G	E		●	●		23	17	5	0.9	1.2	
	XDGX175016PDER-GM	G	E		●	●		22	15.9	5	1.4	1.6	
	XDGX175020PDER-GM	G	E		●	●		22	15.9	5	0.8	2.0	
	XDGX175024PDER-GM	G	E		●	●		22	15.9	5	0.4	2.4	
	XDGX175030PDER-GM	G	E		●	●		21.1	16	5	0.6	3.0	
	XDGX175032PDER-GM	G	E		●	●		21.1	16	5	0.4	3.2	
	XDGX175040PDER-GM	G	E		●	●		20	14.8	5	0.5	4.0	
	XDGX175050PDER-GM	G	E		●	●		19.4	15	5	0.4	5.0	
AXD4000 ➲ M134	**XDGX175004PDFR-GM**	G	F				●	23	17	5	1.7	0.4	
	XDGX175008PDFR-GM	G	F				●	23	17	5	1.2	0.8	
	XDGX175012PDFR-GM	G	F				●	23	17	5	0.9	1.2	
	XDGX175016PDFR-GM	G	F				●	22	15.9	5	1.4	1.6	
	XDGX175020PDFR-GM	G	F				●	22	15.9	5	0.8	2.0	
	XDGX175024PDFR-GM	G	F				●	22	15.9	5	0.4	2.4	
	XDGX175030PDFR-GM	G	F				●	21.1	16	5	0.6	3.0	
	XDGX175032PDFR-GM	G	F				●	21.1	16	5	0.4	3.2	
	XDGX175040PDFR-GM	G	F				●	20	14.8	5	0.5	4.0	
	XDGX175050PDFR-GM	G	F				●	19.4	15	5	0.4	5.0	

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			LC15TF	MP6120	MP9120	TF15
	P	Steel		◐		
	M	Stainless Steel				
	K	Cast Iron				
	N	Non-ferrous Metal	◐			●
	S	Heat-resistant Alloy, Titanium Alloy			◐	
	H	Hardened Steel				

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

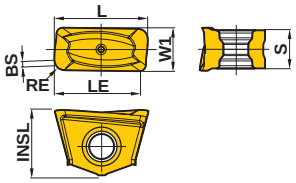
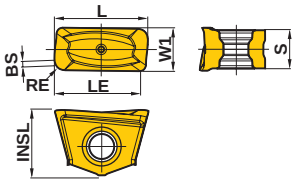
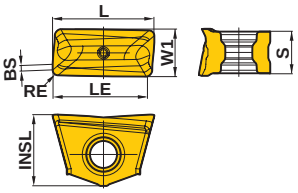
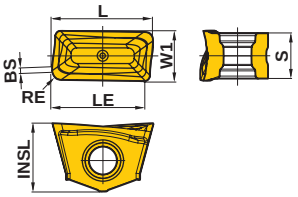
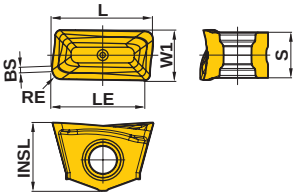
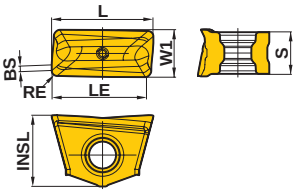
Shape	Order Number	Class	Honing	Coated LC15TF	Coated MP6120	Coated MP9120	Carbide TF15	Dimensions (mm) L	LE	S	BS	RE	Geometry
AXD7000 ➲ M142	**XDGX227008PDFR-GL**	G	F	●			●	30	21.6	7	2	0.8	
	XDGX227016PDFR-GL	G	F	●			●	30	21.7	7	1.2	1.6	
	XDGX227020PDFR-GL	G	F	●			●	30	21.7	7	0.8	2.0	
	XDGX227030PDFR-GL	G	F	●			●	28.8	21.2	7	0.9	3.0	
	XDGX227032PDFR-GL	G	F	●			●	28.8	21.2	7	0.7	3.2	
	XDGX227040PDFR-GL	G	F	●			●	27.5	20.6	7	1	4.0	
	XDGX227050PDFR-GL	G	F	●			●	27	20.3	7	0.4	5.0	
AXD7000 ➲ M142	**XDGX227008PDER-GLA**	G	E		●	●		30	21.7	7	2	0.8	
	XDGX227016PDER-GLA	G	E		●	●		30	21.7	7	1.2	1.6	
	XDGX227020PDER-GLA	G	E		●	●		30	21.7	7	0.8	2.0	
	XDGX227024PDER-GLA	G	E		●	●		30	21.7	7	0.3	2.4	
	XDGX227030PDER-GLA	G	E		●	●		28.8	21.1	7	0.9	3.0	
	XDGX227032PDER-GLA	G	E		●	●		28.8	21.1	7	0.6	3.2	
	XDGX227040PDER-GLA	G	E		●	●		27.5	20.4	7	0.9	4.0	
	XDGX227050PDER-GLA	G	E		●	●		27	20.2	7	0.3	5.0	

ROTATING INSERTS

Work Material		
	P	Steel
	M	Stainless Steel
	K	Cast Iron
	N	Non-ferrous Metal
	S	Heat-resistant Alloy, Titanium Alloy
	H	Hardened Steel

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

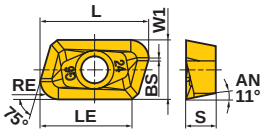
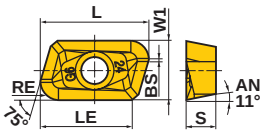
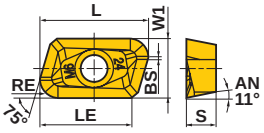
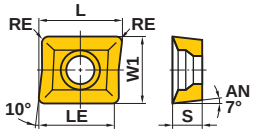
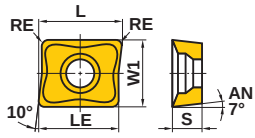
Shape	Order Number	Class	Honing	Coated MP9130	L	LE	W1	INSL	S	BS	RE	Geometry
					Dimensions (mm)							
VFX5 ➲ M220	XNMU160708R-MS	M	E	●	16.0	13.4	7.0	11.1	6.5	1.0	0.8	
	XNMU160712R-MS	M	E	●	16.0	13.8	7.0	11.1	6.5	1.0	1.2	
	XNMU160716R-MS	M	E	●	16.0	13.8	7.0	11.1	6.5	1.0	1.6	
	XNMU160724R-MS	M	E	●	16.0	13.8	7.0	11.1	6.5	1.0	2.4	
	XNMU160732R-MS	M	E	●	17.3	14.4	7.0	11.1	6.5	—	3.2	
	XNMU160740R-MS	M	E	●	18.9	15.2	7.0	11.1	6.5	—	4.0	
VFX5 ➲ M220	XNMU160708R-HS	M	E	●	16.0	13.4	7.0	11.1	6.5	1.0	0.8	
VFX5 ➲ M220	XNMU160708R-LS	M	E	●	16.0	13.4	7.0	11.1	6.5	1.0	0.8	
VFX6 ➲ M224	XNMU190912R-MS	M	E	●	19.1	16.5	9.5	12.7	8.5	1.0	1.2	
	XNMU190916R-MS	M	E	●	19.1	16.5	9.5	12.7	8.5	1.0	1.6	
	XNMU190924R-MS	M	E	●	19.1	16.6	9.5	12.7	8.5	1.0	2.4	
	XNMU190932R-MS	M	E	●	20.2	17.1	9.5	12.7	8.5	—	3.2	
	XNMU190940R-MS	M	E	●	21.8	17.8	9.5	12.7	8.5	—	4.0	
	XNMU190950R-MS	M	E	●	21.8	17.8	9.5	12.7	8.5	—	5.0	
VFX6 ➲ M224	XNMU190912R-HS	M	E	●	19.1	16.5	9.5	12.7	8.5	1.0	1.2	
VFX6 ➲ M224	XNMU190912R-LS	M	E	●	19.1	16.5	9.5	12.7	8.5	1.0	1.2	

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			F7030	VP15TF	UP20M				HTi10	UTi20T
	P	Steel	◐	◐	◐					◐
	M	Stainless Steel	◔	◔	◔					◔
	K	Cast Iron		✱					◐	✱
	N	Non-ferrous Metal							◐	
	S	Heat-resistant Alloy, Titanium Alloy		◐						
	H	Hardened Steel		◔						

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing :
E : Round **F :** Sharp

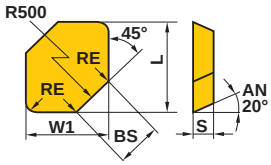
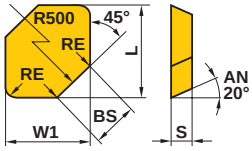
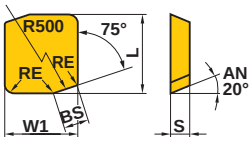
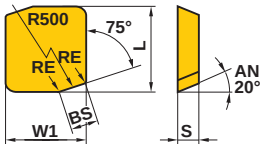
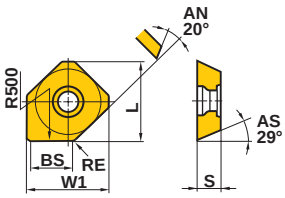
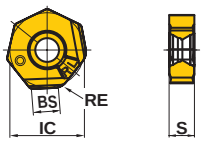
Shape	Order Number	Class	Honing	Coated						Carbide		Dimensions (mm)						Geometry
				F7030	VP15TF	UP20M				HTi10	UTi20T	L	LE	W1	S	BS	RE	
BAP3500	**XPGT13T3PDER-G1**	G	E		●							14.6	11.7	7.9	3.97	1.6	0.4	
	XPGT13T3PDER-G2	G	E		●							14.7	11.7	7.9	3.97	1.2	0.8	
	XPGT13T3PDER-G6	G	E		●							14.2	11.5	7.9	3.97	0.4	2.4	
	XPGT13T3PDER-G75	G	E		●							13.8	11.3	7.9	3.97	0.4	3.0	
	XPGT13T3PDER-G8	G	E		●							13.7	11.2	7.9	3.97	0.4	3.2	
BAP3500	**XPGT13T3PDFR-G1**	G	F							●		14.6	11.7	7.9	3.97	1.6	0.4	
	XPGT13T3PDFR-G2	G	F							●		14.7	11.7	7.9	3.97	1.2	0.8	
	XPGT13T3PDFR-G6	G	F							●		14.2	11.5	7.9	3.97	0.4	2.4	
	XPGT13T3PDFR-G75	G	F							●		13.8	11.3	7.9	3.97	0.4	3.0	
	XPGT13T3PDFR-G8	G	F							●		13.7	11.2	7.9	3.97	0.4	3.2	
BAP3500	**XPMT13T3PDER-M1**	M	E	●	●							14.6	11.7	7.9	3.97	1.6	0.4	
	XPMT13T3PDER-M2	M	E	●	●							14.7	11.8	7.9	3.97	1.2	0.8	
	XPMT13T3PDER-M6	M	E	●	●							14.2	11.6	7.9	3.97	0.4	2.4	
	XPMT13T3PDER-M75	M	E	●	●							13.8	11.4	7.9	3.97	0.4	3.0	
	XPMT13T3PDER-M8	M	E	●	●							13.7	11.3	7.9	3.97	0.4	3.2	
DCCC ➲ M212	**ZCMX083508ER-A**	M	E	●							●	11.0	8.5	7.94	3.5	—	0.8	
	ZCMX09T308ER-A	M	E	●	●	●					●	12.7	11.0	9.525	3.97	—	0.8	
DCCC ➲ M212	**ZCMX09T308ER-B**	M	E	●		●					●	12.7	11.0	9.525	3.97	—	0.8	

WIPER INSERTS

Work Material		MP6120	MC5020	VP15TF	NX2525	VP25N	HTi05T
P	Steel	◐		◐	◐	◐	
M	Stainless Steel			◔	◔	◔	
K	Cast Iron		◐	✠	◐	◐	◐
N	Non-ferrous Metal						◐
S	Heat-resistant Alloy, Titanium Alloy			◐			
H	Hardened Steel			◔			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **T :** Chamfer

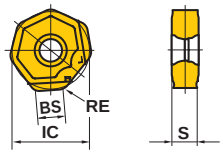
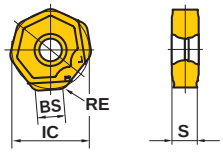
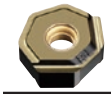
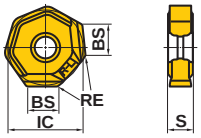
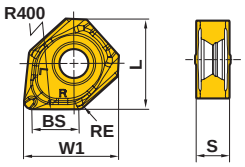
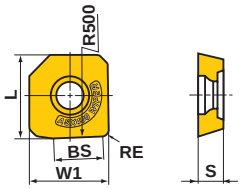
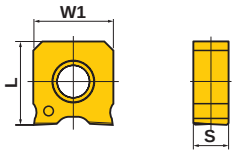
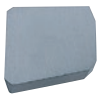
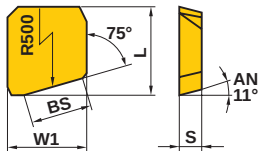
Shape	Order Number	Class	Honing	Coated MP6120	Coated MC5020	Coated VP15TF	Cermet NX2525	Coated Cermet VP25N	Carbide HTi05T	L	W1	IC	S	BS	RE	Dimensions (mm)
SE445 LSE445	**WEC42AFTR5C**	C	T				●			15.33	12.7	—	3.18	5	1.0	
SE545	**WEC53AFER5C**	C	E						●	18.505	15.875	—	4.76	5	1.0	
	WEC53AFTR5C	C	T				●			18.505	15.875	—	4.76	5	1.0	
SE415	**WEC42EFER5C**	C	E						●	13.728	12.7	—	3.18	5	1.0	
	WEC42EFTR5C	C	T				●			13.728	12.7	—	3.18	5	1.0	
SE515 ➲ M062	**WEC53EFTR5C**	C	T				●			16.903	15.875	—	4.76	5	1.0	
ASX445 ➲ M030	**WEEW13T3AGER8C**	E	E		●	●			●	16.6	16.48	—	3.97	7.5	1.5	
	WEEW13T3AGTR8C	E	T				●	●		16.6	16.48	—	3.97	7.5	1.5	
AHX440S ➲ M038	**WNEU1305ZEN4C-M**	E	E	●	●	●				—	—	13.4	5.1	4	2.7	

● : Inventory maintained in Japan.
(10 inserts in one case)

Work Material			MC5020	MP6120	VP15TF	NX2525	MX3020 (NEW)	HTi05T
	P	Steel		◐	◐	●	◐	
	M	Stainless Steel			◔	○	◔	
	K	Cast Iron	◐		✱	●	◐	●
	N	Non-ferrous Metal						●
	S	Heat-resistant Alloy, Titanium Alloy			◐			
	H	Hardened Steel			◔			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing :
E : Round **F :** Sharp **T :** Chamfer

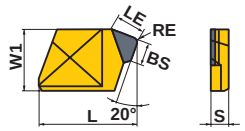
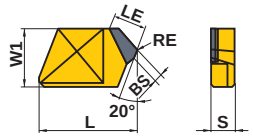
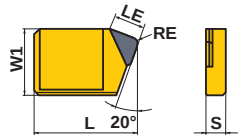
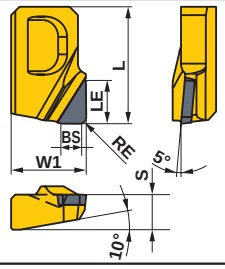
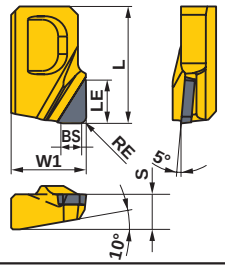
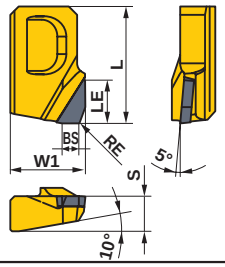
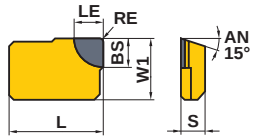
Shape	Order Number	Class	Honing	Coated			Cermet		Carbide	Dimensions (mm)						Geometry
				MC5020	MP6120	VP15TF	NX2525	MX3020 (NEW)	HTi05T	L	W1	IC	S	BS	RE	
AHX640S ➲ M046	WNEU2007ZEN7C-M	E	E		●					—	—	20	6.9	7.2	0.8	
AHX640S ➲ M046	WNEU2007ZEN7C-WP	E	E			●				—	—	20	6.9	7.1	0.8	
AHX640S ➲ M046 AHX640W ➲ M054 	WNEU2006ZEN7C-WK	E	E	●						—	—	20	6.55	7.4	0.8	
WSX445 ➲ M018	WNGU1406ANEN8C-M	G	E	●	●	●		●		16.87	16.87	—	6	8	1.0	
ASX400 ➲ M080	WOEW12T308PEER8C	E	E						●	13.2	12.5	—	3.97	8	0.8	
	WOEW12T308PETR8C	E	T				●			13.2	12.5	—	3.97	8	0.8	
VOX400 ➲ M076	WOEX1206PER5C	E	E			●				13.025	12.5	—	5.5	—	—	
FBP415 QBP415 	WPC42EEER10C	C	E						●	15.163	12.7	—	3.175	10	—	 Right hand insert shown.
	WPC42EEEL10C	C	E						●	15.163	12.7	—	3.175	10	—	

● = NEW

CBN & PCD INSERTS

Work Material			MB730	MD220	MD2030
	K	Cast Iron	◐	◐	◐
	N	Non-ferrous Metal			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

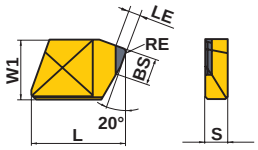
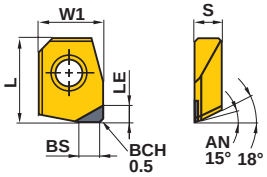
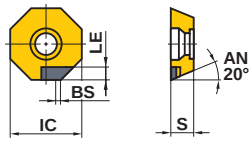
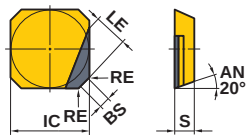
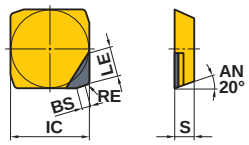
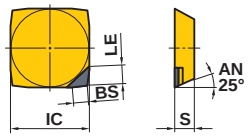
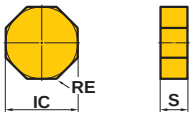
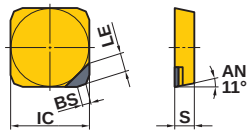
Shape	Order Number	Class	CBN MB730	PCD MD220	PCD MD2030	L	W1	S	BS	LE	RE	Geometry
NF10000 ➲ M072	GDCN2004PDFR3	C		●		20	12.7	4.76	3	5	1.2	
NR10000	GDCN2004ZDTR1	C		●		20	12.7	4.76	1.4	6.3	0.8	
AF10000	GDCN2004PDR	C		●		20	12.7	4.76	4.9	6.2	1.2	
FMAX ➲ M066	GOER1404PXFR2	E		●	●	14	9	4.2	2	5	0.4	
	GOER1408PXFR2	E		●	●	14	9	4.2	2	5	0.8	
FMAX ➲ M066 NEW	GOER1408PXFR2-8	E		●		14	9	4.2	2	8	0.8	
FMAX ➲ M066 NEW	GOER1401ZXFR2	E		●		14	9	4.2	2	5	0.1	
AF5000	LDCN190412R	C		●		19.05	12.7	4.76	4.3	6.2	1.2	
	LDCN190412R	C	●			19.05	12.7	4.76	4.3	6.0	1.2	
	LDCN190412L	C		●		19.05	12.7	4.76	4.3	6.2	1.2	

● = NEW

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(1 inserts in one case)

Work Material																		
	K	Cast Iron		◐	◐	◐												
	N	Non-ferrous Metal					◐											

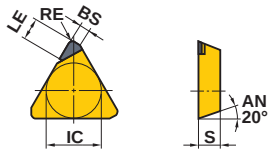
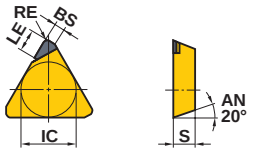
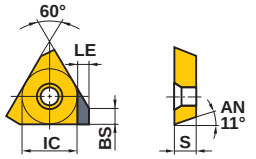
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	CBN			PCD	Dimensions (mm)							Geometry
			MB710	MB730	BC5030	MD220	L	W1	IC	LE	S	BS	RE	
NF10000 ➲ M072	NP-GDCN2004PDSR3	C		●			20	12.7	—	2.5	4.76	3	0.8	
V10000 ➲ M070	NP-GDCW1240PDFR2	C				●	12	9.5	—	2	4	2	—	
OCTACUT ➲ M180	OEMX12T3ETR1	M		●			—	—	12.7	2.5	3.97	1	—	
SE445 LSE445	SECN1203AFFR1	C				▲	—	—	12.7	5	3.18	1.4	1.0	
SE415	SECN1203EFFR1	C				●	—	—	12.7	5	3.18	1.4	1.0	
BF407	SFCN1203ZFFR2	C				▲	—	—	12.7	3	3.175	2.4	—	
AOX445 ➲ M060	SL-ONEN120404ASN	E			●		—	—	12.7	—	4.76	—	0.4	
FBP415	SPEN1203EETR1	E	●				—	—	12.7	3	3.175	1.4	—	

CBN & PCD INSERTS

Work Material			MB710	BC5030	MD220
	K	Cast Iron	◐	◐	
	N	Non-ferrous Metal			◐

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	CBN MB710	CBN BC5030	PCD MD220	IC	LE	S	BS	RE	Geometry
SE300 NSE300	**TECN1603PEFR1**	C			●	9.525	5	3.175	1.4	0.4	
SE400 NSE400	**TECN2204PEFR1**	C			▲	12.7	5	4.76	1.4	1.0	
PMF ➲ M256	**TPEW1303ZPTR2**	E	●			7.94	1.5	3.18	2	—	

L

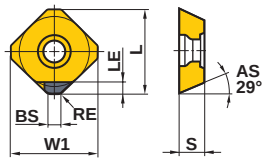
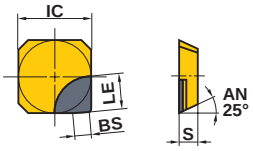
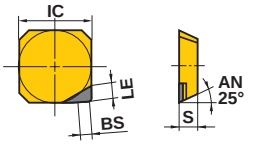
ROTATING TOOL INSERTS

● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(1 inserts in one case)

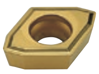
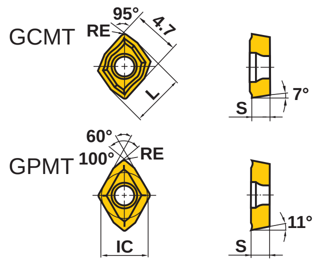
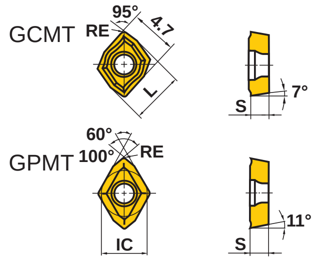
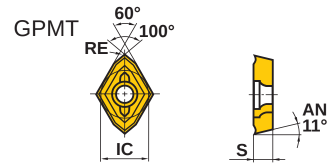
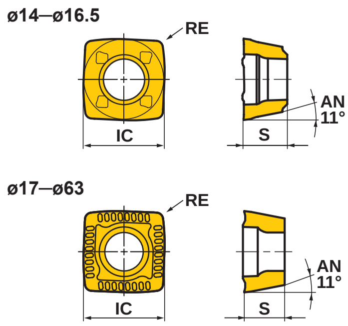
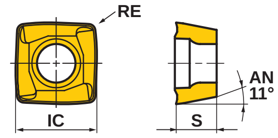
CBN & PCD INSERTS WITH WIPER

Work Material				
K	Cast Iron	◐		
N	Non-ferrous Metal		◐	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

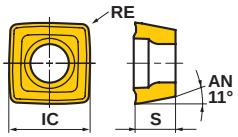
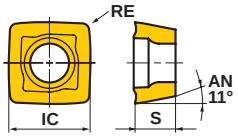
Shape	Order Number	Class	CBN MB710	PCD MD220	Dimensions (mm) L	W1	LE	IC	S	BS	RE	Geometry
ASX445 ➲ M030	**WEEW13T3AGFR3C**	E		●	16.6	16.48	1.8	—	3.97	3.0	1.5	
	WEEW13T3AGTR3C	E	●		16.6	16.48	1.8	—	3.97	3.0	1.5	
BF407	**WFC42ZFER2**	C		▲	—	—	6.2	12.4	3.175	2.4	—	
BF407	**NP-WFC42ZFER2**	C		▲	—	—	3.0	12.4	3.175	2.4	—	

DRILLING INSERTS

Shape	Order Number	Class	Coated VP15TF	Coated UP20M	Coated GP20M	Coated UE6020	Coated US735	Coated MC1020	Coated MC5020	Dimensions (mm) IC	Dimensions (mm) L	Dimensions (mm) S	Dimensions (mm) RE	Geometry
TAF ➲ P241 GCMT  GPMT	GCMT040204-U1	M		●						—	5.0	2.38	0.4	**U1** Breaker 
	GPMT060204-U1	M		●		●				5.56	—	2.38	0.4	
	GPMT070204-U1	M		●		●				6.35	—	2.38	0.4	
	GPMT090304-U1	M		●		●				7.94	—	3.18	0.4	
	GPMT11T308-U1	M		●		●				9.525	—	3.97	0.8	
	GPMT140408-U1	M		●		●				12.7	—	4.76	0.8	
TAF ➲ P241 GCMT GPMT	GCMT040204-U2	M	●		●					—	5.0	2.38	0.4	**U2** Breaker 
	GPMT060204-U2	M	●	●		●	●			5.56	—	2.38	0.4	
	GPMT070204-U2	M	●	●		●	●			6.35	—	2.38	0.4	
	GPMT090304-U2	M	●	●		●	●			7.94	—	3.18	0.4	
	GPMT11T308-U2	M	●	●		●	●			9.525	—	3.97	0.8	
	GPMT140408-U2	M	●	●		●	●			12.7	—	4.76	0.8	
TAF ➲ P241	GPMT060204-U3	M		●		●	●			5.56	—	2.38	0.4	**U3** Breaker 
	GPMT070204-U3	M		●		●	●			6.35	—	2.38	0.4	
	GPMT090304-U3	M		●		●	●			7.94	—	3.18	0.4	
	GPMT11T308-U3	M		●		●	●			9.525	—	3.97	0.8	
	GPMT140408-U3	M		●		●	●			12.7	—	4.76	0.8	
MVX ➲ P230	NEW SOMX052704-UM	M	●					●	●	5	—	2.7	0.4	
	SOMX063005-UM	M	●					●	●	6	—	3	0.5	
	SOMX073505-UM	M	●					●	●	7	—	3.5	0.5	
	SOMX084005-UM	M	●					●	●	8.3	—	4	0.5	
	SOMX094506-UM	M	●					●	●	9.7	—	4.5	0.6	
	SOMX115506-UM	M	●					●	●	11.6	—	5.5	0.6	
	SOMX136008-UM	M	●					●	●	13.8	—	6	0.8	
	SOMX166508-UM	M	●					●	●	16.5	—	6.5	0.8	
	SOMX187008-UM	M	●					●	●	18.2	—	7	0.8	
MVX ➲ P230	SOMX063005-US	M	●							6	—	3	0.5	
	SOMX073505-US	M	●							7	—	3.5	0.5	
	SOMX084005-US	M	●							8.3	—	4	0.5	
	SOMX094506-US	M	●							9.7	—	4.5	0.6	
	SOMX115506-US	M	●							11.6	—	5.5	0.6	
	SOMX136008-US	M	●							13.8	—	6	0.8	
	SOMX166508-US	M	●							16.5	—	6.5	0.8	
	SOMX187008-US	M	●							18.2	—	7	0.8	

● = NEW

● : Inventory maintained in Japan.
(10 insert in one case)

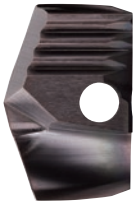
Shape	Order Number	Class	Coated							Dimensions (mm)				Geometry
			DP8020	TF15						IC	L	S	RE	
MVX P230	SOMX062905-UH	M	●							6	–	2.9	0.5	
	SOMX073405-UH	M	●							7	–	3.4	0.5	
	SOMX083905-UH	M	●							8.3	–	3.9	0.5	
	SOMX094406-UH	M	●							9.7	–	4.4	0.6	
	SOMX115406-UH	M	●							11.6	–	5.4	0.6	
	SOMX135908-UH	M	●							13.8	–	5.9	0.8	
	SOMX166408-UH	M	●							16.5	–	6.4	0.8	
	SOMX186908-UH	M	●							18.2	–	6.9	0.8	
MVX P230	SOGX063005-UN	G		●						6	–	3	0.5	
	SOGX073505-UN	G		●						7	–	3.5	0.5	
	SOGX084005-UN	G		●						8.3	–	4	0.5	
	SOGX094506-UN	G		●						9.7	–	4.5	0.6	
	SOGX115506-UN	G		●						11.6	–	5.5	0.6	
	SOGX136008-UN	G		●						13.8	–	6	0.8	
	SOGX166508-UN	G		●						16.5	–	6.5	0.8	
	SOGX187008-UN	G		●						18.2	–	7	0.8	

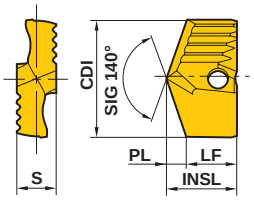
DRILLING INSERTS

Applicable Drill Shape Geometry

TAW H Type

➲ P219





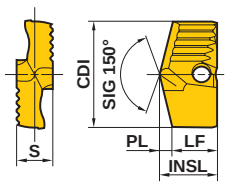
Order Number	Coated VP15TF	Coated VP10H	CDI	INSL	LF	PL	S	Applicable Holder
TAWNH1850T	●	□	18.5	12.7	9.3	3.4	7.0	TAWSN 1900S25 / TAWMN 1900S25 / TAWLN 1900S25
TAWNH1860T	●	□	18.6	12.7	9.3	3.4	7.0	
TAWNH1870T	●	□	18.7	12.7	9.3	3.4	7.0	
TAWNH1880T	●	□	18.8	12.7	9.3	3.4	7.0	
TAWNH1890T	●	□	18.9	12.7	9.3	3.4	7.0	
TAWNH1900T	●	□	19.0	12.7	9.2	3.5	7.0	
TAWNH1910T	●	□	19.1	12.7	9.2	3.5	7.0	
TAWNH1920T	●	□	19.2	12.7	9.2	3.5	7.0	
TAWNH1930T	●	□	19.3	12.7	9.2	3.5	7.0	
TAWNH1940T	●	□	19.4	12.7	9.2	3.5	7.0	
TAWNH1950T	●	□	19.5	12.6	9.1	3.5	7.0	TAWSN 2000S25 / TAWMN 2000S25 / TAWLN 2000S25
TAWNH1960T	●	□	19.6	12.7	9.1	3.6	7.0	
TAWNH1970T	●	□	19.7	12.7	9.1	3.6	7.0	
TAWNH1980T	●	□	19.8	12.7	9.1	3.6	7.0	
TAWNH1990T	●	□	19.9	12.7	9.1	3.6	7.0	
TAWNH2000T	●	□	20.0	12.6	9.0	3.6	7.0	
TAWNH2010T	□	□	20.1	12.7	9.0	3.7	7.0	
TAWNH2020T	□	□	20.2	12.7	9.0	3.7	7.0	
TAWNH2030T	□	□	20.3	12.7	9.0	3.7	7.0	
TAWNH2040T	□	□	20.4	12.7	9.0	3.7	7.0	
TAWNH2050T	●	□	20.5	12.6	8.9	3.7	7.0	TAWSN 2100S25 / TAWMN 2100S25 / TAWLN 2100S25
TAWNH2060T	□	□	20.6	12.6	8.9	3.7	7.0	
TAWNH2070T	□	□	20.7	12.7	8.9	3.8	7.0	
TAWNH2080T	□	□	20.8	12.7	8.9	3.8	7.0	
TAWNH2090T	□	□	20.9	12.7	8.9	3.8	7.0	
TAWNH2100T	●	□	21.0	12.6	8.8	3.8	7.0	
TAWNH2110T	□	□	21.1	12.6	8.8	3.8	7.0	
TAWNH2120T	□	□	21.2	12.7	8.8	3.9	7.0	
TAWNH2130T	□	□	21.3	12.7	8.8	3.9	7.0	
TAWNH2140T	□	□	21.4	12.7	8.8	3.9	7.0	
TAWNH2150T	●	□	21.5	14.5	10.6	3.9	8.0	TAWSN 2200S25 / TAWMN 2200S25 / TAWLN 2200S25
TAWNH2160T	□	□	21.6	14.5	10.6	3.9	8.0	
TAWNH2170T	□	□	21.7	14.5	10.6	3.9	8.0	
TAWNH2180T	□	□	21.8	14.6	10.6	4.0	8.0	
TAWNH2190T	□	□	21.9	14.6	10.6	4.0	8.0	
TAWNH2200T	●	□	22.0	14.5	10.5	4.0	8.0	
TAWNH2210T	□	□	22.1	14.5	10.5	4.0	8.0	
TAWNH2220T	□	□	22.2	14.5	10.5	4.0	8.0	
TAWNH2230T	□	□	22.3	14.6	10.5	4.1	8.0	
TAWNH2240T	□	□	22.4	14.6	10.5	4.1	8.0	
TAWNH2250T	●	□	22.5	14.5	10.4	4.1	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWNH2260T	□	□	22.6	14.5	10.4	4.1	8.0	
TAWNH2270T	□	□	22.7	14.5	10.4	4.1	8.0	
TAWNH2280T	□	□	22.8	14.5	10.4	4.1	8.0	
TAWNH2290T	□	□	22.9	14.6	10.4	4.2	8.0	

Order Number	Coated VP15TF	Coated VP10H	CDI	INSL	LF	PL	S	Applicable Holder
TAWNH2300T	●	□	23.0	14.5	10.3	4.2	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWNH2310T	□	□	23.1	14.5	10.3	4.2	8.0	
TAWNH2320T	□	□	23.2	14.5	10.3	4.2	8.0	
TAWNH2330T	□	□	23.3	14.5	10.3	4.2	8.0	
TAWNH2340T	□	□	23.4	14.6	10.3	4.3	8.0	
TAWNH2350T	●	□	23.5	14.5	10.2	4.3	8.0	TAWSN 2400S32 / TAWMN 2400S32 / TAWLN 2400S32
TAWNH2360T	□	□	23.6	14.5	10.2	4.3	8.0	
TAWNH2370T	□	□	23.7	14.5	10.2	4.3	8.0	
TAWNH2380T	□	□	23.8	14.5	10.2	4.3	8.0	
TAWNH2390T	□	□	23.9	14.5	10.2	4.3	8.0	
TAWNH2400T	●	□	24.0	14.5	10.1	4.4	8.0	
TAWNH2410T	□	□	24.1	14.5	10.1	4.4	8.0	
TAWNH2420T	□	□	24.2	14.5	10.1	4.4	8.0	
TAWNH2430T	□	□	24.3	14.5	10.1	4.4	8.0	
TAWNH2440T	□	□	24.4	14.5	10.1	4.4	8.0	
TAWNH2450T	●	□	24.5	16.2	11.7	4.5	9.0	TAWSN 2500S32 / TAWMN 2500S32 / TAWLN 2500S32
TAWNH2460T	□	□	24.6	16.2	11.7	4.5	9.0	
TAWNH2470T	□	□	24.7	16.2	11.7	4.5	9.0	
TAWNH2480T	□	□	24.8	16.2	11.7	4.5	9.0	
TAWNH2490T	□	□	24.9	16.2	11.7	4.5	9.0	
TAWNH2500T	●	□	25.0	16.1	11.6	4.5	9.0	
TAWNH2510T	□	□	25.1	16.2	11.6	4.6	9.0	
TAWNH2520T	□	□	25.2	16.2	11.6	4.6	9.0	
TAWNH2530T	□	□	25.3	16.2	11.6	4.6	9.0	
TAWNH2540T	□	□	25.4	16.2	11.6	4.6	9.0	
TAWNH2550T	●	□	25.5	16.1	11.5	4.6	9.0	TAWSN 2600S32 / TAWMN 2600S32 / TAWLN 2600S32
TAWNH2560T	□	□	25.6	16.2	11.5	4.7	9.0	
TAWNH2570T	□	□	25.7	16.2	11.5	4.7	9.0	
TAWNH2580T	□	□	25.8	16.2	11.5	4.7	9.0	
TAWNH2590T	□	□	25.9	16.2	11.5	4.7	9.0	
TAWNH2600T	●	□	26.0	16.1	11.4	4.7	9.0	
TAWNH2610T	□	□	26.1	16.1	11.4	4.7	9.0	
TAWNH2620T	□	□	26.2	16.2	11.4	4.8	9.0	
TAWNH2630T	□	□	26.3	16.2	11.4	4.8	9.0	
TAWNH2640T	□	□	26.4	16.2	11.4	4.8	9.0	
TAWNH2650T	●	□	26.5	16.1	11.3	4.8	9.0	TAWSN 2700S32 / TAWMN 2700S32 / TAWLN 2700S32
TAWNH2660T	□	□	26.6	16.1	11.3	4.8	9.0	
TAWNH2670T	□	□	26.7	16.2	11.3	4.9	9.0	
TAWNH2680T	□	□	26.8	16.2	11.3	4.9	9.0	
TAWNH2690T	□	□	26.9	16.2	11.3	4.9	9.0	
TAWNH2700T	●	□	27.0	16.1	11.2	4.9	9.0	
TAWNH2710T	□	□	27.1	16.1	11.2	4.9	9.0	
TAWNH2720T	□	□	27.2	16.1	11.2	4.9	9.0	
TAWNH2730T	□	□	27.3	16.2	11.2	5.0	9.0	
TAWNH2740T	□	□	27.4	16.2	11.2	5.0	9.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWNH2750T	●	□	27.5	17.3	12.3	5.0	10.0	TAWSN 2800S32 / TAWMN 2800S32 / TAWLN 2800S32
TAWNH2760T	□	□	27.6	17.3	12.3	5.0	10.0	
TAWNH2770T	□	□	27.7	17.3	12.3	5.0	10.0	
TAWNH2780T	□	□	27.8	17.4	12.3	5.1	10.0	
TAWNH2790T	□	□	27.9	17.4	12.3	5.1	10.0	
TAWNH2800T	●	□	28.0	17.3	12.2	5.1	10.0	
TAWNH2810T	□	□	28.1	17.3	12.2	5.1	10.0	
TAWNH2820T	□	□	28.2	17.3	12.2	5.1	10.0	
TAWNH2830T	□	□	28.3	17.4	12.2	5.2	10.0	
TAWNH2840T	□	□	28.4	17.4	12.2	5.2	10.0	
TAWNH2850T	●	□	28.5	17.3	12.1	5.2	10.0	TAWSN 2900S32 / TAWMN 2900S32 / TAWLN 2900S32
TAWNH2860T	□	□	28.6	17.3	12.1	5.2	10.0	
TAWNH2870T	□	□	28.7	17.3	12.1	5.2	10.0	
TAWNH2880T	□	□	28.8	17.3	12.1	5.2	10.0	
TAWNH2890T	□	□	28.9	17.4	12.1	5.3	10.0	
TAWNH2900T	●	□	29.0	17.3	12.0	5.3	10.0	
TAWNH2910T	□	□	29.1	17.3	12.0	5.3	10.0	
TAWNH2920T	□	□	29.2	17.3	12.0	5.3	10.0	
TAWNH2930T	□	□	29.3	17.3	12.0	5.3	10.0	
TAWNH2940T	□	□	29.4	17.4	12.0	5.4	10.0	

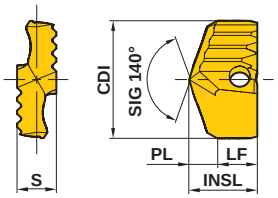
Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWNH2950T	●	□	29.5	17.3	11.9	5.4	10.0	TAWSN 3000S32 / TAWMN 3000S32 / TAWLN 3000S32
TAWNH2960T	□	□	29.6	17.3	11.9	5.4	10.0	
TAWNH2970T	□	□	29.7	17.3	11.9	5.4	10.0	
TAWNH2980T	□	□	29.8	17.3	11.9	5.4	10.0	
TAWNH2990T	□	□	29.9	17.3	11.9	5.4	10.0	
TAWNH3000T	●	□	30.0	17.3	11.8	5.5	10.0	
TAWNH3010T	□	□	30.1	17.3	11.8	5.5	10.0	
TAWNH3020T	□	□	30.2	17.3	11.8	5.5	10.0	
TAWNH3030T	□	□	30.3	17.3	11.8	5.5	10.0	
TAWNH3040T	□	□	30.4	17.3	11.8	5.5	10.0	

Applicable Drill Shape Geometry	Order Number	Coated VP15TF		Dimensions (mm) CDI	INSL	LF	PL	S
TAW H Type ➲ P229 	**TAWBH2450T**	●		24.5	15.0	11.7	3.3	9.0
	TAWBH2460T	□		24.6	15.0	11.7	3.3	9.0
	TAWBH2470T	●		24.7	15.0	11.7	3.3	9.0
	TAWBH2650T	□		26.5	14.9	11.3	3.6	9.0
	TAWBH2670T	●		26.7	14.9	11.3	3.6	9.0

DRILLING INSERTS

Applicable Drill Shape Geometry

TAW H Type
(Cast Iron)
➲ **P219**



Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH1850TG	●	18.5	12.7	8.6	4.1	7.0	TAWSN 1900S25 / TAWMN 1900S25 / TAWLN 1900S25
TAWKH1860TG	●	18.6	12.7	8.6	4.1	7.0	
TAWKH1870TG	●	18.7	12.7	8.6	4.1	7.0	
TAWKH1880TG	●	18.8	12.7	8.6	4.1	7.0	
TAWKH1890TG	●	18.9	12.7	8.6	4.1	7.0	
TAWKH1900TG	●	19.0	12.6	8.5	4.1	7.0	
TAWKH1910TG	●	19.1	12.7	8.5	4.2	7.0	
TAWKH1920TG	●	19.2	12.7	8.5	4.2	7.0	
TAWKH1930TG	●	19.3	12.7	8.5	4.2	7.0	
TAWKH1940TG	●	19.4	12.7	8.5	4.2	7.0	
TAWKH1950TG	●	19.5	12.6	8.4	4.2	7.0	TAWSN 2000S25 / TAWMN 2000S25 / TAWLN 2000S25
TAWKH1960TG	●	19.6	12.7	8.4	4.3	7.0	
TAWKH1970TG	●	19.7	12.7	8.4	4.3	7.0	
TAWKH1980TG	●	19.8	12.7	8.4	4.3	7.0	
TAWKH1990TG	●	19.9	12.7	8.4	4.3	7.0	
TAWKH2000TG	●	20.0	12.6	8.3	4.3	7.0	
TAWKH2010TG	□	20.1	12.6	8.3	4.3	7.0	
TAWKH2020TG	□	20.2	12.7	8.3	4.4	7.0	
TAWKH2030TG	□	20.3	12.7	8.3	4.4	7.0	
TAWKH2040TG	□	20.4	12.7	8.3	4.4	7.0	
TAWKH2050TG	●	20.5	12.6	8.2	4.4	7.0	TAWSN 2100S25 / TAWMN 2100S25 / TAWLN 2100S25
TAWKH2060TG	□	20.6	12.6	8.2	4.4	7.0	
TAWKH2070TG	□	20.7	12.7	8.2	4.5	7.0	
TAWKH2080TG	□	20.8	12.7	8.2	4.5	7.0	
TAWKH2090TG	□	20.9	12.7	8.2	4.5	7.0	
TAWKH2100TG	●	21.0	12.6	8.1	4.5	7.0	
TAWKH2110TG	□	21.1	12.6	8.1	4.5	7.0	
TAWKH2120TG	□	21.2	12.6	8.1	4.5	7.0	
TAWKH2130TG	□	21.3	12.7	8.1	4.6	7.0	
TAWKH2140TG	□	21.4	12.7	8.1	4.6	7.0	
TAWKH2150TG	●	21.5	14.5	9.8	4.7	8.0	TAWSN 2200S25 / TAWMN 2200S25 / TAWLN 2200S25
TAWKH2160TG	□	21.6	14.5	9.8	4.7	8.0	
TAWKH2170TG	□	21.7	14.5	9.8	4.7	8.0	
TAWKH2180TG	□	21.8	14.6	9.8	4.8	8.0	
TAWKH2190TG	□	21.9	14.6	9.8	4.8	8.0	
TAWKH2200TG	●	22.0	14.5	9.7	4.8	8.0	
TAWKH2210TG	□	22.1	14.5	9.7	4.8	8.0	
TAWKH2220TG	□	22.2	14.5	9.7	4.8	8.0	
TAWKH2230TG	□	22.3	14.5	9.7	4.8	8.0	
TAWKH2240TG	□	22.4	14.6	9.7	4.9	8.0	
TAWKH2250TG	●	22.5	14.5	9.6	4.9	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWKH2260TG	□	22.6	14.5	9.6	4.9	8.0	
TAWKH2270TG	□	22.7	14.5	9.6	4.9	8.0	
TAWKH2280TG	□	22.8	14.5	9.6	4.9	8.0	
TAWKH2290TG	□	22.9	14.6	9.6	5.0	8.0	

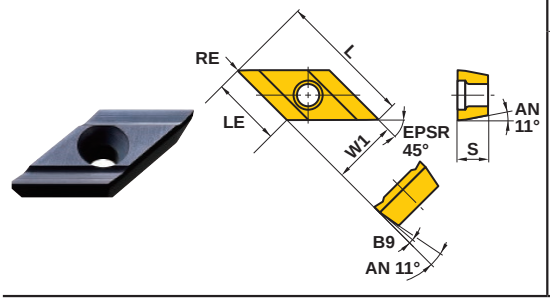
Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2300TG	●	23.0	14.5	9.5	5.0	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWKH2310TG	□	23.1	14.5	9.5	5.0	8.0	
TAWKH2320TG	□	23.2	14.5	9.5	5.0	8.0	
TAWKH2330TG	□	23.3	14.5	9.5	5.0	8.0	
TAWKH2340TG	□	23.4	14.5	9.5	5.0	8.0	
TAWKH2350TG	●	23.5	14.5	9.4	5.1	8.0	TAWSN 2400S32 / TAWMN 2400S32 / TAWLN 2400S32
TAWKH2360TG	□	23.6	14.5	9.4	5.1	8.0	
TAWKH2370TG	□	23.7	14.5	9.4	5.1	8.0	
TAWKH2380TG	□	23.8	14.5	9.4	5.1	8.0	
TAWKH2390TG	□	23.9	14.5	9.4	5.1	8.0	
TAWKH2400TG	●	24.0	14.5	9.3	5.2	8.0	
TAWKH2410TG	□	24.1	14.5	9.3	5.2	8.0	
TAWKH2420TG	□	24.2	14.5	9.3	5.2	8.0	
TAWKH2430TG	□	24.3	14.5	9.3	5.2	8.0	
TAWKH2440TG	□	24.4	14.5	9.3	5.2	8.0	
TAWKH2450TG	●	24.5	16.0	10.7	5.3	9.0	TAWSN 2500S32 / TAWMN 2500S32 / TAWLN 2500S32
TAWKH2460TG	□	24.6	16.1	10.7	5.4	9.0	
TAWKH2470TG	□	24.7	16.1	10.7	5.4	9.0	
TAWKH2480TG	□	24.8	16.1	10.7	5.4	9.0	
TAWKH2490TG	□	24.9	16.1	10.7	5.4	9.0	
TAWKH2500TG	●	25.0	16.1	10.7	5.4	9.0	
TAWKH2510TG	□	25.1	16.2	10.7	5.5	9.0	
TAWKH2520TG	□	25.2	16.2	10.7	5.5	9.0	
TAWKH2530TG	□	25.3	16.2	10.7	5.5	9.0	
TAWKH2540TG	□	25.4	16.2	10.7	5.5	9.0	
TAWKH2550TG	●	25.5	16.1	10.6	5.5	9.0	TAWSN 2600S32 / TAWMN 2600S32 / TAWLN 2600S32
TAWKH2560TG	□	25.6	16.1	10.6	5.5	9.0	
TAWKH2570TG	□	25.7	16.2	10.6	5.6	9.0	
TAWKH2580TG	□	25.8	16.2	10.6	5.6	9.0	
TAWKH2590TG	□	25.9	16.2	10.6	5.6	9.0	
TAWKH2600TG	●	26.0	16.1	10.5	5.6	9.0	
TAWKH2610TG	□	26.1	16.1	10.5	5.6	9.0	
TAWKH2620TG	□	26.2	16.2	10.5	5.7	9.0	
TAWKH2630TG	□	26.3	16.2	10.5	5.7	9.0	
TAWKH2640TG	□	26.4	16.2	10.5	5.7	9.0	
TAWKH2650TG	●	26.5	16.1	10.4	5.7	9.0	TAWSN 2700S32 / TAWMN 2700S32 / TAWLN 2700S32
TAWKH2660TG	□	26.6	16.1	10.4	5.7	9.0	
TAWKH2670TG	□	26.7	16.1	10.4	5.7	9.0	
TAWKH2680TG	□	26.8	16.2	10.4	5.8	9.0	
TAWKH2690TG	□	26.9	16.2	10.4	5.8	9.0	
TAWKH2700TG	●	27.0	16.1	10.3	5.8	9.0	
TAWKH2710TG	□	27.1	16.1	10.3	5.8	9.0	
TAWKH2720TG	□	27.2	16.1	10.3	5.8	9.0	
TAWKH2730TG	□	27.3	16.2	10.3	5.9	9.0	
TAWKH2740TG	□	27.4	16.2	10.3	5.9	9.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2750TG	●	27.5	17.2	11.2	6.0	10.0	TAWSN 2800S32 / TAWMN 2800S32 / TAWLN 2800S32
TAWKH2760TG	□	27.6	17.2	11.2	6.0	10.0	
TAWKH2770TG	□	27.7	17.2	11.2	6.0	10.0	
TAWKH2780TG	□	27.8	17.3	11.2	6.1	10.0	
TAWKH2790TG	□	27.9	17.3	11.2	6.1	10.0	
TAWKH2800TG	●	28.0	17.3	11.2	6.1	10.0	
TAWKH2810TG	□	28.1	17.3	11.2	6.1	10.0	
TAWKH2820TG	□	28.2	17.3	11.2	6.1	10.0	
TAWKH2830TG	□	28.3	17.3	11.2	6.1	10.0	
TAWKH2840TG	□	28.4	17.4	11.2	6.2	10.0	
TAWKH2850TG	●	28.5	17.3	11.1	6.2	10.0	TAWSN 2900S32 / TAWMN 2900S32 / TAWLN 2900S32
TAWKH2860TG	□	28.6	17.3	11.1	6.2	10.0	
TAWKH2870TG	□	28.7	17.3	11.1	6.2	10.0	
TAWKH2880TG	□	28.8	17.3	11.1	6.2	10.0	
TAWKH2890TG	□	28.9	17.4	11.1	6.3	10.0	
TAWKH2900TG	●	29.0	17.3	11.0	6.3	10.0	
TAWKH2910TG	□	29.1	17.3	11.0	6.3	10.0	
TAWKH2920TG	□	29.2	17.3	11.0	6.3	10.0	
TAWKH2930TG	□	29.3	17.3	11.0	6.3	10.0	
TAWKH2940TG	□	29.4	17.3	11.0	6.3	10.0	

Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2950TG	●	29.5	17.3	10.9	6.4	10.0	TAWSN 3000S32 / TAWMN 3000S32 / TAWLN 3000S32
TAWKH2960TG	□	29.6	17.3	10.9	6.4	10.0	
TAWKH2970TG	□	29.7	17.3	10.9	6.4	10.0	
TAWKH2980TG	□	29.8	17.3	10.9	6.4	10.0	
TAWKH2990TG	□	29.9	17.3	10.9	6.4	10.0	
TAWKH3000TG	●	30.0	17.3	10.8	6.5	10.0	
TAWKH3010TG	□	30.1	17.3	10.8	6.5	10.0	
TAWKH3020TG	□	30.2	17.3	10.8	6.5	10.0	
TAWKH3030TG	□	30.3	17.3	10.8	6.5	10.0	
TAWKH3040TG	□	30.4	17.3	10.8	6.5	10.0	

Insert for TAW Drill Chamfering Module

Shape Geometry	Order Number	Coated VP15TF		Dimensions (mm) L	LE	WI	S	RE	B9
	TAWC12T301-45GM	●		17.4	9.05	8.5	3.97	0.1	5°

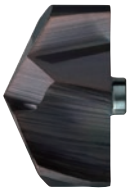
● : Inventory maintained in Japan. (10 insert in one case)

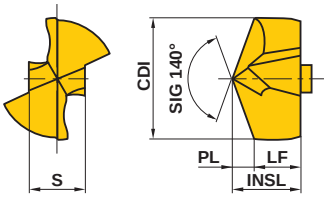
DRILLING INSERTS

Applicable Drill Shape Geometry

STAW

➲ **P210**





Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
STAWN1000TH	●	□	10.0	5.6	3.8	1.8	4.6	STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16
STAWN1010TH	●	□	10.1	5.6	3.8	1.8	4.6	
STAWN1020TH	●	□	10.2	5.7	3.8	1.9	4.6	
STAWN1030TH	●	□	10.3	5.7	3.8	1.9	4.6	
STAWN1040TH	●	□	10.4	5.7	3.8	1.9	4.6	
STAWN1050TH	●	□	10.5	5.9	4.0	1.9	4.8	STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16
STAWN1060TH	●	□	10.6	5.9	4.0	1.9	4.8	
STAWN1070TH	●	□	10.7	5.9	4.0	1.9	4.8	
STAWN1080TH	●	□	10.8	6.0	4.0	2.0	4.8	
STAWN1090TH	●	□	10.9	6.0	4.0	2.0	4.8	
STAWN1100TH	●	□	11.0	6.2	4.2	2.0	5.1	STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16
STAWN1110TH	●	□	11.1	6.2	4.2	2.0	5.1	
STAWN1120TH	●	□	11.2	6.2	4.2	2.0	5.1	
STAWN1130TH	●	□	11.3	6.3	4.2	2.1	5.1	
STAWN1140TH	●	□	11.4	6.3	4.2	2.1	5.1	
STAWN1150TH	●	□	11.5	6.5	4.4	2.1	5.3	STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16
STAWN1160TH	●	□	11.6	6.5	4.4	2.1	5.3	
STAWN1170TH	●	□	11.7	6.5	4.4	2.1	5.3	
STAWN1180TH	●	□	11.8	6.5	4.4	2.1	5.3	
STAWN1190TH	●	□	11.9	6.6	4.4	2.2	5.3	
STAWN1200TH	●	□	12.0	6.8	4.6	2.2	5.5	STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16
STAWN1210TH	●	□	12.1	6.8	4.6	2.2	5.5	
STAWN1220TH	●	□	12.2	6.8	4.6	2.2	5.5	
STAWN1230TH	●	□	12.3	6.8	4.6	2.2	5.5	
STAWN1240TH	●	□	12.4	6.9	4.6	2.3	5.5	
STAWN1250TH	●	□	12.5	7.1	4.8	2.3	5.8	STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16
STAWN1260TH	●	□	12.6	7.1	4.8	2.3	5.8	
STAWN1270TH	●	□	12.7	7.1	4.8	2.3	5.8	
STAWN1280TH	●	□	12.8	7.1	4.8	2.3	5.8	
STAWN1290TH	●	□	12.9	7.1	4.8	2.3	5.8	
STAWN1300TH	●	□	13.0	7.3	4.9	2.4	6.0	STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16
STAWN1310TH	●	□	13.1	7.3	4.9	2.4	6.0	
STAWN1320TH	●	□	13.2	7.3	4.9	2.4	6.0	
STAWN1330TH	●	□	13.3	7.3	4.9	2.4	6.0	
STAWN1340TH	●	□	13.4	7.3	4.9	2.4	6.0	
STAWN1350TH	●	□	13.5	7.6	5.1	2.5	6.2	STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16
STAWN1360TH	●	□	13.6	7.6	5.1	2.5	6.2	
STAWN1370TH	●	□	13.7	7.6	5.1	2.5	6.2	
STAWN1380TH	●	□	13.8	7.6	5.1	2.5	6.2	
STAWN1390TH	●	□	13.9	7.6	5.1	2.5	6.2	
STAWN1400TH	●		14.0	7.8	5.3	2.5	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
STAWN1410TH	●		14.1	7.9	5.3	2.6	6.4	
STAWN1420TH	●		14.2	7.9	5.3	2.6	6.4	
STAWN1430TH	●		14.3	7.9	5.3	2.6	6.4	
STAWN1440TH	●		14.4	7.9	5.3	2.6	6.4	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

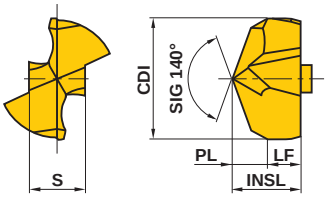
Order Number	Coated		Dimensions (mm)					Applicable Holder
	VP15TF	VP10H	CDI	INSL	LF	PL	S	
STAWN1450TH	●		14.5	8.1	5.5	2.6	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
STAWN1460TH	●		14.6	8.2	5.5	2.7	6.7	
STAWN1470TH	●		14.7	8.2	5.5	2.7	6.7	
STAWN1480TH	●		14.8	8.2	5.5	2.7	6.7	
STAWN1490TH	●		14.9	8.2	5.5	2.7	6.7	
STAWN1500TH	●		15.0	8.4	5.7	2.7	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
STAWN1510TH	●		15.1	8.4	5.7	2.7	6.9	
STAWN1520TH	●		15.2	8.5	5.7	2.8	6.9	
STAWN1530TH	●		15.3	8.5	5.7	2.8	6.9	
STAWN1540TH	●		15.4	8.5	5.7	2.8	6.9	
STAWN1550T	●		15.5	8.7	5.9	2.8	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
STAWN1560T	●		15.6	8.7	5.9	2.8	7.1	
STAWN1570T	●		15.7	8.8	5.9	2.9	7.1	
STAWN1580T	●		15.8	8.8	5.9	2.9	7.1	
STAWN1590T	●		15.9	8.8	5.9	2.9	7.1	
STAWN1600T	●		16.0	8.8	5.9	2.9	7.1	
STAWN1610T	●		16.1	8.8	5.9	2.9	7.1	
STAWN1620T	●		16.2	8.8	5.9	2.9	7.1	
STAWN1630T	●		16.3	8.9	5.9	3.0	7.1	
STAWN1640T	●		16.4	8.9	5.9	3.0	7.1	
STAWN1650T	●		16.5	9.3	6.3	3.0	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
STAWN1660T	●		16.6	9.3	6.3	3.0	7.6	
STAWN1670T	●		16.7	9.3	6.3	3.0	7.6	
STAWN1680T	●		16.8	9.4	6.3	3.1	7.6	
STAWN1690T	●		16.9	9.4	6.3	3.1	7.6	
STAWN1700T	●		17.0	9.4	6.3	3.1	7.6	
STAWN1710T	●		17.1	9.4	6.3	3.1	7.6	
STAWN1720T	●		17.2	9.4	6.3	3.1	7.6	
STAWN1730T	●		17.3	9.4	6.3	3.1	7.6	
STAWN1740T	●		17.4	9.5	6.3	3.2	7.6	
STAWN1750T	●		17.5	9.9	6.7	3.2	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
STAWN1760T	●		17.6	9.9	6.7	3.2	8.1	
STAWN1770T	●		17.7	9.9	6.7	3.2	8.1	
STAWN1780T	●		17.8	9.9	6.7	3.2	8.1	
STAWN1790T	●		17.9	10.0	6.7	3.3	8.1	
STAWN1800T	●		18.0	10.0	6.7	3.3	8.1	
STAWN1810T	●		18.1	10.0	6.7	3.3	8.1	
STAWN1820T	●		18.2	10.0	6.7	3.3	8.1	
STAWN1830T	●		18.3	10.0	6.7	3.3	8.1	
STAWN1840T	●		18.4	10.0	6.7	3.3	8.1	

DRILLING INSERTS

Applicable Drill Shape Geometry

STAW

➲ **P210**



Order Number	Coated DP5010		Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
STAWK1000TG	●		10.0	5.6	3.3	2.3	4.6	STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16
STAWK1010TG	●		10.1	5.6	3.3	2.3	4.6	
STAWK1020TG	●		10.2	5.6	3.3	2.3	4.6	
STAWK1030TG	●		10.3	5.7	3.3	2.4	4.6	
STAWK1040TG	●		10.4	5.7	3.3	2.4	4.6	
STAWK1050TG	●		10.5	5.9	3.5	2.4	4.8	STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16
STAWK1060TG	●		10.6	5.9	3.5	2.4	4.8	
STAWK1070TG	●		10.7	5.9	3.5	2.4	4.8	
STAWK1080TG	●		10.8	5.9	3.5	2.4	4.8	
STAWK1090TG	●		10.9	6.0	3.5	2.5	4.8	
STAWK1100TG	●		11.0	6.2	3.7	2.5	5.1	STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16
STAWK1110TG	●		11.1	6.2	3.7	2.5	5.1	
STAWK1120TG	●		11.2	6.2	3.7	2.5	5.1	
STAWK1130TG	●		11.3	6.2	3.7	2.5	5.1	
STAWK1140TG	●		11.4	6.3	3.7	2.6	5.1	
STAWK1150TG	●		11.5	6.5	3.9	2.6	5.3	STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16
STAWK1160TG	●		11.6	6.5	3.9	2.6	5.3	
STAWK1170TG	●		11.7	6.5	3.9	2.6	5.3	
STAWK1180TG	●		11.8	6.5	3.9	2.6	5.3	
STAWK1190TG	●		11.9	6.5	3.9	2.6	5.3	
STAWK1200TG	●		12.0	6.8	4.1	2.7	5.5	STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16
STAWK1210TG	●		12.1	6.8	4.1	2.7	5.5	
STAWK1220TG	●		12.2	6.8	4.1	2.7	5.5	
STAWK1230TG	●		12.3	6.8	4.1	2.7	5.5	
STAWK1240TG	●		12.4	6.8	4.1	2.7	5.5	
STAWK1250TG	●		12.5	7.0	4.2	2.8	5.8	STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16
STAWK1260TG	●		12.6	7.0	4.2	2.8	5.8	
STAWK1270TG	●		12.7	7.0	4.2	2.8	5.8	
STAWK1280TG	●		12.8	7.0	4.2	2.8	5.8	
STAWK1290TG	●		12.9	7.0	4.2	2.8	5.8	
STAWK1300TG	●		13.0	7.2	4.4	2.8	6.0	STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16
STAWK1310TG	●		13.1	7.3	4.4	2.9	6.0	
STAWK1320TG	●		13.2	7.3	4.4	2.9	6.0	
STAWK1330TG	●		13.3	7.3	4.4	2.9	6.0	
STAWK1340TG	●		13.4	7.3	4.4	2.9	6.0	
STAWK1350TG	●		13.5	7.5	4.6	2.9	6.2	STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16
STAWK1360TG	●		13.6	7.6	4.6	3.0	6.2	
STAWK1370TG	●		13.7	7.6	4.6	3.0	6.2	
STAWK1380TG	●		13.8	7.6	4.6	3.0	6.2	
STAWK1390TG	●		13.9	7.6	4.6	3.0	6.2	

● : Inventory maintained in Japan.
(1 insert in one case)

Order Number	Coated		Dimensions (mm)					Applicable Holder
	DP5010		CDI	INSL	LF	PL	S	
STAWK1400TG	●		14.0	7.8	4.8	3.0	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
STAWK1410TG	●		14.1	7.8	4.8	3.0	6.4	
STAWK1420TG	●		14.2	7.9	4.8	3.1	6.4	
STAWK1430TG	●		14.3	7.9	4.8	3.1	6.4	
STAWK1440TG	●		14.4	7.9	4.8	3.1	6.4	
STAWK1450TG	●		14.5	8.1	5.0	3.1	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
STAWK1460TG	●		14.6	8.1	5.0	3.1	6.7	
STAWK1470TG	●		14.7	8.2	5.0	3.2	6.7	
STAWK1480TG	●		14.8	8.2	5.0	3.2	6.7	
STAWK1490TG	●		14.9	8.2	5.0	3.2	6.7	
STAWK1500TG	●		15.0	8.4	5.2	3.2	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
STAWK1510TG	●		15.1	8.4	5.2	3.2	6.9	
STAWK1520TG	●		15.2	8.4	5.2	3.2	6.9	
STAWK1530TG	●		15.3	8.5	5.2	3.3	6.9	
STAWK1540TG	●		15.4	8.5	5.2	3.3	6.9	
STAWK1550TG	●		15.5	8.7	5.3	3.4	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
STAWK1560TG	●		15.6	8.7	5.3	3.4	7.1	
STAWK1570TG	●		15.7	8.7	5.3	3.4	7.1	
STAWK1580TG	●		15.8	8.8	5.3	3.5	7.1	
STAWK1590TG	●		15.9	8.8	5.3	3.5	7.1	
STAWK1600TG	●		16.0	8.8	5.3	3.5	7.1	
STAWK1610TG	●		16.1	8.8	5.3	3.5	7.1	
STAWK1620TG	●		16.2	8.8	5.3	3.5	7.1	
STAWK1630TG	●		16.3	8.8	5.3	3.5	7.1	
STAWK1640TG	●		16.4	8.9	5.3	3.6	7.1	
STAWK1650TG	●		16.5	9.3	5.7	3.6	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
STAWK1660TG	●		16.6	9.3	5.7	3.6	7.6	
STAWK1670TG	●		16.7	9.3	5.7	3.6	7.6	
STAWK1680TG	●		16.8	9.3	5.7	3.6	7.6	
STAWK1690TG	●		16.9	9.4	5.7	3.7	7.6	
STAWK1700TG	●		17.0	9.4	5.7	3.7	7.6	
STAWK1710TG	●		17.1	9.4	5.7	3.7	7.6	
STAWK1720TG	●		17.2	9.4	5.7	3.7	7.6	
STAWK1730TG	●		17.3	9.4	5.7	3.7	7.6	
STAWK1740TG	●		17.4	9.4	5.7	3.7	7.6	
STAWK1750TG	●		17.5	9.8	6.0	3.8	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
STAWK1760TG	●		17.6	9.8	6.0	3.8	8.1	
STAWK1770TG	●		17.7	9.8	6.0	3.8	8.1	
STAWK1780TG	●		17.8	9.8	6.0	3.8	8.1	
STAWK1790TG	●		17.9	9.8	6.0	3.8	8.1	
STAWK1800TG	●		18.0	9.9	6.0	3.9	8.1	
STAWK1810TG	●		18.1	9.9	6.0	3.9	8.1	
STAWK1820TG	●		18.2	9.9	6.0	3.9	8.1	
STAWK1830TG	●		18.3	9.9	6.0	3.9	8.1	
STAWK1840TG	●		18.4	9.9	6.0	3.9	8.1	

HOW TO READ THE STANDARD OF INDEXABLE MILLING

●How this section page is organised

①Organised according to the face milling cutting mode.
(Refer to the index on the next page.)

SCOPE OF AVAILABLE WORK MATERIAL
provides a graph depicting the scope of the available work material for machining.

PRODUCT FEATURES

CORNER ANGLE ICON

TYPE/ NAME OF PRODUCT

APPLICATION ICON
represents available machining applications, such as finishing and roughing.

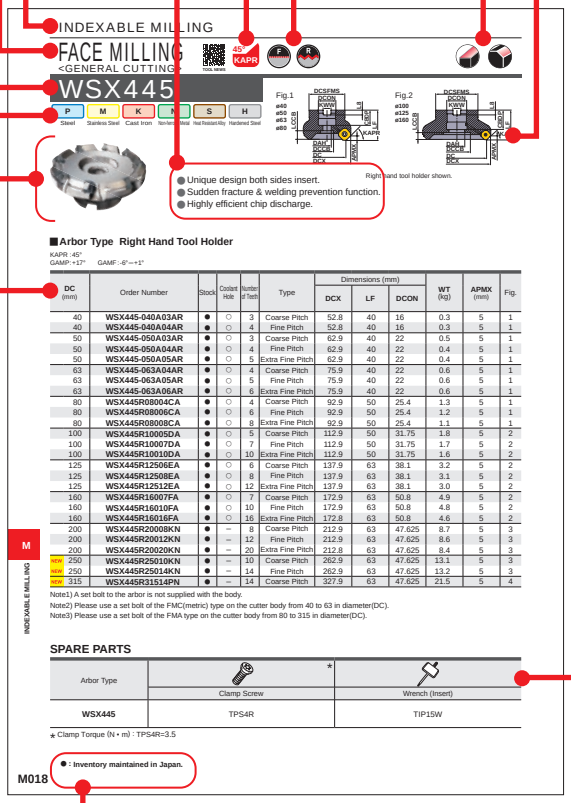
APPLICATION

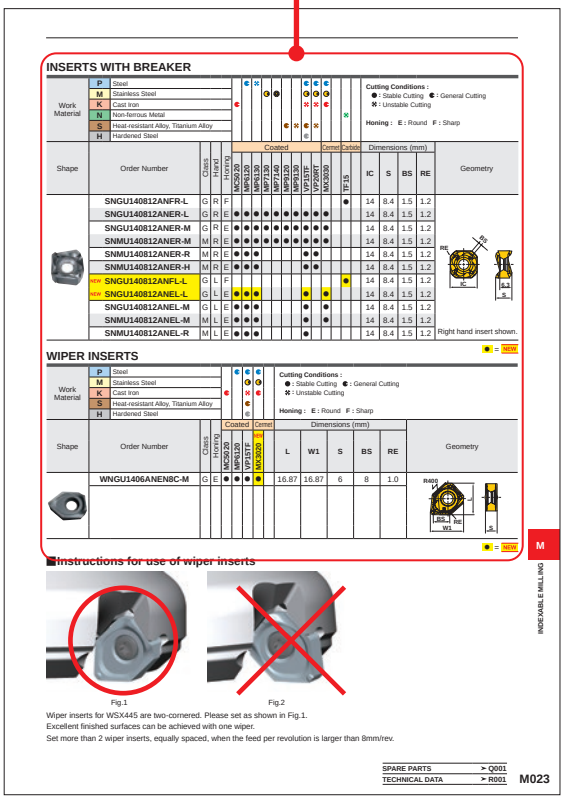
CUTTING MODE ICON
represents available cutting modes, such as face milling and shoulder milling.

STANDARDS FOR APPLICABLE INSERTS
indicates stock status, dimensions, etc. for applicable inserts.

PRODUCT SECTION

GEOMETRY





LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

SPARE PARTS FOR MIILING TOOLS
indicates the names of the applicable spare parts.

PRODUCT STANDARDS
indicates tool types, order numbers, stock status (per right/left hand), dimensions, etc.

PHOTO OF PRODUCT

●To Order : For title product, please specify ①order number and hand of tool (right/left).
For insert, please specify ①insert number and ②grade.

MILLING TOOLS

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CLASSIFICATION ··· M006
CLASSIFICATION OF SIDE CUTTER ··· M009
CLASSIFICATION OF BORE BORING TOOLS ··· M009
CLASSIFICATION OF END MILLS ··· M010
CLASSIFICATION OF SCREW-IN TOOLS ··· M014
HOW TO SELECT AN END MILL ··· M016

STANDARD OF MILLING

FACE MILLING
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ASX445 ··· M030
AHX440S ··· M038
AHX475S ··· M043
AHX640S ··· M046
AHX640W ··· M054
AOX445 ··· M060
SE515 ··· M062
SG20 ··· M064

FACE MILLING (HIGH FEED)
FMAX ··· M066
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FF3000 ··· M074

SHOULDER MILLING
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ASX400 ··· M080
BAP300 ··· M086

SIDE CUTTER
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VAS500 ··· M092
VOS400 ··· M094
ASX400 ··· M095

MULTI FUNCTIONAL MILLING
APX3000 ··· M096
APX4000 ··· M102
NEW VPX200 ··· M110
NEW VPX300 ··· M122
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AXD7000 ··· M142
BXD4000 ··· M150
AQX ··· M154
AJX ··· M162
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ARX ··· M192
BRP ··· M196

DEEP SHOULDER MILLING
NEW APX3000 LONG CUTTING EDGE TYPE ··· M202
APX4000 LONG CUTTING EDGE TYPE ··· M206
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CHAMFER MILLING
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SPOT MILLING
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KSMG ··· M252

VERTICAL FEED MILLING
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QUICK CHANGE TYPE
FP490 ··· M262
FP590 ··· M264
FE404 ··· M266
SETTING FIXTURE ··· M268

ARBOR STANDARDS
FOR SCREW-IN TOOLS ··· M269
Qing SYSTEM ··· M271

*Arranged by Alphabetical order

M038 AHX440S
M043 AHX475S
M046 AHX640S
M054 AHX640W
M162 AJX
M060 AOX445
M096 APX3000
M202 APX3000 LONG CUTTING EDGE TYPE
M102 APX4000
M206 APX4000 LONG CUTTING EDGE TYPE
M154 AQX
M186 ARP
M192 ARX
M080 ASX400
M095 ASX400
M030 ASX445
M134 AXD4000
M142 AXD7000
M086 BAP300
M210 BAP300 LONG CUTTING EDGE TYPE
M260 BMR
M196 BRP
M150 BXD4000
M250 CBJP,CBMP
M246 CESP,CFSP,CGSP
M212 DCCC
M266 FE404
M074 FF3000
M066 FMAX
M262 FP490
M264 FP590
M252 KSMG
M072 NF10000
M180 OCTACUT
M254 PMC
M256 PMF
M258 PMR
M271 Qing
M269 SC-M
M062 SE515
M268 SEF
M064 SG20
M215 SPX
M228 SRF/SRB
M232 SUF
M236 SRM2
M244 SRM2φ40,φ50
M248 TSMP
M070 V10000
M090 VAS400
M092 VAS500
M220 VFX5
M224 VFX6
M094 VOS400
M076 VOX400
M110 VPX200
M122 VPX300
M172 WJX
M018 WSX445
M269 ARBORS FOR SCREW-IN TOOLS
M268 SETTING FIXTURE

SYMBOL DESCRIPTIONS

KAPR (Cutting Edge Angle) List

15° KAPR	15°
30° KAPR	30°
35° KAPR	35°
42° KAPR	42°
45° KAPR	45°
50° KAPR	50°
60° KAPR	60°
75° KAPR	75°
86° KAPR	86°
90° KAPR	90°
94° KAPR	94°
R KAPR	R

● : Inventory maintained.
▲ : Inventory maintained.
To be replaced by new products.
□ : Non stock, produced to order only.

Application

Face Milling

Chamfer Milling

Shoulder Milling with R

Face Milling Near the Wall

Shoulder Milling

Wall Milling

Slot Milling

Step Milling

Pocket Milling

Slot Milling with R

Copy Milling

T-Slot Milling

Spot Milling

Helical Drilling

Accuracy

F Finish Cutting

PF Medium Cutting

R Rough Cutting

Work Material Range

1st Recommenedation

P M K N S H

2nd Recommenedation

P M K N S H

LIST OF CUTTING EDGE DIAMETER TOLERANCES

Cutter Type	Cutting Edge Diameter Tolerance (mm)	Cutter Type	Cutting Edge Diameter Tolerance (mm)
AJX	−0.1 −0.4	BXD4000 Arbor Type	−0.1 −0.4
APX3000 Arbor Type	−0.1 −0.4	BXD4000 Shank Type	−0.1 −0.2
APX3000 Shank Type	−0.1 −0.2	CBJP	0 −0.3
APX3000 Long Cutting Edge Type	−0.1 −0.3	CBMP	0 −0.3
APX4000 Arbor Type	−0.1 −0.4	OCTACUT	0 −0.3
APX4000 Shank Type	−0.1 −0.2	PMC	±0.05
APX4000 Long Cutting Edge Type	−0.1 −0.3	PMF	0 −0.3
AQX	−0.1 −0.3	PMR	0 −0.3
ARP Arbor Type	−0.1 −0.3	SPX	−0.1 −0.3
ARP Shank Type	−0.1 −0.2	SRF	0 −0.027
ARX	−0.05 −0.15	SRM	−0.05 −0.15
ASX400	0 −0.3	SUF	0 −0.02
AXD4000 Arbor Type	−0.1 −0.4	TSMP	−0.1 −0.3
AXD4000 Shank Type	−0.1 −0.2	VFX5, VFX6 Shell Type	−0.1 −0.3
AXD7000 Arbor Type	−0.1 −0.4	VOX400	−0.1 −0.4
AXD7000 Shank Type	−0.1 −0.2	VPX Arbor Type	−0.1 −0.3
BAP300	0 −0.3	VPX Shank Type	−0.1 −0.2
BRP	−0.1 −0.3	WJX	−0.1 −0.3

Note 1) Cutting edge diameter tolerance when the gauge insert is set.
Note 2) When setting the insert available, the insert tolerance is added to the above tolerance.
(Tolerance when setting the insert for SRF.)

MAXIMUM ALLOWABLE REVOLUTION FOR CUTTER

Diameter (mm)	WSX445		ASX445		AOX445		ASX400		SE515	
	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)
40	19000	3.5	–	–	–	–	–	–	–	–
50	17000	3.5	18000	3.5	13000	8	18000	3.5	–	–
63	15000	3.5	16000	3.5	12000	8	16000	3.5	–	–
80	14000	3.5	14000	3.5	11000	8	14000	3.5	–	–
100	12000	3.5	13000	3.5	9300	8	13000	3.5	9300	8
125	11000	3.5	12000	3.5	8300	8	12000	3.5	8100	8
160	9500	3.5	10000	3.5	7200	8	10000	3.5	7000	8
200	8500	3.5	9000	3.5	6400	8	9000	3.5	–	–
250	7500	–	8000	3.5	–	–	8000	3.5	–	–
315	6500	–	6500	3.5	–	–	–	–	–	–

Diameter (mm)	FMAX		V10000		NF10000		SG20		AHX640W	
	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)
40	30000	–	–	–	–	–	–	–	–	–
50	30000	3.5	–	–	–	–	–	–	–	–
63	27000	3.5	25000	3.5	–	–	–	–	–	–
80	24500	3.5	22300	3.5	16000	8.5	8200	8.5	8900	6
100	22000	3.5	20000	3.5	14000	8.5	7000	8.5	7800	6
125	19600	3.5	17800	3.5	12000	8.5	6100	8.5	6600	6
160	–	–	–	–	–	–	5300	8.5	5300	6
200	–	–	–	–	–	–	–	–	4100	6
250	–	–	–	–	–	–	–	–	2900	6
315	–	–	–	–	–	–	–	–	1700	6

Diameter (mm)	AXD4000		AXD7000		BXD4000		VPX200		VPX300	
	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)	Max. Allowable Revolution (min^{-1})	Clamp Torque (N • m)
16	–	–	–	–	–	–	37900	1.0	–	–
18	–	–	–	–	–	–	35300	1.0	–	–
20	15000	1.5	–	–	15000	4	33200	1.0	–	–
22	–	–	–	–	–	–	31400	1.0	–	–
25	49000	1.5	–	–	38000	4	29000	1.0	24100	3.0
28	48500	1.5	–	–	–	–	27200	1.0	22500	3.0
30	–	–	–	–	–	–	26000	1.0	21500	3.0
32	48000	1.5	41000	3.5	33000	4	25100	1.0	20600	3.0
35	45000	1.5	–	–	31000	4	23800	1.0	19500	3.0
40	41000	1.5	36000	3.5	29000	4	22000	1.0	17900	3.0
50	35000	1.5	30000	3.5	24000	4	19200	1.0	15500	3.0
63	30000	1.5	25000	3.5	21000	4	16700	1.0	13400	3.0
80	27000	1.5	23000	3.5	19000	4	–	–	11500	3.0
100	23000	1.5	19000	3.5	16000	4	–	–	–	–
125	20000	1.5	16000	3.5	14000	4	–	–	–	–
160	–	–	–	–	–	–	–	–	–	–

Note 1) All values shown on this chart are based on the insert being properly seated in pocket and torqued to the recommended values.

CLASSIFICATION

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
For General Cutting **WSX445** 45° KAPR	5	●Unique design both sides insert. ●Sudden fracture & welding prevention function. ●Highly efficient chip discharge. TOOL NEWS	Ø40 — Ø315	P M K N S H	M018
For General Cutting **ASX445** 45° KAPR	6	●Precision inexpensive moulded type 20° positive insert. ●Screw-on type. ●A wide range of chip breakers. ●High rigidity due to carbide shim. TOOL NEWS	Ø50 — Ø315	P M K N S H	M030
For General Cutting **AHX440S** 50° KAPR	3	●Heptagonal double sided insert. ●Economical 14 cutting edge inserts. ●Multi insert design for high feed machining. TOOL NEWS	Ø40 — Ø160	P M K H	M036 M038
For High Feed Cutting **AHX475S** 15° KAPR	1.6	●Heptagonal double sided insert. ●Economical 14 cutting edge inserts. ●Multi insert design for high feed machining. ●With through coolant holes. TOOL NEWS	Ø50 — Ø160	P K H	M036 M043
For General Cutting **AHX640S** 50° KAPR	6	●Heptagonal double sided insert. ●Economical 14 cutting edge inserts. ●Multi insert design for high feed machining. TOOL NEWS	Ø63 — Ø200	P M K S H	M036 M046
For High Feed Cutting for Cast Iron **AHX640W** 50° KAPR	6	●Heptagonal double sided insert. ●Economical 14 cutting edge inserts. ●Multi insert design for high feed machining. TOOL NEWS	Ø80 — Ø315	K	M054
For High Efficiency Cutting for Cast Iron **AOX445** 45° KAPR	8	●Solid CBN octagonal double sided insert. ●Economical 16 cutting edge inserts. (When the depth of cut is 3mm) ●For high efficiency roughing through to finishing. ●Easy operation and cleansing. TOOL NEWS	Ø63 — Ø160	K	M060
For Heavy Cutting **SE515** 75° KAPR	11.5	●20°positive insert. ●High rake angle. ●High rigidity due to carbide shim.	Ø100 — Ø160	P M K	M062
For Difficult-to-cut Materials **SG20** R KAPR	8	●30°positive insert. ●High rake angle. ●Round shape insert with a strong cutting edge. ●Suitable for difficult-to-cut materials.	Ø80 — Ø160	P M K H	M064
For High-efficiency Finishing of Aluminium Alloys **FMAX** 90° KAPR	3	●Feed Maximum (FMAX) milling cutter for ultra efficient and accurate finishing. ●With through coolant holes. TOOL NEWS	Ø40 — Ø160	N	M066

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
High Feed Finishing for Aluminium Alloy **V10000** 90° KAPR	1.5	●Insert with PCD. ●Light weight, strong aluminium alloy cutter body. ●Anti-Fly insert mechanism enables high speed milling. ●Adjustable cutting edge run-out function. TOOL NEWS	Ø63 — Ø125	N	M070
High Speed Finishing for Aluminium Alloy and Cast Iron **NF10000** 90° KAPR	PCD 4.0 CBN 1.0	●Suitable for light alloy and cast iron finishing. ●Adjustable cutting edge run-out function. TOOL NEWS	Ø80 — Ø125	K N	M072
High Feed Finishing **FF3000** 90° KAPR	0.3	●11°positive insert. ●1000—3000mm/min high feed machining. ●For finishing of steel machining. ●Adjustable cutting edge run-out function.	Ø125 — Ø250	P M K N	M074
High Feed Cutting for Cast Iron **FP490** 90° KAPR	0.5	●11°positive insert. ●Suitable for cast iron finishing. ●Multi-insert design. ●For high feed cutting. ●Easy tool exchange.	Ø80 — Ø500	K	M262
High Feed Cutting for Cast Iron **FP590** 90° KAPR	0.5	●11°positive insert. ●Suitable for cast iron finishing. ●Multi-insert design. ●For high feed cutting. ●Easy tool exchange.	Ø125 — Ø500	K	M264
High Feed Cutting for Aluminium **FE404** 86° KAPR	9	●21°positive insert. ●High rake and relief angle. ●Multi-insert design. ●Suitable for light alloy machining. ●Easy tool exchange.	Ø100 — Ø500	N	M266
Multi Functional Milling NEW **WJX** 	2	●Negative inserts. ●Stable clamp with dovetail structure. ●Suitable for high feed machining. ●Special insert design with 6 cutting edges. ●With through coolant holes. TOOL NEWS	Ø50 — Ø160	P M K S H	M172
Multi Functional Milling **AJX** 	2	●15°positive insert. ●High rigidity double clamp structure. ●Suitable for high feed machining. ●Special insert design with 3 cutting edges. ●With through coolant holes. TOOL NEWS	Ø50 — Ø160	P M K S H	M162
Multi Functional Milling of Difficult-to-cut Materials **ARP** R KAPR	5 I 6	●Run-out does not occur easily when changing sections. ●Solid clamping system. ●Standardized stock of extra fine pitch. ●With through coolant holes. TOOL NEWS	Ø40 — Ø100	M S	M186
Multi Functional Milling **BRP** R KAPR	6 I 8	●11°positive insert. ●Round shape insert with a strong cutting edge. ●Wide range of tools available. ●Suitable for mould machining. TOOL NEWS	Ø40 — Ø100	P M K S H	M198

CLASSIFICATION

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
Multi Functional Milling **OCTACUT** 42° KAPR	7 I 9	●20°positive insert. ●For octagonal and round type inserts. ●Multi functional machining.	Ø40 — Ø160	P M K H	M181
For Cast Iron **VOX400** 90° KAPR	10	●Vertical inserts with high strength cutting edge. ●Economical 8 cutting edge inserts. ●Screw-on type. TOOL NEWS	Ø50 — Ø250	K	M076
For General Cutting **ASX400** 90° KAPR	10	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through air & coolant holes. TOOL NEWS	Ø50 — Ø250	P M K N S H	M080
For Multi Functional Cutting **APX3000** 90° KAPR	10	●Low cutting force insert. ●High accuracy, high quality vertical wall. ●With through air & coolant holes. TOOL NEWS	Ø32 — Ø100	P M K N S H	M097
For Multi Functional Cutting **APX4000** 90° KAPR	15	●Low cutting force insert. ●High accuracy, high quality vertical wall. ●With through air & coolant holes. TOOL NEWS	Ø40 — Ø160	P M K S H	M103
Multi Functional Milling for High Efficiency Machining NEW **VPX200** 90° KAPR	8	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø32 — Ø63	P M K N S H	M112
Multi Functional Milling for High Efficiency Machining NEW **VPX300** 90° KAPR	11	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø40 — Ø80	P M K N S H	M124
Aluminium Alloy to Difficult-to-cut Material Cutting **AXD4000** 90° KAPR	14.8 15.5	●Low resistance chipbreaker. ●Low resistance insert and high rigidity design for excellent performance. ●For high-speed machining. ●Multi-functional machining. ●With through coolant holes. TOOL NEWS	Ø40 — Ø125	P N S	M135
Aluminium Alloy to Difficult-to-cut Material Cutting **AXD7000** 90° KAPR	20.4 21	●Low resistance chipbreaker. ●Low resistance insert and high rigidity design for excellent performance. ●For high-speed machining. ●Multi-functional machining. ●With through coolant holes. TOOL NEWS	Ø50 — Ø125	P N S	M142
Aluminium Alloy to Difficult-to-cut Material Cutting **BXD4000** 90° KAPR	15	●Curved cutting edge and high rigidity holder produce high wall accuracy. ●Low resistance insert and high rigidity design for excellent performance. ●With through coolant holes to ensure smooth chip discharge. ●For high-speed machining. ●With through coolant holes. TOOL NEWS	Ø40 — Ø125	P M N S H	M150

CLASSIFICATION OF SIDE CUTTER

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
VAS400 Side Cutter 90° KAPR	11.4 – 12.2	●Insert with 4 cutting edges secure clamping. ●Excellent sharpness with low cutting resistance insert. ●Holders can load all corner R. *Cutter bodies are only available through special orders. TOOL NEWS	Ø80 — Ø160	P K	M090
VAS500 Side Cutter 90° KAPR	15.4 – 16.2	●Insert with 4 cutting edges secure clamping. ●Excellent sharpness with low cutting resistance insert. ●Holders can load all corner R. *Cutter bodies are only available through special orders. TOOL NEWS	Ø100 — Ø200	P K	M092
VOS400 Side Cutter 90° KAPR	10	●For cast iron. ●Cutter body with high-rigidity design. ●Innovative vertical insert. ●Economical 8 cutting edge inserts. *Cutter bodies are only available through special orders. TOOL NEWS	Ø80 — Ø160	K	M094
ASX400 Side Cutter 90° KAPR	10	●High-precision non-grinding insert. ●Economical 4 cutting edge inserts. ●Excellent wall surface precision with curved cutting edges and high-precision body. *Cutter bodies are only available through special orders. TOOL NEWS	Ø80 — Ø160	P M K	M095

CLASSIFICATION OF BORE BORING TOOLS

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
BMR 35° KAPR	—	●Double positive breaker. ●12-corner type with right hand. ●Body with peripheral cutting edge run-out regulator. *Cutter bodies are only available through special orders.	—	K	M260

CLASSIFICATION

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
WSX445 45° KAPR	5	●Unique design both sides insert. ●Sudden fracture & welding prevention function. ●Highly efficient chip discharge. ●With through coolant holes. TOOL NEWS	Ø40 — Ø80	P M K N S H	M022
ASX445 45° KAPR	6	●Precision inexpensive moulded type 20°positive insert. ●Screw-on type. ●A wide range of chip breakers. ●High rigidity due to carbide shim. TOOL NEWS	Ø50 — Ø80	P M K N S H	M032
AOX445 45° KAPR	8	●Solid CBN octagonal double sided insert. ●Economical 16 cutting edge inserts. (when the depth of cut is 3mm) ●For high efficiency roughing through to finishing. ●Easy operation and cleansing. TOOL NEWS	Ø50 — Ø63	K	M060
AJX	2	●13° and 15° positive inserts. ●High rigidity double clamp structure. ●Suitable for high feed machining. ●Special insert design with 3 cutting edges. ●With through coolant holes. TOOL NEWS	Ø16 — Ø63	P M K S H	M164
ASX400 90° KAPR	10	●High tolerance M-class inserts. ●Economical 4 cutting edge inserts. ●Curved cutting edge and high rigidity holder. ●Screw-on type. TOOL NEWS	Ø40 — Ø80	P M K N S H	M082
VPX200 NEW 90° KAPR	8	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø16 — Ø50	P M K N S H	M110
VPX300 NEW 90° KAPR	11	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø25 — Ø50	P M K N S H	M122
APX3000 90° KAPR	10	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through coolant holes. TOOL NEWS	Ø12 — Ø63	P M K N S H	M096
APX3000 Long Cutting Edge 90° KAPR	28 | 55	●High accuracy, high quality vertical wall. ●Low cutting force insert. TOOL NEWS	Ø20 — Ø40	P M K N S	M202
APX3000 Shell Type 90° KAPR	37 46	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through coolant holes. TOOL NEWS	Ø40 Ø50	P M K N S	M203

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
BAP300 90° KAPR	9	●11° positive insert. ●Inserts with wiper edges produce optimal finished surface. ●Multi insert design for high feed machining. TOOL NEWS	Ø10 — Ø63	P M K N S H	M086
BAP300 Long Cutting Edge 90° KAPR	25 | 51	●11° positive insert. ●Inserts with wiper edges produce optimal finished surface. ●Multi insert design for high feed machining. TOOL NEWS	Ø20 — Ø40	P M K N S H	M210
APX4000 90° KAPR	15	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through air & coolant holes. TOOL NEWS	Ø25 — Ø63	P M K S H	M102
APX4000 Long Cutting Edge 90° KAPR	56 84	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through air & coolant holes. TOOL NEWS	Ø40 Ø50	P M K S	M206
APX4000 Shell Type 90° KAPR	42 56	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through coolant holes. TOOL NEWS	Ø50 Ø63	P M K S	M207
AXD4000 90° KAPR	14.8 15.5	●Low resistance chipbreaker. ●Low resistance insert and high rigidity design for excellent performance. ●For high-speed machining. ●Multi-functional machining. ●With through coolant holes. TOOL NEWS	Ø20 — Ø40	P N S	M134
AXD7000 90° KAPR	20.4 21	●Low resistance chipbreaker. ●Low resistance insert and high rigidity design for excellent performance. ●For high-speed machining. ●Multi-functional machining. ●With through coolant holes. TOOL NEWS	Ø32 — Ø50	P N S	M142
BXD4000 90° KAPR	15	●Curved cutting edge and high rigidity holder produce high wall accuracy. ●Low resistance insert and high rigidity design for excellent performance. ●With through coolant holes to ensure smooth chip discharge. ●For high-speed machining. ●With through coolant holes. TOOL NEWS	Ø20 — Ø40	P M N S H	M152
AQX 90° KAPR	7.4 | 55	●The center bottom cutting edge enables drilling without previously formed hole. ●With through coolant holes. TOOL NEWS	Ø16 — Ø050	P M K N S H	M154
ARP R KAPR	5 | 6	●Run out does not occur easily when changing sections. ●Solid clamping system. ●Standardized stock of extra fine pitch. ●With through coolant holes. TOOL NEWS	Ø25 — Ø050	M S	M188

CLASSIFICATION

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
ARX R KAPR	2.5 | 3.5	●15°positive, high tolerance M-class insert. ●Effective for various machining applications. ●With through coolant holes. TOOL NEWS	Ø10 — Ø25	P M K H	M192
WJX NEW	2	●Multi functional milling. ●Negative inserts. ●Stable clamp with dovetail structure. ●Suitable for high feed machining. ●Special insert design with 6 cutting edges. ●With through coolant holes. TOOL NEWS	Ø50	P M K S H	M175
OCTACUT 42° KAPR	7 | 9	●20°positive insert. ●For octagonal and round type inserts. ●Multi-functional machining.	Ø32 — Ø63	P M K H	M180
BRP R KAPR	4 | 5	●11°positive insert. ●Round shape insert with a strong cutting edge. ●Wide range of tools available. ●Suitable for mould machining. TOOL NEWS	Ø12 — Ø63	P M K S H	M196
DCCC 90° KAPR	27 | 93	●Different helical flute angles prevents chattering. TOOL NEWS	Ø25 — Ø50	P M K	M212
SPX 90° KAPR	72 | 261	●Low cutting resistance due to the use of wavy inserts. ●Suitable for heavy cutting due to holder rigidity. TOOL NEWS	Ø50 — Ø63	P M K S	M215
SPX Shell Type 90° KAPR	58	●Low cutting resistance due to the use of wavy inserts. ●Suitable for heavy cutting due to holder rigidity. TOOL NEWS	Ø63 Ø80	P M K S	M216
VFX5 90° KAPR	26 | 75	●High performance titanium alloy milling. ●High rigidity design. ●Highly reliable clamping mechanism. ●With through coolant holes. TOOL NEWS	Ø40 — Ø80	S	M220
VFX6 90° KAPR	31 | 90	●High performance titanium alloy milling. ●High rigidity design. ●Highly reliable clamping mechanism. ●With through coolant holes. TOOL NEWS	Ø63 — Ø100	S	M224
SRF/SRB R KAPR	5.5 | 17	●S-shaped cutting edge provides sharpness similar to that of solid ball nose end mills. ●Highly accurate corner radius tolerance allows for high precision finishing. ●Carbide shank type available. TOOL NEWS	Ø10 — Ø32	P K N H	M228

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
SUF R KAPR	1.5 | 5.2	●Highly accurate corner radius tolerance allows for high precision finishing. ●Seamless gash. TOOL NEWS	Ø10 — Ø32	P M K H	M232
SRM2 R KAPR	12 | 44	●Suitable for roughing to semi-finishing of small and medium moulds. ●High rigidity body design. ●Low resistance chipbreaker. ●Through coolant hole type. TOOL NEWS	Ø16 — Ø30	P M K S H	M236
SRM2 ϕ40/ϕ50 R KAPR	54 63	●Best for roughing of moulds. ●Low resistance chipbreaker. ●Highly rigid body. TOOL NEWS	Ø40 Ø50	P K	M244
CESP•CFSP•CGSP 30° KAPR 45° KAPR 60° KAPR	5.9 | 10.2	●Covers 5 cutting modes. ●Excellent sharpness with 11°positive inserts. ●30°, 45° and 60° chamfer series.	Ø8 — Ø32	P K	M246
TSMP 90° KAPR	11 | 18	●T-groove order number 14, 18 and 22 are available. ●86° rhombic shape 11° positive insert. ●Shoulder milling and inversed spot facing are also possible.	Ø25 — Ø40	P K	M248
CBJP•CBMP 94° KAPR	—	●Capable of spot facing machining, boring and interpolation. ●For seat machining of hexagon socket head bolt (M8-M30). ●86°rhombic shape 11°positive insert.	Ø14 — Ø48	P M K	M250
KSMG	1.2 | 4.5	●Side face grooving tool for machining centers. ●The minimum cutting diameter is ϕ25mm for internal grooving. ●For groove widths of 1.25mm — 6.0mm.	Ø25 Ø40	P K	M252
PMF	0.1	●2 directional cutting with large overhang. ●Excellent straightness. ●Excellent wall accuracy. TOOL NEWS	Ø50 — Ø80	P K	M256
PMR	11	●2 directional cutting with large overhang. ●Horizontal feed cutting and oblique cutting are also possible. ●Unique shape of curved edge gives high rigidity and low resistance. TOOL NEWS	Ø50 — Ø80	P K	M258

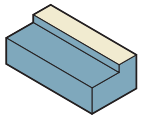
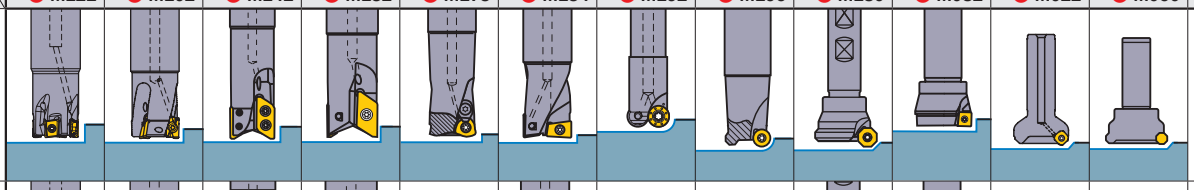
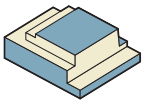
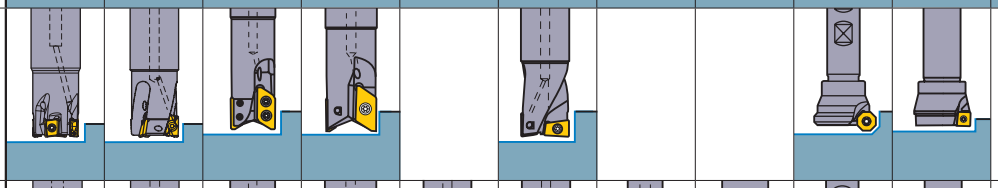
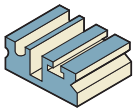
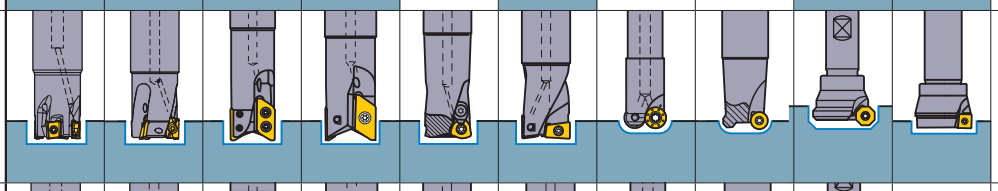
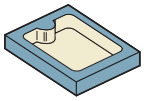
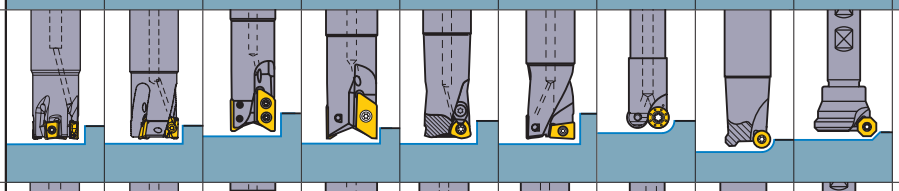
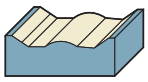
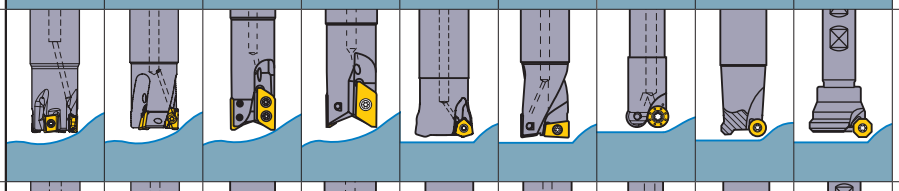
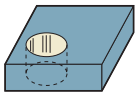
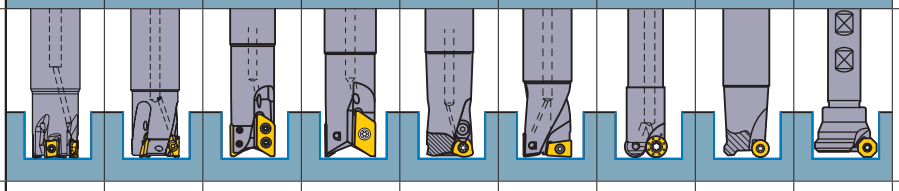
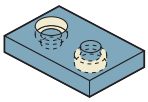
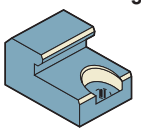
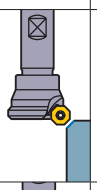
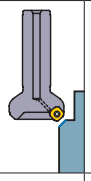
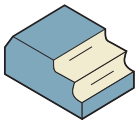
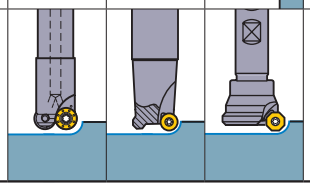
CLASSIFICATION OF SCREW-IN TOOLS

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
ASX400 90° KAPR	10	●High tolerance M-class inserts. ●Economical 4 cutting edge inserts. ●Curved cutting edge and high rigidity holder. ●Screw-on type. ●With through coolant holes. TOOL NEWS	Ø32 — Ø40	P M K N S H	M083
APX3000 90° KAPR	10	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through air & coolant holes. TOOL NEWS	Ø16 — Ø40	P M K N S H	M098
APX4000 90° KAPR	15	●High accuracy, high quality vertical wall. ●Low cutting force insert. ●With through air & coolant holes. TOOL NEWS	Ø25 — Ø40	P M K S H	M104
AQX 90° KAPR	7.4 – 18	●The center bottom cutting edge enables drilling without previously formed hole. ●With through coolant holes. TOOL NEWS	Ø16 — Ø40	P M K N S H	M156
VPX200 NEW 90° KAPR	8	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø16 — Ø40	P M K N S H	M111
VPX300 NEW 90° KAPR	11	●Special insert design with 4 cutting edges. ●High precision, high quality insert cutting edge with finishing blade. ●With through coolant holes. TOOL NEWS	Ø25 — Ø40	P M K N S H	M123
AJX	2	●13° and 15° positive inserts. ●High rigidity double clamp structure. ●Suitable for high feed machining. ●Special insert design with 3 cutting edges. ●With through coolant holes. TOOL NEWS	Ø16 — Ø40	P M K S H	M166
ARP R KAPR	5 – 6	●Run-out does not occur easily when changing sections. ●Solid clamping system. ●With through coolant holes. TOOL NEWS	Ø25 — Ø40	M S	M189
ARX R KAPR	3	●15°positive, high tolerance M-class insert. ●Effective for various machining applications. ●With through air & coolant holes. TOOL NEWS	Ø16 — Ø25	P M K H	M193

CLASSIFICATION OF SCREW-IN TOOLS

Product Name · Shape	APMX (mm)	Features	Cutter Dia. (mm)	Work Material	Page
SRF/SRB R KAPR	9 – 17	●S-shaped cutting edge provides sharpness similar to that of solid ball nose end mills. ●Highly accurate corner radius tolerance allows for high precision finishing. ●Carbide shank type available. ●With through coolant holes. TOOL NEWS	Ø16 — Ø32	P K N H	M229
SUF R KAPR	2.1 – 5.2	●Highly accurate corner radius tolerance allows for high precision finishing. ●Seamless gash. ●With through coolant holes. TOOL NEWS	Ø16 — Ø32	P M K H	M233
SRM2 R KAPR	12 – 44	●Suitable for roughing to semi-finishing of small and medium moulds. ●High rigidity body design. ●Low resistance chipbreaker. ●With through coolant holes. TOOL NEWS	Ø16 — Ø32	P M K S H	M238
PMC	1.5 – 3.5	●For under-cutting trimmed part of press mould. ●2 directional cutting with large overhang. ●With through coolant holes. TOOL NEWS	Ø25 — Ø40	P K	M254

CLASSIFICATION

Cutting Mode \ Product Name	Multi Functional Type									General Type		
	VPX200 VPX300 NEW	APX3000 APX4000	AXD4000 AXD7000	BXD4000	AJX WJX NEW	AQX	ARX	ARP BRP	OCTACUT	ASX400	ASX445 WSX445	AOX445
	M110 M122	M096 M102	M134 M142	M152	M164 M175	M154	M192	M188 M196	M180	M082	M032 M022	M060
Face Milling 												
Shoulder Milling 												
Slot Milling 												
Pocket Milling 												
Copy Milling 												
Helical Drilling 												
Spot Milling 												
Chamfer Milling 												
Radius Milling 												

	Long Cutting Edge Type					Ball/Radius Type			Special Purpose Type				
BAP300	BAP300 Long Cutting Edge Type DCCC	NEW APX3000 APX4000 Long Cutting Edge Type	VFX5 VFX6	SPX	SRM2	SRF/SRB For Finishing	SUF For Finishing	CESP CFSP CGSP	TSMP	CBJP CBMP	PMC*1 PMF PMR	KSMG
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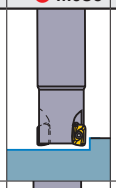
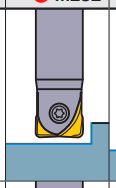
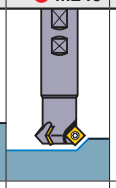
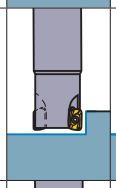
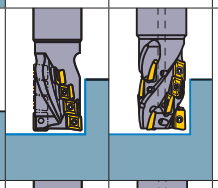
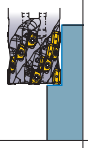
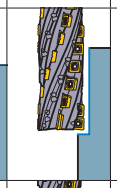
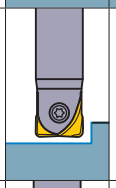
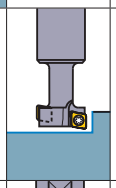
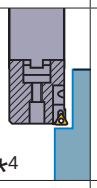
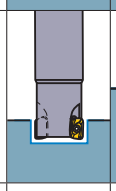
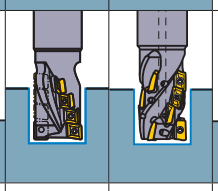
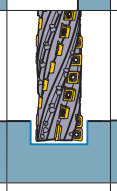
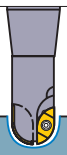
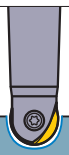
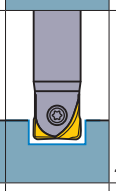
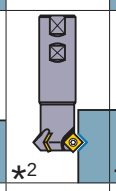
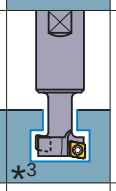
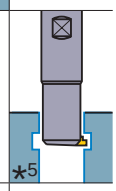
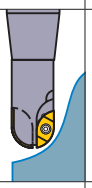
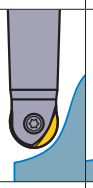
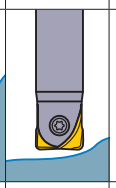
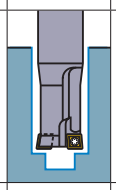
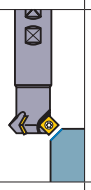
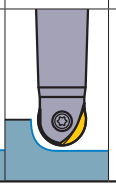
												
											 *4	
								 *2	 *3			 *5
												
												
												
												

*1 Vertical Feed Milling *2 V-Slot Milling *3 T-Slot Milling *4 Plunging *5 Slot Milling

FACE MILLING
<GENERAL CUTTING>

TOOL NEWS

45° KAPR

F R

WSX445

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

Fig.1

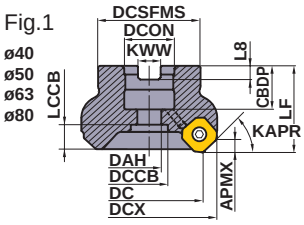
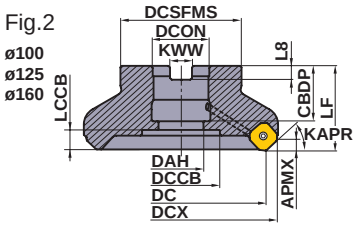


Fig.2



Right hand tool holder shown.

- Unique design both sides insert.
- Sudden fracture & welding prevention function.
- Highly efficient chip discharge.

■Arbor Type Right Hand Tool Holder

KAPR :45°
GAMP:+17° GAMF:-6°−+1°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Type	Dimensions (mm) DCX	LF	DCON	WT (kg)	APMX (mm)	Fig.
40	**WSX445-040A03AR**	●	○	3	Coarse Pitch	52.8	40	16	0.3	5	1
40	**WSX445-040A04AR**	●	○	4	Fine Pitch	52.8	40	16	0.3	5	1
50	**WSX445-050A03AR**	●	○	3	Coarse Pitch	62.9	40	22	0.5	5	1
50	**WSX445-050A04AR**	●	○	4	Fine Pitch	62.9	40	22	0.4	5	1
50	**WSX445-050A05AR**	●	○	5	Extra Fine Pitch	62.9	40	22	0.4	5	1
63	**WSX445-063A04AR**	●	○	4	Coarse Pitch	75.9	40	22	0.6	5	1
63	**WSX445-063A05AR**	●	○	5	Fine Pitch	75.9	40	22	0.6	5	1
63	**WSX445-063A06AR**	●	○	6	Extra Fine Pitch	75.9	40	22	0.6	5	1
80	**WSX445R08004CA**	●	○	4	Coarse Pitch	92.9	50	25.4	1.3	5	1
80	**WSX445R08006CA**	●	○	6	Fine Pitch	92.9	50	25.4	1.2	5	1
80	**WSX445R08008CA**	●	○	8	Extra Fine Pitch	92.9	50	25.4	1.1	5	1
100	**WSX445R10005DA**	●	○	5	Coarse Pitch	112.9	50	31.75	1.8	5	2
100	**WSX445R10007DA**	●	○	7	Fine Pitch	112.9	50	31.75	1.7	5	2
100	**WSX445R10010DA**	●	○	10	Extra Fine Pitch	112.9	50	31.75	1.6	5	2
125	**WSX445R12506EA**	●	○	6	Coarse Pitch	137.9	63	38.1	3.2	5	2
125	**WSX445R12508EA**	●	○	8	Fine Pitch	137.9	63	38.1	3.1	5	2
125	**WSX445R12512EA**	●	○	12	Extra Fine Pitch	137.9	63	38.1	3.0	5	2
160	**WSX445R16007FA**	●	○	7	Coarse Pitch	172.9	63	50.8	4.9	5	2
160	**WSX445R16010FA**	●	○	10	Fine Pitch	172.9	63	50.8	4.8	5	2
160	**WSX445R16016FA**	●	○	16	Extra Fine Pitch	172.8	63	50.8	4.6	5	2
200	**WSX445R20008KN**	●	–	8	Coarse Pitch	212.9	63	47.625	8.7	5	3
200	**WSX445R20012KN**	●	–	12	Fine Pitch	212.9	63	47.625	8.6	5	3
200	**WSX445R20020KN**	●	–	20	Extra Fine Pitch	212.8	63	47.625	8.4	5	3
NEW 250	**WSX445R25010KN**	●	–	10	Coarse Pitch	262.9	63	47.625	13.1	5	3
NEW 250	**WSX445R25014KN**	●	–	14	Fine Pitch	262.9	63	47.625	13.2	5	3
NEW 315	**WSX445R31514PN**	●	–	14	Coarse Pitch	327.9	63	47.625	21.5	5	4

Note1) A set bolt to the arbor is not supplied with the body.
Note2) Please use a set bolt of the FMC(metric) type on the cutter body from 40 to 63 in diameter(DC).
Note3) Please use a set bolt of the FMA type on the cutter body from 80 to 315 in diameter(DC).

SPARE PARTS

Arbor Type	* Clamp Screw	Wrench (Insert)
WSX445	TPS4R	TIP15W

* Clamp Torque (N • m) : TPS4R=3.5

● : **Inventory maintained in Japan.**

Fig.3

ø200
ø250

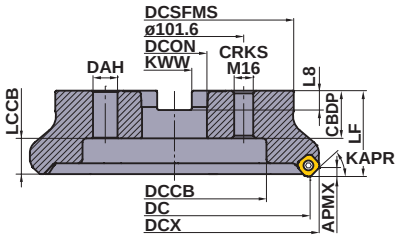
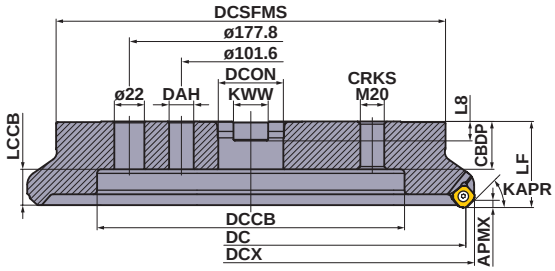


Fig.4

ø315



Right hand tool holder shown.

■ Arbor Type Left Hand Tool Holder

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Type	Dimensions (mm) DCX	LF	DCON	WT (kg)	APMX (mm)	Fig.
80	**WSX445L08004CA**	●	○	4	Coarse Pitch	92.9	50	25.4	1.3	5	1
100	**WSX445L10005DA**	●	○	5	Coarse Pitch	112.9	50	31.75	1.8	5	2
125	**WSX445L12506EA**	●	○	6	Coarse Pitch	137.9	63	38.1	3.2	5	2
160	**WSX445L16007FA**	●	○	7	Coarse Pitch	172.9	63	50.8	4.9	5	2
200	**WSX445L20008KN**	●	–	8	Coarse Pitch	212.9	63	47.625	8.7	5	3
NEW 250	**WSX445L25010KN**	●	–	10	Coarse Pitch	262.9	63	47.625	13.1	5	3

Note1) A set bolt to the arbor is not supplied with the body.
Note2) Please use a set bolt of the FMA type on the cutter body from 80 to 250 in diameter(DC).

SET BOLT (SOLD SEPARATELY)

Arbor Type	Set Bolt: With Coolant Hole Order Number	Set Bolt: Without Coolant Hole Order Number	Fig.	Reference Dimensions (mm) a	b	c	d	e	f	g	Geometry
WSX445-040A○○AR	HSC08025H	HSC08040	1	13	M8×1.25	33	8	5	–	–	
WSX445-050A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
WSX445-063A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
WSX445-080A○○A○	HSC12035H	HSC12035 HSC12045	1	18	M12×1.75	47 57	12	10	–	–	Fig.1
WSX445-100B○○A○	MBA16033H	—	2	40	M16×2	43	10	14	6	23	
WSX445-125B○○A○	MBA20040H	—	2	50	M20×2.5	54	14	17	6	27	
WSX445-160C○○N○	No coolant hole	—	2	50	M20×2.5	54	14	17	6	27	
WSX445-200C○○NR	No coolant hole	—	1	24	M16×2	43	16	14	–	–	
WSX445-250C○○NR	No coolant hole	—	1	24	M16×2	43	16	14	–	–	
WSX445-315C○○NR	No coolant hole	—	1	24	M16×2	43	16	14	–	–	Fig.2
WSX445○080○○CA	HSC12035H	HSC12035 HSC12045	1	18	M12×1.75	47 57	12	10	–	–	
WSX445○100○○DA	MBA16033H	—	2	40	M16×2	43	10	14	6	23	
WSX445○125○○EA	MBA20040H	—	2	50	M20×2.5	54	14	17	6	27	
WSX445○160○○FA	MBA24045H	—	2	65	M24×3	59	14	17	10	37	
WSX445○200○○KN	No coolant hole	—	1	24	M16×2	43	16	14	–	–	
WSX445○250○○KN	No coolant hole	—	1	24	M16×2	43	16	14	–	–	
WSX445○315○○PN	No coolant hole	—	1	30	M20×2.5	43	20	17	–	–	

Note 1) Internal coolant is necessary with the set bolt.

MOUNTING DIMENSION ➤ M024
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Metric Standard

The cutter bore diameter DCON is indicated in millimetres.

Fig.1

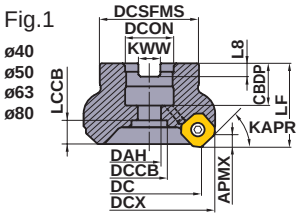
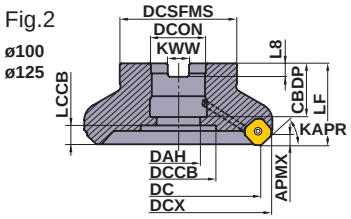


Fig.2



Right hand insert shown.

■ Arbor Type Right Hand Tool Holder

KAPR : 45°
GAMP : +17° GAMF : -6°—+1°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Type	Dimensions (mm) DCX	LF	DCON	WT (kg)	APMX (mm)	Fig.
40	**WSX445-040A03AR**	●	○	3	Coarse Pitch	52.8	40	16	0.3	5	1
40	**WSX445-040A04AR**	●	○	4	Fine Pitch	52.8	40	16	0.3	5	1
50	**WSX445-050A03AR**	●	○	3	Coarse Pitch	62.9	40	22	0.5	5	1
50	**WSX445-050A04AR**	●	○	4	Fine Pitch	62.9	40	22	0.4	5	1
50	**WSX445-050A05AR**	●	○	5	Extra Fine Pitch	62.9	40	22	0.4	5	1
63	**WSX445-063A04AR**	●	○	4	Coarse Pitch	75.9	40	22	0.6	5	1
63	**WSX445-063A05AR**	●	○	5	Fine Pitch	75.9	40	22	0.6	5	1
63	**WSX445-063A06AR**	●	○	6	Extra Fine Pitch	75.9	40	22	0.6	5	1
80	**WSX445-080A04AR**	●	○	4	Coarse Pitch	92.9	50	27	1.3	5	1
80	**WSX445-080A06AR**	●	○	6	Fine Pitch	92.9	50	27	1.2	5	1
80	**WSX445-080A08AR**	●	○	8	Extra Fine Pitch	92.9	50	27	1.1	5	1
100	**WSX445-100B05AR**	●	○	5	Coarse Pitch	112.9	50	32	1.9	5	2
100	**WSX445-100B07AR**	●	○	7	Fine Pitch	112.9	50	32	1.9	5	2
100	**WSX445-100B10AR**	●	○	10	Extra Fine Pitch	112.9	50	32	1.8	5	2
125	**WSX445-125B06AR**	●	○	6	Coarse Pitch	137.9	63	40	3.4	5	2
125	**WSX445-125B08AR**	●	○	8	Fine Pitch	137.9	63	40	3.4	5	2
125	**WSX445-125B12AR**	●	○	12	Extra Fine Pitch	137.9	63	40	3.2	5	2
160	**WSX445-160C07NR**	●	–	7	Coarse Pitch	172.9	63	40	4.9	5	3
160	**WSX445-160C10NR**	●	–	10	Fine Pitch	172.9	63	40	4.8	5	3
160	**WSX445-160C16NR**	●	–	16	Extra Fine Pitch	172.8	63	40	4.6	5	3
200	**WSX445-200C08NR**	●	–	8	Coarse Pitch	212.9	63	60	7.5	5	4
200	**WSX445-200C12NR**	●	–	12	Fine Pitch	212.9	63	60	7.4	5	4
200	**WSX445-200C20NR**	●	–	20	Extra Fine Pitch	212.8	63	60	7.2	5	4

Note1) A set bolt to the arbor is not supplied with the body.
Note2) Please use a set bolt of the FMC(metric) type on the cutter body from 40 to 100 in diameter(DC).
Note3) Please use a set bolt of the FMB type on the cutter body from 125 to 200 in diameter(DC).

SPARE PARTS

Arbor Type	* Clamp Screw	Wrench (Insert)
WSX445	TPS4R	TIP15W

* Clamp Torque (N • m) : TPS4R=3.5

● : **Inventory maintained in Japan.**

Fig.3

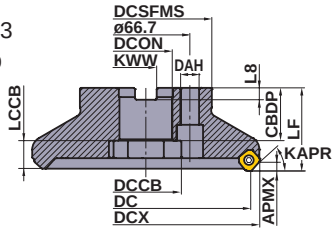
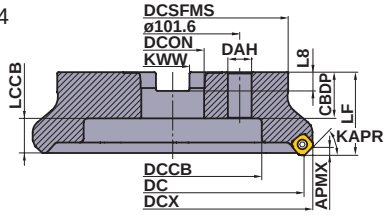


Fig.4



Right hand insert shown.

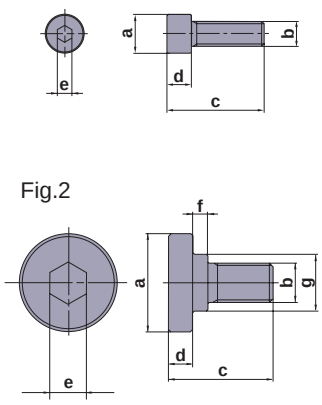
■ Arbor Type Left Hand Tool Holder

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Type	Dimensions (mm) DCX	LF	DCON	WT (kg)	APMX (mm)	Fig.
80	**WSX445-080A04AL**	●	○	4	Coarse Pitch	92.9	50	27	1.3	5	1
100	**WSX445-100B05AL**	●	○	5	Coarse Pitch	112.9	50	32	1.9	5	2
125	**WSX445-125B06AL**	●	○	6	Coarse Pitch	137.9	63	40	3.4	5	2
160	**WSX445-160C07NL**	●	–	7	Coarse Pitch	172.9	63	40	4.9	5	3

Note1) A set bolt to the arbor is not supplied with the body.
Note2) Please use a set bolt of the FMC(metric) type on the cutter body from 80 to 100 in diameter(DC).
Note3) Please use a set bolt of the FMB type on the cutter body from 125 to 160 in diameter(DC).

SET BOLT (SOLD SEPARATELY)

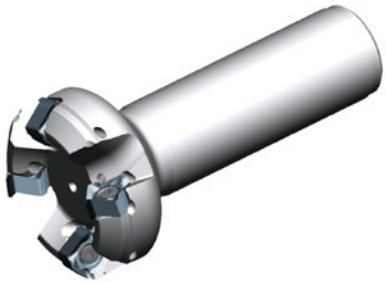
Arbor Type	Set Bolt: With Coolant Hole Order Number	Set Bolt: Without Coolant Hole Order Number	Fig.	Reference Dimensions (mm) a	b	c	d	e	f	g	Geometry
WSX445-040A○○AR	HSC08025H	HSC08040	1	13	M8×1.25	33	8	5	–	–	Fig.1
WSX445-050A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
WSX445-063A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
WSX445-080A○○A○	HSC12035H	HSC12035 (HSC12045)	1	18	M12×1.75	47 57	12	10	–	–	
WSX445-100B○○A○	MBA16033H	—	2	40	M16×2	43	10	14	6	23	Fig.2
WSX445-125B○○A○	MBA20040H	—	2	50	M20×2.5	54	14	17	6	27	
WSX445-160C○○N○	No coolant hole	—	2	50	M20×2.5	54	14	17	6	27	
WSX445-200C○○NR	No coolant hole	—	1	24	M16×2	43	16	14	–	–	

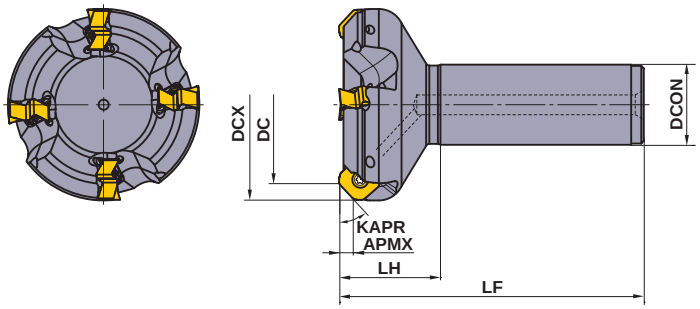


Note 1) Internal coolant is necessary with the set bolt.

M
INDEXABLE MILLING

MOUNTING DIMENSION ➤ M024
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001





Right hand tool holder only.

■SHANK TYPE

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Type	Dimensions (mm)				WT (kg)	APMX (mm)
						DCX	LF	DCON	LH		
40	**WSX445R4003SA32M**	●	○	3	Coarse Pitch	52.8	125	32	40	0.8	5
40	**WSX445R4004SA32M**	●	○	4	Fine Pitch	52.8	125	32	40	0.8	5
50	**WSX445R5003SA32M**	●	○	3	Coarse Pitch	62.9	125	32	40	1.0	5
50	**WSX445R5004SA32M**	●	○	4	Fine Pitch	62.9	125	32	40	1.0	5
63	**WSX445R6304SA32M**	●	○	4	Coarse Pitch	75.9	125	32	40	1.2	5
63	**WSX445R6305SA32M**	●	○	5	Fine Pitch	75.9	125	32	40	1.2	5
80	**WSX445R8004SA32M**	●	○	4	Coarse Pitch	92.9	125	32	40	1.6	5
80	**WSX445R8006SA32M**	●	○	6	Fine Pitch	92.9	125	32	40	1.5	5

SPARE PARTS

Arbor Type	*	
	Clamp Screw	Wrench (Insert)
WSX445	TPS4R	TIP15W

* Clamp Torque (N • m) : TPS4R=3.5

M

INDEXABLE MILLING

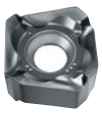
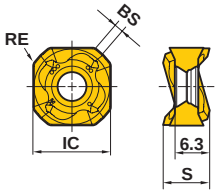
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS WITH BREAKER

Work Material		MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	MX3030		TF15	
P	Steel		◐	✣					◐	◐	◐			
M	Stainless Steel				◔	✣			◔	◔	◔			
K	Cast Iron	◐							✣	✣	◐			
N	Non-ferrous Metal												✣	
S	Heat-resistant Alloy, Titanium Alloy						◐	✣	◐	✣				
H	Hardened Steel								◔					

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting
✣ : Unstable Cutting

Honing : **E :** Round **F :** Sharp

Shape	Order Number	Class	Hand	Honing	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP20RT	MX3030		TF15		IC	S	BS	RE	Geometry
					Coated									Cermet		Carbide		Dimensions (mm)				
	SNGU140812ANFR-L	G	R	F												●		14	8.4	1.5	1.2	
	SNGU140812ANER-L	G	R	E	●	●	●	●	●	●	●	●	●	●				14	8.4	1.5	1.2	
	SNGU140812ANER-M	G	R	E	●	●	●	●	●	●	●	●	●	●				14	8.4	1.5	1.2	
	SNMU140812ANER-M	M	R	E	●	●	●	●	●	●	●	●	●	●				14	8.4	1.5	1.2	
	SNMU140812ANER-R	M	R	E	●	●	●					●	●					14	8.4	1.5	1.2	
	SNMU140812ANER-H	M	R	E	●	●	●					●	●					14	8.4	1.5	1.2	
	NEW SNGU140812ANFL-L	G	L	F												●		14	8.4	1.5	1.2	
	NEW SNGU140812ANEL-L	G	L	E	●	●	●					●		●				14	8.4	1.5	1.2	
	SNGU140812ANEL-M	G	L	E	●	●	●					●		●				14	8.4	1.5	1.2	
	SNMU140812ANEL-M	M	L	E	●	●	●					●		●				14	8.4	1.5	1.2	
	SNMU140812ANEL-R	M	L	E	●	●	●					●						14	8.4	1.5	1.2	Right hand insert shown.

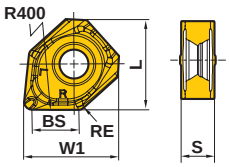
● = NEW

WIPER INSERTS

Work Material		MC5020	MP6120	VP15TF	MX3020	
P	Steel		◐	◐	◐	
M	Stainless Steel			◔	◔	
K	Cast Iron	◐		✣	◐	
S	Heat-resistant Alloy, Titanium Alloy			◐		
H	Hardened Steel			◔		

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting
✣ : Unstable Cutting

Honing : **E :** Round **F :** Sharp

Shape	Order Number	Class	Honing	MC5020	MP6120	VP15TF	MX3020		L	W1	S	BS	RE	Geometry
				Coated			Cermet		Dimensions (mm)					
	WNGU1406ANEN8C-M	G	E	●	●	●	NEW ●		16.87	16.87	6	8	1.0	

● = NEW

■Instructions for use of wiper inserts

Fig.1

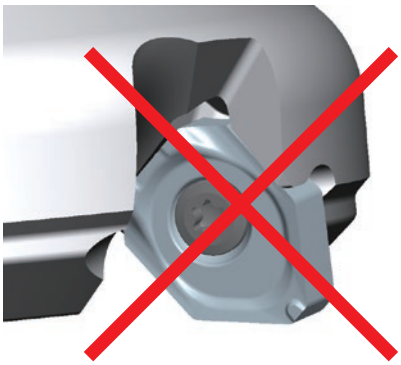


Fig.2

Wiper inserts for WSX445 are two-cornered. Please set as shown in Fig.1.
Excellent finished surfaces can be achieved with one wiper.
Set more than 2 wiper inserts, equally spaced, when the feed per revolution is larger than 8mm/rev.

Arbor Type Mounting Dimensions

Fig.1

ø40
ø50
ø63
ø80

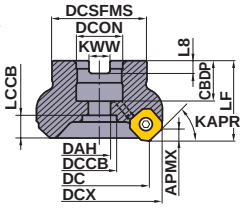


Fig.2

ø100
ø125
ø160

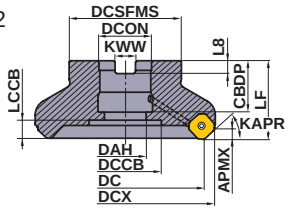
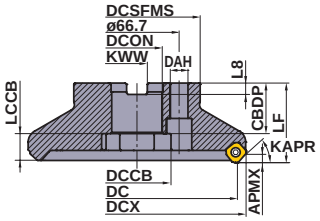


Fig.3

ø160



Right hand insert shown.

DC (mm)	Order Number	Dimensions (mm)								Fig.
		DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
40	**WSX445-040A03AR**	16	18	9	14	13.3	37	8.4	5.6	1
40	**WSX445-040A04AR**	16	18	9	14	13.3	37	8.4	5.6	1
50	**WSX445-050A03AR**	22	20	11	17	11.3	47	10.4	6.3	1
50	**WSX445-050A04AR**	22	20	11	17	11.3	47	10.4	6.3	1
50	**WSX445-050A05AR**	22	20	11	17	11.3	47	10.4	6.3	1
63	**WSX445-063A04AR**	22	20	11	17	11.3	50	10.4	6.3	1
63	**WSX445-063A05AR**	22	20	11	17	11.3	50	10.4	6.3	1
63	**WSX445-063A06AR**	22	20	11	17	11.3	50	10.4	6.3	1
80	**WSX445R08004CA**	25.4	26	13	20	14.3	56	9.5	6	1
80	**WSX445R08006CA**	25.4	26	13	20	14.3	56	9.5	6	1
80	**WSX445R08008CA**	25.4	26	13	20	14.3	56	9.5	6	1
80	**WSX445L08004CA**	25.4	26	13	20	14.3	56	9.5	6	1
80	**WSX445-080A04AR**	27	23	13	20	14.3	56	12.4	7	1
80	**WSX445-080A06AR**	27	23	13	20	14.3	56	12.4	7	1
80	**WSX445-080A08AR**	27	23	13	20	14.3	56	12.4	7	1
80	**WSX445-080A04AL**	27	23	13	20	14.3	56	12.4	7	1
100	**WSX445R10005DA**	31.75	32	26	45	11.3	70	12.7	8	2
100	**WSX445R10007DA**	31.75	32	26	45	11.3	70	12.7	8	2
100	**WSX445R10010DA**	31.75	32	26	45	11.3	70	12.7	8	2
100	**WSX445L10005DA**	31.75	32	26	45	11.3	70	12.7	8	2
100	**WSX445-100B05AR**	32	26	26	45	16.3	78	14.4	8	2
100	**WSX445-100B07AR**	32	26	26	45	16.3	78	14.4	8	2
100	**WSX445-100B10AR**	32	26	26	45	16.3	78	14.4	8	2
100	**WSX445-100B05AL**	32	26	26	45	16.3	78	14.4	8	2
125	**WSX445R12506EA**	38.1	36	30	56	19.3	80	15.9	10	2
125	**WSX445R12508EA**	38.1	36	30	56	19.3	80	15.9	10	2
125	**WSX445R12512EA**	38.1	36	30	56	19.3	80	15.9	10	2
125	**WSX445L12506EA**	38.1	36	30	56	19.3	80	15.9	10	2
125	**WSX445-125B06AR**	40	28	30	56	21.3	89	16.4	9	2
125	**WSX445-125B08AR**	40	28	30	56	21.3	89	16.4	9	2
125	**WSX445-125B12AR**	40	28	30	56	21.3	89	16.4	9	2
125	**WSX445-125B06AL**	40	28	30	56	21.3	89	16.4	9	2

Fig.4

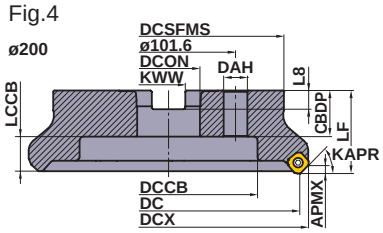


Fig.5

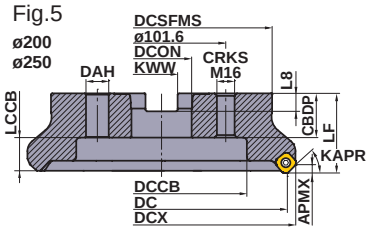
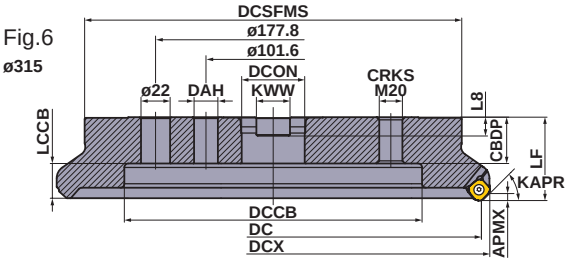


Fig.6



Right hand insert shown.

DC (mm)	Order Number	Dimensions (mm)								Fig.
		DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
160	**WSX445-160C07NR**	40	40	14	56	21.3	100	16.4	9	3
160	**WSX445-160C10NR**	40	40	14	56	21.3	100	16.4	9	3
160	**WSX445-160C16NR**	40	40	14	56	21.3	100	16.4	9	3
160	**WSX445-160C07NL**	40	40	14	56	21.3	100	16.4	9	3
160	**WSX445R16007FA**	50.8	38	40	72	16.3	100	19.1	11	2
160	**WSX445R16010FA**	50.8	38	40	72	16.3	100	19.1	11	2
160	**WSX445R16016FA**	50.8	38	40	72	16.3	100	19.1	11	2
160	**WSX445L16007FA**	50.8	38	40	72	16.3	100	19.1	11	2
200	**WSX445R20008KN**	47.625	35	18	135	26.3	175	25.4	14.22	5
200	**WSX445R20012KN**	47.625	35	18	135	26.3	175	25.4	14.22	5
200	**WSX445R20020KN**	47.625	35	18	135	26.3	175	25.4	14.22	5
200	**WSX445L20008KN**	47.625	35	18	135	26.3	175	25.4	14.22	5
200	**WSX445-200C08NR**	60	32	18	135	29.3	160	25.7	14.22	4
200	**WSX445-200C12NR**	60	32	18	135	29.3	160	25.7	14.22	4
200	**WSX445-200C20NR**	60	32	18	135	29.3	160	25.7	14.22	4
250	**WSX445R25010KN**	47.625	35	18	180	26.3	220	25.4	14.22	5
250	**WSX445R25014KN**	47.625	35	18	180	26.3	220	25.4	14.22	5
250	**WSX445L25010KN**	47.625	35	18	180	26.3	220	25.4	14.22	5
315	**WSX445R31514PN**	47.625	35	18	225	26.3	285	25.4	14.22	6

RECOMMENDED CUTTING CONDITIONS

■ Dry cutting

Work Material		Hardness	1st Recommendation	2nd Recommendation	vc (m/min)	Finish Cutting fz (mm/t.)	Finish Cutting ap
P						L Breaker	
	Mild Steel	≤ 180HB	MP6120	VP15TF	250 (200—300)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	240 (190—290)	0.15 (0.1—0.2)	≤ 1.0
			MX3030	—	180 (130—230)	0.15 (0.1—0.2)	≤ 1.0
	Carbon Steel Alloy Steel	180—350HB	MP6120	VP15TF	220 (170—270)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	200 (150—250)	0.15 (0.1—0.2)	≤ 1.0
			MX3030	—	150 (120—180)	0.15 (0.1—0.2)	≤ 1.0
	Alloy Tool Steel	≤ 350HB (Annealing)	MP6120	VP15TF	220 (170—270)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	200 (150—250)	0.15 (0.1—0.2)	≤ 1.0
			MX3030	—	150 (120—180)	0.15 (0.1—0.2)	≤ 1.0
	Pre-Hardened Steel	35—45HRC	MP6120	VP15TF	140 (100—180)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	120 (90—150)	0.15 (0.1—0.2)	≤ 1.0
M						L Breaker	
	Austenitic Stainless Steel	≤ 200HB	MP7130	VP15TF	200 (150—250)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	200 (150—250)	0.15 (0.1—0.2)	≤ 1.0
			MX3030	—	130 (100—180)	0.15 (0.1—0.2)	≤ 1.0
	Austenitic Stainless Steel	>200HB	MP7130	VP15TF	170 (120—220)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	170 (120—220)	0.15 (0.1—0.2)	≤ 1.0
	Two-phase Stainless Steel	≤ 280HB	MP7130	VP15TF	160 (110—210)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	160 (110—210)	0.15 (0.1—0.2)	≤ 1.0
	Precipitation Hardening Stainless Steel	≤ 450HB	MP7130	VP15TF	150 (100—200)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	150 (100—200)	0.15 (0.1—0.2)	≤ 1.0
K						L Breaker	
	Gray Cast Iron	≤ 350MPa	MC5020	—	220 (200—270)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	—	180 (130—250)	0.15 (0.1—0.2)	≤ 1.0
			VP20RT	—	170 (120—240)	0.15 (0.1—0.2)	≤ 1.0
			MX3030	—	150 (120—180)	0.15 (0.1—0.2)	≤ 1.0
	Ductile Cast Iron	≤ 450MPa	MC5020	—	200 (180—250)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	VP20RT	160 (110—240)	0.15 (0.1—0.2)	≤ 1.0
	Ductile Cast Iron	≤ 800MPa	MC5020	—	200 (180—250)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	—	160 (110—240)	0.15 (0.1—0.2)	≤ 1.0
			VP20RT	—	150 (100—200)	0.15 (0.1—0.2)	≤ 1.0
H						M Breaker	
	Hardened Steel	40—55HRC	VP15TF	—	50 (30—70)	0.05 (0.05—0.1)	≤ 1.0
	Hardened Steel	55—62HRC	VP15TF	—	40 (20—50)	0.05 (0.05—0.1)	≤ 1.0

Note 1) Refer to the table above and set the cutting conditions to match the application.
Note 2) Wet cutting is recommended, when focusing on the surface finish. (Life is lower than dry cutting.)

A feed per revolution by processing area **fz**(mm/t.) and the depth of cut **ap**								
	Light Cutting		Medium Cutting		Rough Cutting		Heavy Cutting	
	fz (mm/t.)	**ap**	**fz** (mm/t.)	**ap**	**fz** (mm/t.)	**ap**	**fz** (mm/t.)	**ap**
	L,M Breaker		M Breaker		M,R Breaker		R,H Breaker	
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	L,M Breaker		M Breaker					
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	—	—	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	L,M Breaker		M Breaker		M,R Breaker		R,H Breaker	
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	M,R Breaker		R,H Breaker					
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—

RECOMMENDED CUTTING CONDITIONS

■ Wet Cutting

Work Material		Hardness	1st Recommendation	2nd Recommendation	vc (m/min)	Finish Cutting fz (mm/t.)	Finish Cutting ap
P						L Breaker	
	Mild Steel	≤ 180HB	MP6120	VP15TF	150 (100—200)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	150 (100—200)	0.15 (0.1—0.2)	≤ 1.0
	Carbon Steel Alloy Steel	180—350HB	MP6120	VP15TF	120 (80—160)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	120 (80—160)	0.15 (0.1—0.2)	≤ 1.0
	Alloy Tool Steel	≤ 350HB (Annealing)	MP6120	VP15TF	120 (80—160)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	120 (80—160)	0.15 (0.1—0.2)	≤ 1.0
	Pre-Hardened Steel	35—45HRC	MP6120	VP15TF	100 (80—120)	0.15 (0.1—0.2)	≤ 1.0
			MP6130	VP20RT	100 (80—120)	0.15 (0.1—0.2)	≤ 1.0
M						L Breaker	
	Austenitic Stainless Steel	≤ 200HB	MP7130	VP15TF	130 (80—180)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	130 (80—180)	0.15 (0.1—0.2)	≤ 1.0
	Austenitic Stainless Steel	> 200HB	MP7130	VP15TF	100 (80—150)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	100 (80—150)	0.15 (0.1—0.2)	≤ 1.0
	Two-phase Stainless Steel	≤ 280HB	MP7130	VP15TF	100 (80—150)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	100 (80—150)	0.15 (0.1—0.2)	≤ 1.0
	Precipitation Hardening Stainless Steel	≤ 450HB	MP7130	VP15TF	90 (50—140)	0.15 (0.1—0.2)	≤ 1.0
			MP7140	VP20RT	90 (50—140)	0.15 (0.1—0.2)	≤ 1.0
K						L Breaker	
	Gray Cast Iron	≤ 350MPa	MC5020	—	180 (160—200)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	VP20RT	130 (100—160)	0.15 (0.1—0.2)	≤ 1.0
	Ductile Cast Iron	≤ 450MPa	MC5020	—	180 (160—200)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	VP20RT	130 (100—160)	0.15 (0.1—0.2)	≤ 1.0
	Ductile Cast Iron	≤ 800MPa	MC5020	—	180 (160—200)	0.15 (0.1—0.2)	≤ 1.0
			VP15TF	VP20RT	110 (80—140)	0.15 (0.1—0.2)	≤ 1.0
N						L Breaker	
	Aluminium Alloy	—	TF15	—	≥ 300	0.15 (0.1—0.2)	≤ 1.0
S						L Breaker	
	Titanium Alloy	—	MP9120	VP15TF	50 (40—60)	0.05 (0.05—0.1)	≤ 1.0
			MP9130	VP20RT	50 (40—60)	0.05 (0.05—0.1)	≤ 1.0
	Heat Resistant Alloy	—	MP9120	VP15TF	40 (20—50)	0.05 (0.05—0.1)	≤ 1.0
			MP9130	VP20RT	40 (20—50)	0.05 (0.05—0.1)	≤ 1.0

Note 1) Refer to the table above and set the cutting conditions to match the application.
Note 2) Wet cutting is recommended, when focusing on the surface finish. (Life is lower than dry cutting.)

A feed per revolution by processing area **fz**(mm/t.) and the depth of cut **ap**								
	Light Cutting		Medium Cutting		Rough Cutting		Heavy Cutting	
	fz (mm/t.)	**ap**	**fz** (mm/t.)	**ap**	**fz** (mm/t.)	**ap**	**fz** (mm/t.)	**ap**
	L,M Breaker		M Breaker		M,R Breaker		R,H Breaker	
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	L,M Breaker		M Breaker					
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	—	—	—	—
	L,M Breaker		M Breaker		M,R Breaker		R,H Breaker	
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	0.15 (0.1—0.2)	≤ 2.0	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	L Breaker		L Breaker		L Breaker		L Breaker	
	0.15 (0.1—0.2)	≤ 2.0	0.2 (0.15—0.25)	≤ 3.0	0.2 (0.15—0.25)	≤ 4.0	0.25 (0.2—0.3)	≤ 5.0
	L,M Breaker		M Breaker					
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—
	0.05 (0.05—0.1)	≤ 1.5	0.1 (0.05—0.15)	≤ 2.0	—	—	—	—

FACE MILLING
<GENERAL CUTTING>

TOOL NEWS

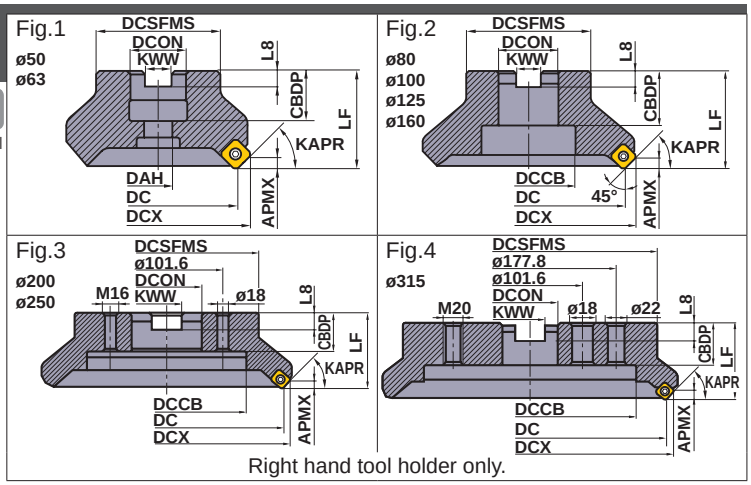
45° KAPR

F R

ASX445

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

- Precision inexpensive moulded type 20°positive insert.
- Screw-on type.
- A wide range of chip breakers.
- High rigidity due to carbide shim.



Right hand tool holder only.

■ARBOR TYPE

KAPR : 45°
GAMP : +20°—+23° GAMF : -10°—-13°

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	DCX	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT * (kg)	APMX (mm)	Fig.
Coarse Pitch	ASX445-050A03R	●	3	50	63.0	40	22	20	11	—	45	10.4	6.3	0.5	6	1
	ASX445-063A04R	●	4	63	75.9	40	22	20	11	—	50	10.4	6.3	0.7	6	1
	ASX445R08004C	●	4	80	93.2	50	25.4	26	—	38	56	9.5	6	1.1	6	2
	ASX445R10005D	●	5	100	113.2	50	31.75	32	—	45	70	12.7	8	1.8	6	2
	ASX445R12506E	●	6	125	138.0	63	38.1	35	—	60	80	15.9	10	2.9	6	2
	ASX445R16007F	●	7	160	173.0	63	50.8	38	—	80	100	19.1	11	4.7	6	2
	ASX445R20008K	●	8	200	212.9	63	47.625	35	—	140	175	25.4	14.22	7.9	6	3
	ASX445R25010K	●	10	250	262.9	63	47.625	35	—	180	220	25.4	14.22	12.9	6	3
	ASX445R31514P	●	14	315	327.9	63	47.625	40	—	245	285	25.4	14.22	22.4	6	4
Fine Pitch	ASX445-050A04R	●	4	50	63.0	40	22	20	11	—	45	10.4	6.3	0.4	6	1
	ASX445-063A05R	●	5	63	75.9	40	22	20	11	—	50	10.4	6.3	0.6	6	1
	ASX445R08006C	●	6	80	93.2	50	25.4	26	—	38	56	9.5	6	1.0	6	2
	ASX445R10007D	●	7	100	113.2	50	31.75	32	—	45	70	12.7	8	1.7	6	2
	ASX445R12508E	●	8	125	138.0	63	38.1	35	—	60	80	15.9	10	2.8	6	2
	ASX445R16010F	●	10	160	173.0	63	50.8	38	—	80	100	19.1	11	4.6	6	2
	ASX445R20012K	●	12	200	212.9	63	47.625	35	—	140	175	25.4	14.22	7.8	6	3
	ASX445R25014K	●	14	250	262.9	63	47.625	35	—	180	220	25.4	14.22	12.8	6	3
	ASX445R31518P	●	18	315	327.9	63	47.625	40	—	245	285	25.4	14.22	22.2	6	4
Extra Fine Pitch	ASX445-050A05R	●	5	50	63.0	40	22	20	11	—	45	10.4	6.3	0.4	6	1
	ASX445-063A06R	●	6	63	75.9	40	22	20	11	—	50	10.4	6.3	0.6	6	1
	ASX445R08008C	●	8	80	93.2	50	25.4	26	—	38	56	9.5	6	1.1	6	2
	ASX445R10010D	●	10	100	113.2	50	31.75	32	—	45	70	12.7	8	1.8	6	2
	ASX445R12512E	●	12	125	138.0	63	38.1	35	—	60	80	15.9	10	2.9	6	2
	ASX445R16016F	●	16	160	173.0	63	50.8	38	—	80	100	19.1	11	4.7	6	2
	ASX445R20020K	●	20	200	212.9	63	47.625	35	—	140	175	25.4	14.22	7.8	6	3
	ASX445R25024K	●	24	250	262.9	63	47.625	35	—	180	220	25.4	14.22	12.8	6	3
	ASX445R31528P	●	28	315	327.9	63	47.625	40	—	245	285	25.4	14.22	21.8	6	4

* WT : Tool Weight

● : Inventory maintained in Japan.

Fig.1
ø50
ø63

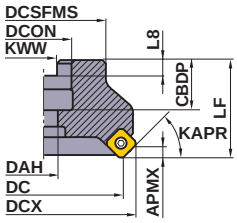


Fig.2
ø80
ø100

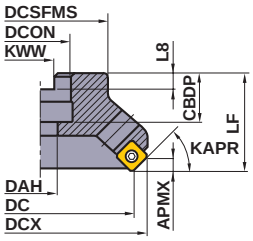
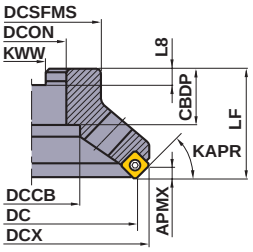


Fig.3
ø125



For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

ø50, ø63

Over ø80

Fig.4
ø160

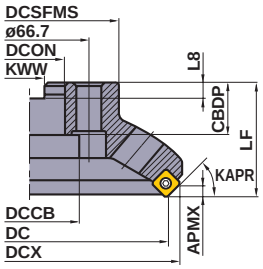
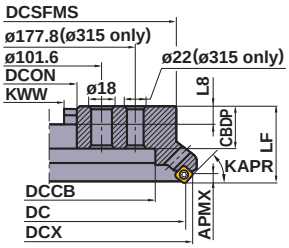


Fig.5
ø200
ø250
ø315



■ARBOR TYPE

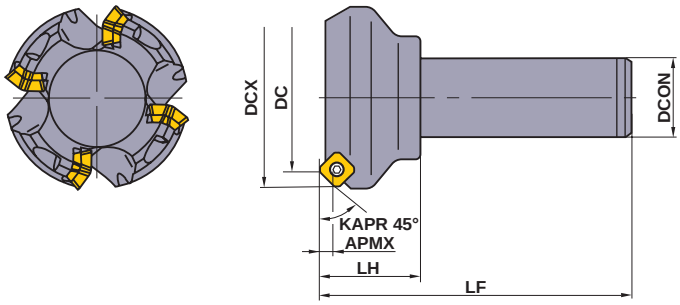
KAPR :45°
GAMP:+20°—+23° GAMF:-13°—-10°

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	DCX	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT* (kg)	APMX (mm)	Fig.
Coarse Pitch	ASX445-050A03R	●	3	50	63.0	40	22	20	11	—	45	10.4	6.3	0.5	6	1
	ASX445-063A04R	●	4	63	75.9	40	22	20	11	—	50	10.4	6.3	0.7	6	1
	ASX445-080A04R	●	4	80	93.2	50	27	23	13	—	56	12.4	7	1.0	6	2
	ASX445-100A05R	●	5	100	113.2	50	32	26	17	—	70	14.4	8	1.6	6	2
	ASX445-125B06R	●	6	125	138.0	63	40	32	—	56	80	16.4	9	2.4	6	3
	ASX445-160C07R	●	7	160	173.0	63	40	29	—	56	100	16.4	9	3.9	6	4
	ASX445-200C08R	●	8	200	212.9	63	60	32	—	135	155	25.7	14.22	6.7	6	5
	ASX445-250C10R	●	10	250	262.9	63	60	32	—	174	200	25.7	14.22	10.5	6	5
	ASX445-315C14R	●	14	315	327.9	80	60	57	—	256.8	285	25.7	14.22	22.4	6	5
Fine Pitch	ASX445-050A04R	●	4	50	63.0	40	22	20	11	—	45	10.4	6.3	0.4	6	1
	ASX445-063A05R	●	5	63	75.9	40	22	20	11	—	50	10.4	6.3	0.6	6	1
	ASX445-080A06R	●	6	80	93.2	50	27	23	13	—	56	12.4	7	0.9	6	2
	ASX445-100A07R	●	7	100	113.2	50	32	26	17	—	70	14.4	8	1.5	6	2
	ASX445-125B08R	●	8	125	138.0	63	40	32	—	56	80	16.4	9	2.3	6	3
	ASX445-160C10R	●	10	160	173.0	63	40	29	—	56	100	16.4	9	3.6	6	4
	ASX445-200C12R	●	12	200	212.9	63	60	32	—	135	155	25.7	14.22	5.8	6	5
	ASX445-250C14R	●	14	250	262.9	63	60	32	—	174	200	25.7	14.22	10.6	6	5
	ASX445-315C18R	●	18	315	327.9	80	60	57	—	256.8	285	25.7	14.22	22.2	6	5
Extra Fine Pitch	ASX445-050A05R	●	5	50	63.0	40	22	20	11	—	45	10.4	6.3	0.4	6	1
	ASX445-063A06R	●	6	63	75.9	40	22	20	11	—	50	10.4	6.3	0.6	6	1
	ASX445-080A08R	●	8	80	93.2	50	27	23	13	—	56	12.4	7	0.9	6	2
	ASX445-100A10R	●	10	100	113.2	50	32	26	17	—	70	14.4	8	1.5	6	2
	ASX445-125B12R	●	12	125	138.0	63	40	32	—	56	80	16.4	9	2.3	6	3
	ASX445-160C16R	●	16	160	173.0	63	40	29	—	56	100	16.4	9	3.6	6	4
	ASX445-200C20R	●	20	200	212.9	63	60	32	—	135	155	25.7	14.22	6.5	6	5
	ASX445-250C24R	●	24	250	262.9	63	60	32	—	174	200	25.7	14.22	10.3	6	5
	ASX445-315C28R	●	28	315	327.9	80	60	57	—	256.8	285	25.7	14.22	21.8	6	5

* WT : Tool Weight

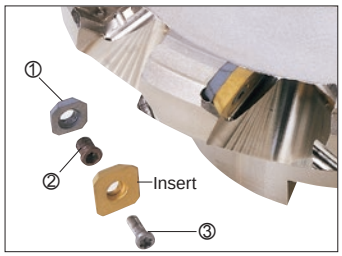
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001



Right hand tool holder only.

■ SHANK TYPE

Order Number	Stock	Number of Teeth	Dimensions(mm)					APMX (mm)
	R		DC	DCX	LF	DCON	LH	
ASX445R503S32	●	3	50	63.0	125	32	40	6
ASX445R634S32	●	4	63	75.9	125	32	40	6
ASX445R804S32	●	4	80	93.2	125	32	40	6



SPARE PARTS

Tool Holder Number	①	② *	③ *		
	Shim	Shim Screw	Clamp Screw	Wrench (Insert)	Wrench (Shim)
ASX445	STASX445N	WCS503507H	TPS35	TIP15T	HKY35R

* Clamp Torque (N • m) : WCS503507H=5.0, TPS35=3.5

Wrench	1. Wrench The ASX400 uses a TORXPLUS clamp screw. The attached wrench is for the exclusive use of this screw. To ensure the effectiveness of TORXPLUS only use the attached wrench. 2. Hexagonal wrench The attached hexagonal wrench is for use with the seat and the shim. The wrench size is 3.5mm.
Spare Parts	Only use the original parts that were supplied when purchased. If other parts are used the performance and safety can not be assured.

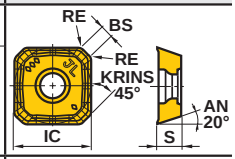
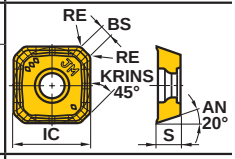
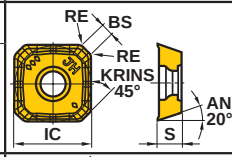
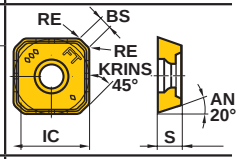
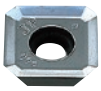
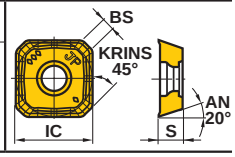
● : **Inventory maintained in Japan.**
(10 inserts in one case)

INSERTS

Work Material		F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545		HTi10	
P	Steel	◐		◐	✣					◐	✣	◐			
M	Stainless Steel	◔				◔	✣			◔	✣	◔			
K	Cast Iron		◐							✣	✣			◐	
N	Non-ferrous Metal													◐	
S	Heat-resistant Alloy, Titanium Alloy							◐	✣	◐	✣				
H	Hardened Steel									◔					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp
S : Chamfer + Hone **T :** Chamfer

Application	Shape	Order Number	Class	Honing	Coated										Cermet		Carbide		Dimensions(mm)				Geometry
					F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545		HTi10		IC	S	BS	RE	
Finish–Light Cutting	**JL** Breaker	**SEET13T3AGEN-JL**	E	E	●		●	●	●	●	●	●	●	●	●				13.4	3.97	1.9	1.5	
Light–Rough Cutting	**JM** Breaker	**SEMT13T3AGSN-JM**	M	S	●	●	●	●	●	●	●	●	●	●	●				13.4	3.97	1.9	1.5	
Medium–Heavy Cutting	**JH** Breaker	**SEMT13T3AGSN-JH**	M	S	●	●	●	●	●	●	●	●	●	●					13.4	3.97	1.9	1.5	
Roughing For Cast Iron	**FT** Breaker	**SEMT13T3AGSN-FT**	M	S		●													13.4	3.97	1.9	1.5	
For Aluminium Alloy	**JP** Breaker 	**SEGT13T3AGFN-JP**	G	F													●		13.4	3.97	2.2	—	

■ Instructions for use of the JP breaker

Note1) The JP breaker has sharp cutting edges.
Wear gloves when handling.

Note2) When machining aluminium alloy, welding to the cutting edge tends to occur, often leading to insert failure.

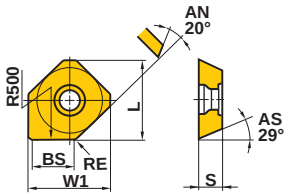
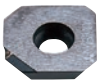
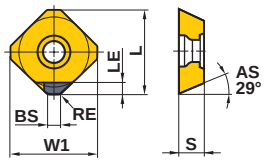
Note3) Wet cutting is recommended.

WIPER INSERTS

Work Material		MC5020	VP15TF	NX2525	VP25N	HTi05T	MB710	MD220
P	Steel		◐	◐	◐			
M	Stainless Steel		◐	◐	◐			
K	Cast Iron	◐	✣	◐	◐	◐	◐	
N	Non-ferrous Metal					◐		◐
S	Heat-resistant Alloy, Titanium Alloy		◐					
H	Hardened Steel		◐					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp
S : Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	Coated MC5020	Coated VP15TF	Cermet NX2525	Coated Cermet VP25N	Carbide HTi05T	CBN MB710	PCD MD220	Dimensions(mm) L	LE	W1	S	BS	RE	Geometry
	WEEW13T3AGER8C	E	E	●	●			●			16.6	–	16.48	3.97	7.5	1.5	
	WEEW13T3AGTR8C	E	T			●	●				16.6	–	16.48	3.97	7.5	1.5	
	WEEW13T3AGFR3C	E	F							●	16.6	1.8	16.48	3.97	3.0	1.5	
	WEEW13T3AGTR3C	E	T						●		16.6	1.8	16.48	3.97	3.0	1.5	

⋆Wiper inserts are single-cornered.
⋆CBN grade MB710 is for cast iron.
⋆PCD grade MD220 is for aluminium alloy.

■Instructions for use of wiper inserts

Fig.1

Fig.2

Note 1) These wiper inserts are single-cornered.
Note 2) Install the insert so that the cutting edge is located as shown in Fig. 1.
Do not install the wiper insert as shown in Fig. 2. (The insert may be damaged by a too heavy cutting load.)
Note 3) Recommended depth of cutting is ap=0.2-0.5(mm). (Be aware of the cutting load if the depth of cut is over the recommendation.)
Note 4) The major cutting edge of a wiper insert is set more inside than a general tooth.
This is to prevent heavy loads on the wiper insert. (To prevent fracture set the feed under 0.2 mm/t.)
Note 5) Excellent finished surface can be obtained with one wiper insert.
Note 6) When the feed per revolution is larger than the width of the wiper edge, install 2 or more wiper inserts equally inside the cutting body.

RECOMMENDED CUTTING CONDITIONS WHEN USING A WIPER INSERT

Work Material	Grade	Recommended Cutting Speed (m/min)
P	VP25N	200 (80–250)
	VP15TF	180 (80–250)
M	VP15TF	120–270
K	MC5020	130–250
	VP15TF	
	MB710	
S	VP15TF	20–50
H	VP15TF	40–80
N	MD220	650 (300–1000)

●Recommended depth of cut (ap) is 0.2mm-0.5mm and feed per tooth (fz) is up to 0.2mm/t.

● : Inventory maintained in Japan.
(CBN and PCD wiper inserts are available in 1 piece in one case)

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Finish—Light Cutting		Light—Rough Cutting		Medium—Heavy Cutting	
					Feed per Tooth (mm/t.)	Breaker	Feed per Tooth (mm/t.)	Breaker	Feed per Tooth (mm/t.)	Breaker
P	Mild Steel	≤180HB	**F7030**	280 (210—350)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6120 VP15TF	250 (200—300)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6130	240 (190—290)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			VP30RT	230 (180—280)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			NX4545	180 (130—230)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	—	—
	Carbon Steel Alloy Steel	180—280HB	**F7030**	250 (200—300)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6120 VP15TF	220 (170—270)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6130	200 (150—230)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			VP30RT	150 (120—180)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			NX4545	150 (120—180)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	—	—
		280—350HB	**F7030**	180 (130—230)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6120 VP15TF	140 (100—180)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP6130	120 (90—150)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			VP30RT	100 (80—160)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			NX4545	100 (80—160)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	—	—
M	Stainless Steel	≤270HB	**MP7130 VP15TF**	220 (170—270)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP7140 VP30RT	200 (150—250)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			NX4545	150 (120—180)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	—	—
K	Cast Iron Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	200 (150—250)	—	—	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH FT**
			VP15TF	180 (130—250)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
		Tensile Strength ≥450MPa	**MC5020**	110 (80—150)	—	—	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH FT**
N	Aluminium Alloy	—	**HTi10**	650 (300—1000)	0.15 (0.1—0.2)	**JP**	0.2 (0.1—0.3)	**JP**	0.3 (0.2—0.4)	**JP**
S	Titanium Alloy	—	**MP9120 VP15TF**	50 (40—60)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP9130	45 (30—55)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
	Heat Resistant Alloy (Inconel718 etc.)	—	**MP9120 VP15TF**	40 (20—50)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
			MP9130	35 (15—45)	0.15 (0.1—0.2)	**JL**	0.2 (0.1—0.3)	**JM**	0.3 (0.2—0.4)	**JH**
H	Hardened Steel	40—55HRC	**VP15TF**	80 (60—100)	0.1 (0.05—0.15)	**JL**	0.15 (0.1—0.2)	**JM**	0.2 (0.1—0.3)	**JH**

●Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC) ●Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

FACE MILLING
<GENERAL CUTTING>

AHX440S/475S/640S

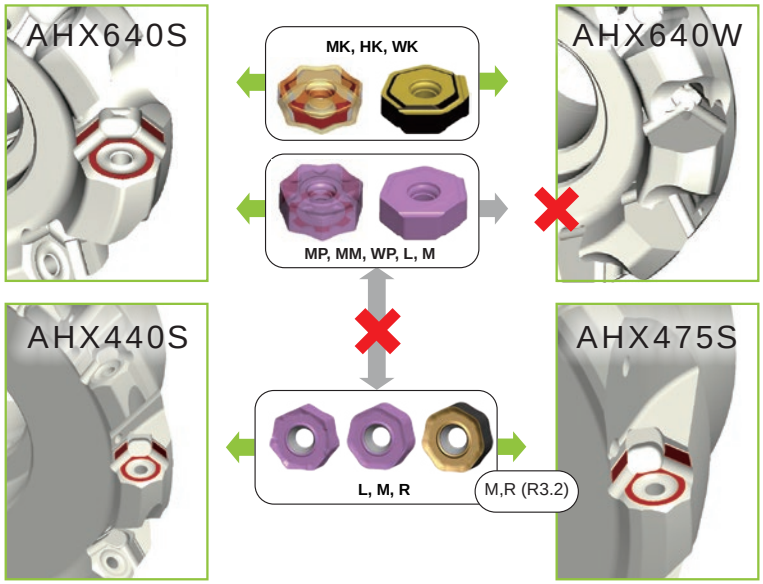
Selection Reference Table (Cutting Edge Count and Cutting Conditions)

DC	Type	Number of Teeth	AHX440S			AHX475S			AHX640S		
			General Cutting			High Feed Machining			General Cutting		
			Stock	fr (mm/rev)	APMX	Stock	fr (mm/rev)	APMX	Stock	fr (mm/rev)	APMX
40	Fine Pitch	3	●	0.6—1.2	3						
	Extra Fine Pitch	4	●	0.8—1.6	3						
50	Fine Pitch	4	●	0.8—1.6	3	●	2.4—4.0	1.6			
	Extra Fine Pitch	5	●	1.0—2.0	3	●	3.0—5.0	1.6			
	Super Extra Fine Pitch	6	●	1.2—2.4	3						
63	Coarse Pitch	4							●	0.8—1.6	6
	Fine Pitch	5	●	1.0—2.0	3	●	3.0—5.0	1.6	●	1.0—2.0	6
	Extra Fine Pitch	6	●	1.2—2.4	3	●	3.6—6.0	1.6			
	Super Extra Fine Pitch	8	●	1.6—3.2	3						
80	Coarse Pitch	4							●	0.8—1.6	6
	Fine Pitch	6	●	1.2—2.4	3	●	3.6—6.0	1.6	●	1.2—2.4	6
	Extra Fine Pitch	8	●	1.6—3.2	3	●	4.8—8.0	1.6			
	Super Extra Fine Pitch	10	●	2.0—4.0	3						
100	Coarse Pitch	5							●	1.0—2.0	6
	Fine Pitch	7	●	1.4—2.8	3	●	4.2—7.0	1.6	●	1.4—2.8	6
	Extra Fine Pitch	9				●	5.4—9.0	1.6			
		10	●	2.0—4.0	3						
	Super Extra Fine Pitch	12	●	2.4—4.8	3						
125	Coarse Pitch	6							●	1.2—2.4	6
	Fine Pitch	8	●	1.6—3.2	3	●	4.8—8.0	1.6	●	1.6—3.2	6
	Extra Fine Pitch	10				●	6.0—10.0	1.6			
		12	●	2.4—4.8	3						
	Super Extra Fine Pitch	14	●	2.8—5.6	3						
160	Coarse Pitch	7							●	1.4—2.8	6
	Fine Pitch	10	●	2.0—4.0	3	●	6.0—10.0	1.6	●	2.0—4.0	6
	Extra Fine Pitch	12				●	7.2—12.0	1.6			
		14	●	2.8—5.6	3						
	Super Extra Fine Pitch	16	●	3.2—6.4	3						
200	Coarse Pitch	8							●	1.6—3.2	6
	Fine Pitch	12							●	2.4—4.8	6

Note 1) fr : Feed rate per revolution (AHX475S : the feed rate per cutter (fz) will be limited by the cutting width ae. Please refer to page M045 for details.)
Note 2) APMX : Maximum depths of cut (AHX440S : the maximum depths of cut will vary depending on the breaker)
Note 3) The depths of cut and feed rate are identical to the recommended conditions for carbon steel and alloy steel.

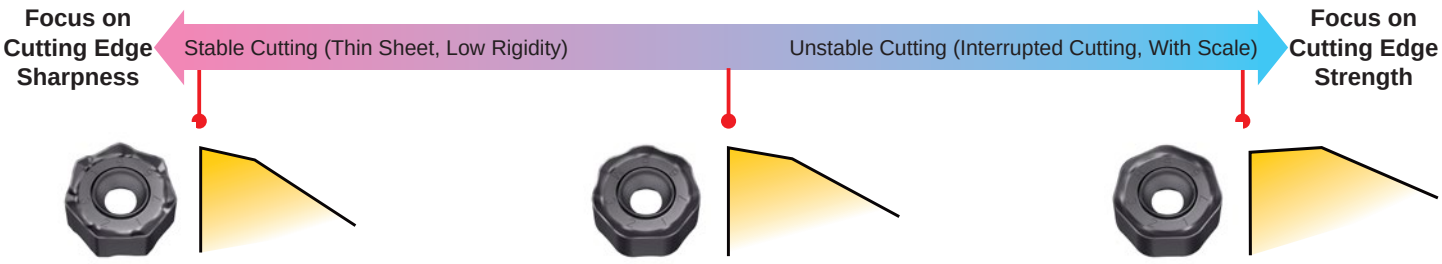
Compatibility with Inserts for AHX Series

The RE = 3.2 mm insert for use with AHX440S can be mounted on AHX475S.
All inserts for use with AHX640 can be mounted on AHX640S (note, however, that the set height will differ).
The inserts for mounting on AHX640W are the MK, HK, and WK breakers for casting.



Breaker System

Breaker Series for Varied Cutting Conditions



L Breaker
Focus on cutting edge sharpness
Low resistance type

M Breaker
1st Recommendation
All-around

R Breaker
Focused on fracture resistance
Reinforced edge type

Work Material	Cutting Conditions		
	Stable Cutting	General Cutting	Unstable Cutting
P	AHX440S: L (With Wiper); M (R0.8) (With Wiper); M (R3.2) (Shared with AHX475); R (Shared with AHX475)		
	AHX640S: M; MP		
M	AHX440S: L (With Wiper); M (R0.8) (With Wiper); M (R3.2); R		
	AHX640S: MM		
K	AHX440S: L (With Wiper); M (R0.8) (With Wiper); M (R3.2) (Shared with AHX475); R (Shared with AHX475)		
	AHX640S: MK; HK		

Wiper Insert of AHX640S

Based on the number of inserts and the cutting conditions, use of wiper inserts can improve overall surface finishes.

P — WP + combination with MP
Right-hand 2 corners, left-hand 2 corners.

K — WK + combination with MK
Right-hand 2 corners, left-hand 2 corners.

FACE MILLING
<GENERAL CUTTING>

TOOL NEWS

50° KAPR

AHX440S

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel

Fig. 1
ø40
ø50
ø63
ø80

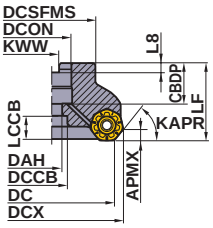


Fig. 2
ø100
ø125
ø160

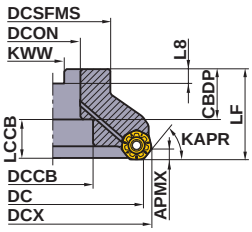
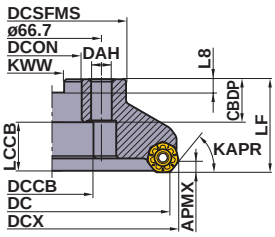


Fig. 3
ø160



KAPR :50°
GAMP:-6° GAMF:-7°
DCON=Inch size

Right hand tool holder only.

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
40	**AHX440S-040A03AR**	●	○	3	40	48.4	16	1	0.3	3
	AHX440S-040A04AR	●	○	4	40	48.4	16	1	0.2	3
50	**AHX440S-050A04AR**	●	○	4	40	58.4	22	1	0.4	3
	AHX440S-050A05AR	●	○	5	40	58.4	22	1	0.4	3
	AHX440S-050A06AR	●	○	6	40	58.4	22	1	0.4	3
63	**AHX440S-063A05AR**	●	○	5	40	71.4	22	1	0.6	3
	AHX440S-063A06AR	●	○	6	40	71.4	22	1	0.6	3
	AHX440S-063A08AR	●	○	8	40	71.4	22	1	0.5	3
80	**AHX440SR08006CA**	●	○	6	50	88.4	25.4	1	1.1	3
	AHX440SR08008CA	●	○	8	50	88.4	25.4	1	1.1	3
	AHX440SR08010CA	●	○	10	50	88.4	25.4	1	1.1	3
100	**AHX440SR10007DA**	●	○	7	50	108.4	31.75	2	1.6	3
	AHX440SR10010DA	●	○	10	50	108.4	31.75	2	1.6	3
	AHX440SR10012DA	●	○	12	50	108.3	31.75	2	1.6	3
125	**AHX440SR12508EA**	●	○	8	63	133.4	38.1	2	3.0	3
	AHX440SR12512EA	●	○	12	63	133.4	38.1	2	3.0	3
	AHX440SR12514EA	●	○	14	63	133.3	38.1	2	2.9	3
160	**AHX440SR16010FA**	●	○	10	63	168.4	50.8	2	4.8	3
	AHX440SR16014FA	●	○	14	63	168.4	50.8	2	4.6	3
	AHX440SR16016FA	●	○	16	63	168.4	50.8	2	4.7	3

Note 1) The cutter body does not have a set bolt for an arbor.
Note 2) The above "APMX" will vary depending on the breaker insert.

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench (Insert)
AHX440S	TS35R	TKY15T

* Clamp Torque (N • m) : TS35R=3.5

● : **Inventory maintained in Japan.**

Metric Standard

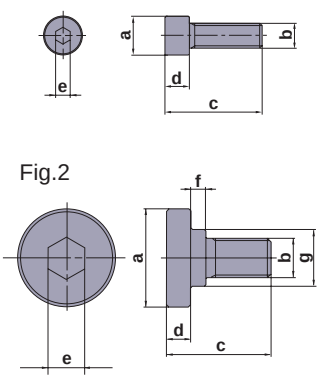
KAPR : 50°
GAMP : -6° GAMF : -7°
DCON = mm size

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
40	**AHX440S-040A03AR**	●	○	3	40	48.4	16	1	0.3	3
	AHX440S-040A04AR	●	○	4	40	48.4	16	1	0.2	3
50	**AHX440S-050A04AR**	●	○	4	40	58.4	22	1	0.4	3
	AHX440S-050A05AR	●	○	5	40	58.4	22	1	0.4	3
	AHX440S-050A06AR	●	○	6	40	58.4	22	1	0.4	3
63	**AHX440S-063A05AR**	●	○	5	40	71.4	22	1	0.6	3
	AHX440S-063A06AR	●	○	6	40	71.4	22	1	0.6	3
	AHX440S-063A08AR	●	○	8	40	71.4	22	1	0.5	3
80	**AHX440S-080A06AR**	●	○	6	50	88.4	27	1	1.1	3
	AHX440S-080A08AR	●	○	8	50	88.4	27	1	1.1	3
	AHX440S-080A10AR	●	○	10	50	88.4	27	1	1.1	3
100	**AHX440S-100B07AR**	●	○	7	50	108.4	32	2	1.6	3
	AHX440S-100B10AR	●	○	10	50	108.4	32	2	1.6	3
	AHX440S-100B12AR	●	○	12	50	108.3	32	2	1.6	3
125	**AHX440S-125B08AR**	●	○	8	63	133.4	40	2	3.0	3
	AHX440S-125B12AR	●	○	12	63	133.4	40	2	3.0	3
	AHX440S-125B14AR	●	○	14	63	133.3	40	2	2.9	3
160	**AHX440S-160C10NR**	●	–	10	63	168.4	40	3	4.8	3
	AHX440S-160C14NR	●	–	14	63	168.4	40	3	4.6	3
	AHX440S-160C16NR	●	–	16	63	168.4	40	3	4.7	3

Note 1) The cutter body does not have a set bolt for an arbor.Please refer to the table below,when ordering.
Note 2) The above "APMX" will vary depending on the breaker insert.

SET BOLT (SOLD SEPARATELY)

Tool Holder Number	Set Bolt: With Coolant Hole Order Number	Set Bolt: Without Coolant Hole Order Number	Fig.	Reference Dimensions (mm) a	b	c	d	e	f	g	Geometry
AHX440S-040A○○AR	HSC08025H	HSC08040	1	13	M8×1.25	33	8	5	–	–	Fig.1
AHX440S-050A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
AHX440S-063A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–	
AHX440S-080A○○AR	HSC12035H	HSC12035 (HSC12045)	1	18	M12×1.75	47 57	12	10	–	–	
AHX440S-100B○○AR	MBA16033H	–	2	40	M16×2	43	10	14	6	23	Fig.2
AHX440S-125B○○AR	MBA20040H	–	2	50	M20×2.5	54	14	17	6	27	
AHX440S-160C○○NR	No coolant hole	–	2	50	M20×2.5	54	14	17	6	27	
AHX440SR080○○CA	HSC12035H	HSC12035 HSC12045	1	18	M12×1.75	47 57	12	10	–	–	
AHX440SR100○○DA	MBA16033H	–	2	40	M16×2	43	10	14	6	23	
AHX440SR125○○EA	MBA20040H	–	2	50	M20×2.5	54	14	17	6	27	
AHX440SR160○○FA	MBA24045H	–	2	65	M24×3	59	14	17	10	37	



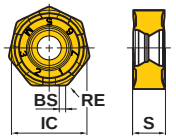
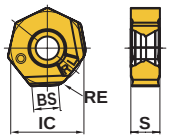
Note 1) Internal coolant is necessary with the set bolt.

MOUNTING DIMENSION ➤ M052
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

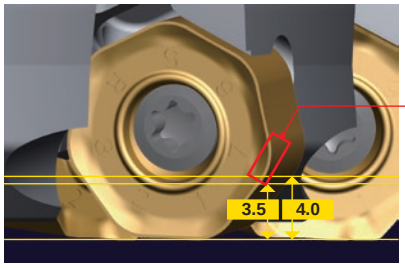
INSERTS

Work Material			MP6120	MP6130	MP7130	MP7140	MC5020	VP15TF
P	Steel		◐	✠				◐
M	Stainless Steel				◐	✠		◐
K	Cast Iron						◐	◐
H	Hardened Steel							◐

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing :
E : Round

Application	Shape	Order Number	Class	Honing	MP6120	MP6130	MP7130	MP7140	MC5020	VP15TF	IC	RE	BS	S	APMX	Geometry
					Coated						Dimensions (mm)					
Stable Cutting		**NNMU130508ZER-L**	M	E	●	●	●	●	●	●	13.4	0.8	1	5.77	3	
General Cutting		**NNMU130508ZEN-M**	M	E	●	●	●	●	●	●	13.4	0.8	1	5.57	⁎4	
		NNMU130532ZEN-M	M	E	●	●	●	●	●	●	13.4	3.2	—	5.57	⁎4	
Unstable Cutting		**NNMU130532ZEN-R**	M	E	●	●	●	●	●	●	13.4	3.2	—	5.47	⁎4	
Finish Cutting	Wiper	**WNEU1305ZEN4C-M**	E	E	●				●	●	13.4	2.7	4	5.1	0.5	

⁎ When not using the Wiper, APMX = 3.5mm



Corner R on Opposite Side

If using corner R on the opposite side, APMX = 4.0 mm
If not using the opposite corner, APMX = 3.5 mm

■Instructions for Use of Wiper Iinserts

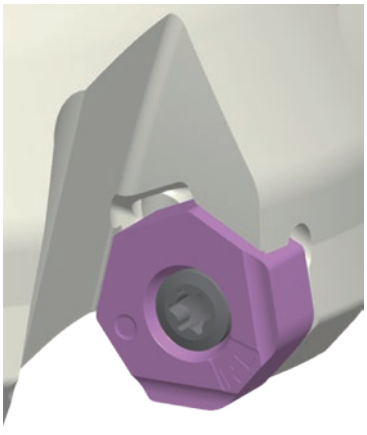


Fig.1

Fig.2

Note 1) The specifications for these wipers are right hand body 2 corners and left hand body 2 corners. Refer to Figure 1.
Note 2) Satisfactory finish surface can be achieved with one wiper insert.
However, if the feed rate per revolution will be equal to or greater than the width of the wiper edge, it is recommended to install the second and further wiper inserts spaced evenly within the cutting body.

● : Inventory maintained in Japan. (10 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

■ Dry Cutting

	Work Material	Hardness	Grade	vc (m/min)	fz (mm/t.)	ap (mm)
P	Mild Steel	≤180HB	**MP6120,VP15TF**	250(200－300)	0.3(0.2－0.4)	≤3
			MP6130	240(190－290)	0.3(0.2－0.4)	≤3
	Carbon Steel,Alloy Steel	180－280HB	**MP6120,VP15TF**	220(170－270)	0.3(0.2－0.4)	≤3
			MP6130	200(150－250)	0.3(0.2－0.4)	≤3
	Carbon Steel,Alloy Steel	280－350HB	**MP6120,VP15TF**	140(100－180)	0.3(0.2－0.4)	≤3
			MP6130	120(90－150)	0.3(0.2－0.4)	≤3
	Alloy Tool Steel	≤350HB (Annealing)	**MP6120,VP15TF**	140(100－180)	0.15(0.1－0.2)	≤1
			MP6130	120(90－150)	0.15(0.1－0.2)	≤1
	Pre-hardened Steel	35－45HRC	**MP6120,VP15TF**	140(100－180)	0.15(0.1－0.2)	≤1
			MP6130	120(90－150)	0.15(0.1－0.2)	≤1
M	Austenitic Stainless Steel	≤200HB	**MP7130,VP15TF**	200(150－250)	0.2(0.1－0.3)	≤3
			MP7140	180(120－230)	0.2(0.1－0.3)	≤3
		> 200HB	**MP7130,VP15TF**	150(100－200)	0.2(0.1－0.3)	≤3
			MP7140	130(80－180)	0.2(0.1－0.3)	≤3
	Ferritic and Maltensitic Stainless Steel	≤200HB	**MP7130,VP15TF**	200(150－250)	0.2(0.1－0.3)	≤3
			MP7140	180(120－230)	0.2(0.1－0.3)	≤3
		> 200HB	**MP7130,VP15TF**	150(100－200)	0.2(0.1－0.3)	≤3
			MP7140	130(80－180)	0.2(0.1－0.3)	≤3
	Two-phase Stainless Steel	≤280HB	**MP7130,VP15TF**	140(100－180)	0.15(0.05－0.25)	≤3
			MP7140	120(80－160)	0.15(0.05－0.25)	≤3
	Precipitation Hardening Stainless Steel	< 450HB	**MP7130,VP15TF**	130(100－160)	0.15(0.05－0.25)	≤3
			MP7140	110(80－140)	0.15(0.05－0.25)	≤3
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MC5020**	220(150－300)	0.3(0.2－0.4)	≤3
			VP15TF	180(130－230)	0.3(0.2－0.4)	≤3
	Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	200(150－250)	0.2(0.1－0.3)	≤3
			VP15TF	170(120－220)	0.2(0.1－0.3)	≤3
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MC5020**	170(150－200)	0.2(0.1－0.3)	≤3
			VP15TF	140(100－180)	0.2(0.1－0.3)	≤3
H	Hardened Steel	40－55HRC	**VP15TF**	80(60－100)	0.15(0.1－0.2)	≤1

■ Wet Cutting

	Work Material	Hardness	Grade	vc (m/min)	fz (mm/t.)	ap (mm)
M	Austenitic Stainless Steel	≤200HB	**MP7130,VP15TF**	125(100－150)	0.15(0.1–0.2)	≤3
			MP7140	100(80－140)	0.15(0.1–0.2)	≤3
		> 200HB	**MP7130,VP15TF**	100(75－125)	0.15(0.1–0.2)	≤3
			MP7140	80(55－105)	0.15(0.1–0.2)	≤3
	Ferritic and Maltensitic Stainless Steel	≤200HB	**MP7130,VP15TF**	125(100－150)	0.15(0.1–0.2)	≤3
			MP7140	100(80－140)	0.15(0.1–0.2)	≤3
		> 200HB	**MP7130,VP15TF**	100(75－125)	0.15(0.1–0.2)	≤3
			MP7140	80(55－105)	0.15(0.1–0.2)	≤3
	Two-phase Stainless Steel	≤280HB	**MP7130,VP15TF**	80(60－100)	0.1(0.05–0.15)	≤3
			MP7140	60(40－80)	0.1(0.05–0.15)	≤3
	Precipitation Hardening Stainless Steel	< 450HB	**MP7130,VP15TF**	70(50－90)	0.1(0.05–0.15)	≤3
			MP7140	50(30－70)	0.1(0.05–0.15)	≤3

RECOMMENDED CUTTING CONDITIONS

■Cutting Conditions with Wiper Insert

	Work Material	Hardness	Grade	vc (m/min)	fz (mm/t.)	ap (mm)
P	Mild Steel	≤180HB	**MP6120,VP15TF**	250(200−300)	0.3(0.2−0.4)	≤0.5
	Carbon Steel,Alloy Steel	180−280HB	**MP6120,VP15TF**	220(170−270)	0.3(0.2−0.4)	≤0.5
		280−350HB	**MP6120,VP15TF**	140(100−180)	0.3(0.2−0.4)	≤0.5
	Alloy Tool Steel	≤350HB (Annealing)	**MP6120,VP15TF**	140(100−180)	0.15(0.1−0.2)	≤0.5
	Pre-hardened Steel	35−45HRC	**MP6120,VP15TF**	140(100−180)	0.15(0.1−0.2)	≤0.5
M	Austenitic Stainless Steel	≤200HB	**VP15TF**	125(100−150)	0.15(0.1−0.2)	≤0.5
		> 200HB	**VP15TF**	100(75−125)	0.15(0.1−0.2)	≤0.5
	Ferritic and Maltensitic Stainless Steel	≤200HB	**VP15TF**	125(100−150)	0.15(0.1−0.2)	≤0.5
		> 200HB	**VP15TF**	100(75−125)	0.15(0.1−0.2)	≤0.5
	Two-phase Stainless Steel	≤280HB	**VP15TF**	80(60−100)	0.1(0.05−0.15)	≤0.5
	Precipitation Hardening Stainless Steel	< 450HB	**VP15TF**	70(50−90)	0.1(0.05−0.15)	≤0.5
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MC5020**	320(250−400)	0.3(0.2−0.4)	≤0.5
			VP15TF	220(150−300)	0.3(0.2−0.4)	≤0.5
	Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	250(200−300)	0.2(0.1−0.3)	≤0.5
			VP15TF	200(150−250)	0.2(0.1−0.3)	≤0.5
		Tensile Strength ≤800MPa	**MC5020**	220(200−250)	0.2(0.1−0.3)	≤0.5
			VP15TF	170(150−200)	0.2(0.1−0.3)	≤0.5
H	Hardened Steel	40−55HRC	**VP15TF**	80(60−100)	0.15(0.1−0.2)	≤0.5

Note 1) Refer to the above table and set up cutting conditions according to cutting applications.
Note 2) When placing emphasis on surface finish quality, wet cutting is recommended. (tool life is lowered as compared to dry cutting)
Note 3) The recommended depth of cut differs according to insert geometry.
Note 4) When clamp rigidity is low and tool overhang is long, we recommended to reduce the cutting speed and the feed rate by 70-80%.
Note 5) Recommended wet cutting for good surface finishing of stainless steel. (Tool life is short compared to wet cutting.)

FACE MILLING
<HIGH FEED CUTTING>

TOOL NEWS

15° KAPR

AHX475S

P	M	K	N	S	H
Steel		Cast Iron			Hardened Steel

Fig.1

ø50
ø63
ø80
ø100

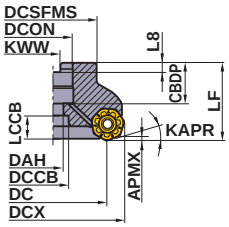
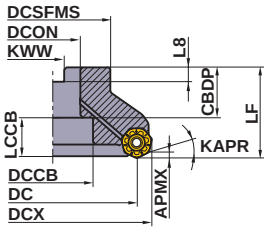


Fig.2

ø125
ø160



Right hand tool holder only.

KAPR :15°
GAMP:-6° GAMF:-10°
DCON=Inch size

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
50	AHX475S-050A04AR	●	○	4	50	65.7	22	1	0.6	1.6
	AHX475S-050A05AR	●	○	5	50	65.7	22	1	0.6	1.6
63	AHX475S-063A05AR	●	○	5	50	78.7	22	1	1.0	1.6
	AHX475S-063A06AR	●	○	6	50	78.7	22	1	1.0	1.6
80	AHX475SR08006DA	●	○	6	63	95.6	31.75	1	2.0	1.6
	AHX475SR08008DA	●	○	8	63	95.6	31.75	1	2.0	1.6
100	AHX475SR10007DA	●	○	7	63	115.6	31.75	1	3.2	1.6
	AHX475SR10009DA	●	○	9	63	115.6	31.75	1	3.2	1.6
125	AHX475SR12508EA	●	○	8	63	140.6	38.1	2	4.0	1.6
	AHX475SR12510EA	●	○	10	63	140.6	38.1	2	4.0	1.6
160	AHX475SR16010FA	●	○	10	63	175.6	50.8	2	5.5	1.6
	AHX475SR16012FA	●	○	12	63	175.6	50.8	2	5.5	1.6

Note 1) The cutter body does not have a set bolt for an arbor.

Metric Standard

KAPR :15°
GAMP:-6° GAMF:-10°
DCON=mm size

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
50	AHX475S-050A04AR	●	○	4	50	65.7	22	1	0.6	1.6
	AHX475S-050A05AR	●	○	5	50	65.7	22	1	0.6	1.6
63	AHX475S-063A05AR	●	○	5	50	78.7	22	1	1.0	1.6
	AHX475S-063A06AR	●	○	6	50	78.7	22	1	1.0	1.6
80	AHX475S-080A06AR	●	○	6	50	95.6	27	1	1.6	1.6
	AHX475S-080A08AR	●	○	8	50	95.6	27	1	1.6	1.6
100	AHX475S-100A07AR	●	○	7	63	115.6	32	1	3.3	1.6
	AHX475S-100A09AR	●	○	9	63	115.6	32	1	3.3	1.6
125	AHX475S-125B08AR	●	○	8	63	140.6	40	2	4.0	1.6
	AHX475S-125B10AR	●	○	10	63	140.6	40	2	4.0	1.6
160	AHX475S-160B10AR	●	○	10	63	175.6	40	2	6.0	1.6
	AHX475S-160B12AR	●	○	12	63	175.6	40	2	6.0	1.6

Note 1) The cutter body does not have a set bolt for an arbor.

● : Inventory maintained in Japan.

MOUNTING DIMENSION ➤ M052
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench (Insert)
AHX475S	TS35R	TKY15T

* Clamp Torque (N • m) : TS35R=3.5

SET BOLT (SOLD SEPARATELY)

Tool Holder Number	Set Bolt: With Coolant Hole Order Number	Set Bolt: Without Coolant Hole Order Number	Fig.	Reference Dimensions (mm) a	b	c	d	e	f	g
AHX475S-050A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–
AHX475S-063A○○AR	HSC10030H	HSC10035	1	16	M10×1.5	40	10	6	–	–
AHX475S-080A○○AR	HSC12035H	HSC12035 (HSC12045)	1	18	M12×1.75	47 57	12	10	–	–
AHX475S-100B○○AR	HSC16040H	–	1	24	M16×2	56	16	14	–	–
AHX475S-125B○○AR	MBA20040H	–	2	50	M20×2.5	54	14	17	6	27
AHX475S-160C○○AR	MBA20040H	–	2	50	M20×2.5	54	14	17	6	27
AHX475SR080○○DA	HSC16040H	–	1	24	M16×2	56	16	14	–	–
AHX475SR100○○DA	HSC16040H	–	1	24	M16×2	56	16	14	–	–
AHX475SR125○○EA	MBA20040H	–	2	50	M20×2.5	54	14	17	6	27
AHX475SR160○○FA	MBA24045H	–	2	65	M24×3	59	14	17	10	37

Geometry

Fig.1

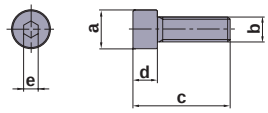
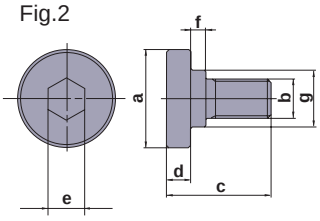


Fig.2

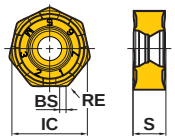


Note 1) Internal coolant is necessary with the set bolt.

INSERTS

Work Material		
P	Steel	
K	Cast Iron	
H	Hardened Steel	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting
Honing : E : Round

Application	Shape	Order Number	Class	Honing	Coated MP6120	MP6130	MC5020	VP15TF			Dimensions (mm) IC	RE	BS	S	APMX	Geometry
General Cutting		**NNMU130532ZEN-M**	M	E	●	●	●	●			13.4	3.2	–	5.57	1.6	
Unstable Cutting		**NNMU130532ZEN-R**	M	E	●	●	●	●			13.4	3.2	–	5.47	1.6	

● : **Inventory maintained in Japan. (10 inserts in one case)**

RECOMMENDED CUTTING CONDITIONS

■ Dry Cutting

	Work Material	Hardness	Grade	Breaker	vc (m/min)	fz (mm/t.)	ap (mm)	ae (mm)
P	Mild Steel	≤180HB	**MP6120**	**R**	150(100−200)	0.6	≤1.6	≤0.5DC
			MP6120	**R**	150(100−200)	0.8	≤1.6	0.5−0.8DC
			MP6120	**M**	150(100−200)	1	≤1.6	0.8−1DC
			MP6130	**R**	130(80−180)	0.6	≤1.6	≤0.5DC
			MP6130	**R**	130(80−180)	0.8	≤1.6	0.5−0.8DC
			MP6130	**M**	130(80−180)	1	≤1.6	0.8−1DC
	Carbon Steel,Alloy Steel	180−280HB	**MP6120**	**R**	130(80−180)	0.6	≤1.6	≤0.5DC
			MP6120	**R**	130(80−180)	0.8	≤1.6	0.5−0.8DC
			MP6120	**M**	130(80−180)	1	≤1.6	0.8−1DC
			MP6130	**R**	110(60−160)	0.6	≤1.6	≤0.5DC
			MP6130	**R**	110(60−160)	0.8	≤1.6	0.5−0.8DC
			MP6130	**M**	110(60−160)	1	≤1.6	0.8−1DC
	Carbon Steel,Alloy Steel	280−350HB	**MP6120**	**R**	100(50−150)	0.5	≤1.6	≤0.5DC
			MP6120	**R**	100(50−150)	0.6	≤1.6	0.5−0.8DC
			MP6120	**R**	100(50−150)	0.7	≤1.6	0.8−1DC
			MP6130	**R**	80(30−130)	0.5	≤1.6	≤0.5DC
			MP6130	**R**	80(30−130)	0.6	≤1.6	0.5−0.8DC
			MP6130	**R**	80(30−130)	0.7	≤1.6	0.8−1DC
	Alloy Tool Steel	≤350HB (Annealing)	**MP6120**	**R**	100(50−150)	0.5	≤1.6	≤0.5DC
			MP6120	**R**	100(50−150)	0.6	≤1.6	0.5−0.8DC
			MP6120	**R**	100(50−150)	0.7	≤1.6	0.8−1DC
			MP6130	**R**	80(30−120)	0.5	≤1.6	≤0.5DC
			MP6130	**R**	80(30−120)	0.6	≤1.6	0.5−0.8DC
			MP6130	**R**	80(30−120)	0.7	≤1.6	0.8−1DC
	Pre-hardened Steel	35−45HRC	**MP6120**	**R**	100(70−130)	0.5	≤1.6	≤0.5DC
			MP6120	**R**	100(70−130)	0.6	≤1.6	0.5−0.8DC
			MP6120	**R**	100(70−130)	0.7	≤1.6	0.8−1DC
			MP6130	**R**	80(50−110)	0.5	≤1.6	≤0.5DC
			MP6130	**R**	80(50−110)	0.6	≤1.6	0.5−0.8DC
			MP6130	**R**	80(50−110)	0.7	≤1.6	0.8−1DC
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MC5020**	**R**	150(100−200)	0.6	≤1.6	≤0.5DC
			MC5020	**R**	150(100−200)	0.8	≤1.6	0.5−0.8DC
			MC5020	**M**	150(100−200)	1	≤1.6	0.8−1DC
			VP15TF	**M**	120(80−160)	0.6	≤1.6	≤0.5DC
			VP15TF	**M**	120(80−160)	0.8	≤1.6	0.5−0.8DC
			VP15TF	**M**	120(80−160)	1	≤1.6	0.8−1DC
	Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	**R**	150(100−200)	0.6	≤1.6	≤0.5DC
			MC5020	**R**	150(100−200)	0.8	≤1.6	0.5−0.8DC
			MC5020	**M**	150(100−200)	1	≤1.6	0.8−1DC
			VP15TF	**R**	120(80−160)	0.6	≤1.6	≤0.5DC
			VP15TF	**R**	120(80−160)	0.8	≤1.6	0.5−0.8DC
			VP15TF	**M**	120(80−160)	1	≤1.6	0.8−1DC
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MC5020**	**R**	150(100−200)	0.5	≤1.6	≤0.5DC
			MC5020	**R**	150(100−200)	0.6	≤1.6	0.5−0.8DC
			MC5020	**R**	150(100−200)	0.7	≤1.6	0.8−1DC
			VP15TF	**R**	120(80−160)	0.5	≤1.6	≤0.5DC
			VP15TF	**R**	120(80−160)	0.6	≤1.6	0.5−0.8DC
			VP15TF	**R**	120(80−160)	0.7	≤1.6	0.8−1DC
H	Hardened Steel	40−55HRC	**VP15TF**	**R**	70(50−90)	0.4	≤1.6	≤0.5DC
			VP15TF	**R**	70(50−90)	0.5	≤1.6	0.5−0.8DC
			VP15TF	**R**	70(50−90)	0.6	≤1.6	0.8−1DC

Note 1) When clamp rigidity is low and tool overhang is long, we recommended to reduce the cutting speed and the feed rate by 70-80%.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

FACE MILLING
<GENERAL CUTTING>

TOOL NEWS

50° KAPR

F R

AHX640S

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	Hardened Steel

Fig. 1
ø63
ø80

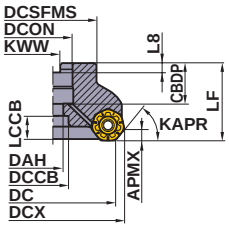


Fig. 2
ø100
ø125
ø160

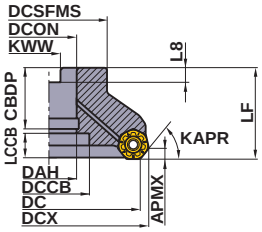
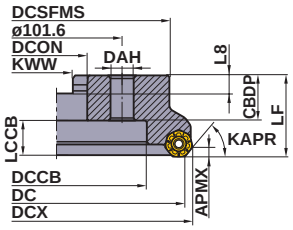
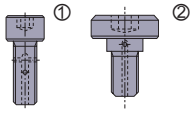


Fig. 3
ø200



Right hand tool holder only.

DC	Set Bolt	Geometry
ϕ63	HSC10030H	①
ϕ80	HSC12035H	①
ϕ100	MBA16033H	②
ϕ125	MBA20040H	②
ϕ160	MBA24045H	②
ϕ200	—	—



KAPR :50°
GAMP:-6° GAMF:-5°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
63	**AHX640S-063A04AR**	●	○	4	50	75.55	22	1	0.7	6
	AHX640S-063A05AR	●	○	5	50	75.55	22	1	0.6	6
80	**AHX640SR08004CA**	●	○	4	50	92.55	25.4	1	1.1	6
	AHX640SR08006CA	●	○	6	50	92.55	25.4	1	1.0	6
100	**AHX640SR10005DA**	●	○	5	50	112.55	31.75	2	1.7	6
	AHX640SR10007DA	●	○	7	50	112.55	31.75	2	1.5	6
125	**AHX640SR12506EA**	●	○	6	63	137.55	38.1	2	3.0	6
	AHX640SR12508EA	●	○	8	63	137.55	38.1	2	2.9	6
160	**AHX640SR16007FA**	●	○	7	63	172.55	50.8	2	4.9	6
	AHX640SR16010FA	●	○	10	63	172.55	50.8	2	4.7	6
200	**AHX640SR20008KN**	●	–	8	63	212.55	47.625	3	8.2	6
	AHX640SR20012KN	●	–	12	63	212.55	47.625	3	7.9	6

● : Inventory maintained in Japan.

Fig. 1
ø63
ø80

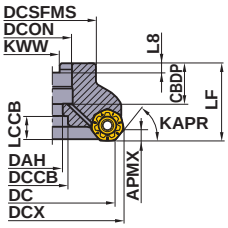


Fig. 2
ø100
ø125

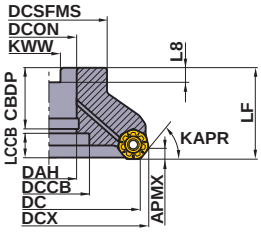


Fig. 3
ø160

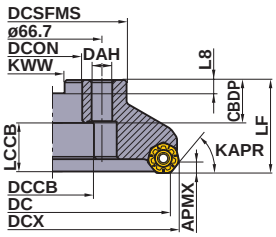
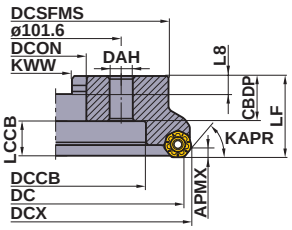
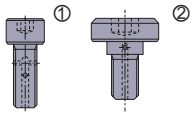


Fig. 4
ø200



Right hand tool holder only.

DC	Set Bolt	Geometry
ϕ63	HSC10030H	①
ϕ80	HSC12035H	
ϕ100	MBA16033H	②
ϕ125	MBA20040H	
ϕ160	–	–
ϕ200	–	–



Metric Standard

KAPR :50°
GAMP:-6° GAMF:-5°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
63	**AHX640S-063A04AR**	●	○	4	50	75.55	22	1	0.7	6
	AHX640S-063A05AR	●	○	5	50	75.55	22	1	0.6	6
80	**AHX640S-080A04AR**	●	○	4	50	92.55	27	1	1.1	6
	AHX640S-080A06AR	●	○	6	50	92.55	27	1	1.0	6
100	**AHX640S-100B05AR**	●	○	5	50	112.55	32	2	1.7	6
	AHX640S-100B07AR	●	○	7	50	112.55	32	2	1.6	6
125	**AHX640S-125B06AR**	●	○	6	63	137.55	40	2	3.1	6
	AHX640S-125B08AR	●	○	8	63	137.55	40	2	3.0	6
160	**AHX640S-160C07NR**	●	–	7	63	172.55	40	3	5.4	6
	AHX640S-160C10NR	●	–	10	63	172.55	40	3	5.2	6
200	**AHX640S-200C08NR**	●	–	8	63	212.55	60	4	7.8	6
	AHX640S-200C12NR	●	–	12	63	212.55	60	4	7.5	6

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench (Insert)
AHX640S	CS5015060T	TKY20T

* Clamp Torque (N • m) : CS5015060T=5.0

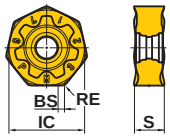
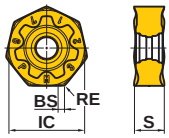
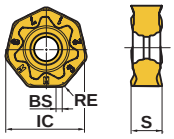
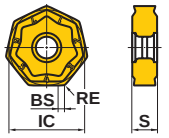
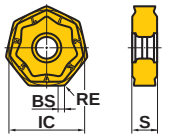
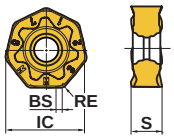
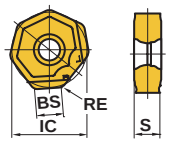
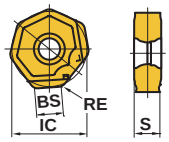
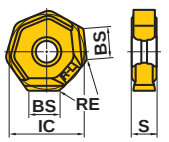
MOUNTING DIMENSION ➤ M052
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

Work Material		MP6120	MP6130	MP7030	MP9120	MP9130	MC5020	VP15TF	VP20RT
P	Steel	◐	✠					◐	◐
M	Stainless Steel			◔				◔	◔
K	Cast Iron						◐	✠	✠
N	Non-ferrous Metal								
S	Heat-resistant Alloy, Titanium Alloy				◐	✠		◐	◐
H	Hardened Steel							◔	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round

Application	Shape	Order Number	Class	Honing	MP6120	MP6130	MP7030	MP9120	MP9130	MC5020	VP15TF	VP20RT	IC	RE	BS	S	APMX	Geometry
For Steel General Cutting		**NNMU200708ZEN-M**	M	E	●	●							20	0.8	1	8	6	
For Steel General Cutting		**NNMU200708ZEN-MP**	M	E							●		20	0.8	1	8	6	
For Stainless Steel		**NNMU200712ZER-MM**	M	E			●						20	1.2	1	8	6	
For Cast Iron General Cutting		**NNMU200608ZEN-MK**	M	E						●	●	●	20	0.8	1	6.55	6	
For Cast Iron Strong Cutting Edge Type		**NNMU200608ZEN-HK**	M	E						●	●	●	20	0.8	1	6.55	6	
For Titanium Alloy and Heat Resistant Alloy		**NNMU200712ZER-L**	M	E				●	●				20	1.2	1	8	6	
For Steel	Wiper	**WNEU2007ZEN7C-M**	E	E	●								20	0.8	7.2	6.9	0.5	
General Cutting	Wiper	**WNEU2007ZEN7C-WP**	E	E							●		20	0.8	7.1	6.9	0.5	
For Cast Iron	Wiper	**WNEU2006ZEN7C-WK**	E	E						●			20	0.8	7.4	6.55	0.5	

Note 1) The height of cutter when setting MK, HK inserts are different from when setting MP, MM inserts.

● : Inventory maintained in Japan. (10 inserts in one case)

■Instructions for Use of Wiper Iinserts

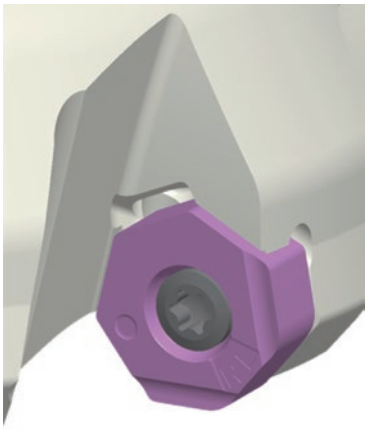


Fig.1

Fig.2

Note 1) The specifications for these wipers are right hand body 2 corners and left hand body 2 corners. Refer to Figure 1.
Note 2) Satisfactory finish surface can be achieved with one wiper insert.
However, if the feed rate per revolution will be equal to or greater than the width of the wiper edge, it is recommended to install the second and further wiper inserts spaced evenly within the cutting body.

RECOMMENDED CUTTING CONDITIONS

■ Dry Cutting

	Work Material	Hardness	Grade	Breaker	vc (m/min)	fz (mm/t.)	ap (mm)	ae (mm)
P	Mild Steel	≤180HB	**MP6120**	**M**	250(200−300)	0.3(0.2−0.4)	≤5	≤0.8DC
			VP15TF	**MP**	250(200−300)	0.3(0.2−0.4)	≤5	≤0.8DC
			MP6130	**M**	220(170−270)	0.4(0.3−0.5)	≤5	≤0.8DC
	Carbon Steel,Alloy Steel	180−280HB	**MP6120**	**M**	220(170−270)	0.3(0.2−0.4)	≤5	≤0.8DC
			VP15TF	**MP**	220(170−270)	0.3(0.2−0.4)	≤5	≤0.8DC
			MP6130	**M**	190(140−240)	0.4(0.3−0.5)	≤5	≤0.8DC
	Carbon Steel,Alloy Steel	280−350HB	**MP6120**	**M**	140(100−180)	0.3(0.2−0.4)	≤5	≤0.8DC
			VP15TF	**MP**	140(100−180)	0.3(0.2−0.4)	≤5	≤0.8DC
			MP6130	**M**	110(70−150)	0.4(0.3−0.5)	≤5	≤0.8DC
	Pre-hardened Steel	≤350HB (Annealing)	**MP6120**	**M**	140(100−180)	0.15(0.1−0.2)	≤3	≤0.8DC
			VP15TF	**MP**	140(100−180)	0.15(0.1−0.2)	≤3	≤0.8DC
			MP6130	**M**	110(70−150)	0.25(0.2−0.3)	≤3	≤0.8DC
	Alloy Tool Steel	35−45HRC	**MP6120**	**M**	140(100−180)	0.15(0.1−0.2)	≤3	≤0.8DC
			VP15TF	**MP**	140(100−180)	0.15(0.1−0.2)	≤5	≤0.8DC
			MP6130	**M**	110(70−150)	0.25(0.2−0.3)	≤3	≤0.8DC
M	Austenitic Stainless Steel	≤200HB	**MP7030**	**MM**	200(150−250)	0.2(0.1−0.3)	≤5	≤0.8DC
	Austenitic Stainless Steel	> 200HB	**MP7030**	**MM**	150(100−200)	0.2(0.1−0.3)	≤5	≤0.8DC
	Two-phase Stainless Steel	≤280HB	**MP7030**	**MM**	140(100−180)	0.15(0.05−0.25)	≤5	≤0.8DC
	Ferritic and Maltensitic Stainless Steel	≤200HB	**MP7030**	**MM**	200(150−250)	0.2(0.1−0.3)	≤5	≤0.8DC
	Ferritic and Maltensitic Stainless Steel	> 200HB	**MP7030**	**MM**	150(100−200)	0.2(0.1−0.3)	≤5	≤0.8DC
	Precipitation Hardening Stainless Steel	< 450HB	**MP7030**	**MM**	130(100−160)	0.15(0.05−0.25)	≤5	≤0.8DC
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MC5020**	**MK,HK**	220(150−300)	0.3(0.2−0.4)	≤5	≤0.8DC
			VP15TF,VP20RT	**MK,HK**	180(130−230)	0.3(0.2−0.4)	≤5	≤0.8DC
			VP15TF	**MP**	180(130−230)	0.3(0.2−0.4)	≤5	≤0.8DC
	Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	**MK,HK**	200(150−250)	0.2(0.1−0.3)	≤5	≤0.8DC
			VP15TF,VP20RT	**MK,HK**	170(120−220)	0.2(0.1−0.3)	≤5	≤0.8DC
			VP15TF	**MP**	170(120−220)	0.2(0.1−0.3)	≤5	≤0.8DC
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MC5020**	**MK,HK**	170(150−200)	0.2(0.1−0.3)	≤5	≤0.8DC
			VP15TF,VP20RT	**MK,HK**	140(100−180)	0.2(0.1−0.3)	≤5	≤0.8DC
			VP15TF	**MP**	140(100−180)	0.2(0.1−0.3)	≤5	≤0.8DC
H	Hardened Steel	40−55HRC	**VP15TF**	**MP**	80(60−100)	0.15(0.1−0.2)	≤3	≤0.8DC

Note1) Recommended wet cutting for good surface finishing of stainless steel. (Tool life is short compared to wet cutting.)
Note2) We recommend wet cutting with internal coolant for titanium alloy and heat resistant alloy.
Note3) When clamp rigidity is low and tool overhang is long, we recommended to reduce the cutting speed and the feed rate by 30%.

■ Wet Cutting

	Work Material	Hardness	Breaker	Grade	vc (m/min)	fz (mm/t.)	ap (mm)	ae (mm)
M	Austenitic Stainless Steel	≤200HB	**MP7030**	**MM**	125(100−150)	0.15(0.1−0.2)	≤5	≤0.8DC
	Austenitic Stainless Steel	> 200HB	**MP7030**	**MM**	100(75−125)	0.15(0.1−0.2)	≤5	≤0.8DC
	Two-phase Stainless Steel	≤280HB	**MP7030**	**MM**	80(60−100)	0.1(0.05−0.15)	≤5	≤0.8DC
	Ferritic and Maltensitic Stainless Steel	≤200HB	**MP7030**	**MM**	125(100−150)	0.15(0.1−0.2)	≤5	≤0.8DC
	Ferritic and Maltensitic Stainless Steel	> 200HB	**MP7030**	**MM**	100(75−125)	0.15(0.1−0.2)	≤5	≤0.8DC
	Precipitation Hardening Stainless Steel	< 450HB	**MP7030**	**MM**	70(50−90)	0.1(0.05−0.15)	≤5	≤0.8DC
S	Titanium Alloy	–	**MP7030**	**MM**	40(20−50)	0.15(0.1−0.2)	≤3	≤0.6DC
		–	**MP9120**	**L**	60(50−70)	0.1(0.05−0.15)	≤3	≤0.6DC
		–	**MP9130**	**L**	40(20−50)	0.15(0.1−0.2)	≤3	≤0.6DC
	Heat Resistant Alloy	–	**MP7030**	**MM**	40(20−50)	0.15(0.1−0.2)	≤3	≤0.6DC
		–	**MP9120**	**L**	40(20−50)	0.15(0.1−0.2)	≤3	≤0.6DC
		–	**MP9130**	**L**	40(20−50)	0.15(0.1−0.2)	≤3	≤0.6DC

Note1) Recommended wet cutting for good surface finishing of stainless steel. (Tool life is short compared to wet cutting.)
Note2) We recommend wet cutting with internal coolant for titanium alloy and heat resistant alloy.
Note3) When clamp rigidity is low and tool overhang is long, we recommended to reduce the cutting speed and the feed rate by 30%.

■ Cutting Conditions with Wiper Insert

	Work Material	Hardness	Main Insert	Grade	Wiper Insert	Grade	vc (m/min)	fz (mm/t.)	ap (mm)	ae (mm)
P	Mild Steel	≤180HB	**VP15TF**	**MP**	**VP15TF**	**WP**	250(200−300)	0.3(0.2−0.4)	≤0.5	≤0.8DC
			MP6120	**M**	**MP6120**	**M**	250(200−300)	0.3(0.2−0.4)	≤0.5	≤0.8DC
	Carbon Steel,Alloy Steel	180−280HB	**VP15TF**	**MP**	**VP15TF**	**WP**	220(170−270)	0.3(0.2−0.4)	≤0.5	≤0.8DC
			MP6120	**M**	**MP6120**	**M**	220(170−270)	0.3(0.2−0.4)	≤0.5	≤0.8DC
	Carbon Steel,Alloy Steel	280−350HB	**VP15TF**	**MP**	**VP15TF**	**WP**	140(100−180)	0.3(0.2−0.4)	≤0.5	≤0.8DC
			MP6120	**M**	**MP6120**	**M**	140(100−180)	0.3(0.2−0.4)	≤0.5	≤0.8DC
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MC5020**	**MK,HK**	**MC5020**	**WK**	320(250−400)	0.3(0.2−0.4)	≤0.5	≤0.8DC
			VP15TF	**MP**	**VP15TF**	**WP**	220(150−300)	0.3(0.2−0.4)	≤0.5	≤0.8DC
	Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	**MK,HK**	**MC5020**	**WK**	250(200−300)	0.2(0.1−0.3)	≤0.5	≤0.8DC
			VP15TF	**MP**	**VP15TF**	**WP**	200(150−250)	0.2(0.1−0.3)	≤0.5	≤0.8DC
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MC5020**	**MK,HK**	**MC5020**	**WK**	220(200−250)	0.2(0.1−0.3)	≤0.5	≤0.8DC
			VP15TF	**MP**	**VP15TF**	**WP**	170(150−200)	0.2(0.1−0.3)	≤0.5	≤0.8DC
S	Heat Resistant Alloy	–	**VP15TF**	**MP**	**VP15TF**	**WP**	40(20−50)	0.15(0.1−0.2)	≤0.5	≤0.8DC
H	Hardened Steel	40−55HRC	**VP15TF**	**MP**	**VP15TF**	**WP**	80(60−100)	0.15(0.1−0.2)	≤0.5	≤0.8DC

Note 1) When clamp rigidity is low and tool overhang is long, we recommended to reduce the cutting speed and the feed rate by 70-80%.
Note 2) Please use WP geometry insert in combination with MP or M geometry inserts, and use WK geometry insert in combination with MK or HK geometry inserts

AHX440S, AHX475S, AHX640S Mounting Dimensions

Fig. 1

ø40
ø50
ø63
ø80

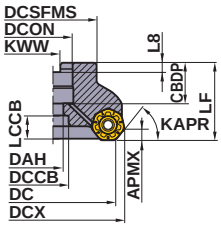


Fig. 2

ø100
ø125
ø160

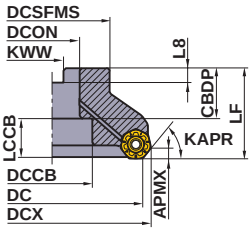
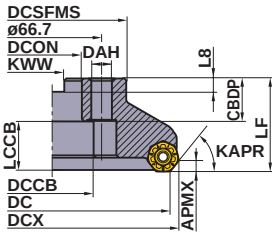


Fig. 3

ø160



Right hand tool holder only.

DCON (mm)	DC (mm)	Order Number	Dimensions(mm)							Fig.
			CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
16	40	**AHX440S-040A03AR**	18	9	14	13.9	37	8.4	5.6	1
16	40	**AHX440S-040A04AR**	18	9	14	13.9	37	8.4	5.6	1
22	50	**AHX440S-050A04AR**	20	11	17	11.9	47	10.4	6.3	1
22	50	**AHX440S-050A05AR**	20	11	17	11.9	47	10.4	6.3	1
22	50	**AHX440S-050A06AR**	20	11	17	11.9	47	10.4	6.3	1
22	50	**AHX475S-050A04AR**	20	11	17	16.7	47	10.4	6.3	5
22	50	**AHX475S-050A05AR**	20	11	17	16.7	47	10.4	6.3	5
22	63	**AHX440S-063A05AR**	20	11	17	11.9	50	10.4	6.3	1
22	63	**AHX440S-063A06AR**	20	11	17	11.9	50	10.4	6.3	1
22	63	**AHX440S-063A08AR**	20	11	17	11.9	50	10.4	6.3	1
22	63	**AHX475S-063A05AR**	20	11	17	16.7	60	10.4	6.3	5
22	63	**AHX475S-063A06AR**	20	11	17	16.7	60	10.4	6.3	5
22	63	**AHX640S-063A04AR**	20	11	17	16.2	50	10.4	6.3	1
22	63	**AHX640S-063A05AR**	20	11	17	16.2	50	10.4	6.3	1
25.4	80	**AHX440SR08006CA**	26	13	20	14.9	56	9.5	6	1
25.4	80	**AHX440SR08008CA**	26	13	20	14.9	56	9.5	6	1
25.4	80	**AHX440SR08010CA**	26	13	20	14.9	56	9.5	6	1
25.4	80	**AHX640SR08004CA**	26	13	20	14.2	56	9.5	6	1
25.4	80	**AHX640SR08006CA**	26	13	20	14.2	56	9.5	6	1
27	80	**AHX440S-080A06AR**	23	13	20	14.9	56	12.4	7	1
27	80	**AHX440S-080A08AR**	23	13	20	14.9	56	12.4	7	1
27	80	**AHX440S-080A10AR**	23	13	20	14.9	56	12.4	7	1
27	80	**AHX475S-080A06AR**	23	13	20	14.7	76	12.4	7	5
27	80	**AHX475S-080A08AR**	23	13	20	14.7	76	12.4	7	5
27	80	**AHX640S-080A04AR**	23	13	20	15.2	56	12.4	7	1
27	80	**AHX640S-080A06AR**	23	13	20	15.2	56	12.4	7	1
31.75	80	**AHX475SR08006DA**	32	17	26	19.7	76	12.7	8	5
31.75	80	**AHX475SR08008DA**	32	17	26	19.7	76	12.7	8	5
31.75	100	**AHX440SR10007DA**	37	—	45	11.9	70	12.7	8	2
31.75	100	**AHX440SR10010DA**	37	—	45	11.9	70	12.7	8	2
31.75	100	**AHX440SR10012DA**	37	—	45	11.9	70	12.7	8	2
31.75	100	**AHX475SR10007DA**	32	17	26	19.7	96	12.7	8	5
31.75	100	**AHX475SR10009DA**	32	17	26	19.7	96	12.7	8	5
31.75	100	**AHX640SR10005DA**	35	—	45	13.2	70	12.7	8	2
31.75	100	**AHX640SR10007DA**	35	—	45	13.2	70	12.7	8	2

Fig. 4

ø200

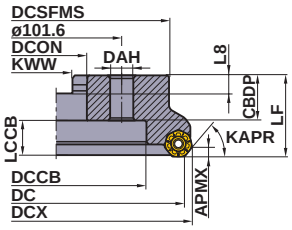


Fig.5

ø50
ø63
ø80
ø100

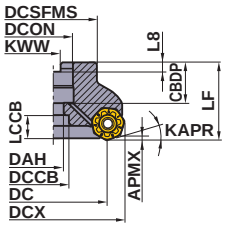
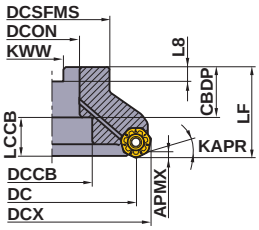


Fig.6

ø125
ø160



Right hand tool holder only.

DCON (mm)	DC (mm)	Order Number	Dimensions(mm)							Fig.
			CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
32	100	**AHX440S-100B07AR**	32	–	45	16.9	78	14.4	8	2
32	100	**AHX440S-100B10AR**	32	–	45	16.9	78	14.4	8	2
32	100	**AHX440S-100B12AR**	32	–	45	16.9	78	14.4	8	2
32	100	**AHX475S-100A07AR**	26	17	26	25.7	96	14.4	8	5
32	100	**AHX475S-100A09AR**	26	17	26	25.7	96	14.4	8	5
32	100	**AHX640S-100B05AR**	32	–	45	16.2	78	14.4	8	2
32	100	**AHX640S-100B07AR**	32	–	45	16.2	78	14.4	8	2
38.1	125	**AHX440SR12508EA**	42	–	56	19.9	80	15.9	10	2
38.1	125	**AHX440SR12512EA**	42	–	56	19.9	80	15.9	10	2
38.1	125	**AHX440SR12514EA**	42	–	56	19.9	80	15.9	10	2
38.1	125	**AHX475SR12508EA**	42	–	56	19.7	100	15.9	10	6
38.1	125	**AHX475SR12510EA**	42	–	56	19.7	100	15.9	10	6
38.1	125	**AHX640SR12506EA**	42	–	56	19.2	80	15.9	10	2
38.1	125	**AHX640SR12508EA**	42	–	56	19.2	80	15.9	10	2
40	125	**AHX440S-125B08AR**	40	–	56	21.9	89	16.4	9	2
40	125	**AHX440S-125B12AR**	40	–	56	21.9	89	16.4	9	2
40	125	**AHX440S-125B14AR**	40	–	56	21.9	89	16.4	9	2
40	125	**AHX475S-125B08AR**	40	–	56	21.7	100	16.4	9	6
40	125	**AHX475S-125B10AR**	40	–	56	21.7	100	16.4	9	6
40	125	**AHX640S-125B06AR**	42	–	56	19.2	89	16.4	9	2
40	125	**AHX640S-125B08AR**	42	–	56	19.2	89	16.4	9	2
40	160	**AHX440S-160C10NR**	40	14	56	21.9	100	16.4	9	3
40	160	**AHX440S-160C14NR**	40	14	56	21.9	100	16.4	9	3
40	160	**AHX440S-160C16NR**	40	14	56	21.9	100	16.4	9	3
40	160	**AHX475S-160B10AR**	40	–	56	21.7	100	16.4	9	6
40	160	**AHX475S-160B12AR**	40	–	56	21.7	100	16.4	9	6
40	160	**AHX640S-160C07NR**	29	14	56	32.2	120	16.4	9	3
40	160	**AHX640S-160C10NR**	29	14	56	32.2	120	16.4	9	3
47.625	200	**AHX640SR20008KN**	35	18	140	26.2	175	25.4	14.22	4
47.625	200	**AHX640SR20012KN**	35	18	140	26.2	175	25.4	14.22	4
50.8	160	**AHX440SR16010FA**	45	–	72	16.9	100	19.1	11	2
50.8	160	**AHX440SR16014FA**	45	–	72	16.9	100	19.1	11	2
50.8	160	**AHX440SR16016FA**	45	–	72	16.9	100	19.1	11	2
50.8	160	**AHX475SR16010FA**	45	–	72	16.7	100	19.1	11	6
50.8	160	**AHX475SR16012FA**	45	–	72	16.7	100	19.1	11	6
50.8	160	**AHX640SR16007FA**	43	–	72	18.2	100	19.1	11	2
50.8	160	**AHX640SR16010FA**	43	–	72	18.2	100	19.1	11	2
60	200	**AHX640S-200C08NR**	32	18	140	29.2	175	25.7	14.22	4
60	200	**AHX640S-200C12NR**	32	18	140	29.2	175	25.7	14.22	4

FACE MILLING

<HIGH FEED CUTTING FOR CAST IRON>

TOOL NEWS

50° KAPR

F R

AHX640W

P M **K** N S H

Cast Iron

Fig.1 ø80

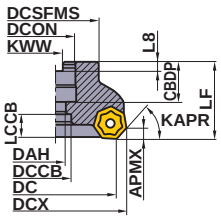


Fig.2 ø100 ø125 ø160

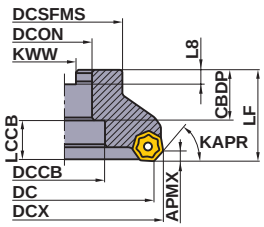


Fig.3 ø200 ø250

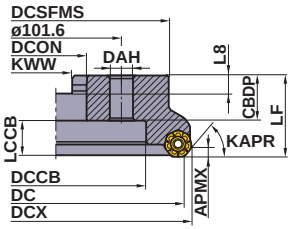
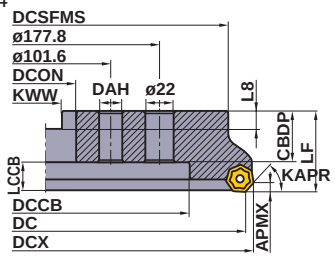


Fig.4 ø315



Right hand tool holder shown.

■ Right Hand Tool Holder

KAPR :50°
GAMP:-6° GAMF:-4°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
80	**AHX640WR08008C**	●	–	8	50	92.6	25.4	1	1.5	6
	AHX640WR08010C	●	–	10	50	92.6	25.4	1	1.5	6
100	**AHX640WR10010D**	●	–	10	50	112.6	31.75	2	2.1	6
	AHX640WR10014D	●	–	14	50	112.6	31.75	2	2.1	6
125	**AHX640WR12512E**	●	–	12	63	137.6	38.1	2	3.5	6
	AHX640WR12518E	●	–	18	63	137.6	38.1	2	3.5	6
160	**AHX640WR16016F**	●	–	16	63	172.6	50.8	2	5.6	6
	AHX640WR16022F	●	–	22	63	172.6	50.8	2	5.6	6
200	**AHX640WR20020K**	●	–	20	63	212.6	47.625	3	9.0	6
	AHX640WR20028K	●	–	28	63	212.6	47.625	3	9.0	6
250	**AHX640WR25024K**	●	–	24	63	262.6	47.625	3	14.4	6
	AHX640WR25036K	●	–	36	63	262.6	47.625	3	14.4	6
315	**AHX640WR31528P**	●	–	28	63	327.6	47.625	4	23.8	6
	AHX640WR31544P	●	–	44	63	327.6	47.625	4	23.8	6

■ Left Hand Tool Holder

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
80	**AHX640WL08008C**	●	–	8	50	92.6	25.4	1	1.5	6
	AHX640WL08010C	●	–	10	50	92.6	25.4	1	1.5	6
100	**AHX640WL10010D**	●	–	10	50	112.6	31.75	2	2.1	6
	AHX640WL10014D	●	–	14	50	112.6	31.75	2	2.1	6
125	**AHX640WL12512E**	●	–	12	63	137.6	38.1	2	3.5	6
	AHX640WL12518E	●	–	18	63	137.6	38.1	2	3.5	6
160	**AHX640WL16016F**	●	–	16	63	172.6	50.8	2	5.6	6
	AHX640WL16022F	●	–	22	63	172.6	50.8	2	5.6	6
200	**AHX640WL20020K**	●	–	20	63	212.6	47.625	3	9.0	6
	AHX640WL20028K	●	–	28	63	212.6	47.625	3	9.0	6
250	**AHX640WL25024K**	●	–	24	63	262.6	47.625	3	14.4	6
	AHX640WL25036K	●	–	36	63	262.6	47.625	3	14.4	6
315	**AHX640WL31528P**	●	–	28	63	327.6	47.625	4	23.8	6
	AHX640WL31544P	●	–	44	63	327.6	47.625	4	23.8	6

● : Inventory maintained in Japan.

Fig.1
ø80

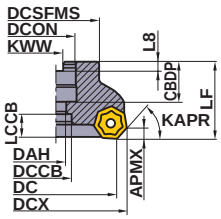


Fig.2
ø100
ø125

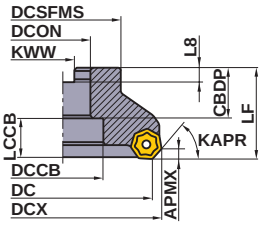


Fig.3
ø160

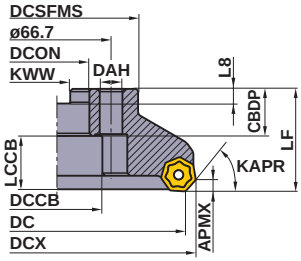


Fig.4
ø200
ø250

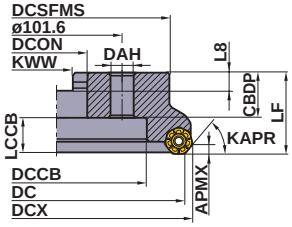
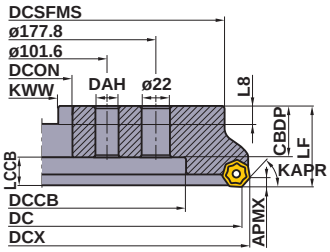


Fig.5
ø315



Right hand tool holder shown.

Metric Standard

KAPR :50°
GAMP:-6° GAMF:-4°

Right Hand Tool Holder

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
80	AHX640W-080A08R	●	–	8	50	92.6	27	1	1.5	6
	AHX640W-080A10R	●	–	10	50	92.6	27	1	1.5	6
100	AHX640W-100B10R	●	–	10	50	112.6	32	2	2.1	6
	AHX640W-100B14R	●	–	14	50	112.6	32	2	2.1	6
125	AHX640W-125B12R	●	–	12	63	137.6	40	2	3.1	6
	AHX640W-125B18R	●	–	18	63	137.6	40	2	3.1	6
160	AHX640W-160C16R	●	–	16	63	172.6	40	3	5.6	6
	AHX640W-160C22R	●	–	22	63	172.6	40	3	5.6	6
200	AHX640W-200C20R	●	–	20	63	212.6	60	4	8	6
	AHX640W-200C28R	●	–	28	63	212.6	60	4	8	6
250	AHX640W-250C24R	●	–	24	63	262.6	60	4	12.6	6
	AHX640W-250C36R	●	–	36	63	262.6	60	4	12.6	6
315	AHX640W-315C28R	●	–	28	80	327.6	60	5	31.5	6
	AHX640W-315C44R	●	–	44	80	327.6	60	5	31.5	6

Left Hand Tool Holder

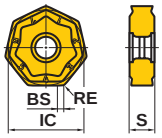
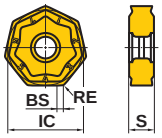
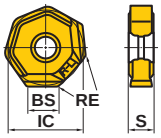
DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	DCX	DCON	Fig.	WT (kg)	APMX (mm)
80	AHX640W-080A08L	●	–	8	50	92.6	27	1	1.5	6
	AHX640W-080A10L	●	–	10	50	92.6	27	1	1.5	6
100	AHX640W-100B10L	●	–	10	50	112.6	32	2	2.1	6
	AHX640W-100B14L	●	–	14	50	112.6	32	2	2.1	6
125	AHX640W-125B12L	●	–	12	63	137.6	40	2	3.1	6
	AHX640W-125B18L	●	–	18	63	137.6	40	2	3.1	6
160	AHX640W-160C16L	●	–	16	63	172.6	40	3	5.6	6
	AHX640W-160C22L	●	–	22	63	172.6	40	3	5.6	6
200	AHX640W-200C20L	●	–	20	63	212.6	60	4	8.0	6
	AHX640W-200C28L	●	–	28	63	212.6	60	4	8.0	6
250	AHX640W-250C24L	●	–	24	63	262.6	60	4	12.6	6
	AHX640W-250C36L	●	–	36	63	262.6	60	4	12.6	6
315	AHX640W-315C28L	●	–	28	80	327.6	60	5	31.5	6
	AHX640W-315C44L	●	–	44	80	327.6	60	5	31.5	6

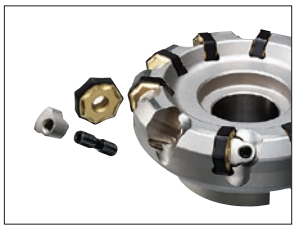
MOUNTING DIMENSION ➤ M058
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

Work Material	K	Cast Iron

Cutting Conditions (Guide) : ● **:** Stable Cutting ◐ **:** General Cutting ✣ **:** Unstable Cutting
Honing : E : Round

Shape	Order Number	Class	Honing	Coated MC5020	Coated VP15TF	Coated VP20RT	IC	RE	BS	S	APMX	Geometry
General Cutting	**NNMU200608ZEN-MK**	M	E	●	●	●	20	0.8	1.0	6.55	6	
Strong Cutting Edge Type	**NNMU200608ZEN-HK**	M	E	●	●	●	20	0.8	1.0	6.55	6	
Wiper	**WNEU2006ZEN7C-WK**	E	E	●			20	0.8	7.4	6.55	0.5	



SPARE PARTS

Tool Holder Number	Wedge	* Clamp Screw	Wrench
AHX640W	CWAHX640WN	LS0622T	TKY15T

* Clamp Torque (N • m) : LS0622T=6.0

● **: Inventory maintained in Japan. (10 inserts in one case)**

RECOMMENDED CUTTING CONDITIONS

■ Dry·Wet Cutting

Work Material		Tensile Strength	Grade	vc (m/min)	fz (mm/t.)
K	Gray Cast Iron	≤350MPa	MC5020	220 (150—300)	0.3 (0.2—0.4)
			VP15TF VP20RT	180 (130—250)	0.3 (0.2—0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200 (150—250)	0.2 (0.1—0.3)
			VP15TF VP20RT	170 (120—220)	0.2 (0.1—0.3)
		≤800MPa	MC5020	170 (150—200)	0.2 (0.1—0.3)
			VP15TF VP20RT	140 (100—180)	0.2 (0.1—0.3)

*Please use 2-3 pcs of Wiper inserts in case of 'over 6mm/rev'.

■ Finishing (Use of Wiper Inserts)

Work Material		Grade	ap (mm)	vc (m/min)	fz (mm/t.)
K	Gray Cast Iron	MC5020	<0.5	320 (250—400)	0.2 (0.1—0.3)
			0.5—3	270 (200—350)	
	Ductile Cast Iron		<0.5	270 (200—350)	
			0.5—3	220 (200—250)	

Note 1) With reference to the above examples, adjust the cutting conditions according to the use environment.
Note 2) Tool life when wet cutting is short compared to dry cutting.

AHX640W Mounting Dimensions

Fig.1

ø80

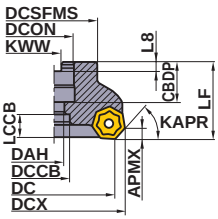
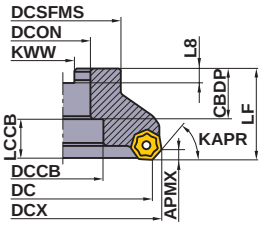


Fig.2

ø100
ø125
ø160



Right hand tool holder shown.

DCON (mm)	DC (mm)	Order Number	Dimensions(mm)							Fig.
			CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
25.4	80	**AHX640WL08008C**	26	13	20	14.8	56	9.5	6	1
25.4	80	**AHX640WL08010C**	26	13	20	14.8	56	9.5	6	1
25.4	80	**AHX640WR08008C**	26	13	20	14.8	56	9.5	6	1
25.4	80	**AHX640WR08010C**	26	13	20	14.8	56	9.5	6	1
27	80	**AHX640W-080A08L**	23	13	20	14.8	56	12.4	7	1
27	80	**AHX640W-080A08R**	23	13	20	14.8	56	12.4	7	1
27	80	**AHX640W-080A10L**	23	13	20	14.8	56	12.4	7	1
27	80	**AHX640W-080A10R**	23	13	20	14.8	56	12.4	7	1
31.75	100	**AHX640WL10010D**	32	–	45	16.8	70	12.7	8	2
31.75	100	**AHX640WL10014D**	32	–	45	16.8	70	12.7	8	2
31.75	100	**AHX640WR10010D**	32	–	45	16.8	70	12.7	8	2
31.75	100	**AHX640WR10014D**	32	–	45	16.8	70	12.7	8	2
32	100	**AHX640W-100B10L**	32	–	45	16.8	70	14.4	8	2
32	100	**AHX640W-100B10R**	32	–	45	16.8	70	14.4	8	2
32	100	**AHX640W-100B14L**	32	–	45	16.8	70	14.4	8	2
32	100	**AHX640W-100B14R**	32	–	45	16.8	70	14.4	8	2
38.1	125	**AHX640WL12512E**	35	–	56	26.8	80	15.9	10	2
38.1	125	**AHX640WL12518E**	35	–	56	26.8	80	15.9	10	2
38.1	125	**AHX640WR12512E**	35	–	56	26.8	80	15.9	10	2
38.1	125	**AHX640WR12518E**	35	–	56	26.8	80	15.9	10	2
40	125	**AHX640W-125B12L**	32	–	56	29.8	80	16.4	9	2
40	125	**AHX640W-125B12R**	32	–	56	29.8	80	16.4	9	2
40	125	**AHX640W-125B18L**	32	–	56	29.8	80	16.4	9	2
40	125	**AHX640W-125B18R**	32	–	56	29.8	80	16.4	9	2
40	160	**AHX640W-160C16L**	29	14	56	32.8	100	16.4	9	3
40	160	**AHX640W-160C16R**	29	14	56	32.8	100	16.4	9	3
40	160	**AHX640W-160C22L**	29	14	56	32.8	100	16.4	9	3
40	160	**AHX640W-160C22R**	29	14	56	32.8	100	16.4	9	3

Fig.3

ø160

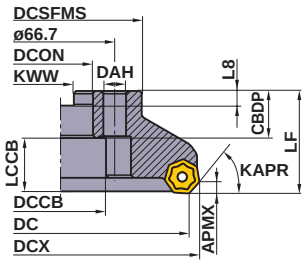


Fig.4

ø200
ø250

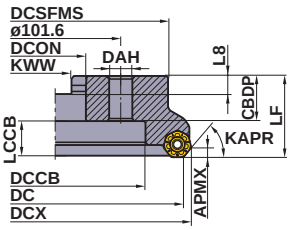
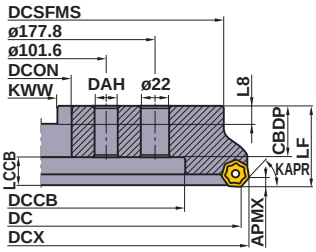


Fig.5

ø315



Right hand tool holder shown.

DCON (mm)	DC (mm)	Order Number	Dimensions(mm)							Fig.
			CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
47.625	200	**AHX640WL20020K**	35	18	140	26.8	175	25.4	14.22	4
47.625	200	**AHX640WL20028K**	35	18	140	26.8	175	25.4	14.22	4
47.625	200	**AHX640WR20020K**	35	18	140	26.8	175	25.4	14.22	4
47.625	200	**AHX640WR20028K**	35	18	140	26.8	175	25.4	14.22	4
47.625	250	**AHX640WL25024K**	35	18	180	26.8	220	25.4	14.22	4
47.625	250	**AHX640WL25036K**	35	18	180	26.8	220	25.4	14.22	4
47.625	250	**AHX640WR25024K**	35	18	180	26.8	220	25.4	14.22	4
47.625	250	**AHX640WR25036K**	35	18	180	26.8	220	25.4	14.22	4
47.625	315	**AHX640WL31528P**	40	18	225	21.8	285	25.4	14.22	5
47.625	315	**AHX640WL31544P**	40	18	225	21.8	285	25.4	14.22	5
47.625	315	**AHX640WR31528P**	40	18	225	21.8	285	25.4	14.22	5
47.625	315	**AHX640WR31544P**	40	18	225	21.8	285	25.4	14.22	5
50.8	160	**AHX640WL16016F**	38	—	72	23.8	100	19.1	11	2
50.8	160	**AHX640WL16022F**	38	—	72	23.8	100	19.1	11	2
50.8	160	**AHX640WR16016F**	38	—	72	23.8	100	19.1	11	2
50.8	160	**AHX640WR16022F**	38	—	72	23.8	100	19.1	11	2
60	200	**AHX640W-200C20L**	32	18	135	29.8	155	25.7	14.22	4
60	200	**AHX640W-200C20R**	32	18	135	29.8	155	25.7	14.22	4
60	200	**AHX640W-200C28L**	32	18	135	29.8	155	25.7	14.22	4
60	200	**AHX640W-200C28R**	32	18	135	29.8	155	25.7	14.22	4
60	250	**AHX640W-250C24L**	32	18	180	29.8	200	25.7	14.22	4
60	250	**AHX640W-250C24R**	32	18	180	29.8	200	25.7	14.22	4
60	250	**AHX640W-250C36L**	32	18	180	29.8	200	25.7	14.22	4
60	250	**AHX640W-250C36R**	32	18	180	29.8	200	25.7	14.22	4
60	315	**AHX640W-315C28L**	57	18	225	21.8	285	25.7	14.22	5
60	315	**AHX640W-315C28R**	57	18	225	21.8	285	25.7	14.22	5
60	315	**AHX640W-315C44L**	57	18	225	21.8	285	25.7	14.22	5
60	315	**AHX640W-315C44R**	57	18	225	21.8	285	25.7	14.22	5

FACE MILLING

<HIGH EFFICIENCY CUTTING FOR CAST IRON>

TOOL NEWS

45° KAPR

F R

AOX445

P M **K** N S H

Cast Iron

- **Solid CBN octagonal double sided insert.**
- **Economical 16 cutting edge inserts. (when the depth of cut is 3mm)**
- **For high efficiency roughing through to finishing.**
- **Easy operation and cleansing.**

Fig.1 ø63

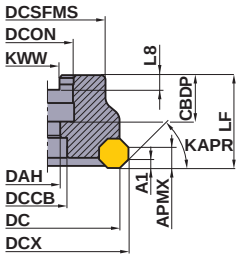
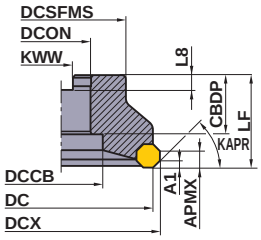


Fig.2 ø80 ø100 ø125 ø160



■ ARBOR TYPE

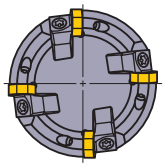
KAPR : 45°
GAMP : -5°
GAMF : -9°—-6°

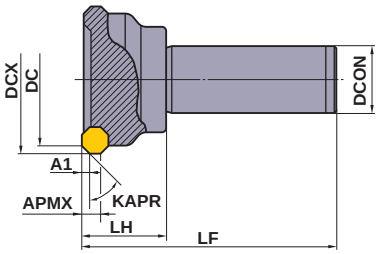
Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	DC	DCX	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT* (kg)	A1 (mm)	APMX (mm)	Max. Allowable Revolution (min^{-1})	Fig.
Coarse Pitch	**AOX445-063A04R**	●	4	63	70.8	40	22	20	11	—	50	10.4	6.3	0.6	3	8	12000	1
	AOX445R08006C	●	6	80	87.8	50	25.4	26	—	38	60	9.5	6	1.2	3	8	11000	2
	AOX445R10008D	●	8	100	107.8	50	31.75	32	—	45	70	12.7	8	1.8	3	8	9300	2
	AOX445R12510E	●	10	125	132.8	63	38.1	35	—	60	80	15.9	10	3.0	3	8	8300	2
	AOX445R16012F	●	12	160	167.8	63	50.8	38	—	80	100	19.1	11	4.9	3	8	7200	2

Note 1) When machining with a depth of cut of 8mm, 16 corners cannot be used.

* WT : Tool Weight





■ SHANK TYPE

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	DC	DCX	LF	DCON	LH	WT* (kg)	A1 (mm)	APMX (mm)	Max. Allowable Revolution (min^{-1})
Coarse Pitch	**AOX445R503S32**	●	3	50	57.8	125	32	40	1.1	3	8	13000
	AOX445R634S32	●	4	63	70.8	125	32	40	1.4	3	8	12000

* WT : Tool Weight

● : Inventory maintained in Japan. (CBN inserts are available in 1 piece in one case.)

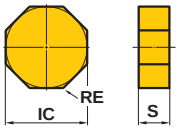
SPARE PARTS

Tool Holder Number		*	
	Wedge	Clamp Screw	Wrench
AOX445	CWAOX445N	LS15T	TKY25T

* Clamp Torque (N • m) : LS15T=8.0

INSERTS

Work Material	K	Cast Iron	◐		**Cutting Conditions (Guide) :** ● **:** Stable Cutting ◐ **:** General Cutting ✠ **:** Unstable Cutting **Honing : E :** Round

Shape	Order Number	Class	CBN BC5030		Dimensions(mm) IC	RE	S	Geometry
	SL-ONEN120404ASN	E	●		12.7	0.4	4.76	

RECOMMENDED CUTTING CONDITIONS

Work Material		Tensile Strength	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K	Gray Cast Iron	≤200MPa	**BC5030**	1000 (800—1500)	0.1 (0.05—0.15)
		250—350 MPa			

Note 1) Dry cutting is recommended.

FACE MILLING
<HEAVY CUTTING>

75° KAPR

SE515

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			

- 20°positive insert.
- High rake angle.
- High rigidity due to carbide shim.

Fig.1
ø100

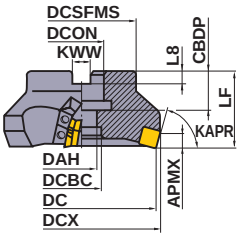
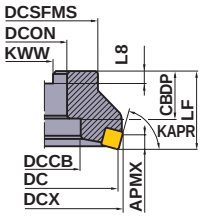


Fig.2
ø125
ø160

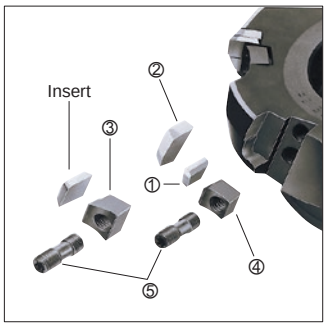


Right hand tool holder only.

KAPR :75°
GAMP:+19° GAMF:+5°

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	DCX	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT* (kg)	APMX (mm)	Fig.
Coarse Pitch	SE515R0405D	▲	5	100	108.9	63	31.75	32	17	—	80	12.7	8	2.3	11.5	1
	SE515R0506E	▲	6	125	133.6	63	38.1	38	—	60	80	15.9	10	3.5	11.5	2
	SE515R0608F	▲	8	160	168.3	63	50.8	38	—	80	90	19.1	11	5.6	11.5	2
Close Pitch	SE515R0407D	▲	7	100	108.9	63	31.75	32	17	—	90	12.7	8	2.3	11.5	1
	SE515R0509E	▲	9	125	133.6	63	38.1	38	—	60	120	15.9	10	3.5	11.5	2
	SE515R0611F	▲	11	160	168.3	63	50.8	38	—	80	120	19.1	11	5.6	11.5	2

* WT : Tool Weight



SPARE PARTS

Tool Holder Number	① Locator	② Shim	③ Wedge-T	④ Wedge-S	⑤ Clamp Screw *	Wrench	Set Bolt
SE515R0405D 0407D	SPSE515R	STSE515R	CWSE545TR	CWSE545SN	LS15T	TKY25T	HSC16035
SE515R0506E ~ SE515R0611F							—

* Clamp Torque (N • m) : LS15T=8.0

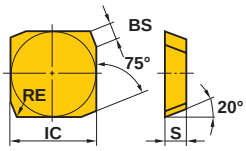
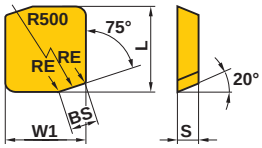
● : Inventory maintained in Japan. ▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

INSERTS

Work Material			F7030	VP15TF			NX2525	NX4545	UTi20T	
	P	Steel	◐	◐			◐	◐	◐	
	M	Stainless Steel	◔	◔			◔	◔	◔	
	K	Cast Iron		✠			●		✠	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **S :** Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	Coated				Cermet		Carbide		Dimensions(mm)						Geometry
				F7030	VP15TF			NX2525	NX4545	UTi20T		W1	L	IC	S	BS	RE	
	SECN1504EFTR1	C	T						●			—	—	15.875	4.76	1.4	1.0	
	SEEN1504EFER1	E	E		●							—	—	15.875	4.76	1.4	1.0	
	SEEN1504EFTR1	E	T						●			—	—	15.875	4.76	1.4	1.0	
	SEEN1504EFSR1	E	S	●								—	—	15.875	4.76	1.4	1.0	
	SEKN1504EFTR1	K	T							●		—	—	15.875	4.76	1.4	—	
	SEKN1504EFSR1	K	S	●								—	—	15.875	4.76	1.4	—	
Wiper	WEC53EFTR5C	C	T					●				15.875	16.903	—	4.76	5	1.0	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**F7030**	200 (160—250)	0.2 (0.1—0.3)
			VP15TF	180 (100—250)	
			NX4545	140 (80—200)	
	Carbon Steel Alloy Steel	180—280HB	**F7030**	200 (160—250)	0.2 (0.1—0.3)
			VP15TF	180 (100—250)	
			NX4545	140 (80—200)	
		280—350HB	**VP15TF**	120 (80—160)	0.15 (0.1—0.2)

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
M	Stainless Steel	≤200HB	**VP15TF**	150 (100—200)	0.2 (0.1—0.3)
K	Cast Iron	Tensile Strength ≤450MPa	**VP15TF**	160 (100—220)	0.2 (0.1—0.3)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)
=Feed per Tooth x Number of Teeth x Cutter Revolution

FACE MILLING

<CUTTING FOR DIFFICULT-TO-CUT MATERIALS>

SG20

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel

- **30° positive insert.**
- **High rake angle.**
- **Round shape insert with a strong cutting edge.**
- **Suitable for difficult-to-cut materials.**

Fig.1

ø80
ø100

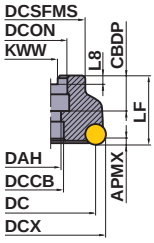
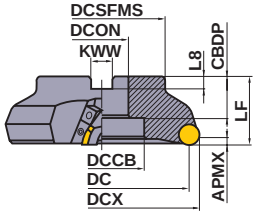


Fig.2

ø125
ø160



Right hand tool holder only.

GAMP:+24° GAMF:+9°

Order Number	Stock	Number of Teeth	Dimensions(mm)										WT* (kg)	APMX (mm)	Fig.
	R		DC	DCX	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8			
SG20R0304C	●	4	80	101.2	50	25.4	26	13	–	60	9.5	6	1.5	8	1
SG20R0405D	●	5	100	121.4	63	31.75	32	17	–	80	12.7	8	2.9	8	1
SG20R0506E	●	6	125	146.4	63	38.1	38	–	60	90	15.9	10	3.8	8	2
SG20R0608F	●	8	160	181.4	63	50.8	38	–	80	120	19.1	11	6.1	8	2

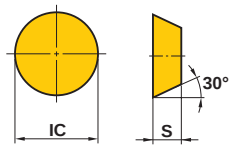
* WT : Tool Weight

● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material			F7030	VP15TF	UP20M	UTi20T	HTi10
	P	Steel	◐	◐	◐	◐	
	M	Stainless Steel	◔	◔	◔	◔	
	K	Cast Iron		✣		✣	●
	H	Hardened Steel		◔			

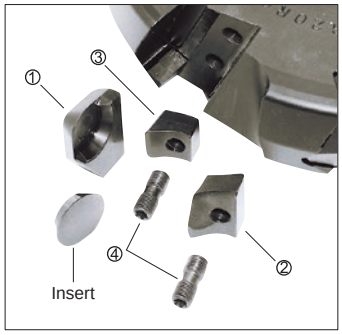
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting
Honing :
E : Round

Shape	Order Number	Class	Coated F7030	Coated VP15TF	Coated UP20M	Carbide UTi20T	Carbide HTi10	Dimensions (mm) IC	Dimensions (mm) S	Geometry
	RGEN2004M0SN	E	●		●	●	●	20	4.76	
	RGEN2004M0EN	E		●				20	4.76	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Recommended Max. Depth of Cut (mm)
P	Carbon Steel Alloy Steel	≤180HB	**VP15TF**	180 (100—250)	0.35 (0.2—0.5)	4.5
			NX2525	175 (150—200)	0.25 (0.2—0.3)	4.5
		280—350HB	**VP15TF**	180 (100—250)	0.3 (0.2—0.4)	4.5
			NX2525	165 (130—200)	0.25 (0.2—0.3)	4.5
M	Stainless Steel	≤200HB	**VP15TF**	150 (100—200)	0.35 (0.2—0.5)	3
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	160 (100—220)	0.4 (0.3—0.5)	4.5
H	Hardened Steel	40—60HRC	**VP15TF**	80 (50—100)	0.2 (0.1—0.3)	2

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution



SPARE PARTS

Tool Holder Number	① Locator	② Wedge-T	③ Wedge-S	④ Clamp Screw *	Wrench	Set Bolt
SG20R0304C	SPSG20R	CWSG20TR	CWSG20SN	LS15T	TKY25T	—
SG20R0405D						HSC16035
SG20R0506E						—
SG20R0608F						

* Clamp Torque (N • m) : LS15T=8.0

M

INDEXABLE MILLING

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

FACE MILLING

<FOR HIGH-EFFICIENCY FINISHING OF ALUMINIUM ALLOYS>

TOOL NEWS

90° KAPR

F

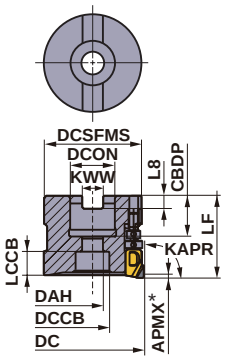
FMAX

P | M | K | **N** | S | H

Non-ferrous Metal

Fig.1

ø40
ø50
ø63



Right hand tool holder only.

■ARBOR TYPE

KAPR: 90°
GAMP: +5° GAMF: -6°– -3°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	Dimensions (mm) DCON	WT (kg)	RPMX (min-1)	Fig.
NEW 40	**FMAX-040A04R**	●	○	4	40	16	0.24	30000	1
NEW 40	**FMAX-040A06R**	●	○	6	40	16	0.23	30000	1
50	**FMAX-050A08R**	●	○	8	40	22	0.37	30000	1
50	**FMAX-050A10R**	●	○	10	40	22	0.35	30000	1
63	**FMAX-063A10R**	●	○	10	40	22	0.67	27000	1
63	**FMAX-063A12R**	●	○	12	40	22	0.66	27000	1

* For the maximum depth of cut (APMX), please refer to recommended cutting conditions (ap).
Note 1) The maximum depth of cut for should be 2mm or less for ultra high efficiency machining with table feed (vf ≥ 20000mm/min).

Mounting Dimensions

DCON (mm)	DC (mm)	Order Number	Dimensions (mm) CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	KWL	Fig.
16	40	**FMAX-040A04R**	18	9	14	10	37	8.4	5.6	–	1
16	40	**FMAX-040A06R**	18	9	14	10	37	8.4	5.6	–	1
22	50	**FMAX-050A08R**	20	11	17	12	47	10.4	6.3	–	1
22	50	**FMAX-050A10R**	20	11	17	12	47	10.4	6.3	–	1
22	63	**FMAX-063A10R**	20	11	17	12	60	10.4	6.3	–	1
22	63	**FMAX-063A12R**	20	11	17	12	60	10.4	6.3	–	1

SPARE PARTS

DC	Tool Holder Type	Insert Clamp* Screw	Micro Adjustment Nut	Large Adjustment Screw	Balance Adjustment Screw	Cutter Set Bolt	Wrench T10	Wrench ø2.5
40	**FMAX-040**	TSS04505S	KSN2	KSS2	HSS04004G	HSC08030H	TKY10T	RKY25S
50	**FMAX-050**	TSS04505S	KSN2	KSS2	HSS04004G	HSC10030H	TKY10T	RKY25S
63	**FMAX-063**	TSS04505S	KSN2	KSS2	HSS04004G	HSC10030H	TKY10T	RKY25S

* Clamp Torque (N • m) : TSS04505S = 3.5
Note 1) Please refer to the instruction manual included in the cutter body for how to locate the insert and adjust the run-out.

● : **Inventory maintained in Japan.**

Fig.2
ø80
ø160

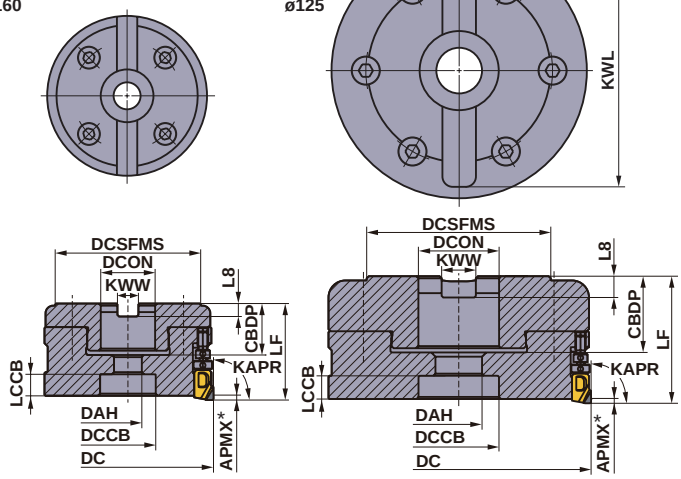


Fig.3
ø100
ø125

Right hand tool holder only.

■Arbor Type

KAPR: 90°
GAMP: +5° GAMF: 0°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm) LF	Dimensions (mm) DCON	WT (kg)	RPMX (min-1)	Fig.
80	**FMAXR08010C**	●	○	10	45	25.4	1.11	24500	2
80	**FMAXR08014C**	●	○	14	45	25.4	1.09	24500	2
100	**FMAXR10012D**	●	○	12	50	31.75	1.85	22000	3
100	**FMAXR10018D**	●	○	18	50	31.75	1.81	22000	3
125	**FMAXR12516E**	●	○	16	60	38.1	3.33	19600	3
125	**FMAXR12524E**	●	○	24	60	38.1	3.27	19600	3
NEW 160	**FMAXR16016D**	●	○	16	63	31.75	3.30	10000	2
NEW 160	**FMAXR16024D**	●	○	24	63	31.75	3.39	10000	2

* For the maximum depth of cut (APMX), please refer to recommended cutting conditions (ap).
Note 1) The maximum depth of cut for should be 2mm or less for ultra high efficiency machining with table feed (vf ≥ 20000mm/min).

Mounting Dimensions

DCON (mm)	DC (mm)	Order Number	Dimensions (mm) CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	KWL	Fig.
25.4	80	**FMAXR08010C**	24	13	26	11	68	9.5	6	—	2
25.4	80	**FMAXR08014C**	24	13	26	11	68	9.5	6	—	2
31.75	100	**FMAXR10012D**	32	17	32	10	79	12.7	8	90	3
31.75	100	**FMAXR10018D**	32	17	32	10	79	12.7	8	90	3
38.1	125	**FMAXR12516E**	36	22	38	12	88	15.9	10	112	3
38.1	125	**FMAXR12524E**	36	22	38	12	88	15.9	10	112	3
31.75	160	**FMAXR16016D**	38	17	53	10	75	12.7	8	—	2
31.75	160	**FMAXR16024D**	38	17	53	10	75	12.7	8	—	2

SPARE PARTS

DC	Tool Holder Type	Insert Clamp* Screw	Micro Adjustment Nut	Large Adjustment Screw	Balance Adjustment Screw	Cutter Set Bolt	Wrench T10	Wrench ø2.5
80	**FMAXR080**	TSS04505S	KSN2	KSS2	HSS05005G	HSCX12030H	TKY10T	RKY25S
100	**FMAXR100**	TSS04505S	KSN2	KSS2	HSS06006G	HSCX16035H	TKY10T	RKY25S
125	**FMAXR125**	TSS04505S	KSN2	KSS2	HSS08008G	HSCX20035H	TKY10T	RKY25S
160	**FMAXR160**	TSS04505S	KSN2	KSS2	HSS08008G	HSCX16045H	TKY10T	RKY25S

* Clamp Torque (N • m) : TSS04505S = 3.5
Note 1) Please refer to the instruction manual included in the cutter body for how to locate the insert and adjust the run-out.

Metric Standard

The cutter bore diameter DCON is indicated in millimetres.

Fig.1

ø80
ø160

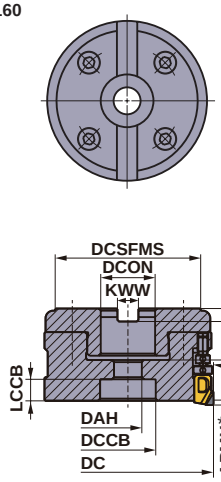
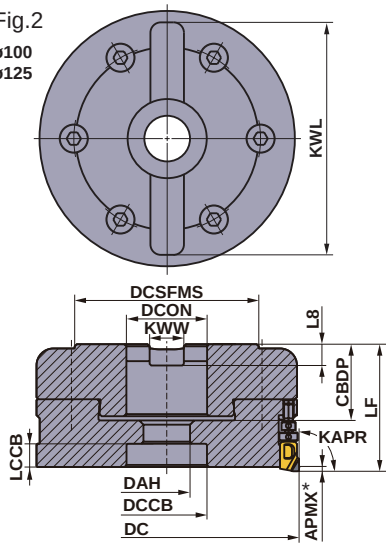


Fig.2

ø100
ø125



Right hand tool holder only.

■Arbor Type

KAPR: 90°
GAMP: +5° GAMF: 0°

DC (mm)	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm)		WT (kg)	RPMX (min-1)	Fig.
					LF	DCON			
80	**FMAX-080B14R**	●	○	14	45	27	1.08	24500	1
100	**FMAX-100B18R**	●	○	18	50	32	1.81	22000	2
125	**FMAX-125B24R**	●	○	24	60	40	3.26	19600	2

* For the maximum depth of cut (APMX), please refer to recommended cutting conditions (ap).
Note 1) The maximum depth of cut for should be 2mm or less for ultra high efficiency machining with table feed (vf ≥ 20000mm/min).

Mounting Dimensions

DCON (mm)	DC (mm)	Order Number	Dimensions (mm)								Fig.
			CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	KWL	
27	80	**FMAX-080B14R**	24	13	26	11	68	12.4	7	—	1
32	100	**FMAX-100B18R**	32	17	32	10	79	14.4	8	90	2
40	125	**FMAX-125B24R**	36	22	38	12	88	16.4	9	112	2

SPARE PARTS

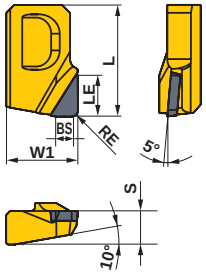
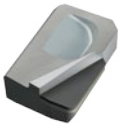
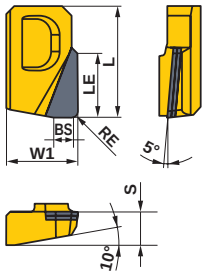
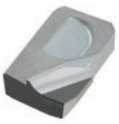
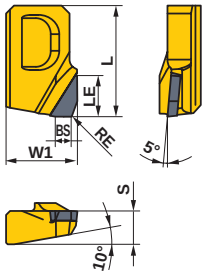
DC	Tool Holder Type	Insert Clamp Screw*	Micro Adjustment Nut	Large Adjustment Screw	Balance Adjustment Screw	Cutter Set Bolt	Wrench T10	Wrench ø2.5
80	**FMAX-080**	TSS04505S	KSN2	KSS2	HSS05005G	HSCX12030H	TKY10T	RKY25S
100	**FMAX-100**	TSS04505S	KSN2	KSS2	HSS06006G	HSCX16035H	TKY10T	RKY25S
125	**FMAX-125**	TSS04505S	KSN2	KSS2	HSS08008G	HSCX20035H	TKY10T	RKY25S

* Clamp Torque (N • m) : TSS04505S = 3.5
Note 1) Please refer to the instruction manual included in the cutter body for how to locate the insert and adjust the run-out.

● : Inventory maintained. (PCD inserts are available in 1 piece in one case)

INSERTS

Work Material	N	Non-ferrous Metal	◐	◐	Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	MD220	MD2030	Dimensions (mm) L	LE	W1	S	BS	RE	Geometry
General Purpose	GOER1404PXFR2	●	●	14.0	5.0	9.0	4.2	2.0	0.4	
	GOER1408PXFR2	●	●	14.0	5.0	9.0	4.2	2.0	0.8	
 Long Edge	NEW GOER1408PXFR2-8	●		14.0	8.0	9.0	4.2	2.0	0.8	
 Burr Prevention	NEW GOER1401ZXFR2	●		14.0	5.0	9.0	4.2	2.0	0.1	

Note 1) If general purpose inserts (RE = 0.4mm, 0.8mm), burr prevention inserts and long edge inserts are used together, they will not be able to sufficiently display their full performance. Inserts of the same shape should be used according to the application.
Note 2) The cutting diameter will change depending on the shape.
Be particularly careful when cutting near vertical walls, since there is a possibility of interference with the holder.
Note 3) The long edge inserts corresponds to the gate remainder and can not be used for constant depth cutting.

RECOMMENDED CUTTING CONDITIONS

■ Wet cutting

Work Material		Characteristics	Grade	vc (m/min)	Depth of Cut (mm) ae	ap	fz (mm/t.)
N	Aluminium Alloy	Si < 5%	MD2030 MD220	2500 (2000—3000)	≤ 0.2 DC	≤ 3.0(0.5—3.0)	0.08 (0.05—0.2)
					≤ 0.5 DC	≤ 2.5(0.5—2.5)	
					≤ 0.8 DC	≤ 2.0(0.5—2.0)	
		5% ≤ Si ≤ 10%	MD2030 MD220	2500 (2000—3000)	≤ 0.2 DC	≤ 3.0(0.5—3.0)	0.08 (0.05—0.2)
					≤ 0.5 DC	≤ 2.5(0.5—2.5)	
					≤ 0.8 DC	≤ 2.0(0.5—2.0)	
		10% <Si < 15%	MD2030 MD220	600 (400—800)	≤ 0.2 DC	≤ 3.0(0.5—3.0)	0.08 (0.05—0.2)
					≤ 0.5 DC	≤ 2.5(0.5—2.5)	
					≤ 0.8 DC	≤ 2.0(0.5—2.0)	
		Si ≥ 15%	MD2030 MD220	600 (400—800)	≤ 0.2 DC	≤ 3.0(0.5—3.0)	0.08 (0.05—0.2)
					≤ 0.5 DC	≤ 2.5(0.5—2.5)	
					≤ 0.8 DC	≤ 2.0(0.5—2.0)	

Note 1) Please adjust the depth of cut depending on the width of cut.
Note 2) When using the long edge insert, please select the conditions depending on depths of cut (ap) excluding the length of the gate.
Note 3) Wet cutting is recommended.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

FACE MILLING

<HIGH SPEED FINISHING ALUMINIUM ALLOY >

TOOL NEWS

90° KAPR

F

V10000

P | M | K | **N** | S | H

Non-ferrous Metal

- **Insert with PCD.**
- **Light weight, strong aluminium alloy cutter body.**
- **Anti-Fly insert mechanism enables high speed milling.**
- **Adjustable cutting edge run-out function.**

Fig.1
ø63

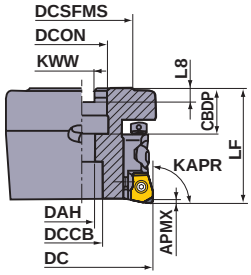
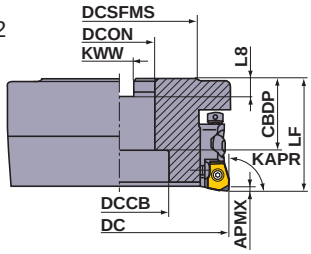


Fig.2
ø80
ø100
ø125



Right hand tool holder only.

KAPR :90°
GAMP:+8° GAMF:+8°

Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT* (kg)	APMX (mm)	Max. Allowable Revolution (min^{-1})	Fig.
V10000-063A04R	●	4	63	50	22	20	11	—	45	10.4	6.3	0.5	1.5	25000	1
V10000R0305C	●	5	80	50	25.4	26	—	38	60	9.5	6	0.6	1.5	22300	2
V10000R0406D	●	6	100	50	31.75	32	—	45	70	12.7	8	0.9	1.5	20000	2
V10000R0508E	●	8	125	63	38.1	35	—	60	80	15.9	10	1.8	1.5	17800	2

* WT : Tool Weight

SPARE PARTS

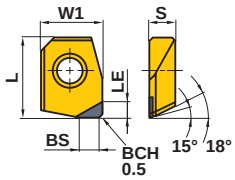
Tool Holder Number	Cartridge	* Cartridge Clamp Screw-A	* Cartridge Clamp Screw-B	* Insert Clamp Screw	Run-out Adjust Screw	Balance Adjust Screw	Wrench	Wrench
V10000-063A04R ~ V10000R0508E	VCT13R	HBH06016	HBH04008	CS350790T	KS1	HSS05005	HKY25R HKY40R	TKY10R

* Clamp Torque (N • m) : CS350790T=3.5, HBH06016=8.0, HBH04008=4.0

● : **Inventory maintained in Japan. (1 insert in one case)**

INSERTS

Work Material	N	Non-ferrous Metal	◐	Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	PCD	Dimensions(mm)						Geometry
			MD220	L	W1	IC	S	BS	LE	
	NP-GDCW1240PDFR2	C	●	12	9.5	–	4	2	2	

RECOMMENDED CUTTING CONDITIONS

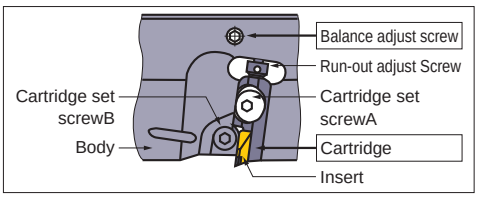
Work Material		Silicon (%)	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Depth of Cut (mm)
N	Aluminium Alloy	≤16	–6500	–0.2	–0.5
		≥16	–1000		

■NOTE ON ROTATIONAL BALANCE

- ● At the time of shipping, the cutter body is balanced by using a special high accuracy master insert in order that it will conform to balance quality G6.3 based on ISO 1940/1 (approximate value at the maximum revolution for each cutter diameter). In order to keep good rotational balance, do not adjust the balance screw (HSS05005) located on the outer surface of the body.
- ● Rotational balance will change after exchanging cartridges. If you use the cutter at the same revolution as that of the following table or higher, re-balancing is necessary after exchanging cartridges. Please contact Mitsubishi Materials to re-balance the cutter.

Note 1) If the revolution is the same as or lower than the value indicated above, the cutter can be used with a standard arbor. (Do not use long shank type arbors or special arbors, as the overhang could make it dangerous to use.)

Note 2) If the revolution is higher than the value indicated above, please set the balance as follows : (Arbor + cutter)≤G6.3



Diameter of cutter (mm)	Revolution requiring re-balancing (min^{-1})
63	17000
80	14500
100	14000
125	Re-balancing not necessary up to the max. revolution

FACE MILLING

<FOR ALUMINIUM ALLOY AND CAST IRON / HIGH FEED RATE AND FINISHING>

TOOL NEWS

90° KAPR

F

NF10000

P | M | **K** | **N** | S | H

Cast Iron — Non-ferrous Metal

- **Suitable for high-speed finishing of light alloy and cast iron.**
- **Adjustable cutting edge run-out function.**

Fig.1
ø80
ø100

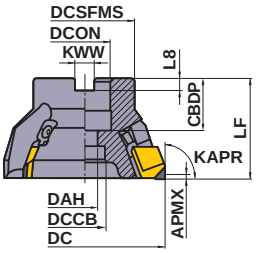
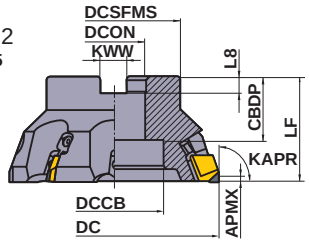


Fig.2
ø125



Right hand tool holder only.

KAPR :90°
GAMP:+10° GAMF:+5°

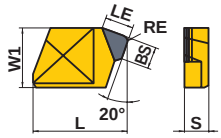
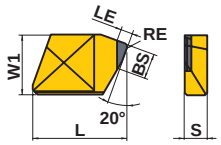
Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT*2 (kg)	APMX (mm) PCD	CBN	Max.*1 Allowable Revolution (min^{-1})	Fig.
Coarse Pitch	**NF10000R0305C**	●	5	80	50	25.4	26	13	—	50	9.5	6	1.0	4.0	1.0	16000	1
	NF10000R0406D	●	6	100	63	31.75	32	17	—	60	12.7	8	1.8	4.0	1.0	14000	1
	NF10000R0508E	●	8	125	63	38.1	38	—	60	80	15.9	10	2.7	4.0	1.0	12000	2
Fine Pitch	**NF10000R0306C**	●	6	80	50	25.4	26	13	—	50	9.5	6	1.0	4.0	1.0	16000	1
	NF10000R0408D	●	8	100	63	31.75	32	17	—	60	12.7	8	1.8	4.0	1.0	14000	1
	NF10000R0510E	●	10	125	63	38.1	38	—	60	80	15.9	10	2.7	4.0	1.0	12000	2

*1 Ensure max. spindle speed is achieved under the conditions that the cutter is clamped by a machine clamping force of 18kN with a standard type arbor. (HSK 63A-FMA○○○-60) The figure varies in actual machining depending on cutting conditions, such as the length of overhang or if there is insufficient drawing force from the arbor.

*2 WT : Tool Weight

● : Inventory maintained in Japan. (1 insert in one case)

INSERTS

Work Material																		
	K	Cast Iron				◐			**Cutting Conditions (Guide) :**									
	N	Non-ferrous Metal		◐					● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting									
Shape	Order Number	Class	PCD		CBN		Dimensions(mm)						Geometry					
			MD220		MB730		L	W1	S	BS	LE	RE						
	GDCN2004PDFR3	C	●				20	12.7	4.76	3	5	1.2						
	NP-GDCN2004PDSR3	C			●		20	12.7	4.76	3	2.5	0.8						

SPARE PARTS

Tool Holder Number	Wedge	* Clamp Screw	Wrench
NF10000R0305C ~ NF10000R0510E	CWAF10R1	LS10T	TKY25T

* Clamp Torque (N • m) : LS10T=8.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K	Gray Cast Iron	**MB730**	1000 (800－1500)	0.15 (0.05－0.5)
N	Aluminium Alloy	**MD220**	3500 (1000－4500)	0.12 (0.05－0.20)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

FACE MILLING

<GENERAL HIGH FEED FINISHING>

90° KAPR

F

FF3000

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		

- 11°positive insert.
- 1000－3000mm/min high feed machining.
- For finishing of steel machining.
- Adjustable cutting edge run-out function.

Fig.1

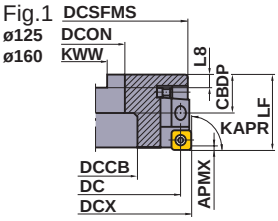
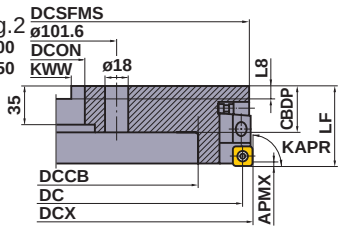


Fig.2



Right hand tool holder only.

KAPR :90°
GAMP :+5° GAMF :-15°

Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	DCX	LF	DCON	CBDP	DCCB	DCSFMS	KWW	L8	WT* (kg)	APMX (mm)	Fig.
FF3000R0502E	●	2	125	140.4	75	38.1	38	60	85	15.9	10	5.8	0.3	1
FF3000R0602F	●	2	160	175.4	75	50.8	38	80	110	19.1	11	9.0	0.3	1
FF3000R0802K	●	2	200	215.4	75	47.625	45	134	130	25.4	14	12.6	0.3	2
FF3000R1002K	●	2	250	265.4	75	47.625	45	182	130	25.4	14	19.5	0.3	2

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	Cartridge	Shim	Lock Pin *	Cartridge Clamp Screw *	Washer	Radial Spring
FF3000R0502E - FF3000R1002K	FFCSR	FFSS	FFP	HBH08040	FFW	FFRP
						① ②
	Adjusting Wedge	Adjusting Screw	Lever	Lever Screw	Axial Spring	Wrench
	FFAWR	LS3	FFL	FFLB	HP3	①HKY25L ②HKY40T

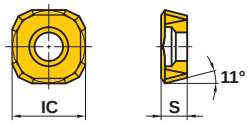
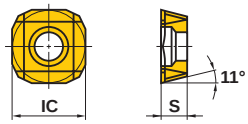
* Clamp Torque (N • m) : FFP=2.2, HBH08040=9.5

● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material			NX2525		HTi05T	
	P	Steel	●			
	M	Stainless Steel	●			
	K	Cast Iron	●		●	
	N	Non-ferrous Metal			●	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Cermet NX2525		Carbide HTi05T		Dimensions(mm) IC	Dimensions(mm) S	Geometry
	SPCA53Z	C	●				15.88	4.8	
	SPCG53Z	C	●		●		15.88	4.8	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**NX2525 (SPCG)**	280 (250−300)	2.25 (2−2.5)
P	Carbon Steel Alloy Steel	180−280HB	**NX2525 (SPCG)**	180 (150−220)	2.25 (2−2.5)
P	High Alloy Steel	200−280HB	**NX2525 (SPCA)**	120 (80−150)	2.25 (2−2.5)
M	Stainless Steel	≤200HB	**NX2525 (SPCA)**	250 (230−280)	3.0 (2.5−3.5)
K	Cast Iron	Tensile Strength ≤450MPa	**NX2525 (SPCG)**	180 (130−200)	2.25 (2−2.5)
K	Cast Iron	Tensile Strength ≤450MPa	**HTi05T**	120 (100−150)	2.25 (2−2.5)
N	Aluminium Alloy	–	**HTi05T**	≤500	0.85 (0.7−1.0)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)
=Feed per Tooth x Number of Teeth x Cutter Revolution

SHOULDER MILLING
<FOR CAST IRON>

TOOL NEWS

90° KAPR

VOX400

P | M | **K** | N | S | H

Cast Iron

- **Vertical inserts with high strength cutting edge.**
- **Economical 8 cutting edge inserts.**
- **Screw-on type.**

Fig.1

ø50
ø63
ø80

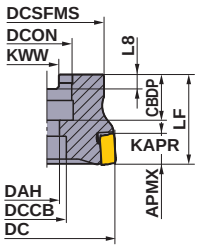


Fig.2

ø100
ø125
ø160

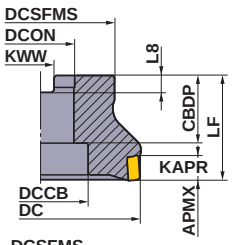
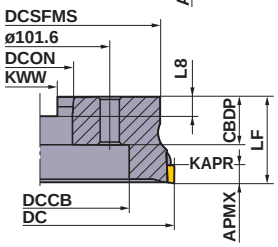


Fig.3

ø200
ø250



Right hand tool holder only.

■ ARBOR TYPE

KAPR :90°
GAMP:-6° GAMF:-18°

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	*2 WT (kg)	APMX (mm)	Fig.	*1 Clamp Screw	Wrench
Coarse Pitch	VOX400-050A03R	●	3	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1	CS401160T	TKY15T
	VOX400-063A04R	●	4	63	40	22	20	11	17	50	10.4	6.3	0.6	10	1	CS401160T	TKY15T
	VOX400R08004C	●	4	80	50	25.4	26	13	20	55	9.5	6	1.0	10	1	CS401160T	TKY15T
	VOX400R10006D	●	6	100	50	31.75	32	—	45	70	12.7	8	1.5	10	2	CS401160T	TKY15T
	VOX400R12508E	●	8	125	63	38.1	40	—	60	80	15.9	10	2.7	10	2	CS401160T	TKY15T
	VOX400R16010F	●	10	160	63	50.8	43	—	80	120	19.1	11	5.3	10	2	CS401160T	TKY15T
	VOX400R20012K	●	12	200	63	47.625	35	—	130	175	25.4	14.22	8.5	10	3	CS401160T	TKY15T
	VOX400R25016K	●	16	250	63	47.625	35	—	180	220	25.4	14.22	13.3	10	3	CS401160T	TKY15T
Fine Pitch	VOX400-050A05R	●	5	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1	CS401160T	TKY15T
	VOX400-063A06R	●	6	63	40	22	20	11	17	50	10.4	6.3	0.6	10	1	CS401160T	TKY15T
	VOX400R08008C	●	8	80	50	25.4	26	13	20	55	9.5	6	1.0	10	1	CS401160T	TKY15T
	VOX400R10010D	●	10	100	50	31.75	32	—	45	70	12.7	8	1.5	10	2	CS401160T	TKY15T
	VOX400R12512E	●	12	125	63	38.1	40	—	60	80	15.9	10	2.7	10	2	CS401160T	TKY15T
	VOX400R16016F	●	16	160	63	50.8	43	—	80	120	19.1	11	5.3	10	2	CS401160T	TKY15T
	VOX400R20020K	●	20	200	63	47.625	35	—	130	175	25.4	14.22	8.5	10	3	CS401160T	TKY15T
	VOX400R25024K	●	24	250	63	47.625	35	—	180	220	25.4	14.22	13.3	10	3	CS401160T	TKY15T
Extra Fine Pitch	VOX400-063A08R	●	8	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1	CS401160T	TKY15T
	VOX400R08010C	●	10	80	50	25.4	26	13	20	55	9.5	6	1.0	10	1	CS401160T	TKY15T
	VOX400R10012D	●	12	100	50	31.75	32	—	45	70	12.7	8	1.4	10	2	CS401160T	TKY15T
	VOX400R12516E	●	16	125	63	38.1	40	—	60	80	15.9	10	2.6	10	2	CS401160T	TKY15T
	VOX400R16020F	●	20	160	63	50.8	43	—	80	120	19.1	11	5.1	10	2	CS401160T	TKY15T
	VOX400R20026K	●	26	200	63	47.625	35	—	130	175	25.4	14.22	8.2	10	3	CS401160T	TKY15T
	VOX400R25034K	●	34	250	63	47.625	35	—	180	220	25.4	14.22	13.0	10	3	CS401160T	TKY15T

*1 Clamp Torque (N • m) : CS401160T=3.5
*2 WT : Tool Weight

● : Inventory maintained in Japan.

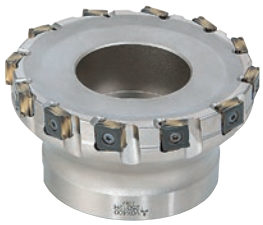


Fig.1

ø50
ø63
ø80

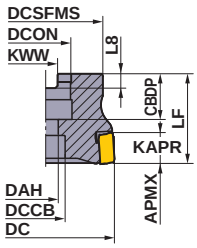


Fig.2

ø100
ø125

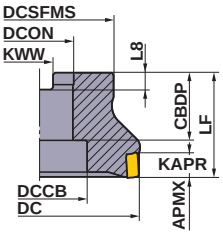
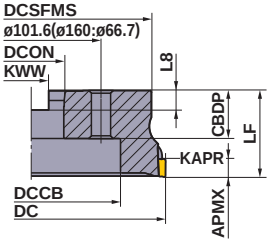


Fig.3

ø160
ø200
ø250



Right hand tool holder only.

For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

■ ARBOR TYPE

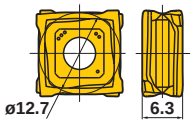
Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	*2 WT (kg)	APMX (mm)	Fig.	*1 Clamp Screw	Wrench
Coarse Pitch	**VOX400-050A03R**	●	3	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1	CS401160T	TKY15T
	VOX400-063A04R	●	4	63	40	22	20	11	17	50	10.4	6.3	0.6	10	1	CS401160T	TKY15T
	VOX400-080A04R	●	4	80	50	27	23	13	20	56	12.4	7	1	10	1	CS401160T	TKY15T
	VOX400-100B06R	●	6	100	50	32	32	—	45	78	14.4	8	1.7	10	2	CS401160T	TKY15T
	VOX400-125B08R	●	8	125	63	40	32	—	56	89	16.4	9	3	10	2	CS401160T	TKY15T
	VOX400-160C10R	●	10	160	63	40	29	—	56	120	16.4	9	5.4	10	3	CS401160T	TKY15T
	VOX400-200C12R	●	12	200	63	60	32	—	130	175	25.7	14.22	8.1	10	3	CS401160T	TKY15T
	VOX400-250C16R	●	16	250	63	60	32	—	180	210	25.7	14.22	11.8	10	3	CS401160T	TKY15T
Fine Pitch	**VOX400-050A05R**	●	5	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1	CS401160T	TKY15T
	VOX400-063A06R	●	6	63	40	22	20	11	17	50	10.4	6.3	0.6	10	1	CS401160T	TKY15T
	VOX400-080A08R	●	8	80	50	27	23	13	20	56	12.4	7	1	10	1	CS401160T	TKY15T
	VOX400-100B10R	●	10	100	50	32	32	—	45	78	14.4	8	1.7	10	2	CS401160T	TKY15T
	VOX400-125B12R	●	12	125	63	40	32	—	56	89	16.4	9	3	10	2	CS401160T	TKY15T
	VOX400-160C16R	●	16	160	63	40	29	—	56	120	16.4	9	5.4	10	3	CS401160T	TKY15T
	VOX400-200C20R	●	20	200	63	60	32	—	130	175	25.7	14.22	8.1	10	3	CS401160T	TKY15T
	VOX400-250C24R	●	24	250	63	60	32	—	180	210	25.7	14.22	11.8	10	3	CS401160T	TKY15T
Extra Fine Pitch	**VOX400-063A08R**	●	8	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1	CS401160T	TKY15T
	VOX400-080A10R	●	10	80	50	27	23	13	20	56	12.4	7	1.0	10	1	CS401160T	TKY15T
	VOX400-100B12R	●	12	100	50	32	32	—	45	78	14.4	8	1.6	10	2	CS401160T	TKY15T
	VOX400-125B16R	●	16	125	63	40	32	—	56	89	16.4	9	2.8	10	2	CS401160T	TKY15T
	VOX400-160C20R	●	20	160	63	40	29	—	56	120	16.4	9	5.2	10	3	CS401160T	TKY15T
	VOX400-200C26R	●	26	200	63	60	32	—	130	175	25.7	14.22	7.9	10	3	CS401160T	TKY15T
	VOX400-250C34R	●	34	250	63	60	32	—	180	210	25.7	14.22	11.5	10	3	CS401160T	TKY15T

*1 Clamp Torque (N • m) : CS401160T=3.5
*2 WT : Tool Weight

INSERTS

Work Material	K	Cast Iron

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

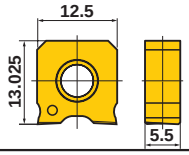
Shape	Order Number	Class	Honing	Coated MC5020	Coated VP15TF	Geometry
	SONX1206PER	N	E	●	●	 Right hand tool holder shown.
	SONX1206PEL	N	E		●	

* Left hand insert use for the side cutter (special products).
Please refer to the TOOL NEWS B242B Side Cutter Series.

WIPER INSERTS

Work Material	K	Cast Iron

Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	Class	Honing	Coated VP15TF	Geometry
	WOEX1206PER5C	E	E	●	

RECOMMENDED CUTTING CONDITIONS

■ VOX400 (Standard Pitch)

Work Material		Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ50－ϕ250 Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250－350)	≤DC	≤10	0.4(0.3－0.5)
			VP15TF	250(200－300)	≤DC	≤10	0.4(0.3－0.5)
		≤350MPa	MC5020	220(150－300)	≤DC	≤10	0.3(0.2－0.4)
			VP15TF	200(150－300)	≤DC	≤10	0.3(0.2－0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150－250)	≤DC	≤10	0.3(0.2－0.4)
			VP15TF	170(150－200)	≤DC	≤10	0.3(0.2－0.4)
		≤800MPa	MC5020	170(150－200)	≤DC	≤10	0.2(0.1－0.3)
			VP15TF	150(100－200)	≤DC	≤10	0.2(0.1－0.3)

■ VOX400 (Fine Pitch)

Work Material		Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ50,ϕ63 Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	ϕ80 Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250－350)	≤DC	≤10	0.4(0.3－0.5)	≤DC	≤10	0.4(0.3－0.5)
			VP15TF	250(200－300)	≤DC	≤10	0.4(0.3－0.5)	≤DC	≤10	0.4(0.3－0.5)
		≤350MPa	MC5020	220(150－300)	≤DC	≤10	0.3(0.2－0.4)	≤DC	≤10	0.3(0.2－0.4)
			VP15TF	200(150－300)	≤DC	≤10	0.3(0.2－0.4)	≤DC	≤10	0.3(0.2－0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150－250)	≤0.8DC	≤10	0.3(0.2－0.4)	≤0.6DC	≤10	0.3(0.2－0.4)
			VP15TF	170(150－200)	≤0.8DC	≤10	0.3(0.2－0.4)	≤0.6DC	≤10	0.3(0.2－0.4)
		≤800MPa	MC5020	170(150－200)	≤0.8DC	≤10	0.2(0.1－0.3)	≤0.6DC	≤10	0.2(0.1－0.3)
			VP15TF	150(100－200)	≤0.8DC	≤10	0.2(0.1－0.3)	≤0.6DC	≤10	0.2(0.1－0.3)

Work Material		Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ100 Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	ϕ125 Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250－350)	≤DC	≤10	0.4(0.3－0.5)	≤DC	≤10	0.4(0.3－0.5)
			VP15TF	250(200－300)	≤DC	≤10	0.4(0.3－0.5)	≤DC	≤10	0.4(0.3－0.5)
		≤350MPa	MC5020	220(150－300)	≤DC	≤10	0.3(0.2－0.4)	≤DC	≤10	0.3(0.2－0.4)
			VP15TF	200(150－300)	≤DC	≤10	0.3(0.2－0.4)	≤DC	≤10	0.3(0.2－0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150－250)	≤0.5DC	≤10	0.3(0.2－0.4)	≤0.4DC	≤10	0.3(0.2－0.4)
			VP15TF	170(150－200)	≤0.5DC	≤10	0.3(0.2－0.4)	≤0.4DC	≤10	0.3(0.2－0.4)
		≤800MPa	MC5020	170(150－200)	≤0.5DC	≤10	0.2(0.1－0.3)	≤0.4DC	≤10	0.2(0.1－0.3)
			VP15TF	150(100－200)	≤0.5DC	≤10	0.2(0.1－0.3)	≤0.4DC	≤10	0.2(0.1－0.3)

● : Inventory maintained in Japan.

	Work Material	Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ160			ϕ200−ϕ250		
					Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250−350)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
			VP15TF	250(200−300)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
		≤350MPa	MC5020	220(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
			VP15TF	200(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150−250)	≤0.3DC	≤10	0.3(0.2−0.4)	≤0.2DC	≤10	0.3(0.2−0.4)
			VP15TF	170(150−200)	≤0.3DC	≤10	0.3(0.2−0.4)	≤0.2DC	≤10	0.3(0.2−0.4)
		≤800MPa	MC5020	170(150−200)	≤0.3DC	≤10	0.2(0.1−0.3)	≤0.2DC	≤10	0.2(0.1−0.3)
			VP15TF	150(100−200)	≤0.3DC	≤10	0.2(0.1−0.3)	≤0.2DC	≤10	0.2(0.1−0.3)

Note 1) DC is cutter diameter.
Note 2) When using wiper insert, please reduce the feed per tooth to half the normal rate.

■VOX400 (Extra Fine Pitch)

	Work Material	Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ63			ϕ80		
					Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250−350)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
			VP15TF	250(200−300)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
		≤350MPa	MC5020	220(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
			VP15TF	200(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150−250)	≤0.6DC	≤10	0.3(0.2−0.4)	≤0.5DC	≤10	0.3(0.2−0.4)
			VP15TF	170(150−200)	≤0.6DC	≤10	0.3(0.2−0.4)	≤0.5DC	≤10	0.3(0.2−0.4)
		≤800MPa	MC5020	170(150−200)	≤0.6DC	≤10	0.2(0.1−0.3)	≤0.5DC	≤10	0.2(0.1−0.3)
			VP15TF	150(100−200)	≤0.6DC	≤10	0.2(0.1−0.3)	≤0.5DC	≤10	0.2(0.1−0.3)

	Work Material	Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ100			ϕ125		
					Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250−350)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
			VP15TF	250(200−300)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
		≤350MPa	MC5020	220(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
			VP15TF	200(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150−250)	≤0.4DC	≤10	0.3(0.2−0.4)	≤0.3DC	≤10	0.3(0.2−0.4)
			VP15TF	170(150−200)	≤0.4DC	≤10	0.3(0.2−0.4)	≤0.3DC	≤10	0.3(0.2−0.4)
		≤800MPa	MC5020	170(150−200)	≤0.4DC	≤10	0.2(0.1−0.3)	≤0.3DC	≤10	0.2(0.1−0.3)
			VP15TF	150(100−200)	≤0.4DC	≤10	0.2(0.1−0.3)	≤0.3DC	≤10	0.2(0.1−0.3)

	Work Material	Tensile Strength	Insert Grade	Cutting Speed (m/min)	ϕ160			ϕ200−ϕ250		
					Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)	Radial Depth of Cut ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)
K	Gray Cast Iron	≤200MPa	MC5020	300(250−350)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
			VP15TF	250(200−300)	≤DC	≤10	0.4(0.3−0.5)	≤DC	≤10	0.4(0.3−0.5)
		≤350MPa	MC5020	220(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
			VP15TF	200(150−300)	≤DC	≤10	0.3(0.2−0.4)	≤DC	≤10	0.3(0.2−0.4)
	Ductile Cast Iron	≤450MPa	MC5020	200(150−250)	≤0.25DC	≤10	0.3(0.2−0.4)	≤0.15DC	≤10	0.3(0.2−0.4)
			VP15TF	170(150−200)	≤0.25DC	≤10	0.3(0.2−0.4)	≤0.15DC	≤10	0.3(0.2−0.4)
		≤800MPa	MC5020	170(150−200)	≤0.25DC	≤10	0.2(0.1−0.3)	≤0.15DC	≤10	0.2(0.1−0.3)
			VP15TF	150(100−200)	≤0.25DC	≤10	0.2(0.1−0.3)	≤0.15DC	≤10	0.2(0.1−0.3)

Note 1) DC is cutter diameter.
Note 2) When using wiper insert, please reduce the feed per tooth to half the normal rate.

SHOULDER MILLING
<GENERAL CUTTING>

TOOL NEWS

90° KAPR

ASX400

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

Fig.1
ø50
ø63

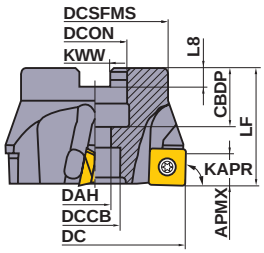


Fig.2
ø80
ø100
ø125
ø160

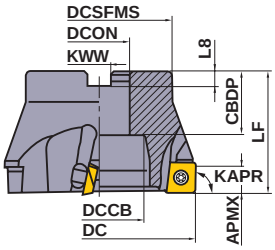
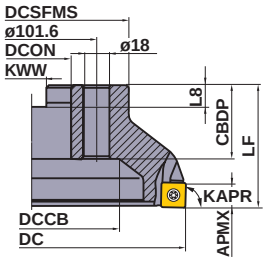


Fig.3
ø200
ø250



- **High tolerance M-class inserts.**
- **Economical 4 cutting edge inserts.**
- **Curved cutting edge and high rigidity holder.**
- **Screw-on type.**

■ ARBOR TYPE

No coolant hole

KAPR :90°
GAMP:+11°
GAMF:-9°—-11°

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT* (kg)	APMX (mm)	Fig.
				Dimensions(mm)											
Coarse Pitch	**ASX400-050A03R**	●	3	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1
	ASX400-063A04R	●	4	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1
	ASX400R08004C	●	4	80	50	25.4	26	—	38	60	9.5	6	1.0	10	2
	ASX400R10005D	●	5	100	50	31.75	32	—	45	70	12.7	8	1.5	10	2
	ASX400R12506E	●	6	125	63	38.1	35	—	60	80	15.9	10	2.5	10	2
	ASX400R16008F	●	8	160	63	50.8	38	—	90	100	19.1	11	4.0	10	2
	ASX400R20010K	●	10	200	63	47.625	35	—	135	160	25.4	14.22	7.0	10	3
	ASX400R25012K	●	12	250	63	47.625	35	—	180	210	25.4	14.22	12.0	10	3
Fine Pitch	**ASX400-050A04R**	●	4	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1
	ASX400-063A05R	●	5	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1
	ASX400R08006C	●	6	80	50	25.4	26	—	38	60	9.5	6	1.0	10	2
	ASX400R10007D	●	7	100	50	31.75	32	—	45	70	12.7	8	1.5	10	2
	ASX400R12508E	●	8	125	63	38.1	35	—	60	80	15.9	10	2.5	10	2
	ASX400R16012F	●	12	160	63	50.8	38	—	90	100	19.1	11	4.0	10	2
	ASX400R20016K	●	16	200	63	47.625	35	—	135	160	25.4	14.22	7.0	10	3
	ASX400R25018K	●	18	250	63	47.625	35	—	180	210	25.4	14.22	12.0	10	3

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	Shim	* Shim Screw	* Clamp Screw	Wrench (Insert)	Wrench (Shim)
ASX400	STASX400N	WCS503507H	TPS35	TIP15T	HKY35R

* Clamp Torque (N • m) : WCS503507H=5.0, TPS35=3.5

● : **Inventory maintained in Japan.**

Fig.1

ø50
ø63

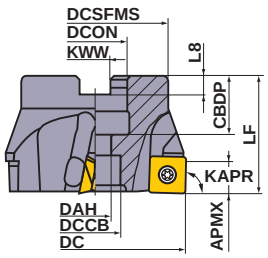


Fig.2

ø80
ø100
ø125

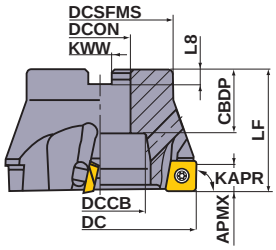


Fig.3

ø160

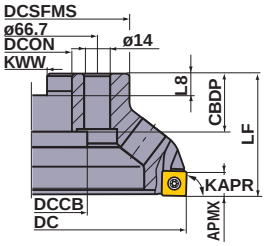
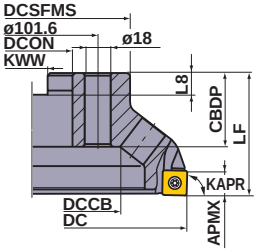


Fig.4

ø200
ø250



For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

■ ARBOR TYPE

No coolant hole

KAPR :90°
GAMP:+11°

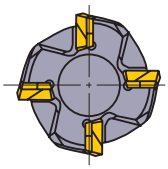
GAMF:-9°–-11°

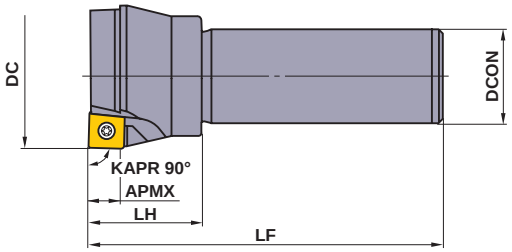
Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	CBDP	DAH	DCCB	DCSFMS	KWW	L8	WT * (kg)	APMX (mm)	Fig.
Coarse Pitch	**ASX400-050A03R**	●	3	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1
	ASX400-063A04R	●	4	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1
	ASX400-080B04R	●	4	80	50	27	29	–	38	60	12.4	7	0.9	10	2
	ASX400-100B05R	●	5	100	50	32	32	–	45	70	14.4	8	1.4	10	2
	ASX400-125B06R	●	6	125	63	40	32	–	60	80	16.4	9	2.3	10	2
	ASX400-160C08R	●	8	160	63	40	29	–	56	100	16.4	9	3.6	10	3
	ASX400-200C10R	●	10	200	63	60	32	–	135	160	25.7	14.22	6.3	10	4
	ASX400-250C12R	●	12	250	63	60	32	–	180	210	25.7	14.22	10.8	10	4
Fine Pitch	**ASX400-050A04R**	●	4	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1
	ASX400-063A05R	●	5	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1
	ASX400-080B06R	●	6	80	50	27	29	–	38	60	12.4	7	0.9	10	2
	ASX400-100B07R	●	7	100	50	32	32	–	45	70	14.4	8	1.4	10	2
	ASX400-125B08R	●	8	125	63	40	32	–	60	80	16.4	9	2.2	10	2
	ASX400-160C12R	●	12	160	63	40	29	–	56	100	16.4	9	3.5	10	3
	ASX400-200C16R	●	16	200	63	60	32	–	135	160	25.7	14.22	6.2	10	4
	ASX400-250C18R	●	18	250	63	60	32	–	180	210	25.7	14.22	10.7	10	4
Extra Fine Pitch	**ASX400-050A05R**	●	5	50	40	22	20	11	17	41	10.4	6.3	0.3	10	1
	ASX400-063A06R	●	6	63	40	22	20	11	17	50	10.4	6.3	0.5	10	1
	ASX400-080B08R	●	8	80	50	27	29	–	38	60	12.4	7	0.9	10	2
	ASX400-100B10R	●	10	100	50	32	32	–	45	70	14.4	8	1.4	10	2
	ASX400-125B12R	●	12	125	63	40	32	–	60	80	16.4	9	2.1	10	2
	ASX400-160C15R	●	15	160	63	40	29	–	56	100	16.4	9	3.4	10	3
	ASX400-200C19R	●	19	200	63	60	32	–	135	160	25.7	14.22	6.2	10	4
	ASX400-250C22R	●	22	250	63	60	32	–	180	210	25.7	14.22	10.5	10	4

* WT : Tool Weight

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001





■ SHANK TYPE

No coolant hole

Right hand tool holder only.

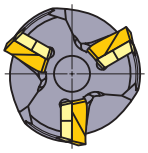
Type	Order Number	Stock	Number of Teeth	Dimensions(mm)				
		R		DC	LF	DCON	LH	APMX
Coarse Pitch	**ASX400R403S32**	●	3	40	125	32	40	10
	ASX400R503S32	●	3	50	125	32	40	10
	ASX400R634S32	●	4	63	125	32	40	10
	ASX400R804S32	●	4	80	125	32	40	10
Fine Pitch	**ASX400R504S32**	●	4	50	125	32	40	10
	ASX400R635S32	●	5	63	125	32	40	10
	ASX400R806S32	●	6	80	125	32	40	10

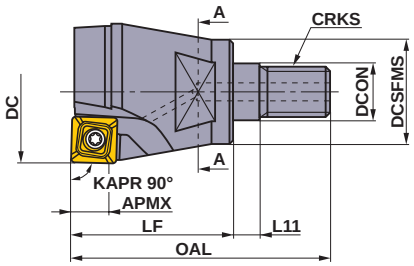
SPARE PARTS

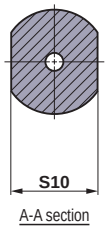
Tool Holder Number		*	*		
	Shim	Shim Screw	Clamp Screw	Wrench (Insert)	Wrench (Shim)
ASX400	STASX400N	WCS503507H	TPS35	TIP15T	HKY35R

* Clamp Torque (N • m) : WCS503507H=5.0, TPS35=3.5

● : **Inventory maintained in Japan.**







■ SCREW-IN TYPE

Right hand tool holder only.

With Coolant Hole

Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm)									*1 WT		*2	*2		
	R			DC	DCON	DCSFMS	OAL	LF	L11	S10	CRKS	APMX	(kg)	Shim	Shim Screw	Clamp Screw	Wrench (Insert)	Wrench (Shim)
ASX400R322AM1640	●	○	2	32	17	29	63	40	6	24	M16	10	0.3	–	WCS503507H	TPS35	TIP15T	HKY35R
ASX400R403AM1645	●	○	3	40	17	29	68	45	6	24	M16	10	0.3	STASX400N	WCS503507H	TPS35	TIP15T	HKY35R

*1 WT : Tool Weight

*2 Clamp Torque (N • m) : WCS503507H=5.0, TPS35=3.5

Note 1) For screw-in type arbors, refer to page M269.

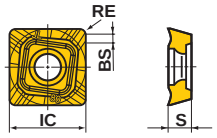
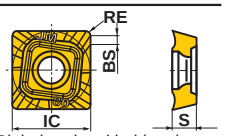
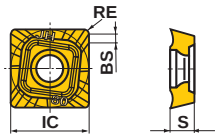
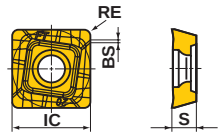
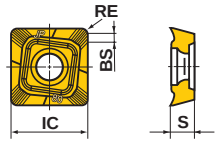
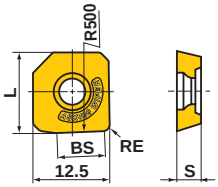
ARBORS ➢ M269
SPARE PARTS ➢ Q001
TECHNICAL DATA ➢ R001

INSERTS

Work Material		F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545	NX2525	HTi10	HTi05T
P	Steel	General		General	Unstable					General	Unstable	General	Stable		
M	Stainless Steel	General				General	Unstable			General	Unstable	General	General		
K	Cast Iron		General							Unstable	Unstable		Stable	General	General
N	Non-ferrous Metal													General	General
S	Heat-resistant Alloy, Titanium Alloy							General	Unstable	General	Unstable				
H	Hardened Steel									General					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting
✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp **T :** Chamfer

Application	Shape	Order Number	Class	Honing	F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545	NX2525	HTi10	HTi05T	L	IC	S	BS	RE	Geometry
					Coated										Cermet		Carbide		Dimensions (mm)					
Finish–Light Cutting	**JL** Breaker	**SOET12T308PEER-JL**	E	E	●		●	●	●	●	●	●	●	●	●				–	12.7	3.97	1.4	0.8	
Light–Rough Cutting	**JM** Breaker	**SOMT12T308PEER-JM**	M	E	●	●	●	●	●	●	●	●	●	●	●				–	12.7	3.97	1.4	0.8	 Right hand tool holder shown.
		SOMT12T308PEEL-JM	M	E									●						–	12.7	3.97	1.4	0.8	
Medium–Heavy Cutting	**JH** Breaker	**SOMT12T308PEER-JH**	M	E	●	●	●	●	●	●	●	●	●	●					–	12.7	3.97	1.4	0.8	
Heavy Interrupted Cutting	**FT** Breaker	**SOMT12T320PEER-FT**	M	E		●	●				●	●	●						–	12.7	3.97	0.5	2.0	
For Aluminium Alloy	**JP** Breaker	**SOGT12T308PEFR-JP**	G	F													●		–	12.7	3.97	1.4	0.8	
Wiper		**WOEW12T308PEER8C**	E	E														●	13.2	–	3.97	8	0.8	
		WOEW12T308PETR8C	E	T												●			13.2	–	3.97	8	0.8	

● : Inventory maintained in Japan. (10 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)	Finish−Light Cutting		Light−Rough Cutting		Medium−Heavy Cutting	
					Feed per Tooth (mm/t.)	Breaker	Feed per Tooth (mm/t.)	Breaker	Feed per Tooth (mm/t.)	Breaker
P	Mild Steel	≤180HB	**F7030**	280 (210−350)	0.18 (0.08−0.28)	**JL**	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH**
			MP6120 VP15TF	250 (200−300)	0.18 (0.08−0.28)	**JL**	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH FT**
			MP6130	240 (190−290)	0.18 (0.08−0.28)	**JL**	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH**
			VP30RT	230 (180−280)	0.18 (0.08−0.28)	**JL**	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH**
			NX4545	180 (130−230)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	–	–
	Carbon Steel Alloy Steel	180−280HB	**F7030**	250 (200−300)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH**
			MP6120 VP15TF	220 (170−270)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH FT**
			MP6130	180 (150−230)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH**
			VP30RT	150 (120−180)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH**
			NX4545	150 (120−180)	0.13 (0.06−0.20)	**JL**	0.15 (0.10−0.25)	**JM**	–	–
		280−350HB	**F7030**	180 (130−230)	0.13 (0.06−0.20)	**JL**	0.15 (0.10−0.25)	**JM**	0.18 (0.10−0.28)	**JH**
			MP6120 VP15TF	140 (100−180)	0.13 (0.06−0.20)	**JL**	0.15 (0.10−0.25)	**JM**	0.18 (0.10−0.28)	**JH FT**
			MP6130	120 (90−150)	0.13 (0.06−0.20)	**JL**	0.15 (0.10−0.25)	**JM**	0.18 (0.10−0.28)	**JH**
			VP30RT	100 (80−160)	0.13 (0.06−0.20)	**JL**	0.15 (0.10−0.25)	**JM**	0.18 (0.10−0.28)	**JH**
			NX4545	100 (80−160)	0.10 (0.05−0.15)	**JL**	0.13 (0.10−0.20)	**JM**	–	–
M	Stainless Steel	≤270HB	**MP7130 VP15TF**	220 (170−270)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH FT**
			MP7140 VP30RT	200 (150−250)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	0.20 (0.10−0.30)	**JH**
			NX4545	150 (120−180)	0.15 (0.07−0.23)	**JL**	0.18 (0.10−0.28)	**JM**	–	–
K	Cast Iron Ductile Cast Iron	Tensile Strength ≤450MPa	**MC5020**	200 (150−250)	–	–	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH FT**
			VP15TF	180 (130−230)	0.18 (0.10−0.28)	**JL**	0.20 (0.10−0.30)	**JM**	0.25 (0.10−0.35)	**JH FT**
N	Aluminium Alloy	–	**HTi10**	650 (300−1000)	0.15 (0.10−0.20)	**JP**	0.20 (0.10−0.30)	**JP**	0.30 (0.20−0.40)	**JP**
S	Titanium Alloy	–	**MP9120 VP15TF**	50 (40−60)	0.12 (0.05−0.20)	**JL**	0.15 (0.05−0.20)	**JM**	0.18 (0.10−0.28)	**JH FT**
			MP9130	45 (30−55)	0.10 (0.05−0.20)	**JL**	0.15 (0.05−0.20)	**JM**	0.18 (0.10−0.28)	**JH FT**
	Heat Resistant Alloy (Inconel etc.)	–	**MP9120 VP15TF**	40 (20−50)	0.12 (0.05−0.20)	**JL**	0.15 (0.05−0.20)	**JM**	0.18 (0.10−0.28)	**JH FT**
			MP9130	35 (15−45)	0.10 (0.05−0.20)	**JL**	0.15 (0.05−0.20)	**JM**	0.18 (0.10−0.28)	**JH FT**
H	Hardened Steel	40−55HRC	**VP15TF**	80 (60−100)	0.08 (0.04−0.13)	**JL**	0.10 (0.05−0.15)	**JM**	0.12 (0.07−0.17)	**JH FT**

●Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
●Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

INSTRUCTIONS FOR USING INSERTS

■ Instructions for use of the JP breaker

- The JP breaker has sharp cutting edges. Wear gloves when handling.
- When machining aluminium alloy, welding to the cutting edge tends to occur, often leading to insert failure. To prevent this, wet cutting is recommended.

■ Instructions for use of wiper inserts

- Wiper inserts for the ASX400 are single-cornered.
- When installing the wiper insert, place the insert so that the small chamfer is located as shown.
- The peripheral cutting edge of the wiper insert is located back than general inserts. Beware of wear of the insert just behind the wiper insert.
- When using wiper set the following standard conditions. Depth of Cut (ap)≤0.5mm, Feed per Tooth (fz)≤0.2mm/t.

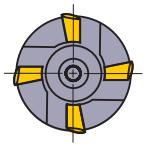
SHOULDER MILLING

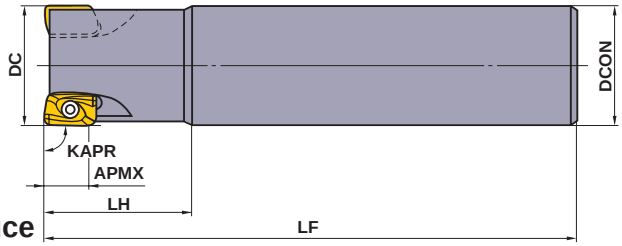
TOOL NEWS

90° KAPR

BAP300

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel





- **11° positive insert.**
- **Inserts with wiper edges produce optimal finished surface.**
- **Multi insert design for high feed machining.**

SHANK TYPE

KAPR :90°

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	LH	APMX	* Clamp Screw	Wrench	Insert
Standard	**BAP300R101S16**	●	1	10	85	16	25	9	TS25	TKY08F	APG/MT1135PD◌R-◌◌
	BAP300R121S16	●	1	12	85	16	25	9	TS25	TKY08F	
	BAP300R141S16	●	1	14	85	16	25	9	TS25	TKY08F	
	BAP300R162S16	●	2	16	85	16	25	9	TS25	TKY08F	
	BAP300R182S16	●	2	18	85	16	25	9	TS25	TKY08F	
	BAP300R203S20	●	3	20	100	20	30	9	TS25	TKY08F	
	BAP300R223S20	●	3	22	100	20	30	9	TS25	TKY08F	
	BAP300R254S25	●	4	25	115	25	35	9	TS25	TKY08F	
	BAP300R284S25	●	4	28	115	25	35	9	TS25	TKY08F	
	BAP300R304S32	●	4	30	125	32	45	9	TS25	TKY08F	
	BAP300R325S32	●	5	32	125	32	45	9	TS25	TKY08F	
	BAP300R406S32	●	6	40	125	32	45	9	TS25	TKY08F	
	BAP300R507S32	●	7	50	125	32	45	9	TS25	TKY08F	
	BAP300R638S32	●	8	63	125	32	45	9	TS25	TKY08F	
Long	**BAP300R202LS20**	●	2	20	150	20	60	9	TS25	TKY08F	APG/MT1135PD◌R-◌◌
	BAP300R253LS25	●	3	25	170	25	70	9	TS25	TKY08F	
	BAP300R323LS32	●	3	32	190	32	90	9	TS25	TKY08F	
	BAP300R403LS32	●	3	40	190	32	90	9	TS25	TKY08F	

* Clamp Torque (N • m) : TS25=1.0

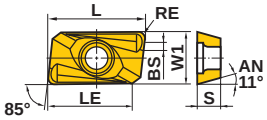
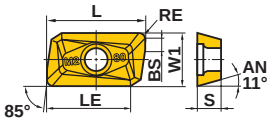
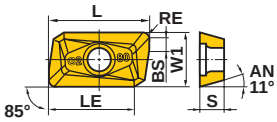
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			F7030	VP15TF			NX2525	NX4545	HTi10	
	P	Steel	◐	◐			●	◐		
	M	Stainless Steel	◔	◔			○	◔		
	K	Cast Iron		✣			●		◐	
	N	Non-ferrous Metal							◐	
	S	Heat-resistant Alloy, Titanium Alloy		◐						
	H	Hardened Steel		◐						

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	Coated F7030	Coated VP15TF			Cermet NX2525	Cermet NX4545	Carbide HTi10		Dimensions(mm) L	LE	W1	S	BS	RE	Geometry
	APMT1135PDER-H1	M	E	●	●			●	●	●		11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-H2	M	E	●	●			●	●	●		11.25	9	6.35	3.5	1.2	0.8	
	APMT1135PDER-H3	M	E	●								11.26	9	6.35	3.5	0.8	1.2	
	APMT1135PDER-H4	M	E	●								11.24	9	6.35	3.5	0.4	1.6	
	APMT1135PDER-H6	M	E	●								11.10	9	6.35	3.5	0.4	2.4	
	APMT1135PDER-M0	M	E	●								11.25	9	6.35	3.5	1.8	0.2	
	APMT1135PDER-M1	M	E	●								11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-M2	M	E	●	●				●			11.18	9	6.35	3.5	1.2	0.8	
	APGT1135PDFR-G2	G	F							●		11.3	9.7	6.35	3.5	1.2	0.8	

RECOMMENDED CUTTING CONDITIONS

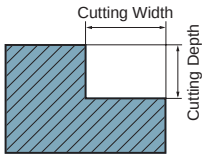
	Work Material	Hardness	Grade	Breaker	Cutting Mode	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**NX4545**	**H**	Finish Cutting	160 (120—180)	0.1 (0.05—0.15)
			F7030	**M**	General Cutting	180 (150—200)	0.15 (0.1—0.2)
	Carbon Steel Alloy Steel	180—280HB	**NX4545**	**H**	Finish Cutting	120 (100—160)	0.08 (0.05—0.1)
			F7030	**M**	General Cutting	150 (120—200)	0.15 (0.1—0.2)
			F7030	**H**	Unstable Cutting	120 (100—160)	0.15 (0.1—0.2)
		280—350HB	**NX4545**	**H**	Finish Cutting	100 (80—120)	0.08 (0.05—0.1)
			F7030	**M**	General Cutting	140 (120—160)	0.15 (0.1—0.2)
			F7030	**H**	Unstable Cutting	100 (80—120)	0.2 (0.1—0.25)
M	Stainless Steel	≤200HB	**F7030**	**M**	General Cutting	140 (120—160)	0.15 (0.1—0.2)
			F7030	**H**	Unstable Cutting	120 (80—140)	0.2 (0.1—0.25)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	**M**	General Cutting	140 (120—160)	0.15 (0.1—0.2)
			HTi10	**H**	General Cutting	120 (100—140)	0.2 (0.1—0.25)
	Ductile Cast Iron (≤JIS FCD450)	Tensile Strength ≤450MPa	**VP15TF**	**M**	General Cutting	120 (100—140)	0.15 (0.1—0.2)
			HTi10	**H**	General Cutting	100 (80—120)	0.2 (0.1—0.25)
	Ductile Cast Iron (≥JIS FCD500)	Tensile Strength 500—800MPa	**VP15TF**	**M**	General Cutting	100 (80—120)	0.1 (0.05—0.15)
			HTi10	**H**	General Cutting	80 (60—100)	0.15 (0.1—0.2)
N	Aluminium Alloy	—	**HTi10**	**G**	General Cutting	500 (200—1000)	0.2 (0.1—0.3)
S	Ti Alloy	≥350HB	**HTi10**	**G**	General Cutting	40 (30—60)	0.2 (0.1—0.3)
	Heat Resistant Alloy	—	**F7030**	**M**	General Cutting	30 (20—40)	0.15 (0.1—0.2)
H	Hardened Steel	≥40HRC	**VP15TF**	**M**	General Cutting	70 (50—100)	0.1 (0.05—0.15)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

■CUTTING PERFORMANCE

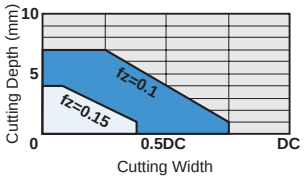
Cemented carbide/Coated carbide

Shoulder Milling

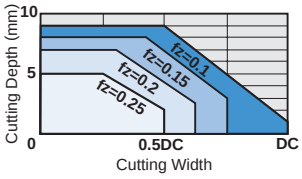


Workpiece : **JIS S50C**
Grade : **F7030**

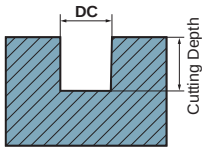
●φ10−φ14



●φ16−φ100

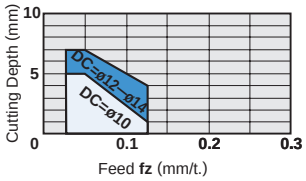


Slot Milling

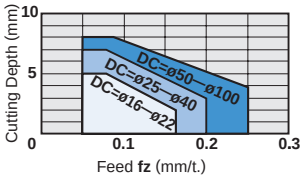


Workpiece : **JIS S50C**
Grade : **F7030**

●φ10−φ14

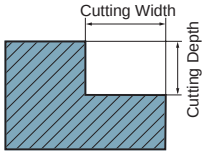


●φ16−φ100



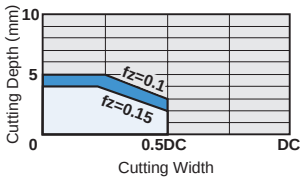
Cermet

Shoulder Milling

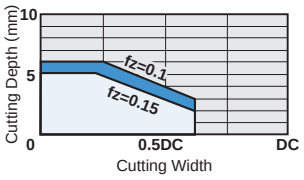


Workpiece : **JIS S50C**
Grade : **NX2525**

●φ10−φ14



●φ16−φ100



Note 1) In each of the adove graphs cutting performance is shown for carbon steel (JIS S50C).
In case of alloy steels, reduce the conditions by 20−30%.
Note 2) In the case of deep slot milling, air blow should be used.
Note 3) The diameter "DC" is taken from the tools peripheral cutting edge.

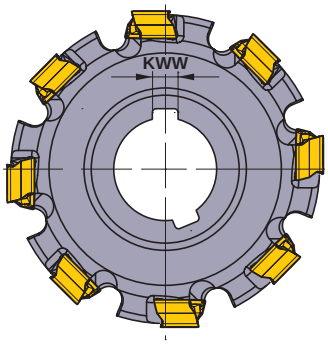
SIDE CUTTER

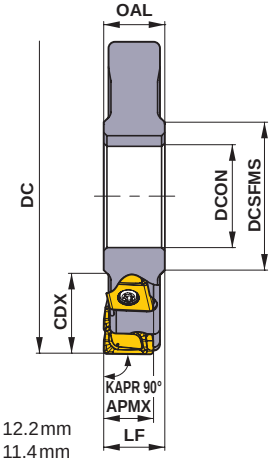
TOOL NEWS

90° KAPR

VAS400

P	M	K	N	S	H
Steel		Cast Iron			

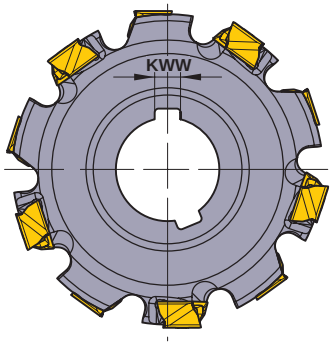


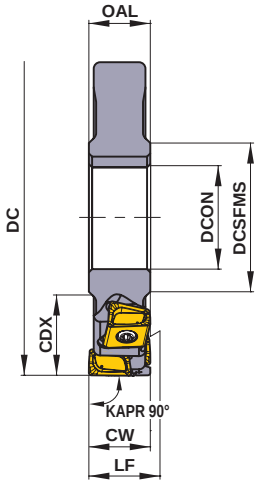


Max. Cutting Diameter **DC** : ø400mm
Max. Depth of Cut **APMX** : RE1<3.0mm 12.2mm
RE1≥3.0mm 11.4mm

■ HALF SIDE

DC (mm)	Effective No. of Teeth	Dimensions (mm)						Insert Type
		LF	CDX	DCON	DCSFMS	OAL	KWW	
80	8	≥18	20	27	40	≥18	7	LNGU13
100	10	≥18	27	32	46	≥18	8	LNGU13
125	12	≥18	35	40	55	≥18	10	LNGU13
160	14	≥18	52.5	40	55	≥18	10	LNGU13





Largest Width **CW** : 100mm
Max. Cutting Diameter **DC** : ø400mm

■ FULL SIDE

DC (mm)	Effective No. of Teeth	Total No. of Teeth	Dimensions (mm)							Insert Type
			LF *1	CW *2	CDX	DCON	DCSFMS	OAL	KWW	
80	4	8	≥18	18 – 24	20	27	40	≥18	7	LNGU13
100	5	10	≥18	18 – 24	27	32	46	≥18	8	LNGU13
125	6	12	≥18	18 – 24	35	40	55	≥18	10	LNGU13
160	7	14	≥18	18 – 24	52.5	40	55	≥18	10	LNGU13

*1 In case of adjustment piece specification. LF : ≥24
*2 CW of RE1<3.0mm is 24mm, and RE1<3.0mm is 22.8mm. Multilevel designs available for CW over each sizes.
Note 1) Please contact us for details of any geometry of half sides and full sides.

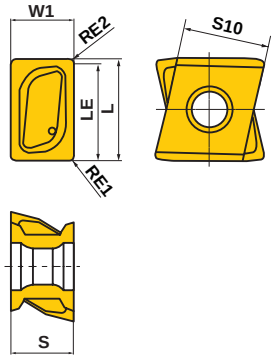
INSERTS

Work Material			MP6120	VP15TF
	P	Steel	◐	●
	K	Cast Iron		✣

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting
Honing :
E : Round

Shape	Order Number	Hand	Class	Honing	MP6120	VP15TF	L	LE	S	S10	RE1	RE2	W1
Low Resistance Type **M** Breaker	**LNGU130804PNER-M**	R	G	E		●	13.0	12.2	8.0	11.0	0.4	0.8	8.0
	LNGU130804PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	0.4	0.8	8.0
	LNGU130808PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	0.8	0.8	8.0
	LNGU130808PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	0.8	0.8	8.0
	LNGU130812PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	1.2	0.8	8.0
	LNGU130812PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	1.2	0.8	8.0
	LNGU130816PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	1.6	0.8	8.0
	LNGU130816PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	1.6	0.8	8.0
	LNGU130820PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	2.0	0.8	8.0
	LNGU130820PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	2.0	0.8	8.0
	LNGU130824PNER-M	R	G	E		●	13.0	12.2	8.0	11.0	2.4	0.8	8.0
	LNGU130824PNEL-M	L	G	E		●	13.0	12.2	8.0	11.0	2.4	0.8	8.0
	LNGU130830PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	3.0	1.6	8.0
	LNGU130830PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	3.0	1.6	8.0
	LNGU130840PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	4.0	1.6	8.0
	LNGU130840PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	4.0	1.6	8.0
	LNGU130850PNER-M	R	G	E		●	13.0	11.4	8.0	11.0	5.0	1.6	8.0
	LNGU130850PNEL-M	L	G	E		●	13.0	11.4	8.0	11.0	5.0	1.6	8.0
Strong Cutting Edge Type **R** Breaker	**LNGU130804PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	0.4	0.8	8.0
	LNGU130804PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	0.4	0.8	8.0
	LNGU130808PNER-R	R	G	E	●	●	13.0	12.2	8.0	11.0	0.8	0.8	8.0
	LNGU130808PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	0.8	0.8	8.0
	LNGU130812PNER-R	R	G	E	●	●	13.0	12.2	8.0	11.0	1.2	0.8	8.0
	LNGU130812PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	1.2	0.8	8.0
NEW	**LNGU130816PNER-R**	R	G	E	●	●	13.0	12.2	8.0	11.0	1.6	0.8	8.0
	LNGU130816PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	1.6	0.8	8.0
	LNGU130820PNER-R	R	G	E	●	●	13.0	12.2	8.0	11.0	2.0	0.8	8.0
	LNGU130820PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	2.0	0.8	8.0
	LNGU130824PNER-R	R	G	E	●	●	13.0	12.2	8.0	11.0	2.4	0.8	8.0
	LNGU130824PNEL-R	L	G	E	●	●	13.0	12.2	8.0	11.0	2.4	0.8	8.0
	LNGU130830PNER-R	R	G	E	●	●	13.0	11.4	8.0	11.0	3.0	1.6	8.0
	LNGU130830PNEL-R	L	G	E	●	●	13.0	11.4	8.0	11.0	3.0	1.6	8.0
	LNGU130840PNER-R	R	G	E	●	●	13.0	11.4	8.0	11.0	4.0	1.6	8.0
	LNGU130840PNEL-R	L	G	E	●	●	13.0	11.4	8.0	11.0	4.0	1.6	8.0
	LNGU130850PNER-R	R	G	E	●	●	13.0	11.4	8.0	11.0	5.0	1.6	8.0
	LNGU130850PNEL-R	L	G	E	●	●	13.0	11.4	8.0	11.0	5.0	1.6	8.0

Geometry



Right hand insert shown.

● : Inventory maintained in Japan. (10 inserts in one case)

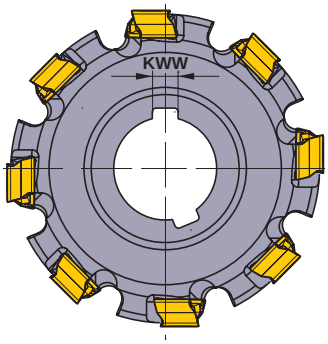
SIDE CUTTER

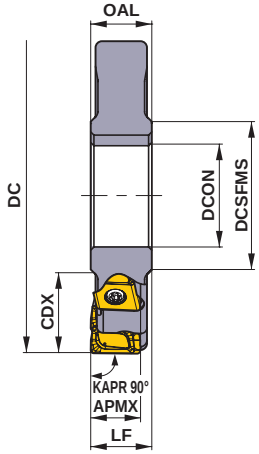
TOOL NEWS

90° KAPR

VAS500

P	M	K	N	S	H
Steel		Cast Iron			



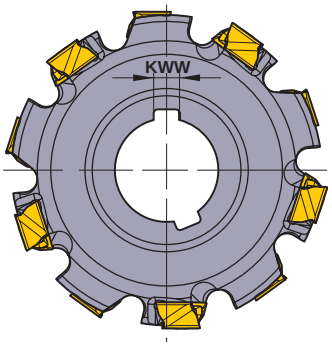


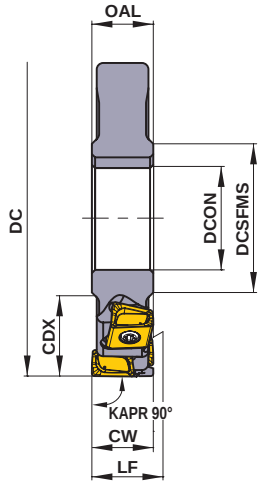
Max. Cutting Diameter **DC** : ø660mm
Max. Depth of Cut **APMX** : RE1<3.0mm 16.2mm
RE1≥3.0mm 15.4mm

■ HALF SIDE

DC (mm)	Effective No. of Teeth	Dimensions(mm)						Insert Type
		LF	CDX	DCON	DCSFMS	OAL	KWW	
100	8	≥23	27	32	46	≥23	8	LNGU17
125	10	≥23	35	40	55	≥23	10	LNGU17
160	12	≥23	52.5	40	55	≥23	10	LNGU17
200	16	≥23	65	50	70	≥23	12	LNGU17

⋆ In case of adjustment piece specification. **LF** : ≥29





Largest Width **CW** : 100mm
Max. Cutting Diameter **DC** : ø660mm

■ FULL SIDE

DC (mm)	Effective No. of Teeth	Total No. of Teeth	Dimensions(mm)							Insert Type
			LF ⋆1	CW ⋆2	CDX	DCON	DCSFMS	OAL	KWW	
100	4	8	≥23	23 – 32	27	32	46	≥23	8	LNGU17
125	5	10	≥23	23 – 32	35	40	55	≥23	10	LNGU17
160	6	12	≥23	23 – 32	52.5	40	55	≥23	10	LNGU17
200	8	16	≥23	23 – 32	65	50	70	≥23	12	LNGU17

⋆1 In case of adjustment piece specification. **LF** : ≥29
⋆2 CW of RE1<3.0mm is 32mm, and RE1<3.0mm is 30.8mm. Multilevel designs available for CW over each sizes.
Note 1) Please contact us for details of any geometry of half sides and full sides.

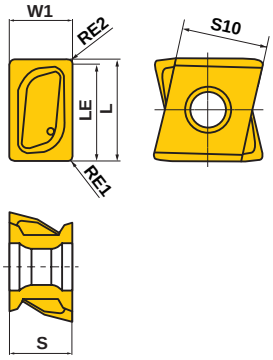
INSERTS

Work Material			MP6120	VP15TF
	P	Steel	◐	◐
	K	Cast Iron		◐

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing :
E : Round

Shape	Order Number	Hand	Class	Honing	MP6120 (Coated)	VP15TF (Coated)	L	LE	S	S10	RE1	RE2	W1	Geometry
Strong Cutting Edge Type R Breaker	**LNGU171004PNER-R**	R	G	E	●	●	17.0	16.2	10.0	13.0	0.4	0.8	10.0	
	LNGU171004PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	0.4	0.8	10.0	
	LNGU171008PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	0.8	0.8	10.0	
	LNGU171008PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	0.8	0.8	10.0	
	LNGU171012PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	1.2	0.8	10.0	
	LNGU171012PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	1.2	0.8	10.0	
	LNGU171016PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	1.6	0.8	10.0	
	LNGU171016PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	1.6	0.8	10.0	
	LNGU171020PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	2.0	0.8	10.0	
	LNGU171020PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	2.0	0.8	10.0	
	LNGU171024PNER-R	R	G	E	●	●	17.0	16.2	10.0	13.0	2.4	0.8	10.0	
	LNGU171024PNEL-R	L	G	E	●	●	17.0	16.2	10.0	13.0	2.4	0.8	10.0	
	LNGU171030PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	3.0	1.6	10.0	
	LNGU171030PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	3.0	1.6	10.0	
	LNGU171040PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	4.0	1.6	10.0	
	LNGU171040PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	4.0	1.6	10.0	
	LNGU171050PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	5.0	1.6	10.0	
	LNGU171050PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	5.0	1.6	10.0	
	LNGU171060PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	6.0	1.6	10.0	
	LNGU171060PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	6.0	1.6	10.0	
	LNGU171070PNER-R	R	G	E	●	●	17.0	15.4	10.0	13.0	7.0	1.6	10.0	
	LNGU171070PNEL-R	L	G	E	●	●	17.0	15.4	10.0	13.0	7.0	1.6	10.0	Right hand insert shown.

NEW



M

INDEXABLE MILLING

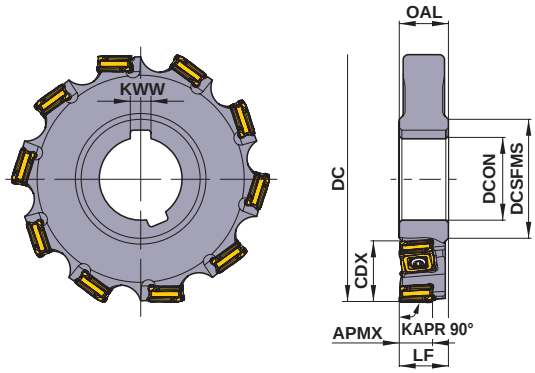
● : Inventory maintained in Japan. (10 inserts in one case)

SIDE CUTTER

TOOL NEWS 90° KAPR

VOS400

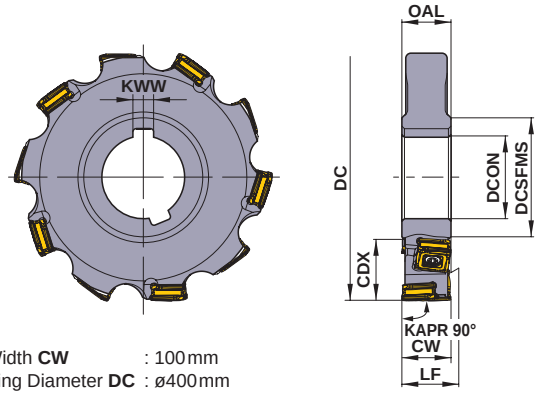
P M **K** N S H



HALF SIDE

Max. Cutting Diameter **DC** : ø400mm

DC (mm)	Effective No. of Teeth	Dimensions (mm)						APMX (mm)
		LF	CDX	DCON	DCSFMS	OAL	KWW	
80	8	≥16	20	27	40	≥16.8	7	10.0
100	10	≥16	27	32	46	≥16.8	8	10.0
125	12	≥16	35	40	55	≥16.8	10	10.0
160	14	≥16	52.5	40	55	≥16.8	10	10.0



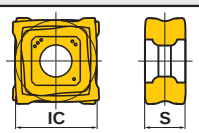
FULL SIDE

Largest Width **CW** : 100mm
Max. Cutting Diameter **DC** : ø400mm

DC (mm)	Effective No. of Teeth	Total No. of Teeth	Dimensions (mm)						
			LF	CW	CDX	DCON	DCSFMS	OAL	KWW
80	4	8	≥16	16 – 20	20	27	40	≥16	7
100	5	10	≥16	16 – 20	27	32	46	≥16	8
125	6	12	≥16	16 – 20	35	40	55	≥16	10
160	7	14	≥16	16 – 20	52.5	40	55	≥16	10

Note 1) Multilevel designs available for CW over 20mm.
Note 2) Please contact us for details of any geometry of half sides and full sides.

INSERTS

Shape	Order Number	Hand	Class	Honing	Coated VP15TF		Dimensions (mm) IC	Dimensions (mm) S	Geometry
	SONX1206PER	R	N	E	●		12.7	6.3	 Right hand insert shown.
	SONX1206PEL	L	N	E	●		12.7	6.3	

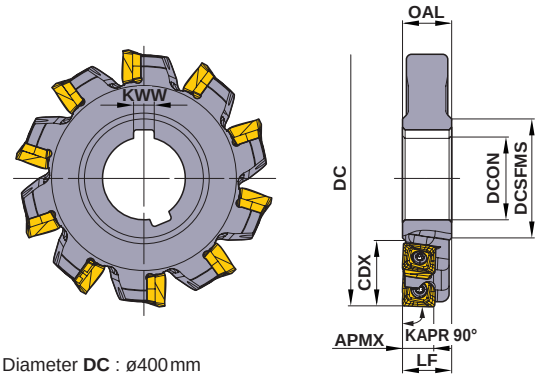
● : **Inventory maintained in Japan. (10 inserts in one case)**

SIDE CUTTER

TOOL NEWS 90° KAPR R

ASX400

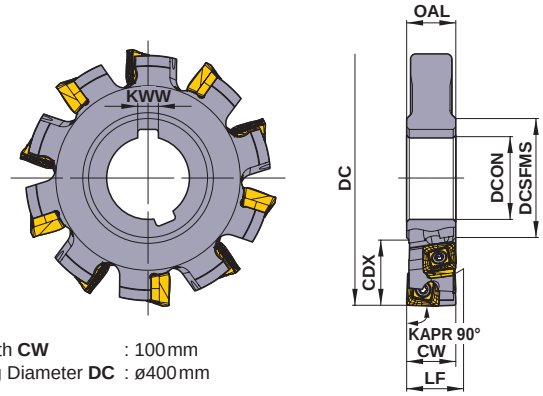
P M K N S H



HALF SIDE

Max. Cutting Diameter **DC** : ø400mm

DC (mm)	Effective No. of Teeth	Dimensions (mm)						APMX (mm)
		LF	CDX	DCON	DCSFMS	OAL	KWW	
80	8	≥16	20	27	40	≥16.8	7	10.0
100	10	≥16	27	32	46	≥16.8	8	10.0
125	12	≥16	35	40	55	≥16.8	10	10.0
160	14	≥16	52.5	40	55	≥16.8	10	10.0



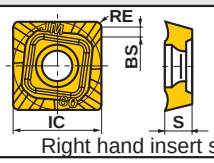
FULL SIDE

Largest Width **CW** : 100mm
Max. Cutting Diameter **DC** : ø400mm

DC (mm)	Effective No. of Teeth	Total No. of Teeth	Dimensions (mm)						
			LF	CW	CDX	DCON	DCSFMS	OAL	KWW
80	4	8	≥16	16 – 20	20	27	40	≥16	7
100	5	10	≥16	16 – 20	27	32	46	≥16	8
125	6	12	≥16	16 – 20	35	40	55	≥16	10
160	7	14	≥16	16 – 20	52.5	40	55	≥16	10

Note 1) Multilevel designs available for CW over 20mm.
Note 2) Please contact us for details of any geometry of half sides and full sides.

INSERTS

Shape	Order Number	Hand	Class	Honing	Coated VP15TF		Dimensions (mm) IC	S	BS	RE	Geometry
	SOMT12T308PEER-JM	R	M	E	●		12.7	3.97	1.4	0.8	 Right hand insert shown.
	SOMT12T308PEEL-JM	L	M	E	●		12.7	3.97	1.4	0.8	

MULTI FUNCTIONAL MILLING

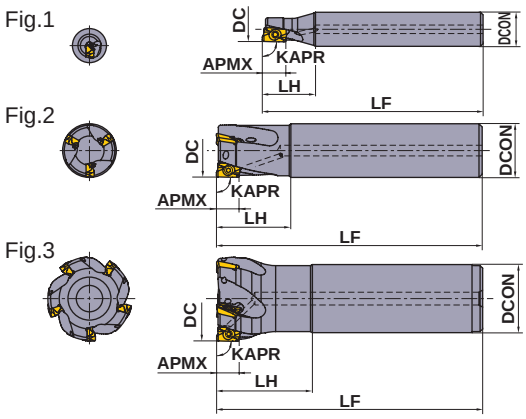
TOOL NEWS

90° KAPR

APX3000

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

- **High accuracy, high quality vertical wall.**
- **Low cutting force insert.**



Right hand tool holder only.

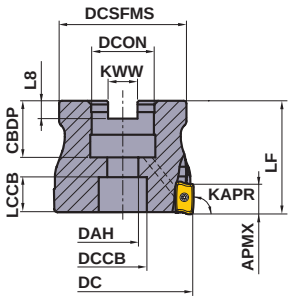
■ SHANK TYPE

KAPR : 90°
With Coolant Hole

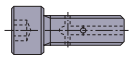
DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	LF	LH	WT (kg)	APMX (mm)	RMPX	RPMX (min-1)	Fig.	Insert Type
12	**APX3000R121SA16SA**	●	1	16	85	25	0.10	10	6.0°	10500	1	AO□T12
14	**APX3000R141SA16SA**	●	1	16	85	25	0.11	10	6.0°	9000	1	AO□T12
16	**APX3000R162SA16SA**	●	2	16	85	25	0.11	10	11.3°	20900	2	AO□T12
18	**APX3000R182SA16SA**	●	2	16	85	25	0.11	10	8.6°	19600	3	AO□T12
18	**APX3000R182SA16LA**	●	2	16	120	25	0.16	10	8.6°	19600	3	AO□T12
18	**APX3000R182SA16ELA**	●	2	16	180	25	0.25	10	8.6°	19600	3	AO□T12
20	**APX3000R202SA20SA**	●	2	20	100	30	0.21	10	6.9°	18500	2	AO□T12
20	**APX3000R203SA20SA**	●	3	20	100	30	0.21	10	6.9°	18500	2	AO□T12
20	**APX3000R202SA20LA**	●	2	20	150	60	0.32	10	6.9°	18500	2	AO□T12
20	**APX3000R202SA20ELA**	●	2	20	200	70	0.42	10	6.9°	18500	2	AO□T12
22	**APX3000R223SA20SA**	●	3	20	115	30	0.25	10	5.7°	17600	3	AO□T12
22	**APX3000R222SA20LA**	●	2	20	150	30	0.34	10	5.7°	17600	3	AO□T12
22	**APX3000R222SA20ELA**	●	2	20	200	30	0.45	10	5.7°	17600	3	AO□T12
25	**APX3000R252SA25SA**	●	2	25	115	35	0.38	10	4.6°	16400	2	AO□T12
25	**APX3000R253SA25SA**	●	3	25	115	35	0.38	10	4.6°	16400	2	AO□T12
25	**APX3000R254SA25SA**	●	4	25	115	35	0.38	10	4.6°	16400	2	AO□T12
25	**APX3000R252SA25LA**	●	2	25	170	70	0.51	10	4.6°	16400	2	AO□T12
25	**APX3000R253SA25LA**	●	3	25	170	70	0.51	10	4.6°	16400	2	AO□T12
25	**APX3000R252SA25ELA**	●	2	25	220	80	0.75	10	4.6°	16400	2	AO□T12
25	**APX3000R253SA25ELA**	●	3	25	220	80	0.75	10	4.6°	16400	2	AO□T12
28	**APX3000R284SA25SA**	●	4	25	115	35	0.40	10	3.8°	15500	3	AO□T12
28	**APX3000R282SA25LA**	●	2	25	170	35	0.61	10	3.8°	15500	3	AO□T12
28	**APX3000R283SA25LA**	●	3	25	170	35	0.61	10	3.8°	15500	3	AO□T12
28	**APX3000R282SA25ELA**	●	2	25	220	35	0.80	10	3.8°	15500	3	AO□T12
28	**APX3000R283SA25ELA**	●	3	25	220	35	0.79	10	3.8°	15500	3	AO□T12
30	**APX3000R304SA32SA**	●	4	32	125	45	0.64	10	3.4°	14900	2	AO□T12
32	**APX3000R323SA32SA**	●	3	32	125	45	0.68	10	3.1°	14400	2	AO□T12
32	**APX3000R324SA32SA**	●	4	32	125	45	0.67	10	3.1°	14400	2	AO□T12
32	**APX3000R325SA32SA**	●	5	32	125	45	0.68	10	3.1°	14400	2	AO□T12
32	**APX3000R322SA32LA**	●	2	32	190	90	1.07	10	3.1°	14400	2	AO□T12
32	**APX3000R323SA32LA**	●	3	32	190	90	1.05	10	3.1°	14400	2	AO□T12
32	**APX3000R322SA32ELA**	●	2	32	260	100	1.47	10	3.1°	14400	2	AO□T12
32	**APX3000R323SA32ELA**	●	3	32	260	100	1.45	10	3.1°	14400	2	AO□T12
35	**APX3000R352SA32LA**	●	2	32	190	45	1.12	10	2.7°	13700	3	AO□T12
35	**APX3000R353SA32LA**	●	3	32	190	45	1.11	10	2.7°	13700	3	AO□T12
35	**APX3000R352SA32ELA**	●	2	32	260	45	1.53	10	2.7°	13700	3	AO□T12
35	**APX3000R353SA32ELA**	●	3	32	260	45	1.52	10	2.7°	13700	3	AO□T12
40	**APX3000R403SA32SA**	●	3	32	125	45	0.75	10	2.2°	12800	3	AO□T12
40	**APX3000R405SA32SA**	●	5	32	125	45	0.75	10	2.2°	12800	3	AO□T12
40	**APX3000R406SA32SA**	●	6	32	125	45	0.76	10	2.2°	12800	3	AO□T12
50	**APX3000R507SA32SA**	●	7	32	125	45	0.90	10	1.7°	11300	3	AO□T12
63	**APX3000R638SA32SA**	●	8	32	125	45	1.04	10	1.3°	10000	3	AO□T12

Note 1) When using inserts with corner radius RE≥2.4mm, machining of the holder is required as shown on page M099.
Note 2) The maximum spindle speeds RPMX are set to ensure tool and insert stability.
Note 3) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

● : **Inventory maintained in Japan.**



Right hand tool holder only.

DC	Set Bolt	Geometry
32, 40	HSC08030H	
50, 63	HSC10030H	
80	HSC12035H	
100	HSC16040H	

■ ARBOR TYPE

KAPR :90°
GAMP:+7°—+21° GAMF:+15°—+27°
With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	RMPX	RPMX (min-1)	Insert Type
32	**APX3000-032A05RA**	●	5	40	16	0.2	10	3.1°	14400	AO◌T12
40	**APX3000-040A06RA**	●	6	40	16	0.3	10	2.2°	12800	AO◌T12
50	**APX3000-050A07RA**	●	7	40	22	0.4	10	1.7°	11300	AO◌T12
63	**APX3000-063A08RA**	●	8	40	22	0.7	10	1.3°	10000	AO◌T12
80	**APX3000R08009CA**	●	9	50	25.4	1.3	10	1.0°	8800	AO◌T12
80	**APX3000-080A09RA**	●	9	50	27	1.3	10	1.0°	8800	AO◌T12
100	**APX3000R10011DA**	●	11	63	31.75	2.2	10	0.8°	7800	AO◌T12
100	**APX3000-100A11RA**	●	11	63	32	2.2	10	0.8°	7800	AO◌T12

Note 1) When using inserts with corner radius RE≥2.4mm, machining of the holder is required as shown on page M099.
Note 2) The maximum spindle speeds RPMX are set to ensure tool and insert stability.
Note 3) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

Mounting Dimensions

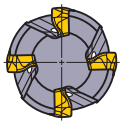
DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8
32	**APX3000-032A05RA**	16	18	9	14	10.22	30	8.4	5.6
40	**APX3000-040A06RA**	16	18	9	14	10.35	34	8.4	5.6
50	**APX3000-050A07RA**	22	20	11	17	12.35	45	10.4	6.3
63	**APX3000-063A08RA**	22	20	11	17	12.35	55	10.4	6.3
80	**APX3000R08009CA**	25.4	26	13	20	15.35	70	9.5	6
80	**APX3000-080A09RA**	27	23	13	20	16.35	70	12.4	7
100	**APX3000R10011DA**	31.75	32	17	26	20.35	80	12.7	8
100	**APX3000-100A11RA**	32	26	17	26	26.35	80	14.4	8

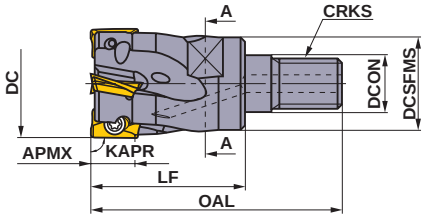
SPARE PARTS

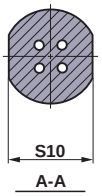
DC (mm)	Tool Holder Type	DC (mm)	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
12	**APX3000R12**	14	**APX3000R14**	TPS25	TIP07F	MK1KS
16	**APX3000R16**	18	**APX3000R18**	TPS25	TIP07F	MK1KS
20	**APX3000R20**			TPS25	TIP07F	MK1KS
22	**APX3000R22**	25	**APX3000R25**	TPS25-1	TIP07F	MK1KS
28	**APX3000R28**	30	**APX3000R30**	TPS25-1	TIP07F	MK1KS
32	**APX3000R32**	32	**APX3000-032**	TPS25-1	TIP07F	MK1KS
35	**APX3000R35**			TPS25-1	TIP07F	MK1KS
40	**APX3000R40**	40	**APX3000-040**	TPS25-1	TIP07F	MK1KS
50	**APX3000R50**	50	**APX3000-050**	TPS25-1	TIP07F	MK1KS
63	**APX3000R63**	63	**APX3000-063**	TPS25-1	TIP07F	MK1KS
80	**APX3000R080**	80	**APX3000-080**	TPS25-1	TIP07F	MK1KS
100	**APX3000R100**	100	**APX3000-100**	TPS25-1	TIP07F	MK1KS

* Clamp Torque (N • m) : TPS25 = 1.0, TPS25-1 = 1.0

SPARE PARTS ➤ **Q001**
TECHNICAL DATA ➤ **R001**







■SCREW-IN TYPE

Right hand tool holder only.

KAPR :90°
With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	DCSFMS	OAL	LF	S10	CRKS	WT (kg)	APMX (mm)	RMPX	Insert Type
16	**APX3000R162M08A30**	●	2	8.5	13	48	30	10	M8	0.1	10	11.3°	AO◌T12
18	**APX3000R182M08A30**	●	2	8.5	13	48	30	10	M8	0.1	10	8.6°	AO◌T12
20	**APX3000R203M10A30**	●	3	10.5	18	49	30	14	M10	0.1	10	6.9°	AO◌T12
22	**APX3000R223M10A30**	●	3	10.5	18	49	30	14	M10	0.1	10	5.7°	AO◌T12
25	**APX3000R254M12A35**	●	4	12.5	21	57	35	19	M12	0.2	10	4.6°	AO◌T12
28	**APX3000R284M12A35**	●	4	12.5	21	57	35	19	M12	0.2	10	3.8°	AO◌T12
30	**APX3000R304M16A40**	●	4	17	29	63	40	24	M16	0.3	10	3.4°	AO◌T12
32	**APX3000R325M16A40**	●	5	17	29	63	40	24	M16	0.3	10	3.1°	AO◌T12
35	**APX3000R355M16A40**	●	5	17	29	63	40	24	M16	0.3	10	2.7°	AO◌T12
40	**APX3000R406M16A40**	●	6	17	29	63	40	24	M16	0.3	10	2.2°	AO◌T12

Note 1) When using inserts with corner radius RE≥2.4mm, machining of the holder is required as shown on page M099.
Note 2) For screw-in type arbors, refer to pages M269.

SPARE PARTS

DC	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
16	**APX3000R16**	TPS25	TIP07F	MK1KS
18	**APX3000R18**	TPS25	TIP07F	MK1KS
20	**APX3000R20**	TPS25	TIP07F	MK1KS
22	**APX3000R22**	TPS25-1	TIP07F	MK1KS
25	**APX3000R25**	TPS25-1	TIP07F	MK1KS
28	**APX3000R28**	TPS25-1	TIP07F	MK1KS
30	**APX3000R30**	TPS25-1	TIP07F	MK1KS
32	**APX3000R32**	TPS25-1	TIP07F	MK1KS
35	**APX3000R35**	TPS25-1	TIP07F	MK1KS
40	**APX3000R40**	TPS25-1	TIP07F	MK1KS

* Clamp Torque (N • m) : TPS25 = 1.0, TPS25-1 = 1.0

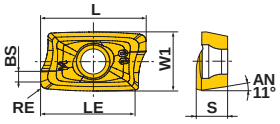
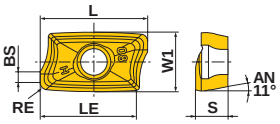
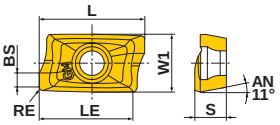
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15
	P	Steels		◐	✠				◐	◐	
	M	Stainless Steels				◔			◔	◔	
	K	Cast Irons	◐						✠	✠	
	N	Non-ferrous Metals									◐
	S	Heat Resistant Alloys, Titanium Alloys					◐	✠	◐		
	H	Hardened Steels							◔		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

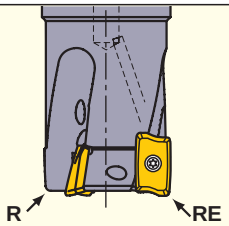
Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15		L	LE	W1	S	BS	RE *	Geometry
				Coated								Carbide		Dimensions (mm)						
General **M** Breaker	**AOMT123602PEER-M**	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.8	0.2	
	AOMT123604PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.2	0.8	
	AOMT123610PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.0	1.0	
	AOMT123612PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.8	1.2	
	AOMT123616PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	1.6	
	AOMT123620PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	2.0	
	AOMT123624PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	2.4	
	AOMT123630PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	3.0	
	AOMT123632PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	3.2	
Strong Cutting Edge Type **H** Breaker	**AOMT123604PEER-H**	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-H	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	1.2	0.8	
	AOMT123616PEER-H	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	1.6	
For Machining of Aluminium Alloys **GM** Breaker	**AOGT123602PEFR-GM**	G	F									●		12	10	6.6	3.6	1.8	0.2	
	AOGT123604PEFR-GM	G	F									●		12	10	6.6	3.6	1.6	0.4	
	AOGT123608PEFR-GM	G	F									●		12	10	6.6	3.6	1.2	0.8	

* Corner radius RE is different from the work material of R shape depending on the axial rake angle of the body.

Note on Use of Inserts with Large Corner Radii

When using inserts with corner radius RE≥R2.4mm, please machine the holder with a radius form as shown on the right table.



RE (mm)	R (mm)
2.4	1.9
3.0	2.5
3.2	2.7

R : Holder End Radius
RE : Insert Corner Radius

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

	Work Material	Characteristics	Insert Grade Priority 1st	Insert Grade Priority 2nd	Breaker		ae (mm) ≤0.25DC	0.25–0.5DC	0.5–0.75DC	DC (Slot)
							vc (m/min)			
P	Mild Steel	≤180HB	MP6120	VP15TF	M	H	230(180–270)	220(170–260)	180(140–210)	180(140–210)
			MP6130	VP20RT	M	H	200(150–240)	190(140–230)	150(110–180)	150(110–180)
	Carbon Steel Alloy Steel	180–350HB	MP6120	VP15TF	M	H	180(140–210)	170(130–200)	140(110–160)	140(110–160)
			MP6130	VP20RT	M	H	150(110–180)	140(100–170)	110(80–130)	110(80–130)
M	Stainless Steel	≤270HB	MP7130	VP20RT	M	H	180(140–210)	170(130–200)	140(110–160)	140(110–160)
K	Gray Cast Iron	≤350MPa	MC5020	VP15TF	H	–	250(200–300)	240(190–290)	210(160–260)	140(110–160)
	Ductile, Cast Iron	≤800MPa	MC5020	VP15TF	H	–	130(100–150)	120(90–140)	100(80–120)	100(80–120)
N	Aluminium Alloy	–	TF15	–	GM	–	500(200–1000)	500(200–1000)	500(200–1000)	500(200–1000)
S	Titanium Alloy	≤350HB	MP9120	VP15TF	M	H	50(40–70)	–	–	50(40–70)
			MP9130	VP20RT	M	H	40(30–60)	–	–	40(30–60)
	Heat-resistant Alloy	–	MP9120	VP15TF	M	H	40(30–60)	–	–	40(30–60)
			MP9130	VP20RT	M	H	30(20–40)	–	–	30(20–40)
H	Hardened Steel	40–55HRC	VP15TF	–	H	–	90(70–100)	85(60–100)	70(50–80)	70(50–80)

DEPTH OF CUT AND FEED

	Work Material	Characteristics	ae (mm)	DC ø12–ø16 Depth of Cut ap (mm)	DC ø12–ø16 Feed per Tooth fz (mm/t.)	DC ø18–ø25 Depth of Cut ap (mm)	DC ø18–ø25 Feed per Tooth fz (mm/t.)	DC ø28–ø100 Depth of Cut ap (mm)	DC ø28–ø100 Feed per Tooth fz (mm/t.)
P	Mild Steel Carbon Steel Alloy Steel	≤180HB 180–350HB	≤0.25DC	≤4	0.15	≤5	0.25	≤5	0.20
				4–7	0.10	5–7	0.20	5–7	0.15
				–	–	7–8.5	0.15	7–8.5	0.10
				–	–	8.5–10	0.10	8.5–10	0.07
			0.25–0.5DC	≤2	0.15	≤3	0.25	≤3	0.20
				2–5	0.10	3–5.5	0.20	3–5.5	0.15
				–	–	5.5–8	0.15	5.5–8	0.10
				–	–	8–10	0.10	8–10	0.07
			0.5–0.75DC	≤4	0.10	≤4	0.15	≤3	0.10
				–	–	4–10	0.10	3–7	0.07
			DC (Slot)	≤3	0.10	≤4	0.10	≤3	0.10
						4–7	0.07	3–5	0.07
M	Stainless Steel	≤270HB	≤0.25DC	≤4	0.15	≤5	0.20	≤5	0.20
				4–7	0.10	5–7	0.15	5–7	0.15
				–	–	7–8.5	0.10	7–8.5	0.10
				–	–	8.5–10	0.07	8.5–10	0.07
			0.25–0.5DC	≤2	0.15	≤3	0.20	≤3	0.20
				2–5	0.10	3–5.5	0.15	3–5.5	0.15
				–	–	5.5–8	0.10	5.5–8	0.10
				–	–	8–10	0.07	8–10	0.07
			0.5–0.75DC	≤4	0.10	≤4	0.10	≤3	0.10
				–	–	4–10	0.07	3–7	0.07
			DC (Slot)	≤3	0.10	≤4	0.10	≤3	0.10
						4–7	0.07	3–5	0.07
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.25DC	≤4	0.15	≤5	0.25	≤5	0.20
				4–7	0.10	5–7	0.20	5–7	0.15
				–	–	7–8.5	0.15	7–8.5	0.10
				–	–	8.5–10	0.10	8.5–10	0.07
			0.25–0.5DC	≤2	0.15	≤3	0.25	≤3	0.20
				2–5	0.10	3–5.5	0.20	3–5.5	0.15
				–	–	5.5–8	0.15	5.5–8	0.10
				–	–	8–10	0.10	8–10	0.07
			0.5–0.75DC	≤4	0.10	≤4	0.15	≤3	0.10
				–	–	4–10	0.10	3–7	0.07
			DC (Slot)	≤3	0.10	≤4	0.10	≤3	0.10
						4–7	0.07	3–5	0.07
	Ductile, Cast Iron	Tensile Strength ≤800MPa	≤0.25DC	≤4	0.10	≤5	0.20	≤5	0.20
				4–7	0.07	5–7	0.15	5–7	0.15
				–	–	7–8.5	0.10	7–8.5	0.10
				–	–	8.5–10	0.07	8.5–10	0.07
			0.25–0.5DC	≤2	0.10	≤3	0.20	≤3	0.20
				2–5	0.07	3–5.5	0.15	3–5.5	0.15
				–	–	5.5–8	0.10	5.5–8	0.10
				–	–	8–10	0.07	8–10	0.07
			0.5–0.75DC	≤4	0.07	≤4	0.10	≤3	0.10
				–	–	4–10	0.07	3–7	0.07
			DC (Slot)	≤3	0.07	≤4	0.10	≤3	0.10
						4–7	0.07	3–5	0.07

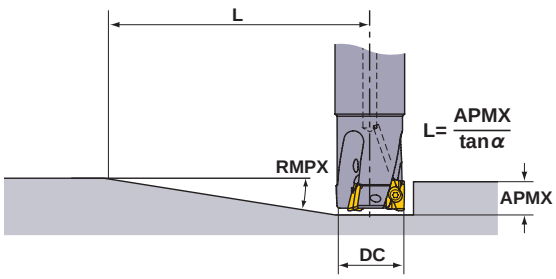
	Work Material	Characteristics	ae (mm)	DC					
				ø12—ø16		ø18—ø25		ø28—ø100	
				Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)
N	Aluminium Alloy	—	≤0.25DC	≤4	0.15	≤4	0.25	≤4	0.20
				4—7	0.10	4—7	0.15	4—7	0.10
			0.25—0.5DC	≤4	0.15	≤4	0.20	≤4	0.20
				4—7	0.10	4—7	0.10	4—7	0.10
			0.5—0.75DC	≤5	0.10	≤5	0.15	≤5	0.10
			DC (Slot)	≤5	0.10	≤5	0.20	≤5	0.15
S	Titanium Alloy	≤350HB	≤0.25DC	≤4	0.15	≤4	0.15	≤4	0.10
				4—7	0.10	4—7	0.10	4—7	0.07
			0.25—0.5DC	≤3	0.05	≤3	0.05	≤3	0.05
	Heat-resistant Alloy	—	0.5—0.75DC	≤2	0.10	≤2	0.05	≤2	0.05
			DC (Slot)	≤1	0.05	≤1	0.05	≤1	0.05
H	Hardened Steel	40—55HRC	≤0.25DC	≤4	0.10	≤5	0.15	≤5	0.15
				4—7	0.07	5—7	0.10	5—7	0.10
				—	—	7—8.5	0.07	—	—
			0.25—0.5DC	≤2	0.10	≤3	0.15	≤3	0.15
				2—5	0.07	3—5.5	0.10	—	—
			0.5—0.75DC	≤4	0.07	≤4	0.07	≤3	0.07
			DC (Slot)	≤3	0.07	≤4	0.07	≤3	0.07

Note 1) These cutting conditions are a guide to the standard shank type and the arbor type.
Please make adjustments according to the machining conditions.
Note 2) Vibration is liable to occur in certain cases. Please reduce the depth of cut and / or reduce cutting conditions in the following cases.
- When using the long shank type and extra long shank type.
- When using long tool overhang with the standard or arbor type.
- When the application has poor clamping rigidity or when using a low rigidity machine.

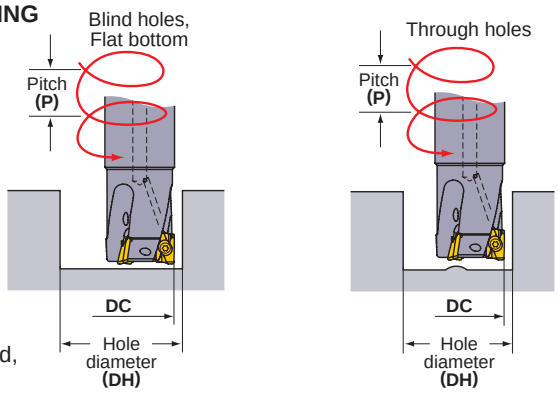
Note 3) In case of coarse and fine pitch cutters, the coarse pitch type is recommended to prevent vibration.
Note 4) For heavy interrupted and unstable cutting, the H breaker is first recommendation.

RAMPING/HELICAL CUTTING

● RAMPING



● HELICAL CUTTING



Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

Cutting Edge Diameter **DC**(mm)	Ramping		Helical Cutting (Blind Hole, Flat Bottom)				Helical Cutting (Through Hole)	
	Maximum Ramping Angle **RMPX**	Minimum Distance*1 **L**(mm)	Maximum Hole Diameter*2 **DH max.**(mm)	Maximum Pitch **P max.**(mm)	Minimum Hole Diameter **DH min.**(mm)	Maximum Pitch **P max.**(mm)	Minimum Hole Diameter **DH min.**(mm)	Maximum Pitch **P max.**(mm)
12	6.0°	95	22	2.5	20.5	2	14	0.5
14	6.0°	95	26	2.5	24.5	2	18	1
16	11.3°	50	30	9	28	7	21	2
18	8.6°	66	34	5	32	4.5	25	2
20	6.9°	83	38	5	36	4.5	29	2
22	5.7°	100	42	5	40	4.5	33	2
25	4.6°	124	48	6	46	5	39	3
28	3.8°	151	54	4.5	52	4	45	2
30	3.4°	168	58	4.5	56	4	49	2
32	3.1°	185	62	4.5	60	4	53	2
35	2.7°	212	68	4	66	3.5	59	2
40	2.2°	260	78	4	76	3.5	69	2
50	1.7°	337	98	2	96	2	89	2
63	1.3°	441	124	2	122	2	115	2
80	1.0°	573	158	2	156	2	149	2
100	0.8°	716	198	1	196	1	189	1

Note 1) When machining highly ductile materials with ramping angles above, chips could be continuous.
In this case, decrease the ramping angle or feed per tooth.
*1 L (=10 / tan α). Cutters' moving distance until depth of cut reaches 10mm at a maximum ramping angle.
*2 In case corner radius of 0.8mm. Other than that, find with the below formula.
{(cutting edge diameter DC)−(corner radius)−0.2)}×2

MULTI FUNCTIONAL MILLING

TOOL NEWS

90° KAPR

APX4000

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	Hardened Steel

- **High accuracy, high quality vertical wall.**
- **Low cutting force insert.**

Fig.1

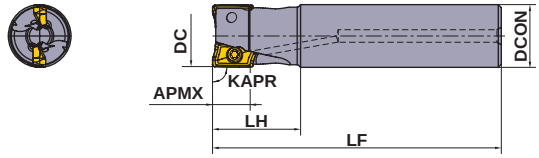
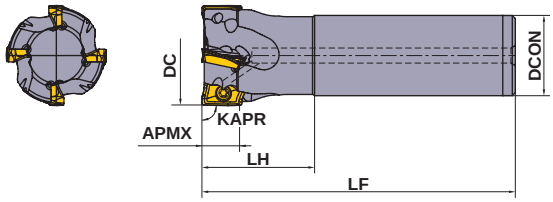


Fig.2



Right hand tool holder only.

■ SHANK TYPE

KAPR : 90°
With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	LF	LH	WT (kg)	APMX (mm)	RMPX	RPMX (min-1)	Fig.	Insert Type
25	**APX4000R252SA25SA**	●	2	25	115	35	0.40	15	11.0°	18900	1	AO◌T18
25	**APX4000R252SA25LA**	●	2	25	170	35	0.61	15	11.0°	18900	1	AO◌T18
25	**APX4000R252SA25ELA**	●	2	25	220	80	0.76	15	11.0°	18900	1	AO◌T18
28	**APX4000R282SA25LA**	●	2	25	170	35	0.63	15	9.0°	17700	2	AO◌T18
28	**APX4000R282SA25ELA**	●	2	25	220	35	0.81	15	9.0°	17700	2	AO◌T18
32	**APX4000R322SA32SA**	●	2	32	125	45	0.71	15	7.0°	16300	1	AO◌T18
32	**APX4000R323SA32SA**	●	3	32	125	45	0.71	15	7.0°	16300	1	AO◌T18
32	**APX4000R322SA32LA**	●	2	32	190	45	1.11	15	7.0°	16300	1	AO◌T18
32	**APX4000R323SA32LA**	●	3	32	190	45	1.11	15	7.0°	16300	1	AO◌T18
32	**APX4000R322SA32ELA**	●	2	32	260	100	1.49	15	7.0°	16300	1	AO◌T18
32	**APX4000R323SA32ELA**	●	3	32	260	100	1.49	15	7.0°	16300	1	AO◌T18
35	**APX4000R352SA32LA**	●	2	32	190	45	1.14	15	6.0°	15400	2	AO◌T18
35	**APX4000R353SA32LA**	●	3	32	190	45	1.14	15	6.0°	15400	2	AO◌T18
35	**APX4000R352SA32ELA**	●	2	32	260	45	1.57	15	6.0°	15400	2	AO◌T18
35	**APX4000R353SA32ELA**	●	3	32	260	45	1.57	15	6.0°	15400	2	AO◌T18
40	**APX4000R403SA32SA**	●	3	32	125	45	0.80	15	6.0°	14200	2	AO◌T18
40	**APX4000R404SA32SA**	●	4	32	125	45	0.80	15	6.0°	14200	2	AO◌T18
40	**APX4000R402SA32LA**	●	2	32	190	45	1.19	15	6.0°	14200	2	AO◌T18
40	**APX4000R403SA32LA**	●	3	32	190	45	1.19	15	6.0°	14200	2	AO◌T18
40	**APX4000R404SA32LA**	●	4	32	190	45	1.19	15	6.0°	14200	2	AO◌T18
40	**APX4000R402SA32ELA**	●	2	32	260	45	1.62	15	6.0°	14200	2	AO◌T18
40	**APX4000R403SA32ELA**	●	3	32	260	45	1.62	15	6.0°	14200	2	AO◌T18
40	**APX4000R404SA32ELA**	●	4	32	260	45	1.62	15	6.0°	14200	2	AO◌T18
50	**APX4000R504SA32SA**	●	4	32	125	45	0.93	15	4.0°	12400	2	AO◌T18
50	**APX4000R505SA32SA**	●	5	32	125	45	0.93	15	4.0°	12400	2	AO◌T18
63	**APX4000R634SA32SA**	●	4	32	125	45	1.15	15	3.0°	10800	2	AO◌T18
63	**APX4000R636SA32SA**	●	6	32	125	45	1.15	15	3.0°	10800	2	AO◌T18

Note 1) When using inserts with corner radius RE≥3.2mm, machining of the holder is required as shown on page M105.
Note 2) The maximum spindle speeds RPMX are set to ensure tool and insert stability.
Note 3) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

SPARE PARTS

DC (mm)	Tool Holder Type	DC (mm)	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
25	**APX4000R25**	28	**APX4000R28**	TPS4	TIP15W	MK1KS
32	**APX4000R32**	35	**APX4000R35**	TPS4	TIP15W	MK1KS
40	**APX4000R40**	40	**APX4000-040**	TPS43	TIP15W	MK1KS
50	**APX4000R50**	50	**APX4000-050**	TPS43	TIP15W	MK1KS
63	**APX4000R63**	63	**APX4000-063**	TPS43	TIP15W	MK1KS
80	**APX4000R080**	80	**APX4000-080**	TPS43	TIP15W	MK1KS
100	**APX4000R100**	100	**APX4000-100**	TPS43	TIP15W	MK1KS
125	**APX4000R125**	125	**APX4000-125**	TPS43	TIP15W	MK1KS
160	**APX4000R160**	160	**APX4000-160**	TPS43	TIP15W	MK1KS

* Clamp Torque (N • m) : TPS4 = 4.0, TPS43 = 4.0

● : **Inventory maintained in Japan.**

Fig.1

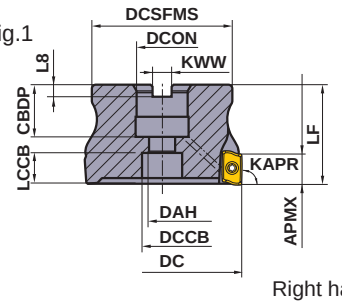
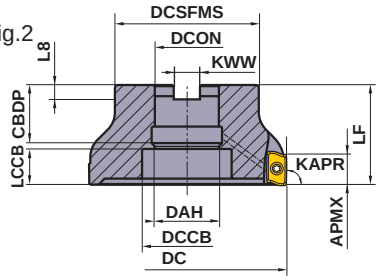
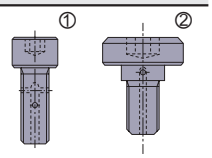


Fig.2



Right hand tool holder only.

DC	Set Bolt	Geometry
40	HSC08030H	①
50, 63	HSC10030H	①
80	HSC12035H	①
100	HSC16040H	①
125	MBA20040H	②
160	MBA24045H	②



■ARBOR TYPE

KAPR :90°
GAMP:+15°—+22° GAMF:+21°—+28°
With Coolant Hole

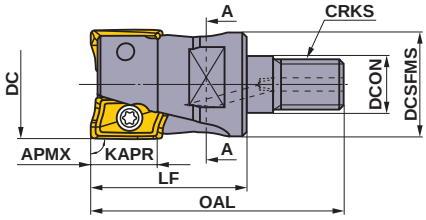
DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	RMPX	RPMX (min-1)	Fig.	Insert Type
40	**APX4000-040A04RA**	●	4	40	16	0.2	15	6.0°	14200	1	AO◌T18
50	**APX4000-050A05RA**	●	5	40	22	0.3	15	4.0°	12400	1	AO◌T18
63	**APX4000-063A06RA**	●	6	40	22	0.5	15	3.0°	10800	1	AO◌T18
80	**APX4000R08007CA**	●	7	50	25.4	1.2	15	2.0°	9300	1	AO◌T18
80	**APX4000-080A07RA**	●	7	50	27	1.2	15	2.0°	9300	1	AO◌T18
100	**APX4000R10008DA**	●	8	63	31.75	2.1	15	1.5°	8100	1	AO◌T18
100	**APX4000-100A08RA**	●	8	50	32	2.1	15	1.5°	8100	1	AO◌T18
125	**APX4000R12509EA**	●	9	63	38.1	3.3	15	1.0°	7100	2	AO◌T18
125	**APX4000-125A09RA**	●	9	63	40	3.3	15	1.0°	7100	2	AO◌T18
160	**APX4000-160A10RA**	●	10	63	40	4.8	15	1.0°	6100	2	AO◌T18
160	**APX4000R16010FA**	●	10	63	50.8	4.8	15	1.0°	6100	2	AO◌T18

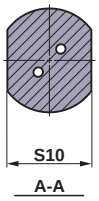
Note 1) When using inserts with corner radius RE≥3.2mm, machining of the holder is required as shown on page M105.
Note 2) The maximum spindle speeds RPMX are set to ensure tool and insert stability.
Note 3) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

Mounting Dimensions

DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8
40	**APX4000-040A04RA**	16	18	9	14	10.08	34	8.4	5.6
50	**APX4000-050A05RA**	22	20	11	17	12.26	45	10.4	6.3
63	**APX4000-063A06RA**	22	20	11	17	12.35	50	10.4	6.3
80	**APX4000R08007CA**	25.4	26	13	20	15.35	70	9.5	6
80	**APX4000-080A07RA**	27	23	13	20	15.35	60	12.4	7
100	**APX4000R10008DA**	31.75	32	17	26	20.35	80	12.7	8
100	**APX4000-100A08RA**	32	26	17	27	17.35	70	14.4	8
125	**APX4000R12509EA**	38.1	40	40	56	22.35	100	15.9	10
125	**APX4000-125A09RA**	40	40	42	56	22.35	90	16.4	9
160	**APX4000-160A10RA**	40	40	42	72	22.35	100	16.4	9
160	**APX4000R16010FA**	50.8	40	53	72	19.35	100	19.1	11

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001





Right hand tool holder only.

■ SCREW-IN TYPE

With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	DCSFMS	OAL	LF	S10	CRKS	WT (kg)	APMX (mm)	RMPX	Insert Type
25	**APX4000R252M12A35**	●	2	12.5	23.5	57	35	19	M12	0.2	15	11.0°	AO◌T18
28	**APX4000R282M12A35**	●	2	12.5	23.5	57	35	19	M12	0.2	15	9.0°	AO◌T18
32	**APX4000R322M16A40**	●	2	17	28.5	63	40	24	M16	0.3	15	7.0°	AO◌T18
32	**APX4000R323M16A40**	●	3	17	28.5	63	40	24	M16	0.3	15	7.0°	AO◌T18
35	**APX4000R352M16A40**	●	2	17	28.5	63	40	24	M16	0.3	15	6.0°	AO◌T18
35	**APX4000R353M16A40**	●	3	17	28.5	63	40	24	M16	0.3	15	6.0°	AO◌T18
40	**APX4000R403M16A40**	●	3	17	28.5	63	40	24	M16	0.3	15	6.0°	AO◌T18
40	**APX4000R404M16A40**	●	4	17	28.5	63	40	24	M16	0.3	15	6.0°	AO◌T18

Note 1) When using inserts with corner radius RE≥3.2mm, machining of the holder is required as shown on page M105.
Note 2) For screw-in type arbors, refer to page M269.

SPARE PARTS

DC (mm)	Tool Holder Type	Clamp Screw *	Wrench	Anti-seize Lubricant
25	**APX4000R25**	TPS4	TIP15W	MK1KS
28	**APX4000R28**	TPS4	TIP15W	MK1KS
32	**APX4000R32**	TPS4	TIP15W	MK1KS
35	**APX4000R35**	TPS4	TIP15W	MK1KS
40	**APX4000R40**	TPS43	TIP15W	MK1KS

* Clamp Torque (N • m) : TPS4 = 4.0, TPS43 = 4.0

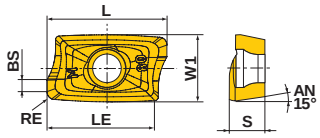
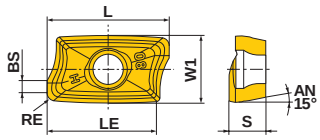
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT
	P	Steels		◐	✠				◐	◐
	M	Stainless Steels				◔			◔	◔
	K	Cast Irons	◐						✠	✠
	S	Heat Resistant Alloys, Titanium Alloys					◐	✠	◐	✠
	H	Hardened Steels							◔	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

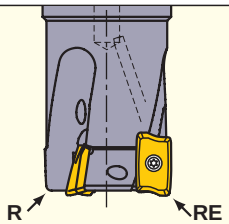
Honing :
E : Round

Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	L	LE	W1	S	BS	RE *	Geometry
				Coated								Dimensions (mm)						
General **M** Breaker	**AOMT184804PEER-M**	M	E		●	●	●	●	●	●	●	18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-M	M	E		●	●	●	●	●	●	●	18	15	9	4.8	1.4	0.8	
	AOMT184810PEER-M	M	E		●			●	●	●		18	15	9	4.8	1.0	1.0	
	AOMT184812PEER-M	M	E		●			●	●	●		18	15	9	4.8	0.8	1.2	
	AOMT184816PEER-M	M	E		●	●	●	●	●	●	●	18	15	9	4.8	0.4	1.6	
	AOMT184820PEER-M	M	E		●			●	●	●		18	15	9	4.8	0.4	2.0	
Strong Cutting Edge Type **H** Breaker	**AOMT184804PEER-H**	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-H	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	1.4	0.8	
	AOMT184816PEER-H	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	0.4	1.6	
	AOMT184832PEER-H	M	E			●	●				●	18	15	9	4.8	0.4	3.2	
	AOMT184840PEER-H	M	E			●	●				●	18	15	9	4.8	0.4	4.0	
	AOMT184850PEER-H	M	E			●	●				●	18	15	9	4.8	–	5.0	
	AOMT184864PEER-H	M	E			●	●				●	18	15	9	4.8	–	6.35	

* Corner radius RE is different from the work material of R shape depending on the axial rake angle of the body.

Note on Use of Inserts with Large Corner Radii

When using inserts with corner radius RE≥R3.2mm, please machine the holder with a radius form as shown on the right table.



RE (mm)	R (mm)
3.2	2.0
4.0	2.5
5.0	3.5
6.35	5.0

R : Holder End Radius
RE : Insert Corner Radius

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

	Work Material	Characteristics	Insert Grade Priority 1st	Insert Grade Priority 2nd	Breaker		ae (mm) ≤0.25DC	0.25—0.5DC	0.5—0.75DC	DC (Slot)
							Cutting Speed **vc** (m/min)			
P	Mild Steel	≤180HB	MP6120	VP15TF	M	H	230(180—270)	220(170—260)	180(140—210)	180(140—210)
			MP6130	VP20RT	M	H	200(150—240)	190(140—230)	150(110—180)	150(110—180)
	Carbon Steel Alloy Steel	180—350HB	MP6120	VP15TF	M	H	180(140—210)	170(130—200)	140(110—160)	140(110—160)
			MP6130	VP20RT	M	H	150(110—180)	140(100—170)	110(80—130)	110(80—130)
M	Stainless Steel	≤270HB	MP7130	VP20RT	M	H	180(140—210)	170(130—200)	140(110—160)	140(110—160)
K	Gray Cast Iron	≤350MPa	MC5020	VP15TF	H	—	250(200—300)	240(190—290)	210(160—260)	140(110—160)
	Ductile, Cast Iron	≤800MPa	MC5020	VP15TF	H	—	130(100—150)	120(90—140)	100(80—120)	100(80—120)
S	Titanium Alloy	≤350HB	MP9120	VP15TF	H	M	50(40—70)	—	—	50(40—70)
			MP9130	VP20RT	H	M	40(30—60)	—	—	40(30—60)
	Heat-resistant Alloy	—	MP9120	VP15TF	H	M	40(30—60)	—	—	40(30—60)
			MP9130	VP20RT	H	M	30(20—40)	—	—	30(20—40)
H	Hardened Steel	40—55HRC	VP15TF	—	H	—	90(70—100)	85(60—100)	70(50—80)	70(50—80)

DEPTH OF CUT AND FEED PER TOOTH

	Work Material	Characteristics	ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.) Cutter Diameter DC (mm) ø25—ø40	ø50—ø80	ø100—ø160
P	Mild Steel Carbon Steel Alloy Steel	≤180HB 180—350HB	≤0.5DC	≤5	0.30	0.30	0.25
				5—7.5	0.25	0.25	0.20
				7.5—10	0.20	0.20	0.15
				10—12.5	0.15	0.15	0.10
				12.5—15	0.10	0.10	0.07
			0.5—0.75DC	≤5	0.20	0.20	0.15
				5—10	0.15	0.15	0.10
				10—15	0.10	0.10	0.07
			DC (Slot)	≤5	0.15	0.15	0.15
				5—7.5	0.10	0.10	0.10
				7.5—10	0.07	0.07	0.07
M	Stainless Steel	≤270HB	≤0.5DC	≤5	0.30	0.25	0.25
				5—7.5	0.25	0.20	0.20
				7.5—10	0.20	0.15	0.15
				10—12.5	0.15	0.10	0.10
				12.5—15	0.10	0.07	0.07
			0.5—0.75DC	≤5	0.20	0.15	0.15
				5—10	0.15	0.10	0.10
				10—15	0.10	0.07	0.07
			DC (Slot)	≤5	0.15	0.15	0.15
				5—7.5	0.10	0.10	0.10
				7.5—10	0.07	0.07	0.07
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.5DC	≤5	0.30	0.30	0.25
				5—7.5	0.25	0.25	0.20
				7.5—10	0.20	0.20	0.15
				10—12.5	0.15	0.15	0.10
				12.5—15	0.10	0.10	0.07
			0.5—0.75DC	≤5	0.20	0.20	0.15
				5—10	0.15	0.15	0.10
				10—15	0.10	0.10	0.07
			DC (Slot)	≤5	0.15	0.15	0.15
				5—7.5	0.10	0.10	0.10
				7.5—10	0.07	0.07	0.07
	Ductile, Cast Iron	Tensile Strength ≤800MPa	≤0.5DC	≤5	0.25	0.25	0.25
				5—7.5	0.20	0.20	0.20
				7.5—10	0.15	0.15	0.15
				10—12.5	0.10	0.10	0.10
				12.5—15	0.07	0.07	0.07
			0.5—0.75DC	≤5	0.20	0.20	0.15
				5—10	0.15	0.15	0.10
				10—15	0.10	0.10	0.07
			DC (Slot)	≤5	0.15	0.15	0.15
				5—7.5	0.10	0.10	0.10
				7.5—10	0.07	0.07	0.07

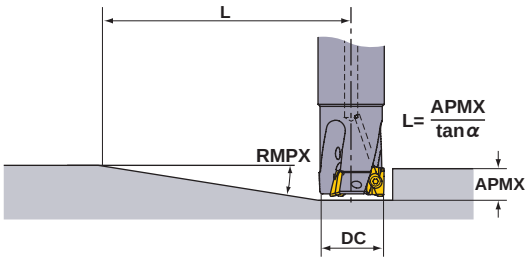
Work Material		Characteristics	ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.) Cutter Diameter DC (mm)		
					ø25—ø40	ø50—ø80	ø100—ø160
S	Titanium Alloy	≤350HB	≤0.25DC	≤5	0.15	0.10	0.10
				5—7.5	0.10	0.05	0.05
				7.5—10	0.05	—	—
			DC (Slot)	≤5	0.05	0.05	0.05
	Heat-resistant Alloy	—	≤0.25DC	≤2	0.10	0.05	0.05
			DC (Slot)	≤1	0.05	0.05	0.05
H	Hardened Steel	40—55HRC	≤0.25DC	≤5	0.15	0.15	0.15
				5—7.5	0.10	0.10	0.10
				7.5—10	0.07	0.07	0.07
			0.25—0.5DC	≤5	0.10	0.10	0.10
				5—7.5	0.07	0.07	0.07
			0.5—0.75DC	≤5	0.07	0.07	0.07
			DC (Slot)	≤5	0.07	0.07	0.07

Note 1) These cutting conditions are a guide to the standard shank type and the arbor type.
Please make adjustments according to the machining conditions.
Note 2) Vibration is liable to occur in certain cases. Please reduce the depth of cut and / or reduce cutting conditions in the following cases.
- When using the long shank type and extra long shank type.
- When using long tool overhang with the standard or arbor type.
- When the application has poor clamping rigidity or when using a low rigidity machine.

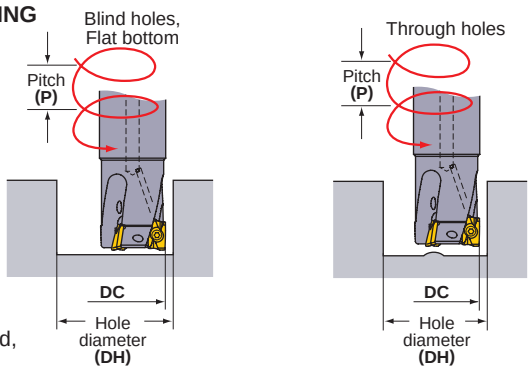
Note 3) In case of coarse and fine pitch cutters, the coarse pitch type is recommended to prevent vibration.
Note 4) For heavy interrupted and unstable cutting, the H breaker is first recommendation.

RAMPING/HELICAL CUTTING

● RAMPING



● HELICAL CUTTING



Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

Cutting Edge Diameter DC (mm)	Ramping		Helical Cutting (Blind Hole, Flat Bottom)				Helical Cutting (Through Hole)	
	Maximum Ramping Angle RMPX	Minimum Distance *1 L (mm)	Maximum Hole Diameter *2 DH max. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)
25	11°	85	48	14	45	12	32	4
28	9°	105	54	12	51	11	38	4
32	7°	135	62	11	59	10	46	5
35	6°	158	68	10	65	9	52	5
40	6°	158	78	12	75	11	62	7
50	4°	238	98	10	95	9	82	7
63	3°	318	124	10	121	9	108	7
80	2°	477	158	8	155	8	142	6
100	1.5°	636	198	8	195	7	182	6
125	1°	954	248	6	245	6	232	5
160	1°	954	318	8	315	8	302	7

Note 1) When machining highly ductile materials with ramping angles above, chips could be continuous.
In this case, decrease the ramping angle or feed per tooth.
*1 L (=15 / tan α). Cutters' moving distance until depth of cut reaches 15mm at a maximum ramping angle.
*2 In case corner radius of 0.8mm. Other than that, find with the below formula.
{(cutting edge diameter DC)−(corner radius)−0.2}×2

■ CAUTION FOR USE

- Only use the inserts and parts provided by Mitsubishi Materials with this tool.
- Clamp the inserts at a specified torque of only.
- The maximum spindle speeds **RPMX** are shown in Table 1. Ensure that the cutter operates under the maximum spindle speed.
  The maximum spindle speeds **RPMX** for safety purposes are determined in accordance with ISO15641
  (Milling Cutters for high speed machining–Safety requirements).

Table 1 Max. Spindle Speed RPMX

Cutting Edge Diameter **DC** (mm)	ø12	ø14	ø16	ø18	ø20	ø22	ø25	ø28	ø30
Max. Spindle Speed **RPMX**(min^{-1})	–	–	19500	17000	15000	14000	12000	11000	10000

Cutting Edge Diameter **DC** (mm)	ø32	ø35	ø40	ø50	ø63	ø80	ø100	ø125	ø160
Max. Spindle Speed **RPMX**(min^{-1})	9500	9000	7500	6000	5000	3500	3000	2500	1500

- It is recommended that flank wear does not exceed 0.3mm.

Memo

MULTI-FUNCTIONAL MILLING

TOOL NEWS

90° KAPR

VPX200 NEW

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

Fig.1

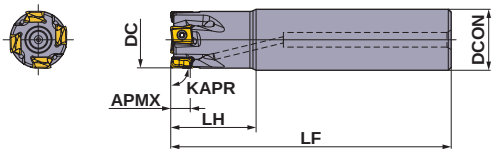
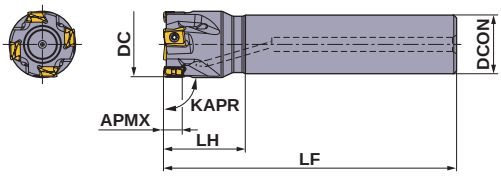


Fig.2



Right hand tool holder only.

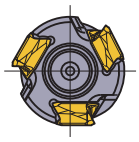
■SHANK TYPE

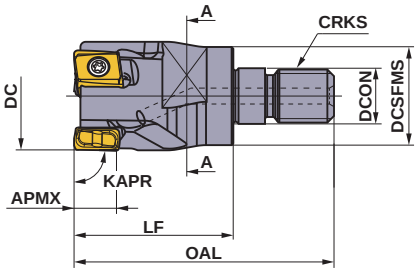
With Coolant Hole

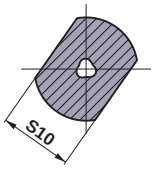
DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	LF	LH	APMX (mm)	RMPX	Max. Spindle Speed (min^{-1})	WT (kg)	Fig.	Insert Type
16	**VPX200R1602SA16S**	●	2	16	85	25	8	1.85°	37900	0.11	1	LOGU09
18	**VPX200R1802SA16S**	●	2	16	85	25	8	1.56°	35300	0.12	2	LOGU09
18	**VPX200R1802SA16L**	●	2	16	120	25	8	1.56°	35300	0.17	2	LOGU09
20	**VPX200R2002SA16S**	●	2	16	100	25	8	1.35°	33200	0.14	2	LOGU09
20	**VPX200R2003SA16S**	●	3	16	100	25	8	1.35°	33200	0.14	2	LOGU09
20	**VPX200R2002SA20S**	●	2	20	100	30	8	1.35°	33200	0.21	1	LOGU09
20	**VPX200R2003SA20S**	●	3	20	100	30	8	1.35°	33200	0.21	1	LOGU09
20	**VPX200R2002SA20L**	●	2	20	150	60	8	1.35°	33200	0.32	1	LOGU09
22	**VPX200R2202SA20S**	●	2	20	115	30	8	1.16°	31400	0.26	2	LOGU09
22	**VPX200R2203SA20S**	●	3	20	115	30	8	1.16°	31400	0.25	2	LOGU09
22	**VPX200R2202SA20L**	●	2	20	150	30	8	1.16°	31400	0.34	2	LOGU09
25	**VPX200R2503SA20S**	●	3	20	115	30	8	0.97°	29000	0.26	2	LOGU09
25	**VPX200R2504SA20S**	●	4	20	115	30	8	0.97°	29000	0.26	2	LOGU09
25	**VPX200R2503SA25S**	●	3	25	115	35	8	0.97°	29000	0.39	1	LOGU09
25	**VPX200R2504SA25S**	●	4	25	115	35	8	0.97°	29000	0.39	1	LOGU09
25	**VPX200R2503SA25L**	●	3	25	170	70	8	0.97°	29000	0.57	1	LOGU09
28	**VPX200R2803SA25S**	●	3	25	115	35	8	0.84°	27200	0.41	2	LOGU09
28	**VPX200R2804SA25S**	●	4	25	115	35	8	0.84°	27200	0.41	2	LOGU09
28	**VPX200R2803SA25L**	●	3	25	170	35	8	0.84°	27200	0.61	2	LOGU09
30	**VPX200R3003SA25S**	●	3	25	125	35	8	0.77°	26000	0.46	2	LOGU09
30	**VPX200R3004SA25S**	●	4	25	125	35	8	0.77°	26000	0.46	2	LOGU09
32	**VPX200R3203SA32S**	●	3	32	125	45	8	0.71°	25100	0.70	1	LOGU09
32	**VPX200R3204SA32S**	●	4	32	125	45	8	0.71°	25100	0.70	1	LOGU09
32	**VPX200R3205SA32S**	●	5	32	125	45	8	0.71°	25100	0.70	1	LOGU09
32	**VPX200R3203SA32L**	●	3	32	190	90	8	0.71°	25100	1.06	1	LOGU09
35	**VPX200R3503SA32L**	●	3	32	190	45	8	0.63°	23800	1.14	2	LOGU09
40	**VPX200R4004SA32S**	●	4	32	125	45	8	0.54°	22000	0.81	2	LOGU09
40	**VPX200R4006SA32S**	●	6	32	125	45	8	0.54°	22000	0.80	2	LOGU09
50	**VPX200R5005SA32S**	●	5	32	125	45	8	0.42°	19200	0.91	2	LOGU09
50	**VPX200R5007SA32S**	●	7	32	125	45	8	0.42°	19200	0.91	2	LOGU09

Note 1) The maximum spindle speeds are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

● : **Inventory maintained in Japan.**







A-A Section

Right hand tool holder only.

■ SCREW-IN TYPE

With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	DCSFMS	OAL	LF	S10	CRKS	WT (kg)	APMX (mm)	RMPX	Insert Type
16	**VPX200R1602AM0830**	●	2	8.5	14.5	48	30	10	M08	0.03	8	1.85°	LOGU09
18	**VPX200R1802AM0830**	●	2	8.5	14.5	48	30	10	M08	0.04	8	1.56°	LOGU09
20	**VPX200R2002AM1030**	●	2	10.5	18.5	49	30	14	M10	0.06	8	1.35°	LOGU09
20	**VPX200R2003AM1030**	●	3	10.5	18.5	49	30	14	M10	0.06	8	1.35°	LOGU09
22	**VPX200R2202AM1030**	●	2	10.5	18.5	49	30	14	M10	0.06	8	1.16°	LOGU09
22	**VPX200R2203AM1030**	●	3	10.5	18.5	49	30	14	M10	0.06	8	1.16°	LOGU09
25	**VPX200R2503AM1235**	●	3	12.5	23.5	57	35	19	M12	0.11	8	0.97°	LOGU09
25	**VPX200R2504AM1235**	●	4	12.5	23.5	57	35	19	M12	0.11	8	0.97°	LOGU09
32	**VPX200R3203AM1640**	●	3	17	28.5	63	40	24	M16	0.21	8	0.71°	LOGU09
32	**VPX200R3204AM1640**	●	4	17	28.5	63	40	24	M16	0.21	8	0.71°	LOGU09
32	**VPX200R3205AM1640**	●	5	17	28.5	63	40	24	M16	0.21	8	0.71°	LOGU09
35	**VPX200R3503AM1640**	●	3	17	28.5	63	40	24	M16	0.24	8	0.63°	LOGU09
35	**VPX200R3505AM1640**	●	5	17	28.5	63	40	24	M16	0.23	8	0.63°	LOGU09
40	**VPX200R4004AM1640**	●	4	17	28.5	63	40	24	M16	0.26	8	0.54°	LOGU09
40	**VPX200R4006AM1640**	●	6	17	28.5	63	40	24	M16	0.26	8	0.54°	LOGU09

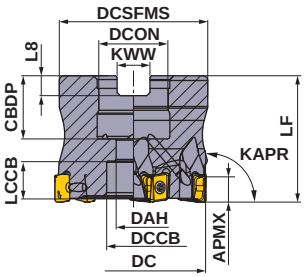
Note 1) For screw-in type arbors, refer to page M269.

SPARE PARTS

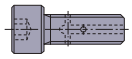
DC	Tool Holder Type	Clamp Screw *	Wrench	Anti-seize Lubricant
16	**VPX200R16**	TPS27F1	TIP07F	MK1KS
18	**VPX200R18**	TPS27F1	TIP07F	MK1KS
20	**VPX200R20**	TPS27F1	TIP07F	MK1KS
22	**VPX200R22**	TPS27F2	TIP07F	MK1KS
25	**VPX200R25**	TPS27F2	TIP07F	MK1KS
28	**VPX200R28**	TPS27F2	TIP07F	MK1KS
30	**VPX200R30**	TPS27F2	TIP07F	MK1KS
32	**VPX200R32**	TPS27F2	TIP07F	MK1KS
35	**VPX200R35**	TPS27F2	TIP07F	MK1KS
40	**VPX200R40**	TPS27F2	TIP07F	MK1KS
50	**VPX200R50**	TPS27F2	TIP07F	MK1KS

* Clamp Torque (N • m) : TPS27F1 = 1.0,TPS27F2 = 1.0

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001



Right hand tool holder only.

DC	Set Bolt	Geometry
ϕ32, ϕ40	HSC08025H	
ϕ50, ϕ63	HSC10030H	

■ARBOR TYPE

KAPR: 90°
GAMP: –6° GAMF: –25°
With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	RMPX	Max. Spindle Speed (min^{-1})	Insert Type
32	**VPX200-032A03AR**	●	3	35	16	0.11	8	0.71°	25100	LOGU09
32	**VPX200-032A05AR**	●	5	35	16	0.11	8	0.71°	25100	LOGU09
40	**VPX200-040A04AR**	●	4	40	16	0.23	8	0.54°	22000	LOGU09
40	**VPX200-040A06AR**	●	6	40	16	0.22	8	0.54°	22000	LOGU09
50	**VPX200-050A05AR**	●	5	40	22	0.36	8	0.42°	19200	LOGU09
50	**VPX200-050A07AR**	●	7	40	22	0.36	8	0.42°	19200	LOGU09
63	**VPX200-063A06AR**	●	6	40	22	0.66	8	0.32°	16700	LOGU09
63	**VPX200-063A09AR**	●	9	40	22	0.66	8	0.32°	16700	LOGU09

Note 1) The maximum spindle speeds are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

Mounting Dimensions

DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8
32	**VPX200-032A03AR**	16	18	9	14	8	30	8.4	5.6
32	**VPX200-032A05AR**	16	18	9	14	8	30	8.4	5.6
40	**VPX200-040A04AR**	16	18	9	14	13	37	8.4	5.6
40	**VPX200-040A06AR**	16	18	9	14	13	37	8.4	5.6
50	**VPX200-050A05AR**	22	20	11	17	11	47	10.4	6.3
50	**VPX200-050A07AR**	22	20	11	17	11	47	10.4	6.3
63	**VPX200-063A06AR**	22	20	11	17	11	60	10.4	6.3
63	**VPX200-063A09AR**	22	20	11	17	11	60	10.4	6.3

SPARE PARTS

DC	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
32	**VPX200-032**	TPS27F2	TIP07F	MK1KS
40	**VPX200-040**	TPS27F2	TIP07F	MK1KS
50	**VPX200-050**	TPS27F2	TIP07F	MK1KS
63	**VPX200-063**	TPS27F2	TIP07F	MK1KS

* Clamp Torque (N • m) : TPS27F2 = 1.0

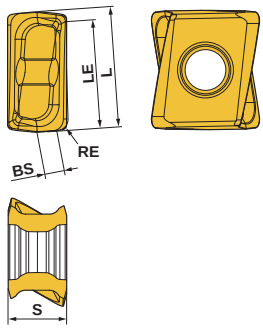
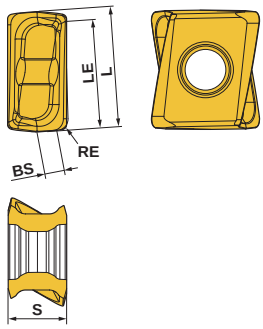
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF		TF15	
	P	Steel		◐	✠				◐			
	M	Stainless Steel				◐			◐			
	K	Cast Iron	◐						✠			
	N	Non-ferrous Metal									◐	
	S	Heat-resistant Alloy, Titanium Alloy					◐	✠	◐			
	H	Hardened Steel							◐			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	Coated								Carbide		Dimensions(mm)					Geometry
				MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF		TF15		L	RE	LE	S	BS	
Low Resistance Type **L Breaker**	**LOGU0904020PNER-L**	G	E	●	●	●	●	●	●	●				8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNER-L	G	E	●	●	●	●	●	●	●				8.7	0.4	7.6	4.3	1.5	
	LOGU0904080PNER-L	G	E	●	●	●	●	●	●	●				8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNER-L	G	E	●	●	●	●	●	●	●				8.7	1.0	7.6	4.3	1.0	
	LOGU0904120PNER-L	G	E	●	●	●	●	●	●	●				8.7	1.2	7.6	4.3	0.8	
	LOGU0904160PNER-L	G	E	●	●	●	●	●	●	●				8.7	1.6	7.6	4.3	0.5	
	LOGU0904020PNFR-L	G	F									●		8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNFR-L	G	F									●		8.7	0.4	7.6	4.3	1.5	
	LOGU0904080PNFR-L	G	F									●		8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNFR-L	G	F									●		8.7	1.0	7.6	4.3	1.0	
	LOGU0904120PNFR-L	G	F									●		8.7	1.2	7.6	4.3	0.8	
	LOGU0904160PNFR-L	G	F									●		8.7	1.6	7.6	4.3	0.5	Right hand insert only.
General M Breaker	**LOGU0904020PNER-M**	G	E	●	●	●	●	●	●	●				8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNER-M	G	E	●	●	●	●	●	●	●				8.7	0.4	7.6	4.3	1.6	
	LOGU0904080PNER-M	G	E	●	●	●	●	●	●	●				8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNER-M	G	E	●	●	●	●	●	●	●				8.7	1.0	7.6	4.3	1.0	
	LOGU0904120PNER-M	G	E	●	●	●	●	●	●	●				8.7	1.2	7.6	4.3	0.9	
	LOGU0904160PNER-M	G	E	●	●	●	●	●	●	●				8.7	1.6	7.6	4.3	0.5	
	LOGU0904020PNFR-M	G	F									●		8.7	0.2	7.6	4.3	1.7	
	LOGU0904040PNFR-M	G	F									●		8.7	0.4	7.6	4.3	1.6	
	LOGU0904080PNFR-M	G	F									●		8.7	0.8	7.6	4.3	1.2	
	LOGU0904100PNFR-M	G	F									●		8.7	1.0	7.6	4.3	1.0	
	LOGU0904120PNFR-M	G	F									●		8.7	1.2	7.6	4.3	0.9	
	LOGU0904160PNFR-M	G	F									●		8.7	1.6	7.6	4.3	0.5	Right hand insert only.

RECOMMENDED CUTTING CONDITIONS

■ Breaker Selection Table by Work Material Cutting State

	Work Material	Characteristics	Cutting Conditions	Breaker		Grade	
				1st Recommended	2nd Recommended	1st Recommended	2nd Recommended
P	Mild Steel	Hardness ≤180HB	● ◐	L	M	MP6120	VP15TF
			✣	M	L	MP6130	–
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180-350HB ≤350HB (Annealing)	●	L	M	MP6120	VP15TF
			◐	M	L	MP6120	VP15TF
			✣	M	L	MP6130	–
	Pre-hardened Steel	Hardness 35–45HRC	● ◐	M	L	MP6120	VP15TF
			✣	M	L	MP6130	–
M	Austenitic Stainless Steel	Hardness ≤280HB	● ◐	L	M	MP7130	VP15TF
			✣	M	L	MP7130	–
		Hardness >200HB	● ◐	L	M	MP7130	VP15TF
			✣	M	L	MP7130	–
	Duplex Stainless Steel	Hardness ≤280HB	● ◐	L	M	MP7130	VP15TF
			✣	M	L	MP7130	–
	Ferritic and Martensitic Stainless Steel	–	● ◐	L	M	MP7130	VP15TF
			✣	M	L	MP7130	–
	Precipitation Hardening Stainless Steel	Hardness <450HB	● ◐	L	M	MP7130	VP15TF
			✣	M	L	MP7130	–
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐	M	L	MC5020	VP15TF
			✣	M	L	VP15TF	–
	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐	M	L	MC5020	VP15TF
			✣	M	L	VP15TF	–
N	Aluminium Alloy	Content Si<5%	● ◐	L	M	TF15	–
			✣	M	L	TF15	–
S	Titanium Alloy (Ti-6Al-4V,etc.)	–	● ◐	L	M	MP9120	VP15TF
			✣	M	L	MP9130	–
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr,etc.)	–	● ◐	L	M	MP9120	VP15TF
			✣	M	L	MP9130	–
	Heat Resistant Alloy	–	● ◐	M	L	MP9120	VP15TF
			✣	M	L	MP9130	–
H	Hardened Steel	Hardness 40–55HRC	● ◐ ✣	M	–	VP15TF	–

The following table shows recommended conditions for dry cutting and wet cutting accordingly.

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

■ Dry cutting
Cutting Speed

	Work Material	Characteristics	Cutting Conditions	Grade	ae (mm) ≤0.25DC	0.25—0.5DC	0.5—0.75DC	DC(Slot)
					vc (m/min)			
P	Mild Steel	Hardness ≤180HB	● ◐	MP6120,VP15TF	230 (180—270)	220 (170—260)	180 (140—210)	180 (140—210)
			✣	MP6130	200 (150—240)	190 (140—230)	150 (110—180)	150 (110—180)
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—350HB ≤350HB (Annealing)	● ◐	MP6120,VP15TF	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
			✣	MP6130	150 (110—180)	140 (100—170)	110 (80—130)	110 (80—130)
	Pre-hardened Steel	Hardness 35—45HRC	● ◐	MP6120,VP15TF	120 (90—140)	110 (80—130)	100 (70—120)	100 (70—120)
			✣	MP6130	100 (80—120)	90 (70—110)	80 (60—100)	80 (60—100)
M	Austenitic Stainless Steel	Hardness ≤200HB	● ◐ ✣	MP7130,VP15TF	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
		Hardness >200HB	● ◐ ✣	MP7130,VP15TF	150 (110—180)	140 (100—160)	110 (80—130)	110 (80—130)
	Duplex Stainless Steel	Hardness ≤280HB	● ◐ ✣	MP7130,VP15TF	140 (110—170)	130 (90—150)	100 (70—120)	100 (70—120)
	Ferritic and Martensitic Stainless Steel	—	● ◐ ✣	MP7130,VP15TF	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
	Precipitation Hardening Stainless Steel	Hardness <450HB	● ◐ ✣	MP7130,VP15TF	130 (100—160)	120 (80—140)	90 (60—110)	90 (60—110)
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐	MC5020	250 (200—300)	240 (190—290)	210 (160—260)	210 (160—260)
			● ◐ ✣	VP15TF	200 (150—250)	190 (140—240)	160 (110—210)	160 (110—210)
	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐	MC5020	180 (150—200)	170 (140—190)	150 (120—170)	150 (120—170)
			● ◐ ✣	VP15TF	130 (100—150)	120 (90—140)	100 (80—120)	100 (80—120)
N	Aluminium Alloy	Content Si<5%	● ◐ ✣	TF15	600 (400—1000)	600 (400—1000)	600 (400—1000)	600 (400—1000)
H	Hardened Steel	Hardness 40—55HRC	● ◐ ✣	VP15TF	90 (70—100)	85 (60—100)	70 (50—80)	70 (50—80)

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø16—ø18 ap (mm)	fz (mm/t.)	ø20—ø25 ap (mm)	fz (mm/t.)	ø28—ø63 ap (mm)	fz (mm/t.)
P	Mild Steel	Hardness ≤180HB	≤0.25DC	● ◐ ✣	≤6	0.10—0.15	≤8	0.10—0.20	≤8	0.10—0.25
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.10—0.15	≤8	0.10—0.20
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.10—0.15
			DC(Slot)	● ◐ ✣	≤2	0.06—0.10	≤4	0.06—0.10	≤4	0.08—0.12
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—280HB	≤0.25DC	● ◐ ✣	≤6	0.10—0.15	≤8	0.10—0.20	≤8	0.10—0.25
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.10—0.15	≤8	0.10—0.20
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.10—0.15
			DC(Slot)	● ◐ ✣	≤2	0.06—0.10	≤4	0.06—0.10	≤4	0.08—0.12
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 280—350HB ≤350HB (Annealing)	≤0.25DC	● ◐ ✣	≤6	0.10—0.15	≤8	0.10—0.15	≤8	0.10—0.20
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.10—0.15
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.06—0.10	≤6	0.08—0.12
			DC(Slot)	● ◐ ✣	≤2	0.06—0.10	≤4	0.06—0.10	≤4	0.05—0.10
	Pre-hardened Steel	Hardness 35—45HRC	≤0.25DC	● ◐ ✣	≤6	0.10—0.15	≤8	0.10—0.15	≤8	0.10—0.20
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.10—0.15
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.06—0.10	≤6	0.08—0.12
			DC(Slot)	● ◐ ✣	≤2	0.06—0.10	≤4	0.06—0.10	≤4	0.06—0.10

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

RECOMMENDED CUTTING CONDITIONS

■ Dry cutting
Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø16—ø18 ap (mm)	ø16—ø18 fz (mm/t.)	ø20—ø25 ap (mm)	ø20—ø25 fz (mm/t.)	ø28—ø63 ap (mm)	ø28—ø63 fz (mm/t.)
M	Austenitic Stainless Steel	—	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
	Duplex Stainless Steel	Hardness ≤280HB	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
	Ferritic and Martensitic Stainless Steel	—	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
	Precipitation Hardening Stainless Steel	Hardness <450HB	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.15	≤8	0.1 —0.15
				✣	≤6	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.06—0.1	≤6	0.06—0.1
				✣	≤4	0.06—0.08	≤6	0.06—0.08	≤6	0.06—0.08
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.25
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.1 —0.2
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.1 —0.2
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.1 —0.15
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.1 —0.15
				✣	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.08—0.12
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.08—0.15
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.08—0.1
	Ductile Cast Iron	Tensile Strength ≤800MPa	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
N	Aluminium Alloy	Content Si< 5%	≤0.25DC	● ◐	≤6	0.1 —0.2	≤8	0.1 —0.25	≤8	0.1 —0.25
				✣	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
			0.25—0.5DC	● ◐	≤5	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤5	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.06—0.15	≤6	0.08—0.15
				✣	≤4	0.06—0.1	≤6	0.06—0.15	≤6	0.08—0.15
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.15	≤4	0.08—0.15
				✣	≤2	0.06—0.08	≤4	0.06—0.12	≤4	0.08—0.12
H	Hardened Steel	Hardness 40—55HRC	≤0.25DC	● ◐	≤4	0.08—0.15	≤4	0.08—0.15	≤4	0.08—0.15
				✣	≤4	0.08—0.12	≤4	0.08—0.12	≤4	0.08—0.12
			0.25—0.5DC	● ◐	≤3	0.08—0.12	≤3	0.08—0.12	≤3	0.08—0.12
				✣	≤3	0.06—0.1	≤3	0.08—0.1	≤3	0.06—0.1
			0.5—0.75DC	● ◐	≤2	0.06—0.1	≤2	0.08—0.1	≤2	0.06—0.1
				✣	≤2	0.06—0.08	≤2	0.06—0.08	≤2	0.06—0.08
			DC(Slot)	● ◐	≤1	0.06—0.1	≤1	0.06—0.1	≤1	0.06—0.1
				✣	≤1	0.06—0.08	≤1	0.06—0.08	≤1	0.06—0.08

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

■ Wet Cutting
Cutting Speed

	Work Material	Characteristics	Cutting Conditions	Grade	ae (mm) ≤0.25DC	0.25—0.5DC	0.5—0.75DC	DC(Slot)
					vc (m/min)			
P	Mild Steel	Hardness ≤180HB	● ◐ ✣	MP6120 MP6130 VP15TF	140 (100—190)	130 (90—180)	100 (70—120)	100 (70—120)
P	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—350HB ≤350HB (Annealing)	● ◐ ✣	MP6120 MP6130 VP15TF	120 (90—140)	110 (80—130)	100 (70—120)	100 (70—120)
P	Pre-hardened Steel	Hardness 35—45HRC	● ◐ ✣	MP6120 MP6130 VP15TF	100 (80—120)	90 (70—110)	80 (60—100)	80 (60—100)
M	Austenitic Stainless Steel	Hardness ≤200HB	● ◐ ✣	MP7130,VP15TF	120 (100—150)	110 (90—140)	90 (70—120)	90 (70—120)
M	Austenitic Stainless Steel	Hardness >200HB	● ◐ ✣	MP7130,VP15TF	100 (80—130)	90 (70—110)	70 (50—100)	70 (50—100)
M	Duplex Stainless Steel	Hardness ≤280HB	● ◐ ✣	MP7130,VP15TF	100 (80—130)	90 (70—120)	70 (50—100)	70 (50—100)
M	Ferritic and Martensitic Stainless Steel	—	● ◐ ✣	MP7130,VP15TF	120 (100—150)	110 (90—140)	90 (70—120)	90 (70—120)
M	Precipitation Hardening Stainless Steel	Hardness <450HB	● ◐ ✣	MP7130,VP15TF	90 (70—120)	80 (60—110)	60 (40—90)	60 (40—90)
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐	MC5020	180 (160—220)	170 (150—210)	150 (130—190)	150 (130—190)
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐ ✣	VP15TF	130 (100—150)	120 (90—140)	100 (80—120)	100 (80—120)
K	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐	MC5020	160 (140—180)	150 (130—170)	130 (110—150)	130 (110—150)
K	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐ ✣	VP15TF	110 (80—140)	100 (70—130)	80 (60—120)	80 (60—120)
N	Aluminium Alloy	Content Si<5%	● ◐ ✣	TF15	600 (400—1000)	600 (400—1000)	600 (400—1000)	600 (400—1000)
S	Titanium Alloy (Ti-6Al-4V,etc.)	—	● ◐	MP9120,VP15TF	50 (40—70)	50 (40—70)	50 (40—70)	50 (40—70)
S	Titanium Alloy (Ti-6Al-4V,etc.)	—	✣	MP9130	40 (30—60)	40 (30—60)	40 (30—60)	40 (30—60)
S	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr,etc.)	—	● ◐ ✣	MP9120 MP9130 VP15TF	30 (20—40)	30 (20—40)	30 (20—40)	30 (20—40)
S	Heat Resistant Alloy	—	● ◐	MP9120,VP15TF	40 (30—60)	40 (30—60)	40 (30—60)	40 (30—60)
S	Heat Resistant Alloy	—	✣	MP9130	30 (20—40)	30 (20—40)	30 (20—40)	30 (20—40)
H	Hardened Steel	Hardness 40—55HRC	● ◐ ✣	VP15TF	90 (70—100)	85 (60—100)	70 (50—80)	70 (50—80)

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

RECOMMENDED CUTTING CONDITIONS

■ Wet Cutting

Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø16—ø18 ap (mm)	ø16—ø18 fz (mm/t.)	ø20—ø25 ap (mm)	ø20—ø25 fz (mm/t.)	ø28—ø63 ap (mm)	ø28—ø63 fz (mm/t.)
P	Mild Steel	Hardness ≤180HB	≤0.25DC	● ◐ ✣	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.25
			0.25—0.5DC	● ◐ ✣	≤5	0.1 —0.15	≤8	0.1 —0.15	≤8	0.1 —0.2
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.1 —0.15
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.08—0.12
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—280HB	≤0.25DC	● ◐ ✣	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.25
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.2
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.1 —0.15
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.08—0.12
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 280—350HB ≤350HB (Annealing)	≤0.25DC	● ◐ ✣	≤6	0.1 —0.15	≤8	0.1 —0.15	≤8	0.1 —0.2
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.1 —0.15
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.08—0.12
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
	Pre-hardened Steel	Hardness 35—45HRC	≤0.25DC	● ◐ ✣	≤6	0.1 —0.15	≤8	0.1 —0.15	≤8	0.1 —0.2
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.1 —0.15
			0.5—0.75DC	● ◐ ✣	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.08—0.12
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
M	Austenitic Stainless Steel	—	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
	Duplex Stainless Steel	Hardness ≤280HB	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.12
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08
	Ferritic and Martensitic Stainless Steel	—	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.08—0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.06—0.08	≤6	0.06—0.1	≤6	0.05—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.05—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.05—0.08
	Precipitation Hardening Stainless Steel	Hardness <450HB	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.15	≤8	0.1 —0.15
				✣	≤6	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.06—0.1	≤6	0.06—0.1	≤6	0.05—0.1
				✣	≤4	0.06—0.08	≤6	0.06—0.08	≤6	0.05—0.08
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.05—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.05—0.08
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.25
				✣	≤6	0.08—0.12	≤8	0.08—0.15	≤8	0.1 —0.2
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.08—0.15	≤8	0.1 —0.2
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.1 —0.15
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.1 —0.15
				✣	≤4	0.08—0.12	≤6	0.06—0.1	≤6	0.08—0.12
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.08—0.15
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.1
	Ductile Cast Iron	Tensile Strength ≤800MPa	≤0.25DC	● ◐	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤6	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
			0.25—0.5DC	● ◐	≤5	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
				✣	≤5	0.06—0.1	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.08—0.12
				✣	≤4	0.08—0.12	≤6	0.08—0.12	≤6	0.06—0.1
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
				✣	≤2	0.06—0.08	≤4	0.06—0.08	≤4	0.06—0.08

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø16—ø18 ap (mm)	ø16—ø18 fz (mm/t.)	ø20—ø25 ap (mm)	ø20—ø25 fz (mm/t.)	ø28—ø63 ap (mm)	ø28—ø63 fz (mm/t.)
N	Aluminium Alloy	Content Si< 5%	≤0.25DC	● ◐	≤6	0.1 —0.2	≤8	0.1 —0.25	≤8	0.1 —0.25
				✣	≤6	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
			0.25—0.5DC	● ◐	≤5	0.1 —0.15	≤8	0.1 —0.2	≤8	0.1 —0.2
				✣	≤5	0.08—0.12	≤8	0.1 —0.15	≤8	0.1 —0.15
			0.5—0.75DC	● ◐	≤4	0.08—0.12	≤6	0.06—0.15	≤6	0.08—0.15
				✣	≤4	0.06—0.1	≤6	0.06—0.15	≤6	0.08—0.15
			DC(Slot)	● ◐	≤2	0.06—0.1	≤4	0.06—0.15	≤4	0.08—0.15
				✣	≤2	0.06—0.08	≤4	0.06—0.12	≤4	0.08—0.12
S	Titanium Alloy (Ti-6Al-4V,etc.)	—	≤0.25DC	● ◐ ✣	≤6	0.08—0.15	≤8	0.08—0.15	≤8	0.08—0.15
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐ ✣	≤4	0.06—0.1	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr,etc.)	—	≤0.25DC	● ◐ ✣	≤6	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐ ✣	≤4	0.06—0.1	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
	Heat Resistant Alloy	—	≤0.25DC	● ◐ ✣	≤6	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.25—0.5DC	● ◐ ✣	≤5	0.08—0.12	≤8	0.08—0.12	≤8	0.08—0.12
			0.5—0.75DC	● ◐ ✣	≤4	0.06—0.1	≤6	0.06—0.1	≤6	0.06—0.1
			DC(Slot)	● ◐ ✣	≤2	0.06—0.1	≤4	0.06—0.1	≤4	0.06—0.1
H	Hardened Steel	Hardness 40—55HRC	≤0.25DC	● ◐	≤4	0.08—0.15	≤4	0.08—0.15	≤4	0.08—0.15
				✣	≤4	0.08—0.12	≤4	0.08—0.12	≤4	0.08—0.12
			0.25—0.5DC	● ◐	≤3	0.08—0.12	≤3	0.08—0.12	≤3	0.08—0.12
				✣	≤3	0.06—0.1	≤3	0.06—0.1	≤3	0.06—0.1
			0.5—0.75DC	● ◐	≤2	0.06—0.1	≤2	0.06—0.1	≤2	0.06—0.1
				✣	≤2	0.06—0.1	≤2	0.06—0.1	≤2	0.06—0.1
			DC(Slot)	● ◐	≤1	0.06—0.1	≤1	0.06—0.1	≤1	0.06—0.1
				✣	≤1	0.06—0.1	≤1	0.06—0.1	≤1	0.06—0.1

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
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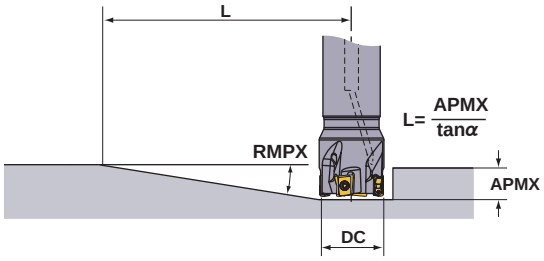
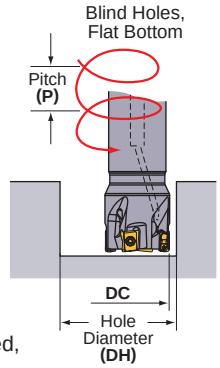
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

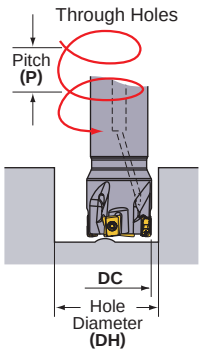
■ Ramping / Helical Milling

● Ramping



● Helical Milling





Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

DC (mm)	RE (mm)	Ramping RMPX	Ramping L (mm) *	Helical Milling (Blind Hole, Flat Bottom) DH max. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)	Helical Milling (Through Hole) DH min. (mm)	P max. (mm)
16	0.2	1.85°	248	31	1.5	27.5	1.2	24.2	0.8
	0.4	1.85°	248	30.6	1.5	27.5	1.2	24.2	0.8
	0.8	1.85°	248	29.8	1.4	27.5	1.2	24.2	0.8
	1	1.85°	248	29.4	1.4	27.5	1.2	24.2	0.8
	1.2	1.85°	248	29	1.3	27.5	1.2	24.2	0.8
	1.6	1.85°	248	28.2	1.2	27.5	1.2	24.2	0.8

Note 1) When machining a highly ductile work material with the ramping angles in the table above, chips may be elongated.
* Shows the distance until a maximum depth of cut of 8 mm is achieved at the maximum ramping angle L (= 8/tan α).

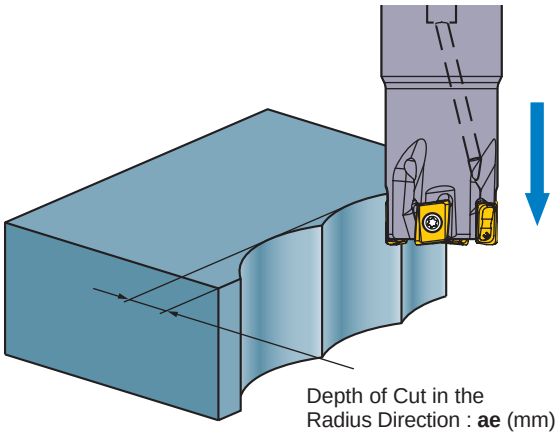
DC (mm)	RE (mm)	Ramping		Helical Milling (Blind Hole, Flat Bottom)				Helical Milling (Through Hole)	
		RMPX	L (mm) *	DH max. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)
18	0.2	1.56°	294	35	1.5	31.5	1.2	28.1	0.9
	0.4	1.56°	294	34.6	1.4	31.5	1.2	28.1	0.9
	0.8	1.56°	294	33.8	1.4	31.5	1.2	28.1	0.9
	1	1.56°	294	33.4	1.3	31.5	1.2	28.1	0.9
	1.2	1.56°	294	33	1.3	31.5	1.2	28.1	0.9
	1.6	1.56°	294	32.2	1.2	31.5	1.2	28.1	0.9
20	0.2	1.35°	340	39	1.4	35.5	1.1	32	0.9
	0.4	1.35°	340	38.6	1.4	35.5	1.1	32	0.9
	0.8	1.35°	340	37.8	1.3	35.5	1.1	32	0.9
	1	1.35°	340	37.4	1.3	35.5	1.1	32	0.9
	1.2	1.35°	340	37	1.3	35.5	1.1	32	0.9
	1.6	1.35°	340	36.2	1.2	35.5	1.1	32	0.9
22	0.2	1.16°	396	43	1.3	39.5	1.1	36	0.9
	0.4	1.16°	396	42.6	1.3	39.5	1.1	36	0.9
	0.8	1.16°	396	41.8	1.3	39.5	1.1	36	0.9
	1	1.16°	396	41.4	1.2	39.5	1.1	36	0.9
	1.2	1.16°	396	41	1.2	39.5	1.1	36	0.9
	1.6	1.16°	396	40.2	1.2	39.5	1.1	36	0.9
25	0.2	0.97°	473	49	1.3	45.5	1.1	42	0.9
	0.4	0.97°	473	48.6	1.3	45.5	1.1	42	0.9
	0.8	0.97°	473	47.8	1.2	45.5	1.1	42	0.9
	1	0.97°	473	47.4	1.2	45.5	1.1	42	0.9
	1.2	0.97°	473	47	1.2	45.5	1.1	42	0.9
	1.6	0.97°	473	46.2	1.1	45.5	1.1	42	0.9
28	0.2	0.84°	546	55	1.2	51.5	1.1	48	0.9
	0.4	0.84°	546	54.6	1.2	51.5	1.1	48	0.9
	0.8	0.84°	546	53.8	1.2	51.5	1.1	48	0.9
	1	0.84°	546	53.4	1.2	51.5	1.1	48	0.9
	1.2	0.84°	546	53	1.2	51.5	1.1	48	0.9
	1.6	0.84°	546	52.2	1.1	51.5	1.1	48	0.9
30	0.2	0.77°	596	59	1.2	55.5	1.1	52	0.9
	0.4	0.77°	596	58.6	1.2	55.5	1.1	52	0.9
	0.8	0.77°	596	57.8	1.2	55.5	1.1	52	0.9
	1	0.77°	596	57.4	1.2	55.5	1.1	52	0.9
	1.2	0.77°	596	57	1.1	55.5	1.1	52	0.9
	1.6	0.77°	596	56.2	1.1	55.5	1.1	52	0.9
32	0.2	0.71°	646	62.8	1.2	59.4	1.1	56	0.9
	0.4	0.71°	646	62.4	1.2	59.4	1.1	56	0.9
	0.8	0.71°	646	61.6	1.2	59.4	1.1	56	0.9
	1	0.71°	646	61.2	1.1	59.4	1.1	56	0.9
	1.2	0.71°	646	60.8	1.1	59.4	1.1	56	0.9
	1.6	0.71°	646	60	1.1	59.4	1.1	56	0.9
35	0.2	0.63°	728	69	1.2	65.5	1.1	62	0.9
	0.4	0.63°	728	68.6	1.2	65.5	1.1	62	0.9
	0.8	0.63°	728	67.8	1.1	65.5	1.1	62	0.9
	1	0.63°	728	67.4	1.1	65.5	1.1	62	0.9
	1.2	0.63°	728	67	1.1	65.5	1.1	62	0.9
	1.6	0.63°	728	66.2	1.1	65.5	1.1	62	0.9
40	0.2	0.54°	849	78.8	1.2	75.4	1	72	0.9
	0.4	0.54°	849	78.4	1.1	75.4	1	72	0.9
	0.8	0.54°	849	77.6	1.1	75.4	1	72	0.9
	1	0.54°	849	77.2	1.1	75.4	1	72	0.9
	1.2	0.54°	849	76.8	1.1	75.4	1	72	0.9
	1.6	0.54°	849	76	1.1	75.4	1	72	0.9
50	0.2	0.42°	1092	98.8	1.1	95.4	1	92	1
	0.4	0.42°	1092	98.4	1.1	95.4	1	92	1
	0.8	0.42°	1092	97.6	1.1	95.4	1	92	1
	1	0.42°	1092	97.2	1.1	95.4	1	92	1
	1.2	0.42°	1092	96.8	1.1	95.4	1	92	1
	1.6	0.42°	1092	96	1.1	95.4	1	92	1
63	0.2	0.32°	1433	124.8	1.1	121.4	1	118	1
	0.4	0.32°	1433	124.4	1.1	121.4	1	118	1
	0.8	0.32°	1433	123.6	1.1	121.4	1	118	1
	1	0.32°	1433	123.2	1.1	121.4	1	118	1
	1.2	0.32°	1433	122.8	1.1	121.4	1	118	1
	1.6	0.32°	1433	122	1	121.4	1	118	1

Note 1) When machining a highly ductile work material with the ramping angles in the table above, chips may be elongated.
* Shows the distance until a maximum depth of cut of 8 mm is achieved at the maximum ramping angle L (= 8/tan α).

■ For Plunging and Drilling

See the tables to the right for cutting conditions. Follow the cutting conditions for slot milling regarding feed per tooth and cutting speed.

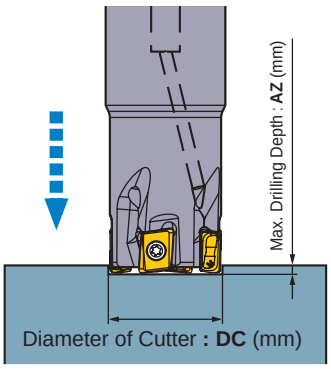
● Plunging



DC (mm)	**ae** (mm)
16	3.9
18	3.9
20	3.9
22	4
25	4
28	4
30	4
32	4
35	4
40	4
50	4
63	4

Note 1) No step feed necessary.

● Drilling



DC (mm)	**AZ** (mm)
16	0.3
18	0.3
20	0.3
22	0.3
25	0.3
28	0.3
30	0.3
32	0.3
35	0.3
40	0.3
50	0.3
63	0.3

Note 1) Exercise due caution as chips scatter easily.
Note 2) Use compressed air to eliminate chips (or coolant for when machining aluminium alloy).

MULTI-FUNCTIONAL MILLING

TOOL NEWS

90° KAPR

VPX300 NEW

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

Fig.1

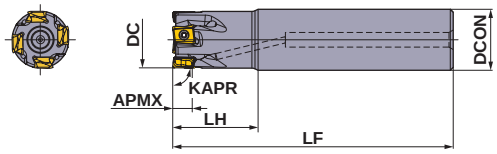
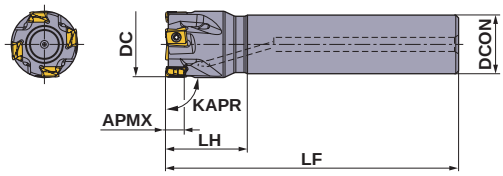


Fig.2



Right hand tool holder only.

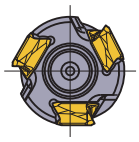
■SHANK TYPE

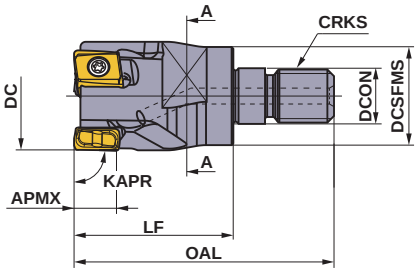
With Coolant Hole

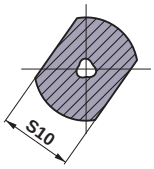
DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	LF	LH	APMX (mm)	RMPX	Max. Spindle Speed (min^{-1})	WT (kg)	Fig.	Insert Type
25	**VPX300R2502SA25S**	●	2	25	115	35	11	2.13°	24100	0.38	1	LOGU12
25	**VPX300R2502SA25L**	●	2	25	170	70	11	2.13°	24100	0.56	1	LOGU12
28	**VPX300R2802SA25S**	●	2	25	115	35	11	1.77°	22500	0.40	2	LOGU12
28	**VPX300R2802SA25L**	●	2	25	170	35	11	1.77°	22500	0.60	2	LOGU12
30	**VPX300R3002SA25S**	●	2	25	125	35	11	1.61°	21500	0.45	2	LOGU12
30	**VPX300R3003SA25S**	●	3	25	125	35	11	1.61°	21500	0.44	2	LOGU12
32	**VPX300R3202SA32S**	●	2	32	125	45	11	1.47°	20600	0.69	1	LOGU12
32	**VPX300R3203SA32S**	●	3	32	125	45	11	1.47°	20600	0.68	1	LOGU12
32	**VPX300R3203SA32L**	●	3	32	190	90	11	1.47°	20600	1.04	1	LOGU12
35	**VPX300R3503SA32L**	●	3	32	190	45	11	1.28°	19500	1.10	2	LOGU12
40	**VPX300R4003SA32S**	●	3	32	125	45	11	1.06°	17900	0.76	2	LOGU12
40	**VPX300R4004SA32S**	●	4	32	125	45	11	1.06°	17900	0.76	2	LOGU12
50	**VPX300R5004SA32S**	●	4	32	125	45	11	0.79°	15500	0.89	2	LOGU12
50	**VPX300R5006SA32S**	●	6	32	125	45	11	0.79°	15500	0.88	2	LOGU12

Note 1) The maximum spindle speeds are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

● : Inventory maintained in Japan.







A-A Section

Right hand tool holder only.

■ SCREW-IN TYPE

With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DCON	DCSFMS	OAL	LF	S10	CRKS	WT (kg)	APMX (mm)	RMPX	Insert Type
25	**VPX300R2502AM1235**	●	2	12.5	23.5	57	35	19	M12	0.10	11	2.13°	LOGU12
28	**VPX300R2802AM1235**	●	2	12.5	23.5	57	35	19	M12	0.12	11	1.77°	LOGU12
32	**VPX300R3202AM1640**	●	2	17	28.5	63	40	24	M16	0.20	11	1.47°	LOGU12
32	**VPX300R3203AM1640**	●	3	17	28.5	63	40	24	M16	0.19	11	1.47°	LOGU12
35	**VPX300R3502AM1640**	●	2	17	28.5	63	40	24	M16	0.22	11	1.28°	LOGU12
35	**VPX300R3503AM1640**	●	3	17	28.5	63	40	24	M16	0.22	11	1.28°	LOGU12
40	**VPX300R4003AM1640**	●	3	17	28.5	63	40	24	M16	0.26	11	1.06°	LOGU12
40	**VPX300R4004AM1640**	●	4	17	28.5	63	40	24	M16	0.26	11	1.06°	LOGU12

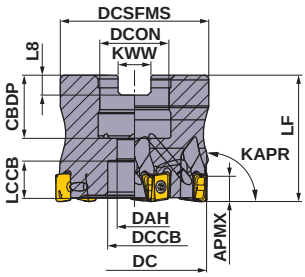
Note 1) For screw-in type arbors, refer to page M269.

SPARE PARTS

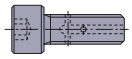
DC	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
25	**VPX300R25**	TPS40F1	TIP15W	MK1KS
28	**VPX300R28**	TPS40F1	TIP15W	MK1KS
30	**VPX300R30**	TPS40F1	TIP15W	MK1KS
32	**VPX300R32**	TPS40F1	TIP15W	MK1KS
35	**VPX300R35**	TPS40F1	TIP15W	MK1KS
40	**VPX300R40**	TPS40F1	TIP15W	MK1KS
50	**VPX300R50**	TPS40F1	TIP15W	MK1KS

* Clamp Torque (N • m) : TPS40F1 = 3.0

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001



Right hand tool holder only.

DC	Set Bolt	Geometry
ϕ40	HSC08025H	
ϕ50, ϕ63	HSC10030H	
ϕ80	HSC12035H	

■ARBOR TYPE

KAPR:90°
GAMP:–6°　GAMF:–22.5°
With Coolant Hole

DC (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	RMPX	Max. Spindle Speed (min^{-1})	Insert Type
40	**VPX300-040A03AR**	●	3	40	16	0.21	11	1.06°	17900	LOGU12
40	**VPX300-040A04AR**	●	4	40	16	0.21	11	1.06°	17900	LOGU12
50	**VPX300-050A04AR**	●	4	40	22	0.34	11	0.79°	15500	LOGU12
50	**VPX300-050A06AR**	●	6	40	22	0.33	11	0.79°	15500	LOGU12
63	**VPX300-063A06AR**	●	6	40	22	0.61	11	0.60°	13400	LOGU12
63	**VPX300-063A08AR**	●	8	40	22	0.62	11	0.60°	13400	LOGU12
80	**VPX300R08007CA**	●	7	50	25.4	1.00	11	0.45°	11500	LOGU12
80	**VPX300R08010CA**	●	10	50	25.4	1.00	11	0.45°	11500	LOGU12
80	**VPX300-080A07AR**	●	7	50	27	0.99	11	0.45°	11500	LOGU12
80	**VPX300-080A10AR**	●	10	50	27	0.99	11	0.45°	11500	LOGU12

Note 1) The maximum spindle speeds are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

Mounting Dimensions

DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8
40	**VPX300-040A03AR**	16	18	9	14	12.4	37	8.4	5.6
40	**VPX300-040A04AR**	16	18	9	14	12.4	37	8.4	5.6
50	**VPX300-050A04AR**	22	20	11	17	10.4	47	10.4	6.3
50	**VPX300-050A06AR**	22	20	11	17	10.4	47	10.4	6.3
63	**VPX300-063A06AR**	22	20	11	17	10.4	60	10.4	6.3
63	**VPX300-063A08AR**	22	20	11	17	10.4	60	10.4	6.3
80	**VPX300R08007CA**	25.4	26	13	20	13.4	56	9.5	6
80	**VPX300R08010CA**	25.4	26	13	20	13.4	56	9.5	6
80	**VPX300-080A07AR**	27	23	13	20	13.4	56	12.4	7
80	**VPX300-080A10AR**	27	23	13	20	13.4	56	12.4	7

SPARE PARTS

DC	Tool Holder Type	* Clamp Screw	Wrench	Anti-seize Lubricant
40	**VPX300-040**	TPS40F1	TIP15W	MK1KS
50	**VPX300-050**	TPS40F1	TIP15W	MK1KS
63	**VPX300-063**	TPS40F1	TIP15W	MK1KS
80	**VPX300R080**	TPS40F1	TIP15W	MK1KS
80	**VPX300-080**	TPS40F1	TIP15W	MK1KS

* Clamp Torque (N • m) : TPS40F1 = 3.0

● : **Inventory maintained in Japan. (10 inserts in one case)**

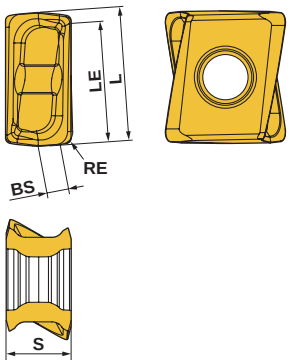
INSERTS

Work Material			MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF		TF15	
	P	Steel		◐	✠				◐			
	M	Stainless Steel				◔			◔			
	K	Cast Iron	◐						✠			
	N	Non-ferrous Metal									◐	
	S	Heat-resistant Alloy, Titanium Alloy					◐	✠	◐			
	H	Hardened Steel							◔			

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF		TF15		L	RE	LE	S	BS	Geometry
				Coated								Carbide		Dimensions(mm)					
General M Breaker	**LOGU1207020PNER-M**	G	E	●	●	●	●	●	●	●				12.4	0.2	11.3	7.0	3.0	
	LOGU1207040PNER-M	G	E	●	●	●	●	●	●	●				12.4	0.4	11.3	7.0	2.8	
	LOGU1207080PNER-M	G	E	●	●	●	●	●	●	●				12.4	0.8	11.3	7.0	2.4	
	LOGU1207100PNER-M	G	E	●	●	●	●	●	●	●				12.4	1.0	11.3	7.0	2.3	
	LOGU1207120PNER-M	G	E	●	●	●	●	●	●	●				12.4	1.2	11.3	7.0	2.1	
	LOGU1207160PNER-M	G	E	●	●	●	●	●	●	●				12.4	1.6	11.3	7.0	1.7	
	LOGU1207200PNER-M	G	E	●	●	●	●	●	●	●				12.4	2.0	11.3	7.0	1.4	
	LOGU1207240PNER-M	G	E	●	●	●	●	●	●	●				12.4	2.4	11.3	7.0	1.0	
	LOGU1207300PNER-M	G	E	●	●	●	●	●	●	●				12.4	3.0	11.3	7.0	0.5	
	LOGU1207320PNER-M	G	E	●	●	●	●	●	●	●				12.4	3.2	11.3	7.0	0.3	
	LOGU1207020PNFR-M	G	F									●		12.4	0.2	11.3	7.0	3.0	
	LOGU1207040PNFR-M	G	F									●		12.4	0.4	11.3	7.0	2.8	
	LOGU1207080PNFR-M	G	F									●		12.4	0.8	11.3	7.0	2.4	
	LOGU1207100PNFR-M	G	F									●		12.4	1.0	11.3	7.0	2.3	
	LOGU1207120PNFR-M	G	F									●		12.4	1.2	11.3	7.0	2.1	
	LOGU1207160PNFR-M	G	F									●		12.4	1.6	11.3	7.0	1.7	
	LOGU1207200PNFR-M	G	F									●		12.4	2.0	11.3	7.0	1.4	
	LOGU1207240PNFR-M	G	F									●		12.4	2.4	11.3	7.0	1.0	
	LOGU1207300PNFR-M	G	F									●		12.4	3.0	11.3	7.0	0.5	
	LOGU1207320PNFR-M	G	F									●		12.4	3.2	11.3	7.0	0.3	Right hand insert only.



M

INDEXABLE MILLING

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

■ Dry Cutting

Cutting Speed

	Work Material	Characteristics	Cutting Conditions	Insert Grade	Insert Breaker	ae (mm) ≤0.25DC	0.25—0.5DC	0.5—0.75DC	DC(Slot)
						vc (m/min)			
P	Mild Steel	Hardness ≤180HB	● ◐	MP6120	M	230 (180—270)	220 (170—260)	180 (140—210)	180 (140—210)
			● ◐	VP15TF	M	230 (180—270)	220 (170—260)	180 (140—210)	180 (140—210)
			✣	MP6130	M	200 (150—240)	190 (170—260)	150 (110—180)	150 (110—180)
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—350HB ≤350HB (Annealing)	● ◐	MP6120	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—180)
			● ◐	VP15TF	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—180)
			✣	MP6130	M	150 (110—180)	140 (100—170)	110 (80—130)	110 (80—130)
	Pre-hardened Steel	Hardness 35—45HRC	● ◐	MP6120	M	120 (90—140)	110 (80—130)	100 (70—120)	100 (70—120)
			● ◐	VP15TF	M	120 (90—140)	110 (80—130)	100 (70—120)	100 (70—120)
			✣	MP6130	M	100 (80—120)	90 (70—110)	80 (60—100)	80 (60—100)
M	Austenitic Stainless Steel	Hardness ≤200HB	● ◐ ✣	MP7130	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
			● ◐	VP15TF	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
		Hardness >200HB	● ◐ ✣	MP7130	M	150 (110—180)	140 (100—160)	110 (80—130)	110 (80—130)
			● ◐	VP15TF	M	150 (110—180)	140 (100—160)	110 (80—130)	110 (80—130)
	Duplex Stainless Steel	Hardness ≤280HB	● ◐ ✣	MP7130	M	140 (110—170)	130 (90—150)	100 (70—120)	100 (70—120)
			● ◐	VP15TF	M	140 (110—170)	130 (90—150)	100 (70—120)	100 (70—120)
	Ferritic and Martensitic Stainless Steel	—	● ◐ ✣	MP7130	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
			● ◐	VP15TF	M	180 (140—210)	170 (130—200)	140 (110—160)	140 (110—160)
	Precipitation Hardening Stainless Steel	Hardness <450HB	● ◐ ✣	MP7130	M	130 (100—160)	120 (80—140)	90 (60—110)	90 (60—110)
			● ◐	VP15TF	M	130 (100—160)	120 (80—140)	90 (60—110)	90 (60—110)
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐	MC5020	M	250 (200—300)	240 (190—290)	210 (160—260)	210 (160—260)
			● ◐ ✣	VP15TF	M	200 (150—250)	190 (140—240)	160 (110—210)	160 (110—210)
	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐	MC5020	M	180 (150—200)	170 (140—190)	150 (120—170)	150 (120—170)
			● ◐ ✣	VP15TF	M	130 (100—150)	120 (90—140)	100 (80—120)	100 (80—120)
N	Aluminium Alloy	Content Si<5%	● ◐ ✣	TF15	M	600 (400—1000)	600 (400—1000)	600 (400—1000)	600 (400—1000)
H	Hardened Steel	Hardness 40—55HRC	● ◐ ✣	VP15TF	M	90 (70—100)	85 (60—100)	70 (50—80)	70 (50—80)

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø25 ap (mm)	ø25 fz (mm/t.)	ø28—ø80 ap (mm)	ø28—ø80 fz (mm/t.)
P	Mild Steel	Hardness ≤180HB	≤0.25DC	● ◐ ✣	≤11	0.1 —0.2	≤11	0.1 —0.3
			0.25—0.5DC	● ◐ ✣	≤11	0.1 —0.15	≤11	0.1 —0.25
			0.5—0.75DC	● ◐ ✣	≤8	0.08—0.12	≤8	0.1 —0.2
			DC(Slot)	● ◐ ✣	≤5	0.06—0.1	≤5	0.08—0.15
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180—280HB	≤0.25DC	● ◐ ✣	≤11	0.1 —0.2	≤11	0.1 —0.3
			0.25—0.5DC	● ◐ ✣	≤11	0.1 —0.15	≤11	0.1 —0.25
			0.5—0.75DC	● ◐ ✣	≤8	0.08—0.12	≤8	0.1 —0.2
			DC(Slot)	● ◐ ✣	≤5	0.06—0.1	≤5	0.08—0.15
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 280—350HB ≤350HB (Annealing)	≤0.25DC	● ◐ ✣	≤11	0.1 —0.15	≤11	0.1 —0.25
			0.25—0.5DC	● ◐ ✣	≤11	0.08—0.12	≤11	0.1 —0.2
			0.5—0.75DC	● ◐ ✣	≤8	0.06—0.1	≤8	0.1 —0.15
			DC(Slot)	● ◐ ✣	≤5	0.06—0.1	≤5	0.08—0.12
	Pre-hardened Steel	Hardness 35—45HRC	≤0.25DC	● ◐ ✣	≤11	0.1 —0.15	≤11	0.1 —0.25
			0.25—0.5DC	● ◐ ✣	≤11	0.08—0.12	≤11	0.1 —0.2
			0.5—0.75DC	● ◐ ✣	≤8	0.06—0.1	≤8	0.1 —0.15
			DC(Slot)	● ◐ ✣	≤5	0.06—0.1	≤5	0.08—0.12

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

■ Dry Cutting
Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø25 ap (mm)	DC (mm) ø25 fz (mm/t.)	DC (mm) ø28–ø80 ap (mm)	DC (mm) ø28–ø80 fz (mm/t.)
M	Austenitic Stainless Steel	–	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08 –0.15	≤11	0.08 –0.15
			0.25–0.5DC	● ◐	≤11	0.08 –0.15	≤11	0.08 –0.15
				✠	≤11	0.08 –0.12	≤11	0.08 –0.12
			0.5–0.75DC	● ◐	≤8	0.08 –0.12	≤8	0.08 –0.12
				✠	≤8	0.06 –0.1	≤8	0.06 –0.1
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.06 –0.1
				✠	≤5	0.06 –0.08	≤5	0.06 –0.08
	Duplex Stainless Steel	Hardness ≤280HB	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08 –0.15	≤11	0.08 –0.15
			0.25–0.5DC	● ◐	≤11	0.08 –0.15	≤11	0.08 –0.15
				✠	≤11	0.08 –0.12	≤11	0.08 –0.12
			0.5–0.75DC	● ◐	≤8	0.08 –0.12	≤8	0.08 –0.12
				✠	≤8	0.06 –0.1	≤8	0.06 –0.1
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.06 –0.1
				✠	≤5	0.06 –0.08	≤5	0.06 –0.08
	Ferritic and Martensitic Stainless Steel	–	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08 –0.15	≤11	0.08 –0.15
			0.25–0.5DC	● ◐	≤11	0.08 –0.15	≤11	0.08 –0.15
				✠	≤11	0.08 –0.12	≤11	0.08 –0.12
			0.5–0.75DC	● ◐	≤8	0.08 –0.12	≤8	0.08 –0.12
				✠	≤8	0.06 –0.1	≤8	0.06 –0.1
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.06 –0.1
				✠	≤5	0.06 –0.08	≤5	0.06 –0.08
	Precipitation Hardening Stainless Steel	Hardness <450HB	≤0.25DC	● ◐	≤11	0.1 –0.15	≤11	0.1 –0.15
				✠	≤11	0.08 –0.12	≤11	0.08 –0.12
			0.25–0.5DC	● ◐	≤11	0.08 –0.12	≤11	0.08 –0.12
				✠	≤11	0.08 –0.12	≤11	0.06 –0.1
			0.5–0.75DC	● ◐	≤8	0.06 –0.1	≤8	0.06 –0.1
				✠	≤8	0.06 –0.08	≤8	0.06 –0.08
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.06 –0.1
				✠	≤5	0.06 –0.08	≤5	0.06 –0.08
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.3
				✠	≤11	0.08 –0.15	≤11	0.1 –0.25
			0.25–0.5DC	● ◐	≤11	0.08 –0.15	≤11	0.1 –0.25
				✠	≤11	0.08 –0.12	≤11	0.1 –0.2
			0.5–0.75DC	● ◐	≤8	0.08 –0.12	≤8	0.1 –0.2
				✠	≤8	0.06 –0.1	≤8	0.08 –0.15
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.08 –0.15
				✠	≤5	0.06 –0.08	≤5	0.08 –0.12
	Ductile Cast Iron	Tensile Strength ≤800MPa	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.25
				✠	≤11	0.1 –0.15	≤11	0.1 –0.2
			0.25–0.5DC	● ◐	≤11	0.1 –0.15	≤11	0.1 –0.2
				✠	≤11	0.08 –0.12	≤11	0.1 –0.15
			0.5–0.75DC	● ◐	≤8	0.08 –0.12	≤8	0.1 –0.15
				✠	≤8	0.08 –0.12	≤8	0.08 –0.12
			DC(Slot)	● ◐	≤5	0.06 –0.1	≤5	0.08 –0.12
				✠	≤5	0.06 –0.08	≤5	0.06 –0.1
N	Aluminium Alloy	Content Si< 5%	≤0.25DC	● ◐	≤11	0.1 –0.25	≤11	0.1 –0.25
				✠	≤11	0.1 –0.2	≤11	0.1 –0.2
			0.25–0.5DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.1 –0.15	≤11	0.1 –0.15
			0.5–0.75DC	● ◐	≤8	0.06 –0.15	≤8	0.08 –0.15
				✠	≤8	0.06 –0.15	≤8	0.08 –0.15
			DC(Slot)	● ◐	≤5	0.06 –0.15	≤5	0.08 –0.15
				✠	≤5	0.06 –0.15	≤5	0.08 –0.12
H	Hardened Steel	Hardness 40–55HRC	≤0.25DC	● ◐	≤5	0.08 –0.15	≤5	0.08 –0.15
				✠	≤5	0.08 –0.12	≤5	0.08 –0.12
			0.25–0.5DC	● ◐	≤4	0.08 –0.12	≤4	0.08 –0.12
				✠	≤4	0.06 –0.1	≤4	0.06 –0.1
			0.5–0.75DC	● ◐	≤3	0.06 –0.1	≤3	0.06 –0.1
				✠	≤3	0.06 –0.08	≤3	0.06 –0.08
			DC(Slot)	● ◐	≤2	0.06 –0.1	≤2	0.06 –0.1
				✠	≤2	0.06 –0.08	≤2	0.06 –0.08

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

RECOMMENDED CUTTING CONDITIONS

■ Wet Cutting
Cutting Speed

	Work Material	Characteristics	Cutting Conditions	Insert Grade	Insert Chip Breaker	ae (mm) ≤0.25DC	0.25–0.5DC	0.5–0.75DC	DC(Slot)
						vc (m/min)			
P	Mild Steel	Hardness ≤180HB	● ◐	MP6120	M	140 (100–190)	130 (90–180)	100 (70–120)	100 (70–120)
			● ◐	VP15TF	M	140 (100–190)	130 (90–180)	100 (70–120)	100 (70–120)
			✚	MP6130	M	140 (100–190)	130 (90–180)	100 (70–120)	100 (70–120)
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180–350HB ≤350HB (Annealing)	● ◐	MP6120	M	120 (90–140)	110 (80–130)	100 (70–120)	100 (70–120)
			● ◐	VP15TF	M	120 (90–140)	110 (80–130)	100 (70–120)	100 (70–120)
			✚	MP6130	M	120 (90–140)	110 (80–130)	100 (70–120)	100 (70–120)
	Pre-hardened Steel	Hardness 35–45HRC	● ◐	MP6120	M	100 (80–120)	90 (70–110)	80 (60–100)	80 (60–100)
			● ◐	VP15TF	M	100 (80–120)	90 (70–110)	80 (60–100)	80 (60–100)
			✚	MP6130	M	100 (80–120)	90 (70–110)	80 (60–100)	80 (60–100)
M	Austenitic Stainless Steel	Hardness ≤200HB	● ◐ ✚	MP7130	M	120 (100–150)	110 (90–140)	90 (70–120)	90 (70–120)
			● ◐	VP15TF	M	120 (100–150)	110 (90–140)	90 (70–120)	90 (70–120)
		Hardness >200HB	● ◐ ✚	MP7130	M	100 (80–130)	90 (70–120)	70 (50–100)	70 (50–100)
			● ◐	VP15TF	M	100 (80–130)	90 (70–120)	70 (50–100)	70 (50–100)
	Duplex Stainless Steel	Hardness ≤280HB	● ◐ ✚	MP7130	M	100 (80–130)	90 (70–120)	70 (50–100)	70 (50–100)
			● ◐	VP15TF	M	100 (80–130)	90 (70–120)	70 (50–100)	70 (50–100)
	Ferritic and Martensitic Stainless Steel	–	● ◐ ✚	MP7130	M	120 (100–150)	110 (90–140)	90 (70–120)	90 (70–120)
			● ◐	VP15TF	M	120 (100–150)	110 (90–140)	90 (70–120)	90 (70–120)
	Precipitation Hardening Stainless Steel	Hardness <450HB	● ◐ ✚	MP7130	M	90 (70–120)	80 (60–110)	60 (40–90)	60 (40–90)
			● ◐	VP15TF	M	90 (70–120)	80 (60–110)	60 (40–90)	60 (40–90)
K	Gray Cast Iron	Tensile Strength ≤350MPa	● ◐	MC5020	M	180 (160–220)	170 (150–210)	150 (130–190)	150 (130–190)
			● ◐ ✚	VP15TF	M	130 (100–150)	120 (90–140)	100 (80–120)	100 (80–120)
	Ductile Cast Iron	Tensile Strength ≤800MPa	● ◐	MC5020	M	160 (140–180)	150 (130–170)	130 (110–150)	130 (110–150)
			● ◐ ✚	VP15TF	M	110 (80–140)	100 (70–130)	80 (60–120)	80 (60–120)
N	Aluminium Alloy	Content Si<5%	● ◐ ✚	TF15	M	600 (400–1000)	600 (400–1000)	600 (400–1000)	600 (400–1000)
S	Titanium Alloy (Ti-6Al-4V,etc.)	–	● ◐	MP9120	M	50 (40–70)	50 (40–70)	50 (40–70)	50 (40–70)
			● ◐	VP15TF	M	50 (40–70)	50 (40–70)	50 (40–70)	50 (40–70)
			✚	MP9130	M	40 (30–60)	40 (30–60)	40 (30–60)	40 (30–60)
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr,etc.)	–	● ◐	MP9120	M	30 (20–40)	30 (20–40)	30 (20–40)	30 (20–40)
			● ◐	VP15TF	M	30 (20–40)	30 (20–40)	30 (20–40)	30 (20–40)
			✚	MP9130	M	30 (20–40)	30 (20–40)	30 (20–40)	30 (20–40)
	Heat Resistant Alloy	–	● ◐	MP9120	M	40 (30–60)	40 (30–60)	40 (30–60)	40 (30–60)
			● ◐	VP15TF	M	40 (30–60)	40 (30–60)	40 (30–60)	40 (30–60)
			✚	MP9130	M	30 (20–40)	30 (20–40)	30 (20–40)	30 (20–40)
H	Hardened Steel	Hardness 40–55HRC	● ◐ ✚	VP15TF	M	90 (70–100)	85 (60–100)	70 (50–80)	70 (50–80)

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
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Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

■ Wet Cutting
Depth of Cut / Feed per Tooth

	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø25 ap (mm)	DC (mm) ø25 fz (mm/t.)	DC (mm) ø28–ø80 ap (mm)	DC (mm) ø28–ø80 fz (mm/t.)
P	Mild Steel	Hardness ≤180HB	≤0.25DC	● ◐ ✠	≤11	0.1 –0.2	≤11	0.1 –0.3
			0.25–0.5DC	● ◐ ✠	≤11	0.1 –0.15	≤11	0.1 –0.25
			0.5–0.75DC	● ◐ ✠	≤8	0.08–0.12	≤8	0.1 –0.2
			DC(Slot)	● ◐ ✠	≤5	0.06–0.1	≤5	0.08–0.15
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 180–280HB	≤0.25DC	● ◐ ✠	≤11	0.1 –0.2	≤11	0.1 –0.3
			0.25–0.5DC	● ◐ ✠	≤11	0.1 –0.15	≤11	0.1 –0.25
			0.5–0.75DC	● ◐ ✠	≤8	0.08–0.12	≤8	0.1 –0.2
			DC(Slot)	● ◐ ✠	≤5	0.06–0.1	≤5	0.08–0.15
	Carbon Steel Alloy Steel Alloy Tool Steel	Hardness 280–350HB ≤350HB (Annealing)	≤0.25DC	● ◐ ✠	≤11	0.1 –0.15	≤11	0.1 –0.25
			0.25–0.5DC	● ◐ ✠	≤11	0.08–0.12	≤11	0.1 –0.2
			0.5–0.75DC	● ◐ ✠	≤8	0.06–0.1	≤8	0.1 –0.15
			DC(Slot)	● ◐ ✠	≤5	0.06–0.1	≤5	0.08–0.12
	Pre-hardened Steel	Hardness 35–45HRC	≤0.25DC	● ◐ ✠	≤11	0.1 –0.15	≤11	0.1 –0.25
			0.25–0.5DC	● ◐ ✠	≤11	0.08–0.12	≤11	0.1 –0.2
			0.5–0.75DC	● ◐ ✠	≤8	0.06–0.1	≤8	0.1 –0.15
			DC(Slot)	● ◐ ✠	≤5	0.06–0.1	≤5	0.08–0.12
M	Austenitic Stainless Steel	–	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08–0.15	≤11	0.08–0.15
			0.25–0.5DC	● ◐	≤11	0.08–0.12	≤11	0.08–0.15
				✠	≤11	0.06–0.1	≤11	0.08–0.12
			0.5–0.75DC	● ◐	≤8	0.06–0.1	≤8	0.08–0.12
				✠	≤8	0.06–0.1	≤8	0.06–0.1
			DC(Slot)	● ◐	≤5	0.06–0.1	≤5	0.06–0.1
				✠	≤5	0.06–0.08	≤5	0.06–0.08
	Duplex Stainless Steel	Hardness ≤280HB	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08–0.15	≤11	0.08–0.15
			0.25–0.5DC	● ◐	≤11	0.08–0.15	≤11	0.08–0.15
				✠	≤11	0.08–0.12	≤11	0.08–0.12
			0.5–0.75DC	● ◐	≤8	0.08–0.12	≤8	0.08–0.12
				✠	≤8	0.06–0.1	≤8	0.06–0.1
			DC(Slot)	● ◐	≤5	0.06–0.1	≤5	0.06–0.1
				✠	≤5	0.06–0.08	≤5	0.06–0.08
	Ferritic and Martensitic Stainless Steel	–	≤0.25DC	● ◐	≤11	0.1 –0.2	≤11	0.1 –0.2
				✠	≤11	0.08–0.15	≤11	0.08–0.15
			0.25–0.5DC	● ◐	≤11	0.08–0.15	≤11	0.08–0.15
				✠	≤11	0.08–0.12	≤11	0.08–0.12
			0.5–0.75DC	● ◐	≤8	0.08–0.12	≤8	0.08–0.12
				✠	≤8	0.06–0.1	≤8	0.06–0.1
			DC(Slot)	● ◐	≤5	0.06–0.1	≤5	0.06–0.1
				✠	≤5	0.06–0.08	≤5	0.06–0.08
	Precipitation Hardening Stainless Steel	Hardness <450HB	≤0.25DC	● ◐	≤11	0.1 –0.15	≤11	0.1 –0.15
				✠	≤11	0.08–0.12	≤11	0.08–0.12
			0.25–0.5DC	● ◐	≤11	0.08–0.12	≤11	0.08–0.12
				✠	≤11	0.08–0.12	≤11	0.08–0.12
			0.5–0.75DC	● ◐	≤8	0.06–0.1	≤8	0.06–0.1
				✠	≤8	0.06–0.08	≤8	0.06–0.08
			DC(Slot)	● ◐	≤5	0.06–0.1	≤5	0.06–0.1
				✠	≤5	0.06–0.08	≤5	0.06–0.08

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

RECOMMENDED CUTTING CONDITIONS

■ Wet Cutting
Depth of Cut / Feed per Tooth

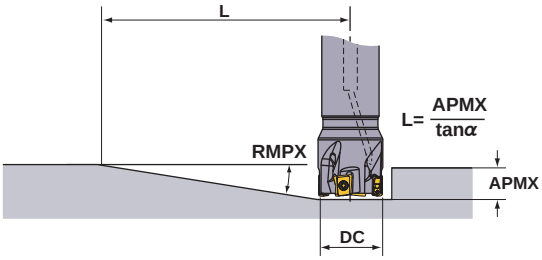
	Work Material	Characteristics	ae (mm)	Cutting Conditions	DC (mm) ø25 ap (mm)	DC (mm) ø25 fz (mm/t.)	DC (mm) ø28—ø80 ap (mm)	DC (mm) ø28—ø80 fz (mm/t.)
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.25DC	● ◐	≤11	0.1 —0.2	≤11	0.1 —0.3
				✠	≤11	0.08—0.15	≤11	0.1 —0.25
			0.25—0.5DC	● ◐	≤11	0.08—0.15	≤11	0.1 —0.25
				✠	≤11	0.08—0.12	≤11	0.1 —0.2
			0.5—0.75DC	● ◐	≤8	0.08—0.12	≤8	0.1 —0.2
				✠	≤8	0.06—0.1	≤8	0.08—0.15
			DC(Slot)	● ◐	≤5	0.06—0.1	≤5	0.08—0.15
				✠	≤5	0.06—0.08	≤5	0.08—0.12
	Ductile Cast Iron	Tensile Strength ≤800MPa	≤0.25DC	● ◐	≤11	0.1 —0.2	≤11	0.1 —0.25
				✠	≤11	0.1 —0.15	≤11	0.1 —0.2
			0.25—0.5DC	● ◐	≤11	0.1 —0.15	≤11	0.1 —0.2
				✠	≤11	0.08—0.12	≤11	0.1 —0.15
			0.5—0.75DC	● ◐	≤8	0.08—0.12	≤8	0.1 —0.15
				✠	≤8	0.06—0.1	≤8	0.08—0.12
			DC(Slot)	● ◐	≤5	0.06—0.1	≤5	0.08—0.12
				✠	≤5	0.06—0.08	≤5	0.06—0.1
N	Aluminium Alloy	Si<5%	≤0.25DC	● ◐	≤11	0.1 —0.25	≤11	0.1 —0.25
				✠	≤11	0.1 —0.2	≤11	0.1 —0.2
			0.25—0.5DC	● ◐	≤11	0.1 —0.2	≤11	0.1 —0.2
				✠	≤11	0.1 —0.15	≤11	0.1 —0.15
			0.5—0.75DC	● ◐	≤8	0.06—0.15	≤8	0.08—0.15
				✠	≤8	0.06—0.15	≤8	0.08—0.15
			DC(Slot)	● ◐	≤5	0.06—0.15	≤5	0.08—0.15
				✠	≤5	0.06—0.15	≤5	0.08—0.12
S	Titanium Alloy (Ti-6Al-4V,etc.)	–	≤0.25DC	● ◐ ✠	≤11	0.08—0.15	≤11	0.08—0.15
			0.25—0.5DC	● ◐ ✠	≤11	0.08—0.12	≤11	0.08—0.12
			0.5—0.75DC	● ◐ ✠	≤8	0.06—0.1	≤8	0.06—0.1
			DC(Slot)	● ◐ ✠	≤5	0.06—0.1	≤5	0.06—0.1
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr,etc.)	–	≤0.25DC	● ◐ ✠	≤11	0.08—0.12	≤11	0.08—0.12
			0.25—0.5DC	● ◐ ✠	≤11	0.08—0.12	≤11	0.08—0.12
			0.5—0.75DC	● ◐ ✠	≤8	0.06—0.1	≤8	0.06—0.1
			DC(Slot)	● ◐ ✠	≤5	0.06—0.1	≤5	0.06—0.1
	Heat Resistant Alloy	–	≤0.25DC	● ◐ ✠	≤11	0.08—0.12	≤11	0.08—0.12
			0.25—0.5DC	● ◐ ✠	≤11	0.08—0.12	≤11	0.08—0.12
			0.5—0.75DC	● ◐ ✠	≤8	0.06—0.1	≤8	0.06—0.1
			DC(Slot)	● ◐ ✠	≤5	0.06—0.1	≤5	0.06—0.1
H	Hardened Steel	40—55HRC	≤0.25DC	● ◐	≤5	0.08—0.15	≤5	0.08—0.15
				✠	≤5	0.08—0.12	≤5	0.08—0.12
			0.25—0.5DC	● ◐	≤4	0.08—0.12	≤4	0.08—0.12
				✠	≤4	0.06—0.1	≤4	0.06—0.1
			0.5—0.75DC	● ◐	≤3	0.06—0.1	≤3	0.06—0.1
				✠	≤3	0.06—0.1	≤3	0.06—0.08
			DC(Slot)	● ◐	≤2	0.06—0.1	≤2	0.06—0.1
				✠	≤2	0.06—0.1	≤2	0.06—0.08

Note 1) These cutting conditions should be referenced for standard shank types (last letter in designation is S) and arbor shank types. If there is chatter, insert chipping, etc. during machining, alter conditions accordingly.
Note 2) Chattering vibration is more likely under the following circumstances. Use a cut and feed per tooth that are at minimum recommended conditions or below.
- When tool overhang is long (using a long shank, screw-in type, etc.)
- Rigidity of machine, work material or attachment of work material is low
- Corner radius during pocket machining

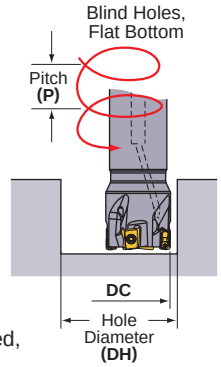
Note 3) A type with fewer teeth is recommended when the depth of cut in the radius direction (ae) is 0.5 DC or more.
Note 4) Wet cutting is recommended, when focusing on the surface finish. (Service life is shorter than for dry cutting.)
Note 5) When using under higher than recommended cutting conditions, or for long periods of time, the bit may become fatigued and break during machining. Please change out the bit periodically.

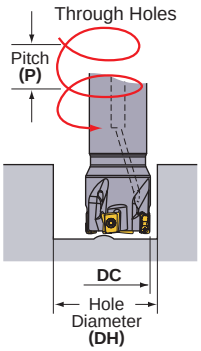
■ Ramping / Helical Milling

● **Ramping**



● **Helical Milling**





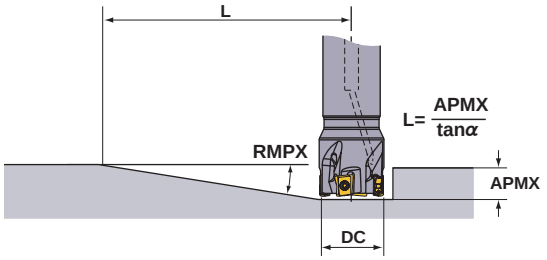
Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

DC (mm)	RE (mm)	Ramping		Helical Milling (Blind Hole, Flat Bottom)				Helical Milling (Through Hole)	
		RMPX	L (mm) *	DH max. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)
25	0.2	2.13°	296	49	2.8	42.7	2.1	36.9	1.4
	0.4	2.13°	296	48.6	2.8	42.7	2.1	36.9	1.4
	0.8	2.13°	296	47.8	2.7	42.7	2.1	36.9	1.4
	1	2.13°	296	47.4	2.6	42.7	2.1	36.9	1.4
	1.2	2.13°	296	47	2.6	42.7	2.1	36.9	1.4
	1.6	2.13°	296	46.2	2.5	42.7	2.1	36.9	1.4
	2	2.13°	296	45.4	2.4	42.7	2.1	36.9	1.4
	2.4	2.13°	296	44.6	2.3	42.7	2.1	36.9	1.4
	3	2.13°	296	43.4	2.2	42.7	2.1	36.9	1.4
	3.2	2.13°	296	43	2.1	42.7	2.1	36.9	1.4
28	0.2	1.77°	356	55	2.6	48.7	2	42.7	1.4
	0.4	1.77°	356	54.6	2.6	48.7	2	42.7	1.4
	0.8	1.77°	356	53.8	2.5	48.7	2	42.7	1.4
	1	1.77°	356	53.4	2.5	48.7	2	42.7	1.4
	1.2	1.77°	356	53	2.4	48.7	2	42.7	1.4
	1.6	1.77°	356	52.2	2.4	48.7	2	42.7	1.4
	2	1.77°	356	51.4	2.3	48.7	2	42.7	1.4
	2.4	1.77°	356	50.6	2.2	48.7	2	42.7	1.4
	3	1.77°	356	49.4	2.1	48.7	2	42.7	1.4
	3.2	1.77°	356	49	2	48.7	2	42.7	1.4
30	0.2	1.61°	392	59	2.6	52.7	2	46.6	1.5
	0.4	1.61°	392	58.6	2.5	52.7	2	46.6	1.5
	0.8	1.61°	392	57.8	2.5	52.7	2	46.6	1.5
	1	1.61°	392	57.4	2.4	52.7	2	46.6	1.5
	1.2	1.61°	392	57	2.4	52.7	2	46.6	1.5
	1.6	1.61°	392	56.2	2.3	52.7	2	46.6	1.5
	2	1.61°	392	55.4	2.2	52.7	2	46.6	1.5
	2.4	1.61°	392	54.6	2.2	52.7	2	46.6	1.5
	3	1.61°	392	53.4	2.1	52.7	2	46.6	1.5
	3.2	1.61°	392	53	2	52.7	2	46.6	1.5
32	0.2	1.47°	429	63	2.5	56.7	2	50.6	1.5
	0.4	1.47°	429	62.6	2.5	56.7	2	50.6	1.5
	0.8	1.47°	429	61.8	2.4	56.7	2	50.6	1.5
	1	1.47°	429	61.4	2.4	56.7	2	50.6	1.5
	1.2	1.47°	429	61	2.3	56.7	2	50.6	1.5
	1.6	1.47°	429	60.2	2.3	56.7	2	50.6	1.5
	2	1.47°	429	59.4	2.2	56.7	2	50.6	1.5
	2.4	1.47°	429	58.6	2.1	56.7	2	50.6	1.5
	3	1.47°	429	57.4	2.1	56.7	2	50.6	1.5
	3.2	1.47°	429	57	2	56.7	2	50.6	1.5
35	0.2	1.28°	493	69	2.4	62.8	1.9	56.6	1.5
	0.4	1.28°	493	68.6	2.4	62.8	1.9	56.6	1.5
	0.8	1.28°	493	67.8	2.3	62.8	1.9	56.6	1.5
	1	1.28°	493	67.4	2.3	62.8	1.9	56.6	1.5
	1.2	1.28°	493	67	2.2	62.8	1.9	56.6	1.5
	1.6	1.28°	493	66.2	2.2	62.8	1.9	56.6	1.5
	2	1.28°	493	65.4	2.1	62.8	1.9	56.6	1.5
	2.4	1.28°	493	64.6	2.1	62.8	1.9	56.6	1.5
	3	1.28°	493	63.4	2	62.8	1.9	56.6	1.5
	3.2	1.28°	493	63	2	62.8	1.9	56.6	1.5

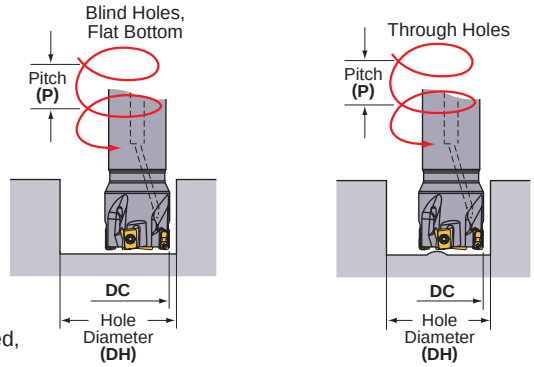
Note 1) When machining a highly ductile work material with the ramping angles in the table above, chips may be elongated.
* Shows the distance until a maximum depth of cut of 11 mm is achieved at the maximum ramping angle L (= 11/tan α).

■ Ramping / Helical Milling

● **Ramping**



● **Helical Milling**



Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

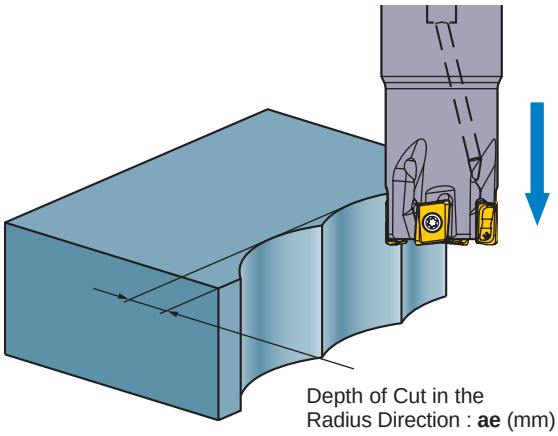
DC (mm)	RE (mm)	Ramping		Helical Milling (Blind Hole, Flat Bottom)				Helical Milling (Through Hole)	
		RMPX	L (mm) *	DH max. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)	DH min. (mm)	P max. (mm)
40	0.2	1.06°	595	78.8	2.3	72.7	1.9	66.5	1.5
	0.4	1.06°	595	78.4	2.2	72.7	1.9	66.5	1.5
	0.8	1.06°	595	77.6	2.2	72.7	1.9	66.5	1.5
	1	1.06°	595	77.2	2.2	72.7	1.9	66.5	1.5
	1.2	1.06°	595	76.8	2.1	72.7	1.9	66.5	1.5
	1.6	1.06°	595	76	2.1	72.7	1.9	66.5	1.5
	2	1.06°	595	75.2	2	72.7	1.9	66.5	1.5
	2.4	1.06°	595	74.4	2	72.7	1.9	66.5	1.5
	3	1.06°	595	73.2	1.9	72.7	1.9	66.5	1.5
	3.2	1.06°	595	72.8	1.9	72.7	1.9	66.5	1.5
50	0.2	0.79°	798	98.8	2.1	92.7	1.8	86.5	1.6
	0.4	0.79°	798	98.4	2.1	92.7	1.8	86.5	1.6
	0.8	0.79°	798	97.6	2.1	92.7	1.8	86.5	1.6
	1	0.79°	798	97.2	2	92.7	1.8	86.5	1.6
	1.2	0.79°	798	96.8	2	92.7	1.8	86.5	1.6
	1.6	0.79°	798	96	2	92.7	1.8	86.5	1.6
	2	0.79°	798	95.2	2	92.7	1.8	86.5	1.6
	2.4	0.79°	798	94.4	1.9	92.7	1.8	86.5	1.6
	3	0.79°	798	93.2	1.9	92.7	1.8	86.5	1.6
	3.2	0.79°	798	92.8	1.9	92.7	1.8	86.5	1.6
63	0.2	0.6°	1051	124.8	2	118.7	1.8	112.5	1.6
	0.4	0.6°	1051	124.4	2	118.7	1.8	112.5	1.6
	0.8	0.6°	1051	123.6	2	118.7	1.8	112.5	1.6
	1	0.6°	1051	123.2	2	118.7	1.8	112.5	1.6
	1.2	0.6°	1051	122.8	2	118.7	1.8	112.5	1.6
	1.6	0.6°	1051	122	1.9	118.7	1.8	112.5	1.6
	2	0.6°	1051	121.2	1.9	118.7	1.8	112.5	1.6
	2.4	0.6°	1051	120.4	1.9	118.7	1.8	112.5	1.6
	3	0.6°	1051	119.2	1.9	118.7	1.8	112.5	1.6
	3.2	0.6°	1051	118.8	1.8	118.7	1.8	112.5	1.6
80	0.2	0.45°	1401	158.8	1.9	152.6	1.8	146.5	1.6
	0.4	0.45°	1401	158.4	1.9	152.7	1.8	146.5	1.6
	0.8	0.45°	1401	157.6	1.9	152.7	1.8	146.5	1.6
	1	0.45°	1401	157.2	1.9	152.7	1.8	146.5	1.6
	1.2	0.45°	1401	156.8	1.9	152.7	1.8	146.5	1.6
	1.6	0.45°	1401	156	1.9	152.7	1.8	146.5	1.6
	2	0.45°	1401	155.2	1.9	152.7	1.8	146.5	1.6
	2.4	0.45	1401	154.4	1.8	152.7	1.8	146.5	1.6
	3	0.45	1401	153.2	1.8	152.7	1.8	146.5	1.6
	3.2	0.45	1401	152.8	1.8	152.7	1.8	146.5	1.6

Note 1) When machining a highly ductile work material with the ramping angles in the table above, chips may be elongated.
* Shows the distance until a maximum depth of cut of 11 mm is achieved at the maximum ramping angle L (= 11/tan α).

■ For Plunging and Drilling

See the tables to the right for cutting conditions. Follow the cutting conditions for slot milling regarding feed per tooth and cutting speed.

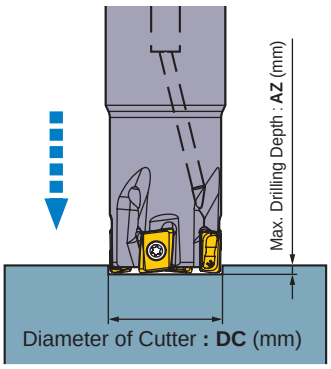
● Plunging



DC (mm)	**ae** (mm)
25	6.5
28	6.6
30	6.6
32	6.6
35	6.7
40	6.7
50	6.7
63	6.7
80	6.7

Note1) No step feed necessary.

● Drilling



DC (mm)	**AZ** (mm)
25	0.55
28	0.55
30	0.55
32	0.55
35	0.55
40	0.55
50	0.55
63	0.55
80	0.55

Note 1) Exercise due caution as chips scatter easily.
Note 2) Use compressed air to eliminate chips (or coolant for when machining aluminium alloy).

MULTI FUNCTIONAL MILLING

<ALUMINIUM ALLOY TO DIFFICULT-TO-CUT MATERIAL CUTTING>

TOOL NEWS

90° KAPR

AXD4000

P	M	K	N	S	H
Steel			Non-ferrous Metal	Heat Resistant Alloy	

Fig.1

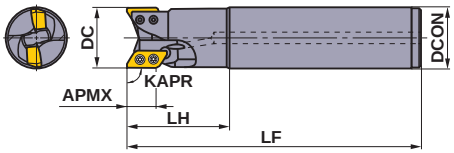
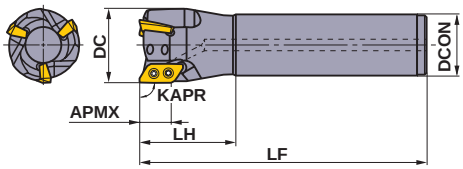


Fig.2



■SHANK TYPE

KAPR :90°

Right hand tool holder only.

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	LH	DCON	APMX (mm)	Max. Allowable Revolution (min^{-1})	Fig.	Clamp Screw *	Wrench	Anti-seize Lubricant	Insert
A Type	0.4 – 3.2	AXD4000R201SA20SA	●	1	20	110	35	20	15.5	15000	1	TS3SBS	TKY08D	MK1KS	XDGX1750○○
		AXD4000R252SA25SA	●	2	25	125	50	25	15.5	49000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R252SA25LA	●	2	25	170	80	25	15.5	49000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R282SA25SA	●	2	28	125	50	25	15.5	48500	2	TS3SB	TKY08D	MK1KS	
		AXD4000R282SA25ELA	●	2	28	220	50	25	15.5	48500	2	TS3SB	TKY08D	MK1KS	
		AXD4000R322SA32SA	●	2	32	150	50	32	15.5	48000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R322SA32LA	●	2	32	200	80	32	15.5	48000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R352SA32SA	●	2	35	150	50	32	15.5	45000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R352SA32ELA	●	2	35	250	50	32	15.5	45000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA32SA	●	3	40	150	50	32	15.5	41000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA42SA	●	3	40	170	80	42	15.5	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA32ELA	●	3	40	250	50	32	15.5	41000	2	TS3SB	TKY08D	MK1KS	
B Type	4.0 – 5.0	AXD4000R201SA20SB	●	1	20	110	35	20	14.8	15000	1	TS3SBS	TKY08D	MK1KS	
		AXD4000R252SA25SB	●	2	25	125	50	25	14.8	49000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R252SA25LB	●	2	25	170	80	25	14.8	49000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R282SA25SB	●	2	28	125	50	25	14.8	48500	2	TS3SB	TKY08D	MK1KS	
		AXD4000R282SA25ELB	●	2	28	220	50	25	14.8	48500	2	TS3SB	TKY08D	MK1KS	
		AXD4000R322SA32SB	●	2	32	150	50	32	14.8	48000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R322SA32LB	●	2	32	200	80	32	14.8	48000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R352SA32SB	●	2	35	150	50	32	14.8	45000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R352SA32ELB	●	2	35	250	50	32	14.8	45000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA32SB	●	3	40	150	50	32	14.8	41000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA42SB	●	3	40	170	80	42	14.8	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000R403SA32ELB	●	3	40	250	50	32	14.8	41000	2	TS3SB	TKY08D	MK1KS	

Note 1) The maximum allowable revolutions are set to ensure tool and insert stability.
Before operating the tool read the operational guidance on page M147.
Note 2) When using the tool at high spindle speeds, ensure that the tool and chuck are correctly balanced.
Note 3) Note for inserts with a corner radius of 1.6 and above, as corner radius increases the LF and LH dimensions decrease.
* Clamp Torque (N • m) : TS3SBS=1.5, TS3SB=1.5
Use the clamp screw by setting the bundled screw.

● : **Inventory maintained in Japan.**

Fig. 1

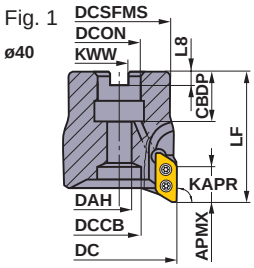


Fig. 2

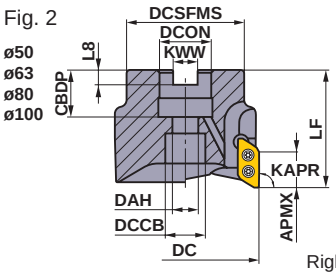
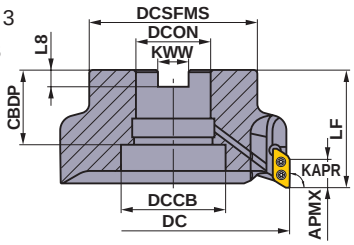
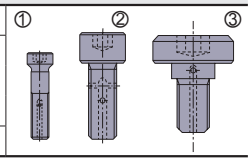


Fig. 3



Right hand tool holder only.

Cutter Diameter DC	Set Bolt	Geometry
ϕ40	HFF08043H	①
ϕ50, ϕ63	HSC10030H	②
ϕ80	HSC12035H	②
ϕ100	HSC16040H	②
ϕ125	MBA20040H	③



■ARBOR TYPE

KAPR :90°
GAMP :+14°−15° GAMF :+21°−+26°

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	CBDP	DAH	BD	KWW	L8	DCCB	WT ⋆2 (kg)	APMX (mm)	Max. Allowable Revolution (min⁻¹)	Fig.	Clamp Screw ⋆1	Wrench	Anti-seize Lubricant	Insert
A Type	0.4 I 3.2	AXD4000-040A02RA	●	2	40	50	16	18	8.5	34	8.4	5.6	12	0.3	15.5	41000	1	TS3SB	TKY08D	MK1KS	XDGX1750○○
		AXD4000-040A03RA	●	3	40	50	16	18	8.5	34	8.4	5.6	12	0.3	15.5	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-050A02RA	●	2	50	50	22	20	11	45	10.4	6.3	17	0.4	15.5	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-050A04RA	●	4	50	50	22	20	11	45	10.4	6.3	17	0.4	15.5	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-063A05RA	●	5	63	50	22	20	11	50	10.4	6.3	17	0.6	15.5	30000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R08005CA	●	5	80	50	25.4	26	13	60	9.5	6	20	1	15.5	27000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R10006DA	●	6	100	63	31.75	32	17	70	12.7	8	26	2	15.5	23000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R12507EA	●	7	125	63	38.1	40	—	90	15.9	10	56	2.8	15.5	20000	3	TS3SB	TKY08D	MK1KS	
B Type	4.0 I 5.0	AXD4000-040A02RB	●	2	40	50	16	18	8.5	34	8.4	5.6	12	0.3	14.8	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-040A03RB	●	3	40	50	16	18	8.5	34	8.4	5.6	12	0.3	14.8	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-050A02RB	●	2	50	50	22	20	11	45	10.4	6.3	17	0.4	14.8	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-050A04RB	●	4	50	50	22	20	11	45	10.4	6.3	17	0.4	14.8	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-063A05RB	●	5	63	50	22	20	11	50	10.4	6.3	17	0.6	14.8	30000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R08005CB	●	5	80	50	25.4	26	13	60	9.5	6	20	1	14.8	27000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R10006DB	●	6	100	63	31.75	32	17	70	12.7	8	26	2	14.8	23000	2	TS3SB	TKY08D	MK1KS	
		AXD4000R12507EB	●	7	125	63	38.1	40	—	90	15.9	10	56	2.8	14.8	20000	3	TS3SB	TKY08D	MK1KS	

For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	CBDP	DAH	BD	KWW	L8	DCCB	WT ⋆2 (kg)	APMX (mm)	Max. Allowable Revolution (min⁻¹)	Fig.	Clamp Screw ⋆1	Wrench	Anti-seize Lubricant	Insert
A Type	0.4 I 3.2	AXD4000-040A02RA	●	2	40	50	16	18	8.5	34	8.4	5.6	12	0.3	15.5	41000	1	TS3SB	TKY08D	MK1KS	XDGX1750○○
		AXD4000-040A03RA	●	3	40	50	16	18	8.5	34	8.4	5.6	12	0.3	15.5	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-050A02RA	●	2	50	50	22	20	11	45	10.4	6.3	17	0.4	15.5	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-050A04RA	●	4	50	50	22	20	11	45	10.4	6.3	17	0.4	15.5	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-063A05RA	●	5	63	50	22	20	11	50	10.4	6.3	17	0.6	15.5	30000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-080A05RA	●	5	80	50	27	23	13	60	12.4	7	20	1	15.5	27000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-100A06RA	●	6	100	63	32	26	17	78	14.4	8	26	2	15.5	23000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-125B07RA	●	7	125	63	40	40	—	90	16.4	9	56	2.8	15.5	20000	3	TS3SB	TKY08D	MK1KS	
B Type	4.0 I 5.0	AXD4000-040A02RB	●	2	40	50	16	18	8.5	34	8.4	5.6	12	0.3	14.8	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-040A03RB	●	3	40	50	16	18	8.5	34	8.4	5.6	12	0.3	14.8	41000	1	TS3SB	TKY08D	MK1KS	
		AXD4000-050A02RB	●	2	50	50	22	20	11	45	10.4	6.3	17	0.4	14.8	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-050A04RB	●	4	50	50	22	20	11	45	10.4	6.3	17	0.4	14.8	35000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-063A05RB	●	5	63	50	22	20	11	50	10.4	6.3	17	0.6	14.8	30000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-080A05RB	●	5	80	50	27	23	13	60	12.4	7	20	1	14.8	27000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-100A06RB	●	6	100	63	32	26	17	78	14.4	8	26	2	14.8	23000	2	TS3SB	TKY08D	MK1KS	
		AXD4000-125B07RB	●	7	125	63	40	40	—	90	16.4	9	56	2.8	14.8	20000	3	TS3SB	TKY08D	MK1KS	

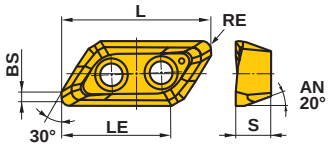
Note 1) The maximum allowable spindle speeds are set to ensure tool and insert stability.
Before operating the tool read the operational guidance on page M147.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.
Note 3) Note for inserts with a corner radius of 1.6 and above, as corner radius increases the LF dimension decrease.
⋆1 Clamp Torque (N • m) : TS3SB=1.5
Use the clamp screw by setting the bundled screw.
⋆2 WT : Tool Weight

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

Work Material			LC15TF	MP6120	MP9120		TF15	
	P	Steel		◐				
	N	Aluminium Alloy	◐				✠	
	S	Titanium Alloy			◐			

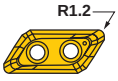
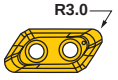
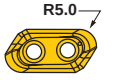
Cutting Conditions (Guide):
● :Stable Cutting ◐ :General Cutting ✠ :Unstable Cutting
Honing:
F :Sharp **E** :Round

Shape	Order Number	Class	Honing	Stock: Coated LC15TF	Coated MP6120	Coated MP9120		Carbide TF15		Dimensions (mm) L	LE	S	BS	RE*	Geometry
GL Breaker	**XDGX175004PDFR-GL**	G	F	●				●		23	16.9	5	1.7	0.4	
	XDGX175008PDFR-GL	G	F	●				●		23	17	5	1.3	0.8	
	XDGX175012PDFR-GL	G	F	●				●		23	17	5	0.9	1.2	
	XDGX175016PDFR-GL	G	F	●				●		22	16.4	5	1.4	1.6	
	XDGX175020PDFR-GL	G	F	●				●		22	16.4	5	1.0	2.0	
	XDGX175024PDFR-GL	G	F	●				●		22	16.4	5	0.6	2.4	
	XDGX175030PDFR-GL	G	F	●				●		21.1	16.1	5	0.8	3.0	
	XDGX175032PDFR-GL	G	F	●				●		21.1	16.1	5	0.6	3.2	
	XDGX175040PDFR-GL	G	F	●				●		20	15.6	5	0.8	4.0	
	XDGX175050PDFR-GL	G	F	●				●		19.4	15.3	5	0.4	5.0	
GM Breaker	**XDGX175004PDER-GM**	G	E		●	●				23	17	5	1.7	0.4	
	XDGX175008PDER-GM	G	E		●	●				23	17	5	0.2	0.8	
	XDGX175012PDER-GM	G	E		●	●				23	17	5	0.9	1.2	
	XDGX175016PDER-GM	G	E		●	●				22	15.9	5	1.4	1.6	
	XDGX175020PDER-GM	G	E		●	●				22	15.9	5	0.8	2.0	
	XDGX175024PDER-GM	G	E		●	●				22	15.9	5	0.4	2.4	
	XDGX175030PDER-GM	G	E		●	●				21.1	16	5	0.6	3.0	
	XDGX175032PDER-GM	G	E		●	●				21.1	16	5	0.4	3.2	
	XDGX175040PDER-GM	G	E		●	●				20	14.8	5	0.5	4.0	
	XDGX175050PDER-GM	G	E		●	●				19.4	15	5	0.4	5.0	
GM Breaker	**XDGX175004PDFR-GM**	G	F					●		23	17	5	1.7	0.4	
	XDGX175008PDFR-GM	G	F					●		23	17	5	1.2	0.8	
	XDGX175012PDFR-GM	G	F					●		23	17	5	0.9	1.2	
	XDGX175016PDFR-GM	G	F					●		22	15.9	5	1.4	1.6	
	XDGX175020PDFR-GM	G	F					●		22	15.9	5	0.8	2.0	
	XDGX175024PDFR-GM	G	F					●		22	15.9	5	0.4	2.4	
	XDGX175030PDFR-GM	G	F					●		21.1	16	5	0.6	3.0	
	XDGX175032PDFR-GM	G	F					●		21.1	16	5	0.4	3.2	
	XDGX175040PDFR-GM	G	F					●		20	14.8	5	0.5	4.0	
	XDGX175050PDFR-GM	G	F					●		19.4	15	5	0.4	5.0	

* Be careful because corner R(RE) has a different shape than machined workpiece R.
When a GM breaker is recommended, stress the dimensional precision of the workpiece shape.

● : **Inventory maintained in Japan. (10 inserts in one case)**

■ Holder And Insert Corner Radius Combination

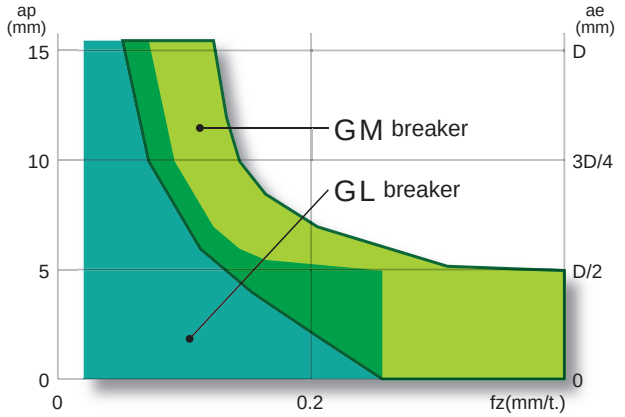
Holder	**A** Type Holder								**B** Type Holder	
	AXD4000–○○○○○○○○A **AXD4000R○○○○○○○○A**								**AXD4000–○○○○○○○B** **AXD4000R○○○○○○○B**	
Applicable Insert Corner R (**RE**)	R0.4	R0.8	R1.2	R1.6	R2.0	R2.4	R3.0	R3.2	R4.0	R5.0
										
	XDGX 175004PD○R-○○	XDGX 175008PD○R-○○	XDGX 175012PD○R-○○	XDGX 175016PD○R-○○	XDGX 175020PD○R-○○	XDGX 175024PD○R-○○	XDGX 175030PD○R-○○	XDGX 175032PD○R-○○	XDGX 175040PD○R-○○	XDGX 175050PD○R-○○

Not interchangeable with the corresponding inserts of the A type and B type holders.

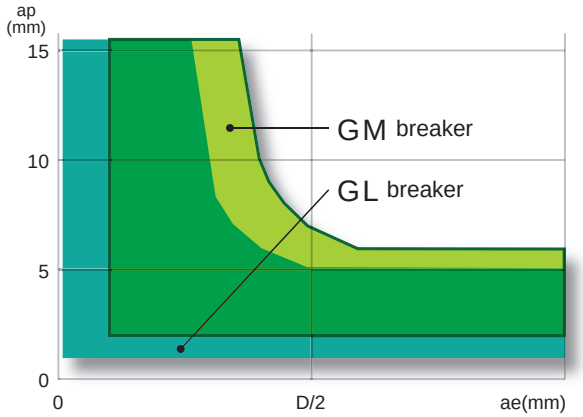
AXD4000 Selection of insert

It is necessary to choose the best insert according to the cutting conditions. Please select an insert from the tables below.
1st recommendation for stable cutting condition is the GL breaker with a strong cutting edge.

Selection of insert according to the feed per tooth and the required cutting depth

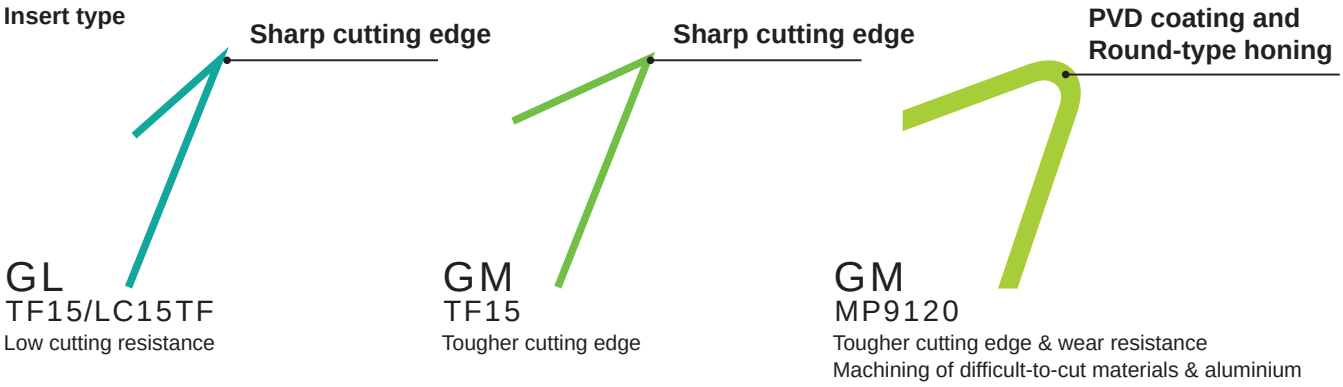


Selection of insert according to the width of cut and the required cutting depth

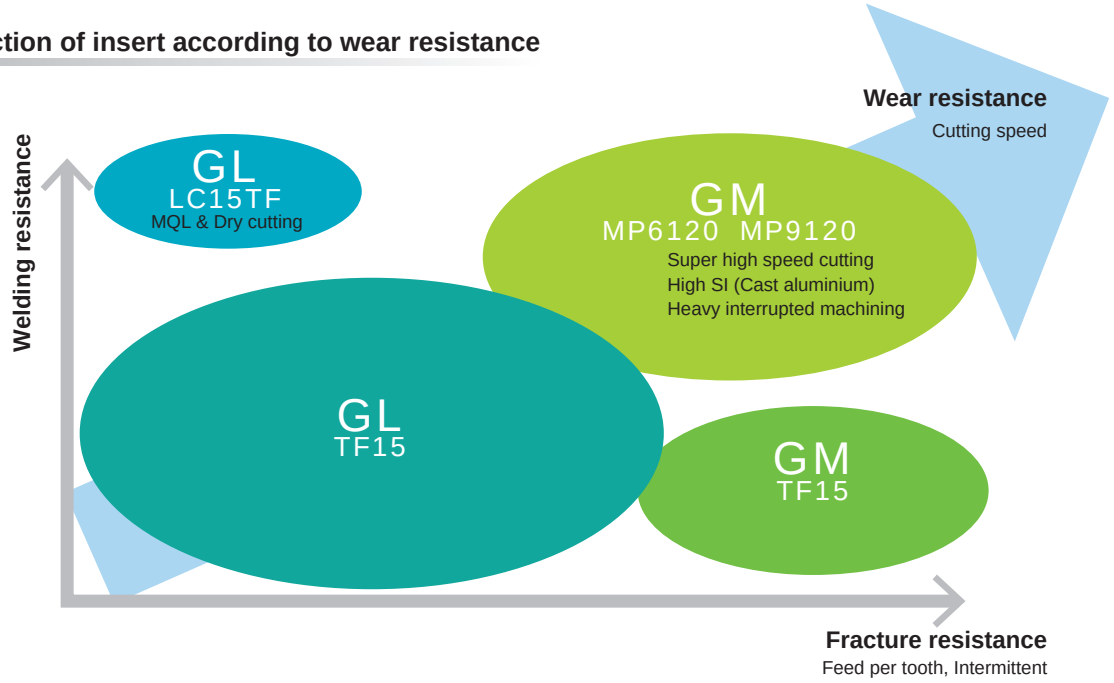


1st recommendation for machining aluminium alloys is GL breaker.
Under high-load conditions such as deep or high feed cutting, it is advisable to use the GM breaker.

Selection of insert according to cutting edge



Selection of insert according to wear resistance



RECOMMENDED CUTTING CONDITIONS

■Cutting Speed

	Work Material		Greade	Breaker	Cutting Speed **vc** (mm/min)
P	Mild Steel (ASTM A36,AISI 1010)	**≤180HB**	**MP6120**	**GM**	200 (150–220)
P	Carbon Steel, Alloy Steel (AISI 1045,AISI 4140)	**180−280HB**	**MP6120**	**GM**	200 (150–220)
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**TF15 LC15TF**	**GL**	1000 (200–3000)
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**TF15 MP9120**	**GM**	1000 (200–3000)
N	Aluminium Alloy (AC4B, ADC12, A390 etc)	**5%≤Si≤10% Si>10%**	**MP9120**	**GM**	1000 (200–3000)
S	Titanium Alloy (Ti-6Al-4V etc)	–	**MP9120**	**GM**	40 (30–60)

■Depth of Cut / Feed per Tooth

	Work Material		Breaker	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth (mm/t.) Cutting Edge Diameter **DC** (mm)					
						20	**25, 28**	**32, 35**	**40**	**50, 63, 80**	**100, 125**
P	Mild Steel (ASTM A36,AISI 1010)	**≤180HB**	**GM**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.05	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 14.5	≤ 0.05	≤ 0.10	≤ 0.10	≤ 0.12	≤ 0.12	–
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	–	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15
					≤ 14.5	–	≤ 0.08	≤ 0.10	≤ 0.10	≤ 0.12	–
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 10	–	≤ 0.10	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.12
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15
	Carbon Steel, Alloy Steel (AISI 1045,AISI 4140)	**180−280HB**	**GM**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.05	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 14.5	≤ 0.05	≤ 0.10	≤ 0.10	≤ 0.12	≤ 0.12	–
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	–	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15
					≤ 14.5	–	≤ 0.08	≤ 0.10	≤ 0.10	≤ 0.12	–
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 10	–	≤ 0.10	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.12
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15

Note 1) The above cutting conditions are determined based on high workpiece and machine rigidity, where no vibration occurred.
If vibrations occur make adjustments according to the machining conditions.

Note 2) Note, vibrations may occur in the following conditions.
- When using long tool overhang.
- When pocket machining corner radii.
- When the workpiece has poor clamping rigidity or when the machine rigidity or workpiece rigidity is low, vibrations can occur easily, if so, reduce cutting conditions such as width and depth of cut and feed per tooth.

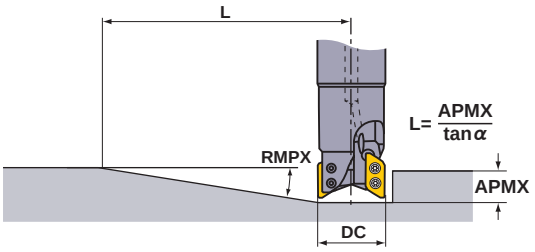
Work Material			Breaker	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth (mm/t.) Cutting Edge Diameter **DC** (mm)					
						20	**25, 28**	**32, 35**	**40**	**50, 63, 80**	**100, 125**
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**GL**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25
					≤ 10	≤ 0.05	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 14.5	≤ 0.05	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25
					≤ 10	–	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 14.5	–	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25
					≤ 10	–	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 14.5	–	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.25
	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**GM**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.05	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35	≤ 0.35
					≤ 14.5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3	≤ 0.3
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.35	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4
					≤ 10	–	≤ 0.3	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 14.5	–	≤ 0.2	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.3	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	–	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 14.5	–	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.35	≤ 0.35
	Aluminium Alloy (AC4B etc) Aluminium Alloy (ADC12, A390 etc)	**5%≤Si≤10%** **Si>10%**	**GM**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.05	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35	≤ 0.35
					≤ 14.5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3	≤ 0.3
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.35	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4
					≤ 10	–	≤ 0.3	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 14.5	–	≤ 0.2	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.3	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	–	≤ 0.25	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 14.5	–	≤ 0.2	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.35	≤ 0.35
S	Titanium Alloy (Ti-6Al-4V etc)	–	**GM**	≤0.25 DC	≤ 5	≤ 0.05	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 10	≤ 0.05	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 14.5	≤ 0.05	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
				≤0.5 DC	≤ 5	≤ 0.05	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 10	–	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 14.5	–	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1	≤ 0.1
				≤0.75 DC	≤ 5	≤ 0.05	≤ 0.05	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 10	–	≤ 0.05	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1
					≤ 14.5	–	≤ 0.05	≤ 0.08	≤ 0.1	≤ 0.1	≤ 0.1
				DC (Slot)	≤ 5	≤ 0.05	≤ 0.05	≤ 0.05	≤ 0.05	≤ 0.05	≤ 0.05

Note 1) The above cutting conditions are determined based on high workpiece and machine rigidity, where no vibration occurred.
If vibrations occur make adjustments according to the machining conditions.

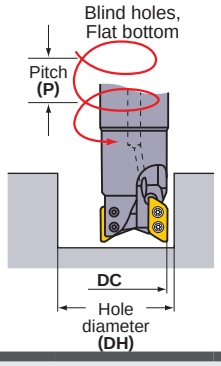
Note 2) Note, vibrations may occur in the following conditions.
- When using long tool overhang.
- When pocket machining corner radii.
- When the workpiece has poor clamping rigidity or when the machine rigidity or workpiece rigidity is low, vibrations can occur easily, if so, reduce cutting conditions such as width and depth of cut and feed per tooth.

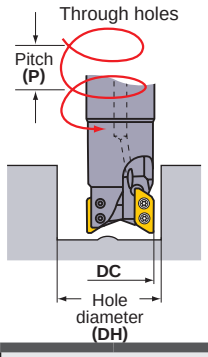
■RAMPING/HELICAL CUTTING

●RAMPING



●HELICAL CUTTING





RAMPING/HELICAL CUTTING (Aluminium Alloy)

Holder Type	Cutting Edge Diameter DC (mm)	Insert Corner R RE (mm)	Ramping: Maximum Ramping Angle RMPX	Ramping: Minimum Distance L *1 (mm)	Helical Milling (Blind Hole, Flat Bottom): Maximum Hole Diameter DH max. (mm)	Helical Milling (Blind Hole, Flat Bottom): Maximum Pitch P max. (mm)	Helical Milling (Blind Hole, Flat Bottom): Minimum Hole Diameter DH min. (mm)	Helical Milling (Blind Hole, Flat Bottom): Maximum Pitch P max. (mm)	Helical Milling: Minimum Hole Diameter DH min. (mm)	Helical Milling: Maximum Pitch P max. (mm)
A type	20	0.4—1.2	20.7°	42	37.1 *2	14	36.1	14	22	2
		1.6—2.4	19.9°	43	34.7 *3	13	34.6	13	22	2
		3.0—3.2	18.9°	46	33.1 *4	12	33.3	12	22	1
	25	0.4—1.2	23.1°	37	47.1 *2	14	46	14	31.6	8
		1.6—2.4	22.0°	39	44.7 *3	13	44.4	13	31.6	8
		3.0—3.2	18.7°	46	43.1 *4	12	43	12	31.6	7
	28	0.4—1.2	19.2°	45	53.1 *2	14	52	14	36	8
		1.6—2.4	18.5°	47	50.7 *3	13	50.4	13	36	8
		3.0—3.2	16.7°	52	49.1 *4	12	48.9	12	36	7
	32	0.4—1.2	15.4°	57	61.1 *2	14	59.9	14	45.5	11
		1.6—2.4	14.7°	60	58.7 *3	13	58.3	13	45.5	11
		3.0—3.2	13.8°	64	57.1 *4	12	56.8	12	45.5	10
	35	0.4—1.2	13.4°	66	67.1 *2	14	65.8	14	50	11
		1.6—2.4	12.7°	69	64.7 *3	13	64.3	13	50	10
		3.0—3.2	11.8°	75	63.1 *4	12	62.8	12	50	9
	40	0.4—1.2	11.1°	80	76.7 *2	14	75.9	14	61.5	13
		1.6—2.4	10.4°	85	74.3 *3	13	74.2	13	61.5	12
		3.0—3.2	9.7°	91	72.7 *4	12	72.7	12	61.5	11
	50	0.4—1.2	8.2°	108	96.7 *2	14	95.6	14	81.4	14
		1.6—2.4	7.6°	117	94.3 *3	13	94	13	81.4	13
		3.0—3.2	6.9°	129	92.7 *4	12	92.4	12	81.4	11
	63	0.4—1.2	6.1°	146	122.7 *2	14	121.6	14	107.4	14
		1.6—2.4	5.6°	159	120.3 *3	13	119.9	13	107.4	13
		3.0—3.2	5.2°	171	118.7 *4	12	118.4	12	107.4	12
	80	0.4—1.2	4.6°	193	156.7 *2	14	155.6	14	141.4	14
		1.6—2.4	4.2°	212	154.3 *3	13	153.9	13	141.4	13
		3.0—3.2	3.8°	234	152.7 *4	12	152.4	12	141.4	12
	100	0.4—1.2	3.5°	254	196.7 *2	14	195.5	14	181.5	14
		1.6—2.4	3.2°	278	194.3 *3	13	193.9	13	181.5	13
		3.0—3.2	2.9°	306	192.7 *4	12	192.3	12	181.5	12
	125	0.4—1.2	2.7°	329	246.7 *2	14	245.5	14	231.5	14
		1.6—2.4	2.5°	356	244.3 *3	13	243.8	13	231.5	13
		3.0—3.2	2.3°	386	242.7 *4	12	242.3	12	231.5	12

Note 1) Ramping, helical, and drilling are not recommended for machining of steel and titanium alloys.

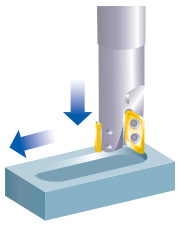
Holder Type	Cutting Edge Diameter **DC** (mm)	Insert Corner R **RE** (mm)	Ramping		Helical Milling (Blind Hole, Flat Bottom)				Helical Milling	
			Maximum Ramping Angle **RMPX**	Minimum Distance **L** ⋆1 (mm)	Maximum Hole Diameter **DH max.** (mm)	Maximum Pitch **P max.** (mm)	Minimum Hole Diameter **DH min.** (mm)	Maximum Pitch **P max.** (mm)	Minimum Hole Diameter **DH min.** (mm)	Maximum Pitch **P max.** (mm)
B type	20	4	17.5°	47	31.5	10	31.8	10	22	1
		5	16.6°	71	29.5	6	31.1	7	22	1
	25	4	15.1°	55	41.5	10	41.4	10	31.7	5
		5	13.7°	61	39.5	9	40.6	9	31.7	5
	28	4	14.1°	59	47.5	10	47.2	10	36	6
		5	13°	65	45.5	9	46.4	9	36	5
	32	4	12.7°	66	55.5	10	55.1	10	45.5	9
		5	12°	70	53.5	9	54.3	9	45.5	8
	35	4	10.8°	78	61.5	10	61	10	50	8
		5	10.2°	83	59.5	9	60.2	9	50	8
	40	4	8.8°	96	71.1	10	70.9	10	61.5	10
		5	8.2°	103	69.1	9	70.1	9	61.5	9
	50	4	6.3°	135	91.1	10	90.6	10	81.3	10
		5	5.8°	146	89.1	9	89.8	9	81.3	9
	63	4	4.6°	184	117.1	10	116.6	10	107.4	10
		5	4.2°	202	115.1	9	115.7	9	107.3	9
	80	4	3.4°	250	151.1	10	150.5	10	141.4	10
		5	3.1°	274	149.1	9	149.6	9	141.4	9
	100	4	2.6°	326	191.1	10	190.5	10	181.4	10
		5	2.4°	354	189.1	9	189.6	9	181.4	9
	125	4	2°	424	241.1	10	240.5	10	231.4	10
		5	1.8°	471	239.1	9	239.6	9	229.9	9

Note 1) The recommended ramping feed is 0.05mm/t. or under.
⋆1 Using the maximum ramping angle, the distance to reach the maximum depth of cut is as follows:
L= (maximum depth of cut APMX/tan α). Maximum depth of cut A type is 15.5mm, B type is 14.8mm.
⋆2 Corner radius of 1.2mm. For other corner radii, use the following formula. {(cutting edge diameter DC)−(corner radius RE)−0.25}×2
⋆3 Corner radius of 2.4mm. For other corner radii, use the following formula. {(cutting edge diameter DC)−(corner radius RE)−0.25}×2
⋆4 Corner radius of 3.2mm. For other corner radii, use the following formula. {(cutting edge diameter DC)−(corner radius RE)−0.25}×2

Max.Drilling Depth (Aluminium Alloy)

Type	Insert Corner R **RE** (mm)	Max.Drilling Depth (mm)					
		Cutting Edge Diameter **DC** (mm)					
		ϕ20	**ϕ25**	**ϕ28**	**ϕ32**	**ϕ35**	**ϕ40−ϕ125**
A type	0.4	5.3	5.2	5.2	5.2	5.3	5.3
	0.8	5.3	5.2	5.2	5.2	5.3	5.3
	1.2	5.3	5.2	5.2	5.2	5.3	5.3
	1.6	4.8	4.6	4.7	4.7	4.9	4.8
	2.0	4.8	4.6	4.7	4.7	4.9	4.8
	2.4	4.8	4.6	4.7	4.7	4.9	4.8
	3.0	4.3	3.7	4.2	4.2	4.4	4.4
	3.2	4.3	3.7	4.2	4.2	4.4	4.4
B type	4.0	3.7	2.7	3.7	3.6	3.8	3.8
	5.0	3.4	2.3	3.3	3.3	3.5	3.5

AXD4000 can be effectively used for pocket machining without the need for a prepared hole.



MULTI FUNCTIONAL MILLING

<ALUMINIUM ALLOY TO DIFFICULT-TO-CUT MATERIAL CUTTING>

TOOL NEWS

90° KAPR

AXD7000

P	M	K	N	S	H
Steel			Non-ferrous Metal	Heat Resistant Alloy	

- Low resistance chipbreaker.
- Low resistance insert and high rigidity design for excellent performance.
- For high-speed machining.
- Multi-functional machining.

Fig.1

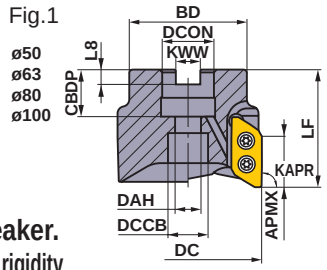
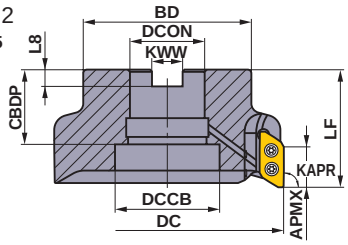
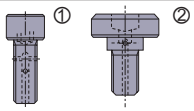


Fig.2



Right hand tool holder only.

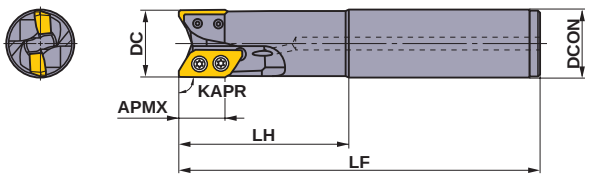
Cutter Diameter DC	Set Bolt	Geometry
ϕ50, ϕ63	HSC10030H	①
ϕ80	HSC12035H	①
ϕ100	HSC16040H	①
ϕ125	MBA20040H	②



■ARBOR TYPE

KAPR :90°
GAMP:+11° GAMF:+26°−+29°

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	CBDP	DAH	BD	KWW	L8	DCCB	*2 WT (kg)	APMX (mm)	Max. Allowable Revolution (min⁻¹)	Fig.	*1 Clamp Screw	Wrench	Anti-seize Lubricant	Insert
A Type	0.8 I 3.2	AXD7000-050A03RA	●	3	50	50	22	20	11	45	10.4	6.3	17	0.4	21	30000	1	TS4SBL	TKY15D	MK1KS	XDGX2270○○
		AXD7000-063A03RA	●	3	63	50	22	20	11	50	10.4	6.3	17	0.5	21	25000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R08004CA	●	4	80	63	25.4	26	13	63	9.5	6	20	1.2	21	23000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R10005DA	●	5	100	63	31.75	32	17	70	12.7	8	26	1.8	21	19000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R12506EA	●	6	125	63	38.1	40	—	90	15.9	10	56	2.7	21	16000	2	TS4SBL	TKY15D	MK1KS	
B Type	4.0 I 5.0	AXD7000-050A03RB	●	3	50	50	22	20	11	45	10.4	6.3	17	0.4	20.4	30000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-063A03RB	●	3	63	50	22	20	11	50	10.4	6.3	17	0.5	20.4	25000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R08004CB	●	4	80	63	25.4	26	13	63	9.5	6	20	1.2	20.4	23000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R10005DB	●	5	100	63	31.75	32	17	70	12.7	8	26	1.8	20.4	19000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000R12506EB	●	6	125	63	38.1	40	—	90	15.9	10	56	2.7	20.4	16000	2	TS4SBL	TKY15D	MK1KS	



■SHANK TYPE

KAPR:90°

Right hand tool holder only.

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	LH	DCON	APMX (mm)	Max. Allowable Revolution (min⁻¹)	*1 Clamp Screw	Wrench	Anti-seize Lubricant	Insert
A Type	0.8 I 3.2	AXD7000R322SA32SA	●	2	32	170	80	32	21	41000	TS4SB	TKY15D	MK1KS	XDGX2270○○
		AXD7000R402SA42SA	●	2	40	170	80	42	21	36000	TS4SBL	TKY15D	MK1KS	
B Type	4.0 I 5.0	AXD7000R322SA32SB	●	2	32	170	80	32	20.4	41000	TS4SB	TKY15D	MK1KS	
		AXD7000R402SA42SB	●	2	40	170	80	42	20.4	36000	TS4SBL	TKY15D	MK1KS	

Note 1) The maximum allowable revolutions are set to ensure tool and insert stability.
Before operating the tool read the operational guidance on page M147.
Note 2) When using the tool at high spindle speeds, ensure that the tool and chuck are correctly balanced.
Note 3) Note for inserts with a corner radius of 3.0 and above, as corner radius increases the LF and LH dimensions decreases.
*1 Clamp Torque (N • m) : TS4SB=3.5, TS4SBL=3.5
Use the clamp screw by setting the bundled screw.
*2 WT : Tool Weight

● : **Inventory maintained in Japan.**

Fig.1

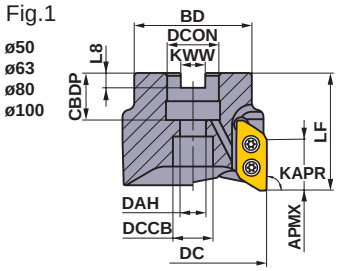
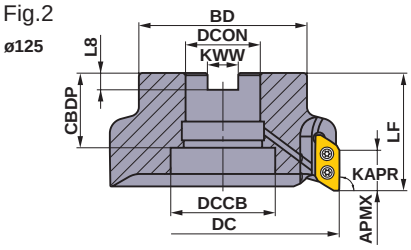


Fig.2

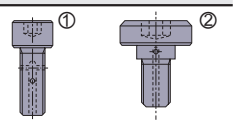


Right hand tool holder only.

For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

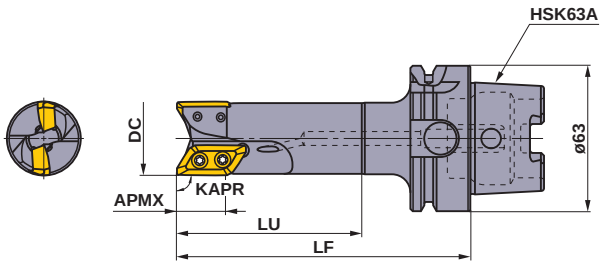
Cutter Diameter DC	Set Bolt	Geometry
ϕ50, ϕ63	HSC10030H	①
ϕ80	HSC12035H	①
ϕ100	HSC16040H	①
ϕ125	MBA20040H	②



■ARBOR TYPE

KAPR :90°
GAMP:+11° GAMF:+26°−+29°

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	CBDP	DAH	BD	KWW	L8	DCCB	*2 WT (kg)	APMX (mm)	Max. Allowable Revolution (min⁻¹)	Fig.	*1 Clamp Screw	Wrench	Anti-seize Lubricant	Insert
A Type	0.8 I 3.2	AXD7000-050A03RA	●	3	50	50	22	20	11	45	10.4	6.3	17	0.4	21	30000	1	TS4SBL	TKY15D	MK1KS	XDGX2270□□
		AXD7000-063A03RA	●	3	63	50	22	20	11	50	10.4	6.3	17	0.5	21	25000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-080A04RA	●	4	80	63	27	23	13	63	12.4	7	20	1.2	21	23000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-100A05RA	●	5	100	63	32	26	17	70	14.4	8	26	1.8	21	19000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-125B06RA	●	6	125	63	40	40	—	90	16.4	9	56	2.7	21	16000	2	TS4SBL	TKY15D	MK1KS	
B Type	4.0 I 5.0	AXD7000-050A03RB	●	3	50	50	22	20	11	45	10.4	6.3	17	0.4	20.4	30000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-063A03RB	●	3	63	50	22	20	11	50	10.4	6.3	17	0.5	20.4	25000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-080A04RB	●	4	80	63	27	23	13	63	12.4	7	20	1.2	20.4	23000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-100A05RB	●	5	100	63	32	26	17	70	14.4	8	26	1.8	20.4	19000	1	TS4SBL	TKY15D	MK1KS	
		AXD7000-125B06RB	●	6	125	63	40	40	—	90	16.4	9	56	2.7	20.4	16000	2	TS4SBL	TKY15D	MK1KS	



■HSK63A SHANK TYPE

KAPR:90°

Right hand tool holder only.

Type	Insert Corner Radius RE	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	LU	APMX (mm)	Max. Allowable Revolution (min⁻¹)	*1 Clamp Screw	Wrench	Anti-seize Lubricant	Insert
A Type	0.8 I 3.2	AXD7000R03202A-H63A	●	2	32	127	80	21	41000	TS4SB	TKY15D	MK1KS	XDGX2270□□
		AXD7000R04002A-H63A	●	2	40	132	85	21	36000	TS4SBL	TKY15D	MK1KS	
		AXD7000R05003A-H63A	●	3	50	137	90	21	30000	TS4SBL	TKY15D	MK1KS	

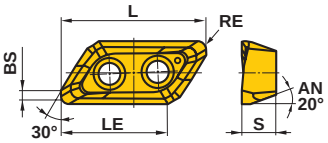
Note 1) The maximum allowable revolutions are set to ensure tool and insert stability.
Before operating the tool read the operational guidance on page M147.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.
Note 3) Note for inserts with a corner radius of 3.0 and above, as corner radius increases the LF and LU dimensions decreases.
Note 4) No hole for data carrier.
Note 5) The HSK63A shank type has a built-in coolant pipe for installation.
*1 Clamp Torque (N • m) : TS4SB=3.5, TS4SBL=3.5
Use the clamp screw by setting the bundled screw.
*2 WT : Tool Weight

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

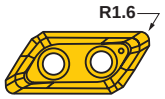
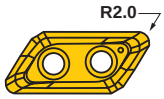
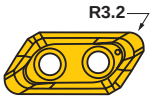
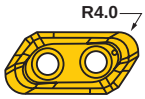
Work Material			LC15TF	MP6120	MP9120		TF15	
	P	Steel		◐				
	N	Aluminium Alloy	◐				✠	
	S	Titanium Alloy			◐			

Cutting Conditions (Guide):
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	Stock: Coated LC15TF	Coated MP6120	Coated MP9120		Carbide TF15		Dimensions (mm) L	LE	S	BS	RE *	Geometry
	XDGX227008PDFR-GL	G	F	●				●		30	21.6	7	2	0.8	
	XDGX227016PDFR-GL	G	F	●				●		30	21.7	7	1.2	1.6	
	XDGX227020PDFR-GL	G	F	●				●		30	21.7	7	0.8	2	
	XDGX227030PDFR-GL	G	F	●				●		28.8	21.2	7	0.9	3	
	XDGX227032PDFR-GL	G	F	●				●		28.8	21.2	7	0.7	3.2	
	XDGX227040PDFR-GL	G	F	●				●		27.5	20.6	7	1	4	
	XDGX227050PDFR-GL	G	F	●				●		27	20.3	7	0.4	5	
	XDGX227008PDER-GLA	G	E		●	●				30	21.7	7	2	0.8	
	XDGX227016PDER-GLA	G	E		●	●				30	21.7	7	1.2	1.6	
	XDGX227020PDER-GLA	G	E		●	●				30	21.7	7	0.8	2	
	XDGX227024PDER-GLA	G	E		●	●				30	21.7	7	0.3	2.4	
	XDGX227030PDER-GLA	G	E		●	●				28.8	21.1	7	0.9	3	
	XDGX227032PDER-GLA	G	E		●	●				28.8	21.1	7	0.6	3.2	
	XDGX227040PDER-GLA	G	E		●	●				27.5	20.4	7	0.9	4	
	XDGX227050PDER-GLA	G	E		●	●				27	20.2	7	0.3	5	

* GLA breaker corner R (RE) is designed with almost same corner R as a machined corner R of workpiece.
* Be careful because corner R (RE) has a different shape machined workpiece R.

■HOLDER AND INSERT CORNER RADIUS COMBINATION

Holder	A Holder					B Holder	
	AXD7000–○○○○○○○A AXD7000R○○○○○○○A AXD7000R○○○○A-H63A					AXD7000–○○○○○○○B AXD7000R○○○○○○○B	
Insert Corner Radius (**RE**)	R0.8	R1.6 	R2.0 	R3.0	R3.2 	R4.0 	R5.0
	XDGX 227008PDFR-GL	**XDGX 227016PDFR-GL**	**XDGX 227020PDFR-GL**	**XDGX 227030PDFR-GL**	**XDGX 227032PDFR-GL**	**XDGX 227040PDFR-GL**	**XDGX 227050PDFR-GL**

Not interchangeable with the corresponding inserts of the A type and B type holders.

M

INDEXABLE MILLING

● : **Inventory maintained in Japan. (10 inserts in one case)**

RECOMMENDED CUTTING CONDITIONS

■Cutting Speed

Work Material			Greade	Breaker	Cutting Speed **vc** (mm/min)
P	Mild Steel (SS400, S10C etc)	**≤180HB**	**MP6120**	**GLA**	200 (150–220)
P	Carbon Steel Alloy Steel (S45C, SCM440 etc)	**180–280HB**	**MP6120**	**GLA**	200 (150–220)
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**LC15TF**	**GL**	1000 (200–3000)
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**TF15**	**GL**	1000 (200–3000)
N	Aluminium Alloy (AC4B, ADC12, A390 etc)	**5%≤Si≤10%** **Si>10%**	**LC15TF**	**GL**	1000 (200–3000)
S	Titanium Alloy (Ti-6Al-4V etc)		**MP9120**	**GLA**	40 (30–60)

■Depth of Cut / Feed per Tooth

Work Material			Breaker	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth (mm/t.) Cutting Edge Diameter **DC** (mm)			
						32	**40**	**50, 63, 80**	**100, 125**
P	Mild Steel (SS400, S10C etc)	**≤180HB**	**GLA**	≤0.25 DC	≤ 5	≤ 0.18	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 10	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 15	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 20	≤ 0.1	≤ 0.12	≤ 0.12	–
				≤0.5 DC	≤ 5	≤ 0.18	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 10	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 15	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 20	≤ 0.1	≤ 0.12	≤ 0.12	–
				≤0.75 DC	≤ 5	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15
					≤ 15	≤ 0.1	≤ 0.1	≤ 0.12	≤ 0.12
				DC (Slot)	≤ 5	≤ 0.12	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.1	≤ 0.12	≤ 0.15	≤ 0.15
	Carbon Steel Alloy Steel (S45C, SCM440 etc)	**180–280HB**	**GLA**	≤0.25 DC	≤ 5	≤ 0.18	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 10	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 15	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 20	≤ 0.1	≤ 0.12	≤ 0.12	–
				≤0.5 DC	≤ 5	≤ 0.18	≤ 0.2	≤ 0.2	≤ 0.2
					≤ 10	≤ 0.15	≤ 0.18	≤ 0.18	≤ 0.18
					≤ 15	≤ 0.12	≤ 0.15	≤ 0.15	≤ 0.15
					≤ 20	≤ 0.1	≤ 0.12	≤ 0.12	–
				≤0.75 DC	≤ 5	≤ 0.15	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.12	≤ 0.12	≤ 0.15	≤ 0.15
					≤ 15	≤ 0.1	≤ 0.1	≤ 0.12	≤ 0.12
				DC (Slot)	≤ 5	≤ 0.12	≤ 0.15	≤ 0.18	≤ 0.18
					≤ 10	≤ 0.1	≤ 0.12	≤ 0.15	≤ 0.15

Note 1) The above cutting conditions are determined based on high workpiece and machine rigidity, where no vibration occurred.
If vibrations occur make adjustments according to the machining conditions.

Note 2) Note, vibrations may occur in the following conditions.
- When using long tool overhang.
- When pocket machining corner radii.
- When the workpiece has poor clamping rigidity or when the machine rigidity or workpiece rigidity is low, vibrations can occur easily, if so, reduce cutting conditions such as width and depth of cut and feed per tooth.

RECOMMENDED CUTTING CONDITIONS

■ Depth of Cut / Feed per Tooth

	Work Material		Breaker	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth (mm/t.) Cutting Edge Diameter **DC** (mm)			
						32	**40**	**50, 63, 80**	**100, 125**
N	Aluminium Alloy (A6061, A7075 etc)	**Si<5%**	**GL**	≤0.25 DC	≤ 5	≤ 0.35	≤ 0.4	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.3	≤ 0.35	≤ 0.35	≤ 0.35
					≤ 15	≤ 0.25	≤ 0.3	≤ 0.3	≤ 0.3
					≤ 20	≤ 0.2	≤ 0.25	≤ 0.25	≤ 0.25
				≤0.5 DC	≤ 5	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 15	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 20	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
				≤0.75 DC	≤ 5	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 15	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
					≤ 20	≤ 0.15	≤ 0.15	≤ 0.2	≤ 0.2
				DC (Slot)	≤ 5	≤ 0.25	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	≤ 0.2	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 15	≤ 0.15	≤ 0.2	≤ 0.25	≤ 0.25
					≤ 20	≤ 0.1	≤ 0.15	≤ 0.2	≤ 0.2
	Aluminium Alloy (AC4B etc) Aluminium Alloy (ADC12, A390 etc)	**5%≤Si≤10%** **Si>10%**	**GL**	≤0.25 DC	≤ 5	≤ 0.35	≤ 0.4	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.3	≤ 0.35	≤ 0.35	≤ 0.35
					≤ 15	≤ 0.25	≤ 0.3	≤ 0.3	≤ 0.3
					≤ 20	≤ 0.2	≤ 0.25	≤ 0.25	≤ 0.25
				≤0.5 DC	≤ 5	≤ 0.35	≤ 0.35	≤ 0.4	≤ 0.4
					≤ 10	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 15	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 20	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
				≤0.75 DC	≤ 5	≤ 0.3	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	≤ 0.25	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 15	≤ 0.2	≤ 0.2	≤ 0.25	≤ 0.25
					≤ 20	≤ 0.15	≤ 0.15	≤ 0.2	≤ 0.2
				DC (Slot)	≤ 5	≤ 0.25	≤ 0.3	≤ 0.35	≤ 0.35
					≤ 10	≤ 0.2	≤ 0.25	≤ 0.3	≤ 0.3
					≤ 15	≤ 0.15	≤ 0.2	≤ 0.25	≤ 0.25
					≤ 20	≤ 0.1	≤ 0.15	≤ 0.2	≤ 0.2
S	Titanium Alloy (Ti-6Al-4V etc)	–	**GLA**	≤0.25 DC	≤ 5	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 10	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 15	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 20	≤ 0.1	≤ 0.12	≤ 0.12	–
				≤0.5 DC	≤ 5	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 10	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 15	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 20	–	≤ 0.1	≤ 0.1	–
				≤0.75 DC	≤ 5	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 10	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 15	≤ 0.1	≤ 0.12	≤ 0.12	–
					≤ 20	–	≤ 0.1	≤ 0.1	–
				DC (Slot)	≤ 5	≤ 0.08	≤ 0.08	≤ 0.08	–
					≤ 10	≤ 0.05	≤ 0.08	≤ 0.08	–

Note 1) The above cutting conditions are determined based on high workpiece and machine rigidity, where no vibration occurred.
If vibrations occur make adjustments according to the machining conditions.

Note 2) Note, vibrations may occur in the following conditions.
- When using long tool overhang.
- When pocket machining corner radii.
- When the workpiece has poor clamping rigidity or when the machine rigidity or workpiece rigidity is low, vibrations can occur easily, if so, reduce cutting conditions such as width and depth of cut and feed per tooth.

■CAUTION FOR USE

Procedure for attaching inserts

1) Clean the seat by air blowing or with a brush before installing the insert.
2) Tighten the clamp screw using the accessory wrench while pressing the insert against the seat.
3) Tighten the clamp screw as shown in Figure 1.
4) Coat the clamp screw with anti-seize compound and tighten it to the specified tightening torque.
   The tightening torque is shown below.
   AXD7000 3.5N•m(2.58ft•lb)
   AXD4000 1.5N•m(1.11ft•lb)
5) The clamp screw is an important part in ensuring safety.
   Purchase an official product from Mitsubishi Materials.
   When using over the revolution shown in Table 2, replacing the clamp screw simultaneously with insert replacement is recommended.

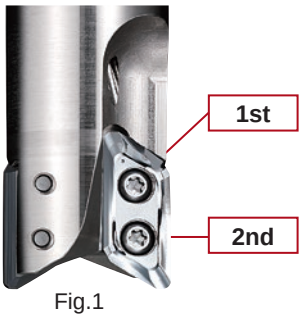
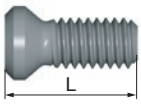


Fig.1

Type	AXD4000		AXD7000	
Cutting Edge Diameter **DC**(mm)	ø20	ø25−ø125	ø32	ø40−ø125
Clamp Screw Number	TS3SBS	TS3SB	TS4SB	TS4SBL
Overall Length **L**(mm)	6.5	8	9	10.5



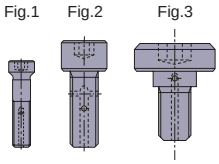
6) Check that there is no clearance at the insert seat surface.

Installation of arbor type

1) Clean carefully the inside and face of the hole and the arbor face before installing the body to the arbor.
2) Set the body at the arbor and tighten it with the accessory. Refer to the table shown below for the tightening torque.
3) The set bolt supplied with the AXD is a special coolant through compatible nozzle. Be careful not to lose it.

AXD4000

Geometry	Set Bolt	Clamp Torque (N • m)	Cutting Edge Diameter **DC**(mm)	Fig
Fig.1 Fig.2 Fig.3	HFF08043H	11	ø40	1
	HSC10030H	40	ø50, ø63	2
	HSC12035H	80	ø80	2
	HSC16040H	150	ø100	2
	MBA20040H	320	ø120	3



AXD7000

Geometry	Set Bolt	Clamp Torque (N•m)	Cutting Edge Diameter **DC**(mm)	Fig
Fig.1 Fig.2	HSC10030H	40	ø50, ø63	1
	HSC12035H	80	ø80	1
	HSC16040H	150	ø100	1
	MBA20040H	320	ø120	2

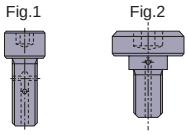


Table 1 Max. Allowable Revolution

AXD4000

Cutting Edge Diameter **DC**(mm)	ø25	ø32	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min^{-1})	49000	48000	41000	35000	30000	27000	23000	20000

AXD7000

Cutting Edge Diameter **DC**(mm)	ø32	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min^{-1})	41000	36000	30000	25000	23000	19000	16000

● Even when operating under the maximum allowable spindle speed, if the spindle speed is equal to or higher than the values shown in table 2, it is recommended that the balance quality (with the arbor or milling chuck) conforms to G6.3 or betterbased on ISO1940. It is also recommended to replace the clamp screws with new ones when changing inserts. Furthermore,ensure to use machines that are provided with safety measures in case of cutter breakage.

Note 1) The balance quality of the holder (without inserts and clamp screws) is G6.3 or better at 10,000min^{-1}.

Table 2 Maximum spindle speed when balancing with the arbor or milling chuck has not been achieved

AXD4000

Cutting Edge Diameter **DC**(mm)	ø25	ø32	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min^{-1})	12000	9500	7600	6000	4800	3800	3000	2400

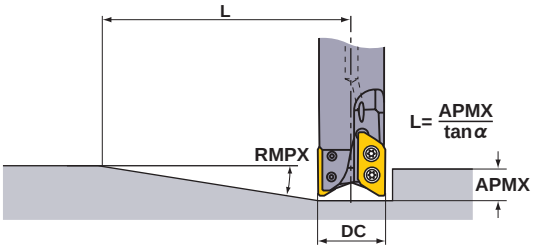
AXD7000

Cutting Edge Diameter **DC**(mm)	ø32	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min^{-1})	9500	7600	6000	4800	3800	3000	2400

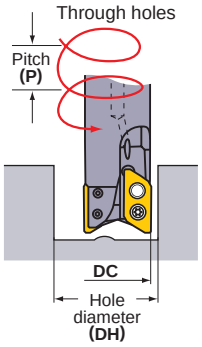
● When setting the spindle speed, take into consideration the maximum allowable spindle speed of the arbor or milling chuck.
● Use the specified set bolt when using the arbor type with through coolant.
● The inserts have sharp cutting edges and handling them with bare hands may cause injuries.
   Always wear safety gloves whenhandling the indexable inserts.

■RAMPING/HELICAL CUTTING

● **RAMPING**



● **HELICAL CUTTING**



RAMPING/HELICAL CUTTING (ALUMINIUM ALLOY)

Type	DC (mm)	RE (mm)	Ramping	
			RMPX	L (mm) *1
A type	32	0.8 - 2.4	19°	61
		3,3.2	18°	65
	40	0.8 - 2.4	14°	85
		3, 3.2	13°	91
	50	0.8 - 2.4	10°	120
		3, 3.2	9°	133
	63	0.8 - 2.4	8°	150
		3, 3.2	7°	172
	80	0.8 - 2.4	6°	200
		3, 3.2	5°	241
	100	0.8 - 2.4	4°	301
		3, 3.2	4°	301
	125	0.8 - 2.4	3°	401
		3, 3.2	3°	401
B type	32	4, 5	18°	63
	40	4, 5	11°	105
	50	4, 5	8°	146
	63	4, 5	6°	195
	80	4, 5	4°	292
	100	4, 5	3°	390
	125	4, 5	2°	585

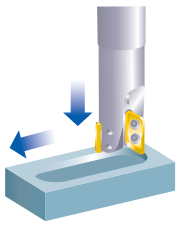
Type	DC (mm)	RE (mm)	Helical Milling	
			DH min. (mm)	P max. (mm)
A type	32	0.8 - 2.4	41	8
		3, 3.2	41	7
	40	0.8 - 2.4	57	10
		3, 3.2	57	9
	50	0.8 - 2.4	77	12
		3, 3.2	77	11
	63	0.8 - 2.4	103	13
		3, 3.2	103	12
	80	0.8 - 2.4	137	14
		3, 3.2	137	12
	100	0.8 - 2.4	177	14
		3, 3.2	177	13
	125	0.8 - 2.4	227	15
		3, 3.2	227	13
B type	32	4	41	7
		5	41	6
	40	4	57	9
		5	57	8
	50	4	77	10
		5	77	9
	63	4	103	10
		5	103	10
	80	4	137	11
		5	137	10
	100	4	177	11
		5	177	10
	125	4	227	11
		5	227	11

Note 1) The recommended ramping feed is 0.05mm/t. or under.
Ramping, helical, and drilling are not recommended for machining of steel and titanium alloys.
*1 L (Max. Depth of Cut =15 / tan α). Cutters' moving distance until depth of cut reaches APMX at a maximum ramping angle.
Maximum depth of cut A type is 21mm, B type is 20.4mm.
*2 The maximum diameter when machining a blind hole with a flat face using a corner radius of 0.8mm for A type and 4mm for B type.
Other than that, find with the below formula.
{(cutting edge diameter DC)−(corner radius)−0.3}×2
*3 The minimum diameter when machining a blind hole with a flat face using a corner radius of 0.8mm for A type and 4mm for B type.
Other than that, find with the below formula.
{(cutting edge diameter DC)−(corner radius)−(Width of wiper edge BS)−0.1}×2

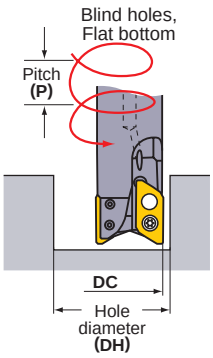
■Max. Drilling Depth (Aluminium Alloy)

Type	Insert corner radius RE (mm)	Max. Drilling Depth (mm)
Type A	0.8−2.4	5
	3, 3.2	4.5
Type B	4	4
	5	3.5

AXD7000 can be effectively used for pocket machining without the need for a prepared hole.



● **HELICAL CUTTING**



RAMPING/HELICAL CUTTING (ALUMINIUM ALLOY)

Type	DC (mm)	RE (mm)	BS (mm)	Helical Cutting (Blind Hole, Flat Bottom)			
				DH max. (mm) *2	P max. (mm)	DH min. (mm) *3	P max. (mm)
A type	32	0.8	2	61.9	20	58.3	20
		1.6	1.2	60.3	19	58.3	19
		2	0.8	59.5	18	58.3	18
		2.4	0.4	58.7	18	58.3	18
		3	0.8	57.5	17	56.2	17
		3.2	0.6	57.1	17	56.2	17
	40	0.8	2	77.9	20	74.3	20
		1.6	1.2	76.3	19	74.3	19
		2	0.8	75.5	18	74.3	18
		2.4	0.4	74.7	18	74.3	18
		3	0.8	73.5	17	72.2	17
		3.2	0.6	73.1	17	72.2	17
	50	0.8	2	97.5	20	94.1	20
		1.6	1.2	95.9	19	94.1	19
		2	0.8	95.1	18	94.1	18
		2.4	0.4	94.3	18	94.1	18
		3	0.8	93.1	17	92.1	17
		3.2	0.6	92.7	17	92.1	17
	63	0.8	2	123.5	20	120.1	19
		1.6	1.2	121.9	19	120.1	19
		2	0.8	121.1	18	120.1	18
		2.4	0.4	120.3	18	120.1	18
		3	0.8	119.1	17	118	16
		3.2	0.6	118.7	17	118	16
	80	0.8	2	157.5	19	154.1	18
		1.6	1.2	155.9	19	154.1	18
		2	0.8	155.1	18	154.1	18
		2.4	0.4	154.3	18	154.1	18
		3	0.8	153.1	16	152	16
		3.2	0.6	152.7	16	152	16
	100	0.8	2	197.5	18	194.1	18
		1.6	1.2	195.9	18	194.1	18
		2	0.8	195.1	18	194.1	18
		2.4	0.4	194.3	18	194.1	18
		3	0.8	193.1	15	192	15
		3.2	0.6	192.7	15	192	15
	125	0.8	2	247.5	18	244.1	17
		1.6	1.2	245.9	17	244.1	17
		2	0.8	245.1	17	244.1	17
		2.4	0.4	244.3	17	244.1	17
		3	0.8	243.1	15	242	15
		3.2	0.6	242.7	15	242	15
B type	32	4	0.9	55.5	16	54	16
		5	0.4	53.5	15	53.1	15
	40	4	0.9	71.5	16	70	16
		5	0.4	69.5	15	69	14
	50	4	0.9	91.1	15	89.8	15
		5	0.4	89.1	14	88.9	14
	63	4	0.9	117.1	14	115.8	14
		5	0.4	115.1	13	114.9	13
	80	4	0.9	151.1	14	149.8	13
		5	0.4	149.1	12	148.9	12
	100	4	0.9	191.1	13	189.8	13
		5	0.4	189.1	12	188.8	12
	125	4	0.9	241.1	13	239.8	13
		5	0.4	239.1	12	238.8	12

Note 1) The recommended ramping feed is 0.05mm/t. or under.

*1 L (Max. Depth of Cut =15 / tan α). Cutters' moving distance until depth of cut reaches APMX at a maximum ramping angle. Maximum depth of cut A type is 21mm, B type is 20.4mm.

*2 The maximum diameter when machining a blind hole with a flat face using a corner radius of 0.8mm for A type and 4mm for B type.Other than that, find with the below formula. {(cutting edge diameter DC)−(corner radius)−0.3}×2

*3 The minimum diameter when machining a blind hole with a flat face using a corner radius of 0.8mm for A type and 4mm for B type.Other than that, find with the below formula. {(cutting edge diameter DC)−(corner radius)−(Width of wiper edge BS)−0.1}×2

MULTI FUNCTIONAL MILLING

<ALUMINIUM ALLOY TO DIFFICULT-TO-CUT MATERIAL CUTTING>

TOOL NEWS

90° KAPR

BXD4000

P	M	K	N	S	H
Steel	Stainless Steel		Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

- Curved cutting edge and high rigidity holder produce high wall accuracy.
- Low resistance insert and high rigidity design for excellent performance.
- With through coolant holes to ensure smooth chip discharge.
- For high-speed machining.

Fig.1 ø40

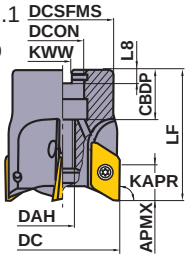


Fig.2 ø50 ø63 ø80 ø100

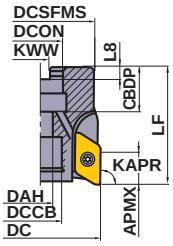
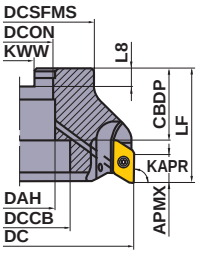
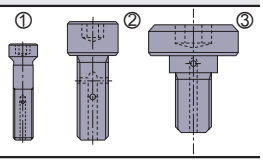


Fig.3 ø125



Right hand tool holder only.

Cutter Diameter DC	Set Bolt	Geometry
ϕ40	HFF08043H	①
ϕ50, ϕ63	HSC10030H	②
ϕ80	HSC12035H	②
ϕ100	HSC16040H	②
ϕ125	MBA20040H	③



● The set bolts in the right table are supplied with respective cutter.

■ ARBOR TYPE

KAPR :90°
GAMP:+14°—+15° GAMF:+13°—+16°

Type	Insert Radius RE	Order Number	Stock R	Number of Teeth	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	DCCB	WT*3 (kg)	APMX (mm)	RMPX*2	Max. Allowable Revolution (min⁻¹)	Fig.	*1 Clamp Screw	Wrench	Insert
A type	0.4 — 3.2	BXD4000-040A03RA	●	3	40	50	16	18	8.5	32	8.4	5.6	—	0.3	15	9°	29000	1	TS4SL	TKY15W	XDGT1550 PD○R-G○○
		BXD4000-050A04RA	●	4	50	50	22	20	11	41	10.4	6.3	17	0.4	15	6°	24000	2	TS4SL	TKY15W	
		BXD4000-063A05RA	●	5	63	50	22	20	11	50	10.4	6.3	17	0.7	15	5°	21000	2	TS4SL	TKY15W	
		BXD4000R08005CA	●	5	80	50	25.4	26	13	60	9.5	6	20	1.1	15	3°	19000	2	TS4SL	TKY15W	XDGT1550 PD○R-GL○○
		BXD4000R10006DA	●	6	100	63	31.75	32	17	70	12.7	8	26	2.0	15	3°	16000	2	TS4SL	TKY15W	
		BXD4000R12507EA	●	7	125	63	38.1	40	42	80	15.9	10	56	2.8	15	2°	14000	3	TS4SL	TKY15W	
B type	4.0 — 5.0	BXD4000-040A03RB	●	3	40	50	16	18	8.5	32	8.4	5.6	—	0.3	15	9°	29000	1	TS4SL	TKY15W	XDGT1550 PD○R-G○○
		BXD4000-050A04RB	●	4	50	50	22	20	11	41	10.4	6.3	17	0.4	15	6°	24000	2	TS4SL	TKY15W	
		BXD4000-063A05RB	●	5	63	50	22	20	11	50	10.4	6.3	17	0.7	15	5°	21000	2	TS4SL	TKY15W	
		BXD4000R08005CB	●	5	80	50	25.4	26	13	60	9.5	6	20	1.1	15	3°	19000	2	TS4SL	TKY15W	
		BXD4000R10006DB	●	6	100	63	31.75	32	17	70	12.7	8	26	2.0	15	3°	16000	2	TS4SL	TKY15W	
		BXD4000R12507EB	●	7	125	63	38.1	40	42	80	15.9	10	56	2.8	15	2°	14000	3	TS4SL	TKY15W	

Note 1) The maximum allowable revolutions are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.
*1 Clamp Torque (N • m) : TS4SL=4.0
*2 RMPX : Max. Ramping Angle
*3 WT : Tool Weight

● : Inventory maintained in Japan.

Fig.1 ø40

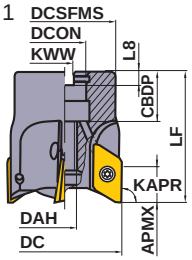


Fig.2 ø50 ø63 ø80 ø100

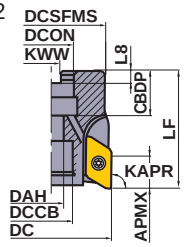
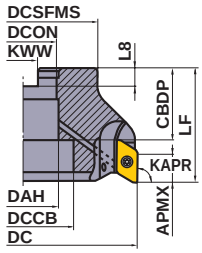
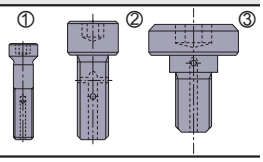


Fig.3 ø125



Right hand tool holder only.

Cutter Diameter DC	Set Bolt	Geometry
ϕ40	HFF08043H	①
ϕ50, ϕ63	HSC10030H	②
ϕ80	HSC12035H	②
ϕ100	HSC16040H	②
ϕ125	MBA20040H	③



For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

■ARBOR TYPE

KAPR :90°
GAMP:+14°−+15° GAMF:+13°−+16°

Type	Insert Radius RE	Order Number	Stock R	Number of Teeth	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	DCCB	WT*3 (kg)	APMX (mm)	RMPX*2	Max. Allowable Revolution (min-1)	Fig.	Clamp Screw (*1)	Wrench	Insert
A type	0.4 – 3.2	BXD4000-040A03RA	●	3	40	50	16	18	8.5	32	8.4	5.6	—	0.3	15	9°	29000	1	TS4SL	TKY15W	XDGT1550 PD○R-G○○
		BXD4000-050A04RA	●	4	50	50	22	20	11	41	10.4	6.3	17	0.4	15	6°	24000	2	TS4SL	TKY15W	
		BXD4000-063A05RA	●	5	63	50	22	20	11	50	10.4	6.3	17	0.7	15	5°	21000	2	TS4SL	TKY15W	
		BXD4000-080A05RA	●	5	80	50	27	23	13	60	12.4	7	20	1.1	15	3°	19000	2	TS4SL	TKY15W	
		BXD4000-100A06RA	●	6	100	63	32	26	17	70	14.4	8	26	2.0	15	3°	16000	2	TS4SL	TKY15W	
		BXD4000-125B07RA	●	7	125	63	40	40	42	80	16.4	9	56	2.8	15	2°	14000	3	TS4SL	TKY15W	
B type	4.0 – 5.0	BXD4000-040A03RB	●	3	40	50	16	18	8.5	32	8.4	5.6	—	0.3	15	9°	29000	1	TS4SL	TKY15W	XDGT1550 PD○R-G○○
		BXD4000-050A04RB	●	4	50	50	22	20	11	41	10.4	6.3	17	0.4	15	6°	24000	2	TS4SL	TKY15W	
		BXD4000-063A05RB	●	5	63	50	22	20	11	50	10.4	6.3	17	0.7	15	5°	21000	2	TS4SL	TKY15W	
		BXD4000-080A05RB	●	5	80	50	27	23	13	60	12.4	7	20	1.1	15	3°	19000	2	TS4SL	TKY15W	
		BXD4000-100A06RB	●	6	100	63	32	26	17	70	14.4	8	26	2.0	15	3°	16000	2	TS4SL	TKY15W	
		BXD4000-125B07RB	●	7	125	63	40	40	42	80	16.4	9	56	2.8	15	2°	14000	3	TS4SL	TKY15W	

Note 1) The maximum allowable revolutions are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.
*1 Clamp Torque (N • m) : TS4SL=4.0 *2 RMPX : Max. Ramping Angle *3 WT : Tool Weight

■CAUTION FOR USE

- Only use the inserts and parts provided by Mitsubishi Materials with this tool. Use of the correct insert clamp screws is especially important to ensure overall tool safety. Do not use damaged or worn clamp screws.
- The maximum allowable spindle speeds are shown in Table 1. Ensure that the cutter operates under the maximum allowable spindle speed. The maximum allowable spindle speeds for safety purposes are determined in accordance with ISO15641 (Milling Cutters for high speed machining–Safety requirements).

Table 1 Max. Allowable Revolution

Cutting Edge Diameter DC(mm)	ø20	ø25	ø28	ø32	ø35	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min-1)	15000*	38000	35000	33000	31000	29000	24000	21000	19000	16000	14000

* ϕ20mm with one tooth balancing is necessary to adjust sensitively.

- Even when operating under the maximum allowable spindle speed, if the spindle speed is equal to or higher than the values shown in table 2, it is recommended that the balance quality (with the arbor or milling chuck) conforms to G40 or betterbased on ISO1940. It is also recommended to replace the clamp screws with new ones when changing inserts. Furthermore,ensure to use machines that are provided with safety measures in case of cutter breakage.

Table 2 Maximum spindle speed when balancing with the arbor or milling chuck has not been achieved

Cutting Edge Diameter DC(mm)	ø20	ø25	ø28	ø32	ø35	ø40	ø50	ø63	ø80	ø100	ø125
Max. Allowable Revolution (min-1)	15000	12000	10800	9500	8700	7600	6000	4800	3800	3000	2400

- When setting the spindle speed, take into consideration the maximum allowable spindle speed of the arbor or milling chuck.
- Use the specified set bolt when using the arbor type with through coolant.
- The inserts have sharp cutting edges and handling them with bare hands may cause injuries.
  Always wear safety gloves when handling the indexable inserts.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Fig.1 Straight Shank

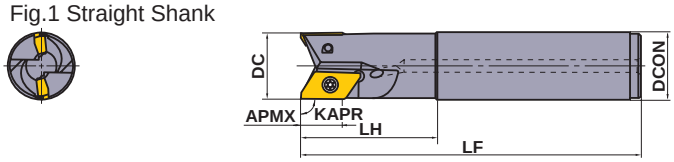
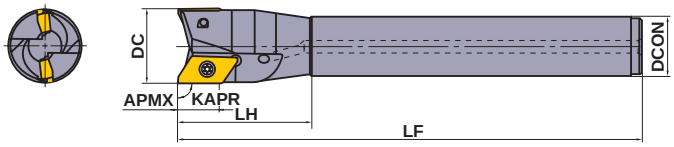


Fig.2 Offset Shank



■SHANK TYPE

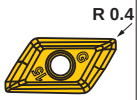
KAPR :90°

Right hand tool holder only.

Type	Insert Radius RE	Shank Type	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	APMX	LF	LH	DCON	⋆2 RMPX	Max. Allowable Revolution (min^{-1})	Fig.	⋆1 Clamp Screw	Wrench	Insert
Type A	0.4 – 3.2	Standard	**BXD4000R201SA20SA**	●	1	20	15	110	35	20	28°	15000	1	TS4SL	TKY15W	XDGT1550 PD◌R-G◌◌ / XDGT1550 PD◌R-GL◌◌
			BXD4000R252SA25SA	●	2	25	15	125	50	25	20°	38000	1	TS4SL	TKY15W	
			BXD4000R282SA25SA	●	2	28	15	125	50	25	17°	35000	2	TS4SL	TKY15W	
			BXD4000R322SA32SA	●	2	32	15	150	50	32	13°	33000	1	TS4SL	TKY15W	
			BXD4000R352SA32SA	●	2	35	15	150	50	32	11°	31000	2	TS4SL	TKY15W	
			BXD4000R403SA32SA	●	3	40	15	170	80	32	9°	29000	2	TS4SL	TKY15W	
			BXD4000R403SA42SA	●	3	40	15	170	80	42	9°	29000	1	TS4SL	TKY15W	
		Long	**BXD4000R252SA25LA**	●	2	25	15	170	80	25	20°	38000	1	TS4SL	TKY15W	
			BXD4000R322SA32LA	●	2	32	15	200	80	32	13°	33000	1	TS4SL	TKY15W	
		Extra Long	**BXD4000R282SA25ELA**	●	2	28	15	220	50	25	17°	35000	2	TS4SL	TKY15W	
			BXD4000R352SA32ELA	●	2	35	15	250	50	32	11°	31000	2	TS4SL	TKY15W	
			BXD4000R403SA32ELA	●	3	40	15	250	65	32	9°	29000	2	TS4SL	TKY15W	
Type B	4.0 – 5.0	Standard	**BXD4000R201SA20SB**	●	1	20	15	110	35	20	28°	15000	1	TS4SL	TKY15W	XDGT1550 PD◌R-G◌◌
			BXD4000R252SA25SB	●	2	25	15	125	50	25	20°	38000	1	TS4SL	TKY15W	
			BXD4000R282SA25SB	●	2	28	15	125	50	25	17°	35000	2	TS4SL	TKY15W	
			BXD4000R322SA32SB	●	2	32	15	150	50	32	13°	33000	1	TS4SL	TKY15W	
			BXD4000R352SA32SB	●	2	35	15	150	50	32	11°	31000	2	TS4SL	TKY15W	
			BXD4000R403SA32SB	●	3	40	15	170	80	32	9°	29000	2	TS4SL	TKY15W	
			BXD4000R403SA42SB	●	3	40	15	170	80	42	9°	29000	1	TS4SL	TKY15W	
		Long	**BXD4000R252SA25LB**	●	2	25	15	170	80	25	20°	38000	1	TS4SL	TKY15W	
			BXD4000R322SA32LB	●	2	32	15	200	80	32	13°	33000	1	TS4SL	TKY15W	
		Extra Long	**BXD4000R282SA25ELB**	●	2	28	15	220	50	25	17°	35000	2	TS4SL	TKY15W	
			BXD4000R352SA32ELB	●	2	35	15	250	50	32	11°	31000	2	TS4SL	TKY15W	
			BXD4000R403SA32ELB	●	3	40	15	250	65	32	9°	29000	2	TS4SL	TKY15W	

Note 1) The maximum allowed revolutions are set to ensure tool and insert stability.
Note 2) When using the tool at high revolutions, ensure that the tool and arbor are correctly balanced.
⋆1 Clamp Torque (N • m) : TS4SL=4.0 ⋆2 RMPX : Max. Ramping Angle

■HOLDER AND INSERT CORNER RADIUS COMBINATION

Holder	A Holder							B Holder	
	BXD4000R◌◌◌◌◌◌◌◌A							BXD4000R◌◌◌◌◌◌◌◌B	
Insert Corner Radius (RE)	R 0.4	R 0.8	R 1.2	R 1.6	R 2.0	R 3.0	R 3.2	R 4.0	R 5.0
									
	XDGT.....-G04 XDGT.....-GL04	XDGT.....-G08 XDGT.....-GL08	XDGT.....-G12	XDGT.....-G16	XDGT.....-G20	XDGT.....-G30	XDGT.....-G32	XDGT.....-G40	XDGT.....-G50

Note 1) Please only use the holder and insert corner radius combinations shown above.
Note 2) XDGT....-GL08 and -G12 inserts are compatible only with the BXD4000R◌◌◌◌◌◌◌◌A type holder.

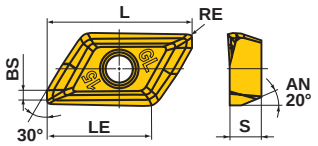
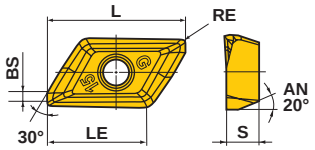
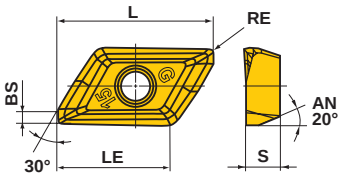
● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material			VP15TF	LC15TF			TF15	
	P	Steel	◐					
	M	Stainless Steel	◔					
	K	Cast Iron	✣					
	N	Non-ferrous Metal		◐			✣	
	S	Heat-resistant Alloy, Titanium Alloy	◐					
	H	Hardened Steel	◔					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	Stock: Coated VP15TF	Coated LC15TF	Coated	Coated	Carbide TF15	Carbide	L	LE	S	BS	RE	Geometry
Low Resistance Type	**XDGT1550PDFR-GL04**	G	F					●		22	15.5	5	1.5	0.4	
	XDGT1550PDFR-GL08	G	F					●		22	15.5	5	1.1	0.8	
	XDGT1550PDFR-G04	G	F		●			●		22	15.5	5	1.5	0.4	
	XDGT1550PDFR-G08	G	F		●			●		22	15.5	5	1.1	0.8	
	XDGT1550PDFR-G12	G	F		●			●		22	15.5	5	0.7	1.2	
	XDGT1550PDFR-G16	G	F		●			●		22	15.6	5	0.4	1.6	
	XDGT1550PDFR-G20	G	F		●			●		21.7	15.6	5	0.2	2.0	
	XDGT1550PDFR-G30	G	F		●			●		20	14.8	5	0.6	3.0	
	XDGT1550PDFR-G32	G	F		●			●		20	14.8	5	0.4	3.2	
	XDGT1550PDFR-G40	G	F		●			●		19	14.4	5	0.5	4.0	
	XDGT1550PDFR-G50	G	F		●			●		18	14	5	0.4	5.0	
	XDGT1550PDER-G04	G	E	●						22	15.5	5	1.5	0.4	
	XDGT1550PDER-G08	G	E	●						22	15.5	5	1.1	0.8	
	XDGT1550PDER-G12	G	E	●						22	15.5	5	0.7	1.2	
	XDGT1550PDER-G16	G	E	●						22	15.6	5	0.4	1.6	
	XDGT1550PDER-G20	G	E	●						21.7	15.6	5	0.2	2.0	
	XDGT1550PDER-G30	G	E	●						20	14.8	5	0.6	3.0	
	XDGT1550PDER-G32	G	E	●						20	14.8	5	0.4	3.2	
	XDGT1550PDER-G40	G	E	●						19	14.4	5	0.5	4.0	
	XDGT1550PDER-G50	G	E	●						18	14	5	0.4	5.0	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**VP15TF**	180 (150—200)	0.15 (0.1—0.2)
P	Carbon Steel Alloy Steel	≤280HB	**VP15TF**	150 (120—200)	0.15 (0.1—0.2)
P	Carbon Steel Alloy Steel	280—350HB	**VP15TF**	140 (120—160)	0.15 (0.1—0.2)
M	Stainless Steel	≤270HB	**VP15TF**	140 (120—160)	0.2 (0.1—0.3)
N	Aluminium Alloy	—	**LC15TF TF15**	1000 (200—3000)	0.3 (0.1—0.5)
S	Ti Alloy	—	**VP15TF**	40 (30—60)	0.1 (0.1—0.3)
S	Heat Resistance Alloy (Inconel etc.)	—	**VP15TF**	30 (20—40)	0.15 (0.1—0.2)
H	Hardened Steel	40—60HRC	**VP15TF**	70 (50—100)	0.1 (0.05—0.15)

●Figures above are a guide lines for optimum general use. They may vary depending on machine rigidity, work clamping and length of tool overhang.
●When using ϕ20 shank type, set the table feed at under 0.05mm/t. and maintain observation during cutting.
●Please adjust the table feed when using long- and extra-long-shank types.
●Please adjust the table feed when ramping (Recommended feed:0.05 mm/t. under).

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

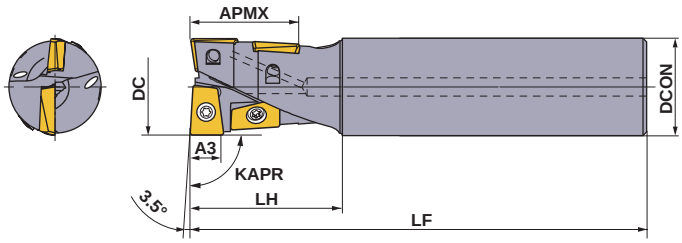
MULTI FUNCTIONAL MILLING

TOOL NEWS

90° KAPR

AQX

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel



- **The center bottom cutting edge enables drilling without previously formed hole.**
- **With through coolant holes.**

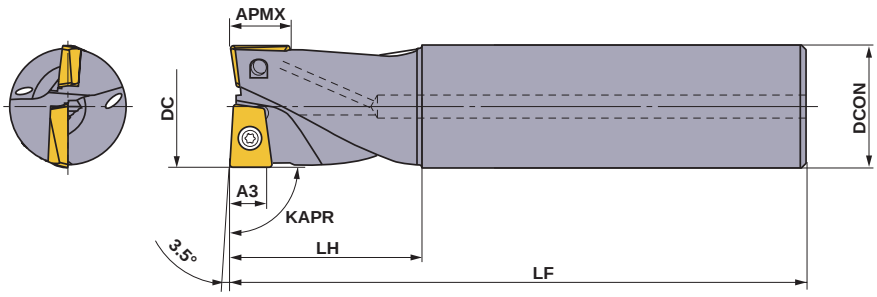
STANDARD EDGE TYPE KAPR :90°

Right hand tool holder only.

Type	Order Number	Stock R	Coolant Hole	DC	LF	DCON	LH	A3 *1	APMX *2 (mm)	Clamp Screw *3	Wrench	Insert
Standard	AQXR164SA16S	●	○	16	120	16	30	4.5	17.6	TS2A	①TKY06F	QOG/MT0830R-G1/M2
	AQXR164SN16S	●	–	16	120	16	30	4.5	17.6	TS2A	①TKY06F	
	AQXR174SA16S	●	○	17	120	16	30	4.5	17.6	TS2A	①TKY06F	
	AQXR174SN16S	●	–	17	120	16	30	4.5	17.6	TS2A	①TKY06F	
	AQXR204SA20S	●	○	20	130	20	35	6	22	TS25	①TKY08F	QOG/MT1035R-G1/M2
	AQXR204SN20S	●	–	20	130	20	35	6	22	TS25	①TKY08F	
	AQXR214SA20S	●	○	21	130	20	35	6	22	TS25	①TKY08F	
	AQXR214SN20S	●	–	21	130	20	35	6	22	TS25	①TKY08F	
	AQXR254SA25S	●	○	25	140	25	40	7.5	27.5	TS33	②TKY08D	QOG/MT1342R-G1/M2
	AQXR254SN25S	●	–	25	140	25	40	7.5	27.5	TS33	②TKY08D	
	AQXR264SA25S	●	○	26	140	25	40	7.5	27.5	TS33	②TKY08D	
	AQXR264SN25S	●	–	26	140	25	40	7.5	27.5	TS33	②TKY08D	
	AQXR324SA32S	●	○	32	150	32	50	9.5	35.2	TS407	②TKY15D	QOG/MT1651R-G1/M2
	AQXR324SN32S	●	–	32	150	32	50	9.5	35.2	TS407	②TKY15D	
	AQXR334SA32S	●	○	33	150	32	50	9.5	35.2	TS407	②TKY15D	
	AQXR334SN32S	●	–	33	150	32	50	9.5	35.2	TS407	②TKY15D	
	AQXR354SA32S	●	○	35	150	32	50	11	40	TS407	②TKY15D	QOG/MT1856R-G1/M2
	AQXR354SN32S	●	–	35	150	32	50	11	40	TS407	②TKY15D	
	AQXR404SA32S	●	○	40	160	32	60	12	44	TS55	②TKY25D	QOG/MT2062R-G1/M2
	AQXR404SN32S	●	–	40	160	32	60	12	44	TS55	②TKY25D	
	AQXR504SA42S	●	○	50	170	42	70	15	55	TS6S	③TKY30T	QOG/MT2576R-G1/M2
	AQXR504SN42S	●	–	50	170	42	70	15	55	TS6S	③TKY30T	
Long	AQXR164SA16L	●	○	16	175	16	50	4.5	17.6	TS2A	①TKY06F	QOG/MT0830R-G1/M2
	AQXR164SN16L	●	–	16	175	16	50	4.5	17.6	TS2A	①TKY06F	
	AQXR174SA16L	●	○	17	175	16	30	4.5	17.6	TS2A	①TKY06F	
	AQXR174SN16L	●	–	17	175	16	30	4.5	17.6	TS2A	①TKY06F	
	AQXR204SA20L	●	○	20	185	20	60	6	22	TS25	①TKY08F	QOG/MT1035R-G1/M2
	AQXR204SN20L	●	–	20	185	20	60	6	22	TS25	①TKY08F	
	AQXR214SA20L	●	○	21	185	20	35	6	22	TS25	①TKY08F	
	AQXR214SN20L	●	–	21	185	20	35	6	22	TS25	①TKY08F	
	AQXR254SA25L	●	○	25	220	25	75	7.5	27.5	TS33	②TKY08D	QOG/MT1342R-G1/M2
	AQXR254SN25L	●	–	25	220	25	75	7.5	27.5	TS33	②TKY08D	
	AQXR264SA25L	●	○	26	220	25	40	7.5	27.5	TS33	②TKY08D	
	AQXR264SN25L	●	–	26	220	25	40	7.5	27.5	TS33	②TKY08D	
	AQXR324SA32L	●	○	32	230	32	90	9.5	35.2	TS407	②TKY15D	QOG/MT1651R-G1/M2
	AQXR324SN32L	●	–	32	230	32	90	9.5	35.2	TS407	②TKY15D	
	AQXR334SA32L	●	○	33	230	32	50	9.5	35.2	TS407	②TKY15D	
	AQXR334SN32L	●	–	33	230	32	50	9.5	35.2	TS407	②TKY15D	
	AQXR354SA32L	●	○	35	230	32	50	11	40	TS407	②TKY15D	QOG/MT1856R-G1/M2
	AQXR354SN32L	●	–	35	230	32	50	11	40	TS407	②TKY15D	
	AQXR404SA32L	●	○	40	240	32	60	12	44	TS55	②TKY25D	QOG/MT2062R-G1/M2
	AQXR404SN32L	●	–	40	240	32	60	12	44	TS55	②TKY25D	
	AQXR504SA42L	●	○	50	250	42	70	15	55	TS6S	③TKY30T	QOG/MT2576R-G1/M2
	AQXR504SN42L	●	–	50	250	42	70	15	55	TS6S	③TKY30T	

*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts. *2 APMX : Maximum depth of cut.
*3 Clamp Torque (N • m) : TS2A=0.6, TS25=1.0, TS33=1.0, TS407=3.5, TS55=7.5, TS6S=10.0

● : Inventory maintained in Japan.



■SHORT EDGE TYPE

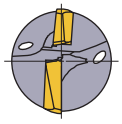
Number of Teeth : **2**
KAPR : 90°

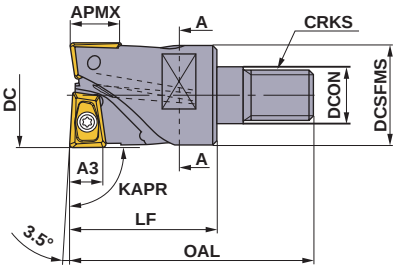
Right hand tool holder only.

Type	Order Number	Stock R	Coolant Hole	Dimensions (mm) DC	LF	DCON	LH	A3 *1	APMX *2 (mm)	*3 Clamp Screw	① ② ③ Wrench	Insert
Standard	**AQXR162SA16S**	●	○	16	120	16	30	4.5	7.4	TS2A	①TKY06F	QOG/MT0830R-G1/M2
	AQXR162SN16S	●	–	16	120	16	30	4.5	7.4	TS2A	①TKY06F	
	AQXR172SA16S	●	○	17	120	16	30	4.5	7.4	TS2A	①TKY06F	
	AQXR172SN16S	●	–	17	120	16	30	4.5	7.4	TS2A	①TKY06F	
	AQXR202SA20S	●	○	20	130	20	35	6	9.2	TS25	①TKY08F	QOG/MT1035R-G1/M2
	AQXR202SN20S	●	–	20	130	20	35	6	9.2	TS25	①TKY08F	
	AQXR212SA20S	●	○	21	130	20	35	6	9.2	TS25	①TKY08F	
	AQXR212SN20S	●	–	21	130	20	35	6	9.2	TS25	①TKY08F	
	AQXR252SA25S	●	○	25	140	25	40	7.5	11.5	TS33	②TKY08D	QOG/MT1342R-G1/M2
	AQXR252SN25S	●	–	25	140	25	40	7.5	11.5	TS33	②TKY08D	
	AQXR262SA25S	●	○	26	140	25	40	7.5	11.5	TS33	②TKY08D	
	AQXR262SN25S	●	–	26	140	25	40	7.5	11.5	TS33	②TKY08D	
	AQXR322SA32S	●	○	32	150	32	50	9.5	14.5	TS407	②TKY15D	QOG/MT1651R-G1/M2
	AQXR322SN32S	●	–	32	150	32	50	9.5	14.5	TS407	②TKY15D	
	AQXR332SA32S	●	○	33	150	32	50	9.5	14.5	TS407	②TKY15D	
	AQXR332SN32S	●	–	33	150	32	50	9.5	14.5	TS407	②TKY15D	
	AQXR352SA32S	●	○	35	150	32	50	11	16	TS407	②TKY15D	QOG/MT1856R-G1/M2
	AQXR352SN32S	●	–	35	150	32	50	11	16	TS407	②TKY15D	
	AQXR402SA32S	●	○	40	160	32	60	12	18	TS55	②TKY25D	QOG/MT2062R-G1/M2
	AQXR402SN32S	●	–	40	160	32	60	12	18	TS55	②TKY25D	
	AQXR502SA42S	●	○	50	170	42	70	15	23	TS6S	③TKY30T	QOG/MT2576R-G1/M2
	AQXR502SN42S	●	–	50	170	42	70	15	23	TS6S	③TKY30T	
Long	**AQXR162SA16L**	●	○	16	175	16	50	4.5	7.4	TS2A	①TKY06F	QOG/MT0830R-G1/M2
	AQXR162SN16L	●	–	16	175	16	50	4.5	7.4	TS2A	①TKY06F	
	AQXR172SA16L	●	○	17	175	16	30	4.5	7.4	TS2A	①TKY06F	
	AQXR172SN16L	●	–	17	175	16	30	4.5	7.4	TS2A	①TKY06F	
	AQXR202SA20L	●	○	20	185	20	60	6	9.2	TS25	①TKY08F	QOG/MT1035R-G1/M2
	AQXR202SN20L	●	–	20	185	20	60	6	9.2	TS25	①TKY08F	
	AQXR212SA20L	●	○	21	185	20	35	6	9.2	TS25	①TKY08F	
	AQXR212SN20L	●	–	21	185	20	35	6	9.2	TS25	①TKY08F	
	AQXR252SA25L	●	○	25	220	25	75	7.5	11.5	TS33	②TKY08D	QOG/MT1342R-G1/M2
	AQXR252SN25L	●	–	25	220	25	75	7.5	11.5	TS33	②TKY08D	
	AQXR262SA25L	●	○	26	220	25	40	7.5	11.5	TS33	②TKY08D	
	AQXR262SN25L	●	–	26	220	25	40	7.5	11.5	TS33	②TKY08D	
	AQXR322SA32L	●	○	32	230	32	90	9.5	14.5	TS407	②TKY15D	QOG/MT1651R-G1/M2
	AQXR322SN32L	●	–	32	230	32	90	9.5	14.5	TS407	②TKY15D	
	AQXR332SA32L	●	○	33	230	32	50	9.5	14.5	TS407	②TKY15D	
	AQXR332SN32L	●	–	33	230	32	50	9.5	14.5	TS407	②TKY15D	
	AQXR352SA32L	●	○	35	230	32	50	11	16	TS407	②TKY15D	QOG/MT1856R-G1/M2
	AQXR352SN32L	●	–	35	230	32	50	11	16	TS407	②TKY15D	
	AQXR402SA32L	●	○	40	240	32	60	12	18	TS55	②TKY25D	QOG/MT2062R-G1/M2
	AQXR402SN32L	●	–	40	240	32	60	12	18	TS55	②TKY25D	
	AQXR502SA42L	●	○	50	250	42	70	15	23	TS6S	③TKY30T	QOG/MT2576R-G1/M2
	AQXR502SN42L	●	–	50	250	42	70	15	23	TS6S	③TKY30T	

*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts.
*2 APMX : Maximum depth of cut.
*3 Clamp Torque (N • m) : TS2A=0.6, TS25=1.0, TS33=1.0, TS407=3.5, TS55=7.5, TS6S=10.0

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001





A-A section

■SCREW-IN TYPE

Number of Teeth : **2**
KAPR : 90°

Right hand tool holder only.

Order Number	Stock	Coolant Hole	Dimensions (mm)								APMX (mm)	WT (kg)	*2 Clamp Screw	① ② Wrench	Insert Type
	R		DC	DCON	DCSFMS	OAL	LF	S10	CRKS	A3 *1					
AQXR162M08A30	●	○	16	8.5	14.7	48	30	10	M8	4.5	7.4	0.1	TS2A	①TKY06F	QO◌T0830R
AQXR172M08A30	●	○	17	8.5	14.5	48	30	10	M8	4.5	7.4	0.1	TS2A	①TKY06F	
AQXR202M10A30	●	○	20	10.5	18.6	49	30	14	M10	6	9.2	0.2	TS25	①TKY08F	QO◌T1035R
AQXR212M10A30	●	○	21	10.5	18.5	49	30	14	M10	6	9.2	0.2	TS25	①TKY08F	
AQXR252M12A35	●	○	25	12.5	23.5	57	35	19	M12	7.5	11.5	0.2	TS33	②TKY08D	QO◌T1342R
AQXR262M12A35	●	○	26	12.5	23.5	57	35	19	M12	7.5	11.5	0.2	TS33	②TKY08D	
AQXR322M16A40	●	○	32	17	28.5	63	40	24	M16	9.5	14.5	0.3	TS407	②TKY15D	QO◌T1651R
AQXR332M16A40	●	○	33	17	28.5	63	40	24	M16	9.5	14.5	0.3	TS407	②TKY15D	
AQXR352M16A40	●	○	35	17	28.5	63	40	24	M16	11	16	0.3	TS407	②TKY15D	QO◌T1856R
AQXR402M16A45	●	○	40	17	28.5	68	45	24	M16	12	18	0.3	TS55	②TKY25D	QO◌T2062R

*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts.
*2 Clamp Torque (N • m) : TS2A=0.5, TS25=1.0, TS33=1.5, TS407=3.5, TS55=7.5
Note 1) For screw-in type arbors, refer to page M269.

● : **Inventory maintained in Japan. (10 inserts in one case)**

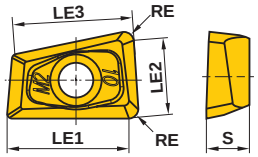
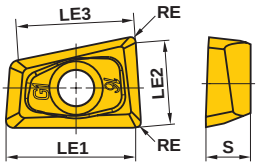
ARBORS	**➢ M269**
SPARE PARTS	**➢ Q001**
TECHNICAL DATA	**➢ R001**

INSERTS

Work Material		MP6120	MP6130	MP7130	MP7140	MP9120	VP15TF	VP30RT	HTi10
P	Steel	●	◐				◐	✠	
M	Stainless Steel			◐	✠		◐	✠	
K	Cast Iron						✠	✠	◐
N	Non-ferrous Metal								◐
S	Heat-resistant Alloy, Titanium Alloy					◐	◐	✠	
H	Hardened Materials						◐		

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Honing:
E: Round F: Sharp

Shape	Order Number	DC	Class	Honing	Coated MP6120	MP6130	MP7130	MP7140	MP9120	VP15TF	VP30RT	Carbide HTi10			Dimensions (mm) LE1	LE2	LE3	S	RE	Geometry
	QOMT0830R-M2	ϕ16,17	M	E	●	●	●	●	●	●	●				7.3	4.4	7.3	3	0.8	
	QOMT1035R-M2	ϕ20,21	M	E	●	●	●	●	●	●	●				9.5	5.9	9.3	3.5	0.8	
	QOMT1342R-M2	ϕ25,26	M	E	●	●	●	●	●	●	●				12	7.6	11.6	4.2	0.8	
	QOMT1651R-M2	ϕ32,33	M	E	●	●	●	●	●	●	●				15.4	9.9	14.6	5.1	0.8	
	QOMT1856R-M2	ϕ35	M	E	●	●	●	●	●	●	●				16.9	10.9	16	5.6	0.8	
	QOMT2062R-M2	ϕ40	M	E	●	●	●	●	●	●	●				19.4	12.6	18.1	6.2	0.8	
	QOMT2576R-M2	ϕ50	M	E	●	●	●	●	●	●	●				24.8	16.1	23.1	7.6	0.8	
	QOGT0830R-G1	ϕ16,17	G	E*	●				●	●		●			7.7	4.9	7.3	3	0.4	
	QOGT1035R-G1	ϕ20,21	G	E*	●				●	●		●			9.9	6.4	9.3	3.5	0.4	
	QOGT1342R-G1	ϕ25,26	G	E*	●				●	●		●			12.4	8.1	11.6	4.2	0.4	
	QOGT1651R-G1	ϕ32,33	G	E*	●				●	●		●			15.8	10.4	14.6	5.1	0.4	
	QOGT1856R-G1	ϕ35	G	E*	●				●	●		●			17.3	11.4	16	5.6	0.4	
	QOGT2062R-G1	ϕ40	G	E*	●				●	●		●			19.8	13.1	18.1	6.2	0.4	
	QOGT2576R-G1	ϕ50	G	E*	●				●	●		●			25.2	16.6	23.1	7.6	0.4	

* HTi10 insert honing is "F" type.

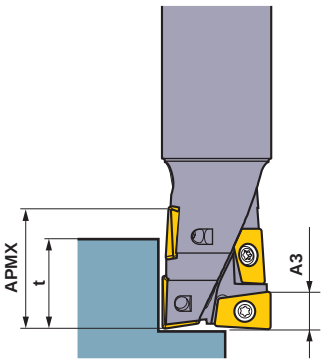
RECOMMENDED CUTTING CONDITIONS

■ CUTTING SPEED

Work Material	No.	Hardness	Breaker	Cutting Speed for Different Grades vc (m/min)		
P				**MP6120**	**VP15TF**	**MP6130**
Mild Steel (ASTM A36, AISI 1010 etc.)	1	≤180HB	M2	200 (170–240)	180 (150–220)	160 (130–200)
Carbon Steel, Alloy Steel (AISI 1045, AISI 4140 etc.)	2	180–350HB	M2	180 (140–220)	160 (120–200)	140 (100–180)
M				**MP7130**	**MP7140**	**VP30RT(VP15TF)**
Austenitic Stainless Steel (AISI 304, AISI 316 etc.)	1	≤200HB	M2	170 (120–200)	160 (100–180)	150 (120–180)
Austenitic Stainless Steel (AISI 304LN, AISI 316LN etc.)	2	>200HB	M2			
Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430 etc.)	3	≤200HB	M2			
Ferritic and Martensitic Stainless Steel (AISI 431, AISI 420 etc.)	4	>200HB	M2			
K				**VP15TF**		
Gray Cast Iron (AISI No45B etc.)	1	≤350MPa	M2	180 (150–220)	–	–
Ductile Cast Iron (FCD450 etc.)	2	≤450MPa	M2	180 (150–220)	–	–
N				**HTi10**		
Aluminium Alloy (A6061, A7075 etc.)	1	Si<5%	G1	500 (200–800)	–	–
Aluminium Alloy (AC4B etc.)	2	5%≤Si≤10%	G1	100 (50–300)	–	–
Aluminium Alloy (ADC12, A390 etc.)	3	Si>5%	G1	100 (50–300)	–	–
S				**MP9120**		
Titanium Alloy* (Ti-6Al-4V etc.)	1	–	M2	50 (30–70)	–	–
H				**VP15TF**		
Hardened Steel (AISI H13, AISI L6 etc.)	1	40–55HRC	M2	80 (50–120)	–	–

* Wet cutting is recommended for Titanium alloy.

RECOMMENDED CUTTING CONDITIONS

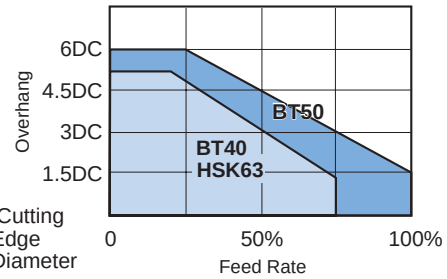


- A3 is the depth of cut for the full dual insert portion at the end of the cutting edge.
- Beyond the range of A3 where overlapping occurs, there is an area where the cutting edge becomes a single insert, not forming full dual insert configuration. As such, please pay special attention to the relationship between depth of cut and feed.
- In general, the edge at the border of cut tends to suffer from damages. At large depth of cut operations, applying the following depth of cut (**t**), at which the edge is full dual insert at the border of cut, is recommended to prevent damage to the cutting edge.

(mm)

Tool diameter	Recommended depth of cut t (mm)
ϕ16,17	12 – 14
ϕ20,21	14 – 17
ϕ25,26	17 – 22
ϕ32,33	22 – 28
ϕ35	25 – 32
ϕ40	28 – 35
ϕ50	35 – 45

∗ Figures for A3 and APMX are shown in the standard holder tables on the previous pages.



∗ **DC**=Cutting Edge Diameter

- Chatter vibration and other problems tend to occur at operations where overhang length is large and/or machine rigidity is low, resulting in unstable machining.
- Please reduce feed accordingly, using the above chart as a guideline.

■ CUTTING CONDITIONS FOR SHOULDER MILLING

	Work Material	No.	Hardness	ϕ16, 17			ϕ20, 21			ϕ25, 26		
				ap (mm)	ae (mm)	fr (mm/rev)	ap (mm)	ae (mm)	fr (mm/rev)	ap (mm)	ae (mm)	fr (mm/rev)
P	Mild Steel	1	≤180HB	≤4.5	≤8	0.25	≤6	≤10	0.3	≤7.5	≤12.5	0.35
				4.5–12	≤5	0.16	6–14	≤7	0.25	7.5–17	≤8	0.28
				12–17	≤3	0.1	14–22	≤4	0.18	17–27	≤5	0.2
	Carbon Steel Alloy Steel	2	180–350HB	≤4.5	≤8	0.2	≤6	≤10	0.25	≤7.5	≤12.5	0.3
				4.5–12	≤4	0.14	6–14	≤6	0.2	7.5–17	≤7	0.25
				12–17	≤2	0.08	14–22	≤3	0.16	17–27	≤4	0.18
M	Stainless Steel	1,2,3,4	–	≤4.5	≤8	0.2	≤6	≤10	0.25	≤7.5	≤12.5	0.3
				4.5–12	≤4	0.14	6–14	≤6	0.2	7.5–17	≤7	0.25
				12–17	≤2	0.08	14–22	≤3	0.16	17–27	≤4	0.18
K	Cast Iron	1,2	–	≤4.5	≤8	0.25	≤6	≤10	0.3	≤7.5	≤12.5	0.35
				4.5–12	≤5	0.16	6–14	≤7	0.25	7.5–17	≤8	0.28
				12–17	≤3	0.1	14–22	≤4	0.18	17–27	≤5	0.2
N	Aluminium Alloy	1,2,3	–	≤4.5	≤11	0.3	≤6	≤14	0.35	≤7.5	≤12.5	0.4
				4.5–12	≤8	0.21	6–14	≤10	0.3	7.5–17	≤7	0.33
				12–17	≤5	0.15	14–22	≤6	0.23	17–27	≤4	0.25
S	Titanium Alloy	1	–	≤4.5	≤8	0.14	≤6	≤10	0.18	≤7.5	≤17.5	0.21
				4.5–12	≤4	0.1	6–14	≤6	0.14	7.5–17	≤12.5	0.18
				12–17	≤2	0.06	14–22	≤3	0.11	17–27	≤7.5	0.13
H	Hardened Steel	1	40–55HRC	≤4.5	≤5	0.16	≤6	≤6	0.2	≤7.5	≤7	0.22
				4.5–12	≤3	0.1	6–14	≤4	0.16	7.5–17	≤4	0.18
				12–17	≤1	0.06	14–22	≤2	0.12	17–27	≤2	0.14

	Work Material	No.	Hardness	ϕ32, 33			ϕ35			ϕ40			ϕ50		
				ap (mm)	ae (mm)	fr (mm/rev)	ap (mm)	ae (mm)	fr (mm/rev)	ap (mm)	ae (mm)	fr (mm/rev)	ap (mm)	ae (mm)	fr (mm/rev)
P	Mild Steel	1	≤180HB	≤9.5	≤16	0.4	≤11	≤17.5	0.45	≤12	≤20	0.5	≤15	≤25	0.6
				9.5–22	≤11	0.32	11–25	≤12	0.35	12–28	≤13	0.4	15–35	≤16	0.5
				22–35	≤6	0.25	25–40	≤6.5	0.28	28–44	≤7	0.3	35–55	≤10	0.35
	Carbon Steel Alloy Steel	2	180–350HB	≤9.5	≤16	0.35	≤11	≤17.5	0.37	≤12	≤20	0.4	≤15	≤25	0.5
				9.5–22	≤10	0.28	11–25	≤11	0.3	12–28	≤12	0.32	15–35	≤14	0.4
				22–35	≤5	0.2	25–40	≤5.5	0.22	28–44	≤6	0.25	35–55	≤8	0.3
M	Stainless Steel	1,2,3,4	–	≤9.5	≤16	0.35	≤11	≤17.5	0.37	≤12	≤20	0.4	≤15	≤25	0.5
				9.5–22	≤10	0.28	11–25	≤12	0.3	12–28	≤12	0.32	15–35	≤14	0.4
				22–35	≤5	0.2	25–40	≤6.5	0.22	28–44	≤6	0.25	35–55	≤8	0.3
K	Cast Iron	1,2	–	≤9.5	≤16	0.4	≤11	≤17.5	0.45	≤12	≤20	0.5	≤15	≤25	0.6
				9.5–22	≤11	0.32	11–25	≤12	0.35	12–28	≤13	0.4	15–35	≤16	0.5
				22–35	≤6	0.25	25–40	≤6.5	0.28	28–44	≤7	0.3	35–55	≤10	0.35
N	Aluminium Alloy	1,2,3	–	≤9.5	≤16	0.45	≤11	≤17.5	0.5	≤12	≤20	0.55	≤15	≤25	0.65
				9.5–22	≤10	0.37	11–25	≤12	0.4	12–28	≤12	0.45	15–35	≤14	0.55
				22–35	≤5	0.3	25–40	≤6.5	0.32	28–44	≤6	0.35	35–55	≤8	0.4
S	Titanium Alloy	1	–	≤9.5	≤23	0.25	≤11	≤24.5	0.26	≤12	≤28	0.28	≤15	≤35	0.35
				9.5–22	≤16	0.2	11–25	≤17.5	0.21	12–28	≤20	0.22	15–35	≤25	0.28
				22–35	≤10	0.14	25–40	≤10.5	0.15	28–44	≤12	0.18	35–55	≤15	0.21
H	Hardened Steel	1	40–55HRC	≤9.5	≤8	0.25	≤11	≤9	0.28	≤12	≤10	0.3	≤15	≤14	0.35
				9.5–22	≤5	0.2	11–25	≤5.5	0.22	12–28	≤6	0.24	15–35	≤8	0.3
				22–35	≤2	0.16	25–40	≤2	0.17	28–44	≤2	0.18	35–55	≤4	0.22

Note 1) Please pay special attention on the depth of cut when using the short edge type.
Note 2) When using the G1 breaker (VP15TF), please reduce the feed rate by 20%.
Note 3) For the details of No., Please refer to the cutting speed on page M157.

■ SLOT MILLING

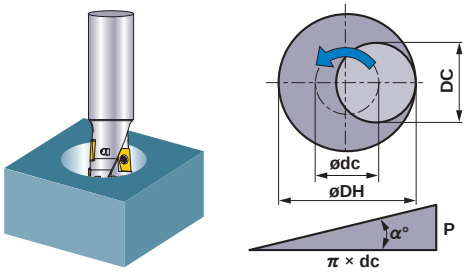
	Work Material	No.	Hardness	ϕ16, 17		ϕ20, 21		ϕ25, 26	
				ap (mm)	fr (mm/rev)	ap (mm)	fr (mm/rev)	ap (mm)	fr (mm/rev)
P	Mild Steel	1	≤180HB	≤4.5	0.16	≤6	0.18	≤7.5	0.2
				4.5−12	0.1	6−14	0.14	7.5−17	0.16
				12−17	0.07	14−22	0.1	17−27	0.12
	Carbon Steel Alloy Steel	2	180−350HB	≤4.5	0.14	≤6	0.16	≤7.5	0.18
				4.5−12	0.09	6−14	0.12	7.5−17	0.14
				12−17	0.05	14−22	0.1	17−27	0.1
M	Stainless Steel	1,2,3,4	–	≤4.5	0.14	≤6	0.16	≤7.5	0.18
				4.5−12	0.09	6−14	0.12	7.5−17	0.14
				12−17	0.05	14−22	0.1	17−27	0.1
K	Gray Cast Iron	1	≤350MPa	≤4.5	0.16	≤6	0.18	≤7.5	0.2
				4.5−12	0.1	6−14	0.14	7.5−17	0.16
				12−17	0.07	14−22	0.1	17−27	0.12
N	Aluminium Alloy	1,2,3	–	≤4.5	0.18	≤6	0.2	≤7.5	0.22
				4.5−12	0.12	6−14	0.16	7.5−17	0.18
				12−17	0.09	14−22	0.12	17−27	0.14
S	Titanium Alloy	1	–	≤4.5	0.1	≤6	0.12	≤7.5	0.15
				4.5−12	0.05	6−14	0.08	7.5−17	0.1
				12−17	0.03	14−22	0.05	17−27	0.08
H	Hardened Steel	1	40−55HRC	≤4.5	0.1	≤6	0.12	≤7.5	0.14
				4.5−12	0.07	6−14	0.1	7.5−17	0.12
				–	–	–	–	–	–

	Work Material	No.	Hardness	ϕ32, 33		ϕ35		ϕ40		ϕ50	
				ap (mm)	fr (mm/rev)	ap (mm)	fr (mm/rev)	ap (mm)	fr (mm/rev)	ap (mm)	fr (mm/rev)
P	Mild Steel	1	≤180HB	≤9.5	0.25	≤11	0.27	≤12	0.3	≤15	0.35
				9.5−22	0.2	11−25	0.22	12−28	0.25	15−35	0.3
				22−35	0.14	25−40	0.16	28−44	0.18	35−55	0.22
	Carbon Steel Alloy Steel	2	180−350HB	≤9.5	0.2	≤11	0.22	≤12	0.25	≤15	0.3
				9.5−22	0.16	11−25	0.18	12−28	0.2	15−35	0.25
				22−35	0.12	25−40	0.13	28−44	0.14	35−55	0.16
M	Stainless Steel	1,2,3,4	–	≤9.5	0.2	≤11	0.22	≤12	0.25	≤15	0.3
				9.5−22	0.16	11−25	0.18	12−28	0.2	15−35	0.25
				22−35	0.12	25−40	0.13	28−44	0.14	35−55	0.16
K	Gray Cast Iron	1	≤350MPa	≤9.5	0.25	≤11	0.27	≤12	0.3	≤15	0.35
				9.5−22	0.2	11−25	0.22	12−28	0.25	15−35	0.3
				22−35	0.14	25−40	0.16	28−44	0.18	35−55	0.22
N	Aluminium Alloy	1,2,3	–	≤9.5	0.27	≤11	0.3	≤12	0.32	≤15	0.37
				9.5−22	0.22	11−25	0.25	12−28	0.27	15−35	0.32
				22−35	0.16	25−40	0.18	28−44	0.2	35−55	0.25
S	Titanium Alloy	1	–	≤9.5	0.18	≤11	0.2	≤12	0.23	≤15	0.25
				9.5−22	0.12	11−25	0.15	12−28	0.2	15−35	0.23
				22−35	0.1	25−40	0.12	28−44	0.15	35−55	0.18
H	Hardened Steel	1	40−55HRC	≤9.5	0.16	≤11	0.17	≤12	0.18	≤15	0.22
				9.5−22	0.12	11−25	0.13	12−28	0.14	15−35	0.16
				–	–	–	–	–	–	–	–

Note 1) Please pay special attention on the depth of cut when using the short edge type.
Note 2) When using the G1 breaker (VP15TF), please reduce the feed rate by 20%.
Note 3) For the details of No., Please refer to the cutting speed on page M157.

RECOMMENDED CUTTING CONDITIONS

■ FOR HELICAL CUTTING



● How to derive a locus of the center of the tool.

Ø dc = Ø DH - DC
Locus of the center of the tool — Desired hole diameter — Cutting edge diameter

● Depth of cut for each pass.

P = π × dc × tan α°
(Note) α°≤ 3°

● Min. machined hole diameter for helical cutting : 1.2DC
Max. machined hole diameter for helical cutting : 1.8DC

● For efficient chip discharge, always apply air blow.

● When using a G1 breaker insert (VP15TF), please reduce the feed rate by 20%.

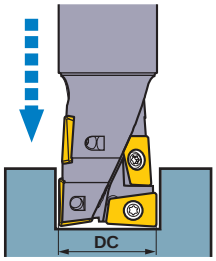
	Work Material	No.	Hardness	ϕ16, 17				ϕ20, 21				ϕ25, 26			
				DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)	DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)	DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)
P	Mild Steel	1	≤180HB	20	8	0.16	0.44	24	10	0.18	0.44	30	12.5	0.2	0.55
				25	12	0.14	0.99	30	15	0.16	1.1	38	19	0.18	1.43
				29	16	0.12	1.43	36	20	0.14	1.76	45	25	0.16	2.2
	Carbon Steel Alloy Steel	2	180−350HB	20	8	0.14	0.33	24	10	0.16	0.33	30	12.5	0.18	0.41
				25	12	0.12	0.74	30	15	0.14	0.82	38	19	0.16	1.07
				29	16	0.1	1.07	36	20	0.12	1.32	45	25	0.14	1.65
M	Stainless Steel	1,2,3,4	–	20	3	0.14	0.22	24	4	0.16	0.22	30	5	0.18	0.27
				25	5	0.12	0.49	30	7	0.14	0.55	38	9	0.16	0.71
				29	8	0.1	0.71	36	10	0.12	0.88	45	12.5	0.14	1.1
K	Gray Cast Iron	1	≤350MPa	20	10	0.16	0.55	24	14	0.18	0.55	30	18	0.2	0.69
				25	13	0.14	1.23	30	17	0.16	1.37	38	21	0.18	1.78
				29	16	0.12	1.78	36	20	0.14	2.19	45	25	0.16	2.74
N	Aluminium Alloy	1,2,3	–	20	10	0.18	0.44	24	14	0.2	0.44	30	18	0.22	0.55
				25	13	0.16	0.99	30	17	0.18	1.1	38	21	0.2	1.43
				29	16	0.14	1.43	36	20	0.16	1.76	45	25	0.18	2.2
S	Titanium Alloy	1	–	20	3	0.1	0.22	24	4	0.11	0.22	30	5	0.13	0.27
				25	5	0.08	0.49	30	7	0.1	0.55	38	9	0.11	0.71
				29	8	0.07	0.71	36	10	0.08	0.88	45	12.5	0.1	1.1
H	Hardened Steel	1	40−55HRC	20	3	0.1	0.22	24	4	0.12	0.22	30	5	0.14	0.27
				25	5	0.08	0.49	30	7	0.1	0.55	38	9	0.12	0.71
				29	8	0.06	0.71	36	10	0.08	0.88	45	12.5	0.1	1.1

	Work Material	No.	Hardness	ϕ32, 33				ϕ35				ϕ40				ϕ50			
				DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)	DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)	DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)	DH (mm)	APMX (mm)	fr (mm/rev)	P (mm/pass)
P	Mild Steel	1	≤180HB	38	16	0.25	0.66	42	18	0.28	0.77	48	20	0.3	0.88	60	25	0.35	1.1
				48	24	0.22	1.76	53	27	0.24	1.97	60	30	0.26	2.19	75	38	0.3	2.74
				58	32	0.2	2.85	63	35	0.21	3.07	72	40	0.22	3.51	90	50	0.26	4.39
	Carbon Steel Alloy Steel	2	180−350HB	38	16	0.2	0.49	42	18	0.22	0.58	48	20	0.25	0.66	60	25	0.28	0.82
				48	24	0.18	1.32	53	27	0.2	1.48	60	30	0.22	1.65	75	38	0.26	2.06
				58	32	0.16	2.14	63	35	0.18	2.3	72	40	0.2	2.63	90	50	0.24	3.29
M	Stainless Steel	1,2,3,4	–	38	6	0.2	0.33	42	7	0.22	0.38	48	8	0.25	0.44	60	10	0.28	0.55
				48	11	0.18	0.88	53	13	0.2	0.99	60	14	0.22	1.1	75	18	0.26	1.37
				58	16	0.16	1.43	63	18	0.18	1.53	72	20	0.2	1.75	90	25	0.27	2.19
K	Gray Cast Iron	1	≤350MPa	38	22	0.25	0.82	42	25	0.28	0.95	48	28	0.3	1.1	60	35	0.35	1.37
				48	27	0.22	2.19	53	30	0.24	2.47	60	34	0.26	2.74	75	43	0.3	3.43
				58	32	0.2	3.57	63	35	0.21	3.84	72	40	0.22	4.39	90	50	0.26	5.49
N	Aluminium Alloy	1,2,3	–	38	22	0.27	0.66	42	25	0.3	0.77	48	28	0.32	0.88	60	35	0.37	1.1
				48	27	0.24	1.76	53	30	0.26	1.97	60	34	0.28	2.19	75	43	0.32	2.74
				58	32	0.22	2.85	63	35	0.21	3.07	72	40	0.24	3.51	90	50	0.27	4.39
S	Titanium Alloy	1	–	38	6	0.14	0.33	42	7	0.15	0.38	48	8	0.18	0.44	60	10	0.2	0.55
				48	11	0.13	0.88	53	13	0.14	0.99	60	14	0.15	1.1	75	18	0.18	1.37
				58	16	0.11	1.43	63	18	0.13	1.53	72	20	0.14	1.75	90	25	0.17	2.19
H	Hardened Steel	1	40−55HRC	38	6	0.16	0.33	42	7	0.17	0.38	48	8	0.18	0.44	60	10	0.2	0.55
				48	11	0.14	0.88	53	13	0.15	0.99	60	14	0.16	1.1	75	18	0.18	1.37
				58	16	0.12	1.43	63	18	0.13	1.53	72	20	0.14	1.75	90	25	0.16	2.19

Note 1) Helical grooving is strongly recommended for machining tempered steel.
Note 2) When using G1 breaker (VP15TF), please reduce the feed rate by 20%.
Note 3) For the details of No., Please refer to the cutting speed on page M157.

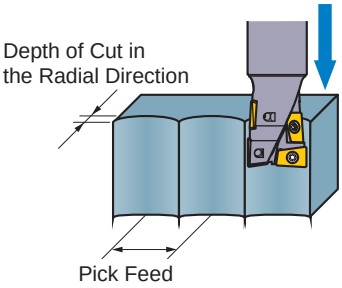
■ FOR DRILLING AND PLUNGING

● Drilling



- The recommended drilling depth is less than 0.5DC.
- Use step feed when drilling (0.25−0.5mm) to ensure that the chips are effectively broken.
- Use internal or external cooling to ensure that the chip disposal is sufficiently achieved.
- The chips generated can dispel in any direction, so ensure that adequate safety precautions are taken.

● Plunging



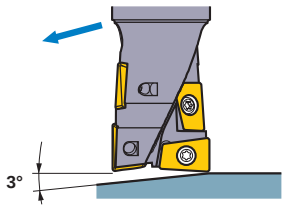
- The feed for plunging is the same as the feed for drilling.
- No step feed necessary.
- Please refer to the following table for the depth of cut at plunging operations.

Depth of Cut in the Radial Direction	≤ 0.4DC
Pick Feed	≤ 0.5DC

	Work Material	No.	Hardness	ϕ16, 17		ϕ20, 21		ϕ25, 26		ϕ32, 33, 35		ϕ40		ϕ50	
				fr (mm/rev)	Step (mm)	fr (mm/rev)	Step (mm)	fr (mm/rev)	Step (mm)	fr (mm/rev)	Step (mm)	fr (mm/rev)	Step (mm)	fr (mm/rev)	Step (mm)
P	Mild Steel	1	≤180HB	0.035	0.2	0.045	0.3	0.05	0.3	0.055	0.3	0.06	0.3	0.065	0.3
P	Carbon Steel Alloy Steel	2	180−350HB	0.03	0.2	0.04	0.3	0.045	0.3	0.05	0.3	0.055	0.3	0.06	0.3
M	Stainless Steel	1,2,3,4	–	0.03	0.15	0.04	0.25	0.045	0.25	0.05	0.25	0.055	0.25	0.06	0.25
K	Gray Cast Iron	1	≤350MPa	0.04	0.4	0.05	0.5	0.06	0.5	0.065	0.5	0.07	0.5	0.075	0.5
N	Aluminium Alloy	1,2,3	–	0.04	0.2	0.05	0.3	0.06	0.3	0.065	0.3	0.07	0.3	0.075	0.3
H	Hardened Steel	1	40−55HRC	0.02	0.15	0.03	0.25	0.035	0.25	0.04	0.25	0.045	0.25	0.05	0.25

Note 1) Helical grooving is strongly recommended for machining tempered steel.
Note 2) When using G1 breaker (VP15TF), please reduce the feed rate by 20%.
Note 3) For the details of No., Please refer to the cutting speed on page M157.

■ FOR RAMPING



- When machining steel the recommended ramping angle is 3°. If a ramping angle larger than 3° is used, then the chips may not be broken effectively resulting in chips wrapping around the tool.
- During ramping, it is recommended to reduce the feed rate by 40% from the cutting conditions.

MULTI FUNCTIONAL MILLING

TOOL NEWS

AJX

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	Hardened Steel

Fig.1

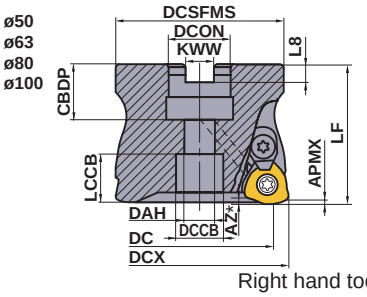
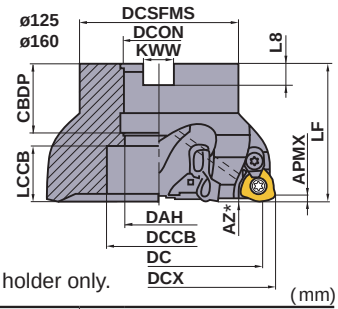


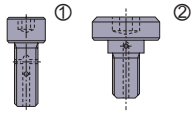
Fig.2



Right hand tool holder only.

(mm)

DCX		Set Bolt	Geometry
DCON inch size	DCON mm size		
ϕ50, ϕ63	ϕ50, ϕ63	HSC10030H	①
	ϕ80	HSC12035H	①
ϕ80, ϕ100	ϕ100	HSC16040H	①
ϕ125	ϕ125, ϕ160	MBA20040H	②
ϕ160		MBA24045H	②



■ARBOR TYPE

With Coolant Hole

AJX09	AJX12	AJX14
GAMP :+8°	GAMP :+8°	GAMP :+8°
GAMF :-6°	GAMF :-5°—-4°	GAMF :-5°—-3°

DCX=mm size, DCON=inch size

(mm)

DCX	Order Number	Stock R	Number of Teeth	DC	LF	DCON	WT (kg)	APMX	RMPX	Fig.	Insert Type
50	**AJX12R05003B**	●	3	38.3	50	22.225	0.4	1.2	2°	1	JDM□1204
50	**AJX12R05004B**	●	4	38.3	50	22.225	0.4	1.2	2°	1	JDM□1204
50	**AJX09R05005B**	●	5	40	50	22.225	0.5	1.2	1.1°	1	JDM□09T3
63	**AJX14R06303B**	●	3	51.1	50	22.225	0.7	1.2	2.8°	1	JDM□1405
63	**AJX14R06304B**	●	4	51.1	50	22.225	0.7	1.2	2.8°	1	JDM□1405
63	**AJX12R06305B**	●	5	51.3	50	22.225	0.9	1.2	1.5°	1	JDM□1204
80	**AJX14R08004D**	●	4	68.1	63	31.75	1.3	1.2	1.8°	1	JDM□1405
80	**AJX14R08005D**	●	5	68.1	63	31.75	1.3	1.2	1.8°	1	JDM□1405
80	**AJX12R08006D**	●	6	68.3	63	31.75	1.7	1.2	1.1°	1	JDM□1204
100	**AJX14R10005D**	●	5	88.1	63	31.75	2.4	1.2	1.2°	1	JDM□1405
100	**AJX14R10006D**	●	6	88.1	63	31.75	2.4	1.2	1.2°	1	JDM□1405
100	**AJX12R10007D**	●	7	88.3	63	31.75	2.9	1.2	0.8°	1	JDM□1204
125	**AJX14R12505E**	●	5	113.2	63	38.1	3.3	1.2	0.8°	2	JDM□1405
125	**AJX14R12507E**	●	7	113.2	63	38.1	3.3	1.2	0.8°	2	JDM□1405
160	**AJX14R16006F**	●	6	148.2	63	50.8	5	1.2	0.5°	2	JDM□1405
160	**AJX14R16008F**	●	8	148.2	63	50.8	5	1.2	0.5°	2	JDM□1405

DCX=mm size, DCON=mm size

(mm)

DCX	Order Number	Stock R	Number of Teeth	DC	LF	DCON	WT (kg)	APMX	RMPX	Fig.	Insert Type
50	**AJX12-050A03R**	●	3	38.3	50	22	0.4	1.2	2°	1	JDM□1204
50	**AJX12-050A04R**	●	4	38.3	50	22	0.4	1.2	2°	1	JDM□1204
50	**AJX09-050A05R**	●	5	40	50	22	0.5	1.2	1.1°	1	JDM□09T3
63	**AJX14-063A03R**	●	3	51.1	50	22	0.7	1.2	2.8°	1	JDM□1405
63	**AJX14-063A04R**	●	4	51.1	50	22	0.7	1.2	2.8°	1	JDM□1405
63	**AJX12-063A05R**	●	5	51.3	50	22	0.9	1.2	1.5°	1	JDM□1204
80	**AJX14-080A04R**	●	4	68.1	50	27	1.2	1.2	1.8°	1	JDM□1405
80	**AJX14-080A05R**	●	5	68.1	50	27	1.2	1.2	1.8°	1	JDM□1405
80	**AJX12-080A06R**	●	6	68.3	50	27	1.2	1.2	1.1°	1	JDM□1204
100	**AJX14-100A05R**	●	5	88.1	63	32	2.4	1.2	1.2°	1	JDM□1405
100	**AJX14-100A06R**	●	6	88.1	63	32	2.4	1.2	1.2°	1	JDM□1405
100	**AJX12-100A07R**	●	7	88.3	63	32	2.6	1.2	0.8°	1	JDM□1204
125	**AJX14-125B05R**	●	5	113.2	63	40	3.3	1.2	0.8°	2	JDM□1405
125	**AJX14-125B07R**	●	7	113.2	63	40	3.3	1.2	0.8°	2	JDM□1405
160	**AJX14-160B06R**	●	6	148.2	63	40	5	1.2	0.5°	2	JDM□1405
160	**AJX14-160B08R**	●	8	148.2	63	40	5	1.2	0.5°	2	JDM□1405

* Refer to page M169, for the max. drilling depth (**AZ**).
Note 1) Refer to page M169, for the max. depth of cut (**APMX**) and max. drilling depth (**AZ**).

● : **Inventory maintained in Japan.**

Mounting Dimensions

DCX=mm size, DCON=inch size

(mm)

DCX	Order Number	DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	Fig.
50	**AJX12R05003B**	22.225	19	11	17	18.28	47	8.4	5	1
50	**AJX12R05004B**	22.225	19	11	17	18.28	47	8.4	5	1
50	**AJX09R05005B**	22.225	19	11	17	18.31	47	8.4	5	1
63	**AJX14R06303B**	22.225	19	11	17	18.16	60	8.4	5	1
63	**AJX14R06304B**	22.225	19	11	17	18.16	60	8.4	5	1
63	**AJX12R06305B**	22.225	19	11	17	18.28	60	8.4	5	1
80	**AJX14R08004D**	31.75	32	17	26	20.16	76	12.7	8	1
80	**AJX14R08005D**	31.75	32	17	26	20.16	76	12.7	8	1
80	**AJX12R08006D**	31.75	32	17	26	20.28	76	12.7	8	1
100	**AJX14R10005D**	31.75	32	17	26	20.16	96	12.7	8	1
100	**AJX14R10006D**	31.75	32	17	26	20.16	96	12.7	8	1
100	**AJX12R10007D**	31.75	32	17	26	20.28	96	12.7	8	1
125	**AJX14R12505E**	38.1	40	–	56	22.14	100	15.9	10	2
125	**AJX14R12507E**	38.1	40	–	56	22.14	100	15.9	10	2
160	**AJX14R16006F**	50.8	43	–	72	19.14	100	19.1	11	2
160	**AJX14R16008F**	50.8	43	–	72	19.14	100	19.1	11	2

DCX=mm size, DCON=mm size

(mm)

DCX	Order Number	DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	Fig.
50	**AJX12-050A03R**	22	20	11	17	17.28	47	10.4	6.3	1
50	**AJX12-050A04R**	22	20	11	17	17.28	47	10.4	6.3	1
50	**AJX09-050A05R**	22	20	11	17	17.31	47	10.4	6.3	1
63	**AJX14-063A03R**	22	20	11	17	17.16	60	10.4	6.3	1
63	**AJX14-063A04R**	22	20	11	17	17.16	60	10.4	6.3	1
63	**AJX12-063A05R**	22	20	11	17	17.28	60	10.4	6.3	1
80	**AJX14-080A04R**	27	23	13	19	16.16	76	12.4	7	1
80	**AJX14-080A05R**	27	23	13	19	16.16	76	12.4	7	1
80	**AJX12-080A06R**	27	23	13	19	16.28	76	12.4	7	1
100	**AJX14-100A05R**	32	26	17	26	26.16	96	14.4	8	1
100	**AJX14-100A06R**	32	26	17	26	26.16	96	14.4	8	1
100	**AJX12-100A07R**	32	26	17	26	26.28	96	14.4	8	1
125	**AJX14-125B05R**	40	40	–	56	22.14	100	16.4	9	2
125	**AJX14-125B07R**	40	40	–	56	22.14	100	16.4	9	2
160	**AJX14-160B06R**	40	40	–	56	22.14	100	16.4	9	2
160	**AJX14-160B08R**	40	40	–	56	22.14	100	16.4	9	2

SPARE PARTS

(mm)

Tool Holder Type	*		*		
	Clamp Screw	Clamp Bridge	Clamp Bridge Screw	Spring	Wrench
AJX09	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX12	TS43	AMS4	AJS4012T15	ASS2	TKY15T
AJX14	TS54	AMS5	AJS5014T25	ASS3	TKY25T

* Clamp Torque (N • m) : TS351=2.5, TS43=3.5, TS54=7.5, AJS3010T10=2.5, AJS4012T15=3.5, AJS5014T25=7.5

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Fig.1

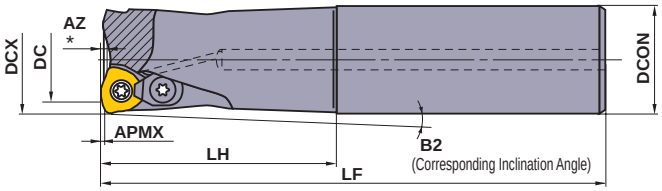
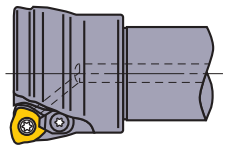


Fig.2



Right hand tool holder only.

■ SHANK TYPE

With Coolant Hole

(mm)

DCX	Order Number	Stock R	Number of Teeth	LF	DC	LH	DCON	B2	APMX	RMPX	Fig.	Insert Type
16	**AJX06R162SA16SS**	●	2	70	8.9	20	16	3.5°	0.6	3°	1	JOM◌06T2
16	**AJX06R162SA16S**	●	2	110	8.9	30	16	2.25°	0.6	3°	1	JOM◌06T2
16	**AJX06R162SA16L**	●	2	150	8.9	70	16	0.93°	0.6	3°	1	JOM◌06T2
16	**AJX06R162SA16EL**	●	2	200	8.9	100	16	0.64°	0.6	3°	1	JOM◌06T2
17	**AJX06R172SA16SS**	●	2	70	9.9	20	16	–	0.6	2.5°	1	JOM◌06T2
17	**AJX06R172SA16S**	●	2	110	9.9	20	16	–	0.6	2.5°	1	JOM◌06T2
17	**AJX06R172SA16L**	●	2	150	9.9	20	16	–	0.6	2.5°	1	JOM◌06T2
17	**AJX06R172SA16EL**	●	2	200	9.9	20	16	–	0.6	2.5°	1	JOM◌06T2
20	**AJX08R202SA20S**	●	2	130	11.4	50	20	1.34°	0.9	3.5°	1	JOM◌0803
20	**AJX06R203SA20S**	●	3	130	12.9	50	20	1.31°	0.6	1.5°	1	JOM◌06T2
20	**AJX08R202SA20L**	●	2	180	11.4	100	20	0.65°	0.9	3.5°	1	JOM◌0803
20	**AJX06R203SA20L**	●	3	180	12.9	100	20	0.64°	0.6	1.5°	1	JOM◌06T2
20	**AJX08R202SA20EL**	●	2	250	11.4	130	20	0.5°	0.9	3.5°	1	JOM◌0803
22	**AJX08R222SA20S**	●	2	130	13.4	30	20	–	0.9	3°	1	JOM◌0803
22	**AJX06R223SA20S**	●	3	130	14.9	30	20	–	0.6	1°	1	JOM◌06T2
22	**AJX08R222SA20L**	●	2	180	13.4	30	20	–	0.9	3°	1	JOM◌0803
22	**AJX06R223SA20L**	●	3	180	14.9	30	20	–	0.6	1°	1	JOM◌06T2
22	**AJX08R222SA20EL**	●	2	250	13.4	30	20	–	0.9	3°	1	JOM◌0803
25	**AJX09R252SA25S**	●	2	140	14.9	60	25	1.1°	1.2	4°	1	JDM◌09T3
25	**AJX08R253SA25S**	●	3	140	16.4	60	25	1.1°	0.9	2°	1	JOM◌0803
25	**AJX09R252SA25L**	●	2	200	14.9	120	25	0.54°	1.2	4°	1	JDM◌09T3
25	**AJX08R253SA25L**	●	3	200	16.4	120	25	0.54°	0.9	2°	1	JOM◌0803
25	**AJX09R252SA25EL**	●	2	300	14.9	180	25	0.36°	1.2	4°	1	JDM◌09T3
28	**AJX09R282SA25S**	●	2	140	17.9	40	25	–	1.2	3°	1	JDM◌09T3
28	**AJX08R283SA25S**	●	3	140	19.4	40	25	–	0.9	1.7°	1	JOM◌0803
28	**AJX09R282SA25L**	●	2	200	17.9	40	25	–	1.2	3°	1	JDM◌09T3
28	**AJX08R283SA25L**	●	3	200	19.4	40	25	–	0.9	1.7°	1	JOM◌0803
28	**AJX09R282SA25EL**	●	2	300	17.9	40	25	–	1.2	3°	1	JDM◌09T3
30	**AJX12R302SA32S**	●	2	150	18.3	70	32	1.82°	1.2	4.5°	1	JDM◌1204
30	**AJX09R303SA32S**	●	3	150	20	70	32	1.79°	1.2	2.7°	1	JDM◌09T3
30	**AJX12R302SA32L**	●	2	200	18.3	120	32	1.04°	1.2	4.5°	1	JDM◌1204
30	**AJX09R303SA32L**	●	3	200	20	120	32	1.03°	1.2	2.7°	1	JDM◌09T3
30	**AJX12R302SA32EL**	●	2	300	18.3	180	32	0.69°	1.2	4.5°	1	JDM◌1204
32	**AJX12R322SA32S**	●	2	150	20.3	70	32	0.96°	1.2	4°	1	JDM◌1204
32	**AJX09R323SA32S**	●	3	150	21.9	70	32	0.94°	1.2	2.5°	1	JDM◌09T3
32	**AJX12R322SA32L**	●	2	200	20.3	120	32	0.55°	1.2	4°	1	JDM◌1204
32	**AJX09R323SA32L**	●	3	200	21.9	120	32	0.54°	1.2	2.5°	1	JDM◌09T3
32	**AJX12R322SA32EL**	●	2	300	20.3	180	32	0.36°	1.2	4°	1	JDM◌1204
35	**AJX12R352SA32S**	●	2	150	23.3	50	32	–	1.2	3.5°	1	JDM◌1204
35	**AJX09R353SA32S**	●	3	150	24.9	50	32	–	1.2	2°	1	JDM◌09T3
35	**AJX12R352SA32L**	●	2	200	23.3	50	32	–	1.2	3.5°	1	JDM◌1204
35	**AJX09R353SA32L**	●	3	200	24.9	50	32	–	1.2	2°	1	JDM◌09T3
35	**AJX12R352SA32EL**	●	2	300	23.3	50	32	–	1.2	3.5°	1	JDM◌1204

⁎ Refer to page M169, for the max. drilling depth (**AZ**).
Note 1) Refer to page M169, for the max. depth of cut (**APMX**) and max. drilling depth (**AZ**).

● : **Inventory maintained in Japan.**

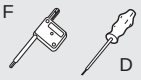
(mm)

DCX	Order Number	Stock R	Number of Teeth	LF	DC	LH	DCON	B2	APMX	RMPX	Fig.	Insert Type
40	**AJX12R403SA32S**	●	3	150	28.3	50	32	–	1.2	3°	1	JDM◌1204
40	**AJX09R404SA32S**	●	4	150	29.9	50	32	–	1.2	1.5°	1	JDM◌09T3
40	**AJX12R403SA32L**	●	3	250	28.3	50	32	–	1.2	3°	1	JDM◌1204
40	**AJX09R404SA32L**	●	4	250	29.9	50	32	–	1.2	1.5°	1	JDM◌09T3
40	**AJX12R402SA32EL**	●	2	350	28.3	50	32	–	1.2	3°	1	JDM◌1204
40	**AJX12R403SA42S**	●	3	150	28.3	70	42	1.79°	1.2	3°	1	JDM◌1204
40	**AJX09R404SA42S**	●	4	150	29.9	70	42	1.8°	1.2	1.5°	1	JDM◌09T3
40	**AJX12R403SA42L**	●	3	250	28.3	70	42	1.79°	1.2	3°	1	JDM◌1204
40	**AJX09R404SA42L**	●	4	250	29.9	70	42	1.8°	1.2	1.5°	1	JDM◌09T3
40	**AJX12R402SA42EL**	●	2	350	28.3	70	42	1.79°	1.2	3°	1	JDM◌1204
50	**AJX14R503SA42S**	●	3	150	38.2	50	42	–	1.2	4.2°	1	JDM◌1405
50	**AJX14R503SA42L**	●	3	250	38.1	50	42	–	1.2	4.2°	1	JDM◌1405
63	**AJX14R634SA42S**	●	4	150	51.1	50	42	–	1.2	2.8°	2	JDM◌1405
63	**AJX14R634SA42L**	●	4	250	51.1	50	42	–	1.2	2.8°	2	JDM◌1405

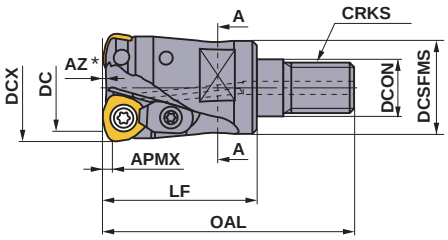
* Refer to page M169, for the max. drilling depth (**AZ**).
Note 1) Refer to page M169, for the max. depth of cut (**APMX**) and max. drilling depth (**AZ**).

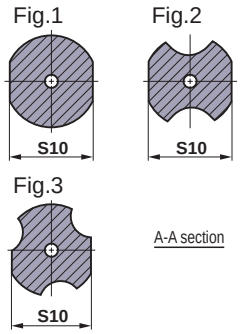
SPARE PARTS

(mm)

Tool Holder Type	* Clamp Screw	Clamp Bridge	* Clamp Bridge Screw	Spring	 F D Wrench
AJX06R162	TS25	–	–	–	TKY08F
AJX06R172	TS25	–	–	–	TKY08F
AJX06R203	TS25	–	–	–	TKY08F
AJX06R223	TS25	–	–	–	TKY08F
AJX08R202	TS33	–	–	–	TKY08D
AJX08R222	TS33	–	–	–	TKY08D
AJX08R253	TS33	–	–	–	TKY08D
AJX08R283	TS33	–	–	–	TKY08D
AJX09R252	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX09R282	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX09R303	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX09R323	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX09R353	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX09R404	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX12R302	TS407	AMS4	AJS4012T15	ASS2	TKY15D
AJX12R322	TS43	AMS4	AJS4012T15	ASS2	TKY15D
AJX12R352	TS43	AMS4	AJS4012T15	ASS2	TKY15D
AJX12R402	TS43	AMS4	AJS4012T15	ASS2	TKY15D
AJX12R403	TS43	AMS4	AJS4012T15	ASS2	TKY15D
AJX14R503	TS54	AMS5	AJS5014T25	ASS3	TKY25D
AJX14R634	TS54	AMS5	AJS5014T25	ASS3	TKY25D

* Clamp Torque (N • m) : TS25=1.0, TS33=1.0, TS351=2.5, TS407=3.5, TS43=3.5, TS54=7.5, AJS3010T10=2.5, AJS4012T15=3.5, AJS5014T25=7.5





■ SCREW-IN TYPE

With Coolant Hole

Right hand tool holder only.

(mm)

DCX	Order Number	Stock R	Number of Teeth	DC	LF	OAL	DCON	DCSFMS	S10	CRKS	WT (kg)	APMX	RMPX	Fig.	Shank Type	Insert Type
16	**AJX06R162AM0830**	●	2	8.9	30	48	8.5	13	10	M8	0.1	0.6	3°	1	SC16M08	JOM◌06T2
17	**AJX06R172AM0830**	●	2	9.9	30	48	8.5	13	10	M8	0.1	0.6	2.5°	1	SC16M08	JOM◌06T2
20	**AJX08R202AM1030**	●	2	11.4	30	49	10.5	18	14	M10	0.1	0.9	3.5°	2	SC20M10	JOM◌0803
20	**AJX06R203AM1030**	●	3	12.9	30	49	10.5	18	14	M10	0.1	0.6	1.5°	3	SC20M10	JOM◌06T2
22	**AJX08R222AM1030**	●	2	13.4	30	49	10.5	18	14	M10	0.1	0.9	3°	2	SC20M10	JOM◌0803
22	**AJX06R223AM1030**	●	3	14.9	30	49	10.5	18	14	M10	0.1	0.6	1°	3	SC20M10	JOM◌06T2
25	**AJX09R252AM1235**	●	2	14.9	35	57	12.5	21	19	M12	0.2	1.2	4°	2	SC25M12	JDM◌09T3
25	**AJX08R253AM1235**	●	3	16.4	35	57	12.5	21	19	M12	0.1	0.9	2°	1	SC25M12	JOM◌0803
28	**AJX09R282AM1235**	●	2	17.9	35	57	12.5	21	19	M12	0.2	1.2	3°	2	SC25M12	JDM◌09T3
28	**AJX08R283AM1235**	●	3	19.4	35	57	12.5	21	19	M12	0.1	0.9	1.7°	1	SC25M12	JOM◌0803
30	**AJX12R302AM1645**	●	2	18.3	45	68	17	29	24	M16	0.3	1.2	4.5°	2	SC32M16	JDM◌1204
30	**AJX09R303AM1645**	●	3	20	45	68	17	29	24	M16	0.2	1.2	2.7°	1	SC32M16	JDM◌09T3
32	**AJX12R322AM1645**	●	2	20.3	45	68	17	29	24	M16	0.3	1.2	4°	2	SC32M16	JDM◌1204
32	**AJX09R323AM1645**	●	3	21.9	45	68	17	29	24	M16	0.2	1.2	2.5°	1	SC32M16	JDM◌09T3
35	**AJX12R352AM1645**	●	2	23.3	45	68	17	29	24	M16	0.3	1.2	3.5°	2	SC32M16	JDM◌1204
35	**AJX09R353AM1645**	●	3	24.9	45	68	17	29	24	M16	0.2	1.2	2°	1	SC32M16	JDM◌09T3
40	**AJX12R403AM1645**	●	3	28.3	45	68	17	29	24	M16	0.3	1.2	3°	2	SC32M16	JDM◌1204
40	**AJX09R404AM1645**	●	4	29.9	45	68	17	29	24	M16	0.2	1.2	1.5°	1	SC32M16	JDM◌09T3

* Refer to page M169, for the max. drilling depth (**AZ**).
Note 1) Refer to page M169, for the max. depth of cut (**APMX**) and max. drilling depth (**AZ**).
Note 2) For screw-in type arbors, refer to page M269.

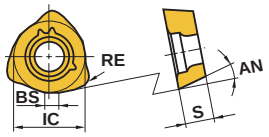
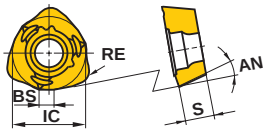
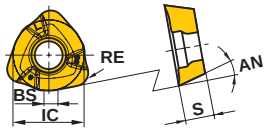
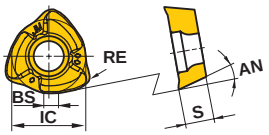
● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

(mm)

Work Material			FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140 (NEW)	VP15TF	VP30RT
	P	Steel	◐	◐	✣						◐	✣
	M	Stainless Steel				◔	❁				◔	❁
	K	Cast Iron	◐								✣	✣
	S	Heat-resistant Alloy, Titanium Alloy						◐	✣	✣	◐	✣
	H	Hardened Materials									◐	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	Class	FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140 (NEW)	VP15TF	VP30RT	AN	IC	S	BS	RE	Geometry
Partial Profile **FT** Breaker	**JOMW06T215ZZSR-FT**	M	●	●	●	●	●	●	●		●	●	13°	6.35	2.78	1.2	1.5	
	JOMW080320ZZSR-FT	M	●	●	●	●	●	●	●		●	●	13°	8	3.18	1.4	2	
	JDMW09T320ZDSR-FT	M	●	●	●	●	●	●	●		●	●	15°	9.525	3.97	1.8	2	
	JDMW120420ZDSR-FT	M	●	●	●	●	●	●	●		●	●	15°	12	4.76	2.5	2	
	JDMW140520ZDSR-FT	M	●	●	●	●	●	●	●		●	●	15°	14	5.56	2.8	2	
Strong Cutting Edge Type **ST** Breaker	**JDMT120420ZDSR-ST**	M	●	●	●	●	●				●	●	15°	12	4.76	2.5	2	
	JDMT140520ZDSR-ST	M	●	●	●	●	●				●	●	15°	14	5.56	2.8	2	
Focus on cutting edge sharpness (For Difficult-to-cut Materials) **JL** Breaker	**JOMT06T216ZZER-JL**	M				●	●	●	●	●			13°	6.35	2.78	1.2	1.6	
	JOMT080322ZZER-JL	M				●	●	●	●	●			13°	8	3.18	1.4	2.2	
	JDMT09T323ZDER-JL	M				●	●	●	●	●			15°	9.525	3.97	1.8	2.3	
	JDMT120423ZDER-JL	M				●	●	●	●	●			15°	12	4.76	2.5	2.3	
	JDMT140523ZDER-JL	M				●	●	●	●	●			15°	14	5.56	2.8	2.3	
Focus on cutting edge sharpness (For General Cutting) **JM** Breaker	**JOMT06T215ZZSR-JM**	M	●	●	●	●	●	●	●		●	●	13°	6.35	2.78	1.2	1.5	
	JOMT080320ZZSR-JM	M	●	●	●	●	●	●	●		●	●	13°	8	3.18	1.4	2	
	JDMT09T320ZDSR-JM	M	●	●	●	●	●	●	●		●	●	15°	9.525	3.97	1.8	2	
	JDMT120420ZDSR-JM	M	●	●	●	●	●	●	●		●	●	15°	12	4.76	2.5	2	
	JDMT140520ZDSR-JM	M	●	●	●	●	●	●	●		●	●	15°	14	5.56	2.8	2	

Note 1) Setting height for ST chipbreaker is slightly different from that for other chipbreakers.
If you use ST chipbreaker, check the setting height.

● = NEW

M

INDEXABLE MILLING

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

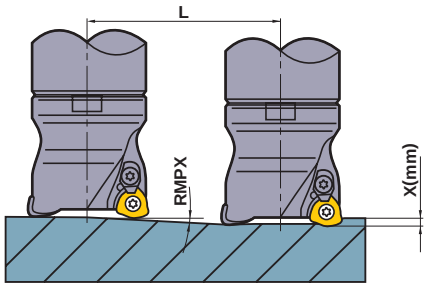
RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

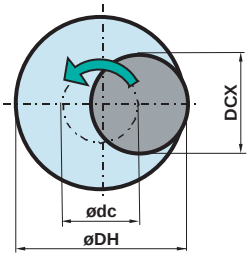
	Workpiece Material	Characteristics	Cutting Speed (m/min) for Different Grades			
P			FH7020	MP6120	MP6130	VP30RT
	Mild Steels	Hardness ≤180HB	170 (120—220)	150 (100—200)	130 (80—180)	110 (60—160)
	Carbon Steels Alloy Steels	Hardness 180—280HB	150 (100—200)	130 (80—180)	110 (60—160)	90 (40—140)
	Carbon Steels Alloy Steels	Hardness 280—350HB	130 (80—180)	100 (50—150)	80 (30—130)	60 (20—110)
	Alloy Tool Steels	Hardness ≤350HB (Annealing)	130 (80—180)	100 (50—150)	80 (30—120)	60 (20—90)
	Pre-hardened Steels	Hardness 35—45HRC	—	100 (70—130)	80 (50—110)	80 (30—90)
M			MP7130	MP7140	—	—
	Stainless Steels	Hardness ≤270HB	140 (100—180)	120 (80—160)		
K			FH7020	VP15TF	—	—
	Gray Cast Irons	Tensile Strength ≤350MPa	150 (100—200)	—		
	Ductile Cast Irons	Tensile Strength ≤800MPa	—	120 (80—160)	—	—
S			MP9120	MP9130	MP9140	—
	Heat Resistant Alloys	Hardness ≤350HB	30 (20—40)	25 (20—35)	20 (15—30)	
	Titanium Alloys	—	50 (40—60)	45 (30—55)	40 (30—50)	
H			VP15TF	—	—	—
	Hardened Steels	Hardness 40—55HRC	70 (50—90)			

MAXIMUM CAPACITIES BY MODE

■ RAMPING



■ HELICAL DRILLING



- How to derive a locus of the centre of the tool.

ødc = øDH - DCX

Locus of the center of the tool — Desired hole diameter — Cutting Diameter Maximum

- For the depth of cut per pass, refer to the cutting conditions above for helical drilling.
- Set the machine spindle revolution so that the tool is rotating and cutting in a down cut direction.

- When ramping and helical cutting, please apply a lower feed (60% of the calculated feed rate or less).
- When drilling, please set the feed in the axial direction at 0.2mm/rev or less.
- The long chips generated can disperse, ensure that adequate safety precautions are taken.

(mm)

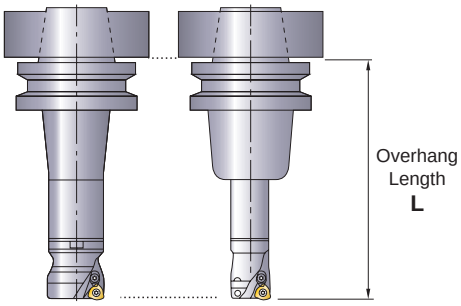
	Tool Holder Type	DCX	DC	APMX		Ramping					Helical Drilling		AZ
						RMPX	L Required distance for X mm depth				DH		
				FT/JM/ST Breaker	JL Breaker		X=1	X=1.2	X=1.5	X=2	Min	Max	
Shank type/Screw-in type	**AJX06**	16	8.9	1	0.6	3°	19.1	—	—	—	23	29	0.3
	AJX06	17	9.9	1	0.6	2.5°	22.9	—	—	—	25	31	0.3
	AJX06	20	12.9	1	0.6	1.5°	38.2	—	—	—	31	37	0.3
	AJX06	22	14.9	1	0.6	1°	57.3	—	—	—	35	41	0.3
	AJX08	20	11.4	1.5	0.9	3.5°	16.3	19.6	24.5	—	27	36	0.5
	AJX08	22	13.4	1.5	0.9	3°	19.1	22.9	28.6	—	31	40	0.5
	AJX08	25	16.4	1.5	0.9	2°	28.6	34.4	43	—	37	46	0.5
	AJX08	28	19.4	1.5	0.9	1.7°	33.7	40.4	50.5	—	43	52	0.5
	AJX09	25	14.9	2	1.2	4°	14.3	17.2	21.5	28.6	33	46	1
	AJX09	28	17.9	2	1.2	3°	19.1	22.9	28.6	38.1	39	52	1
	AJX09	30	20	2	1.2	2.7°	21.2	25.4	31.8	42.4	43	56	1
	AJX09	32	21.9	2	1.2	2.5°	22.9	27.5	34.4	45.8	47	60	1
	AJX09	35	24.9	2	1.2	2°	28.6	34.4	43	57.3	53	66	1
	AJX09	40	29.9	2	1.2	1.5°	38.2	45.8	57.3	76.4	63	76	1
	AJX12	30	18.3	2	1.2	4.5°	12.7	15.2	19	25.4	39	56	1.5
	AJX12	32	20.3	2	1.2	4°	14.3	17.2	21.4	28.6	41	60	1.5
	AJX12	35	23.3	2	1.2	3.5°	16.3	19.6	24.5	32.7	47	66	1.5
	AJX12	40	28.3	2	1.2	3°	19.1	22.9	28.6	38.2	57	76	1.5
	AJX14	50	38.2	2	1.2	4.2°	13.6	16.3	20.4	27.2	72	96	2
	AJX14	63	51.1	2	1.2	2.8°	20.4	24.5	30.7	40.9	98	122	2
Arbor type	**AJX09**	50	40	2	1.2	1.1°	52.1	62.5	78.1	104.2	83	96	1
	AJX12	50	38.3	2	1.2	2°	28.6	34.4	43	57.3	77	96	1.5
	AJX12	63	51.3	2	1.2	1.5°	38.2	45.8	57.3	76.4	103	122	1.5
	AJX12	80	68.3	2	1.2	1.1°	52.1	62.5	78.1	104.2	137	156	1.5
	AJX12	100	88.3	2	1.2	0.8°	71.6	85.9	107.4	143.2	177	196	1.5
	AJX14	63	51.1	2	1.2	2.8°	20.4	24.5	30.7	40.9	98	122	2
	AJX14	80	68.1	2	1.2	1.8°	31.8	38.2	47.7	63.6	132	156	2
	AJX14	100	88.1	2	1.2	1.2°	47.7	57.3	71.6	95.5	172	196	2
	AJX14	125	113.2	2	1.2	0.8°	71.6	85.9	107.4	143.2	222	246	2
	AJX14	160	148.2	2	1.2	0.5°	114.6	137.5	171.9	229.2	292	316	2

RECOMMENDED CUTTING CONDITIONS

DEPTH OF CUT / FEED

	Work Material	Characteristics	Shank Type / Screw-in Type								
			DCX=ø16, ø17			DCX=ø20, ø22			DCX=ø25, ø28		
			L	ap	fz (mm/t.)	L	ap	fz (mm/t.)	L	ap	fz (mm/t.)
P	Mild Steel	Hardness ≤180HB	140	0.8	0.8	160	1.0	1.0	170	1.0	1.2
			180	0.6	0.6	210	0.8	0.8	230	0.8	1.0
			210	0.4	0.4	240	0.6	0.6	290	0.6	0.8
	Carbon Steel Alloy Steel	Hardness 180—280HB	140	0.8	0.8	160	1.0	1.0	170	1.0	1.2
			180	0.6	0.6	210	0.8	0.8	230	0.8	1.0
			210	0.4	0.4	240	0.6	0.6	290	0.6	0.8
	Carbon Steel Alloy Steel	Hardness 280—350HB	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8
	Alloy Tool Steel	Hardness ≤350HB	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8
	Pre-hardened Steel	Hardness 35—45HRC	140	0.7	0.7	160	0.8	0.8	170	0.8	1.0
			180	0.5	0.5	210	0.6	0.6	230	0.6	0.8
			210	0.3	0.3	240	0.4	0.4	290	0.4	0.6
M	Stainless Steel	Hardness ≤270HB	140	0.8	0.7	160	1.0	0.8	170	1.0	1.0
			180	0.6	0.5	210	0.8	0.6	230	0.8	0.8
			210	0.4	0.3	240	0.6	0.4	290	0.6	0.6
K	Gray Cast Iron	Tensile Strength ≤350MPa	140	0.8	1.0	160	1.0	1.2	170	1.0	1.4
			180	0.6	0.8	210	0.8	1.0	230	0.8	1.2
			210	0.4	0.6	240	0.6	0.8	290	0.6	1.0
	Ductile Cast Iron	Tensile Strength ≤800MPa	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8
S	Heat Resistant Alloy	Hardness ≤350HB	140	0.6	0.6	160	0.8	0.6	170	1.0	0.6
			180	0.4	0.4	210	0.6	0.4	230	0.8	0.4
	Titanium Alloy	—	210	0.3	0.3	240	0.4	0.3	290	0.6	0.3
H	Hardened Steel	Hardness 40—55HRC	140	0.5	0.5	160	0.5	0.6	170	0.5	0.8
			180	0.4	0.3	210	0.4	0.4	230	0.4	0.6
			210	0.3	0.2	240	0.3	0.2	290	0.3	0.4

① Overhang Length **L**



② Main Spindle Revolution
n(min^{-1})=(Recommended Cutting Speed x 1000)÷(DCX x 3.14)

③ Table Feed Rate
vf(mm/min)=n x Feed per Tooth x Number of Teeth

④ Recommended width of cut (ae) is more than 60% of the cutting edge diameter (DCX).

⑤ The above cutting conditions are guides to cutting on a #50 BT machine. In case of #40 BT and #63 HSK machines, a cutting edge diameter of under 35mm is recommended. In this case, reduce the depth of cut and table feed rate.

⑥ Use of ST chipbreaker with tougher cutting edges is recommended for machining parts that require interrupted cutting. First recommended insert grade for non-standard 06/08/09 ST chipbreakers is VP30RT irrespective of the workpiece material.

⑦ Cutter body with coarse pitch is recommended for the unstable cutting caused by the long tool overhang.

⑧ Use the "sharp" JM chipbreaker to lower cutting forces or when long tool overhangs are used.

⑨ Heavy chips are generated when machining with the AJX. To avoid chip jamming-related problems, use air blow while machining to discharging chips effectively.

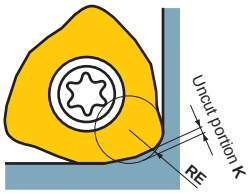
⑩ The maximum depth of cut of JL breaker is different in the insert size. 06 size is up to 0.6mm, 08 size is up to 0.9mm, and 09,12,14 size is up to 1.2mm.

(mm)

Shank Type / Screw-in Type												Arbor Type					
DCX=ø30, ø32, ø35			DCX=ø40 (ø32 Shank)			DCX=ø40 (ø42 Shank)			DCX=ø50, ø63			DCX=ø50, ø63			DCX=ø80, ø100, ø125, ø160		
L	ap	fz (mm/t.)	L	ap	fz (mm/t.)	L	ap	fz (mm/t.)	L	ap	fz (mm/t.)	L	ap	fz (mm/t.)	L	ap	fz (mm/t.)
180	1.2	1.4	180	1.2	1.4	180	1.2	1.5	180	1.4	1.5	150	1.5	1.5	170	1.5	1.5
230	1.0	1.2	240	1.0	1.2	240	1.0	1.3	240	1.2	1.3	250	1.3	1.3	300	1.3	1.3
290	0.8	1.0	300	0.8	1.0	300	0.8	1.1	–	–	–	350	1.1	1.1	450	1.0	1.0
180	1.2	1.4	180	1.2	1.4	180	1.2	1.5	180	1.4	1.5	150	1.5	1.5	170	1.5	1.5
230	1.0	1.2	240	1.0	1.2	240	1.0	1.3	240	1.2	1.3	250	1.3	1.3	300	1.3	1.3
290	0.8	1.0	300	0.8	1.0	300	0.8	1.1	–	–	–	350	1.1	1.1	450	1.0	1.0
180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5	150	1.3	1.5	170	1.3	1.5
230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3	250	1.1	1.3	300	1.1	1.3
290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	–	–	–	350	0.9	1.1	450	0.8	1.0
180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5	150	1.3	1.5	170	1.3	1.5
230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3	250	1.1	1.3	300	1.1	1.3
290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	–	–	–	350	0.9	1.1	450	0.8	1.0
180	1.0	1.2	180	1.0	1.2	180	1.0	1.3	180	1.2	1.3	150	1.3	1.3	170	1.3	1.3
230	0.8	1.0	240	0.8	1.0	240	0.8	1.1	240	1.0	1.1	250	1.1	1.1	300	1.1	1.1
290	0.6	0.8	300	0.6	0.8	300	0.6	0.9	–	–	–	350	0.9	0.9	450	0.8	0.8
180	1.2	1.2	180	1.2	1.2	180	1.2	1.3	180	*1.4	1.3	150	*1.5	1.3	170	*1.5	1.3
230	1.0	1.0	240	1.0	1.0	240	1.0	1.1	240	1.2	1.1	250	*1.3	1.1	300	*1.3	1.1
290	0.8	0.8	300	0.8	0.8	300	0.8	0.9	–	–	–	350	1.1	0.9	450	1.0	0.8
180	1.2	1.6	180	1.2	1.6	180	1.2	1.7	180	1.4	1.7	150	1.5	1.7	170	1.5	1.7
230	1.0	1.4	240	1.0	1.4	240	1.0	1.5	240	1.2	1.5	250	1.3	1.5	300	1.3	1.5
290	0.8	1.2	300	0.8	1.2	300	0.8	1.3	–	–	–	350	1.1	1.3	450	1.0	1.2
180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5	150	1.3	1.5	170	1.3	1.5
230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3	250	1.1	1.3	300	1.1	1.3
290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	–	–	–	350	0.9	1.1	450	0.8	1.0
180	1.2	0.6	180	1.2	0.6	180	1.2	0.6	180	1.2	0.6	150	1.2	0.6	170	1.2	0.6
230	1.0	0.4	240	1.0	0.4	240	1.0	0.4	240	1.0	0.4	250	1.0	0.4	300	1.0	0.4
290	0.8	0.3	300	0.8	0.3	300	0.8	0.3	–	–	–	350	0.8	0.3	450	0.8	0.3
180	0.6	1.0	180	0.6	1.0	180	0.6	1.1	180	0.8	1.1	150	0.9	1.1	170	0.9	1.1
230	0.5	0.8	240	0.5	0.8	240	0.5	0.9	240	0.6	0.9	250	0.7	0.9	300	0.7	0.9
290	0.4	0.6	300	0.4	0.6	300	0.4	0.7	–	–	–	–	–	–	–	–	–

* Depth of cut of JL breaker is up to 1.2 mm.

NOTE FOR PROGRAMMING



When using the AJX, please programme as an R3 radius cutter. The approximate uncut portions for the programme are as follows.

(mm)

Insert Size	Breaker	Approx. RE	Uncut Portion K
06	FT / JM	2.0	0.33
	JL	2.5	0.32
08	FT / JM	2.5	0.46
	JL	2.0	0.40
09	FT / JM	3.0	0.47
	JL	3.0	0.46
12	FT / JM / ST	3.0	0.63
	JL	3.0	0.53
14	FT / JM / ST	3.0	0.64
	JL	3.0	0.55

Note 1) The uncut portion may change slightly depending on cutting conditions.

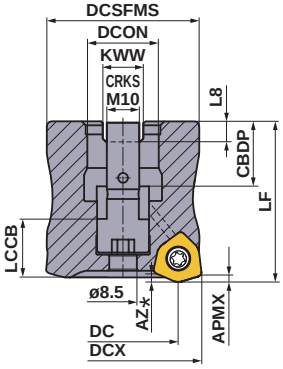
MULTI-FUNCTIONAL MILLING

TOOL NEWS

WJX NEW

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	Hardened Steel

ø50
ø52



Right hand tool holder only.
The set bolt is built in.
A 7mm Allen wrench is used to tighten the set bolt.

■ARBOR TYPE (ϕ50, ϕ52 Size)

With Coolant Hole GAMP:–7° GAMF:–10°

DCX (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	WT (kg)	APMX (mm)	RMPX	RPMX (min^{-1})
50	**WJX14-050A03AR**	●	3	34.5	50	22	0.4	2	4.4°	5000
50	**WJX14-050A04AR**	●	4	34.5	50	22	0.4	2	4.4°	5000
50	**WJX14R05003BA**	●	3	34.5	50	22.225	0.4	2	4.4°	5000
50	**WJX14R05004BA**	●	4	34.5	50	22.225	0.4	2	4.4°	5000
52	**WJX14-052A04AR**	●	4	36.5	50	22	0.4	2	4.1°	5000

* Refer to page M178, for the maximum drilling depth (**AZ**).
Note 1) The maximum spindle speeds **RPMX** are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.
Note 3) The milling cutter has a built-in set bolt. The set bolt cannot be replaced.
Therefore, absolutely do not disassemble the milling cutter.

Mounting Dimensions

DCX (mm)	Order Number	Dimensions(mm) DCON	CBDP	LCCB	DCSFMS	KWW	L8
50	**WJX14-050A03AR**	22	20	18.3	47	10.4	6.3
50	**WJX14-050A04AR**	22	20	18.3	47	10.4	6.3
50	**WJX14R05003BA**	22.225	20	18.3	47	8.4	5
50	**WJX14R05004BA**	22.225	20	18.3	47	8.4	5
52	**WJX14-052A04AR**	22	20	18.3	47	10.4	6.3

Spare Parts

Tool Holder Type	* Clamp Screw	Wrench (Insert)	Anti-seize Lubricant
WJX14	TS5R	TKY20T	MK1KS

* Clamp Torque (N • m) : TS5R = 5.0

● : **Inventory maintained in Japan.**

Fig.1

ø63
ø66
ø80
ø100

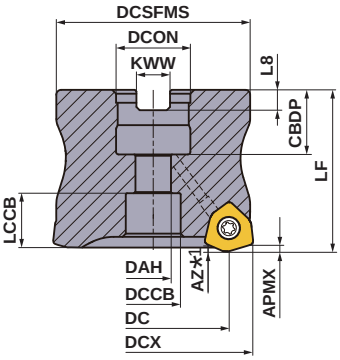
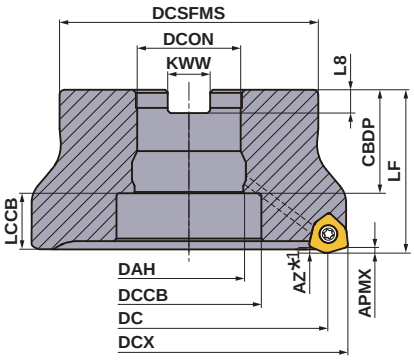
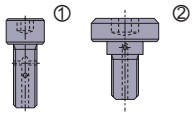


Fig.2

ø125
ø160



Right hand tool holder only.

DCX		Set Bolt	Geometry	
DCON inch size	**DCON** mm size			
ϕ63	ϕ63(22)	HSC10030H	①	
	ϕ63(27), ϕ66, ϕ80	HSC12035H		
ϕ80, ϕ100	ϕ100	HSC16040H		
ϕ125	ϕ125, ϕ160	MBA20040H	②	
ϕ160		MBA24045H		

■ARBOR TYPE

With Coolant Hole

GAMP:–6° GAMF:–10°

DCX (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	DCON	WT (kg)	APMX (mm)	RMPX	RPMX (min^{-1})	Fig.
63	**WJX14-063A04AR**	●	4	47.5	50	22	0.7	2	3°	18200	1
63	**WJX14-063A05AR**	●	5	47.5	50	22	0.7	2	3°	18200	1
63	**WJX14R06304BA**	●	4	47.5	50	22.225	0.7	2	3°	18200	1
63	**WJX14R06305BA**	●	5	47.5	50	22.225	0.7	2	3°	18200	1
63	**WJX14-063X05AR**	●	5	47.5	50	27	0.6	2	3°	18200	1
66	**WJX14-066X05AR**	●	5	50.4	50	27	0.7	2	2.8°	17700	1
80	**WJX14-080A05AR**	●	5	64.4	50	27	1.2	2	2.1°	15600	1
80	**WJX14-080A06AR**	●	6	64.4	50	27	1.2	2	2.1°	15600	1
80	**WJX14R08005DA**	●	5	64.4	63	31.75	1.4	2	2.1°	15600	1
80	**WJX14R08006DA**	●	6	64.4	63	31.75	1.4	2	2.1°	15600	1
100	**WJX14R10006DA**	●	6	84.4	63	31.75	2.5	2	1.5°	13500	1
100	**WJX14R10007DA**	●	7	84.4	63	31.75	2.5	2	1.5°	13500	1
100	**WJX14-100A06AR**	●	6	84.4	63	32	2.5	2	1.5°	13500	1
100	**WJX14-100A07AR**	●	7	84.4	63	32	2.5	2	1.5°	13500	1
125	**WJX14R12507EA**	●	7	109.4	63	38.1	3.2	2	1.2°	11600	2
125	**WJX14R12509EA**	●	9	109.4	63	38.1	3.1	2	1.2°	11600	2
125	**WJX14-125B07AR**	●	7	109.4	63	40	3.2	2	1.2°	11600	2
125	**WJX14-125B09AR**	●	9	109.4	63	40	3.1	2	1.2°	11600	2
160	**WJX14-160B09AR**	●	9	144.4	63	40	4.9	2	0.8°	9900	2
160	**WJX14R16009FA**	●	9	144.4	63	50.8	4.5	2	0.8°	9900	2

* Refer to page M178, for the maximum drilling depth (**AZ**).
Note 1) The maximum spindle speeds **RPMX** are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

MOUNTING DIMENSIONS ➤ M174
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

SPARE PARTS

Tool Holder Type	*		
	Clamp Screw	Wrench (Insert)	Anti-seize Lubricant
WJX14	TS5R	TKY20T	MK1KS

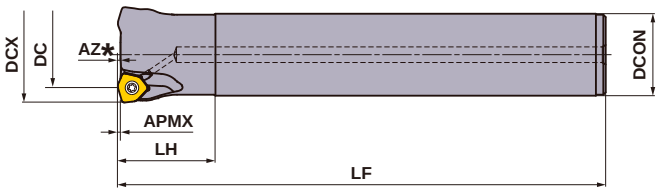
* Clamp Torque (N • m) : TS5R = 5.0

Mounting Dimensions

DCX (mm)	Order Number	Dimensions(mm)								Fig.
		DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8	
63	**WJX14-063A04AR**	22	20	11	17	16.7	60	10.4	6.3	1
63	**WJX14-063A05AR**	22	20	11	17	16.7	60	10.4	6.3	1
63	**WJX14R06304BA**	22.225	19	11	17	17.7	60	8.4	5	1
63	**WJX14R06305BA**	22.225	19	11	17	17.7	60	8.4	5	1
63	**WJX14-063X05AR**	27	23	13	20	15.7	60	12.4	7	1
66	**WJX14-066X05AR**	27	23	13	20	15.7	60	12.4	7	1
80	**WJX14-080A05AR**	27	23	13	20	15.7	76	12.4	7	1
80	**WJX14-080A06AR**	27	23	13	20	15.7	76	12.4	7	1
80	**WJX14R08005DA**	31.75	32	17	26	19.7	76	12.7	8	1
80	**WJX14R08006DA**	31.75	32	17	26	19.7	76	12.7	8	1
100	**WJX14R10006DA**	31.75	32	17	26	19.7	96	12.7	8	1
100	**WJX14R10007DA**	31.75	32	17	26	19.7	96	12.7	8	1
100	**WJX14-100A06AR**	32	26	17	26	25.7	96	14.4	8	1
100	**WJX14-100A07AR**	32	26	17	26	25.7	96	14.4	8	1
125	**WJX14R12507EA**	38.1	40	40	56	21.7	100	15.9	10	2
125	**WJX14R12509EA**	38.1	40	40	56	21.7	100	15.9	10	2
125	**WJX14-125B07AR**	40	40	42	56	21.7	100	16.4	9	2
125	**WJX14-125B09AR**	40	40	42	56	21.7	100	16.4	9	2
160	**WJX14-160B09AR**	40	40	42	56	21.7	100	16.4	9	2
160	**WJX14R16009FA**	50.8	43	53	72	18.7	100	19.1	11	2

■ Cutter Diameter and Flat Surface Milling

The maximum cutting diameter (DCX) shown in the WJX items table is not the same as the possible dimensions for plane cutting.
The possible dimensions for plane cutting are given as the cutting axle DC value. Please note that this is smaller than the DCX value.



Right hand tool holder only.

■SHANK TYPE

With Coolant Hole

DCX (mm)	Order Number	Stock R	Number of Teeth	Dimensions(mm) DC	LF	LH	DCON	APMX (mm)	RMPX	RPMX (min^{-1})
50	**WJX14R5003SA42S**	●	3	34.5	150	50	42	2	4.4°	21200
50	**WJX14R5003SA42L**	●	3	34.5	250	50	42	2	4.4°	21200

* Refer to page M178, for the maximum drilling depth (**AZ**).
Note 1) The maximum spindle speeds **RPMX** are set to ensure tool and insert stability.
Note 2) When using the tool at high spindle speeds, ensure that the tool and arbor are correctly balanced.

SPARE PARTS

Tool Holder Type	Clamp Screw *	Wrench (Insert)	Anti-seize Lubricant
WJX14	TS5R	TKY20D	MK1KS

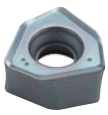
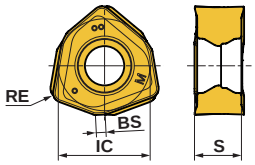
* Clamp Torque (N • m) : TS5R = 5.0

INSERTS

Workpiece Material			MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT
	P	Steels	◐	◐	✣					◐	✣
	M	Stainless Steels	◔			◔	✣			◔	✣
	K	Cast Ions								✣	✣
	S	Heat Resistant Alloys, Titanium Alloys						◐	✣	◐	✣
	H	Hardened Steels								◐	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round

Shape	Order Number	Class	Honing	MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	IC	S	BS	RE	Geometry
	**JOMU140715ZZER-M**	M	E	●	●	●	●	●	●	●	●	●	14	6.63	1.3	1.5	 Right hand insert only.

● : **Inventory maintained in Japan. (10 inserts in one case)**

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

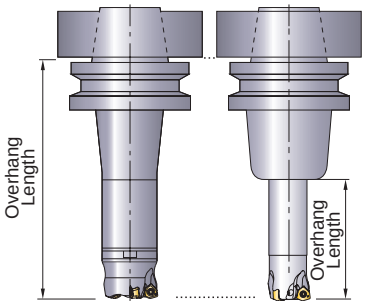
RECOMMENDED CUTTING CONDITIONS

Correction Value According to Overhang Length

Multiply the recommended cutting conditions on pages M176 and M177 by the corrections factor x overhang length.

Type	DCX (mm)	Overhang Length (mm)	Correction Value		
			vc (m/min)	ap (mm)	fz (mm/t.)
Shank Type	50	< 2.5×DCON	100%	100%	100%
		3.0×DCON	90%	100%	90%
		4.0×DCON	80%	80%	90%
Arbor Type	50—80	< 2.5×DCX	100%	100%	100%
		3.0×DCX	85%	100%	90%
		4.0×DCX	80%	80%	80%
		5.0×DCX	75%	75%	60%
		6.0×DCX	70%	70%	40%
	≥100	200	100%	100%	100%
		300	85%	100%	90%
		400	80%	80%	80%

DCON=Connection Dia.



Cutting Speed (Dry Cutting)

	Workpiece Material	Characteristics	Cutting Speed (Priority Basis) vc (m/min)				
P			MP6130	MP6120	MC7020	VP15TF	VP30RT
	Mild Steels	≤180HB	140 (90—180)	150 (100—200)	220 (170—270)	150 (100—200)	120 (80—160)
	Carbon Steels Alloy Steels	180—280HB	120 (70—180)	140 (80—200)	200 (150—250)	140 (80—200)	100 (60—150)
	Carbon Steels Alloy Steels	280—350HB	120 (70—180)	140 (80—200)	200 (150—250)	140 (80—200)	100 (60—150)
	Alloy Tool Steels	≤350HB (Annealing)	120 (70—180)	140 (80—200)	200 (150—250)	140 (80—200)	100 (60—150)
	Pre-hardened Steels	35—45HRC	90 (50—130)	110 (70—150)	—	110 (70—150)	80 (40—120)
M			MP7130	MP7140	MC7020	VP30RT	
	Austenitic Stainless Steels	≤200HB	160 (130—200)	150 (120—180)	220 (170—270)	150 (120—180)	
	Austenitic Stainless Steels	>200HB	140 (100—200)	130 (80—180)	190 (140—240)	130 (80—180)	
	Ferritic and Martensitic Stainless Steels	≤200HB	150 (100—200)	130 (80—180)	220 (170—270)	130 (80—180)	
	Duplex Stainless Steels	≤280HB	130 (80—180)	110 (60—160)	180 (130—230)	110 (60—160)	
	Precipitation Hardening Stainless Steels	<450HB	110 (60—160)	90 (50—130)	170 (120—220)	90 (50—130)	
K			VP15TF				
	Gray Cast Irons	≤350MPa	160 (120—200)				
	Ductile Cast Irons	≤450MPa	150 (100—200)				
	Ductile Cast Irons	≤800MPa	120 (80—160)				
S			MP9130	MP9120	VP15TF		
	Heat Resistant Alloys	—	30 (20—40)	40 (20—50)	40 (20—50)		
H			VP15TF				
	Hardened Steels	40—55HRC	70 (40—100)				

Note 1) To discharge chips effectively, use an air blow when machining. When the air blow is less effective at discharging chips, we recommend wet cutting.
Note 2) When wet cutting, tool life may become shorter than dry cutting. When carrying out wet cutting for the applications recommended with dry cutting, reduce the cutting speed by 25%.
Note 3) When large vibration occurs, reduce the cutting conditions.
Note 4) For interrupted cutting, reduce the cutting speed and feed rate by 20%.

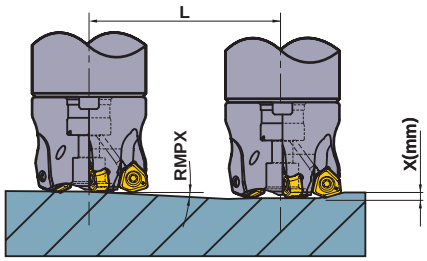
Depth of Cut / Feed per Tooth

	Workpiece Material	Characteristics	ap (mm)	DCX=50	DCX≥63
				fz (mm/t.)	fz (mm/t.)
P	Mild Steels	≤180HB	≤1	1.5(0.6−2.5)	1.7(0.6−2.8)
			≤1.5	1.3(0.6−2.0)	1.5(0.6−2.5)
			≤2	1.2(0.6−2.0)	1.3(0.6−2.5)
			≤2.5	0.8(0.3−1.5)	1.0(0.3−1.6)
			≤3	0.4(0.2−1.0)	0.5(0.2−1.2)
	Carbon Steels Alloy Steels	180−280HB	≤1	1.5(0.5−2.0)	1.7(0.5−2.5)
			≤1.5	1.2(0.5−1.7)	1.3(0.5−2.5)
			≤2	1.0(0.5−1.5)	1.2(0.5−2.0)
			≤2.5	0.7(0.3−1.2)	0.9(0.3−1.5)
			≤3	0.3(0.2−0.8)	0.4(0.2−1.0)
	Carbon Steels Alloy Steels	280−350HB	≤1	1.5(0.5−2.0)	1.7(0.5−2.5)
			≤1.5	1.2(0.5−1.7)	1.3(0.5−2.2)
			≤2	1.0(0.5−1.5)	1.2(0.5−2.0)
			≤2.5	0.7(0.3−1.2)	0.9(0.3−1.5)
			≤3	0.3(0.2−0.8)	0.4(0.2−1.0)
	Alloy Tool Steels	≤350HB (Annealing)	≤1	1.5(0.5−2.0)	1.7(0.5−2.5)
			≤1.5	1.2(0.5−1.7)	1.3(0.5−2.2)
			≤2	1.0(0.5−1.5)	1.2(0.5−2.0)
			≤2.5	0.7(0.3−1.2)	0.9(0.3−1.5)
			≤3	0.3(0.2−0.8)	0.4(0.2−1.0)
	Pre-hardened Steels	35−45HRC	≤1	1.3(0.4−1.7)	1.5(0.4−2.0)
			≤1.5	1.0(0.4−1.5)	1.2(0.4−1.5)
			≤2	0.8(0.4−1.2)	1.0(0.4−1.3)
M	Austenitic Stainless Steels	≤200HB	≤1	1.0(0.5−1.2)	1.0(0.5−1.2)
			≤1.5	1.0(0.5−1.0)	1.0(0.5−1.0)
	Austenitic Stainless Steels	>200HB	≤1	1.0(0.5−1.2)	1.0(0.5−1.2)
			≤1.5	1.0(0.5−1.0)	1.0(0.5−1.0)
	Ferritic and Martensitic Stainless Steels	≤200HB	≤1	1.0(0.5−1.2)	1.0(0.5−1.2)
			≤1.5	1.0(0.5−1.0)	1.0(0.5−1.0)
	Duplex Stainless Steels	≤280HB	≤1	0.8(0.4−1.0)	0.8(0.4−1.0)
			≤1.5	0.8(0.4−0.8)	0.8(0.4−0.8)
	Precipitation Hardening Stainless Steels	<450HB	≤1	0.8(0.4−1.0)	0.8(0.4−1.0)
			≤1.5	0.8(0.4−0.8)	0.8(0.4−0.8)
K	Gray Cast Irons	≤350MPa	≤1	1.7(0.6−2.5)	1.8(0.6−2.8)
			≤1.5	1.5(0.6−2.0)	1.7(0.6−2.5)
			≤2	1.3(0.6−2.0)	1.5(0.6−2.5)
			≤2.5	0.8(0.3−1.5)	1.0(0.3−1.6)
			≤3	0.4(0.2−1.0)	0.5(0.2−1.2)
	Ductile Cast Irons	≤450MPa	≤1	1.5(0.5−2.0)	1.7(0.5−2.5)
			≤1.5	1.3(0.5−1.8)	1.5(0.5−2.0)
			≤2	1.2(0.5−1.8)	1.3(0.5−2.0)
			≤2.5	0.7(0.3−1.2)	0.9(0.3−1.5)
			≤3	0.3(0.2−0.8)	0.4(0.2−1.0)
	Ductile Cast Irons	≤800MPa	≤1	1.3(0.4−1.8)	1.5(0.4−2.0)
			≤1.5	1.2(0.4−1.5)	1.3(0.4−1.8)
			≤2	1.0(0.4−1.5)	1.2(0.4−1.8)
S	Heat Resistant Alloys	–	≤1	1.0(0.3−1.3)	1.0(0.3−1.3)
			≤1.5	0.8(0.3−1.2)	0.8(0.3−1.2)
			≤2	0.7(0.3−1.2)	0.7(0.3−1.2)
H	Hardened Steels	40−55HRC	≤1	0.8(0.3−1.2)	0.8(0.3−1.2)
			≤1.5	0.6(0.3−1.0)	0.6(0.3−1.0)
			≤2	0.5(0.3−0.8)	0.5(0.3−0.8)

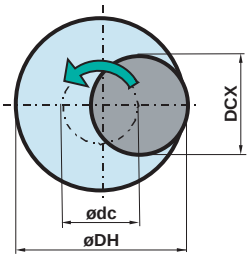
Note 1) To discharge chips effectively, use an air blow when machining. When the air blow is less effective at discharging chips, we recommend wet cutting.
Note 2) When large vibration occurs, reduce the cutting conditions.
Note 3) For interrupted cutting, reduce the cutting speed and feed rate by 20%.
Note 4) If ap is set at 2mm or more, avoid machining on the walls or ramping.

Maximum Capacities by Mode

■ Ramping



■ Helical Milling



● How to derive a locus of the center of the tool.

ødc = øDH - DCX

ødc: Locus of the Center of the Tool
øDH: Desired Hole Diameter
DCX: Cutting Diameter Maximum

Tool Holder Type	DCX (mm)	DC (mm)	APMX (mm)	Ramping			Helical Milling (Blind Hole, Flat Bottom)		Helical Milling (Through Hole)	AZ (mm)
				RMPX	L (mm) Required Distance for X mm Depth		DH (mm)		DH (mm)	
					x = 1 (mm)	x = 2 (mm)	Min.	Max.	Min.	
WJX14R50	50	34.5	2	4.4°	13.0	26.0	82	97	73	2.1
WJX14-050	50	34.5	2	4.4°	13.0	26.0	82	97	73	2.1
WJX14R050	50	34.5	2	4.4°	13.0	26.0	82	97	73	2.1
WJX14-052	52	36.5	2	4.1°	14.0	28.0	86	101	77	2.1
WJX14-063	63	47.5	2	3.0°	19.1	38.2	108	123	99	2.1
WJX14R063	63	47.5	2	3.0°	19.1	38.2	108	123	99	2.1
WJX14-066	66	50.4	2	2.8°	20.5	40.9	114	129	105	2.1
WJX14-080	80	64.4	2	2.1°	27.3	54.6	142	157	133	2.1
WJX14R080	80	64.4	2	2.1°	27.3	54.6	142	157	133	2.1
WX14-100	100	84.4	2	1.5°	38.2	76.4	182	197	173	2.1
WJX14R100	100	84.4	2	1.5°	38.2	76.4	182	197	173	2.1
WJX14-125	125	109.4	2	1.2°	47.8	95.5	232	247	223	2.1
WJX14R125	125	109.4	2	1.2°	47.8	95.5	232	247	223	2.1
WJX14-160	160	144.4	2	0.8°	71.7	143.3	302	317	293	2.1
WJX14R160	160	144.4	2	0.8°	71.7	143.3	302	317	293	2.1

DCX = Cutting Dia. Max. **DC** = Cutting Dia. **DH** = Desired Hole Dia.
APMX = Depth of Cut Max. **RMPX** = Ramping Angle Max. **AZ** = Plunge Depth Max.

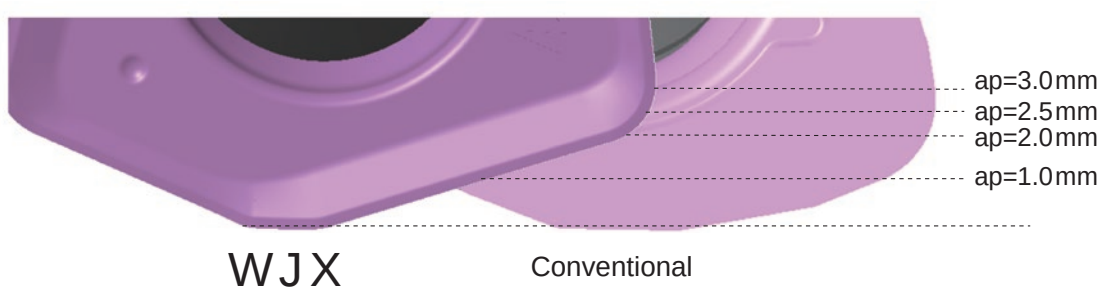
Note 1) When ramping and helical milling, it is recommended to reduce the feed per tooth.
Note 2) When ramping, helical milling and drilling, long continuous chips may be scattered so please be careful.

<Helical Milling>
To obtain a flat bottom surface when helical milling, it requires to remove “the uncut part” in the center of the workpiece material at a final pass.
When helical milling, make sure that the depth of cut per helical pass doesn’t exceed the maximum depth of cut (APMX).
<Drilling>
When drilling, set the axial feed per revolution at 0.2 mm/rev or less.

OPERATIONAL GUIDANCE

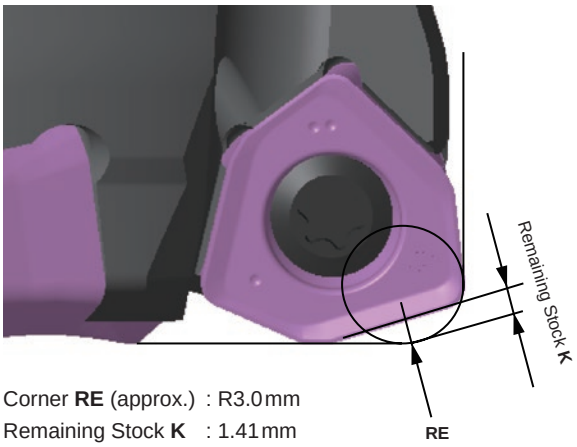
■ Depth of Cut

The straight cutting edge is 2.0mm at maximum depth of cut (APMX).
When plane cutting steels and cast irons, the depth of cut can be set at up to 3.0mm until you reach the corner radius.
When you exceed 2.0mm, you will need to decrease the feed rate. See the cutting conditions on page M177 for reference.

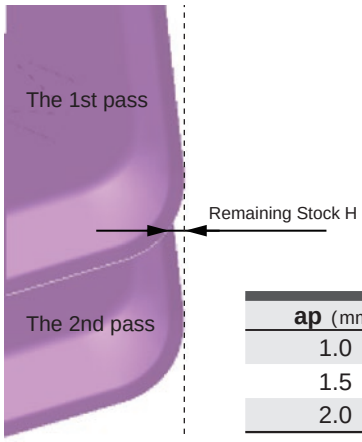


■ Remaining Stock

When using the WJX, please program as a radius cutter.
The approximate remaining stock **K** for the program is shown below.
Also see the table on the right for the remaining stock **H** of the vertical wall.



Corner **RE** (approx.) : R3.0mm
Remaining Stock **K** : 1.41mm



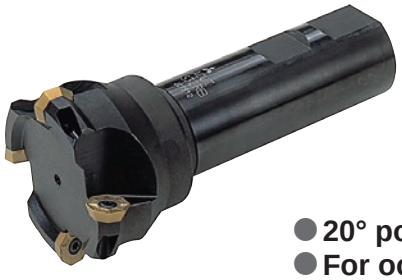
ap (mm)	Remaining Stock **H** (mm)
1.0	0.05
1.5	0.08
2.0	0.12

MULTI FUNCTIONAL MILLING

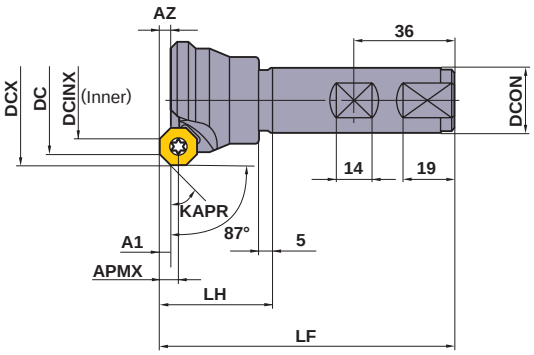
42° KAPR

OCTACUT

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel



- 20° positive insert.
- For octagonal and round type inserts.
- Multi-functional machining.



■SHANK TYPE

KAPR :42°

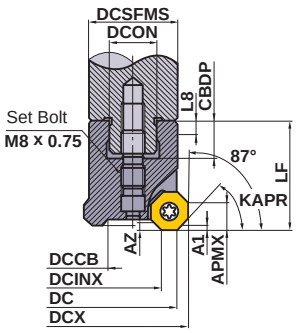
Right hand tool holder only.

Order Number	Stock R	Number of Teeth	DCX	DC	DCINX	LF	DCON	LH	A1	APMX	AZ	* Clamp Screw	① Wrench	① ② Insert
OCTACUT322S32RB	●	2	32	23.6	13.1	125	32	45	2.5	7	3	CS350990T	①TKY10F	①OEMX12T3○○○○ ②REMX12T3○○○○
OCTACUT403S32RB	●	3	40	31.7	21.2	125	32	45	2.5	7	3	CS350990T	①TKY10F	
OCTACUT504S32RB	●	4	50	41.9	31.4	125	32	45	2.5	7	3	CS350990T	①TKY10F	
OCTACUT634S32RB	●	4	63	54.9	44.5	125	32	45	2.5	7	3	CS350990T	①TKY10F	
OCTACUT503S32R	●	3	50	38.3	24.5	125	32	45	3	9	4	CS501290T	②TKY25T	①OEMX1705○○○○ ②REMX1705○○○○
OCTACUT634S32R	●	4	63	51.4	37.6	125	32	45	3	9	4	CS501290T	②TKY25T	

* Clamp Torque (N • m) : CS350990T=2.5, CS501290T=7.5

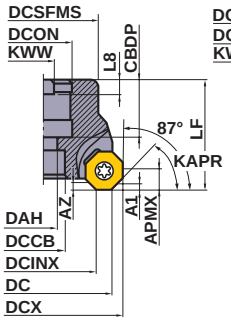
● : Inventory maintained in Japan.

Fig.1



Small Insert Type
ø40
Standard Insert Type
ø50

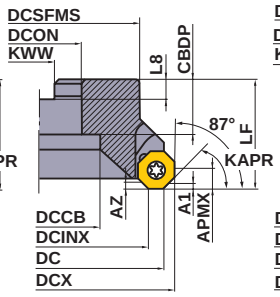
Fig.2



Small Insert Type
ø50
ø63
ø80

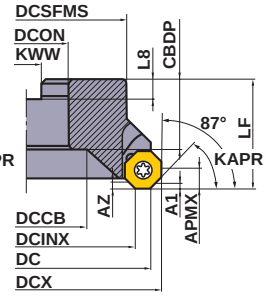
Standard Insert Type
ø63
ø80
ø100

Fig.3



Standard Insert Type
ø125

Fig.4



Standard Insert Type
ø160

■ARBOR TYPE

KAPR :42°
GAMP:+13° GAMF:-4°

Right hand tool holder only.

Order Number	Stock	Number of Teeth	Dimensions (mm)											WT* (kg)	Max. Depth of Cut (mm)			Fig.
	R		DCX	DC	DCINX	LF	DCON	CBDP	DAH	DCCB	KWW	DCSFMS	L8		A1	APMX	AZ	
OCTACUT0403ARB	●	3	40	31.7	21.2	40	16	18	—	19.47	8.4	33	5.6	0.4	2.5	7	3	1
OCTACUT0504ARB	●	4	50	41.9	31.4	50	22	20	11	16	10.4	42.5	6.3	0.5	2.5	7	3	2
OCTACUT0634ARB	●	4	63	54.9	44.5	50	22	20	11	16	10.4	44	6.3	0.7	2.5	7	3	2
OCTACUT0805CRB	●	5	80	71.9	61.5	50	25.4	26	13	20	9.5	53	6	1.2	2.5	7	3	2
OCTACUT0503AR	●	3	50	38.3	24.5	50	22	20	—	22.15	10.4	41	6.3	0.5	3	9	4	1
OCTACUT0634AR	●	4	63	51.4	37.6	50	22	20	11	16	10.4	44	6.3	0.7	3	9	4	2
OCTACUT0805CR	●	5	80	68.4	54.7	50	25.4	26	13	20	9.5	53	6	1.2	3	9	4	2
OCTACUT1006DR	●	6	100	88.5	74.7	63	31.75	32	17	45	12.7	70	8	1.6	3	9	4	2
OCTACUT1257ER	●	7	125	113.5	99.8	63	38.1	35	—	56	15.9	80	10	1.8	3	9	4	3
OCTACUT1608FR	●	8	160	148.5	134.8	63	50.8	38	—	88.7	19.1	120	11	3.6	3	9	4	4

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench	Wrench	Set Bolt	Set Bolt	① ② Insert
OCTACUT0403ARB	CS350990T	TKY10F	—	HDS08030	—	①OEMX12T3○○○○ ②REMX12T3○○○○
OCTACUT0504ARB				—	BOES101	
OCTACUT0634ARB					—	
OCTACUT0805CRB						
OCTACUT0503AR	CS501290T	—	TKY25T	HDS10031	—	①OEMX1705○○○○ ②REMX1705○○○○
OCTACUT0634AR				—	BOES101	
OCTACUT0805CR					—	
OCTACUT1006DR					HSC16035	
OCTACUT1257ER					—	
OCTACUT1608FR						

* Clamp Torque (N • m) : CS350990T=2.5, CS501290T=7.5

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

Fig.1

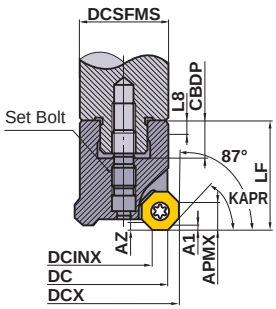


Fig.2

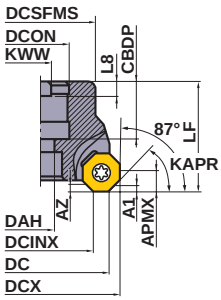


Fig.3

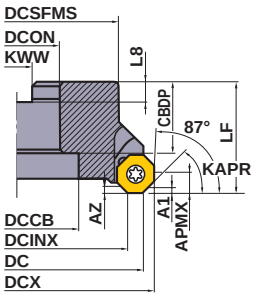


Fig.4

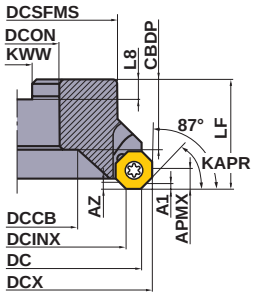
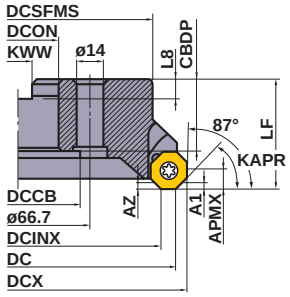


Fig.5



For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

■ARBOR TYPE

KAPR :42°
GAMP:+13° GAMF:-4°

Right hand tool holder only.

Order Number	Stock	Number of Teeth	Dimensions (mm)											WT* (kg)	Max. Depth of Cut (mm)			Fig.
	R		DCX	DC	DCINX	LF	DCON	CBDP	DAH	DCCB	KWW	DCSFMS	L8		A1	APMX	AZ	
OCTACUT0403ARB	●	3	40	31.7	21.2	40	16	18	—	—	8.4	33	5.6	0.4	2.5	7	3	1
OCTACUT0504ARB	●	4	50	41.9	31.4	50	22	20	11	—	10.4	42.5	6.3	0.5	2.5	7	3	2
OCTACUT0634ARB	●	4	63	54.9	44.5	50	22	20	11	—	10.4	44	6.3	0.7	2.5	7	3	2
OCTACUT0805ARB	●	5	80	71.9	61.5	50	27	23	13	—	12.4	53	7	1.2	2.5	7	3	2
OCTACUT0503AR	●	3	50	38.3	24.5	50	22	20	—	—	10.4	41	6.3	0.5	3	9	4	1
OCTACUT0634AR	●	4	63	51.4	37.6	50	22	20	11	—	10.4	44	6.3	0.7	3	9	4	2
OCTACUT0805AR	●	5	80	68.4	54.7	50	27	23	13	—	12.4	53	7	1.2	3	9	4	2
OCTACUT1006AR	●	6	100	88.5	74.7	50	32	32	—	45	14.4	70	8	1.6	3	9	4	3
OCTACUT1257BR	●	7	125	113.5	99.8	50	40	32	—	56	16.4	80	9	1.8	3	9	4	4
OCTACUT1608CR	●	8	160	148.5	134.8	50	40	29	—	88.7	16.4	120	9	3.6	3	9	4	5

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench	Wrench	Set Bolt	Set Bolt	Insert
OCTACUT0403ARB	CS350990T	TKY10F	—	HDS08030	—	①OEMX12T3□□□□ ②REMX12T3□□□□
OCTACUT0504ARB				—	BOES101	
OCTACUT0634ARB OCTACUT0805ARB					—	
OCTACUT0503AR	CS501290T	—	TKY25T	HDS10031	—	①OEMX1705□□□□ ②REMX1705□□□□
OCTACUT0634AR				—	BOES101	
OCTACUT0805AR OCTACUT1608CR					—	

* Clamp Torque (N • m) : CS350990T=2.5, CS501290T=7.5

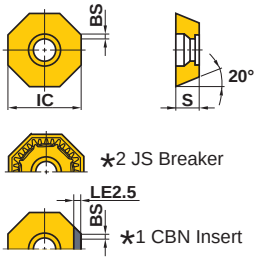
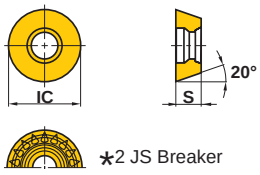
● : Inventory maintained in Japan. (10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

INSERTS

Work Material			F7030	VP15TF		NX4545			MB730		
	P	Steel	◐	◐		◐					
	M	Stainless Steel	◔	◔		◔					
	K	Cast Iron		✱					◐		
	H	Hardened Steel		◔					◔		

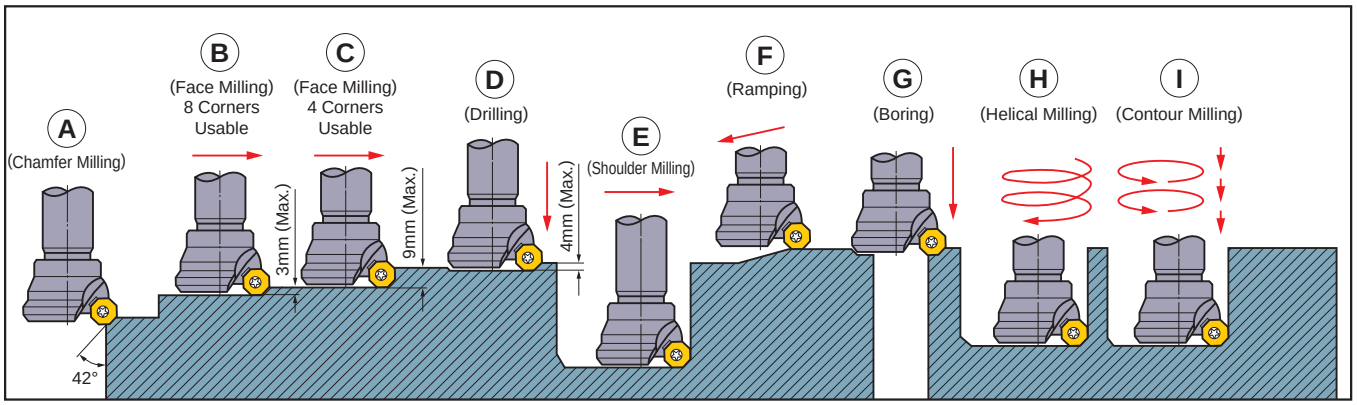
Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Honing :
E : Round **S :** Chamfer + Hone **T :** Chamfer

Shape	Order Number	Class	Honing	Coated F7030	Coated VP15TF		Cermet NX4545			CBN ✱1 MB730			Dimensions (mm) IC	S	BS	Geometry
✱2 JS Breaker	**OEMX12T3ETR1**	M	T				●			●			12.7	3.97	1.0	 ✱2 JS Breaker ✱1 CBN Insert
	OEMX12T3ESR1	M	S	●									12.7	3.97	1.0	
	✱2 **OEMX12T3EER1-JS**	M	E	●									12.7	3.97	1.0	
	OEMX1705ETR1	M	T		●		●						17.0	5.0	1.4	
	OEMX1705ESR1	M	S	●									17.0	5.0	1.4	
	✱2 **OEMX1705EER1-JS**	M	E	●									17.0	5.0	1.4	
	✱2 **OEMX1705ETR1-JS**	M	T		●								17.0	5.0	1.4	
✱2 JS Breaker	✱2 **REMX12T3EN-JS**	M	E	●									12.95	4.17	–	 ✱2 JS Breaker
	REMX1705SN	M	S	●									17.25	5.2	–	
	✱2 **REMX1705EN-JS**	M	E	●									17.25	5.2	–	

✱2 Insert with breaker.

RECOMMENDED CUTTING CONDITIONS



This list of recommended cutting conditions is for cutters with diameter≤ϕ80. For cutters with diameter>ϕ80 increase cutting speed by 10%.
Above sizes are for OEMX1705□□□□.

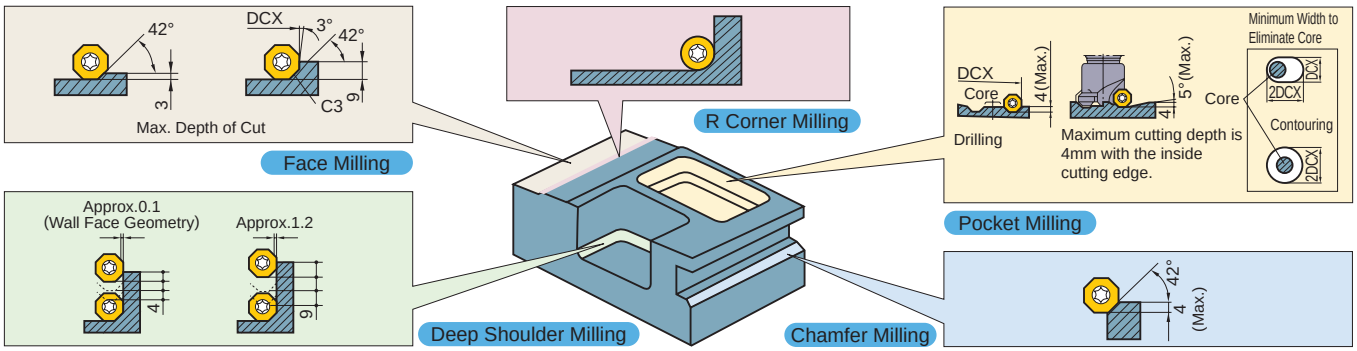
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Cutting Mode	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**F7030**	240 (180—300)	A	0.2 (0.15—0.25)
					B	0.2 (0.15—0.25)
			VP15TF	180 (100—250)	C,E,F	0.2 (0.15—0.25)
					D,G,H,I	0.075 (0.05—0.1)
	Carbon Steel Alloy Steel	180—280HB	**F7030**	200 (140—240)	A	0.2 (0.15—0.25)
					B	0.2 (0.15—0.25)
			VP15TF	180 (100—250)	C,E,F	0.2 (0.15—0.25)
					D,G,H,I	0.075 (0.05—0.1)
		280—380HB	**F7030**	150 (100—170)	A	0.2 (0.15—0.25)
					B	0.2 (0.15—0.25)
			VP15TF	120 (80—160)	C,E,F	0.2 (0.15—0.25)
					D,G,H,I	0.075 (0.05—0.1)
	Pre-Hardened Steel	35—45HRC	**F7030**	130 (90—160)	A	0.15 (0.1—0.2)
					B	0.15 (0.1—0.2)
			VP15TF	120 (80—160)	C,E,F	0.1 (0.05—0.15)
					D,G,H,I	0.05 (0.025—0.075)
	High Alloy Steel	≤300HB	**F7030**	150 (100—170)	A	0.15 (0.1—0.2)
					B	0.15 (0.1—0.2)
			VP15TF	120 (80—160)	C,E,F	0.1 (0.05—0.15)
					D,G,H,I	0.05 (0.025—0.075)
M	Stainless Steel	≤270HB	**F7030**	200 (140—240)	A	0.15 (0.1—0.2)
					B	0.15 (0.1—0.2)
			VP15TF	150 (100—200)	C,E,F	0.1 (0.05—0.15)
					D,G,H,I	0.075 (0.05—0.1)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution
Note 1) This list of recommended cutting conditions is for flank wear of 0.3mm in 30 min. cutting time.
Note 2) More than 50mm shank length should be clamped in the milling chuck.
Note 3) Use step cutting when driling (0.5 mm steps are recommended).
Note 4) When chattering occurs, reduce cutting speed by 20—30 %.
Note 5) When using round inserts, make sure that the flat portion of the flank surface is secure against the insert seat wall.

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Cutting Mode	Feed per Tooth (mm/t.)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	160 (100—220)	A	0.3 (0.25—0.35)
					B	0.25 (0.2—0.3)
					C,E,F	0.15 (0.1—0.2)
					D,G,H,I	0.075 (0.05—0.1)
			MB730	1500 (1000—3000)	B (D.O.C 0.1—0.5mm)	0.15 (0.1—0.2)
	Ductile Cast Iron	Tensile Strength 360—500MPa	**VP15TF**	160 (100—220)	A	0.25 (0.2—0.3)
					B	0.2 (0.15—0.25)
					C,E,F	0.1 (0.05—0.15)
					D,G,H,I	0.05 (0.025—0.075)
	Ductile Cast Iron	Tensile Strength 500—800MPa	**VP15TF**	140 (90—190)	A	0.25 (0.2—0.3)
					B	0.2 (0.15—0.25)
					C,E,F	0.1 (0.05—0.15)
					D,G,H,I	0.05 (0.025—0.075)
H	Hardened Steel	45—60HRC	**VP15TF**	80 (50—100)	A	0.15 (0.1—0.2)
					B	0.15 (0.1—0.2)
					C,E,F	0.1 (0.05—0.12)
					D,G,H,I	0.05 (0.025—0.06)
			MB730	150 (100—200)	B (D.O.C 0.1—0.3mm)	0.15 (0.1—0.2)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution
Note 1) This list of recommended cutting conditions is for flank wear of 0.3mm in 30 min. cutting time.
Note 2) More than 50mm shank length should be clamped in the milling chuck.
Note 3) Use step cutting when driling (0.5 mm steps are recommended).
Note 4) When chattering occurs, reduce cutting speed by 20—30 %.
Note 5) When using round inserts, make sure that the flat portion of the flank surface is secure against the insert seat wall.

APPLICATION



Above sizes are for OEMX1705□□□□.

MULTI FUNCTIONAL MILLING

TOOL NEWS

R KAPR

ARP

P | **M** | K | N | **S** | H

Stainless Steel — Heat Resistant Alloy

Fig.1

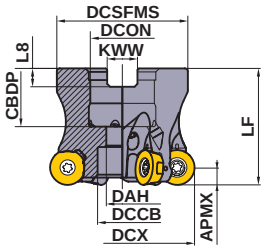
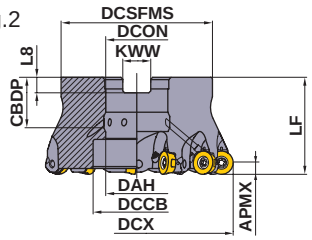
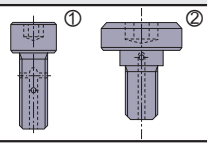


Fig.2



- **Run out does not occur easily when changing sections.**
- **Solid clamping system.**
- **Standardized stock of extra fine pitch.**

Cutter Diameter DCX	Set Bolt	Geometry
ϕ80	HSC08025H	①
–	–	
ϕ100	MBA16033H	②
–	–	



■ARBOR TYPE

GAMP:+4° GAMF:-6°

Type	Cutting Edge R (APMX)	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) DCX	DCSFMS	LF	DCON	CBDP	DAH	DCCB	KWW	L8	WT* (kg)	Max. Depth of Cut (mm) APMX	A1	AZ	RMPX	Fig.
Fine Pitch	6	**ARP6PR08008CA**	●	○	8	80	56	50	25.4	26	13	20	9.5	6	0.89	6.0	2.5	2.5	2.3°	1
		ARP6PR10009DA	●	○	9	100	70	50	31.75	32	31.75	45	12.7	8	1.38	6.0	2.5	2.5	1.7°	2
Extra Fine Pitch	6	**ARP6PR08009CA**	●	○	9	80	56	50	25.4	26	13	20	9.5	6	0.89	6.0	2.5	2.5	2.3°	1
		ARP6PR10011DA	●	○	11	100	70	50	31.75	32	31.75	45	12.7	8	1.36	6.0	2.5	2.5	1.7°	2

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
ARP5	TPS351B	TIP10D	MK1KS	RP○T1040M0E4-○
ARP6	TPS4	TIP15D	MK1KS	RP○T1248M0E4-○

*1 Clamp Torque (N • m) : TPS351B=2.5,TPS4=3.5

*2 Coolant nozzles are available with varying diameters for adjusting coolant pressure. Select nozzles as required by the specification.

	≤1Mpa (≤20 l/min.)	←Standard→	≥5Mpa (≥30 l/min.)	≥7Mpa (≥50 l/min.)
Nozzle Dia.	ø0.6mm	ø0.8mm	ø1.2mm	ø1.6mm
Order Number	**HSD04004H06**	**HSD04004H08**	**HSD04004H12**	**HSD04004H16**

* Clamp Torque (N • m) : HSD0400H○○=1.5

*3 The part number for a blank screw without a through nozzle is HSS04004.

● : **Inventory maintained in Japan.**

Fig.1

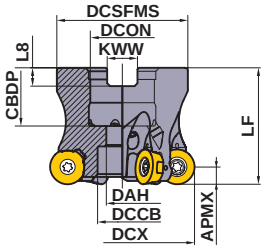
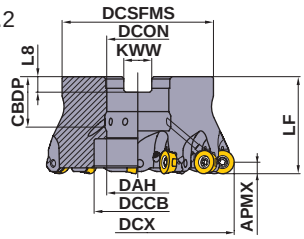


Fig.2

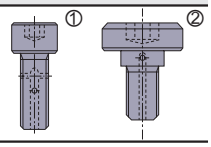


For metric arbors

The cutter bore diameter DCON is indicated in millimetres.

Right hand (R) only for the standard.

Cutter Diameter DCX	Set Bolt	Geometry
ϕ40	HSC08025H	①
ϕ50, ϕ63	HSC10030H	①
ϕ80	HSC12035H	①
ϕ100	MBA16033H	②

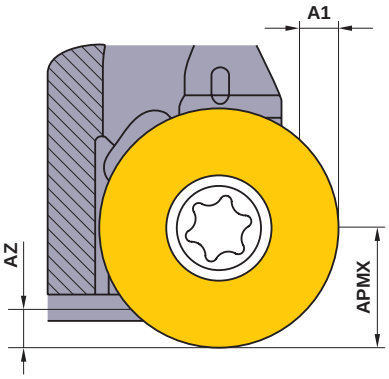


■ARBOR TYPE

GAMP:+4° GAMF:-6°

Type	Cutting Edge R (APMX)	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) DCX	DCSFMS	LF	DCON	CBDP	DAH	DCCB	KWW	L8	WT* (kg)	Max. Depth of Cut (mm) APMX	A1	AZ	RMPX	Fig.
Fine Pitch	5	ARP5P-040A05AR	●	○	5	40	34	40	16	18	9	14	8.4	5.6	0.15	5.0	2.0	1.30	2.8°	1
		ARP5P-050A06AR	●	○	6	50	45	40	22	20	11	17	10.4	6.3	0.27	5.0	2.0	1.85	2.9°	1
		ARP5P-063A07AR	●	○	7	63	50	40	22	20	11	17	10.4	6.3	0.46	5.0	2.5	2.50	3.0°	1
Extra Fine Pitch	5	ARP5P-050A07AR	●	○	7	50	45	40	22	20	11	17	10.4	6.3	0.27	5.0	2.0	1.85	2.9°	1
		ARP5P-063A08AR	●	○	8	63	50	40	22	20	11	17	10.4	6.3	0.46	5.0	2.5	2.50	3.0°	1
Fine Pitch	6	ARP6P-040A04AR	●	○	4	40	34	40	16	18	9	13.4	8.4	5.6	0.15	6.0	2.0	1.15	2.7°	1
		ARP6P-050A05AR	●	○	5	50	45	40	22	20	11	17	10.4	6.3	0.26	6.0	2.0	1.70	2.9°	1
		ARP6P-063A06AR	●	○	6	63	50	40	22	20	11	17	10.4	6.3	0.44	6.0	2.5	2.50	3.1°	1
		ARP6P-080A08AR	●	○	8	80	56	50	27	23	13	20	12.4	7	0.88	6.0	2.5	2.50	2.3°	1
		ARP6P-100B09AR	●	○	9	100	78	50	32	26	32	45	14.4	8	1.47	6.0	2.5	2.50	1.7°	2
Extra Fine Pitch	6	ARP6P-050A06AR	●	○	6	50	45	40	22	20	11	17	10.4	6.3	0.25	6.0	2.0	1.70	2.9°	1
		ARP6P-063A07AR	●	○	7	63	50	40	22	20	11	17	10.4	6.3	0.44	6.0	2.5	2.50	3.1°	1
		ARP6P-080A09AR	●	○	9	80	56	50	27	23	13	20	12.4	7	0.88	6.0	2.5	2.50	2.3°	1
		ARP6P-100B11AR	●	○	11	100	78	50	32	26	32	45	14.4	8	1.45	6.0	2.5	2.50	1.7°	2

* WT : Tool Weight



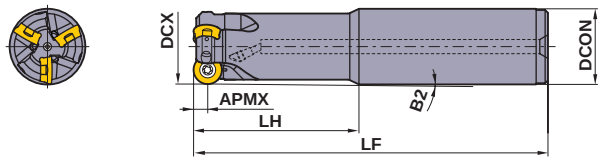


Fig.1

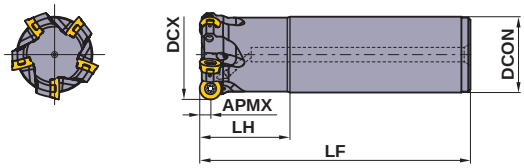


Fig.2

■SHANK TYPE

GAMP:+4° GAMF:-6°—-7°

Type	Cutting Edge R (APMX)	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) DCX	DCON	LF	LH	B2	WT* (kg)	Max. Depth of Cut (mm) APMX	A1	AZ	RMPX	Fig.
Standard	5	ARP5PR2503SA25M	●	○	3	25	25	140	60	1.10°	0.42	5.0	1.0	0.40	1.8°	1
		ARP5PR3204SA32M	●	○	4	32	32	150	70	0.92°	0.77	5.0	1.0	0.65	1.9°	1
Long	5	ARP5PR2502SA25L	●	○	2	25	25	180	80	0.80°	0.56	5.0	1.0	0.40	1.8°	1
		ARP5PR3203SA32L	●	○	3	32	32	200	120	0.51°	1.01	5.0	1.0	0.65	1.9°	1
Standard	6	ARP6PR3203SA32M	●	○	3	32	32	150	70	0.94°	0.76	6.0	1.0	0.60	2.0°	1
		ARP6PR4004SA32M	●	○	4	40	32	150	50	–	0.85	6.0	2.5	1.15	2.7°	2
		ARP6PR5005SA42M	●	○	5	50	42	150	50	–	1.47	6.0	2.5	1.70	2.9°	2
Long	6	ARP6PR3202SA32L	●	○	2	32	32	200	120	0.52°	1.00	6.0	1.0	0.60	2.0°	1
		ARP6PR4003SA32L	●	○	3	40	32	250	50	–	1.48	6.0	2.5	1.15	2.7°	2
		ARP6PR5004SA42L	●	○	4	50	42	250	50	–	2.53	6.0	2.5	1.70	2.9°	2

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
ARP5	TPS351B	TIP10D	MK1KS	RP○T1040M0E4-○
ARP6	TPS4	TIP15D	MK1KS	RP○T1248M0E4-○

*1 Clamp Torque (N • m) : TPS351B=2.5,TPS4=3.5

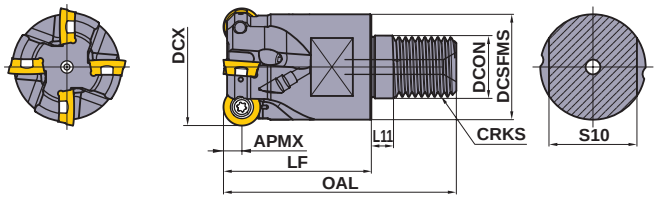
*2 Coolant nozzles are available with varying diameters for adjusting coolant pressure. Select nozzles as required by the specification.

	≤1Mpa (≤20 l/min.)	←Standard→	≥5Mpa (≥30 l/min.)	≥7Mpa (≥50 l/min.)
Nozzle Dia.	ø0.6mm	ø0.8mm	ø1.2mm	ø1.6mm
Order Number	**HSD04004H06**	**HSD04004H08**	**HSD04004H12**	**HSD04004H16**

* Clamp Torque (N • m) : HSD0400H○○=1.5

*3 The part number for a blank screw without a through nozzle is HSS04004.

● : **Inventory maintained in Japan. (10 inserts in one case)**



■SCREW-IN TYPE

GAMP:+4° GAMF:-6°—-7°

Type	Cutting Edge R (APMX)	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) DCX	DCON	DCSFMS	OAL	LF	L11	S10	CRKS	WT* (kg)	Max. Depth of Cut (mm) APMX	A1	AZ	RMPX
Standard	5	ARP5PR2502AM1235	●	○	2	25	12.5	23.5	57	35	6	19	M12	0.10	5.0	–	0.40	1.8°
		ARP5PR3203AM1640	●	○	3	32	17.0	28.5	63	40	6	24	M16	0.16	5.0	1.0	0.65	1.9°
Fine Pitch	5	ARP5PR2503AM1235	●	○	3	25	12.5	23.5	57	35	6	19	M12	0.09	5.0	–	0.40	1.8°
		ARP5PR3204AM1640	●	○	4	32	17.0	28.5	63	40	6	24	M16	0.15	5.0	1.0	0.65	1.9°
Standard	6	ARP6PR3202AM1640	●	○	2	32	17.0	28.5	63	40	6	24	M16	0.18	6.0	1.0	0.60	2.0°
		ARP6PR4003AM1640	●	○	3	40	17.0	28.5	63	40	6	24	M16	0.20	6.0	2.5	1.15	2.7°
Fine Pitch	6	ARP6PR3203AM1640	●	○	3	32	17.0	28.5	63	40	6	24	M16	0.17	6.0	1.0	0.60	2.0°
		ARP6PR4004AM1640	●	○	4	40	17.0	28.5	63	40	6	24	M16	0.20	6.0	2.5	1.15	2.7°

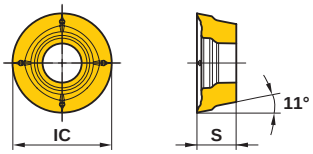
* WT : Tool Weight

Note 1) For screw-in type arbors, refer to page M269.

INSERTS

Work Material										
	M	Stainless Steel	◐	◐						
	S	Heat-resistant Alloy, Titanium Alloy			✠					

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing :
E : Round

Shape		Order Number	Class	Honing	Coated MC7020	MP7130	MP9130	Cermet		Carbide		Dimensions (mm) IC	S	Geometry
	Ground	RPHT1040M0E4-L	H	E	●	●	●					10	3.97	
		RPHT1040M0E4-M	H	E	●	●	●					10	3.97	
		RPHT1040M0E4-R	H	E	●	●	●					10	3.97	
		RPHT1248M0E4-L	H	E	●	●	●					12	4.76	
		RPHT1248M0E4-M	H	E	●	●	●					12	4.76	
		RPHT1248M0E4-R	H	E	●	●	●					12	4.76	
	Sintered	RPMT1040M0E4-L	M	E	●	●	●					10	3.97	
		RPMT1040M0E4-M	M	E	●	●	●					10	3.97	
		RPMT1040M0E4-R	M	E	●	●	●					10	3.97	
		RPMT1248M0E4-L	M	E	●	●	●					12	4.76	
		RPMT1248M0E4-M	M	E	●	●	●					12	4.76	
		RPMT1248M0E4-R	M	E	●	●	●					12	4.76	

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

■ Dry cutting

	Work Material	Hardness	Grade	vc (m/min)	fz (mm/t.)
M	Austenitic Stainless Steel	≤200HB	**MC7020**	220 (170–270)	0.2 (0.1–0.35)
			MP7130	200 (150–250)	0.2 (0.1–0.35)
	Austenitic Stainless Steel	>200HB	**MC7020**	190 (140–240)	0.2 (0.1–0.35)
			MP7130	170 (120–220)	0.2 (0.1–0.35)
	Two-phase Stainless Steel	≤280HB	**MC7020**	180 (130–230)	0.2 (0.1–0.35)
			MP7130	160 (110–210)	0.2 (0.1–0.35)
	Ferritic and Martensitic Stainless Steel	≤200MPa	**MC7020**	240 (190–290)	0.2 (0.1–0.35)
			MP7130	200 (150–250)	0.2 (0.1–0.35)
	Ferritic and Martensitic Stainless Steel	>200HB	**MC7020**	240 (190–290)	0.2 (0.1–0.35)
			MP7130	200 (150–250)	0.2 (0.1–0.35)
	Hardened Stainless Steel	<450HB	**MC7020**	170 (120–220)	0.2 (0.1–0.35)
			MP7130	150 (100–200)	0.2 (0.1–0.35)

■ Wet cutting

	Work Material	Hardness	Grade	vc (m/min)	fz (mm/t.)
M	Austenitic Stainless Steel	≤200HB	**MC7020**	150 (100–200)	0.2 (0.1–0.35)
			MP7130	130 (80–180)	0.2 (0.1–0.35)
	Austenitic Stainless Steel	>200HB	**MC7020**	120 (70–170)	0.2 (0.1–0.35)
			MP7130	100 (80–150)	0.2 (0.1–0.35)
	Two-phase Stainless Steel	≤280HB	**MC7020**	120 (70–170)	0.2 (0.1–0.35)
			MP7130	100 (80–150)	0.2 (0.1–0.35)
	Ferritic and Martensitic Stainless Steel	≤200MPa	**MC7020**	170 (120–220)	0.2 (0.1–0.35)
			MP7130	130 (80–180)	0.2 (0.1–0.35)
	Ferritic and Martensitic Stainless Steel	>200HB	**MC7020**	170 (120–220)	0.2 (0.1–0.35)
			MP7130	130 (80–180)	0.2 (0.1–0.35)
	Hardened Stainless Steel	<450HB	**MC7020**	110 (60–160)	0.2 (0.1–0.35)
			MP7130	90 (50–140)	0.2 (0.1–0.35)
S	Titanium Alloy	–	**MP9130**	45 (30–55)	0.1 (0.05–0.15)
	Heat Resistant Alloy	–	**MP9130**	35 (15–45)	0.1 (0.05–0.15)

Note 1) Actual cutting conditions are estimated to avoid chatter vibration with high rigidity of a machine or workpiece.
Make appropriate adjustments when chatter and/or insert chipping occurs during cutting.
Use with lowered conditions when there is a big overhang and/or when pocket-cutting.

Note 2) The setting level for feeding 1 blade is ap = 2.5mm with ARP5 axial cutting. With ARP6, use ap = 3mm.
Use while matching the ap fluctuation and correction value F of the respective table.
Ex. Feed for the recommended 1 blade when ARP5,SUS304, MP7130,ap=1: 0.2 mm/t.×1.5 (correction value F)=0.3 mm/t.

Note 3) For grooving, use feed at the recommended 70% level. For ramping, drilling, and plunging, use 50% level.

Note 4) Internal coolant is recommended in titanium alloy and heat resistant alloy cutting.
When the coolant nozzle of separately sold is used, it is more effective.

MAXIMUM CAPACITIES BY EACH CUTTING

Cutting Edge	Maximum hole diameter	Order Number	Install	Type	Recommendation (mm)		Ramping	Helical Drilling		Drilling Depth	Plunging
APMX (mm)	**DCX** (mm)				**ap**	**ae**	**RMPX**(deg)	Smallest hole **DH min.**(mm)	Largest hole **DH max.**(mm)	Maximum **AZ**(mm)	**AE1**(mm)
5	25	**ARP5PR2502AM1235**	Screw-in	Standard	≤2.5	≤1.00DCX	1.8°	40	48	0.40	—
		ARP5PR2503AM1235	Screw-in	Fine Pitch	≤1.5	≤1.00DCX	1.8°	40	48	0.40	—
		ARP5PR2503SA25M	Shank	Standard	≤1.5	≤1.00DCX	1.8°	40	48	0.40	1.0
		ARP5PR2502SA25L	Shank	Long	≤1.5	≤1.00DCX	1.8°	40	48	0.40	1.0
	32	**ARP5PR3203AM1640**	Screw-in	Standard	≤2.5	≤1.00DCX	1.9°	54	62	0.65	1.0
		ARP5PR3204AM1640	Screw-in	Fine Pitch	≤2.5	≤1.00DCX	1.9°	54	62	0.65	1.0
		ARP5PR3204SA32M	Shank	Standard	≤2.5	≤1.00DCX	1.9°	54	62	0.65	1.0
		ARP5PR3203SA32L	Shank	Long	≤2.5	≤1.00DCX	1.9°	54	62	0.65	1.0
	40	**ARP5P-040A05AR**	Arbor	Fine Pitch	≤2.5	≤1.00DCX	2.8°	70	78	1.30	2.0
	50	**ARP5P-050A06AR**	Arbor	Fine Pitch	≤2.5	≤1.00DCX	2.9°	90	98	1.85	2.0
		ARP5P-050A07AR	Arbor	Extra Fine Pitch	≤1.5	≤1.00DCX	2.9°	90	98	1.85	2.0
	63	**ARP5P-063A07AR**	Arbor	Fine Pitch	≤2.5	≤0.75DCX	3.0°	116	124	2.50	2.5
		ARP5P-063A08AR	Arbor	Extra Fine Pitch	≤1.5	≤0.75DCX	3.0°	116	124	2.50	2.5
6	32	**ARP6PR3202AM1640**	Screw-in	Standard	≤3.5	≤1.00DCX	2.0°	52	62	0.60	1.0
		ARP6PR3203AM1640	Screw-in	Fine Pitch	≤3.5	≤1.00DCX	2.0°	52	62	0.60	1.0
		ARP6PR3203SA32M	Shank	Standard	≤3.5	≤1.00DCX	2.0°	52	62	0.60	1.0
		ARP6PR3202SA32L	Shank	Long	≤3.5	≤1.00DCX	2.0°	52	62	0.60	1.0
	40	**ARP6PR4003AM1640**	Screw-in	Standard	≤3.5	≤1.00DCX	2.7°	68	78	1.15	2.5
		ARP6PR4004AM1640	Screw-in	Fine Pitch	≤3.5	≤1.00DCX	2.7°	68	78	1.15	2.5
		ARP6PR4004SA32M	Shank	Standard	≤3.5	≤1.00DCX	2.7°	68	78	1.15	2.5
		ARP6PR4003SA32L	Shank	Long	≤3.5	≤1.00DCX	2.7°	68	78	1.15	2.5
		ARP6P-040A04AR	Arbor	Fine Pitch	≤3.5	≤1.00DCX	2.7°	68	78	1.15	2.0
	50	**ARP6PR5005SA42M**	Shank	Standard	≤3.5	≤1.00DCX	2.9°	88	98	1.70	2.5
		ARP6PR5004SA42L	Shank	Long	≤3.5	≤1.00DCX	2.9°	88	98	1.70	2.5
		ARP6P-050A05AR	Arbor	Fine Pitch	≤3.5	≤1.00DCX	2.9°	88	98	1.70	2.0
		ARP6P-050A06AR	Arbor	Extra Fine Pitch	≤2.5	≤1.00DCX	2.9°	88	98	1.70	2.0
	63	**ARP6P-063A06AR**	Arbor	Fine Pitch	≤3.5	≤0.75DCX	3.1°	114	124	2.50	2.5
		ARP6P-063A07AR	Arbor	Extra Fine Pitch	≤2.5	≤0.75DCX	3.1°	114	124	2.50	2.5
	80	**ARP6PR08008CA**	Arbor	Fine Pitch	≤3.5	≤0.60DCX	2.3°	148	158	2.50	2.5
		ARP6PR08009CA	Arbor	Extra Fine Pitch	≤2.5	≤0.60DCX	2.3°	148	158	2.50	2.5
	100	**ARP6PR10009DA**	Arbor	Fine Pitch	≤3.5	≤0.50DCX	1.7°	188	198	2.50	2.5
		ARP6PR10011DA	Arbor	Extra Fine Pitch	≤2.5	≤0.50DCX	1.7°	188	198	2.50	2.5

Note 1) Tool body durability may weaken, when the amount of axial cutting exceeds ARP5=5mm and ARP6=6mm.
Note 2) When drilling, be careful of long scattered cutting chips
Note 3) When cutting helical holes, do not exceed the largest APMX cutting depth per one rotation.
Note 4) Calculate using the following formula for center tool tracks and ϕdc when cutting helical holes : Center tool tracks ϕdc=desired hole diameter ϕDH tool diameter ϕDCX
Note 5) For preventing trouble with cutting chip biting, especially when grooving, ramping, helical cutting, and drilling, thoroughly eliminate cutting chips with an air blower or the like.
Note 6) Cutting chip pockets are small for extra-multiple cutting and small diameter cutters.
Use with caution the ae and ap feed due to the possibility of cutting blockage.
Note 7) When cutting large ae with large diameter cutter, blockage from long cuttings is possible.
Regulate ap and feed.

■ Correction level F feed amount for 1 blade, based on axial cutting ap fluctuation

Holder	ap=0.5mm	ap=1mm	ap=1.5mm	ap=2mm	ap=2.5mm	ap=3mm	ap=3.5mm	ap=4mm	ap=5mm	ap=6mm
ARP5	2.3	1.5	1.2	1.1	1.0	0.9	0.8	0.8	0.8	–
ARP6	2.5	1.7	1.3	1.1	1.0	1.0	0.9	0.9	0.8	0.8

Note 1) Tool body durability may weaken, when the amount of axial cutting exceeds ARP5=5mm and ARP6=6mm.

MULTI FUNCTIONAL MILLING

TOOL NEWS

ARX

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel

- 15° positive, high tolerance M-class insert.
- Effective for various machining applications.
- With through air & coolant holes.

Fig.1

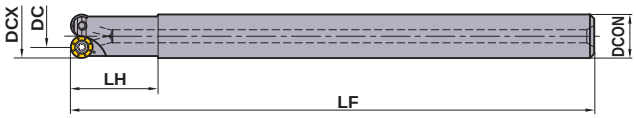


Fig.2 (Center Cutting Edge Type)

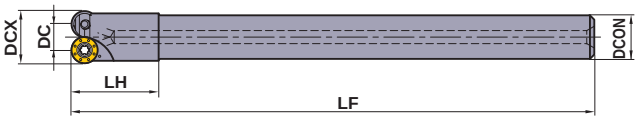
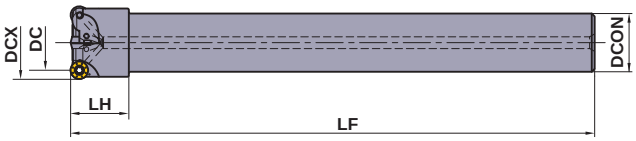


Fig.3 (Non-center Cutting Edge Type (Multi-tooth))



■STEEL SHANK TYPE

Right hand tool holder only.

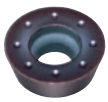
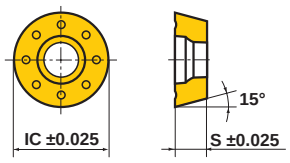
Type	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm)						Fig.	*1		
		R			RE*2	DCX	DCON	DC	LF	LH		Clamp Screw	Wrench	Insert
Center Cutting	ARX25R102SA10S	●	○	2	2.5	10	10	5	120	20	1	TPS20	TIP06F	RDMW0517M0E
	ARX30R122SA10S	●	○	2	3.0	12	10	6	120	20	2	TPS22S	TIP07FS	RDMW0620M0E
	ARX35R142SA12S	●	○	2	3.5	14	12	7	140	20	2	TPS22	TIP07FS	RDMW0724M0E
Non-center Cutting (Multi-tooth)	ARX25R122SA10S	●	○	2	2.5	12	10	7	120	20	3	TPS20	TIP06F	RDMW0517M0E
	ARX25R163SA16S	●	○	3	2.5	16	16	11	180	20	1	TPS20	TIP06F	RDMW0517M0E
	ARX30R163SA16S	●	○	3	3.0	16	16	10	180	20	1	TPS22	TIP07FS	RDMW0620M0E
	ARX25R173SA16S	●	○	3	2.5	17	16	12	180	20	1	TPS20	TIP06F	RDMW0517M0E
	ARX30R173SA16S	●	○	3	3.0	17	16	11	180	20	1	TPS22	TIP07FS	RDMW0620M0E
	ARX25R204SA20S	●	○	4	2.5	20	20	15	180	20	1	TPS20	TIP06F	RDMW0517M0E
	ARX30R203SA20S	●	○	3	3.0	20	20	14	180	20	1	TPS22	TIP07FS	RDMW0620M0E
	ARX25R224SA20S	●	○	4	2.5	22	20	17	180	20	3	TPS20	TIP06F	RDMW0517M0E
	ARX30R224SA20S	●	○	4	3.0	22	20	16	180	20	3	TPS22	TIP07FS	RDMW0620M0E
	ARX25R255SA20S	●	○	5	2.5	25	20	20	180	20	3	TPS20	TIP06F	RDMW0517M0E
	ARX30R254SA20S	●	○	4	3.0	25	20	19	180	20	3	TPS22	TIP07FS	RDMW0620M0E

*1 Clamp Torque (N • m) : TPS20=0.5, TPS22S=0.5, TPS22=0.5
*2 RE is shown for insert corner R.

INSERTS

Work Material				
	P	Steel		◐
	M	Stainless Steel		◔
	K	Cast Iron	●	✠
	H	Hardened Steel	●	◐

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Coated MP8010	Coated VP15TF	Dimensions (mm) IC	Dimensions (mm) S	Geometry
	RDMW0517M0E	●	●	5.0	1.70	
	RDMW0620M0E	●	●	6.0	1.99	
	RDMW0724M0E	●	●	7.0	2.38	

● : Inventory maintained in Japan. (10 inserts in one case)

Fig.1

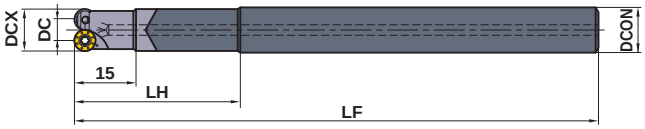


Fig.2

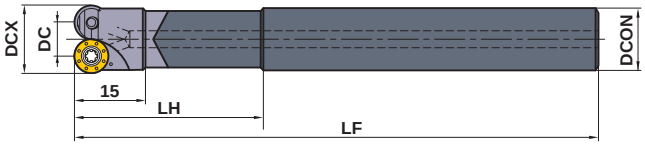
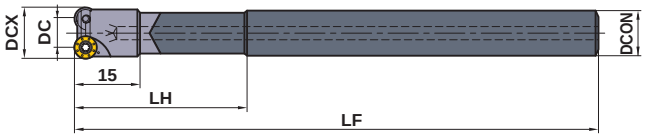


Fig.3

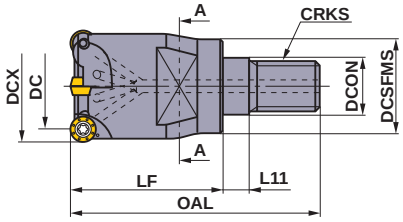


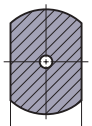
■CARBIDE SHANK TYPE

Right hand tool holder only.

Type	Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm)						Fig.	*1		
		R			RE*2	DCX	DCON	DC	LF	LH		Clamp Screw	Wrench	Insert
Center Cutting	ARX25R102SA10LW	●	○	2	2.5	10	10	5	150	40	1	TPS20	TIP06F	RDMW0517M0E
	ARX30R122SA10LW	●	○	2	3.0	12	10	6	150	40	2	TPS22S	TIP07FS	RDMW0620M0E
	ARX35R142SA12LW	●	○	2	3.5	14	12	7	170	40	2	TPS22	TIP07FS	RDMW0724M0E
Non-center Cutting (Multi-tooth)	ARX25R122SA10LW	●	○	2	2.5	12	10	7	150	40	3	TPS20	TIP06F	RDMW0517M0E

*1 Clamp Torque (N • m) : TPS20=0.5, TPS22S=0.5, TPS22=0.5
*2 RE is shown for insert corner R.





A-A section

■SCREW-IN TYPE

Right hand tool holder only.

Order Number	Stock	Coolant Hole	Number of Teeth	Dimensions (mm)										*2 WT (kg)	*1		
	R			RE*3	DCX	DCON	DC	DCSFMS	OAL	LF	L11	S10	CRKS		Clamp Screw	Wrench	Insert
ARX25R163M08A30	●	○	3	2.5	16	8.5	11	14.7	48	30	6	10	M8	0.1	TPS20	TIP06F	RDMW0517M0E
ARX25R173M08A30	●	○	3	2.5	17	8.5	12	14.5	48	30	6	10	M8	0.1	TPS20	TIP06F	RDMW0517M0E
ARX25R204M10A30	●	○	4	2.5	20	10.5	15	18.6	49	30	6	14	M10	0.2	TPS20	TIP06F	RDMW0517M0E
ARX25R224M10A30	●	○	4	2.5	22	10.5	17	18.5	49	30	6	14	M10	0.2	TPS20	TIP06F	RDMW0517M0E
ARX25R255M12A35	●	○	5	2.5	25	12.5	20	23.6	57	35	6	19	M12	0.2	TPS20	TIP06F	RDMW0517M0E
ARX30R163M08A30	●	○	3	3.0	16	8.5	11	14.6	48	30	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620M0E
ARX30R173M08A30	●	○	3	3.0	17	8.5	12	14.5	48	30	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620M0E
ARX30R203M10A30	●	○	3	3.0	20	10.5	15	18.5	49	30	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620M0E
ARX30R224M10A30	●	○	4	3.0	22	10.5	17	18.5	49	30	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620M0E
ARX30R254M12A35	●	○	4	3.0	25	12.5	20	23.4	57	35	6	19	M12	0.2	TPS22	TIP07FS	RDMW0620M0E

*1 Clamp Torque (N • m) : TPS20=0.5, TPS22=0.5
*2 WT : Tool Weight
*3 RE is shown for insert corner R.
Note 1) For screw-in type arbors, refer to page M269.

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

Note 1) The cutting conditions below are a guide only.Please make adjustments according to the machining conditions.
Note 2) Please note the follows when machining the hardened steel by using MP8010.

- Please shorten the overhang length as much as possible.
- Use with carbide shank recommended.
- Please note the setting of the depth of cut especially to prevent the fracture.
- The first recommended grade when machining hardened steel of less than 50HRC is VP15TF.

■SHOULDER MILLING • POCKET MILLING • RAMPING • COPYING

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	ARX25R○○○SA○○S ARX25R○○○M○○A○○		ARX30R○○○SA○○S ARX30R○○○M○○A○○		ARX35R○○○SA○○S	
					Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF**	180 (150−220)	≤1.0	≤0.5	≤1.2	≤0.5	≤1.5	≤0.5
	Carbon Steel • Alloy Steel	180−350HB	**VP15TF**	160 (120−200)	≤0.7	≤0.3	≤0.9	≤0.3	≤1.2	≤0.3
M	Stainless Steel	≤270HB	**VP15TF**	150 (120−180)	≤0.7	≤0.3	≤0.9	≤0.3	≤1.2	≤0.3
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP15TF**	180 (150−220)	≤1.0	≤0.5	≤1.2	≤0.5	≤1.5	≤0.5
	Ductile Cast Iron	Tensile Strength≤800MPa	**VP15TF**	120 (80−160)	≤1.0	≤0.5	≤1.2	≤0.5	≤1.5	≤0.5
H	Hardened Steel	<50HRC	**VP15TF**	80 (50−120)	≤0.5	≤0.2	≤0.7	≤0.2	≤1.0	≤0.2
		≥50HRC	**MP8010**	80 (50−120)	≤0.3	≤0.2	≤0.4	≤0.2	≤0.5	≤0.2

Note 1) For ramping process, refer to cutting criteria by type.

■SLOT MILLING

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	ARX25R○○○SA○○S ARX25R○○○M○○A○○		ARX30R○○○SA○○S ARX30R○○○M○○A○○		ARX35R○○○SA○○S	
					Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF**	180 (150−220)	≤1.0	≤0.4	≤1.2	≤0.4	≤1.5	≤0.4
	Carbon Steel • Alloy Steel	180−350HB	**VP15TF**	160 (120−200)	≤0.7	≤0.2	≤0.9	≤0.2	≤1.2	≤0.2
M	Stainless Steel	≤270HB	**VP15TF**	150 (120−180)	≤0.7	≤0.2	≤0.9	≤0.2	≤1.2	≤0.2
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP15TF**	180 (150−220)	≤1.0	≤0.4	≤1.2	≤0.4	≤1.5	≤0.4
	Ductile Cast Iron	Tensile Strength≤800MPa	**VP15TF**	120 (80−160)	≤1.0	≤0.4	≤1.2	≤0.4	≤1.5	≤0.4
H	Hardened Steel	<50HRC	**VP15TF**	80 (50−120)	≤0.5	≤0.1	≤0.7	≤0.1	≤1.0	≤0.1
		≥50HRC	**MP8010**	80 (50−120)	≤0.3	≤0.1	≤0.4	≤0.1	≤0.5	≤0.1

■PLUNGING

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	ARX25R○○○SA○○S ARX25R○○○M○○A○○		ARX30R○○○SA○○S ARX30R○○○M○○A○○		ARX35R○○○SA○○S	
					Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF**	180 (150−220)	≤2.5	≤0.3	≤3.0	≤0.3	≤3.5	≤0.3
	Carbon Steel • Alloy Steel	180−350HB	**VP15TF**	160 (120−200)	≤2.5	≤0.2	≤3.0	≤0.2	≤3.5	≤0.2
M	Stainless Steel	≤270HB	**VP15TF**	150 (120−180)	≤2.5	≤0.2	≤3.0	≤0.2	≤3.5	≤0.2
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP15TF**	180 (150−220)	≤2.5	≤0.3	≤3.0	≤0.3	≤3.5	≤0.3
	Ductile Cast Iron	Tensile Strength≤800MPa	**VP15TF**	120 (80−160)	≤2.5	≤0.3	≤3.0	≤0.3	≤3.5	≤0.3
H	Hardened Steel	<50HRC	**VP15TF**	80 (50−120)	≤2.5	≤0.1	≤3.0	≤0.1	≤3.5	≤0.1
		≥50HRC	**MP8010**	80 (50−120)	≤2.5	≤0.1	≤3.0	≤0.1	≤3.5	≤0.1

■HELICAL DRILLING

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	ARX25R○○○SA○○S ARX25R○○○M○○A○○		ARX30R○○○SA○○S ARX30R○○○M○○A○○		ARX35R○○○SA○○S	
					DOC/pass **ap** (mm/pass)	Feed per Tooth **fz** (mm/t.)	DOC/pass **ap** (mm/pass)	Feed per Tooth **fz** (mm/t.)	DOC/pass **ap** (mm/pass)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF**	180 (150−220)	≤1.0	≤0.3	≤1.0	≤0.3	≤1.0	≤0.3
	Carbon Steel • Alloy Steel	180−350HB	**VP15TF**	160 (120−200)	≤0.7	≤0.2	≤0.9	≤0.2	≤1.0	≤0.2
M	Stainless Steel	≤270HB	**VP15TF**	150 (120−180)	≤0.7	≤0.2	≤0.9	≤0.2	≤1.0	≤0.2
K	Gray Cast Iron	Tensile Strength≤350MPa	**VP15TF**	180 (150−220)	≤1.0	≤0.3	≤1.0	≤0.3	≤1.0	≤0.3
	Ductile Cast Iron	Tensile Strength≤800MPa	**VP15TF**	120 (80−160)	≤1.0	≤0.3	≤1.0	≤0.3	≤1.0	≤0.3
H	Hardened Steel	<50HRC	**VP15TF**	80 (50−120)	≤0.5	≤0.1	≤0.7	≤0.1	≤1.0	≤0.1
		≥50HRC	**MP8010**	80 (50−120)	≤0.3	≤0.1	≤0.4	≤0.1	≤0.5	≤0.1

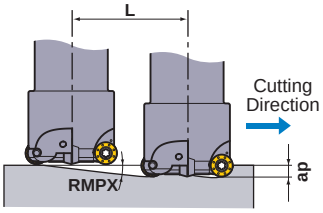
Note 1) For helical drilling, refer to the maximum capacities on page M195.

CUTTING MODE MAXIMUM CAPACITIES

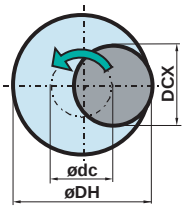
■RAMPING

Finding a cutters' distance moved **"L"** when depth of cut reaches **"ap"** at a ramping angle of **"α°"**.

L=ap/tan α (mm)



■HELICAL DRILLING



- How to derive a locus of the center of the tool.

ødc = øDH - DCX

Locus of the center of the tool / Desired hole diameter / Cutting edge diameter

- For the depth of cut per cycle, refer to the cutting conditions for helical drilling.
- Set the machine spindle revolution so that the tool is rotating and cutting in a down cut direction.

Type	Order Number	Tool Diameter **DCX** (mm)	Corner **RE** (mm)	Number of Teeth	Ramping			Helical Drilling	
					RMPX *1	**APMX** (mm)*2	Distance L at Depth of Cut of **ap L** (mm)	Min. Hole Diameter **DH min.** (mm)	Max. Hole Diameter **DH max.** (mm)
Center Cutting	**ARX25R102SA10S**	10	2.5	2	90°	2.5	0	15	19
	ARX25R102SA10LW	10	2.5	2	90°	2.5	0	15	19
	ARX30R122SA10S	12	3.0	2	90°	3.0	0	18	23
	ARX30R122SA10LW	12	3.0	2	90°	3.0	0	18	23
	ARX35R142SA12S	14	3.5	2	90°	3.5	0	21	27
	ARX35R142SA12LW	14	3.5	2	90°	3.5	0	21	27
Non-center Cutting (Multi-tooth)	**ARX25R122SA10S**	12	2.5	2	27.17°	2.5	4.87	19	23
	ARX25R122SA10LW	12	2.5	2	27.17°	2.5	4.87	19	23
	ARX25R163M08A30	16	2.5	3	13.70°	2.5	10.76	27	31
	ARX25R163SA16S	16	2.5	3	13.70°	2.5	10.26	27	31
	ARX30R163M08A30	16	3.0	3	21.25	3.0	7.71	26	31
	ARX30R163SA16S	16	3.0	3	21.25°	3.0	7.71	26	31
	ARX25R173M08A30	17	2.5	3	12.22°	2.5	11.54	29	33
	ARX25R173SA16S	17	2.5	3	12.22°	2.5	11.54	29	33
	ARX30R173M08A30	17	3.0	3	18.42°	3.0	9.01	28	33
	ARX30R173SA16S	17	3.0	3	18.42°	3.0	9.01	28	33
	ARX30R203M10A30	20	3.0	3	13.21°	3.0	12.78	34	39
	ARX30R203SA20S	20	3.0	3	13.21°	3.0	12.78	34	39
	ARX25R204M10A30	20	2.5	4	9.23°	2.5	15.38	35	39
	ARX25R204SA20S	20	2.5	4	9.23°	2.5	15.38	35	39
	ARX25R224M10A30	22	2.5	4	7.94°	2.5	17.92	39	43
	ARX25R224SA20S	22	2.5	4	7.94°	2.5	17.92	39	43
	ARX30R224M10A30	22	3.0	4	11.13°	3.0	15.25	38	43
	ARX30R224SA20S	22	3.0	4	11.13°	3.0	15.25	38	43
	ARX30R254M12A35	25	3.0	4	9.01°	3.0	18.92	44	49
	ARX30R254SA20S	25	3.0	4	9.01°	3.0	18.92	44	49
	ARX25R255M12A35	25	2.5	5	6.57°	2.5	21.71	45	49
	ARX25R255SA20S	25	2.5	5	6.57°	2.5	21.71	45	49

*1 RMPX : Max.Ramping Angle
*2 APMX : Max. Depth of Cut

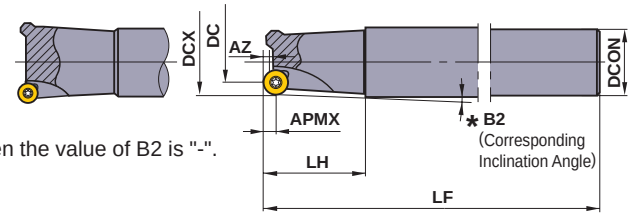
MULTI FUNCTIONAL MILLING

TOOL NEWS

R KAPR

BRP

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	Hardened Steel



When the value of B2 is "-".

*Please allow for an inclination angle of B2+1°

- **11°positive insert.**
- **Round shape insert with a strong cutting edge.**
- **Wide range of tools available.**
- **Suitable for mould machining.**

■SHANK TYPE

Right hand tool holder only.

Cutting Edge R (APMX)	Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) DCX	DC	LF	DCON	LH	AZ	B2	APMX	* Clamp Screw	Wrench	Insert
4	R	**BRP4NR121S12**	●	1	12	3.8	85	12	25	0.2	3.0°	4	CS250560T	TKY08F	①RPMW08T2M0◌ ②RPMT08T2M0E-JS
		BRP4NR161S16	●	1	16	7.8	85	16	25	1.0	3.0°	4	CS250560T	TKY08F	
		BRP4NR202S20	●	2	20	11.8	100	20	30	2.0	2.42°	4	CS250560T	TKY08F	
		BRP4NR253S25	●	3	25	16.8	115	25	35	2.0	2.03°	4	CS250560T	TKY08F	
	L	**BRP4NR121LS12**	●	1	12	3.8	150	12	70	0.2	0.95°	4	CS250560T	TKY08F	
		BRP4NR161LS16	●	1	16	7.8	150	16	70	1.0	0.95°	4	CS250560T	TKY08F	
		BRP4NR202LS20	●	2	20	11.8	180	20	100	2.0	0.65°	4	CS250560T	TKY08F	
		BRP4NR253LS25	●	3	25	16.8	180	25	100	2.0	0.65°	4	CS250560T	TKY08F	
	EL	**BRP4NR202ELS20**	●	2	20	11.8	250	20	130	2.0	0.5°	4	CS250560T	TKY08F	
		BRP4NR253ELS25	●	3	25	16.8	250	25	130	2.0	0.5°	4	CS250560T	TKY08F	
5	R	**BRP5NR161S16**	●	1	16	5.8	85	16	25	0.3	3.15°	5	CS350760T	TKY15F	①RPMW10T3M0◌ ②RPMT10T3M0E-JS
		BRP5NR201S20	●	1	20	9.8	100	20	30	1.2	2.52°	5	CS350760T	TKY15F	
		BRP5NR252S25	●	2	25	14.8	115	25	35	2.5	2.1°	5	CS350860T	TKY15F	
		BRP5NR323S32	●	3	32	21.8	125	32	45	2.5	1.57°	5	CS350860T	TKY15F	
	L	**BRP5NR161LS16**	●	1	16	5.8	150	16	70	0.3	0.97°	5	CS350760T	TKY15F	
		BRP5NR201LS20	●	1	20	9.8	180	20	100	1.2	0.67°	5	CS350760T	TKY15F	
		BRP5NR252LS25	●	2	25	14.8	180	25	100	2.5	0.67°	5	CS350860T	TKY15F	
		BRP5NR323LS32	●	3	32	21.8	200	32	120	2.5	0.55°	5	CS350860T	TKY15F	
	EL	**BRP5NR252ELS25**	●	2	25	14.8	250	25	130	2.5	0.5°	5	CS350860T	TKY15F	
		BRP5NR323ELS32	●	3	32	21.8	300	32	180	2.5	0.34°	5	CS350860T	TKY15F	

Note 1) **R :** Regular type **L :** Long type **EL :** Extra long type

* Clamp Torque (N • m) : CS250560T=1.0, CS350760T=3.5, CS350860T=3.5

● : **Inventory maintained in Japan.**

Cutting Edge R (APMX)	Type	Order Number	Stock	Number of Teeth	Dimensions (mm)								*		① ②
			R		DCX	DC	LF	DCON	LH	AZ	B2	APMX	Clamp Screw	Wrench	Insert
6	R	**BRP6PR322S32**	●	2	32	19.8	125	32	45	4	1.62°	6	TS43	TKY15D	①RPMW1204M0□ ②RPMT1204M0E-JS
		BRP6PR403S32	●	3	40	27.9	125	32	45	4	–	6	TS43	TKY15D	
		BRP6PR504S32	●	4	50	37.8	150	32	50	4	–	6	TS43	TKY15D	
		BRP6PR504S42	●	4	50	37.8	150	42	50	4	–	6	TS43	TKY15D	
	L	**BRP6PR322LS32**	●	2	32	19.8	200	32	120	4	0.55°	6	TS43	TKY15D	
		BRP6PR403LS32	●	3	40	27.9	200	32	120	4	–	6	TS43	TKY15D	
		BRP6PR504LS32	●	4	50	37.8	250	32	150	4	–	6	TS43	TKY15D	
		BRP6PR504LS42	●	4	50	37.8	250	42	150	4	–	6	TS43	TKY15D	
	EL	**BRP6PR322ELS32**	●	2	32	19.8	300	32	50	4	1.43°	6	TS43	TKY15D	
		BRP6PR403ELS32	●	3	40	27.9	300	32	50	4	–	6	TS43	TKY15D	
		BRP6PR403ELS42	●	3	40	27.9	300	42	50	4	2.73°	6	TS43	TKY15D	
		BRP6PR504ELS42	●	4	50	37.8	300	42	50	4	–	6	TS43	TKY15D	
8	R	**BRP8PR402S32**	●	2	40	23.8	125	32	45	5.5	–	8	TS54	TKY25D	①RPMW1606M0□ ②RPMT1606M0E-JS
		BRP8PR503S32	●	3	50	33.8	150	32	50	5.5	–	8	TS54	TKY25D	
		BRP8PR503S42	●	3	50	33.8	150	42	50	5.5	–	8	TS54	TKY25D	
		BRP8PR634S32	●	4	63	46.8	150	32	50	5.5	–	8	TS54	TKY25D	
		BRP8PR634S42	●	4	63	46.8	150	42	50	5.5	–	8	TS54	TKY25D	
	L	**BRP8PR402LS32**	●	2	40	23.8	200	32	120	5.5	–	8	TS54	TKY25D	
		BRP8PR503LS32	●	3	50	33.8	250	32	150	5.5	–	8	TS54	TKY25D	
		BRP8PR503LS42	●	3	50	33.8	250	42	150	5.5	–	8	TS54	TKY25D	
		BRP8PR634LS32	●	4	63	46.8	250	32	150	5.5	–	8	TS54	TKY25D	
		BRP8PR634LS42	●	4	63	46.8	250	42	150	5.5	–	8	TS54	TKY25D	
	EL	**BRP8PR402ELS32**	●	2	40	23.8	300	32	50	5.5	–	8	TS54	TKY25D	
		BRP8PR402ELS42	●	2	40	23.8	300	42	50	5.5	2.87°	8	TS54	TKY25D	
		BRP8PR503ELS42	●	3	50	33.8	300	42	50	5.5	–	8	TS54	TKY25D	
		BRP8PR634ELS42	●	4	63	46.8	300	42	50	5.5	–	8	TS54	TKY25D	

Note 1) **R :** Regular type **L :** Long type **EL :** Extra long type
* Clamp Torque (N • m) : TS43=3.5, TS54=7.5

Fig.1
ø40

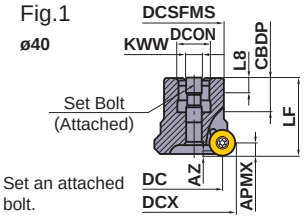


Fig.2
ø50
ø63
ø80

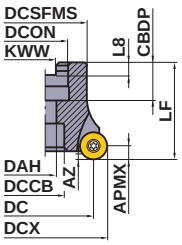
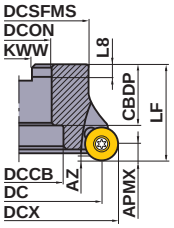


Fig.3
ø100



Right hand tool holder only.

■ARBOR TYPE

GAMP:-7°—+5° GAMF:-15°—0°

Cutting Edge R (APMX)	Order Number	Stock R	Number of Teeth	Dimensions (mm) DCX	DC	DCSFMS	LF	DCON	CBDP	DAH	DCCB	KWW	L8	WT* (kg)	Max. Depth of Cut (mm) APMX	AZ	Fig.
6	**BRP6P-040A03R**	●	3	40	27.9	33.3	40	16	18	—	—	8.4	5.6	0.4	6	4	1
	BRP6P-050A04R	●	4	50	37.8	43.1	50	22	20	11	—	10.4	6.3	0.5	6	4	2
	BRP6PR05004B	●	4	50	37.8	43.1	63	22.225	29	11	—	8.4	5	0.5	6	4	2
	BRP6P-063A05R	●	5	63	50.8	56.1	50	22	20	11	—	10.4	6.3	0.7	6	4	2
	BRP6PR06305B	●	5	63	50.8	56.1	63	22.225	29	11	—	8.4	5	0.7	6	4	2
	BRP6PR08006C	●	6	80	67.8	72.8	50	25.4	26	13	—	9.5	6	1.2	6	4	2
8	**BRP8P-063A04R**	●	4	63	46.8	54.5	50	22	20	11	—	10.4	6.3	0.7	8	5.5	2
	BRP8PR06304B	●	4	63	46.8	54.5	63	22.225	29	11	—	8.4	5	0.7	8	5.5	2
	BRP8PR08005C	●	5	80	63.8	70.9	50	25.4	26	13	—	9.5	6	1.2	8	5.5	2
	BRP8PR10006D	●	6	100	83.8	90.6	50	31.75	32	—	45	12.7	8	1.6	8	5.5	3

* WT : Tool Weight

SPARE PARTS

Tool Holder Number	* Clamp Screw	Wrench	Set Bolt	① ② Insert
BRP6P-040A03R	TS43	TKY15D	HDS08030	①RPMW1204M0◌ ②RPMT1204M0E-JS
BRP6P-050A04R **ı** **BRP6P-R08006C**	TS43	TKY15D	—	
BRP8P	TS54	TKY25D	—	①RPMW1606M0◌ ②RPMT1606M0E-JS

* Clamp Torque (N • m) : TS43=3.5, TS54=7.5

M

INDEXABLE MILLING

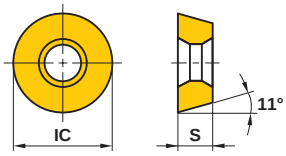
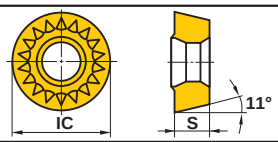
● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			F7030	VP15TF			NX4545		UTi20T	
	P	Steel	◐	◐			◐		◐	
	M	Stainless Steel	◔	◔			◔		◔	
	K	Cast Iron		✣					✣	
	S	Heat-resistant Alloy, Titanium Alloy		◐						
	H	Hardened Steel		◔						

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **T :** Chamfer

Shape	Order Number	Class	Honing	Coated				Cermet		Carbide		Dimensions (mm)		Geometry
				F7030	VP15TF			NX4545		UTi20T		IC	S	
	RPMW08T2M0T	M	T		●							8	2.78	
	RPMW10T3M0E	M	E	●				●				10	3.97	
	RPMW10T3M0T	M	T		●							10	3.97	
	RPMW1204M0E	M	E	●				●		●		12	4.76	
	RPMW1204M0T	M	T		●							12	4.76	
	RPMW1606M0E	M	E	●						●		16	6.35	
	RPMW1606M0T	M	T		●							16	6.35	
	RPMT08T2M0E-JS	M	E	●	●							8	2.78	
	RPMT10T3M0E-JS	M	E	●	●							10	3.97	
	RPMT1204M0E-JS	M	E	●	●					●		12	4.76	
	RPMT1606M0E-JS	M	E	●	●							16	6.35	

RECOMMENDED CUTTING CONDITIONS

■ CUTTING SPEED (m/min)

	Work Material	Hardness	Coated		Carbide
			F7030	VP15TF	UTi20T
P	Mild Steel	≤180HB	**250 (200—300)**	250 (200—300)	150 (100—200)
	Carbon Steel Alloy Steel	180—280HB	**180 (130—220)**	180 (130—220)	140 (100—170)
		280—380HB	**160 (110—190)**	160 (110—190)	100 (70—120)
	Pre-Hardened Steel	35—45HRC	**120 (80—140)**	120 (80—140)	90 (60—100)
	High Alloy Steel	300HB	**130 (90—160)**	130 (90—160)	100 (70—120)
M	Stainless Steel	≤260HB	**180 (130—220)**	180 (130—220)	140 (100—170)
K	Gray Cast Iron	Tensile Strength ≤350MPa	—	**170 (130—220)**	140 (100—170)
	Ductile Cast Iron	Tensile Strength 360—500MPa	—	**140 (100—180)**	120 (80—140)
		Tensile Strength 500—800MPa	—	**110 (80—140)**	90 (70—110)
H	Hardened Steel	45—60HRC	—	**60 (50—100)**	60 (40—70)

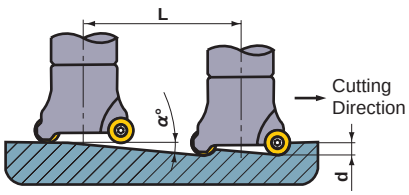
Note 1) Cutting speeds shown in bold type are for the recommended first choice grades.

■ FEED PER TOOTH (mm/t.)

Type	Depth of Cut (mm)							
	1	2	3	4	5	6	7	8
BRP4	0.40	0.30	0.20	0.10	—	—	—	—
BRP5	0.40	0.35	0.30	0.20	0.10	—	—	—
BRP6	0.50	0.40	0.30	0.25	0.23	0.20	—	—
BRP8	0.60	0.50	0.45	0.40	0.33	0.30	0.25	0.20

RAMPING

■ RAMPING ANGLE AND MACHINING LENGTH



Formula to find cutting length "L" at maximum ramping angle.

$$L = \frac{d}{\tan \alpha} \text{ (mm)}$$

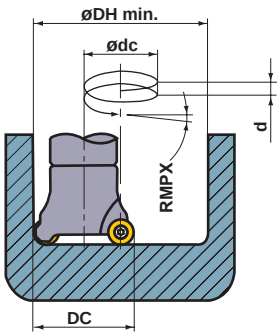
Type	Cutting Edge Diameter (ϕ)	Max. Ramping Angle RMPX	tan α	Cutting Length L at Max. Ramping Angle L(mm)⋆				
				d=2mm	d=4mm	d=5mm	d=6mm (max.)	d=8mm (max.)
BRP4	12	5.02°	0.088	22	45	—	—	—
	16	12.2°	0.216	9	18	—	—	—
	20	14.52°	0.259	7	15	—	—	—
	25	8.8°	0.155	12	25	—	—	—
BRP5	16	4.52°	0.079	25	50	63	—	—
	20	11.4°	0.202	9	19	24	—	—
	25	14.4°	0.257	7	15	19	—	—
	32	8.37°	0.147	13	27	33	—	—
BRP6	32	15.91°	0.285	7	14	17	21	—
	40	10.29°	0.181	11	22	27	33	—
	50	7.12°	0.125	16	32	40	48	—
	63	5.08°	0.089	22	44	56	67	—
	80	3.69°	0.064	31	62	77	93	—
BRP8	40	18.86°	0.342	5	11	14	17	23
	50	11.91°	0.211	9	18	23	28	37
	63	8.01°	0.141	14	28	35	42	56
	80	5.60°	0.098	20	40	50	61	81
	100	4.13°	0.072	27	55	69	83	110

⋆ "L" value is approximate rounded value.

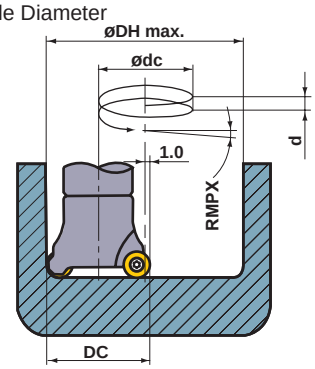
HELICAL DRILLING

■ RELATIONSHIP BETWEEN HOLE DIAMETER AND DEPTH OF CUT

Minimum Hole Diameter



Maximum Hole Diameter



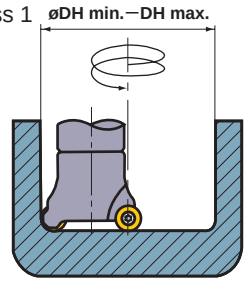
Type	Cutting Edge Diameter DC (mm)	*1 øDH min.	*2 ødc	Ramping Angle RMPX d=2mm	d=4mm	d=5mm	d=6mm	d=8mm	*1 øDH max.	*2 ødc	Ramping Angle RMPX d=2mm	d=4mm	d=5mm	d=6mm	d=8mm
BRP4	12	16	4	d=1mm,RMPX=4.55°					22	10	3.64°	–	–	–	–
	16	24	8	4.55°	9.10°	–	–	–	30	14	2.60°	5.20°	–	–	–
	20	32	12	3.04°	6.08°	–	–	–	38	18	2.03°	4.05°	–	–	–
	25	42	17	2.15°	4.29°	–	–	–	48	23	1.59°	3.17°	–	–	–
BRP5	16	22	6	d=1mm,RMPX=3.04°					30	14	2.60°	5.20°	6.50°	–	–
	20	30	10	3.64°	7.26°	9.10°	–	–	38	18	2.03°	4.05°	5.08°	–	–
	25	40	15	2.43°	4.85°	6.08°	–	–	48	23	1.59°	3.17°	3.98°	–	–
	32	54	22	1.66°	3.31°	4.15°	–	–	62	30	1.22°	2.43°	3.04°	–	–
BRP6	32	52	20	1.82°	3.64°	4.55°	5.45°	–	62	30	1.22°	2.43°	3.04°	3.64°	–
	40	68	28	1.30°	2.60°	3.25°	3.90°	–	78	38	0.96°	1.92°	2.40°	2.88°	–
	50	88	38	0.96°	1.92°	2.40°	2.88°	–	98	48	0.78°	1.52°	1.90°	2.28°	–
	63	114	51	0.72°	1.43°	1.79°	2.14°	–	124	61	0.60°	1.20°	1.49°	1.79°	–
	80	148	68	0.54°	1.07°	1.34°	1.61°	–	158	78	0.47°	0.94°	1.17°	1.40°	–
BRP8	40	64	24	1.52°	3.04°	3.79°	4.55°	6.06°	78	38	0.96°	1.92°	2.40°	2.88°	3.38°
	50	84	34	1.07°	2.14°	2.68°	3.22°	4.28°	98	48	0.76°	1.52°	1.90°	2.28°	3.04°
	63	110	47	0.78°	1.55°	1.94°	2.33°	3.10°	124	61	0.60°	1.20°	1.49°	1.79°	2.39°
	80	144	64	0.57°	1.14°	1.42°	1.71°	2.28°	158	78	0.47°	0.94°	1.17°	1.40°	1.87°
	100	184	84	0.43°	0.87°	1.09°	1.30°	1.74°	198	98	0.37°	0.74°	0.93°	1.12°	1.49°

*1 DH=Hole Diameter : ϕ(mm) *2 dc=Tool Pass : ϕ(mm)

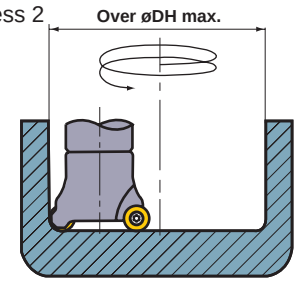
BRP4 DH min. (Minimum Hole Diameter)=(DC - 4)×2, DH max. (Maximum Hole Diameter)=(DC - 1)×2, d max. (Maximum Depth of Cut)=4(mm)
BRP5 DH min. (Minimum Hole Diameter)=(DC - 5)×2, DH max. (Maximum Hole Diameter)=(DC - 1)×2, d max. (Maximum Depth of Cut)=5(mm)
BRP6 DH min. (Minimum Hole Diameter)=(DC - 6)×2, DH max. (Maximum Hole Diameter)=(DC - 1)×2, d max. (Maximum Depth of Cut)=6(mm)
BRP8 DH min. (Minimum Hole Diameter)=(DC - 8)×2, DH max. (Maximum Hole Diameter)=(DC - 1)×2, d max. (Maximum Depth of Cut)=8(mm)
dc=(Tool Pass)**=DH-D**

◀Note▶ When machining a hole larger than DH max., first machine a pilot hole smaller than DH max. before enlarging to the required size as shown above.

Process 1 **øDH min.–DH max.**



Process 2 **Over øDH max.**



DEEP SHOULDER MILLING

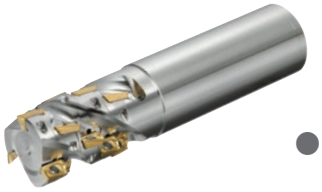
TOOL NEWS

90° KAPR

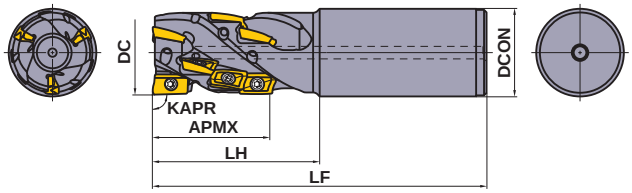
APX3000 NEW

LONG CUTTING EDGE

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



- **High accuracy, high quality vertical wall.**
- **Low cutting force insert.**



Right hand tool holder only.

■ SHANK TYPE

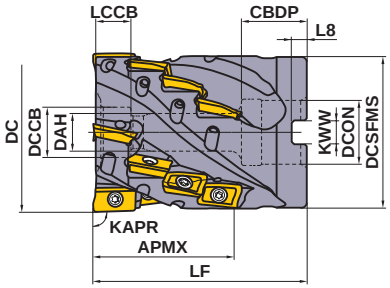
DC (mm)	Order Number	Stock R	Coolant Hole	Number of Flutes	Total	Dimensions(mm) DCON	LF	LH	WT (kg)	APMX (mm)	Insert Type
20	**APX3KR2004SN20S028A**	●	–	1	4	20	125	45	0.27	28	AO□T12
25	**APX3KR2506SA25S028A**	●	○	2	6	25	125	45	0.40	28	AO□T12
25	**APX3KR2508SA25M037A**	●	○	2	8	25	130	50	0.41	37	AO□T12
32	**APX3KR3208SA32S037A**	●	○	2	8	32	130	50	0.70	37	AO□T12
32	**APX3KR3210SA32M046A**	●	○	2	10	32	140	60	0.74	46	AO□T12
32	**APX3KR3212SA32S037A**	●	○	3	12	32	130	50	0.67	37	AO□T12
32	**APX3KR3215SA32M046A**	●	○	3	15	32	140	60	0.71	46	AO□T12
40	**APX3KR4015SA42S046A**	●	○	3	15	42	140	60	1.24	46	AO□T12
40	**APX3KR4018SA42M055A**	●	○	3	18	42	150	70	1.31	55	AO□T12

Note 1) When using inserts with corner radius RE≥2.4mm, machining of the holder is required as shown on page M204.
Note 2) Corner radius RE 0.8mm is recommended for the peripheral cutting edges except the bottom cutting edge (end cutting).
Inserts RE 0.2mm and 0.4mm can also be used.

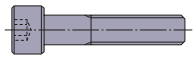
SPARE PARTS

DC (mm)	Tool Holder Type	Clamp Screw *	Wrench	Anti-seize Lubricant
20	**APX3KR20**	TPS25	TIP07F	MK1KS
25	**APX3KR25**	TPS25-1	TIP07F	MK1KS
32	**APX3KR32**	TPS25-1	TIP07F	MK1KS
40	**APX3KR40**	TPS25-1	TIP07F	MK1KS
40	**APX3K-040**	TPS25-1	TIP07F	MK1KS
50	**APX3K-050**	TPS25-1	TIP07F	MK1KS

* Clamp Torque (N • m) : TPS25 = 1.0, TPS25-1 = 1.0



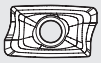
Right hand tool holder only.

DC	Set Bolt	Geometry
40	HSC08040	
50	HSC10045	

■ SHELL TYPE

With Coolant Hole

KAPR：90°
GAMP：+12°　GAMF：+6°

DC (mm)	Order Number	Stock R	Number of Flutes	Total	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	 Insert Type
40	**APX3K-040A16A037RA**	●	4	16	50	16	0.25	37	AO◌T12
50	**APX3K-050A20A046RA**	●	4	20	60	22	0.54	46	AO◌T12

Note 1) When using inserts with corner radius RE≥2.4mm, machining of the holder is required as shown on page M204.
Note 2) Corner radius RE 0.8mm is recommended for the peripheral cutting edges except the bottom cutting edge (end cutting).
Inserts RE 0.2mm and 0.4mm can also be used.
Note 3) Coolant can be supplied from the end face of the centering location bore in the arbor. However, cannot be supplied from the set bolt.

Mounting Dimensions

DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	DCCB	LCCB	DCSFMS	KWW	L8
40	**APX3K-040A16A037RA**	16	18	9	14	9.9	38.5	8.4	5.6
50	**APX3K-050A20A046RA**	22	20	11	17	11.9	48.4	10.4	6.3

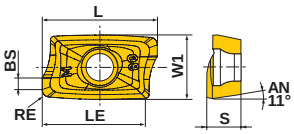
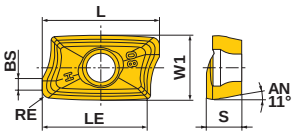
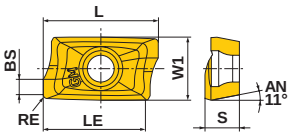
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

Work Material		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15
P	Steels		◐	✠				◐	◐	
M	Stainless Steels				◔			◔	◔	
K	Cast Ions	◐						✠	✠	
N	Non-ferrous Metals									◐
S	Heat Resistant Alloys, Titanium Alloys					◐	✠	◐	✠	
H	Hardened Steels							◔		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

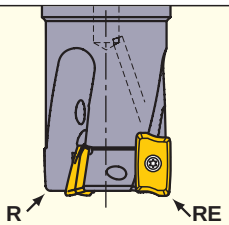
Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15		L	LE	W1	S	BS	RE *	Geometry
				Coated								Carbide		Dimensions (mm)						
General **M** Breaker	**AOMT123602PEER-M**	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.8	0.2	
	AOMT123604PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.2	0.8	
	AOMT123610PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	1.0	1.0	
	AOMT123612PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.8	1.2	
	AOMT123616PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	1.6	
	AOMT123620PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	2.0	
	AOMT123624PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	2.4	
	AOMT123630PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	3.0	
	AOMT123632PEER-M	M	E		●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	3.2	
Strong Cutting Edge Type **H** Breaker	**AOMT123604PEER-H**	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	1.6	0.4	
	AOMT123608PEER-H	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	1.2	0.8	
	AOMT123616PEER-H	M	E	●	●	●	●	●	●	●	●			12	10	6.6	3.6	0.4	1.6	
For Machining of Aluminium Alloys **GM** Breaker	**AOGT123602PEFR-GM**	G	F									●		12	10	6.6	3.6	1.8	0.2	
	AOGT123604PEFR-GM	G	F									●		12	10	6.6	3.6	1.6	0.4	
	AOGT123608PEFR-GM	G	F									●		12	10	6.6	3.6	1.2	0.8	

* Corner radius RE is different from the work material of R shape depending on the axial rake angle of the body.

Note on Use of Inserts with Large Corner Radii

When using inserts with corner radius RE≥R2.4mm, please machine the holder with a radius form as shown on the right table.



RE (mm)	R (mm)
2.4	1.9
3.0	2.5
3.2	2.7

R : Holder End Radius
RE : Insert Corner Radius

RECOMMENDED CUTTING CONDITIONS

Cutting Speed

(mm)

Work Material		Insert Grade Priority 1st	Insert Grade Priority 2nd	Breaker		ae ≤0.25DC	ae 0.25—0.75DC	ae DC (Slot)
						vc (m/min)		
P	Mild Steels	MP6120	VP15TF	M	H	180(140—220)	150(110—180)	120(100—140)
		MP6130	VP20RT	M	H	160(120—200)	130(100—160)	100(80—120)
	Carbon Steels Alloy Steels, Alloy Tool Steels	MP6120	VP15TF	M	H	150(100—200)	120(90—150)	100(80—120)
		MP6130	VP20RT	M	H	130(90—170)	90(70—110)	80(60—100)
	Pre-hardened Steels	MP6120	VP15TF	M	H	120(80—160)	100(70—130)	90(50—120)
		MP6130	VP20RT	M	H	100(70—130)	90(60—120)	70(50—100)
M	Stainless Steels	MP7130	—	M	—	150(120—180)	120(100—140)	100(80—120)
K	Gray Cast Irons	MC5020	—	H	—	200(150—250)	180(150—210)	—
		VP15TF	—	M	H	180(120—240)	150(100—200)	100(60—140)
	Ductile Cast Irons	VP15TF	—	M	H	160(120—200)	140(100—180)	80(60—100)
N	Aluminium Alloys	TF15	MP9120	GM	M	400(200—800)	400(200—800)	400(200—800)
S	Titanium Alloys	MP9130	—	M	—	40(30—60)	—	40(30—60)
		MP9120	—	M	—	50(40—70)	—	50(40—70)
	Heat Resistant Alloys	MP9120	VP15TF	M	H	40(30—60)	—	40(30—60)
		MP9130	VP20RT	M	H	30(20—40)	—	30(20—40)

Depth of Cut / Feed per Tooth

(mm)

Work Material		Characteristics	ae	DC ø20 ap	DC ø20 fz (mm/t.)	DC ø25 ap	DC ø25 fz (mm/t.)	DC ø32—ø50 ap	DC ø32—ø50 fz (mm/t.)
P	Mild Steels	≤180HB	≤0.25DC	≤28	0.15	≤37	0.17	≤55	0.2
			0.25-0.75DC	≤28	0.12	≤37	0.15	≤55	0.17
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
	Carbon Steels Alloy Steels	180—280HB	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
	Tool Alloy Steels	≤350HB (Annealing)	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
	Pre-hardened Steels	35—45HRC	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
M	Ferritic and Martensitic Stainless Steels	—	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
	Duplex Stainless Steels	≤280HB	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
	Precipitation Hardening Stainless Steels	<450HB	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
K	Gray Cast Irons	Tensile Strength ≤350MPa	≤0.25DC	≤28	0.15	≤37	0.17	≤55	0.2
			0.25-0.75DC	≤28	0.12	≤37	0.15	≤55	0.17
			DC (Slot)	≤18	0.1	≤18	0.1	≤18	0.1
	Ductile Cast Irons	Tensile Strength ≤800MPa	≤0.25DC	≤28	0.12	≤37	0.15	≤55	0.17
			0.25-0.75DC	≤28	0.1	≤37	0.12	≤55	0.15
			DC (Slot)	≤18	0.08	≤18	0.08	≤18	0.08
N	Aluminium Alloys	—	≤0.25DC	≤28	0.15	≤37	0.17	≤55	0.2
			0.25-0.75DC	—	—	≤9	0.17	≤9	0.2
			DC (Slot)	—	—	≤9	0.17	≤9	0.2
S	Titanium Alloys	≤350HB	≤0.25DC	≤28	0.1	≤37	0.1	≤55	0.1
			0.25-0.75DC	—	—	—	—	—	—
			DC (Slot)	≤18	0.06	≤18	0.06	≤18	0.06
	Heat Resistant Alloys	—	≤0.25DC	≤28	0.08	≤37	0.08	≤55	0.08
			0.25-0.75DC	—	—	—	—	—	—
			DC (Slot)	≤18	0.05	≤18	0.05	≤18	0.05

Note 1) The above cutting conditons are determined based on high rigidity machine and work materials, where no vibration occurred.
Please adjust processing conditions if the vibration is generated.

DEEP SHOULDER MILLING

TOOL NEWS

90° KAPR

APX4000

LONG CUTTING EDGE

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	

- **High accuracy, high quality vertical wall.**
- **Low cutting force insert.**

Fig.1

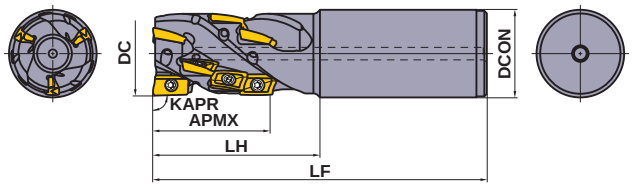
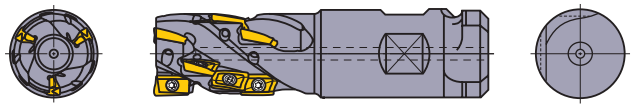


Fig.2



■ SHANK TYPE

KAPR : 90°
With Coolant Hole

Right hand tool holder only.

DC (mm)	Order Number	Stock R	Number of Flutes	Total	Dimensions(mm) DCON	LF	LH	WT (kg)	APMX (mm)	Fig.	Insert Type
40	**APX4KR4008SA42S056A**	●	2	8	42	160	80	1.54	56	1	AO◌T18
40	**APX4KR4012SA42S056A**	●	3	12	42	160	80	1.54	56	1	AO◌T18
50	**APX4KR5012WA508S056A**	●	3	12	50.8	160	80	1.76	56	2	AO◌T18
50	**APX4KR5018WA508M084A**	●	3	18	50.8	190	110	2.18	84	2	AO◌T18

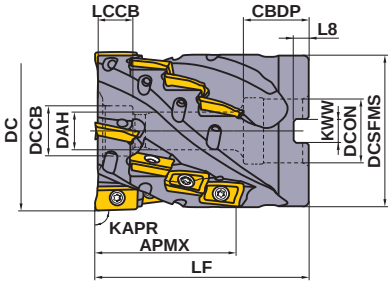
Note 1) When using inserts with corner radius RE≥3.2mm, machining of the holder is required as shown on page M208.
Note 2) Only corner radius RE 0.4mm and 0.8mm can be used for the peripheral cutting edges expect the bottom cutting edge (the end cuttting edge).

SPARE PARTS

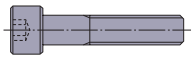
*		
Clamp Screw	Wrench	Anti-seize Lubricant
TPS43	TIP15W	MK1KS

* Clamp Torque (N • m) : TPS43 = 4.0

● : **Inventory maintained in Japan.**



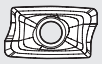
Right hand tool holder only.

DC	Set Bolt	Geometry
50	HSC10050	
63	HSC12070	

■ SHELL TYPE

With Coolant Hole

KAPR :90°
GAMP:+12° GAMF:+6°

DC (mm)	Order Number	Stock R	Number of Flutes	Total	Dimensions(mm) LF	Dimensions(mm) DCON	WT (kg)	APMX (mm)	 Insert Type
50	**APX4K-050A09A042RA**	●	3	9	65	22	0.75	42	AO◌T18
63	**APX4KR06316CA056A**	●	4	16	85	25.4	1.66	56	AO◌T18
63	**APX4K-063A16A056RA**	●	4	16	85	27	1.63	56	AO◌T18

Note 1) When using inserts with corner radius RE≥3.2mm, machining of the holder is required as shown on page M208.
Note 2) Only corner radius RE 0.4mm and 0.8mm can be used for the peripheral cutting edges expect the bottom cutting edge (the end cuttting edge).
Note 3) Coolant can be supplied from the end face of the centering location bore in the arbor. However, cannot be supplied from the set bolt.

Mounting Dimensions

DC (mm)	Order Number	Dimensions(mm) DCON	CBDP	DAH	LCCB	DCSFMS	KWW	L8
50	**APX4K-050A09A042RA**	22	22	11	12.5	48	10.4	6.3
63	**APX4KR06316CA056A**	25.4	26	13	14	60.7	9.5	6
63	**APX4K-063A16A056RA**	27	28	13	14	60.7	12.4	7

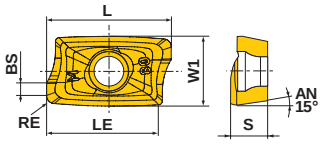
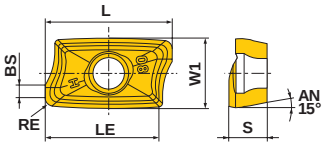
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

INSERTS

Work Material		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT
P	Steels		◐	✠				◐	◐
M	Stainless Steels				◔			◔	◔
K	Cast Irons	◐						✠	✠
S	Heat Resistant Alloys, Titanium Alloys					◐	✠	◐	✠
H	Hardened Steels							◔	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

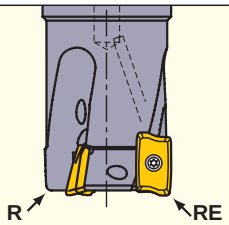
Honing :
E : Round

Shape	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	L	LE	W1	S	BS	RE *	Geometry
				Coated								Dimensions (mm)						
General **M** Breaker	**AOMT184804PEER-M**	M	E		●	●	●	●	●	●	●	18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-M	M	E		●	●	●	●	●	●	●	18	15	9	4.8	1.4	0.8	
	AOMT184810PEER-M	M	E		●			●	●	●		18	15	9	4.8	1.0	1.0	
	AOMT184812PEER-M	M	E		●			●	●	●		18	15	9	4.8	0.8	1.2	
	AOMT184816PEER-M	M	E		●	●	●	●	●	●	●	18	15	9	4.8	0.4	1.6	
	AOMT184820PEER-M	M	E		●			●	●	●		18	15	9	4.8	0.4	2.0	
Strong Cutting Edge Type **H** Breaker	**AOMT184804PEER-H**	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	1.8	0.4	
	AOMT184808PEER-H	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	1.4	0.8	
	AOMT184816PEER-H	M	E	●	●	●	●	●	●	●	●	18	15	9	4.8	0.4	1.6	
	AOMT184832PEER-H	M	E			●	●				●	18	15	9	4.8	0.4	3.2	
	AOMT184840PEER-H	M	E			●	●				●	18	15	9	4.8	0.4	4.0	
	AOMT184850PEER-H	M	E			●	●				●	18	15	9	4.8	–	5.0	
	AOMT184864PEER-H	M	E			●	●				●	18	15	9	4.8	–	6.35	

* Corner radius RE is different from the work material of R shape depending on the axial rake angle of the body.

Note on Use of Inserts with Large Corner Radii

When using inserts with corner radius RE≥R3.2mm, please machine the holder with a radius form as shown on the right table.



RE (mm)	R (mm)
3.2	2.0
4.0	2.5
5.0	3.5
6.35	5.0

R : Holder End Radius
RE : Insert Corner Radius

● : Inventory maintained in Japan. (10 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

■ CUTTING SPEED

	Work Material	Hardness	Insert Grade 1st Recommenedation	Insert Grade 2nd Recommenedation	Breaker		Cutting Width **ae** (mm) ≤0.15DC	0.15—0.3DC	DC (Slot)
							Cutting Speed **vc** (m/min)		
P	Mild Steel	≤180HB	MP6120	VP15TF	M	H	200(160—250)	160(120—200)	140(120—160)
			MP6130	VP20RT	M	H	170(130—220)	130(90—170)	110(90—130)
	Carbon Steel Alloy Steel	180—350HB	MP6120	VP15TF	M	H	160(120—200)	120(100—140)	100(80—120)
			MP6130	VP20RT	M	H	130(90—170)	90(70—110)	70(50—90)
M	Stainless Steel	≤270HB	MP7130	VP15TF	M	H	160(120—200)	120(100—140)	100(80—120)
K	Gray Cast Iron	≤350MPa	MC5020	VP15TF	H	—	230(180—280)	190(140—240)	190(140—240)
	Ductile, Cast Iron	≤800MPa	MC5020	VP15TF	H	—	190(140—220)	170(120—220)	170(120—220)
S	Titanium Alloy	≤350HB	MP9120	VP15TF	H	M	50(40—70)	—	50(40—70)
			MP9130	VP20RT	H	M	40(30—60)	—	40(30—60)
	Heat-resistant Alloy	—	MP9120	VP15TF	H	M	40(30—60)	—	40(30—60)
			MP9130	VP20RT	H	M	30(20—40)	—	30(20—40)

■ DEPTH OF CUT AND FEED

	Work Material	Characteristics	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth **fz** (mm/t.) Cutter Diameter **DC** (mm) ø40 Length of cut 56mm ø50 Length of cut 42mm	ø50 Length of cut 56mm ø63 Length of cut 56mm	ø50 Length of cut 84mm
P	Mild Steel	≤180HB	≤0.3DC	≤20	0.25	0.25	0.20
				20—50	0.20	0.20	0.15
				50—80	—	—	0.10
			DC (Slot)	≤20	0.20	0.20	0.15
				20—50	0.15	0.15	—
	Carbon Steel Alloy Steel	180—350HB	≤0.3DC	≤20	0.25	0.25	0.20
				20—50	0.20	0.20	0.15
				50—80	—	—	0.10
			DC (Slot)	≤20	0.15	0.15	0.10
				20—50	0.10	0.10	—
M	Stainless Steel	≤270HB	≤0.3DC	≤20	0.25	0.25	0.20
				20—50	0.20	0.20	0.15
				50—80	—	—	0.10
			DC (Slot)	≤10	0.10	0.10	0.07
K	Gray Cast Iron	Tensile Strength ≤350MPa	≤0.15DC	≤10	0.30	0.30	0.25
				10—50	0.25	0.25	0.20
				50—80	—	—	0.15
			0.15—0.3DC	≤10	0.25	0.25	0.20
				10—50	0.20	0.20	0.15
				50—80	—	—	0.10
			DC (Slot)	≤10	0.25	0.25	0.20
				10—50	0.20	0.20	0.15
	Ductile, Cast Iron	Tensile Strength ≤800MPa	≤0.15DC	≤20	0.25	0.25	0.20
				20—50	0.20	0.20	0.15
				50—80	—	—	0.10
			0.15—0.3DC	≤20	0.20	0.20	0.15
				20—50	0.15	0.15	0.10
				50—80	—	—	0.07
			DC (Slot)	≤10	0.15	0.15	0.10
				10—50	0.10	0.10	—
S	Titanium Alloy	≤350HB	≤0.15DC	≤20	0.10	0.10	—
				20—50	0.10	0.10	—
			DC (Slot)	≤50	0.08	0.08	—
	Heat-resistant Alloy	—	≤0.15DC	≤10	0.07	0.07	—
			DC (Slot)	≤20	0.05	0.05	—

Note 1) The above cutting conditons are determined based on high rigidity machine and workpiece, where no vibration occurred. Please adjust processing conditions if the vibration is generated.

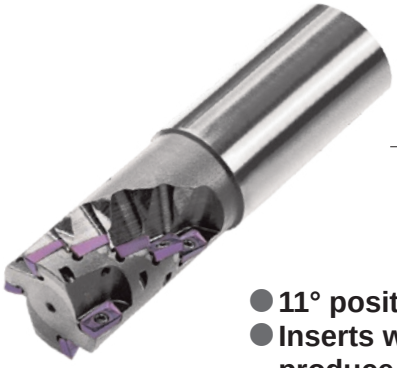
DEEP SHOULDER MILLING

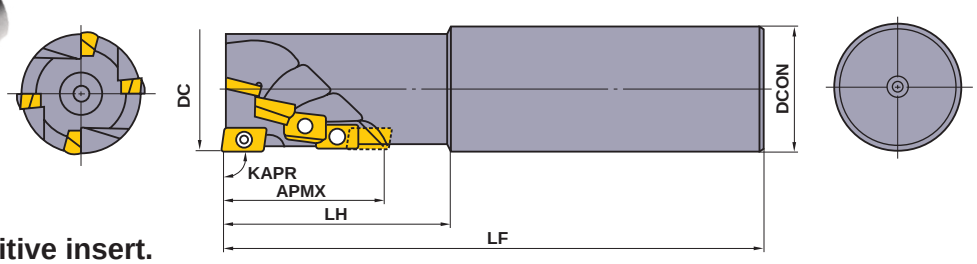
TOOL NEWS 90° KAPR

BAP300

LONG CUTTING EDGE

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel





- **11° positive insert.**
- **Inserts with wiper edges produce optimal finished surface.**
- **Multi insert design for high feed machining.**

SHANK TYPE

KAPR :90°

Right hand tool holder only.

Order Number	Stock R	Number of Flutes	Total	Dimensions(mm) DC	LF	DCON	LH	APMX	* Clamp Screw	Wrench	Insert
BAP300R2004ES20	▲	1	4	20	120	20	40	25	TS25	TKY08F	APG/MT1135 PD□R-M0/□1/□2
BAP300R2508ES25	▲	2	8	25	130	25	50	34	TS25	TKY08F	
BAP300R3212ES32	▲	2	12	32	140	32	60	43	TS25	TKY08F	
BAP300R4014ES42	▲	2	14	40	150	42	70	51	TS25	TKY08F	

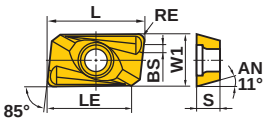
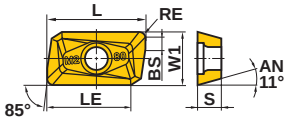
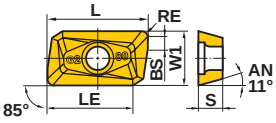
* Clamp Torque (N • m) : TS25=1.0

INSERTS

Work Material			Coated F7030	VP15TF			Cermet NX2525	NX4545	Carbide HT110	
	P	Steels	◐	◐			●	◐		
	M	Stainless Steels	◐	◐			○	◐		
	K	Cast Irons		✣			●		◐	
	N	Non-ferrous Metal							◐	
	S	Heat Resistant Alloys, Titanium Alloys		◐						
	H	Hardened Steels		◐						

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp

Shape	Order Number	Class	Honing	F7030	VP15TF			NX2525	NX4545	HT110		L	LE	W1	S	BS	RE	Geometry
	APMT1135PDER-H1	M	E	●	●			●	●	●		11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-H2	M	E	●	●			●	●	●		11.25	9	6.35	3.5	1.2	0.8	
	APMT1135PDER-M0	M	E	●								11.25	9	6.35	3.5	1.8	0.2	
	APMT1135PDER-M1	M	E	●								11.25	9	6.35	3.5	1.5	0.4	
	APMT1135PDER-M2	M	E	●	●				●			11.18	9	6.35	3.5	1.2	0.8	
	APGT1135PDFR-G2	G	F							●		11.3	9.7	6.35	3.5	1.2	0.8	

● : Inventory maintained in Japan. (10 inserts in one case)
▲ : Product scheduled to be discontinued at the end of March 2020. APX3000 (M202) is alternative product.

RECOMMENDED CUTTING CONDITIONS

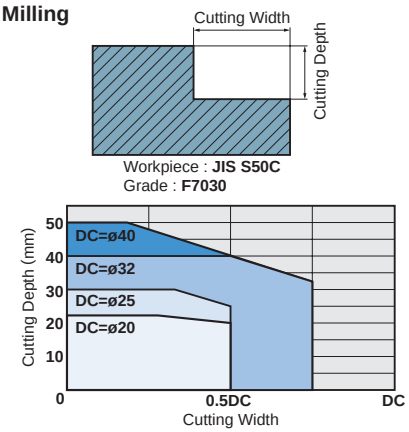
	Work Material	Hardness	Grade	Breaker	Cutting Mode	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**F7030**	**M**	General Cutting	180 (150—200)	0.15 (0.08—0.2)
	Carbon Steel Alloy Steel	180—280HB	**F7030**	**M**	General Cutting	150 (120—280)	0.15 (0.08—0.2)
			F7030	**H**	Unstable Cutting	120 (100—160)	0.2 (0.1—0.25)
		280—350HB	**F7030**	**M**	General Cutting	140 (120—160)	0.1 (0.05—0.15)
			F7030	**H**	Unstable Cutting	100 (80—120)	0.15 (0.08—0.2)
M	Stainless Steel	≤200HB	**F7030**	**M**	General Cutting	140 (120—160)	0.1 (0.08—0.15)
			F7030	**H**	Unstable Cutting	120 (80—140)	0.15 (0.08—0.2)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	**M**	General Cutting	140 (120—160)	0.15 (0.08—0.2)
			HTi10	**H**	General Cutting	120 (100—140)	0.1 (0.05—0.15)
	Ductile Cast Iron	Tensile Strength ≤450MPa	**VP15TF**	**M**	General Cutting	120 (100—140)	0.1 (0.05—0.15)
			HTi10	**H**	General Cutting	100 (80—120)	0.15 (0.08—0.2)
	Ductile Cast Iron	Tensile Strength 500—800MPa	**VP15TF**	**M**	General Cutting	100 (80—120)	0.08 (0.05—0.1)
			HTi10	**H**	General Cutting	80 (60—100)	0.1 (0.05—0.15)
N	Aluminium Alloy	—	**HTi10**	**G**	General Cutting	500 (200—1000)	0.15 (0.05—0.25)
S	Ti Alloy	≥350HB	**HTi10**	**G**	General Cutting	40 (30—60)	0.15 (0.05—0.25)
	Heat Resistant Alloy	—	**F7030**	**M**	General Cutting	30 (20—40)	0.1 (0.05—0.15)
H	Hardened Steel	≥40HRC	**VP15TF**	**M**	General Cutting	70 (50—100)	0.08 (0.05—0.1)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

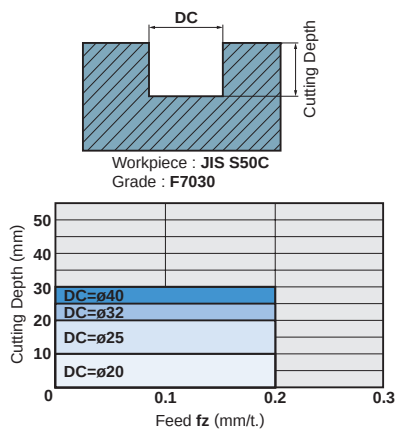
■ CUTTING PERFORMANCE

Cemented carbide/Coated carbide

Shoulder Milling



Slot Milling



Note 1) In each of the above graphs cutting performance is shown for carbon steel (JIS S50C).
In case of alloy steels, reduce the conditions by 20—30%.
Note 2) In the case of deep slot milling, air blow should be used.
Note 3) The diameter "DC" is taken from the tools peripheral cutting edge.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

DEEP SHOULDER MILLING

TOOL NEWS

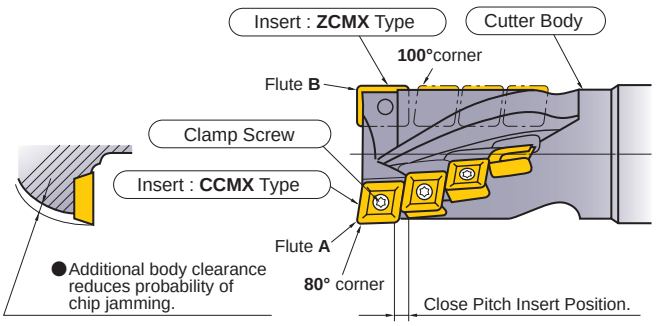
90° KAPR

DCCC

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			

● **Different helical flute angles prevents chattering.**

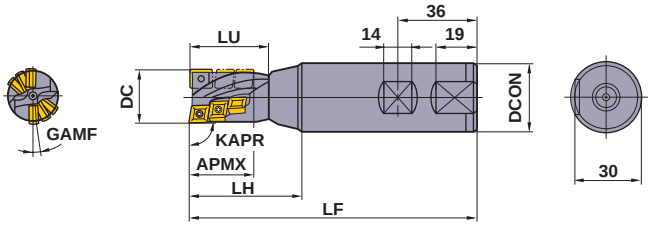
■ DESIGN FEATURES OF DCCC TYPE END MILL



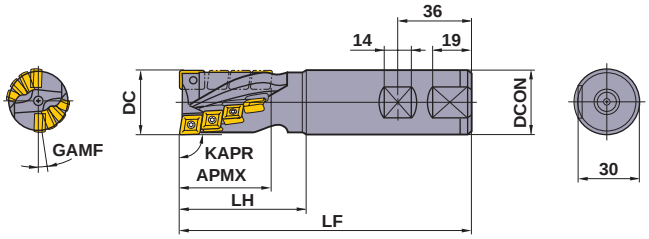
● Additional body clearance reduces probability of chip jamming.

● All 4 cutting edges of CCMX insert are utilized, 80° corners in flute "A" and 100° corners on flute "B".

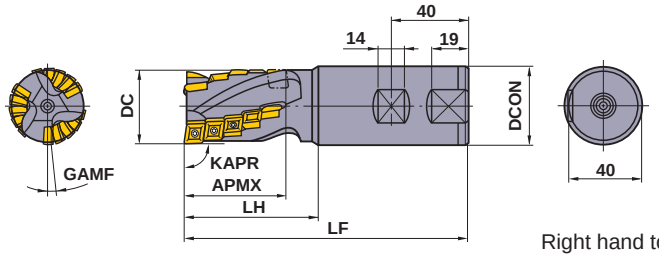
● ϕ25 2 flute



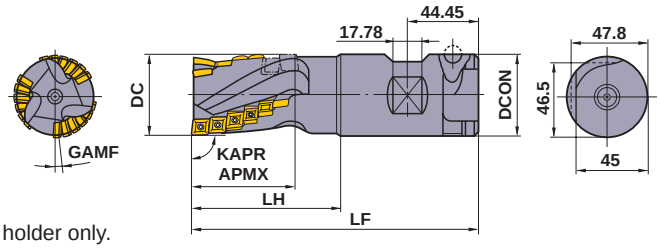
● ϕ32 2 flute



● ϕ40 3 flute



● ϕ50 (Combination Shank) 3 flute



Right hand tool holder only.

■ SHANK TYPE

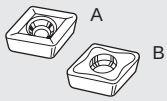
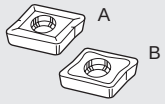
KAPR : 90°

DC (mm)	Order Number	Stock	Dimensions (mm)					GAMF	WT *	No. of Teeth		Peripheral and Bottom		Bottom insert only	
			LF	DCON	LH	LU	APMX			Bottom	Total	Type	Number of Teeth	Type	Number of Teeth
25	**DCCCR2506S32**	●	130	32	50	36	27	8°	0.6	2	6	CCMX08	5	ZCMX08	1
25	**DCCCR2510S32**	●	150	32	70	56	44	8°	0.7	2	10	CCMX08	9	ZCMX08	1
32	**DCCCR3208S32**	●	140	32	60	–	43	8°36′	0.8	2	8	CCMX09	7	ZCMX09	1
32	**DCCCR3212S32**	●	160	32	80	–	63	8°36′	0.8	2	12	CCMX09	11	ZCMX09	1
40	**DCCCR4015S42**	●	150	42	70	–	53	5°31′	1.3	3	15	CCMX09	14	ZCMX09	1
40	**DCCCR4024S42**	●	180	42	100	–	83	5°31′	1.4	3	24	CCMX09	23	ZCMX09	1
50	**DCCCR5018S508**	●	175	50.8	90	–	63	5°51′	2.3	3	18	CCMX09	17	ZCMX09	1
50	**DCCCR5027S508**	●	205	50.8	120	–	93	5°51′	2.6	3	27	CCMX09	26	ZCMX09	1

* WT : Tools Weight (Kg)

● : **Inventory maintained in Japan. (10 inserts in one case)**

SPARE PARTS

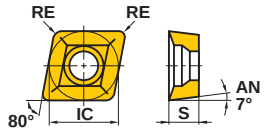
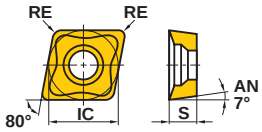
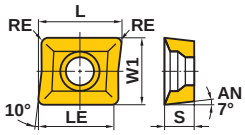
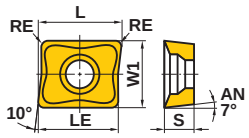
Tool Holder Number	*				
	Clamp Screw	Wrench	Wrench	Insert	
				Peripheral and Bottom Insert	Bottom Insert (One Pocket Only)
DCCCR25	CS300890T	TKY08F	TKY08DS	CCMX083508EN-A	ZCMX083508ER-A
DCCCR32 **DCCCR40** **DCCCR50**	CS350990T	TKY10F	TKY10DS	CCMX09T308EN-A or B	ZCMX09T308ER-A or B

* Clamp Torque (N • m) : CS300890T=1.0, CS350990T=2.5

INSERTS

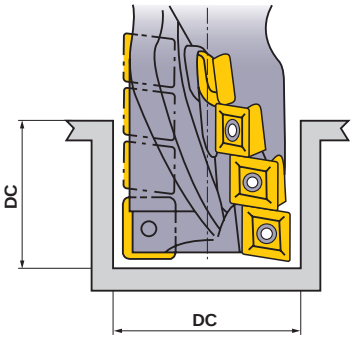
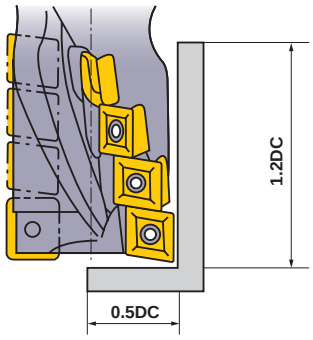
Work Material			F7030	VP15TF	UP20M		UTi20T	
	P	Steel	◐	◐	◐		◐	
	M	Stainless Steel	◔	◔	◔		◔	
	K	Cast Iron		✠			✠	

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Honing : E : Round

Shape	Order Number	Class	Honing	Coated F7030	Coated VP15TF	Coated UP20M		Carbide UTi20T		Dimensions (mm) L	LE	W1	IC	S	RE	Geometry
	CCMX083508EN-A	M	E	●		●		●		–	–	–	7.94	3.5	0.8	
	CCMX09T308EN-A	M	E	●	●	●		●		–	–	–	9.525	3.97	0.8	
Strong Cutting Edge Type	**CCMX09T308EN-B**	M	E	●				●		–	–	–	9.525	3.97	0.8	
	ZCMX083508ER-A	M	E	●				●		11.0	8.5	7.94	–	3.5	0.8	
	ZCMX09T308ER-A	M	E	●	●	●		●		12.7	11.0	9.525	–	3.97	0.8	
Strong Cutting Edge Type	**ZCMX09T308ER-B**	M	E	●		●		●		12.7	11.0	9.525	–	3.97	0.8	

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

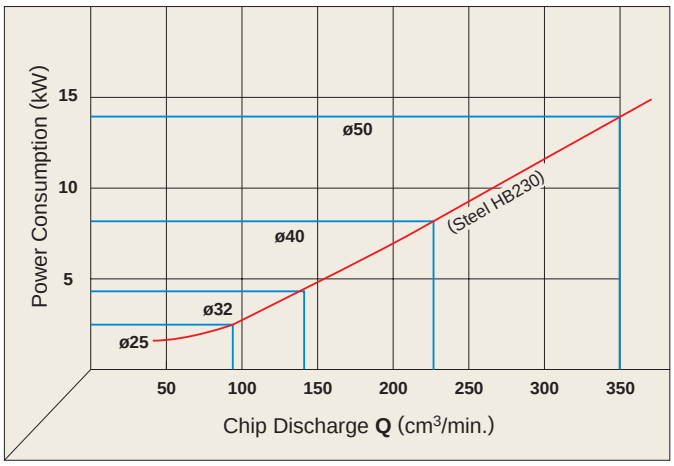
Cutting Mode	A : Slot Milling (APMX Short Type)	B : Shoulder Milling (APMX Short Type)
		

Work Material		Hardness	Grade	Cutting Mode	Cutting Speed (m/min)	Table Feed (mm/min)			
						ϕ25	ϕ32	ϕ40	ϕ50
P	Mild Steel	≤180HB	F7030	A	200 (160—240)	120 (100—140)	120 (100—140)	120 (100—140)	120 (100—140)
			F7030	B	200 (160—240)	200 (180—220)	200 (180—220)	230 (200—250)	230 (200—250)
	Carbon Steel Alloy Steel	180—280HB	F7030	A	160 (130—180)	120 (100—140)	120 (100—140)	140 (120—150)	140 (120—150)
			F7030	B	160 (130—180)	150 (120—180)	150 (120—180)	180 (150—200)	180 (150—200)
		280—350HB	F7030	A	160 (130—180)	100 (80—120)	100 (80—120)	130 (100—150)	130 (100—150)
			F7030	B	160 (130—180)	120 (100—140)	120 (100—140)	150 (120—180)	150 (120—180)
M	Stainless Steel	≤200HB	F7030	A	80 (60—100)	70 (50—90)	70 (50—90)	70 (50—90)	70 (50—90)
			F7030	B	130 (100—160)	100 (80—120)	100 (80—120)	120 (100—140)	120 (100—140)
K	Cast Iron	Tensile Strength ≤450MPa	UTI20T	A	120 (100—140)	200 (180—220)	200 (180—220)	230 (200—250)	230 (200—250)
			UTI20T	B	120 (100—140)	230 (200—250)	230 (200—250)	260 (240—280)	260 (240—280)

- Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
- Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

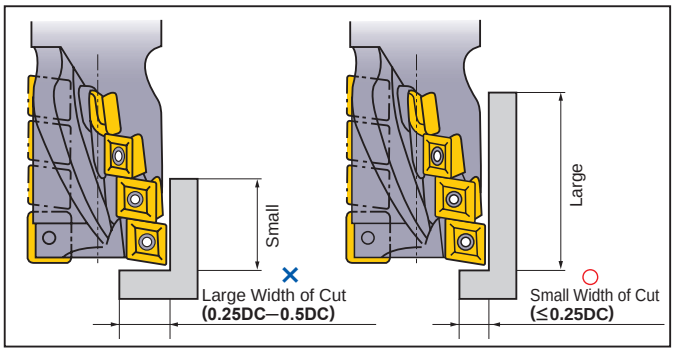
■POWER CONSUMPTION

- Please use the chart below for reference, please select the conditions that suits the machines power.
- Chip Discharge Q (cm^3/min.)=Table Feed x Depth of Cut x Cutting Width÷1000



■FOR USE OF APMX LONG TYPE

- Since the overhang from the milling chuck is long, a large width of cut will cause chattering and tool breakage.
- Keep the width of cut small and the depth of cut in axial direction large. (See the following illustration.)
- For slot milling, keep the table feed at not more than half the value listed in the above table. (Use the APMX Short type as much as possible.)



DEEP SHOULDER MILLING

TOOL NEWS

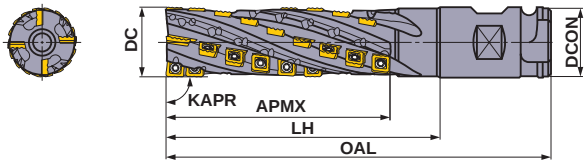
90° KAPR

SPX

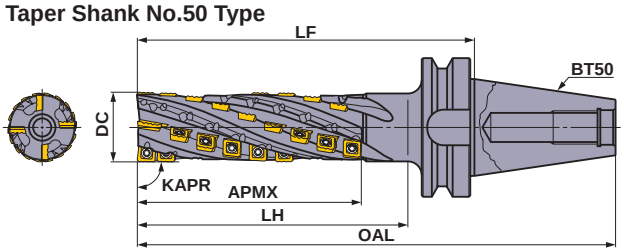
P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron		Heat Resistant Alloy	

- **Low cutting resistance due to the use of wavy inserts.**
- **Suitable for heavy cutting due to holder rigidity.**

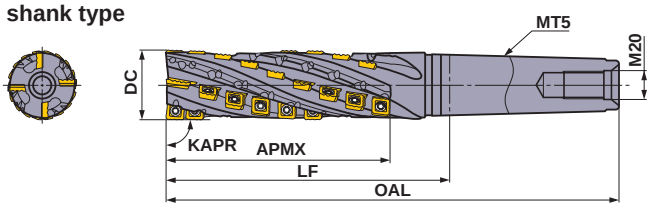
● **Straight Shank Type (Combination Shank)**



● **7/24 Taper Shank No.50 Type**



● **MT5 shank type**



■SHANK TYPE

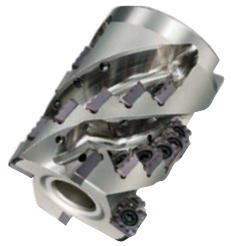
KAPR :90°

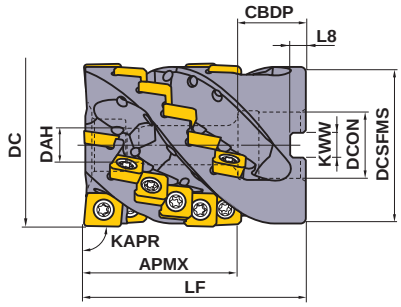
Right hand tool holder only.

Type		Order Number	Stock	Number of Teeth		Dimensions (mm)						Number of Insert		
												Bottom On-edge A	Bottom On-edge B	Peripheral
			R	Flutes	Total	DC	OAL	DCON	LH	LF	APMX	JPMX 190412-○○	MPMX 120412-○○	SPMX 120408-○○
Straight Shank (Combination Shank)	Short Edge Type	SPX4R05016WNES	●	4	16	50	180	50.8	100	—	72	2	2	12
Straight Shank (Combination Shank)	Coarse Pitch	SPX4R05024WNS	●	4	24	50	220	50.8	140	—	110	2	2	20
Straight Shank (Combination Shank)	Coarse Pitch	SPX4R05034WNM	●	4	34	50	270	50.8	190	—	157	2	2	30
7/24 Taper Shank (No. 50)	Short Edge Type	SPX4R05016BT50NES	●	4	16	50	249.8	—	100	148	72	2	2	12
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R05024BT50NS	●	4	24	50	289.8	—	140	188	110	2	2	20
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R05034BT50NM	●	4	34	50	339.8	—	190	238	157	2	2	30
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R06324BT50NS	●	4	24	63	289.8	—	140	188	110	2	2	20
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R06334BT50NM	●	4	34	63	339.8	—	190	238	157	2	2	30
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R06344BT50NL	●	4	44	63	389.8	—	240	288	205	2	2	40
7/24 Taper Shank (No. 50)	Coarse Pitch	SPX4R06356BT50NX	●	4	56	63	439.8	—	290	338	261	2	2	52
MT5 shank type		SPX4R05024MT5NS	●	4	24	50	279.5	—	—	150	110	2	2	20
MT5 shank type		SPX4R05034MT5NM	●	4	34	50	329.5	—	—	200	157	2	2	30

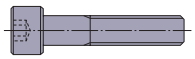
● : **Inventory maintained in Japan.**

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001





Right hand tool holder only.

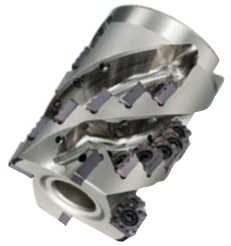
Cutter Diameter DC	Set Bolt	Geometry
ϕ63	HSC12070	
ϕ80	16065	

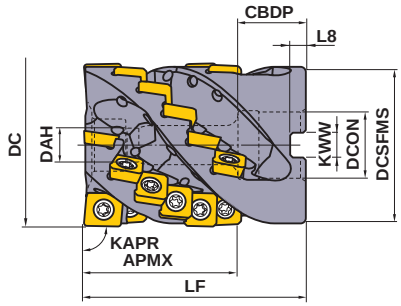
■SHELL TYPE

KAPR :90°

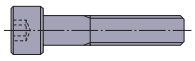
Order Number	Stock	Number of Teeth		Dimensions (mm)									Number of Insert		
													Bottom On-edge **A**	Bottom On-edge **B**	Peripheral
	R	Flutes	Total	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	APMX	JPMX 140412-○○	MPMX 120412-○○	SPMX 120408-○○
SPX4R06324CA058A	●	4	24	63	85	25.4	26	13	60	9.5	6	58	2	2	20
SPX4R08024DA058A	●	4	24	80	85	31.75	38	17	76.8	12.7	8	58	2	2	20

Note 1) In case of internal coolant supply, please use a face mill arbor with through coolant channels. Regular center-thru or side-thru arbors can't be used.





Right hand tool holder only.

Cutter Diameter DC	Set Bolt	Geometry
ϕ63	HSC12070	
ϕ80	16065	

For metric arbor

The cutter bore diameter DCON is indicated in millimetre.

■SHELL TYPE

KAPR :90°

Order Number	Stock	Number of Teeth		Dimensions (mm)									Number of Insert		
													Bottom On-edge **A**	Bottom On-edge **B**	Peripheral
	R	Flutes	Total	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	APMX	JPMX 140412-○○	MPMX 120412-○○	SPMX 120408-○○
SPX4-063A24A058RA	●	4	24	63	85	27	28	13	60	12.4	7	58	2	2	20
SPX4-080A24A058RA	●	4	24	80	85	32	40	17	76.8	14.4	8	58	2	2	20

Note 1) In case of internal coolant supply, please use a face mill arbor with through coolant channels. Regular center-thru or side-thru arbors can't be used.

SPARE PARTS

Tool Holder Number	*					
	Clamp Screw	Wrench	Anti-seize Lubricant	Insert		
				Bottom On-edge **A**	Bottom On-edge **B**	Peripheral
SPX	TS55	TKY25D	MK1KS	JPMX140412-WH	MPMX120412-WH	SPMX120408-WH
				JPMX140412-JM	MPMX120412-JM	SPMX120408-JM

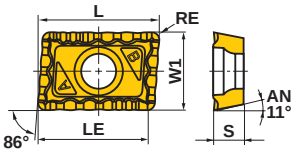
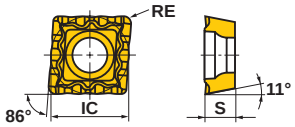
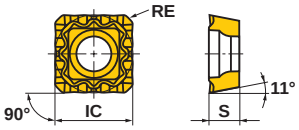
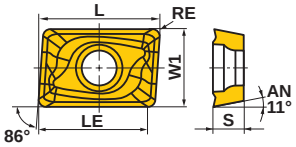
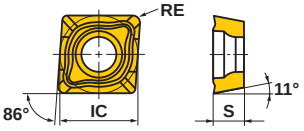
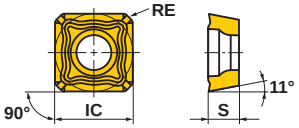
* Clamp Torque (N • m) : TS55=7.5

● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material					
P	Steel	●	●		
M	Stainless Steel	◐	◐		
K	Cast Iron	✣	✣		
S	Heat-resistant Alloy, Titanium Alloy	◐	✣		

Cutting Conditions (Guide) :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Type		Shape	Order Number	Class	Coated VP15TF	Coated VP20RT			Dimensions (mm) L	LE	W1	IC	S	RE	Geometry
Wavy cutting edge type (**WH** Breaker)	Bottom On-edge **A**		**JPMX190412-WH**	M	●	●			19.81	17.6	12.7	—	4.76	1.2	
			⁎ **JPMX140412-WH**	M	●	●			15.04	12.9	12.7	—	4.76	1.2	
	Bottom On-edge **B**		**MPMX120412-WH**	M	●	●			—	—	—	12.7	4.76	1.2	
	Peripheral		**SPMX120408-WH**	M	●	●			—	—	—	12.7	4.76	0.8	
Straight cutting edge type (**JM** Breaker)	Bottom On-edge **A**		**JPMX190412-JM**	M	●	●			19.81	17.6	12.7	—	4.83	1.2	
			⁎ **JPMX140412-JM**	M	●	●			15.04	12.9	12.7	—	4.79	1.2	
	Bottom On-edge **B**		**MPMX120412-JM**	M	●	●			—	—	—	12.7	4.79	1.2	
	Peripheral		**SPMX120408-JM**	M	●	●			—	—	—	12.7	4.80	0.8	

⁎ Only for use with a shell type holder.

RECOMMENDED CUTTING CONDITIONS (SHANK TYPE)

■ CUTTING CONDITIONS FOR SHOULDER MILLING

	Work Material	Hardness	Grade Breaker		Cutting Speed **vc** (m/min)	Cutting Width : **ae** (mm) Feed per Tooth : **fz** (mm/t.)						
						ϕ50 (the last letter of order number for cutter body)			ϕ63 (the last letter of order number for cutter body)			
						S (APMX≤110)	**M** (APMX=157)	**L** (APMX=205)	**S** (APMX=110)	**M** (APMX=157)	**L** (APMX=205)	**X** (APMX=261)
P	Mild Steel	≤180HB	**VP15TF**	**WH**	120 (100−140)	≤10.0 0.15−0.25	≤5.0 0.15−0.25	≤2.5 0.10−0.20	≤12.5 0.15−0.25	≤10.0 0.15−0.25	≤5.0 0.15−0.25	≤2.5 0.10−0.20
				JM	120 (100−140)	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15	≤10.0 0.10−0.20	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15
	Carbon Steel Alloy Steel	180−350HB		**WH**	80 (70−120)	≤10.0 0.15−0.25	≤5.0 0.15−0.25	≤2.5 0.10−0.20	≤12.5 0.15−0.25	≤10.0 0.15−0.25	≤5.0 0.15−0.25	≤2.5 0.10−0.20
				JM	80 (70−120)	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15	≤10.0 0.10−0.20	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15
	Alloy Tool Steel	≤300HB		**WH**	80 (60−100)	≤10.0 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15	≤12.5 0.10−0.20	≤10.0 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15
				JM	80 (60−100)	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.05−0.10	≤10.0 0.10−0.15	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.05−0.10
M	Stainless Steel	≤200HB	**VP20RT**	**WH**	80 (60−100)	≤7.5 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10	≤10.0 0.08−0.15	≤7.5 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10
				JM	80 (60−100)	≤5.0 0.08−0.15	≤3.5 0.08−0.15	≤2.0 0.05−0.10	≤7.5 0.08−0.15	≤5.0 0.08−0.15	≤3.5 0.08−0.15	≤2.0 0.05−0.10
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	**WH**	100 (80−120)	≤10.0 0.15−0.40	≤5.0 0.15−0.35	≤2.5 0.10−0.30	≤12.5 0.15−0.40	≤10.0 0.15−0.40	≤5.0 0.15−0.35	≤2.5 0.10−0.30
				JM	100 (80−120)	≤7.5 0.10−0.25	≤5.0 0.10−0.25	≤2.5 0.05−0.20	≤10.0 0.10−0.25	≤7.5 0.10−0.25	≤5.0 0.10−0.25	≤2.5 0.05−0.20
	Ductile Cast Iron	Tensile Strength ≤800MPa		**WH**	80 (60−100)	≤10.0 0.15−0.35	≤5.0 0.15−0.30	≤2.5 0.10−0.25	≤12.5 0.15−0.35	≤10.0 0.15−0.35	≤5.0 0.15−0.30	≤2.5 0.10−0.25
				JM	80 (60−100)	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15	≤10.0 0.10−0.20	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.05−0.15
S	Ti Alloy	≤350HB	**VP20RT**	**WH**	40 (35−50)	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10	≤7.5 0.05−0.10	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10
				JM	40 (35−50)	≤3.5 0.05−0.10	≤2.5 0.05−0.10	≤1.5 0.05−0.10	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.5 0.05−0.10	≤1.5 0.05−0.10

Note 1) The above cutting conditons are determined based on high rigidity machine and workpiece, where no vibration occurred. Please adjust processing conditions if the vibration is generated.

Note 2) If the cutting angle between the tool and workpiece exceeds 90º when machining corners ,Reduce the cutting speed and table feed by 10-20% and ae by 50%. Also if possible, set a radius cutting path for corners.

■ SLOT MILLING

	Work Material	Hardness	Grade Breaker		Cutting Speed **vc** (m/min)	Depth of Cut : **ap** : (mm) Feed per Tooth : **fz** (mm/t.)						
						ϕ50 (the last letter of order number for cutter body)			ϕ63 (the last letter of order number for cutter body)			
						S (APMX≤110)	**M** (APMX=157)	**L** (APMX=205)	**S** (APMX=110)	**M** (APMX=157)	**L** (APMX=205)	**X** (APMX=261)
P	Mild Steel	≤180HB	**VP15TF**	**WH**	60 (50−120)	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15	≤12.5 0.10−0.25	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15
				JM	60 (50−120)	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15	≤10.0 0.10−0.15	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15
	Carbon Steel Alloy Steel	180−350HB		**WH**	60 (50−100)	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15	≤12.5 0.10−0.25	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15
				JM	60 (50−100)	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15	≤10.0 0.10−0.15	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15
	Alloy Tool Steel	≤300HB		**WH**	50 (40−80)	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15	≤12.5 0.10−0.25	≤10.0 0.10−0.25	≤5.0 0.10−0.20	≤2.5 0.10−0.15
				JM	50 (40−80)	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15	≤10.0 0.10−0.15	≤7.5 0.10−0.15	≤5.0 0.10−0.15	≤2.5 0.10−0.15
M	Stainless Steel	≤200HB	**VP20RT**	**WH**	40 (35−80)	≤10.0 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10	≤12.5 0.08−0.15	≤10.0 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10
				JM	40 (35−80)	≤7.5 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10	≤10.0 0.08−0.15	≤7.5 0.08−0.15	≤5.0 0.08−0.15	≤2.5 0.05−0.10
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	**WH**	50 (40−80)	≤10.0 0.15−0.25	≤5.0 0.10−0.25	≤2.5 0.10−0.20	≤12.5 0.15−0.25	≤10.0 0.15−0.25	≤5.0 0.10−0.25	≤2.5 0.10−0.20
				JM	50 (40−80)	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.10−0.20	≤10.0 0.10−0.20	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.10−0.20
	Ductile Cast Iron	Tensile Strength ≤800MPa		**WH**	40 (35−80)	≤10.0 0.15−0.25	≤5.0 0.10−0.25	≤2.5 0.10−0.20	≤12.5 0.15−0.25	≤10.0 0.15−0.25	≤5.0 0.10−0.25	≤2.5 0.10−0.20
				JM	40 (35−80)	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.10−0.20	≤10.0 0.10−0.20	≤7.5 0.10−0.20	≤5.0 0.10−0.20	≤2.5 0.10−0.20
S	Ti Alloy	≤350HB	**VP20RT**	**WH**	35 (30−50)	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10	≤7.5 0.05−0.10	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10
				JM	35 (30−50)	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10	≤7.5 0.05−0.10	≤5.0 0.05−0.10	≤3.5 0.05−0.10	≤2.0 0.05−0.10

Note 1) The above cutting conditons are determined based on high rigidity machine and workpiece, where no vibration occurred. Please adjust processing conditions if the vibration is generated.

Note 2) For slotting, please use high rigidity tools such as SPX4R05016WNES/BT50NES.

RECOMMENDED CUTTING CONDITIONS (SHELL TYPE)

■SHOULDER MILLING

	Work Material	Hardness	Grade Breaker	Cutting Speed **vc** (m/min)	Depth of Cut **ap** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF JM**	120 (100−140)	−0.5DC	−10	0.15−0.30
				120 (100−140)	0.5DC−	−10	0.15−0.25
	Carbon Steel Alloy Steel	180−350HB	**VP15TF JM**	120 (80−130)	−0.5DC	−10	0.15−0.30
				100 (80−120)	0.5DC−	−10	0.15−0.25
	Alloy Tool Steel	≤300HB	**VP15TF JM**	100 (60−110)	−0.5DC	−10	0.10−0.20
				80 (60−100)	0.5DC−	−10	0.10−0.15
M	Stainless Steel	≤200HB	**VP20RT JM**	140 (100−150)	−0.5DC	−10	0.10−0.25
				120 (100−140)	0.5DC−	−10	0.10−0.20
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF WH**	120 (80−130)	−0.5DC	−10	0.25−0.40
				100 (80−120)	0.5DC−	−10	0.25−0.40
			VP15TF JM	120 (80−130)	−0.5DC	−10	0.15−0.30
				100 (80−120)	0.5DC−	−10	0.15−0.25
	Ductile Cast Iron	Tensile Strength ≤800MPa	**VP15TF WH**	100 (60−110)	−0.5DC	−10	0.20−0.35
				80 (60−110)	0.5DC−	−10	0.20−0.35
			VP15TF JM	100 (60−120)	−0.5DC	−10	0.15−0.30
				80 (60−120)	0.5DC−	−10	0.15−0.30
S	Ti Alloy	≤350HB	**VP20RT JM**	45 (35−50)	−0.5DC	−10	0.08−0.10
				40 (35−50)	0.5DC−	−10	0.08−0.10

Note 1) The above cutting conditons are determined based on high rigidity machine and workpiece, where no vibration occurred. Please adjust processing conditions if the vibration is generated.

■SLOT MILLING

	Work Material	Hardness	Grade Breaker	Cutting Speed **vc** (m/min)	Depth of Cut **ap** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)
P	Mild Steel	≤180HB	**VP15TF JM**	120 (100−140)	−10	DC	0.15−0.25
	Carbon Steel Alloy Steel	180−350HB	**VP15TF JM**	100 (80−120)	−0.25DC	DC	0.15−0.25
	Alloy Tool Steel	≤300HB	**VP15TF JM**	80 (60−100)	−10	DC	0.10−0.20
M	Stainless Steel	≤200HB	**VP20RT JM**	100 (80−140)	−10	DC	0.10−0.15
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF WH**	80 (60−100)	−0.25DC	DC	0.10−0.25
				60 (50−100)	−0.6DC	DC	0.10−0.20
			VP15TF JM	80 (60−100)	−0.25DC	DC	0.10−0.20
				60 (50−100)	−0.6DC	DC	0.10−0.15
	Ductile Cast Iron	Tensile Strength ≤800MPa	**VP15TF WH**	80 (60−100)	−0.25DC	DC	0.10−0.25
				60 (50−100)	−0.5DC	DC	0.10−0.20
			VP15TF JM	80 (60−100)	−0.25DC	DC	0.10−0.20
				60 (50−100)	−0.5DC	DC	0.10−0.15
S	Ti Alloy	≤350HB	**VP20RT JM**	40 (35−50)	−0.25DC	DC	0.06−0.10

Note 1) The above cutting conditons are determined based on high rigidity machine and workpiece, where no vibration occurred. Please adjust processing conditions if the vibration is generated.

DEEP SHOULDER MILLING

<CUTTING FOR TITANIUM ALLOY>

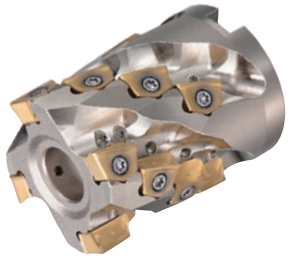
TOOL NEWS

90° KAPR

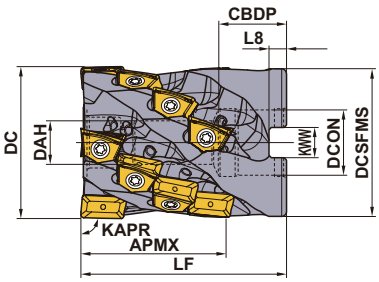
VFX5

P | M | K | N | **S** | H

Heat Resistant Alloy



- **Vertical inserts with high strength cutting edge.**
- **Screw-on type clamping.**
- **High efficiency milling of titanium alloys.**



Right hand tool holder only.

SHELL TYPE

KAPR :90°

Order Number	Stock	Number of Flutes	Total	Dimensions (mm)								APMX (mm)	WT(kg)
	R			DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8		
VFX5-040A03A026R	●	3	6	40	50	16	21	8.5	38.2	8.4	5.6	26	0.3
VFX5-040A03A038R	●	3	9	40	60	16	21	8.5	38.2	8.4	5.6	38	0.4
VFX5-050X03A026R	●	3	6	50	50	27	23	12.5	48.2	12.4	7.0	26	0.4
VFX5-050X03A038R	●	3	9	50	60	27	23	12.5	48.2	12.4	7.0	38	0.5
VFX5-050A04A026R	●	4	8	50	50	22	21	10.5	48.2	10.4	6.3	26	0.5
VFX5-050A04A038R	●	4	12	50	60	22	21	10.5	48.2	10.4	6.3	38	0.6
VFX5-050X04A038R	●	4	12	50	60	27	23	12.5	48.2	12.4	7.0	38	0.5
VFX5-050A04A050R	●	4	16	50	70	22	21	10.5	48.2	10.4	6.3	50	0.7
VFX5-063A05A026R	●	5	10	63	60	27	28	12.5	61	12.4	7.0	26	1.0
VFX5-063A05A063R	●	5	25	63	85	27	28	12.5	61	12.4	7.0	63	1.4
VFX5-080A06A075R	●	6	36	80	100	32	28	16.5	77.3	14.4	8.0	75	2.8

● : Inventory maintained in Japan.

SPARE PARTS

Order Number	*2				*3				Number of Insert	
									End Cutting Edge	Peripheral *1 Cutting Edge
	Clamp Screw	Number	Seal Washer	Wrench	Coolant Nozzle	Number	Anti-seize Lubricant	Set Bolt	XNMU1607 ○○R-○○	XNMU1607 08R-○○
VFX5-040A03A026R	TS352	6	W8-S1	TKY10D	HSD04004H08	9	MK1KS	HSC08040	3	3
VFX5-040A03A038R	TS352	9	W8-S1	TKY10D	HSD04004H08	12	MK1KS	HSC08050	3	6
VFX5-050X03A026R	TS352	6	W12-S1	TKY10D	HSD04004H08	9	MK1KS	HSC12035	3	3
VFX5-050X03A038R	TS352	9	W12-S1	TKY10D	HSD04004H08	12	MK1KS	HSC12045	3	6
VFX5-050A04A026R	TS352	8	W10-S1	TKY10D	HSD04004H08	12	MK1KS	HSC10035	4	4
VFX5-050A04A038R	TS352	12	W10-S1	TKY10D	HSD04004H08	16	MK1KS	HSC10045	4	8
VFX5-050X04A038R	TS352	12	W12-S1	TKY10D	HSD04004H08	16	MK1KS	HSC12045	4	8
VFX5-050A04A050R	TS352	16	W10-S1	TKY10D	HSD04004H08	20	MK1KS	HSC10055	4	12
VFX5-063A05A026R	TS352	10	W12-S1	TKY10D	HSD04004H08	15	MK1KS	HSC12045	5	5
VFX5-063A05A063R	TS352	25	W12-S1	TKY10D	HSD04004H08	30	MK1KS	HSC12070	5	20
VFX5-080A06A075R	TS352	36	W16-S1	TKY10D	HSD04004H08	42	MK1KS	HSC16080	6	30

*1 Only corner radius R0.8 can be used for the peripheral cutting edges except the end cutting edge.
*2 Clamp Torque (N • m) : TS352=2.5
*3 Coolant nozzles are available with varying diameters for adjusting coolant pressure. Select nozzles as required by the specification.

	≤1Mpa (≤20 l/min.)	←Standard→	**≥5Mpa (≥30 l/min.)**	**≥7Mpa (≥50 l/min.)**
Nozzle Dia.	ø0.6mm	ø0.8mm	ø1.2mm	ø1.6mm
Order Number	**HSD04004H06**	**HSD04004H08**	**HSD04004H12**	**HSD04004H16**

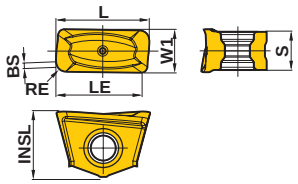
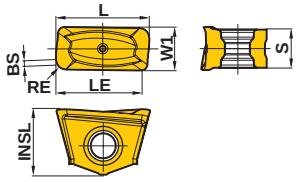
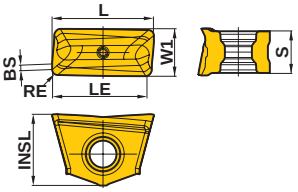
* Clamp Torque (N • m) : HSD0400H○○=1.5

*4 The part number for a blank screw without a through nozzle is HSS04004.
*5 Note for insert with a corner radius of 3.2 and above, as corner radius increases the LF dimension increases.
Corner radius 3.2: LF+0.7mm Corner radius 4.0: LF+1.5mm

SPARE PARTS ➢ Q001
TECHNICAL DATA ➢ R001

INSERTS

Work Material	S	Heat-resistant Alloy, Titanium Alloy	✣				Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	Stock / Coated					Dimensions (mm)							Geometry
		MP9130					L	LE	W1	INSL	S	BS	RE	
General Purpose	XNMU160708R-MS	●					16.0	13.4	7.0	11.1	6.5	1.0	0.8	
	XNMU160712R-MS	●					16.0	13.8	7.0	11.1	6.5	1.0	1.2	
	XNMU160716R-MS	●					16.0	13.8	7.0	11.1	6.5	1.0	1.6	
	XNMU160724R-MS	●					16.0	13.8	7.0	11.1	6.5	1.0	2.4	
	*1 XNMU160732R-MS	●					17.3	14.4	7.0	11.1	6.5	—	3.2	
	*1 XNMU160740R-MS	●					18.9	15.2	7.0	11.1	6.5	—	4.0	
Cutting Edge Enhancement Type	XNMU160708R-HS	●					16.0	13.4	7.0	11.1	6.5	1.0	0.8	
Chip Processing Type	XNMU160708R-LS	●					16.0	13.4	7.0	11.1	6.5	1.0	0.8	

*1 Note for insert with a corner radius of 3.2 and above, as corner radius increases the LF dimension increases.
Corner radius 3.2: LF+0.7mm Corner radius 4.0: LF+1.5mm

● : Inventory maintained in Japan. (10 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

VFX5

	Work Material	Cutting Edge Diameter (mm)	Number of Flutes	Recommended Insert	Cutting Speed **vc** (m/min)	Revolution **n** (min^{-1})	Depth of Cut **apmax** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)	Table Feed **vf** (mm/min)	Chip Removal Rate **Q** (cm^3/min)	Estimated Cutting Power (kW)	Expected Torque (Nm)	Tool Life Ratio (%)
S	Titanium Alloy (Ti-6Al-4V)	ϕ40	3	LS	40	318	38	40	0.10	95	145	6.5	194	40
			3	MS	50	398	38	24	0.10	119	109	4.5	109	60
			3	MS	60	477	38	16	0.10	143	87	3.5	69	80
			3	HS	60	477	38	8	0.12	172	52	2.3	45	100
		ϕ50	3	LS	40	255	38	50	0.10	76	145	6.5	242	40
			4	MS	50	318	50	30	0.10	127	191	7.9	237	60
			4	MS	60	382	50	20	0.10	153	153	6.0	151	80
			4	HS	60	382	50	10	0.12	183	92	3.9	98	100
		ϕ63	5	LS	40	202	60	63	0.10	101	382	16.8	793	40
			5	MS	50	253	60	38	0.10	126	286	11.8	447	60
			5	MS	60	303	60	25	0.10	152	229	9.0	285	80
			5	HS	60	303	60	13	0.12	182	138	5.9	185	100
		ϕ80	6	LS	40	159	75	80	0.10	95	573	25.0	1500	40
			6	MS	50	199	75	48	0.10	119	430	17.6	846	60
			6	MS	60	239	75	32	0.10	143	344	13.5	539	80
			6	HS	60	239	75	16	0.12	172	206	8.7	350	100
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr)	ϕ40	3	LS	25	199	38	40	0.08	48	73	3.4	161	30
			3	MS	25	199	38	24	0.08	48	44	1.9	92	50
			3	MS	30	239	38	16	0.10	72	44	1.8	74	70
			3	HS	30	239	38	8	0.10	72	22	1.0	41	90
		ϕ50	4	LS	25	159	50	50	0.08	51	127	5.8	350	30
			4	MS	25	159	50	30	0.08	51	76	3.4	201	50
			4	MS	30	191	50	20	0.10	76	76	3.2	160	70
			4	HS	30	191	50	10	0.10	76	38	1.8	89	90
		ϕ63	5	LS	25	126	60	63	0.08	51	191	8.7	658	30
			5	MS	25	126	60	38	0.08	51	115	5.0	378	50
			5	MS	30	152	60	25	0.10	76	115	4.8	301	70
			5	HS	30	152	60	13	0.10	76	57	2.6	167	90
		ϕ80	6	LS	25	99	75	80	0.08	48	286	13.0	1246	30
			6	MS	25	99	75	48	0.08	48	172	7.5	716	50
			6	MS	30	119	75	32	0.10	72	172	7.1	570	70
			6	HS	30	119	75	16	0.10	72	86	3.9	316	90

Note 1) Please note that machining performance varies depending to the conditions such as machine rigidity, work clamping rigidity, coolant supply system, pressure and flow volume etc.

Note 2) Internal coolant is recommended. Please use an FMH type arbor for through coolant. Using external coolant in combination with through coolant is even more effective.

Note 3) The tool life ratio shows the standard when ae = tool diameter × 20% is assumed to be 100 when shoulder cutting.

Note 4) The maximum depth of cut (apmax) varies according to the machine rigidity and power.

DEEP SHOULDER MILLING

<CUTTING FOR TITANIUM ALLOY>

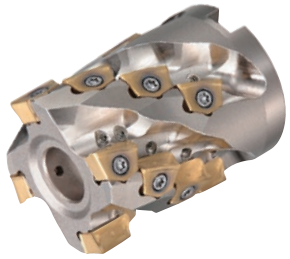
TOOL NEWS

90° KAPR

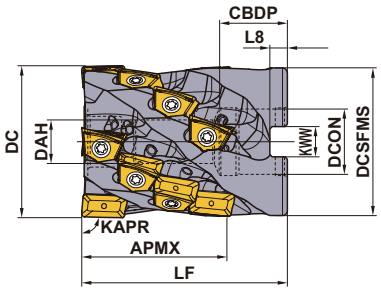
VFX6

P | M | K | N | **S** | H

Heat Resistant Alloy



- **Vertical inserts with high strength cutting edge.**
- **Screw-on type clamping.**
- **High efficiency milling of titanium alloys.**



Right hand tool holder only.

SHELL TYPE

KAPR :90°

Order Number	Stock	Number of Flutes	Total	Dimensions (mm)								APMX (mm)	WT(kg)
	R			DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8		
VFX6-063A04A031R	●	4	8	63	60	27	28	12.5	61	12.4	7	31	0.9
VFX6-063A04A060R	●	4	16	63	85	27	28	12.5	61	12.4	7	60	1.3
VFX6-080A05A031R	●	5	10	80	60	32	28	16.5	77.3	14.4	8	31	1.5
VFX6-080A05A075R	●	5	25	80	100	32	28	16.5	77.3	14.4	8	75	2.6
VFX6-100A06A031R	●	6	12	100	65	40	30	20.5	96.6	16.4	9	31	2.7
VFX6-100A06A090R	●	6	36	100	115	40	30	20.5	96.6	16.4	9	90	4.8

● : Inventory maintained in Japan.

SPARE PARTS

Order Number	*2				*3				Number of Insert	
									End Cutting Edge	Peripheral Cutting Edge *1
	Clamp Screw	Number	Seal Washer	Wrench	Coolant Nozzle	Number	Anti-seize Lubricant	Set Bolt	**XNMU1909 ○○R-○○**	**XNMU1909 12R-○○**
VFX6-063A04A031R	TS450	8	W12-S1	TKY20T	HSD04004H08	12	MK1KS	HSC12045	4	4
VFX6-063A04A060R	TS450	16	W12-S1	TKY20T	HSD04004H08	20	MK1KS	HSC12070	4	12
VFX6-080A05A031R	TS450	10	W16-S1	TKY20T	HSD04004H08	15	MK1KS	HSC16040	5	5
VFX6-080A05A075R	TS450	25	W16-S1	TKY20T	HSD04004H08	30	MK1KS	HSC16080	5	20
VFX6-100A06A031R	TS450	12	W20-S1	TKY20T	HSD04004H08	18	MK1KS	HSC20040	6	6
VFX6-100A06A090R	TS450	36	W20-S1	TKY20T	HSD04004H08	42	MK1KS	HSC20090	6	30

*1 Only corner radius R1.2 can be used for the peripheral cutting edges except the end cutting edge.
*2 Clamp Torque (N • m) : TS450=5.0
*3 Coolant nozzles are available with varying diameters for adjusting coolant pressure. Select nozzles as required by the specification.

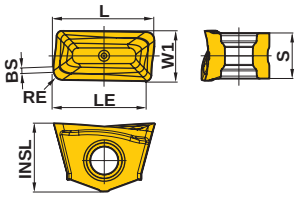
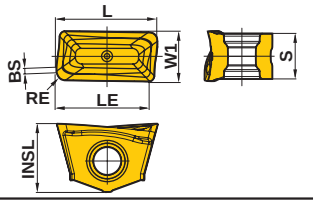
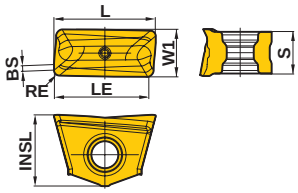
	≤1Mpa (≤20 l/min.)	←Standard→	**≥5Mpa (≥30 l/min.)**	**≥7Mpa (≥50 l/min.)**
Nozzle Dia.	ø0.6mm	ø0.8mm	ø1.2mm	ø1.6mm
Order Number	**HSD04004H06**	**HSD04004H08**	**HSD04004H12**	**HSD04004H16**

* Clamp Torque (N • m) : HSD0400H○○=1.5

*4 The part number for a blank screw without a through nozzle is HSS04004.
*5 Note for insert with a corner radius of 3.2 and above, as corner radius increases the LF dimension increases.
Corner radius 3.2: LF+0.7mm Corner radius 4.0: LF+1.5mm Corner radius 5.0: LF+1.5mm

INSERTS

Work Material	S	Heat-resistant Alloy, Titanium Alloy	✠				Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Stock / Coated					Dimensions (mm)							Geometry
		MP9130					L	LE	W1	INSL	S	BS	RE	
General Purpose	XNMU190912R-MS	●					19.1	16.5	9.5	12.7	8.5	1.0	1.2	
	XNMU190916R-MS	●					19.1	16.5	9.5	12.7	8.5	1.0	1.6	
	XNMU190924R-MS	●					19.1	16.6	9.5	12.7	8.5	1.0	2.4	
	⁎1 XNMU190932R-MS	●					20.2	17.1	9.5	12.7	8.5	—	3.2	
	⁎1 XNMU190940R-MS	●					21.8	17.8	9.5	12.7	8.5	—	4.0	
	⁎1 XNMU190950R-MS	●					21.8	17.8	9.5	12.7	8.5	—	5.0	
Cutting Edge Enhancement Type	XNMU190912R-HS	●					19.1	16.5	9.5	12.7	8.5	1.0	1.2	
Chip Processing Type	XNMU190912R-LS	●					19.1	16.5	9.5	12.7	8.5	1.0	1.2	

⁎1 Note for insert with a corner radius of 3.2 and above, as corner radius increases the LF dimension increases.
Corner radius 3.2: LF+0.7mm Corner radius 4.0: LF+1.5mm Corner radius 5.0: LF+1.5mm

● : Inventory maintained in Japan. (10 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

VFX6

	Work Material	Cutting Edge Diameter (mm)	Number of Flutes	Recommended Insert	Cutting Speed **vc** (m/min)	Revolution **n** (min^{-1})	Depth of Cut **apmax** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)	Table Feed **vf** (mm/min)	Chip Removal Rate **Q** (cm^3/min)	Estimated Cutting Power (kW)	Expected Torque (Nm)	Tool Life Ratio (%)
S	Titanium Alloy (Ti-6Al-4V)	ϕ63	4	LS	40	202	60	63	0.10	81	306	13.4	634	40
			4	MS	50	253	60	38	0.10	101	229	9.5	357	60
			4	MS	60	303	60	25	0.10	121	183	7.2	228	80
			4	HS	60	303	60	13	0.12	146	110	4.7	148	100
		ϕ80	5	LS	40	159	75	80	0.10	80	477	20.8	1250	40
			5	MS	50	199	75	48	0.10	99	358	14.7	705	60
			5	MS	60	239	75	32	0.10	119	286	11.2	449	80
			5	HS	60	239	75	16	0.12	143	172	7.3	291	100
		ϕ100	6	LS	40	127	90	100	0.10	76	688	29.6	2218	40
			6	MS	50	159	90	60	0.10	95	516	20.9	1252	60
			6	MS	60	191	90	40	0.10	115	413	16.0	798	80
			6	HS	60	191	90	20	0.12	138	248	10.3	517	100
	Titanium Alloy (Ti-5Al-5V-5Mo-3Cr)	ϕ63	4	LS	25	126	60	63	0.08	40	153	7.0	527	30
			4	MS	25	126	60	38	0.08	40	92	4.0	303	50
			4	MS	30	152	60	25	0.10	61	92	3.8	241	70
			4	HS	30	152	60	13	0.10	61	46	2.1	133	80
		ϕ80	5	LS	25	99	75	80	0.08	40	239	10.8	1038	30
			5	MS	25	99	75	48	0.08	40	143	6.2	597	50
			5	MS	30	119	75	32	0.10	60	143	5.9	475	70
			5	HS	30	119	75	16	0.10	60	72	3.3	263	80
		ϕ100	6	LS	25	80	90	100	0.08	38	344	15.3	1841	30
			6	MS	25	80	90	60	0.08	38	206	8.8	1059	50
			6	MS	30	95	90	40	0.10	57	206	8.4	844	70
			6	HS	30	95	90	20	0.10	57	103	4.7	466	80

Note 1) Please note that machining performance varies depending to the conditions such as machine rigidity, work clamping rigidity, coolant supply system, pressure and flow volume etc.

Note 2) Internal coolant is recommended. Please use an FMH type arbor for through coolant. Using external coolant in combination with through coolant is even more effective.

Note 3) The tool life ratio shows the standard when ae = tool diameter × 20% is assumed to be 100 when shoulder cutting.

Note 4) The maximum depth of cut (apmax) varies according to the machine rigidity and power.

BALL NOSE END MILL

TOOL NEWS

SRF/SRB

P	M	K	N	S	H
Steel		Cast Iron	Non-ferrous Metal		Hardened Steel

- **S-shaped cutting edge provides sharpness similar to that of solid ball nose end mills.**
- **Highly accurate corner radius tolerance allows for high precision finishing.**
- **Carbide shank type available.**

Fig.1

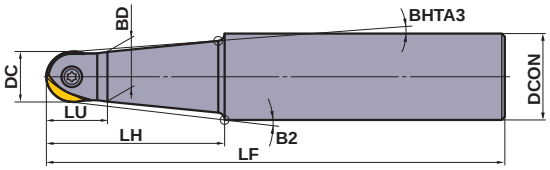


Fig.2

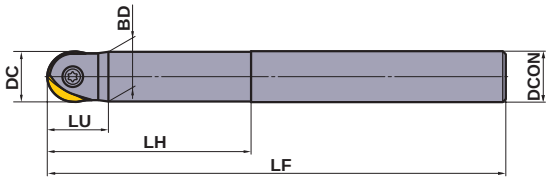
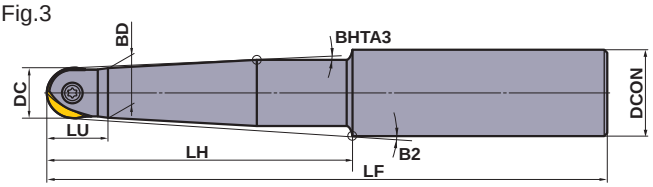


Fig.3



Right hand tool holder only.

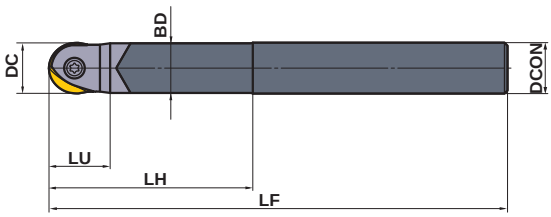
■STEEL SHANK TYPE

Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) RE*2	DC	DCON	LF	BD	LH	LU	B2	BHTA3	Fig.	Clamp Screw *1	Wrench ①②	Insert
Standard	SRFH10S12M	●	1	5	10	12	110	9.5	40	13	1.63°	1.5°	1	RS3008T	①TKY08D	SRFT10 SRBT10
	SRFH12S16M	●	1	6	12	16	120	11.5	50	15	2.6°	1.5°	1	RS3510T	①TKY10D	SRFT12 SRBT12
	SRFH16S20M	●	1	8	16	20	130	15.5	50	20	2.73	1.5°	1	RS4015T	②TKY15T	SRFT16 SRBT16
	SRFH20S25M	●	1	10	20	25	150	19.5	70	24	2.38°	1.5°	1	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH25S32M	●	1	12.5	25	32	180	24.5	80	30	2.97°	1.5°	1	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH30S32M	●	1	15	30	32	200	29.5	100	35	—	—	2	RS8030T	②TKY30T	SRFT30 SRBT30
	SRFH32S32M	●	1	16	32	32	200	31.5	100	35	—	—	2	RS8030T	②TKY30T	SRFT32 SRBT32
Semi-long	SRFH10S12L	●	1	5	10	12	150	9.5	60	13	1.5°	1.5°	1	RS3008T	①TKY08D	SRFT10 SRBT10
	SRFH12S16L	●	1	6	12	16	160	11.5	70	15	1.78°	1.5°	1	RS3510T	①TKY10D	SRFT12 SRBT12
	SRFH16S20L	●	1	8	16	20	160	15.5	70	20	1.85°	1.5°	1	RS4015T	②TKY15T	SRFT16 SRBT16
	SRFH20S25L	●	1	10	20	25	180	19.5	80	24	2.05°	1.5°	1	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH20S20L80	●	1	10	20	20	180	19.5	80	24	—	—	2	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH25S32L	●	1	12.5	25	32	200	24.5	100	30	2.28°	1.5°	1	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH25S25L100	●	1	12.5	25	25	200	24.5	100	30	—	—	2	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH30S32L	●	1	15	30	32	230	29.5	130	35	—	—	2	RS8030T	②TKY30T	SRFT30 SRBT30
Long	SRFH20S25E	●	1	10	20	25	220	19.5	120	24	1.5°	1.5°	3	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH20S20E120	●	1	10	20	20	220	19.5	120	24	—	—	2	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH25S32E	●	1	12.5	25	32	250	24.5	150	30	1.5°	1.5°	3	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH25S25E150	●	1	12.5	25	25	250	24.5	150	30	—	—	2	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH30S32E	●	1	15	30	32	300	29.5	200	35	—	—	2	RS8030T	②TKY30T	SRFT30 SRBT30

*1 Clamp Torque (N • m) : RS3008T=1.5, RS3510T=2.5, RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0
*2 RE is shown for insert corner R.

● : **Inventory maintained in Japan.**

Fig.1

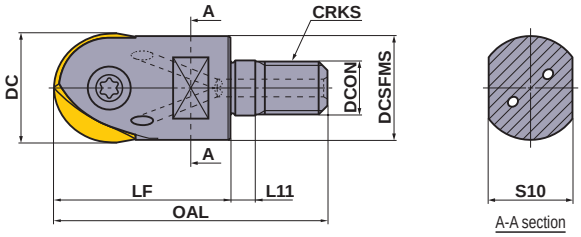


Right hand tool holder only.

■CARBIDE SHANK TYPE

Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) RE*2	DC	DCON	LF	BD	LH	LU	Fig.	Clamp Screw *1	Wrench ①②	Insert
Standard	**SRFH10S10MW**	●	1	5	10	10	110	9.5	40	13	1	RS3008T	①TKY08D	SRFT10 SRBT10
	SRFH12S12MW	●	1	6	12	12	120	11.5	50	15	1	RS3510T	①TKY10D	SRFT12 SRBT12
	SRFH16S16MW	●	1	8	16	16	130	15.5	50	20	1	RS4015T	②TKY15T	SRFT16 SRBT16
	SRFH20S20MW	●	1	10	20	20	180	19.5	80	24	1	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH25S25MW	●	1	12.5	25	25	200	24.5	100	30	1	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH30S32MW	●	1	15	30	32	230	29.5	130	35	1	RS8030T	②TKY30T	SRFT30 SRBT30
				16	32	32	231	29.5	131	36				SRFT32 SRBT32
Long	**SRFH10S10LW**	●	1	5	10	10	150	9.5	60	13	1	RS3008T	①TKY08D	SRFT10 SRBT10
	SRFH12S12LW	●	1	6	12	12	160	11.5	70	15	1	RS3510T	①TKY10D	SRFT12 SRBT12
	SRFH16S16LW	●	1	8	16	16	160	15.5	70	20	1	RS4015T	②TKY15T	SRFT16 SRBT16
	SRFH16S16EW	●	1	8	16	16	200	15.5	110	20	1	RS4015T	②TKY15T	SRFT16 SRBT16
	SRFH20S20LW	●	1	10	20	20	250	19.5	150	24	1	RS5020T	②TKY20T	SRFT20 SRBT20
	SRFH25S25LW	●	1	12.5	25	25	300	24.5	200	30	1	RS6025T	②TKY25T	SRFT25 SRBT25
	SRFH30S32LW	●	1	15	30	32	350	29.5	250	35	1	RS8030T	②TKY30T	SRFT30 SRBT30
				16	32	32	351	29.5	251	36				SRFT32 SRBT32

Note 1) SRFH30S32MW and SRFH30S32LW tool body can use both inserts SRFT30 and SRFT32.
However, the overall length size LF is different respectively.
*1 Clamp Torque (N • m) : RS3008T=1.5, RS3510T=2.5, RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0
*2 RE is shown for insert corner R.



■SCREW-IN TYPE

Right hand tool holder only.

Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) RE*2	DC	DCON	DCSFMS	OAL	LF	L11	S10	CRKS	*2 WT (kg)	Clamp Screw *1	Wrench	Insert
SRFH16AM0830	●	○	1	8	16	8.5	14.9	48	30	6	10	8	0.1	RS4015T	TKY15T	SRFT16 SRBT16
SRFH20AM1035	●	○	1	10	20	10.5	18.4	54	35	6	14	10	0.1	RS5020T	TKY20T	SRFT20 SRBT20
SRFH25AM1240	●	○	1	12.5	25	12.5	23.5	62	40	6	19	12	0.1	RS6025T	TKY25T	SRFT25 SRBT25
SRFH30AM1645	●	○	1	15	30	17	28.1	68	45	6	24	16	0.2	RS8030T	TKY30T	SRFT30 SRBT30
				16	32	17	28.1	69	46	6	24	16	0.2			SRFT32 SRBT32

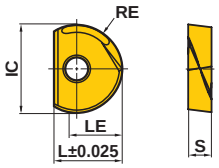
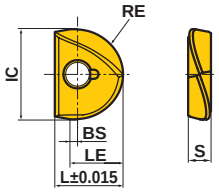
Note 1) SRFH30AM1645 tool body can use both inserts SRFT30 and SRFT32. However, the overall length size OAL is different respectively.
Note 2) For screw-in type arbors, refer to page M269.
*1 Clamp Torque (N • m) : RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0
*2 RE is shown for insert corner R.
*3 WT : Tool Weight

ARBORS	➤ M269
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

INSERTS

Work Material			EP6120	VP15TF	MP8010	
	P	Steel	◐	◐		
	M	Stainless Steel		◔		
	K	Cast Iron		✠	●	
	N	Non-ferrous Metal	◐			
	H	Hardened Steel	◔	◔	●	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Coated EP6120	Coated VP15TF	Coated MP8010		Dimensions (mm) IC	RE Corner R	RE Tolerance	L	LE	BS	S	Geometry
	SRBT10		●			10	5	±0.02	8.5	—	—	2.6	
	SRBT12		●			12	6	±0.02	10	—	—	3	
	SRBT16		●			16	8	±0.025	12	—	—	4	
	SRBT20		●			20	10	±0.025	15	—	—	5	
	SRBT25		●			25	12.5	±0.035	18.5	—	—	6	
	SRBT30		●			30	15	±0.035	22.5	—	—	7	
	SRBT32		●			32	16	±0.035	23.5	—	—	7	
	SRFT10	●	●	●		10	5	±0.06	8.5	5.5	0.5	2.6	
	SRFT12	●	●	●		12	6	±0.06	10	6.5	0.5	3	
	SRFT16	●	●	●		16	8	±0.06	12	9	1	4	
	SRFT20	●	●	●		20	10	±0.06	15	11	1	5	
	SRFT25	●	●	●		25	12.5	±0.06	18.5	13.5	1	6	
	SRFT30	●	●	●		30	15	±0.06	22.5	16	1	7	
	SRFT32	●	●	●		32	16	±0.06	23.5	17	1	7	

FITTING INSERTS ON HOLDERS

1. Clean the insert seat

Clean the insert seat in the holder body by blowing air or using a brush.

2. Fit the insert

Place the concave mark of the insert into the clamp-screw-fastening part of the holder(only SRF type inserts). Fasten the clamp screw while firmly pressing the insert against the insert seat wall. You are recommended to use the special lubricant for preventing screw seizing, MK1KS, and to fasten with recommended torque.

● : Inventory maintained in Japan. (2 inserts in one case)

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)	Depth of Cut **ap** (mm)
P	Mild Steel (ASTM A36, AISI 1010)	≤180HB	**EP6120**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
	Carbon Steel, Alloy Steel (AISI 1045, AISI 4140)	180—280HB	**EP6120**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
			VP15TF	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
	Carbon Steel, Alloy Steel (AISI 4340)	280—350HB	**EP6120**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
	Pre-Hardened Steel (AISI P21, AISI P20 etc)	35—45HRC	**EP6120**	150 (80—200)	0.2 (0.1—0.3)	≤0.05DC
			VP15TF	150 (80—200)	0.2 (0.1—0.3)	≤0.05DC
	Alloy Tool Steel	≤350HB	**EP6120**	150 (80—200)	0.2 (0.1—0.3)	≤0.05DC
			VP15TF	150 (80—200)	0.2 (0.1—0.3)	≤0.05DC
K	Gray Cast Iron (FC300)	Tensile Strength ≤350MPa	**MP8010**	250 (80—450)	0.2 (0.1—0.3)	≤0.05DC
	Ductile Cast Iron (FCD450)	Tensile Strength ≤450MPa	**MP8010**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MP8010**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
N	Copper, Copper alloys	—	**EP6120**	200 (80—300)	0.2 (0.1—0.3)	≤0.05DC
H	Hardened Steel	45—55HRC	**MP8010**	100 (60—120)	0.2 (0.1—0.3)	≤0.05DC
	Hardened Steel	55—65HRC	**MP8010**	80 (60—120)	0.2 (0.1—0.3)	≤0.01DC

Note 1) The above values are average condition values at actual cutting speeds. The values change slightly according to the state of a machine to be used and method of workholding. Adjust the values depending on an actual machine condition, referring to the above values.
Note 2) For end mills with a carbide shank, you will be able to set about 20% higher cutting conditions.
Note 3) Please note the following when machining hardened steel with MP8010.
- Please shorten the overhang length as much as possible.
- Use with carbide shank recommended.
- Please note the setting of the depth of cut especially to prevent the fracture.

CUTTING SPEED FORMULAE

1. Employing $\theta°$ ➡ Calculate cutting speed at point P.
(Cutting speed at the cutting depth border for oblique machining)

Formula : Cutting Speed = $\dfrac{\pi \cdot DC \cdot \sin\theta \cdot n}{1000}$ (m/min)

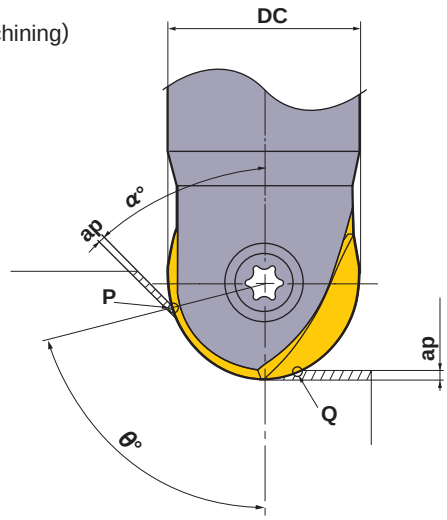
$$\theta° = \cos^{-1}\left(\frac{DC-2ap}{DC}\right)+90-\alpha$$

n : Spindle Speed (min^{-1})

2. Employing ap ➡ Calculate cutting speed at point Q.
(Cutting speed at the cutting depth border)

Formula : Cutting Speed = $\dfrac{2\pi n\sqrt{ap\,(DC-ap)}}{1000}$ (m/min)

n : Spindle Speed (min^{-1})
DC : Cutting Edge Diameter (mm)
ap : Depth of Cut (mm)



M

INDEXABLE MILLING

RADIUS END MILL

TOOL NEWS

R KAPR

SUF

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel

- **Highly accurate corner radius tolerance allows for high precision finishing.**
- **Seamless gash.**

Fig.1

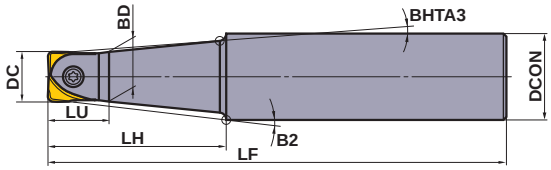


Fig.2

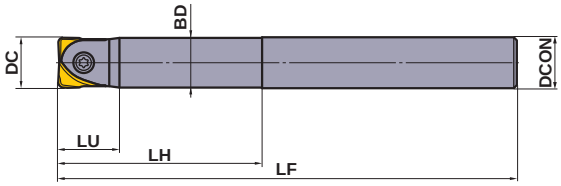
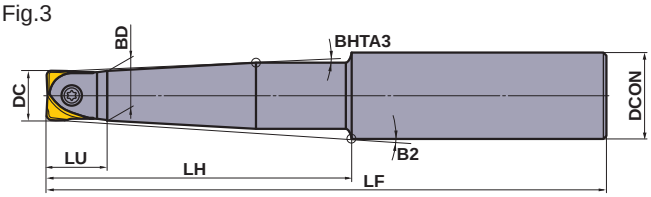


Fig.3



■STEEL SHANK TYPE

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	DCON	LF	BD	LH	LU	B2	BHTA3	Fig.	Clamp Screw *	Wrench ①②	Insert
Standard	SRFH10S12M	●	1	10	12	110	9.5	40	13	1.63°	—	1	RS3008T	①TKY08D	SUFT10R○○
	SRFH12S16M	●	1	12	16	120	11.5	50	15	2.60°	—	1	RS3510T	①TKY10D	SUFT12R○○
	SRFH16S20M	●	1	16	20	130	15.5	50	20	2.73°	—	1	RS4015T	②TKY15T	SUFT16R○○
	SRFH20S25M	●	1	20	25	150	19.5	70	24	2.38°	1.5°	1	RS5020T	②TKY20T	SUFT20R○○
	SRFH25S32M	●	1	25	32	180	24.5	80	30	2.97°	1.5°	1	RS6025T	②TKY25T	SUFT25R○○
	SRFH30S32M	●	1	30	32	200	29.5	100	35	—	—	2	RS8030T	②TKY30T	SUFT30R○○
	SRFH32S32M	●	1	32	32	200	31.5	100	35	—	—	2	RS8030T	②TKY30T	SUFT32R○○
Semi-long	SRFH10S12L	●	1	10	12	150	9.5	60	13	1.5°	—	1	RS3008T	①TKY08D	SUFT10R○○
	SRFH12S16L	●	1	12	16	160	11.5	70	15	1.78°	—	1	RS3510T	①TKY10D	SUFT12R○○
	SRFH16S20L	●	1	16	20	160	15.5	70	20	1.85°	—	1	RS4015T	②TKY15T	SUFT16R○○
	SRFH20S25L	●	1	20	25	180	19.5	80	24	2.05°	1.5°	1	RS5020T	②TKY20T	SUFT20R○○
	SRFH20S20L80	●	1	20	20	180	19.5	80	24	—	—	2	RS5020T	②TKY20T	SUFT20R○○
	SRFH25S32L	●	1	25	32	200	24.5	100	30	2.28°	1.5°	1	RS6025T	②TKY25T	SUFT25R○○
	SRFH25S25L100	●	1	25	25	200	24.5	100	30	—	—	2	RS6025T	②TKY25T	SUFT25R○○
	SRFH30S32L	●	1	30	32	230	29.5	130	35	—	—	2	RS8030T	②TKY30T	SUFT30R○○
Long	SRFH20S25E	●	1	20	25	220	19.5	120	24	1.5°	1.5°	3	RS5020T	②TKY20T	SUFT20R○○
	SRFH20S20E120	●	1	20	20	220	19.5	120	24	—	—	2	RS5020T	②TKY20T	SUFT20R○○
	SRFH25S32E	●	1	25	32	250	24.5	150	30	1.5°	1.5°	3	RS6025T	②TKY25T	SUFT25R○○
	SRFH25S25E150	●	1	25	25	250	24.5	150	30	—	—	2	RS6025T	②TKY25T	SUFT25R○○
	SRFH30S32E	●	1	30	32	300	29.5	200	35	—	—	2	RS8030T	②TKY30T	SUFT30R○○

* Clamp Torque (N • m) : RS3008T=1.5, RS3510T=2.5, RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0

● : **Inventory maintained in Japan.**

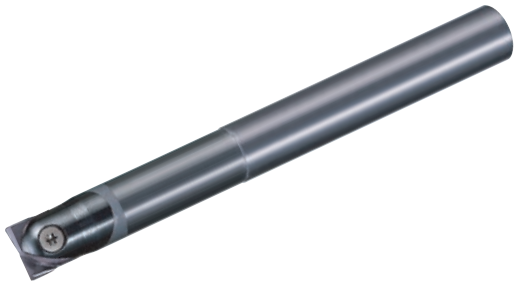
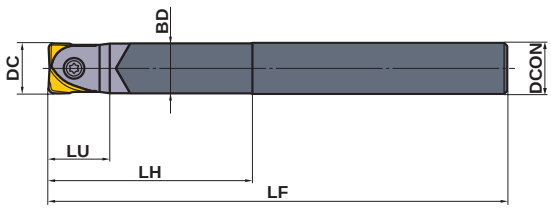


Fig.1

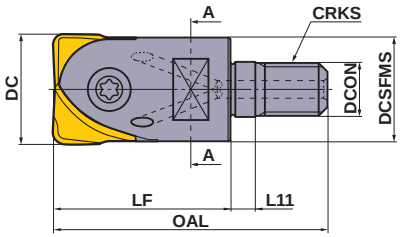


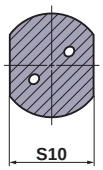
■CARBIDE SHANK TYPE

Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	DCON	LF	BD	LH	LU	Fig.	Clamp Screw *	Wrench ①②	Insert
Standard	**SRFH10S10MW**	●	1	10	10	110	9.5	40	13	1	RS3008T	①TKY08D	SUFT10R○○
	SRFH12S12MW	●	1	12	12	120	11.5	50	15	1	RS3510T	①TKY10D	SUFT12R○○
	SRFH16S16MW	●	1	16	16	130	15.5	50	20	1	RS4015T	②TKY15T	SUFT16R○○
	SRFH20S20MW	●	1	20	20	180	19.5	80	24	1	RS5020T	②TKY20T	SUFT20R○○
	SRFH25S25MW	●	1	25	25	200	24.5	100	30	1	RS6025T	②TKY25T	SUFT25R○○
	SRFH30S32MW	●	1	30	32	230	29.5	130	35	1	RS8030T	②TKY30T	SUFT30R○○
				32	32	231	29.5	131	36				SUFT32R○○
Long	**SRFH10S10LW**	●	1	10	10	150	9.5	60	13	1	RS3008T	①TKY08D	SUFT10R○○
	SRFH12S12LW	●	1	12	12	160	11.5	70	15	1	RS3510T	①TKY10D	SUFT12R○○
	SRFH16S16LW	●	1	16	16	160	15.5	70	20	1	RS4015T	②TKY15T	SUFT16R○○
	SRFH20S20LW	●	1	20	20	250	19.5	150	24	1	RS5020T	②TKY20T	SUFT20R○○
	SRFH25S25LW	●	1	25	25	300	24.5	200	30	1	RS6025T	②TKY25T	SUFT25R○○
	SRFH30S32LW	●	1	30	32	350	29.5	250	35	1	RS8030T	②TKY30T	SUFT30R○○
				32	32	351	29.5	251	36				SUFT32R○○

Note 1) SRFH30S32MW and SRFH30S32LW tool body can use both inserts SUFT30R○○ and SUFT32R○○.
However, the overall length size LF is different respectively.
* Clamp Torque (N • m) : RS3008T=1.5, RS3510T=2.5, RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0





■SCREW-IN TYPE

Right hand tool holder only.

Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) DC	DCON	DCSFMS	OAL	LF	L11	S10	CRKS	*2 WT (kg)	Clamp Screw *1	Wrench	Insert
SRFH16AM0830	●	○	1	16	8.5	14.9	48	30	6	10	8	0.1	RS4015T	TKY15T	SUFT16R○○
SRFH20AM1035	●	○	1	20	10.5	18.4	54	35	6	14	10	0.1	RS5020T	TKY20T	SUFT20R○○
SRFH25AM1240	●	○	1	25	12.5	23.5	62	40	6	19	12	0.1	RS6025T	TKY25T	SUFT25R○○
SRFH30AM1645	●	○	1	30	17	28.1	68	45	6	24	16	0.2	RS8030T	TKY30T	SUFT30R○○
				32	17	28.1	69	46	6	24	16				SUFT32R○○

Note 1) SRFH30AM1645 tool body can use both inserts SUFT30R○○ and SUFT32R○○.
However, the overall length size OAL is different respectively.
Note 2) For screw-in type arbors, refer to page M269.
*1 Clamp Torque (N • m) : RS4015T=3.3, RS5020T=5.0, RS6025T=7.5, RS8030T=10.0
*2 WT : Tool Weight

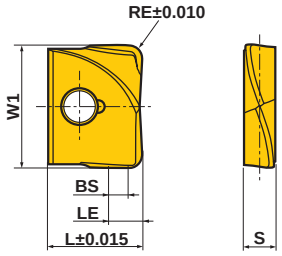
ARBORS	➤ M269
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

INSERTS

Work Material			MP8010	VP15TF			W1	RE	BS	LE	L	S	Geometry
	P	Steel		◐									
	M	Stainless Steel		◔									
	K	Cast Iron	●	✣									
	H	Hardened Steel	●	◐									

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	MP8010 (Coated)	VP15TF (Coated)	W1	RE	BS	LE	L	S
	SUFT10R05	●	●	10	0.5	1	1.5	8.5	2.6
	SUFT10R10	●	●	10	1	1	2	8.5	2.6
	SUFT10R20	●	●	10	2	1	3	8.5	2.6
	SUFT12R05	●	●	12	0.5	1.2	1.7	10	3
	SUFT12R10	●	●	12	1	1.2	2.2	10	3
	SUFT12R20	●	●	12	2	1.2	3.2	10	3
	SUFT12R30	●	●	12	3	1.2	4.2	10	3
	SUFT16R05	●	●	16	0.5	1.6	2.1	12	4
	SUFT16R10	●	●	16	1	1.6	2.6	12	4
	SUFT16R15	●	●	16	1.5	1.6	3.1	12	4
	SUFT16R20	●	●	16	2	1.6	3.6	12	4
	SUFT16R30	●	●	16	3	1.6	4.6	12	4
	SUFT20R05	●	●	20	0.5	2	2.5	15	5
	SUFT20R10	●	●	20	1	2	3	15	5
	SUFT20R15	●	●	20	1.5	2	3.5	15	5
	SUFT20R20	●	●	20	2	2	4	15	5
	SUFT20R30	●	●	20	3	2	5	15	5
	SUFT25R05	●	●	25	0.5	2.5	3	18.5	6
	SUFT25R10	●	●	25	1	2.5	3.5	18.5	6
	SUFT25R20	●	●	25	2	2.5	4.5	18.5	6
	SUFT25R30	●	●	25	3	2.5	5.5	18.5	6
	SUFT30R05	●	●	30	0.5	3	3.5	22.5	7
	SUFT30R10	●	●	30	1	3	4	22.5	7
	SUFT30R20	●	●	30	2	3	5	22.5	7
	SUFT30R30	●	●	30	3	3	6	22.5	7
	SUFT32R05	●	●	32	0.5	3.2	3.7	23.5	7
	SUFT32R10	●	●	32	1	3.2	4.2	23.5	7
	SUFT32R20	●	●	32	2	3.2	5.2	23.5	7



FITTING INSERTS ON HOLDERS

1. Clean the insert seat

Clean the insert seat in the holder body by blowing air or using a brush.

2. Fit the insert

Place the concave mark of the insert into the clamp-screw-fastening part of the holder(only SRF type inserts). Fasten the clamp screw while firmly pressing the insert against the insert seat wall. You are recommended to use the special lubricant for preventing screw seizing, MK1KS, and to fasten with recommended torque.

● : **Inventory maintained in Japan. (2 inserts in one case)**

RECOMMENDED CUTTING CONDITIONS

■SHOULDER MILLING(When small width of cut.*)

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	Depth of Cut **ap** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)
P	Carbon Steel Alloy Steel	180—280HB	**VP15TF**	200 (80—300)	≤0.05DC	≤0.05DC	0.2 (≤0.4)
	Pre-Hardened Steel	≤45HRC	**VP15TF**	150 (80—200)	≤0.05DC	≤0.05DC	0.15 (≤0.3)
	Alloy Tool Steel	180—380HB	**VP15TF**	150 (80—200)	≤0.05DC	≤0.05DC	0.15 (≤0.3)
M	Stainless Steel	≤270HB	**VP15TF**	150 (100—200)	≤0.05DC	≤0.05DC	0.2 (≤0.4)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MP8010**	250 (180—450)	≤0.05DC	≤0.1DC	0.3 (≤0.4)
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MP8010**	200 (80—300)	≤0.05DC	≤0.1DC	0.3 (≤0.4)
H	Hardened Steel	45—55HRC	**MP8010**	100 (80—120)	≤0.05DC	≤0.02DC	0.1 (≤0.2)
	Hardened Steel	55—65HRC	**MP8010**	80 (60—100)	≤0.05DC	≤0.02DC	0.1 (≤0.2)

* When the pick feed direction is along the axis of the tool such as finish machining at the wall part.

■SLOTTING•SHOULDER MILLING(When large width of cut.*)

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	Depth of Cut **ap** (mm)	Cutting Width **ae** (mm)	Feed per Tooth **fz** (mm/t.)
P	Carbon Steel Alloy Steel	180—280HB	**VP15TF**	200 (80—300)	≤0.02DC	≤DC	0.2 (≤0.4)
	Pre-Hardened Steel	≤45HRC	**VP15TF**	150 (80—200)	≤0.02DC	≤DC	0.15 (≤0.3)
	Alloy Tool Steel	180—380HB	**VP15TF**	150 (80—200)	≤0.02DC	≤DC	0.15 (≤0.3)
M	Stainless Steel	≤270HB	**VP15TF**	150 (100—200)	≤0.02DC	≤DC	0.2 (≤0.4)
K	Gray Cast Iron	Tensile Strength ≤350MPa	**MP8010**	250 (180—450)	≤0.03DC	≤DC	0.3 (≤0.4)
	Ductile Cast Iron	Tensile Strength ≤800MPa	**MP8010**	200 (80—300)	≤0.03DC	≤DC	0.3 (≤0.4)
H	Hardened Steel	45—55HRC	**MP8010**	100 (80—120)	≤0.01DC	≤DC	0.1 (≤0.2)
	Hardened Steel	55—65HRC	**MP8010**	70 (60—80)	≤0.01DC	≤DC	0.1 (≤0.2)

* When the pick feed direction is along the axis of the tool such as finish machining at the wall part.

Note 1) This cutting condition is the standard condition when using the steel standard shank type. If it is occurred vibration or chipping on the cutting edge, please decrease the cutting condition as width of cut, depth of cut and feed per tooth depending on the situation.

Note 2) The value of cutting speed is stood at the peripheral diameter of the tool. Please calculate the spindle speed of tool in the following expressions.

Spindle speed of cutting tool n(min^{-1})=1000×Cutting speed vc ÷Diameter of cutting tool DC÷3.14

Note 3) Please note the following when machining hardened steel with MP8010.

- Please shorten the overhang length as much as possible.
- Use with carbide shank recommended.
- Please note the setting of the depth of cut especially to prevent the fracture.

BALL NOSE END MILL

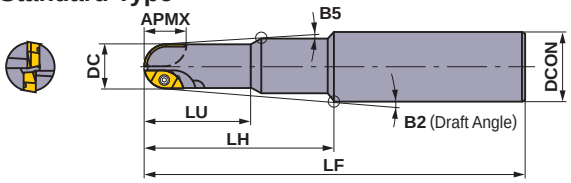
TOOL NEWS

SRM2

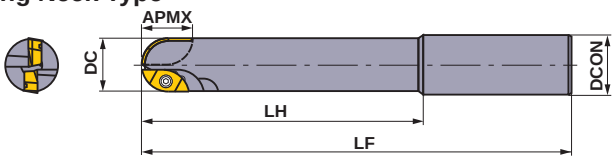
P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			Hardened Steel

- Suitable for roughing to semi-finishing of small and medium moulds.
- High rigidity body design.
- Low resistance chipbreaker.
- Through coolant hole type.

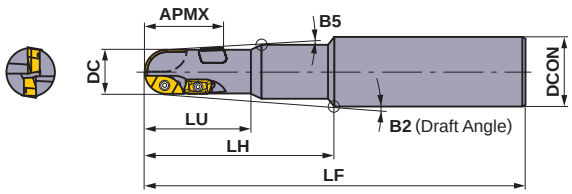
Standard Type



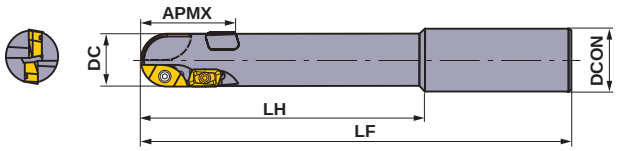
Long Neck Type



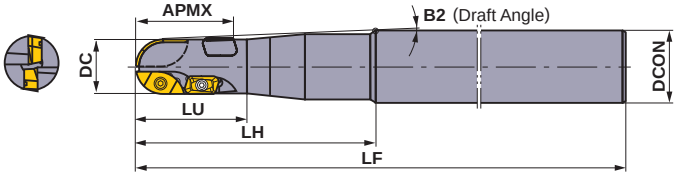
Long Cutting Edge Type



Long Neck Cutting Edge Type



Extra Long Cutting Edge Type



Right hand tool holder only.

Type	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) RE *2	DC	DCON	LF	LH	LU	APMX	B2	B5	*1 Inner, Outer Clamp Screw	*1 Peripheral Clamp Screw	① Inner, Outer Wrench	② Peripheral Wrench	③ Inner Insert	Outer Insert	Peripheral Insert
Standard	SRM2160SNM	●	–	2	8	16	20	130	50	25	12	2.8°	1.5°	TS25H	–	①TKY08D	–	SRG16C SRM16C-M	SRG16E SRM16E-M	–
	SRM2160SAM	●	○	2	8	16	20	130	50	25	12	2.8°	1.5°	TS25H	–	①TKY08D	–	SRG16C SRM16C-M	SRG16E SRM16E-M	–
	SRM2200SNM	●	–	2	10	20	25	150	70	35	14	2.45°	1.5°	TS32	–	①TKY08D	–	SRG20C SRM20C-M	SRG20E SRM20E-M	–
	SRM2200SAM	●	○	2	10	20	25	150	70	35	14	2.45°	1.5°	TS32	–	①TKY08D	–	SRG20C SRM20C-M	SRG20E SRM20E-M	–
	SRM2250SNM	●	–	2	12.5	25	32	180	80	40	19	3.22°	1.5°	TS43	–	②TKY15T	–	SRG25C SRM25C-M	SRG25E SRM25E-M	–
	SRM2250SAM	●	○	2	12.5	25	32	180	80	40	19	3.22°	1.5°	TS43	–	②TKY15T	–	SRG25C SRM25C-M	SRG25E SRM25E-M	–
	SRM2300SNM	●	–	2	15	30	32	200	100	50	24	0.73°	0.5°	TS55	–	②TKY25T	–	SRG30C SRM30C-M	SRG30E SRM30E-M	–
	SRM2300SAM	●	○	2	15	30	32	200	100	50	24	0.73°	0.5°	TS55	–	②TKY25T	–	SRG30C SRM30C-M	SRG30E SRM30E-M	–

*1 Clamp Torque (N • m) : TS25H=1.7, TS25=1.0, TS32=2.0, TS43=3.5, TS55=7.5

*2 RE is shown for insert corner R.

● : Inventory maintained in Japan.

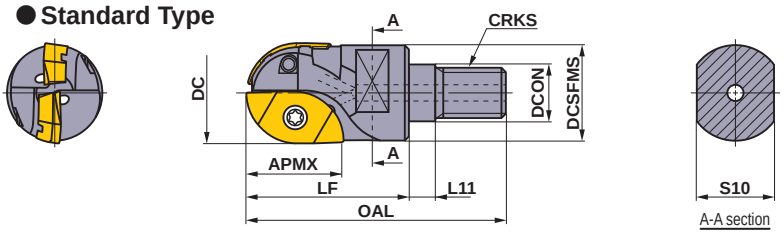
Type	Order Number	Stock R	Coolant Hole	Number of Teeth	Dimensions (mm) RE *2	DC	DCON	LF	LH	LU	APMX	B2	B5	Clamp Screw *1 Inner, Outer	Clamp Screw *1 Peripheral	Wrench ① Inner, Outer	Wrench ② Peripheral	Insert Inner	Insert Outer	Insert Peripheral
Long Cutting Edge	**SRM2200SNL**	●	–	4	10	20	25	150	70	35	30	2.45°	1.5°	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2200SAL	●	○	4	10	20	25	150	70	35	30	2.45°	1.5°	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2250SNL	●	–	4	12.5	25	32	180	80	40	37	3.22°	1.5°	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2250SAL	●	○	4	12.5	25	32	180	80	40	37	3.22°	1.5°	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2300SNL	●	–	4	15	30	32	200	100	50	44	0.73°	0.5°	TS55	TS43	②TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2
	SRM2300SAL	●	○	4	15	30	32	200	100	50	44	0.73°	0.5°	TS55	TS43	②TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2
Long Neck	**SRM2160SNF**	●	–	2	8	16	16	150	70	–	12	–	–	TS25H	–	①TKY08D	–	SRG16C SRM16C-M	SRG16E SRM16E-M	–
	SRM2160SAF	●	○	2	8	16	16	150	70	–	12	–	–	TS25H	–	①TKY08D	–	SRG16C SRM16C-M	SRG16E SRM16E-M	–
	SRM2200SNF	●	–	2	10	20	20	180	100	–	14	–	–	TS32	–	①TKY08D	–	SRG20C SRM20C-M	SRG20E SRM20E-M	–
	SRM2200SAF	●	○	2	10	20	20	180	100	–	14	–	–	TS32	–	①TKY08D	–	SRG20C SRM20C-M	SRG20E SRM20E-M	–
	SRM2250SNF	●	–	2	12.5	25	25	200	120	–	19	–	–	TS43	–	②TKY15T	–	SRG25C SRM25C-M	SRG25E SRM25E-M	–
	SRM2250SAF	●	○	2	12.5	25	25	200	120	–	19	–	–	TS43	–	②TKY15T	–	SRG25C SRM25C-M	SRG25E SRM25E-M	–
	SRM2300SNF	●	–	2	15	30	32	230	150	–	24	–	–	TS55	–	②TKY25T	–	SRG30C SRM30C-M	SRG30E SRM30E-M	–
	SRM2300SAF	●	○	2	15	30	32	230	150	–	24	–	–	TS55	–	②TKY25T	–	SRG30C SRM30C-M	SRG30E SRM30E-M	–
Long Neck Cutting Edge	**SRM2200SNLF**	●	–	4	10	20	20	180	100	–	30	–	–	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2200SALF	●	○	4	10	20	20	180	100	–	30	–	–	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2250SNLF	●	–	4	12.5	25	25	200	120	–	37	–	–	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2250SALF	●	○	4	12.5	25	25	200	120	–	37	–	–	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2300SNLF	●	–	4	15	30	32	230	150	–	44	–	–	TS55	TS43	②TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2
	SRM2300SALF	●	○	4	15	30	32	230	150	–	44	–	–	TS55	TS43	②TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2
Extra Long Cutting Edge	**SRM2200SNLL**	●	–	4	10	20	25	250	120	35	30	1.5°	–	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2200SALL	●	○	4	10	20	25	250	120	35	30	1.5°	–	TS32	TS25	①TKY08D	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-◌2
	SRM2250SNLL	●	–	4	12.5	25	32	300	170	37	37	1.5°	–	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2250SALL	●	○	4	12.5	25	32	300	170	37	37	1.5°	–	TS43	TS25	②TKY15T	③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-◌2
	SRM2300SNLL	●	–	4	15	30	32	350	100	50	44	1.5°	–	TS55	TS43	③TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2
	SRM2300SALL	●	○	4	15	30	32	350	100	50	44	1.5°	–	TS55	TS43	③TKY25T	③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-◌2

*1 Clamp Torque (N • m) : TS25H=1.7, TS25=1.0, TS32=2.0, TS43=3.5, TS55=7.5

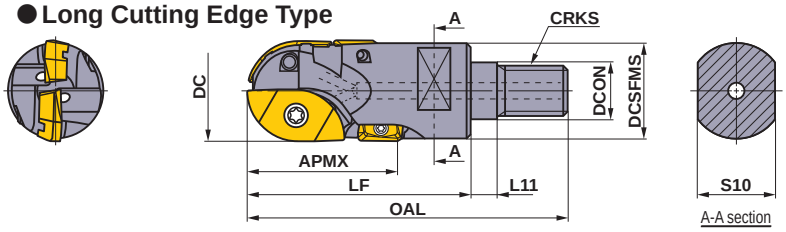
*2 RE is shown for insert corner R.

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

● Standard Type



● Long Cutting Edge Type



■ SCREW-IN TYPE

Right hand tool holder only.

Type	Order Number	Stock R	Coolant Hole	Dimensions (mm) RE *2	DC	DCON	DCSFMS	OAL	LF	L11	S10	CRKS	APMX	*2 WT (kg)	*1 Clamp Screw Inner, Outer	*1 Clamp Screw Peripheral	Wrench	Insert Inner	Insert Outer	Insert Peripheral
Standard	SRM2160AM08S30	●	○	8	16	8.5	14.6	48	30	6	10	M8	12	0.1	TS25H	—	①TKY08D	SRG16C SRM16C-M	SRG16E SRM16E-M	—
Standard	SRM2200AM10S35	●	○	10	20	10.5	18.6	54	35	6	14	M10	14	0.1	TS32	—	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	—
Standard	SRM2250AM12S40	●	○	12.5	25	12.5	23.5	62	40	6	19	M12	19	0.2	TS43	—	②TKY15T	SRG25C SRM25C-M	SRG25E SRM25E-M	—
Standard	SRM2300AM16S45	●	○	15	30	17	28.3	68	45	6	24	M16	24	0.2	TS55	—	②TKY25T	SRG30C SRM30C-M	SRG30E SRM30E-M	—
Standard	SRM2320AM16S45	●	○	16	32	17	30.0	68	45	6	24	M16	28	0.2	TS55	—	②TKY25T	SRG32C SRM32C-M	SRG32E SRM32E-M	—
Long Cutting Edge	SRM2200AM10L45	●	○	10	20	10.5	18.6	64	45	6	14	M10	30	0.2	TS32	TS25	①TKY08D	SRG20C SRM20C-M	SRG20E SRM20E-M	APMT1135 PDER-□2
Long Cutting Edge	SRM2250AM12L55	●	○	12.5	25	12.5	23.5	77	55	6	19	M12	37	0.3	TS43	TS25	②TKY15T ③TKY08F	SRG25C SRM25C-M	SRG25E SRM25E-M	APMT1135 PDER-□2
Long Cutting Edge	SRM2300AM16L60	●	○	15	30	17	28.3	83	60	6	24	M16	44	0.3	TS55	TS43	②TKY25T ③TKY15F	SRG30C SRM30C-M	SRG30E SRM30E-M	APMT1604 PDER-□2
Long Cutting Edge	SRM2320AM16L60	●	○	16	32	17	29.0	83	60	6	24	M16	44	0.3	TS55	TS43	②TKY25T ③TKY15F	SRG32C SRM32C-M	SRG32E SRM32E-M	APMT1604 PDER-□2

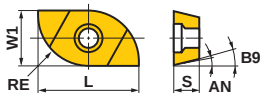
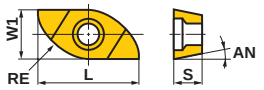
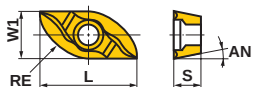
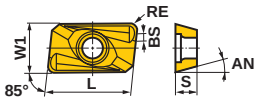
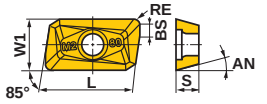
Note 1) For screw-in type arbors, refer to page M269.
*1 Clamp Torque (N • m) : TS25H=1.7, TS25=1.0, TS32=2.0, TS43=3.5, TS55=7.5
*2 RE is shown for insert corner R.
*3 WT : Tool Weight

● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material			F7030	MP6120	MP9120	VP15TF
P	Steel		◐	◐		◐
M	Stainless Steel		◔			◔
K	Cast Iron					✠
S	Heat-resistant Alloy, Titanium Alloy				◐	◐
H	Hardened Steel					◔

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

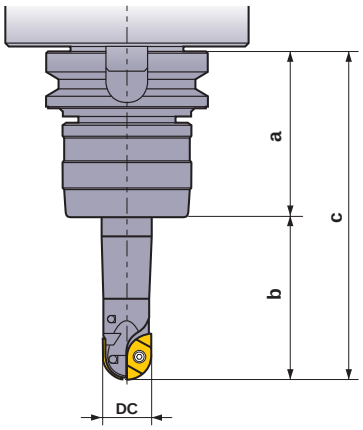
Type	Shape	Order Number	Class	Coated F7030	Coated MP6120	Coated MP9120	Coated VP15TF	RE	L	LE	W1	S	BS	AN	B9	Geometry
Inner	Strong Cutting Edge Type	**SRG16C**	G		●	●	●	8	16	–	8.2	3.5	–	11°	–	
		SRG20C	G		●	●	●	10	19	–	10.2	4.6	–	10°	18°	
		SRG25C	G		●	●	●	12.5	24	–	12.8	5.5	–	10°	18°	
		SRG30C	G		●	●	●	15	28	–	15.3	7	–	10°	18°	
		SRG32C	G		●	●	●	16	28	–	16.3	7	–	10°	18°	
Outer	Strong Cutting Edge Type	**SRG16E**	G		●	●	●	8	13.5	–	6.7	3.5	–	11°	–	
		SRG20E	G		●	●	●	10	15.5	–	8.5	4.6	–	9°	–	
		SRG25E	G		●	●	●	12.5	20.5	–	10.2	5.5	–	9°	–	
		SRG30E	G		●	●	●	15	25.2	–	12.2	7	–	9°	–	
		SRG32E	G		●	●	●	16	26.1	–	13.1	7	–	9°	–	
Inner	Low Resistance Type	**SRM16C-M**	M		●	●	●	8	16	–	8.2	3.5	–	11°	–	
		SRM20C-M	M		●	●	●	10	19	–	10.2	4.6	–	10°	18°	
		SRM25C-M	M		●	●	●	12.5	24	–	12.8	5.5	–	10°	18°	
		SRM30C-M	M		●	●	●	15	28	–	15.3	7	–	10°	18°	
		SRM32C-M	M		●	●	●	16	28	–	16.3	7	–	10°	18°	
Outer	Low Resistance Type	**SRM16E-M**	M		●	●	●	8	13.5	–	6.7	3.5	–	11°	–	
		SRM20E-M	M		●	●	●	10	15.5	–	8.5	4.6	–	9°	–	
		SRM25E-M	M		●	●	●	12.5	20.5	–	10.2	5.5	–	9°	–	
		SRM30E-M	M		●	●	●	15	25.2	–	12.2	7	–	9°	–	
		SRM32E-M	M		●	●	●	16	26.1	–	13.1	7	–	9°	–	
Peripheral	Strong Cutting Edge Type	**APMT1135PDER-H2**	M	●			●	0.8	11.25	9	6.35	3.5	1.2	11°	–	
		APMT1604PDER-H2	M	●			●	0.8	17.11	14	9.525	4.76	1.4	11°	–	
Peripheral *1	Low Resistance Type	**APMT1135PDER-M2**	M	●			●	0.8	11.18	9	6.35	3.5	1.2	11°	–	
		APMT1604PDER-M2	M	●			●	0.8	17.10	14	9.525	4.76	1.4	11°	–	

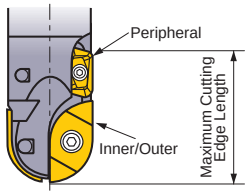
(Low-resistance inner or outer inserts are precision M class type.)
*1 Selection guide for peripheral cutting edges : The first recommendation is the super sharp M breaker (APMT....PDER-M2).
When cutting edge strength is particularly important, use the H breaker (APMT....PDER-H2).

ARBORS ➤ M269
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

RECOMMENDED CUTTING CONDITIONS

SRM2 Ø16—Ø32





(Long Cutting Edge)

Tool Overhang

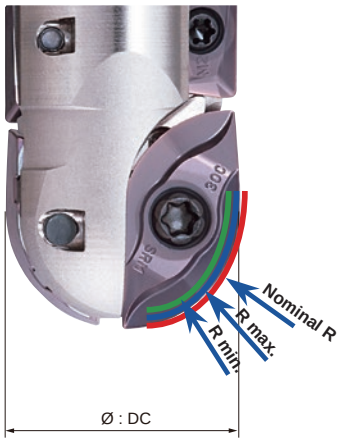
The recommended cutting conditions are chosen based on deflection, vibration and surface finish when using a BT50 arbor under the conditions below -**"a"**, a length from a gauge line to the arbor end face and **"b"**, neck length (tool overhang from the arbor).

Cutting Edge Diameter:DC	Type	a	b	c
16	Standard	105	50	155
	Long Neck		70	175
	Extra Long		–	–
20	Standard		70	175
	Long Neck		100	205
	Extra Long		150	255
25	Standard		80	185
	Long Neck		120	225
	Extra Long		200	305
30	Standard		100	205
	Long Neck		150	255
	Extra Long		250	355

Recommended Depth of Cut for Long Cutting Edge Type

The maximum cutting edge length of the long cutting edge type with a peripheral insert is 1.4-1.5DC. The peripheral insert's main purpose is to remove the small un-machined portions of the pre-machined surface above the main cutting edge. Please refer to recommended cutting conditions for recommended depth of cut **ap**.

■ Radius tolerance and other dimensions with an insert mounted in the body



Radial tolerance

Cutting Edge Diameter DC	Nominal R	Tolerance	R min.	R max.
16	8	G	7.925	7.975
		M	7.910	7.970
20	10	G	9.925	9.975
		M	9.910	9.970
25	12.5	G	12.425	12.475
		M	12.410	12.470
30	15	G	14.925	14.975
		M	14.910	14.970

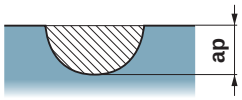
Dimensions with an insert mounted in the body

Cutting Edge Diameter DC	Tolerance	DC min.	DC max.
16	G	15.800	16.000
	M	15.770	15.990
20	G	19.800	20.000
	M	19.770	19.990
25	G	24.800	25.000
	M	24.770	24.990
30	G	29.800	30.000
	M	29.770	29.990

*M : Precision M class

■SLOT MILLING

Cutting Mode



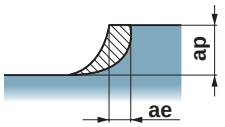
N : Revolution (min^{-1})
F : Table Feed (mm/min)

	Work Material	Hardness	Cutting Speed (m/min)	Insert Grade, Type	Holder Type	ϕ16			ϕ20			ϕ25			ϕ30		
						N	F	ap	N	F	ap	N	F	ap	N	F	ap
P	Carbon Steel Alloy Steel	180−280HB	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	382	6	2546	306	8	2037	489	12.5	1698	407	15
					Long Neck	3183	382	4	2546	306	4	2037	489	6	1698	407	7.5
					Extra Long	—	—	—	2546	306	2	2037	489	4	1698	407	3
		280−350HB	140 (120−160)	**MP6120 VP15TF** Low Resistance Type	Standard	2785	334	6	2228	267	8	1783	428	12.5	1485	357	15
					Long Neck	2785	334	4	2228	267	4	1783	428	6	1485	357	7.5
					Extra Long	—	—	—	2228	267	2	1783	428	4	1485	357	3
	Pre-Hardened Steel	35−45HRC	120 (100−160)	**MP6120 VP15TF** Low Resistance Type	Standard	2387	286	6	1910	229	8	1528	367	12.5	1273	306	15
					Long Neck	2387	286	4	1910	229	4	1528	367	6	1273	306	7.5
					Extra Long	—	—	—	1910	229	2	1528	367	4	1273	306	3
	Alloy Tool Steel	≤350HB	140 (120−160)	**MP6120 VP15TF** Low Resistance Type	Standard	2785	334	6	2228	267	8	1783	535	10	1485	594	12
					Long Neck	2785	334	4	2228	267	4	1783	535	5	1485	594	4.5
					Extra Long	—	—	—	2228	267	2	1783	535	2.5	1485	594	1.5
M	Stainless Steel	≤270HB	200 (100−250)	**VP15TF** Low Resistance Type	Standard	3979	477	4	3183	382	5	2546	764	6	2122	849	7.5
					Long Neck	3979	477	3	3183	382	3	2546	611	4	2122	637	4.5
					Extra Long	—	—	—	3183	382	1.5	2546	509	1.5	2122	509	1.5
K	Gray Cast Iron	≤350MPa	200 (150−300)	**VP15TF** Low Resistance Type	Standard	3979	796	6	3183	637	8	2546	1019	12.5	2122	849	15
					Long Neck	3979	796	4	3183	637	4	2546	1019	7.5	2122	849	4.5
					Extra Long	—	—	—	3183	637	2	2546	1019	4	2122	849	3
	Ductile Cast Iron	≤500MPa	180 (150−240)	**VP15TF** Low Resistance Type	Standard	3581	716	6	2865	573	8	2292	917	12.5	1910	764	15
					Long Neck	3581	716	4	2865	573	4	2292	917	7.5	1910	764	4.5
					Extra Long	—	—	—	2865	573	2	2292	917	4	1910	764	1.5
	Ductile Cast Iron	≤800MPa	160 (150−250)	**VP15TF** Low Resistance Type	Standard	3183	637	6	2546	509	8	2037	815	12.5	1698	679	15
					Long Neck	3183	637	4	2546	509	4	2037	815	7.5	1698	679	4.5
					Extra Long	—	—	—	2546	509	2	2037	815	4	1698	679	1.5
H	Hardened Steel	45−50HRC	100 (60−120)	**VP15TF** Strong Cutting Edge Type	Standard	1989	239	4	1591	191	4	1273	255	6	1061	212	7.5
					Long Neck	1989	239	2	1591	191	2	1273	255	4	1061	212	3
					Extra Long	—	—	—	1591	191	1	1273	255	2.5	1061	212	1.5
	Hardened Steel	50−60HRC	60 (40−100)	**VP15TF** Strong Cutting Edge Type	Standard	1194	143	4	955	115	4	764	153	6	637	127	7.5
					Long Neck	1194	143	2	955	115	2	764	153	4	637	127	3
					Extra Long	—	—	—	955	115	1	764	153	2.5	637	127	1.5
S	Titanium Alloy	≤350HB	50 (30-60)	**MP9120**	Standard	995	100	4	796	80	4	637	64	6	531	53	7.5
					Long Neck	995	100	2	796	80	2	637	64	4	531	53	3
					Extra Long	—	—	—	796	80	1	637	64	2.5	531	53	1.5
	Heat Resistant Alloy	—	40 (30-60)	**MP9120**	Standard	796	80	4	637	64	4	510	51	6	425	43	7.5
					Long Neck	796	80	2	637	64	2	510	51	4	425	43	3
					Extra Long	—	—	—	637	64	1	510	51	2.5	425	43	1.5

RECOMMENDED CUTTING CONDITIONS

■SHOULDER MILLING (Cutting Depth : Small)

Cutting Mode

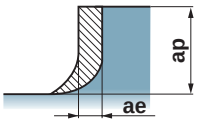


N : Revolution (min^{-1})
F : Table Feed (mm/min)

	Work Material	Hardness	Cutting Speed (m/min)	Insert Grade, Type	Holder Type	ϕ16				ϕ20				ϕ25				ϕ30			
						N	F	ap	ae	N	F	ap	ae	N	F	ap	ae	N	F	ap	ae
P	Carbon Steel Alloy Steel	180−280HB	200 (160−250)	**MP6120 VP15TF** Low Resistance Type	Standard	3979	796	4	6	3183	955	5	8	2546	1273	6	10	2122	1273	7.5	10
					Long Neck	3979	637	4	4	3183	637	5	6	2546	1273	6	7.5	2122	1273	7.5	7.5
					Extra Long	—	—	—	—	3183	382	5	4	2546	1019	6	5	2122	637	7.5	3
		280−350HB	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	509	4	6	2546	509	5	8	2037	815	6	10	1698	849	7.5	10
					Long Neck	3183	382	4	4	2546	407	5	6	2037	611	6	7.5	1698	509	7.5	7.5
					Extra Long	—	—	—	—	2546	306	5	4	2037	489	6	5	1698	407	7.5	3
	Pre-Hardened Steel	35−45HRC	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	509	4	6	2546	509	5	8	2037	815	6	10	1698	849	7.5	10
					Long Neck	3183	382	4	4	2546	407	5	6	2037	611	6	7.5	1698	679	7.5	7.5
					Extra Long	—	—	—	—	2546	306	5	4	2037	489	6	5	1698	509	7.5	3
	Alloy Tool Steel	≤350HB	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	509	4	6	2546	509	5	8	2037	815	6	10	1698	849	7.5	10
					Long Neck	3183	382	4	4	2546	407	5	6	2037	611	6	7.5	1698	509	7.5	7.5
					Extra Long	—	—	—	—	2546	306	5	4	2037	489	6	2.5	1698	407	7.5	1.5
M	Stainless Steel	≤270HB	200 (100−250)	**VP15TF** Low Resistance Type	Standard	3979	477	4	6	3183	509	5	8	2546	764	6	10	2122	849	7.5	10
					Long Neck	3979	477	4	4	3183	382	5	6	2546	611	6	7.5	2122	849	7.5	7.5
					Extra Long	—	—	—	—	3183	382	5	4	2546	509	6	5	2122	424	7.5	1.5
K	Gray Cast Iron	≤350MPa	200 (150−300)	**VP15TF** Low Resistance Type	Standard	3979	1592	4	8	3183	1592	5	10	2546	1528	6	10	2122	1485	7.5	10
					Long Neck	3979	1194	4	6	3183	1273	5	8	2546	1528	6	10	2122	1485	7.5	6
					Extra Long	—	—	—	—	3183	955	5	6	2546	1273	6	7.5	2122	1061	7.5	3
	Ductile Cast Iron	≤500MPa	200 (150−280)	**VP15TF** Low Resistance Type	Standard	3979	1592	4	8	3183	1592	5	10	2546	1528	6	10	2122	1273	7.5	10
					Long Neck	3979	1194	4	6	3183	1273	5	8	2546	1528	6	10	2122	1273	7.5	6
					Extra Long	—	—	—	—	3183	955	5	6	2546	1273	6	7.5	2122	1061	7.5	3
	Ductile Cast Iron	≤800MPa	180 (150−250)	**VP15TF** Low Resistance Type	Standard	3581	1432	4	8	2865	1433	5	10	2292	1375	6	10	1910	1146	7.5	10
					Long Neck	3581	1074	4	6	2865	1146	5	8	2292	1375	6	10	1910	1146	7.5	6
					Extra Long	—	—	—	—	2865	860	5	6	2292	1146	6	7.5	1910	955	7.5	3
H	Hardened Steel	45−50HRC	100 (60−120)	**VP15TF** Strong Cutting Edge Type	Standard	1989	239	4	4	1591	191	5	5	1273	255	6	7.5	1061	212	7.5	3
					Long Neck	1989	239	4	2	1591	191	5	3	1273	255	6	4	1061	212	7.5	1.5
					Extra Long	—	—	—	—	1591	191	5	2	1273	204	6	1.5	1061	170	7.5	1
	Hardened Steel	50−60HRC	60 (40−100)	**VP15TF** Strong Cutting Edge Type	Standard	1194	143	4	4	955	115	5	5	764	153	6	7.5	637	127	7.5	3
					Long Neck	1194	143	4	2	955	115	5	3	764	153	6	4	637	127	7.5	1.5
					Extra Long	—	—	—	—	955	115	5	2	764	122	6	1.5	637	102	7.5	1
S	Titanium Alloy	≤350HB	50 (30-60)	**MP9120**	Standard	995	299	4	4	796	239	4	5	637	191	6	7.5	531	159	7.5	3
					Long Neck	995	299	2	2	796	239	2	3	637	191	4	4	531	159	3	1.5
					Extra Long	—	—	—	—	796	239	1	2	637	191	2.5	1.5	531	159	1.5	1
	Heat Resistant Alloy	—	40 (30-60)	**MP9120**	Standard	796	239	4	4	637	191	4	5	510	153	6	7.5	425	128	7.5	3
					Long Neck	796	239	2	2	637	191	2	3	510	153	4	4	425	128	3	1.5
					Extra Long	—	—	—	—	637	191	1	2	510	153	2.5	1.5	425	128	1.5	1

■SHOULDER MILLING (Cutting Depth : Large)

Cutting Mode



N : Revolution (min^{-1})
F : Table Feed (mm/min)

Note 1) Machining Stainless Steels

When up-cut milling stainless steels at large depths and widths of cut, the machined surface is liable to burrs and welding due to chip jamming. For stainless steels, down-cutting (climb milling) is recommended.

	Work Material	Hardness	Cutting Speed (m/min)	Insert Grade, Type	Holder Type	ϕ16				ϕ20				ϕ25				ϕ30			
						N	F	ap	ae	N	F	ap	ae	N	F	ap	ae	N	F	ap	ae
P	Carbon Steel Alloy Steel	180−280HB	200 (160−250)	**MP6120 VP15TF** Low Resistance Type	Standard	3979	637	8	4	3183	764	10	4	2546	1273	12.5	5	2122	1273	15	4.5
					Long Neck	3979	477	8	3	3183	509	10	3	2546	1019	12.5	4	2122	849	15	3
					Extra Long	—	—	—	—	3183	382	10	2	2546	764	12.5	2.5	2122	849	15	1.5
		280−350HB	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	382	8	4	2546	509	10	4	2037	815	12.5	5	1698	849	15	4.5
					Long Neck	3183	382	8	3	2546	306	10	3	2037	611	12.5	4	1698	509	15	3
					Extra Long	—	—	—	—	2546	306	10	2	2037	489	12.5	2.5	1698	407	15	1.5
	Pre-Hardened Steel	35−45HRC	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	382	8	4	2546	509	10	4	2037	815	12.5	5	1698	849	15	4.5
					Long Neck	3183	382	8	3	2546	306	10	3	2037	611	12.5	4	1698	509	15	3
					Extra Long	—	—	—	—	2546	306	10	2	2037	489	12.5	2.5	1698	407	15	1.5
	Alloy Tool Steel	≤350HB	160 (120−200)	**MP6120 VP15TF** Low Resistance Type	Standard	3183	382	8	4	2546	509	10	4	2037	815	12.5	5	1698	849	15	4.5
					Long Neck	3183	382	8	3	2546	306	10	3	2037	611	12.5	2.5	1698	509	15	3
					Extra Long	—	—	—	—	2546	306	10	2	2037	489	12.5	1.5	1698	407	15	1.5
M	Stainless Steel	≤270HB	200 (100−250)	**VP15TF** Low Resistance Type	Standard	3979	477	8	4	3183	509	10	4	2546	764	12.5	10	2122	849	15	10
					Long Neck	3979	477	8	3	3183	382	10	3	2546	611	12.5	4	2122	509	15	4.5
					Extra Long	—	—	—	—	3183	382	10	2	2546	489	12.5	1.5	2122	340	15	1.5
K	Gray Cast Iron	≤350MPa	200 (150−300)	**VP15TF** Low Resistance Type	Standard	3979	1194	8	8	3183	1273	10	8	2546	1273	12.5	10	2122	1485	15	10
					Long Neck	3979	955	8	5	3183	955	10	4	2546	1273	12.5	7.5	2122	1061	15	4.5
					Extra Long	—	—	—	—	3183	764	10	2	2546	1019	12.5	1.5	2122	849	15	3
	Ductile Cast Iron	≤500MPa	200 (150−280)	**VP15TF** Low Resistance Type	Standard	3979	1194	8	8	3183	1273	10	8	2546	1273	12.5	10	2122	1273	15	10
					Long Neck	3979	955	8	5	3183	955	10	4	2546	1273	12.5	7.5	2122	849	15	4.5
					Extra Long	—	—	—	—	3183	764	10	2	2546	1019	12.5	5	2122	849	15	1.5
	Ductile Cast Iron	≤800MPa	180 (150−250)	**VP15TF** Low Resistance Type	Standard	3581	1074	8	8	2865	1146	10	8	2292	1146	12.5	10	1910	1146	15	10
					Long Neck	3581	859	8	5	2865	860	10	4	2292	1146	12.5	7.5	1910	764	15	4.5
					Extra Long	—	—	—	—	2865	688	10	2	2292	917	12.5	5	1910	764	15	1.5
H	Hardened Steel	45−50HRC	100 (60−120)	**VP15TF** Strong Cutting Edge Type	Standard	1989	239	8	2	1591	191	10	3	1273	255	12.5	4	1061	212	15	3
					Long Neck	1989	239	8	1	1591	191	10	2	1273	204	12.5	1.5	1061	106	15	1.5
					Extra Long	—	—	—	—	1591	191	10	1	—	—	—	—	—	—	—	—
	Hardened Steel	50−60HRC	60 (40−100)	**VP15TF** Strong Cutting Edge Type	Standard	1194	143	8	2	955	115	10	3	764	153	12.5	4	637	127	15	3
					Long Neck	1194	143	8	1	955	115	10	2	764	122	12.5	1.5	637	64	15	1.5
					Extra Long	—	—	—	—	955	115	10	1	—	—	—	—	—	—	—	—
S	Titanium Alloy	≤350HB	50 (30-60)	**MP9120**	Standard	995	199	4	2	796	159	4	3	637	127	6	4	531	106	7.5	3
					Long Neck	995	199	2	1	796	159	2	2	637	127	4	1.5	531	106	3	1.5
					Extra Long	—	—	—	—	796	159	1	1	637	127	2.5	—	531	106	1.5	—
	Heat Resistant Alloy	—	40 (30-60)	**MP9120**	Standard	796	159	4	2	637	127	4	3	510	102	6	4	425	85	7.5	3
					Long Neck	796	159	2	1	637	127	2	2	510	102	4	1.5	425	85	3	1.5
					Extra Long	—	—	—	—	637	127	1	1	510	102	2.5	—	425	85	1.5	—

BALL NOSE END MILL

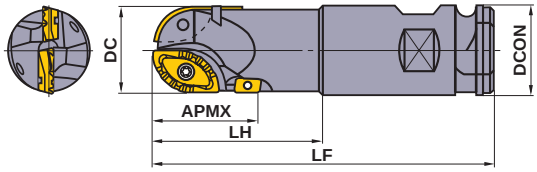
TOOL NEWS

SRM2 ø40 ø50

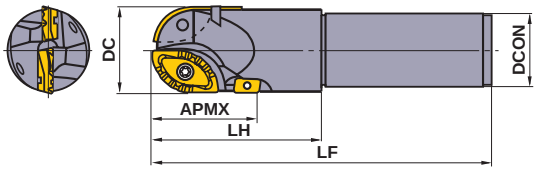
P	M	K	N	S	H
Steel		Cast Iron			

- **Best for roughing of moulds.**
- **Low resistance chipbreaker.**
- **Highly rigid body.**

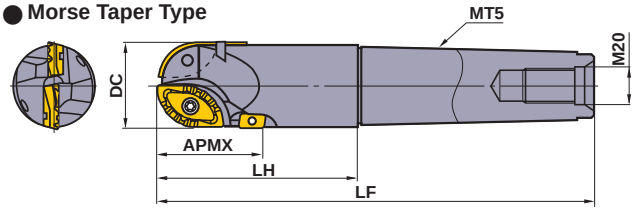
● **Combination Type**



● **Straight Type**



● **Morse Taper Type**



Right hand tool holder only.

Type		Order Number	Stock R	Number of Flutes	Dimensions (mm) RE *2	DC	DCON	LF	LH	APMX	*1 Inner, Outer (Clamp Screw)	*1 Peripheral (Clamp Screw)	Inner, Outer (Wrench)	Peripheral (Wrench)	Inner (Insert)	Outer (Insert)	Peripheral (Insert)
Combination	Standard	**SRM2400WNLS**	●	2	20	40	50.8	200	120	54	TS6S	TS43	TKY30T	TKY15F	SRG40C	SRG40E	APMT1604 PDER-◌2
		SRM2500WNLS	●	2	25	50	50.8	200	120	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
	Long	**SRM2400WNLM**	●	2	20	40	50.8	250	170	54	TS6S	TS43	TKY30T	TKY15F	SRG40C	SRG40E	APMT1604 PDER-◌2
		SRM2500WNLM	●	2	25	50	50.8	250	170	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
	Extra Long	**SRM2500WNLL**	●	2	25	50	50.8	300	220	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
		SRM2500WNLX	●	2	25	50	50.8	350	270	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
Straight	Standard	**SRM2400SNLS**	●	2	20	40	42	200	100	54	TS6S	TS43	TKY30T	TKY15F	SRG40C	SRG40E	APMT1604 PDER-◌2
		SRM2500SNLS	●	2	25	50	42	200	100	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
	Long	**SRM2400SNLM**	●	2	20	40	42	250	150	54	TS6S	TS43	TKY30T	TKY15F	SRG40C	SRG40E	APMT1604 PDER-◌2
		SRM2500SNLM	●	2	25	50	42	250	100	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
Morse Taper	Standard	**SRM2500MNLS**	●	2	25	50	—	256	120	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2
	Long	**SRM2500MNLM**	●	2	25	50	—	286	150	63	TS6	TS43	TKY30T	TKY15F	SRG50C	SRG50E	APMT1604 PDER-◌2

*1 Clamp Torque (N • m) : TS43=6.0, TS6=10.0, TS6S=10.0

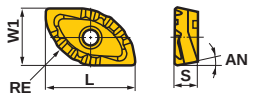
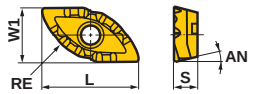
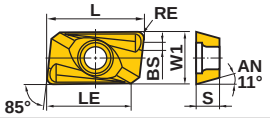
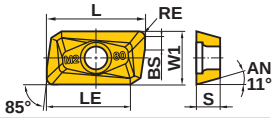
*2 RE is shown for insert corner R.

● : Inventory maintained in Japan. (10 inserts in one case)(Inserts with asterisk (*2) are available in 2 piece in one case)

INSERTS

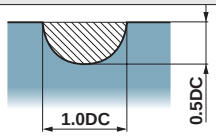
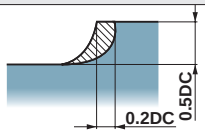
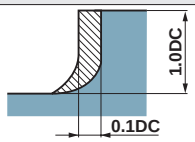
Work Material			F7030	VP15TF	VP20RT	VP30RT
P	Steel		◐	◐	◐	✣
K	Cast Iron			✣	✣	✣

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Type	Shape	Order Number	Class	F7030	VP15TF	VP20RT	VP30RT	RE	L	LE	W1	S	BS	AN	B9	Geometry
Inner		⋆2 **SRG40C**	G		●	●	●	20	36	—	20.5	8.0	—	11°	—	
		⋆2 **SRG50C**	G		●	●	●	25	40	—	26	8.5	—	11°	—	
Outer		⋆2 **SRG40E**	G		●	●	●	20	32	—	16.6	8.0	—	11°	—	
		⋆2 **SRG50E**	G		●	●	●	25	35.8	—	20	8.5	—	11°	—	
⋆1 Peripheral	Strong Cutting Edge Type	**APMT1135PDER-H2**	M	●	●			0.8	11.25	9	6.35	3.5	1.2	11°	—	
		APMT1604PDER-H2	M	●	●			0.8	11.71	14	9.525	4.76	1.4	11°	—	
	Low Resistance Type	**APMT1135PDER-M2**	M	●	●			0.8	11.18	9	6.35	3.5	1.2	11°	—	
		APMT1604PDER-M2	M	●	●			0.8	17.10	14	9.525	4.76	1.4	11°	—	

(Low-resistance inner or outer inserts are precision M class type.)
⋆1 Selection guide for peripheral cutting edges : The first recommendation is the super sharp M breaker (APMT....PDER-M2).
When cutting edge strength is particularly important, use the H breaker (APMT....PDER-H2).

RECOMMENDED CUTTING CONDITIONS

Cutting Mode	A : Slot Milling	B : Shoulder Milling (Standard Type)	C : Shoulder Milling (Long Cutting Edge Type)
			

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Cutting Mode
P	Alloy Tool Steel	≤250HB	**VP20RT VP30RT**	160 (120—200)	0.12 (0.08—0.2)	A
					0.2 (0.1—0.4)	B
					0.15 (0.1—0.3)	C
	Alloy Tool Steel	≤250HB	**VP20RT VP30RT**	200 (160—250)	0.2 (0.1—0.3)	A
					0.3 (0.1—0.4)	B
					0.2 (0.1—0.4)	C
	Cast Tool Steel	≤235HB	**VP20RT**	200 (160—250)	0.2 (0.1—0.3)	A
					0.3 (0.1—0.4)	B
					0.2 (0.1—0.4)	C
	Cast Tool Steel	≤230HB	**VP15TF VP20RT**	200 (160—300)	0.2 (0.1—0.3)	A
					0.3 (0.1—0.45)	B
					0.2 (0.1—0.4)	C
K	Ductile Cast Iron	Tensile Strength ≤540MPa	**VP15TF VP20RT**	200 (160—300)	0.25 (0.1—0.4)	A
					0.35 (0.1—0.45)	B
					0.25 (0.1—0.45)	C
	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF VP20RT**	200 (160—300)	0.25 (0.1—0.4)	A
					0.35 (0.1—0.45)	B
					0.25 (0.1—0.4)	C

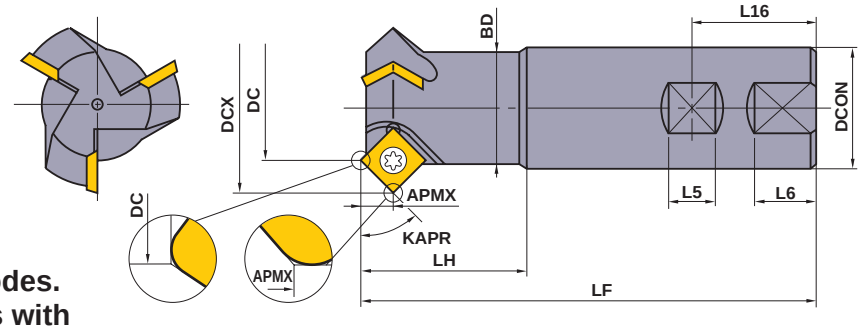
CHAMFER MILLING

60° KAPR 45° KAPR 30° KAPR R

CESP,CFSP,CGSP

P M K N S H

Steel Cast Iron



- Covers 5 cutting modes.
- Excellent sharpness with 11° positive inserts.
- 30°, 45° and 60°chamfer series.

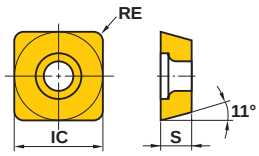
Right hand tool holder only.

Order Number	Stock R	Number of Teeth	Dimensions (mm) KAPR	DC	DCX	LF	DCON	BD	LH	L16	L5	L6	APMX	* Clamp Screw	Wrench	Insert
CESPR081S20	●	1	60°	8	19.6	110	20	19.5	40	25	11	—	10.2	TS52	①TKY25R	SPMW1203○○
CESPR161S20	●	1	60°	16	27.8	110	20	19.5	40	25	11	—	10.2	TS5	①TKY25R	SPMW1203○○
CESPR323S32	●	3	60°	32	43.8	125	32	31.5	45	36	14	19	10.2	TS5	①TKY25R	SPMW1203○○
CFSPR041S16S	●	1	45°	4	15.7	85	16	14.4	25	24	10	—	5.9	TS4	②TKY15F	SPMW0903○○
CFSPR041S16L	●	1	45°	4	15.7	110	16	14.4	50	24	10	—	5.9	TS4	②TKY15F	SPMW0903○○
CFSPR081S20	●	1	45°	8	24.6	110	20	19.5	40	25	11	—	8.3	TS5	①TKY25R	SPMW1203○○
CFSPR161S20	●	1	45°	16	32.6	110	20	19.5	40	25	11	—	8.3	TS5	①TKY25R	SPMW1203○○
CFSPR323S32	●	3	45°	32	48.6	125	32	31.5	45	36	14	19	8.3	TS5	①TKY25R	SPMW1203○○
CGSPR081S20	●	1	30°	8	28.4	110	20	19.5	40	25	11	—	5.9	TS5	①TKY25R	SPMW1203○○
CGSPR161S20	●	1	30°	16	36.4	110	20	19.5	40	25	11	—	5.9	TS5	①TKY25R	SPMW1203○○
CGSPR323S32	●	3	30°	32	52.4	125	32	31.5	45	36	14	19	5.9	TS5	①TKY25R	SPMW1203○○

* Clamp Torque (N • m) : TS4=3.5, TS5=7.5, TS52=7.5

● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material																		
	P	Steel	◐	◐			●	◐	◐		**Cutting Conditions :**							
	K	Cast Iron	✠				●		✠	◐	● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting							
Shape	Order Number	Class	Honing	Coated				Cermet		Carbide		Dimensions (mm)			Geometry			
				VP15TF	UP20M			NX2525	NX4545	UTi20T	HTi10	IC	S	RE				
	SPMW090304	M	E*	●	●			●	●	●	●	9.525	3.18	0.4				
	SPMW090308	M	E*	●	●			●	●	●	●	9.525	3.18	0.8				
	SPMW120304	M	E*	●	●			●	●	●	●	12.7	3.18	0.4				
	SPMW120308	M	E*	●	●			●	●	●	●	12.7	3.18	0.8				

* NX2525 and NX4545 insert honing is "T" type.

RECOMMENDED CUTTING CONDITIONS

Work Material		Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	
					Chamfer Milling	Face Milling
P	Carbon Steel Alloy Steel	180—280HB	**UTi20T**	80 (60—100)	0.4	0.15
			UP20M	130 (100—160)	0.4	0.2
			NX4545	130 (100—160)	0.4	0.2
		280—350HB	**UTi20T**	80 (60—100)	0.3	0.15
K	Cast Iron	Tensile Strength ≤450MPa	**UTi20T**	100 (85—120)	0.5	0.25
			HTi10	100 (85—120)	0.5	0.25

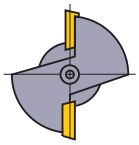
● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

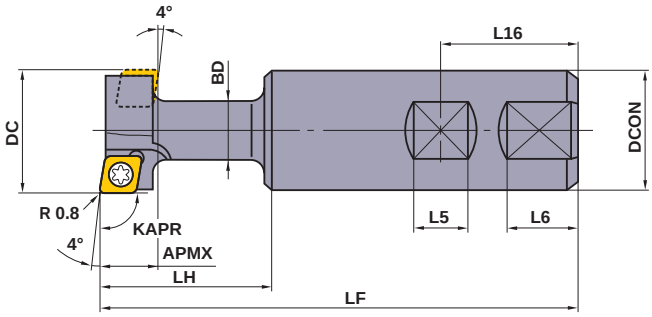
T-SLOT MILLING

90° KAPR

TSMP

P	M	K	N	S	H
Steel		Cast Iron			





- **T-groove order number 14, 18 and 22 are available.**
- **86° rhombic shape 11° positive insert.**
- **Shoulder milling and inversed spot facing are also possible.**

KAPR :90°

Right hand tool holder only.

Order Number	T Slot Nomenclature	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	BD	LH	L16	L5	L6	APMX	* Clamp Screw	① ② Wrench	Insert
TSMPR252S25	14	●	2	25	112	25	12.5	33.2	32	12	17	11	TS3	①TKY08D	MPMW070308
TSMPR322S32	18	●	2	32	120	32	16	41.2	36	14	19	14	TS4	②TKY15R	MPMW090308
TSMPR402S32	22	●	2	40	130	32	20	51.2	36	14	19	18	TS5	②TKY25R	MPMW120408

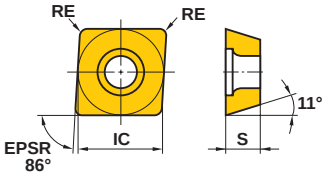
* Clamp Torque (N • m) : TS3=1.0, TS4=3.5, TS5=7.5

● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			
P	Steel	◐	
K	Cast Iron	✣	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	Class	Carbide UTi20T		Dimensions (mm) IC	S	RE	Geometry
	MPMW070308	M	●		7.94	3.18	0.8	
	MPMW090308	M	●		9.525	3.18	0.8	
	MPMW120408	M	●		12.7	4.76	0.8	

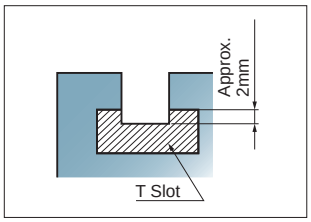
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180−280HB	**UTi20T**	130 (100−160)	0.15 (0.1−0.2)
		280−350HB	**UTi20T**	80 (60−100)	0.1 (0.05−0.15)
K	Cast Iron	Tensile Strength ≤450MPa	**UTi20T**	100 (80−120)	0.15 (0.1−0.2)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)

■ CAUTION FOR USE

● When T slot machining steel, the workpiece must be machined as shown in the drawing to ensure smooth chip evacuation.
● Slots to be machined must be free from chips for smooth machining.

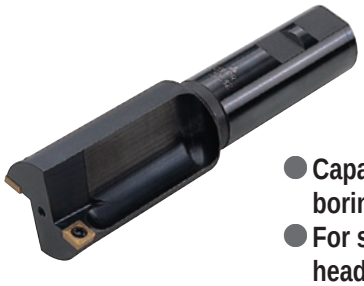


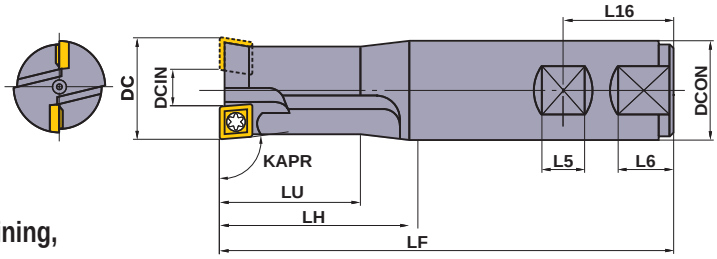
SPOT MILLING

94° KAPR

CBJP,CBMP

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			





- Capable of spot facing machining, boring and interpolation.
- For seat machining of hexagon socket head bolt (M8-M30).
- 86°rhombic shape 11°positive insert.

KAPR :94°

Right hand tool holder only.

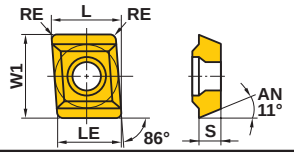
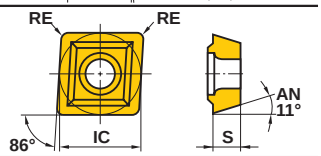
Order Number	For Bolt Size	Stock R	Number of Teeth	Dimensions (mm) DC	DCIN	LF	DCON	LH	LU	L16	L5	L6	* Clamp Screw	①② Wrench	Insert
CBJPR141S25	M8	●	1	14	3.1	108	25	28	21	32	12	17	TS3	①TKY08D	JPMT060204-E
CBJPR172S25	M10	●	2	17.5	5.3	115	25	35	26	32	12	17	TS3	①TKY08D	JPMT060204-E
CBJPR202S25	M12	●	2	20	7.8	120	25	40	30	32	12	17	TS3	①TKY08D	JPMT060204-E
CBJPR232S25	M14	●	2	23	10.8	126	25	46	34.5	32	12	17	TS3	①TKY08D	JPMT060204-E
CBMPR262S32	M16	●	2	26	8.5	132	32	52	39	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR292S32	M18	●	2	29	11.5	138	32	58	43.5	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR322S32	M20	●	2	32	14.5	144	32	64	59	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR352S32	M22	●	2	35	17.5	150	32	70	70	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR392S32	M24	●	2	39	21.5	158	32	78	78	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR432S32	M27	●	2	43	25.5	166	32	86	86	36	14	19	TS4	②TKY15R	MPMT090308
CBMPR482S32	M30	●	2	48	30.5	176	32	96	96	36	14	19	TS4	②TKY15R	MPMT090308

* Clamp Torque (N • m) : TS3=1.0, TS4=3.5

● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material										
	P	Steel	◐	◐			●			**Cutting Conditions :** ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
	M	Stainless Steel	◐	◐			○			
	K	Cast Iron	✠				✠	◐		

Cutter Type	Shape	Order Number	Class	Coated				Carbide		Dimensions (mm)					Geometry
				VP15TF	UP20M			UTi20T	HTi10	L	LE	IC	S	RE	
CBJP		**JPMT060204-E**	M	●	●			●		7.0	6.0	—	2.38	0.4	
CBMP		**MPMT090308**	M	●	●			●		—	—	9.525	3.18	0.8	

RECOMMENDED CUTTING CONDITIONS

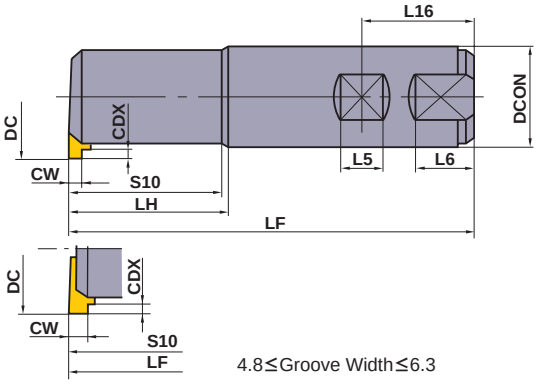
	Work Material	Hardness	Grade	CBJP Cutting Speed (m/min)	CBJP Feed (mm/rev)	CBMP Cutting Speed (m/min)	CBMP Feed (mm/rev)
P	Mild Steel	≤180HB	**VP15TF**	180 (100—200)	0.16 (0.12—0.2)	180 (100—200)	0.225 (0.15—0.3)
P	Carbon Steel Alloy Steel	180—280HB	**VP15TF**	180 (100—200)	0.2 (0.15—0.25)	180 (100—200)	0.275 (0.2—0.35)
P	Carbon Steel Alloy Steel	280—350HB	**VP15TF**	120 (80—160)	0.16 (0.12—0.2)	120 (80—160)	0.225 (0.15—0.3)
M	Stainless Steel	≤200HB	**VP15TF**	150 (100—200)	0.16 (0.12—0.2)	150 (100—200)	0.225 (0.15—0.3)
K	Cast Iron	Tensile Strength ≤450MPa	**VP15TF**	160 (100—220)	0.3 (0.2—0.4)	160 (100—220)	0.35 (0.2—0.5)

●Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC) ●Spindle feed (mm/min) = Feed rate x Tool spindle speed
Note 1) CBJPR141S25 use feed per revolution 50 % of this table, because only 1 insert on the body.

SLOT MILLING

KSMG

P	M	K	N	S	H
Steel		Cast Iron			



- Side face grooving tool for machining centers.
- The minimum cutting diameter is ϕ25mm for internal grooving.
- For groove widths of 1.25mm−6.0mm.

Right hand tool holder only.

Order Number	Stock R	Number of Teeth	LF	DCON	LH	S10	L16	L5	L6	CW	CDX	DC (mm)	Insert Number
			Dimensions (mm)							Geometry of Groove			
KSMGR25S25	●	1	115	25	40	36.5	32	12	17	1.25	1.2	25	MGTL33○○○
										1.45	1.5		
										1.5≤CW≤4.0	3.0		
KSMGR40S32	●	1	130	32	50	49	36	14	19	1.25	1.2	40	MGTL43○○○
										1.45	1.5		
										1.5≤CW≤2.3	3.0		
										2.5≤CW≤4.7	4.5		
			131.6	32	51.6	50.6	36	14	19	5.0≤CW≤6.0	4.5	40	MGTL44○○○
KSMGR40S32L	●	1	180	32	100	99	36	14	19	1.25	1.2	40	MGTL43○○
										1.45	1.5		
										1.5≤CW≤2.3	3.0		
										2.5≤CW≤4.7	4.5		
			181.6	32	101.6	100.6	36	14	19	5.0≤CW≤6.0	4.5	40	MGTL44○○○

SPARE PARTS

Tool Holder Number	Clamp Lever	Spring	Lever Pin	Clamp Screw *	Wrench ① ②
KSMGR25S25	LLCL13S	HLS2	–	LLCS105	①HKY20F
KSMGR40S32	LLCL24	–	LLP14	LLCS108	②HKY30R
KSMGR40S32L	LLCL24	–	LLP14	LLCS108	②HKY30R

* Clamp Torque (N • m) : LLCS105=1.5, LLCS108=3.3

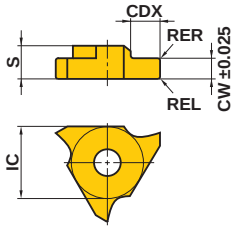
● : Inventory maintained in Japan. (10 inserts in one case)

INSERTS

Work Material					
P	Steel	◐	●	◐	
K	Cast Iron		●	✱	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Order Number	Grooving Width	Stock			Dimensions (mm)				Geometry
		Coated	Cermet	Carbide					
		VP20MF	NX2525	UTi20T	IC	S	RER/L	CDX	
	CW	L	L	L					
MGTL33125	1.25	●		●	9.525	4.76	0.2	1.2	**MGTL...**
MGTL33145	1.45	●		●	9.525	4.76	0.2	1.5	
MGTL33150	1.5	●	●	●	9.525	4.76	0.2	3	
MGTL33175	1.75	●	●	●	9.525	4.76	0.2	3	
MGTL33200	2	●	●	●	9.525	4.76	0.2	3	
MGTL33230	2.3	●		●	9.525	4.76	0.2	3	
MGTL33250	2.5	●	●	●	9.525	4.76	0.3	3	
MGTL33270	2.7	●		●	9.525	4.76	0.3	3	
MGTL33280	2.8	●		●	9.525	4.76	0.3	3	
MGTL33300	3	●	●	●	9.525	4.76	0.3	3	
MGTL33320	3.2	●			9.525	4.76	0.3	3	
MGTL33330	3.3	●		●	9.525	4.76	0.3	3	
MGTL33350	3.5	●		●	9.525	4.76	0.3	3	
MGTL33400	4	●	●	●	9.525	4.76	0.3	3	
MGTL43125	1.25	●	●	●	12.7	4.76	0.2	1.2	
MGTL43145	1.45	●	●	●	12.7	4.76	0.2	1.5	
MGTL43150	1.5	●	●	●	12.7	4.76	0.2	3	
MGTL43175	1.75	●	●	●	12.7	4.76	0.2	3	
MGTL43200	2	●	●	●	12.7	4.76	0.2	3	
MGTL43230	2.3	●	●	●	12.7	4.76	0.2	3	
MGTL43250	2.5	●	●	●	12.7	4.76	0.3	4.5	
MGTL43260	2.6	●		●	12.7	4.76	0.3	4.5	
MGTL43270	2.7	●		●	12.7	4.76	0.3	4.5	
MGTL43280	2.8	●	●	●	12.7	4.76	0.3	4.5	
MGTL43300	3	●	●	●	12.7	4.76	0.3	4.5	
MGTL43320	3.2			●	12.7	4.76	0.3	4.5	
MGTL43330	3.3	●	●	●	12.7	4.76	0.3	4.5	
MGTL43350	3.5	●	●	●	12.7	4.76	0.3	4.5	
MGTL43400	4	●		●	12.7	4.76	0.3	4.5	
MGTL43420	4.2	●		●	12.7	4.76	0.4	4.5	
MGTL43430	4.3	●		●	12.7	4.76	0.4	4.5	
MGTL43450	4.5	●	●	●	12.7	4.76	0.4	4.5	
MGTL43470	4.7	●	●	●	12.7	4.76	0.4	4.5	
MGTL44500	5	●		●	12.7	6.35	0.4	4.5	
MGTL44600	6			●	12.7	6.35	0.4	4.5	



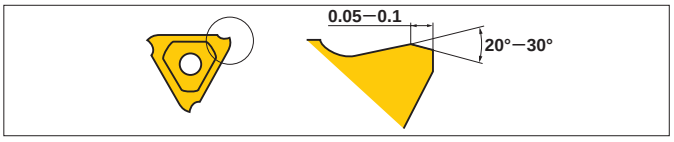
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Mild Steel	≤180HB	**NX2525 UTi20T**	130 (120−150)	0.225 (0.1−0.35)
			VP20MF	160 (120−200)	0.225 (0.1−0.35)
	Carbon Steel Alloy Steel	180−280HB	**NX2525 UTi20T**	110 (100−120)	0.2 (0.1−0.30)
			VP20MF	120 (100−140)	0.2 (0.1−0.30)
		280−350HB	**UTi20T**	110 (100−120)	0.175 (0.1−0.25)
K	Cast Iron	Tensile Strength ≤450MPa	**UTi20T**	100 (80−125)	0.225 (0.1−0.35)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

■HONING OF CUTTING EDGE

Supplementary honing when steel cutting gives longer tool life.
Use a diamond file for best results.



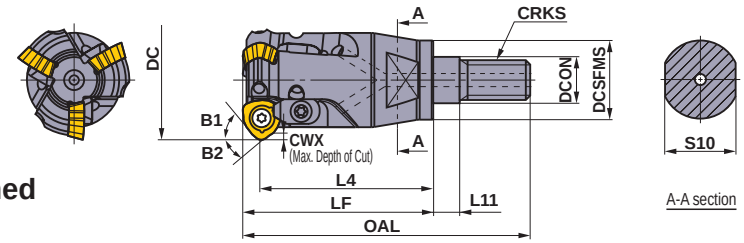
VERTICAL FEED MILLING

TOOL NEWS

PMC

P	M	K	N	S	H
Steel		Cast Iron			

- **For under-cutting trimed part of press mould.**
- **2 directional cutting with large overhang.**



Right hand tool holder only.

Order Number	Stock R	Coolant Hole	Number of Teeth	DC	DCON	DCSFMS	OAL	LF	L4	L11	S10	CRKS	CWX	B1	B2	WT* (kg)	Insert	Shank Arbor
PMC08R252AM1035	●	○	2	25	10.5	18	58.7	39.7	35	6	14	M10	1.5	40.5°	35°	0.1	JOM◌080320 ZZSR-◌◌	SC20M10S ◌◌◌◌W
PMC09R323AM1245	●	○	3	32	12.5	21	72.5	50.5	45	6	19	M12	3	40.5°	35°	0.2	JDM◌09T320 ZDSR-◌◌	SC25M12S ◌◌◌◌W
PMC12R403AM1645	●	○	3	40	17	29	74.4	51.4	45	6	24	M16	3.5	42°	35°	0.3	JDM◌120420 ZDSR-◌◌	SC32M16S ◌◌◌◌W

* WT : Tool Weight

SPARE PARTS

Order Number	Clamp Screw *	Clamp Bridge	Clamp Bridge Screw *	Spring	Wrench	Anti-seize Lubricant
PMC08R252AM1035	TS33	AMS3	AJS3010T10	ASS2	②TKY08D ①TKY10R	MK1KS
PMC09R323AM1245	TS351	AMS3	AJS3010T10	ASS2	②TKY10D	MK1KS
PMC12R403AM1645	TS43	AMS4	AJS4012T15	ASS2	②TKY15D	MK1KS

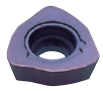
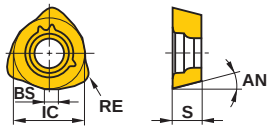
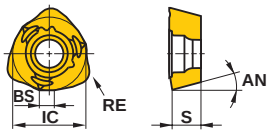
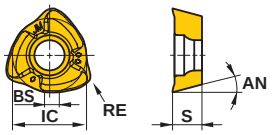
* Clamp Torque (N • m) : TS33=1.5, TS351=2.5, TS43=3.5, AJS3010T10=2.5, AJS4012T15=3.5

● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material			FH7020	VP15TF	VP30RT
	P	Steel	◐	◐	✠
	K	Cast Iron		✠	✠

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Coated FH7020	Coated VP15TF	Coated VP30RT	Dimensions (mm) AN	IC	S	BS	RE	PMC holder	Geometry
Partial Profile **FT** Breaker 	**JOMW080320ZZSR-FT**	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMW09T320ZDSR-FT	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMW120420ZDSR-FT	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
Strong Cutting Edge Type **ST** Breaker	**JDMT120420ZDSR-ST**	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
JM Breaker	**JOMT080320ZZSR-JM**	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMT09T320ZDSR-JM	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMT120420ZDSR-JM	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Breaker	Diameter (mm)	Number of Teeth	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	Width of Cut (mm)	Pick Feed (mm)
P	Carbon Steel Alloy Steel	≤180HB	**VP15TF**	**FT**	ø40	3	250 (200—300)	—0.6	—1.5	—6
					ø32	3	200 (150—220)	—0.55	—1.2	—5
					ø25	2	200 (150—220)	—0.55	—1.0	—5
	Alloy Tool Steel Hardening Tool Steel for Cold Work Dies	≤300HB	**VP15TF**	**FT**	ø40	3	250 (200—300)	—0.55	—1.5	—5
					ø32	3	180 (150—200)	—0.5	—1.2	—3
					ø25	2	180 (150—200)	—0.5	—1.0	—3
	Alloy Tool Steel	≤300HB	**VP15TF**	**FT**	ø40	3	200 (100—300)	—0.55	—1.5	—5
					ø32	3	150 (80—200)	—0.5	—1.2	—3
					ø25	2	150 (80—200)	—0.5	—1.0	—3
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	**FT**	ø40	3	250 (200—300)	—0.6	—1.5	—6
					ø32	3	200 (150—220)	—0.55	—1.2	—5
					ø25	2	200 (150—220)	—0.55	—1.0	—5
	Ductile Cast Iron	Tensile Strength ≤800MPa	**VP15TF**	**FT**	ø40	3	250 (200—300)	—0.6	—1.5	—6
					ø32	3	200 (150—220)	—0.55	—1.2	—5
					ø25	2	200 (150—220)	—0.55	—1.0	—5

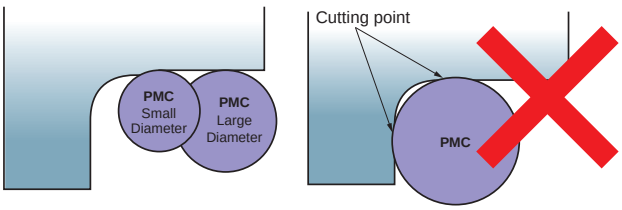
● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

Note 1) The above cutting conditions are general guide lines. Adjustments maybe necessary depending on machine rigidity, workpiece geometry and clamping.
Note 2) A carbide shank extension is recommended to prevent vibrations.

NOTES ON MACHINING METHODS

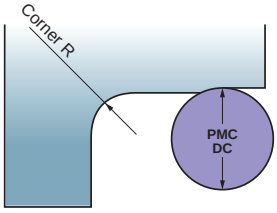
● How to choose an appropriate diameter tool.

Machine plain surfaces with a larger tool and corner radii with smaller diameter cutters.



● Relation of the cutter diameter and corner R size of work piece

A guide for the smallest possible workpiece radius that can be machined is from 0.6—0.7 x diameter of the tool.



Tool diameter **DC**(mm)	Corner R (mm)
ϕ25	R ≥17.5
ϕ32	R ≥22
ϕ40	R ≥24

★Adjust cutting conditions according to the set up.
★Smaller workpiece corner radii (only >0.5 x cutter &) may be possible by reducing the width of cut, speed and pick feed.

VERTICAL FEED MILLING

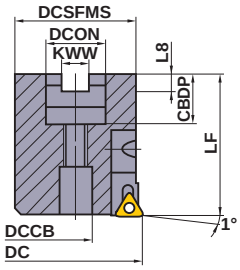
TOOL NEWS

PMF

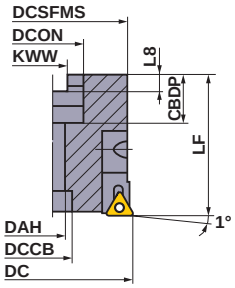
P	M	K	N	S	H
Steel		Cast Iron			

- 2 directional cutting with large overhang.
- Excellent straightness.
- Excellent wall accuracy.

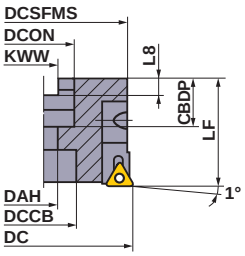
ø50



ø63



ø80



Right hand tool holder only.

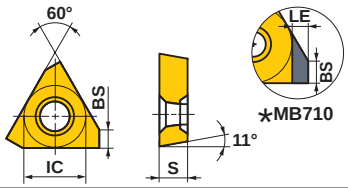
Order Number	Stock R	Number of Teeth	Dimensions (mm) DC	LF	DCON	CBDP	DAH	DCCB	KWW	L8	DCSFMS	Cartridge	Clamp Screw *	Radial Screw	Set Bolt (Cartridge) *	Wrench	Wrench	Set Bolt ①②	Insert
PMF05004A22R	●	4	50	63	22	20	—	12	10.4	6.3	48	PMFA13R	TS254	TSS04005	HBH06012	TKY08F	HKY40R HKY50R	①HDS10031	TPEW 1303 ZP◌R2
PMF06306A22R	●	6	63	63	22	20	11	18	10.4	6.3	60	PMFA13R	TS254	TSS04005	HBH06012	TKY08F	HKY40R	②HSC10050	
PMF08008A27R	●	8	80	50	27	23	13.5	30	12.4	7	75	PMFA13R	TS254	TSS04005	HBH06012	TKY08F	HKY40R	②HSC12035	

* Clamp Torque (N • m) : TS254=1.0, HBH06012=8.5

INSERTS

Work Material																								
	P	Steel	◐	◐																				
	K	Cast Iron	✠	◐				◐																

Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Coated VP15TF	Coated AP10H			CBN MB710		Dimensions (mm) IC	LE	S	BS	Geometry
	TPEW1303ZPER2	E	●	●					7.94	—	3.18	2	
	* TPEW1303ZPTR2	E					●		7.94	1.5	3.18	2	

● : Inventory maintained in Japan.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P	Carbon Steel Alloy Steel	180−280HB	**VP15TF**	250 (150−350)	0.1 (0.05−0.15)
		280−380HB	**VP15TF**	200 (100−300)	
K	Gray Cast Iron	Tensile Strength ≤350MPa	**AP10H**	350 (200−500)	0.1 (0.05−0.15)
			MB710	1500 (1000−2000)	

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K	Ductile Cast Iron	Tensile Strength 360−500MPa	**AP10H**	250 (150−350)	0.1 (0.05−0.15)
			MB710	1000 (800−1200)	
	Ductile Cast Iron	Tensile Strength 500−800MPa	**AP10H**	200 (100−300)	0.1 (0.05−0.15)
			MB710	1000 (800−1200)	

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution
Note 1) Recommended radial depth of cut is 0.1mm.
Note 2) 2 directional vertical cutting is recommended for efficiency.
Note 3) For crossfeed cutting, the feed per tooth should be reduced to less than 0.05(mm/t.).

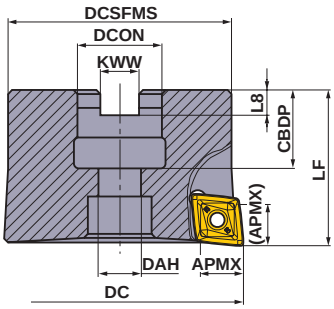
VERTICAL FEED MILLING

TOOL NEWS

PMR

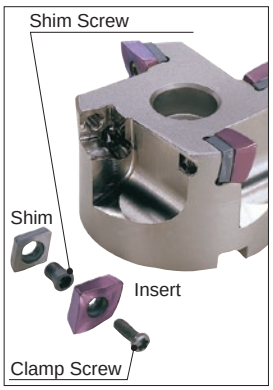
P	M	K	N	S	H
Steel		Cast Iron			

- 1 directional cutting with large overhang.
- Horizontal feed cutting and oblique cutting are also possible.
- Unique shape of curved edge gives high rigidity and low resistance.



Right hand tool holder only.

Type	Order Number	Stock R	Number of Teeth	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	APMX	Insert
Metric	**PMR405003A22R**	●	3	50	40	22	20	11	45	10.4	6.3	11	CPMT1205ZPEN-M2/3
	PMR406304A22R	●	4	63	40	22	20	11	57	10.4	6.3	11	CPMT1205ZPEN-M2/3
	PMR408005A27R	●	5	80	50	27	23	13	73	12.4	7	11	CPMT1205ZPEN-M2/3
Inch	**PMR405003BR**	●	3	50	40	22.225	19	11	45	8.4	5	11	CPMT1205ZPEN-M2/3
	PMR406304BR	●	4	63	40	22.225	19	11	57	8.4	5	11	CPMT1205ZPEN-M2/3
	PMR408005DR	●	5	80	63	31.75	32	17	73	12.7	8	11	CPMT1205ZPEN-M2/3



SPARE PARTS

Tool Holder Number	Shim	Shim Screw *	Clamp Screw *	Wrench (Insert)	Wrench (Shim)	Set Bolt
PMR405003A22R	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC10035
PMR406304A22R	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC10035
PMR408005A27R	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC12035
PMR405003BR	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC10035
PMR406304BR	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC10035
PMR408005DR	STPMR4N	WCS503507H	①TPS35	①TIP15T	HKY35R	HSC16040

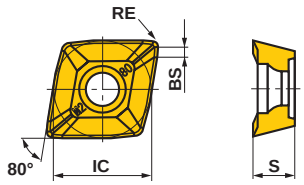
* Clamp Torque (N • m) : TPS35=3.5, CSF401260T=5.0, WCS503507H=5.0, WCS604010H=7.0

● : Inventory maintained in Japan.
(10 inserts in one case)

INSERTS

Work Material			
P	Steel	◐	
K	Cast Iron	✠	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Coated VP15TF	Dimensions (mm) IC	S	BS	RE	Geometry
	CPMT1205ZPEN-M2	M	●	12.7	5.56	1.4	0.8	
	CPMT1205ZPEN-M3	M	●	12.7	5.56	1.4	1.2	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	pf (mm)
P	Carbon Steel Alloy Steel	180−280HB	**VP15TF**	180 (150−200)	0.2 (0.1−0.3)	≤0.5DC
		280−380HB				
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP15TF**	180 (150−200)	0.2 (0.1−0.3)	≤0.5DC
	Ductile Cast Iron	Tensile Strength 360−500MPa	**VP15TF**	150 (120−170)	0.2 (0.1−0.3)	≤0.5DC
		Tensile Strength 500−800MPa	**VP15TF**	120 (100−150)	0.2 (0.1−0.3)	≤0.5DC

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution
Note 1) The above conditions are suitable for general machining purposes, it is possible to use conditions that are different from the above.
Note 2) For horizontal feed machining, please reduce the feed rate by 20−40%.
Note 3) If vibration occurs when machining, please reduce the depth of cut, and reduce the cutting speed by 20−50%.

BORING CUTTER

BMR

P | M | **K** | N | S | H

Cast Iron

Body with Peripheral Cutting Edge Run-out Regulator

With peripheral cutting edge regulating function for possible use of economical M-class inserts.

* Cutter bodies are only available through special orders.

High Clamping Rigidity

High feed processing possible with improved fracture resistance.

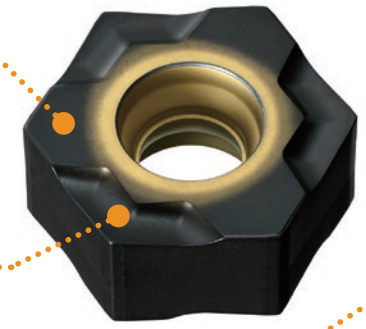
Double Positive Breaker

Reduced cutting resistance. Supports open deck work. Effective finished surface due to wiper edge.

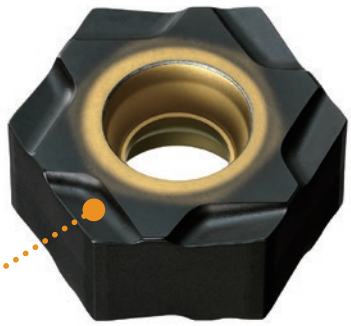
12-Corner Type with Right Hand

Economical 12-corner type that preserves comparable insert rigidity of the 6-corner type by securing the seating surface directly below where the cutting force is absorbed.

Double-sided 6-corner type (No hand)

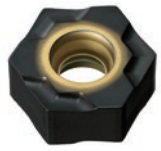
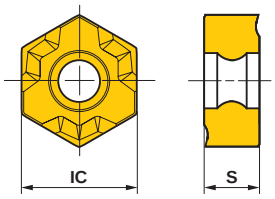
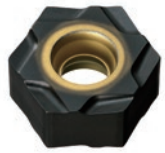
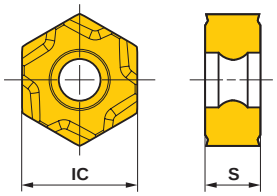


Double-sided 12-corner type (Right hand only)



INSERTS

Work Material	K	Cast Iron	◐	Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Grade	Hand	Cutting edge	Stock	Dimensions (mm) IC	Dimensions (mm) S	Geometry
	**HNMX1206EN06-R**	**MC5015**	–	6	●	12.7	6.0	
	**HNMX1206ER12-R**	**MC5015**	R	12	●	12.7	6.0	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Tensile Strength	Grade	Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)	Cutting depth **ae** (mm)
K	Gray Cast Iron	≤350MPa	**MC5015**	200 (150—250)	0.2 (0.1—0.25)	≤3.0

* With feed per cutter, settings are set small for finished surface roughness and large for ideal product life.

● : **Inventory maintained in Japan. (10 inserts in one case)**

QUICK CHANGE TYPE

<HIGH FEED CUTTING FOR CAST IRON>

90° KAPR

F

FP490

P | M | **K** | N | S | H

Cast Iron

- **11°positive insert.**
- **Suitable for cast iron finishing.**
- **Multi insert design.**
- **For high feed cutting.**
- **Easy tool exchange.**

Fig.1
Q type
(Small
Diameter)
ø80
ø100
ø125
ø160

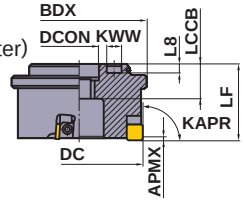


Fig.2
Q type
(Large
Diameter)
ø200
ø250
ø315
ø355
ø400
ø500

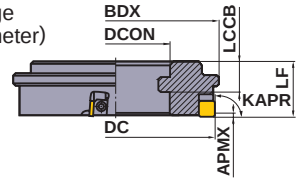
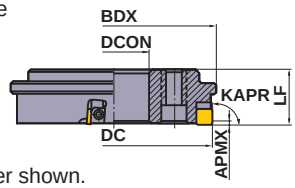


Fig.3
T type
ø250
ø315
ø355
ø400



KAPR : 90°
GAMP : +5° GAMF : +0°

Right hand tool holder shown.

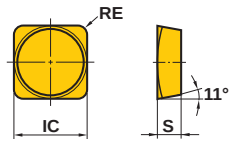
Type	Order Number	Number of Teeth	Dimensions (mm) DC	BDX	LF	DCON	LCCB	KWW	L8	WT* (kg)	APMX (mm)	Installation Detail Dimensions	Fig.
Quick Change Q Type	**FP490R/L0308Q**	8	80	85	50	25.4	26	10.8	7	1.5	0.5	Q Typeϕ80−ϕ160	1
	FP490R/L0410Q	10	100	105	63	31.75	29	12.8	7	2.8	0.5		1
	FP490R/L0514Q	14	125	130	63	38.1	29	15.8	7	4.2	0.5		1
	FP490R/L0618Q	18	160	165	63	50.8	29	18.8	7	6.7	0.5		1
	FP490R/L0822Q	22	200	205	45	125	25	—	—	5.5	0.5	Q Typeϕ200−ϕ500	2
	FP490R/L1028Q	28	250	255	45	175	25	—	—	8.0	0.5		2
	FP490R/L1236Q	36	315	320	45	240	25	—	—	10.7	0.5		2
	FP490R/L1440Q	40	355	360	45	280	25	—	—	12.2	0.5		2
	FP490R/L1646Q	46	400	405	45	325	25	—	—	13.8	0.5		2
	FP490R/L2056Q	56	500	505	45	425	25	—	—	17.8	0.5		2
Quick Change T Type	**FP490R/L1028T**	28	250	260	45	110	—	—	—	9.8	0.5	T Typeϕ250−ϕ400	3
	FP490R/L1236T	36	315	325	45	175	—	—	—	12.1	0.5		3
	FP490R/L1440T	40	355	365	45	215	—	—	—	14.1	0.5		3
	FP490R/L1646T	46	400	410	45	260	—	—	—	15.4	0.5		3

Note 1) These are produced to order only.
* WT : Tool Weight

● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

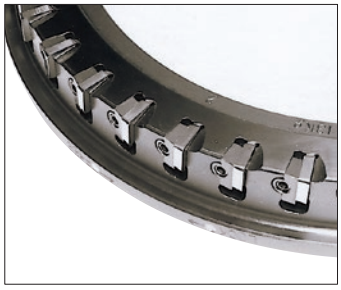
Work Material	K	Cast Iron	◐	●	Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Carbide HTi10	Carbide HTi05T	Dimensions (mm) IC	S	RE	Geometry
	SPEN424A	E	●	●	12.76	3.18	1.6	

RECOMMENDED CUTTING CONDITIONS

Work Material		Tensile Strength	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K	Gray Cast Iron	≤350MPa	**HTi05T**	125 (100—150)	0.2 (0.1—0.3)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)
=Feed per Tooth x Number of Teeth x Cutter Revolution



SPARE PARTS

Tool Holder Number	Wedge	Clamp Screw *	Wrench	Wrench (Sold Separately)	Hexagonal Head (Sold Separately)
FP490R/L0308Q - FP490R/L1646T	CWS42SPR/L	LS14	HKY40T	120QSPK×80 (KANONN-SEIKI CO.)	6.35□×4 (KYOKUTO MFG CO.)

* Clamp Torque (N • m) : LS14=7.8

M

INDEXABLE MILLING

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

QUICK CHANGE TYPE

<HIGH FEED CUTTING FOR CAST IRON>

90° KAPR

F

FP590

P | M | **K** | N | S | H

Cast Iron

- **11°positive insert.**
- **Suitable for cast iron finishing.**
- **Multi insert design.**
- **For high feed cutting.**
- **Easy tool exchange.**

Fig.1
Q type
(Small
Diameter)
ø125
ø160

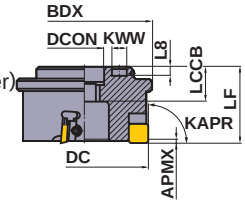


Fig.2
Q type
(Large
Diameter)
ø200
ø250
ø315
ø355
ø400
ø500

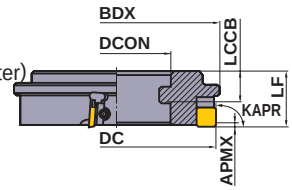
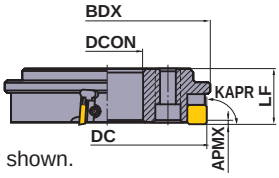


Fig.3
T type
ø250
ø315
ø355
ø400



KAPR : 90°
GAMP : +5° GAMF : +0°

Right hand tool holder shown.

Type	Order Number	Number of Teeth	Dimensions(mm) DC	BDX	LF	DCON	LCCB	KWW	L8	WT* (kg)	APMX (mm)	Installation Detail Dimensions	Fig.
Quick Change Q Type	**FP590R/L0514Q**	14	125	135	63	38.1	29	15.8	7	4.2	0.5	Q Typeϕ125—ϕ160	1
	FP590R/L0618Q	18	160	170	63	50.8	29	18.8	7	6.7	0.5		1
	FP590R/L0822Q	22	200	210	45	125	25	—	—	5.5	0.5	Q Typeϕ200—ϕ500	2
	FP590R/L1028Q	28	250	260	45	175	25	—	—	8.0	0.5		2
	FP590R/L1236Q	36	315	325	45	240	25	—	—	10.7	0.5		2
	FP590R/L1440Q	40	355	365	45	280	25	—	—	12.2	0.5		2
	FP590R/L1646Q	46	400	410	45	325	25	—	—	13.8	0.5		2
	FP590R/L2056Q	56	500	510	45	425	25	—	—	17.8	0.5		2
Quick Change T Type	**FP590R/L1028T**	28	250	260	45	110	—	—	—	9.8	0.5	T Typeϕ250—ϕ400	3
	FP590R/L1236T	36	315	325	45	175	—	—	—	12.1	0.5		3
	FP590R/L1440T	40	355	365	45	215	—	—	—	14.1	0.5		3
	FP590R/L1646T	46	400	410	45	260	—	—	—	15.4	0.5		3

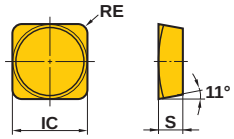
Note 1) These are produced to order only.
* WT : Tool Weight

● : **Inventory maintained in Japan. (10 inserts in one case)**

INSERTS

Work Material	K	Cast Iron

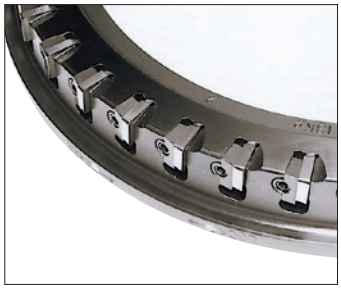
Cutting Conditions :
● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

Shape	Order Number	Class	Carbide HTi05T		Dimensions (mm) IC	S	RE	Geometry
	SPEN535A	E	●		15.875	4.76	2.0	

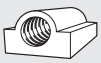
RECOMMENDED CUTTING CONDITIONS

Work Material		Tensile Strength	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K	Gray Cast Iron	≤350MPa	**HTi05T**	125 (100—150)	0.2 (0.1—0.3)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)
=Feed per Tooth x Number of Teeth x Cutter Revolution



SPARE PARTS

Tool Holder Number	 Wedge	* Clamp Screw	Wrench	Wrench (Sold Separately)	Hexagonal Head (Sold Separately)
FP590R/L0514Q - FP590R/L1646T	CWS5	LS14	HKY40T	120QSPK×80 (KANONN-SEIKI CO.)	6.35□×4 (KYOKUTO MFG CO.)

* Clamp Torque (N • m) : LS14=7.8

M

INDEXABLE MILLING

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

QUICK CHANGE TYPE

<FINISHING FOR ALUMINIUM ALLOY>

86° KAPR PF

FE404

P M K **N** S H

Non-ferrous Metal

- **21°positive insert.**
- **High rake and relief angle.**
- **Suitable for light alloy machining.**
- **Easy tool exchange.**

Fig.1
Q type (Small Diameter)
ø100
ø125
ø160

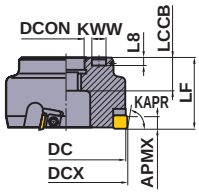


Fig.2
Q type (Large Diameter)
ø200
ø250
ø315
ø355
ø400
ø500

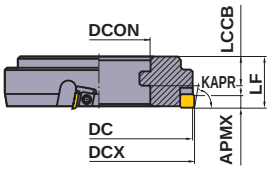
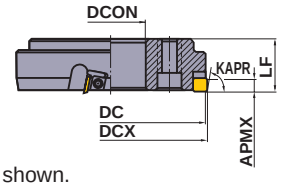


Fig.3
T type
ø250
ø315
ø355
ø400



KAPR:86°
GAMP:+11° GAMF:+9°

Right hand tool holder shown.

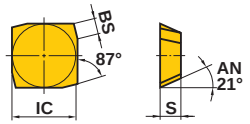
Type	Order Number	Number of Teeth	Dimensions(mm) DC	DCX	LF	DCON	LCCB	KWW	L8	WT* (kg)	APMX (mm)	Installation Detail Dimensions	Fig.
Quick Change Q Type	**FE404R/L0408Q**	8	100	102	63	31.75	29	12.8	7	3.2	9	Refer to page M014. (Q Typeϕ100—ϕ160)	1
	FE404R/L0510Q	10	125	127	63	38.1	29	15.8	7	4.7	9		1
	FE404R/L0612Q	12	160	162	63	50.8	29	18.8	7	7.6	9		1
	FE404R/L0816Q	16	200	202	45	125	25	—	—	6.1	9	Refer to page M015. (Q Typeϕ200—ϕ500)	2
	FE404R/L1020Q	20	250	252	45	175	25	—	—	7.8	9		2
	FE404R/L1224Q	24	315	317	45	240	25	—	—	10.2	9		2
	FE404R/L1428Q	28	355	357	45	280	25	—	—	11.8	9		2
	FE404R/L1632Q	32	400	402	45	325	25	—	—	13.3	9		2
	FE404R/L2040Q	40	500	502	45	425	25	—	—	16.2	9		2
Quick Change T Type	**FE404R/L1020T**	20	250	251	45	110	—	—	—	9.9	9	Refer to page M015. (T Typeϕ250—ϕ400)	3
	FE404R/L1224T	24	315	316	45	175	—	—	—	12.2	9		3
	FE404R/L1428T	28	335	356	45	215	—	—	—	13.7	9		3
	FE404R/L1632T	32	400	401	45	260	—	—	—	16.2	9		3

Note 1) These are produced to order only.
* WT : Tool Weight

▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

INSERTS

Work Material	N	Non-ferrous Metal	◐		Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting

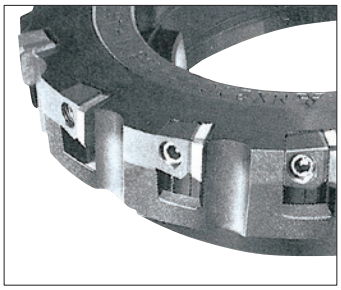
Shape	Order Number	Class	Carbide HTi10		Dimensions (mm) IC	S	BS	Geometry
	SEA42C10GR	A	▲		12.70	3.18	2.4	
	SEA42C10GL	A	▲		12.70	3.18	2.4	

Note 1) Use R at a right hand body and L at a left hand body.

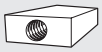
RECOMMENDED CUTTING CONDITIONS

Work Material		Silicon (%)	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
N	Aluminium Alloy	≤10	**HTi10**	700 (400−1000)	0.15 (0.05−0.25)
		≥10	**HTi10**	400 (200−600)	0.15 (0.05−0.25)

● Revolution (min^{-1})=(1000 x Cutting Speed)÷(3.14 x DC)
● Table Feed (mm/min)
=Feed per Tooth x Number of Teeth x Cutter Revolution



SPARE PARTS

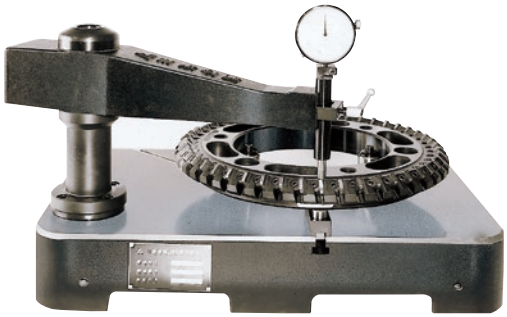
Tool Holder Number	 Wedge	* Clamp Screw	Wrench	Wrench (Sold Separately)	Hexagonal Head (Sold Separately)
FE404R/L0408Q ı **FE404R/L1632T**	CWS42SER/L	LS10	HKY40T	120QSPK×80 (KANONN-SEIKI CO.)	6.35□×4 (KYOKUTO MFG CO.)

* Clamp Torque (N • m) : LS10=8.2

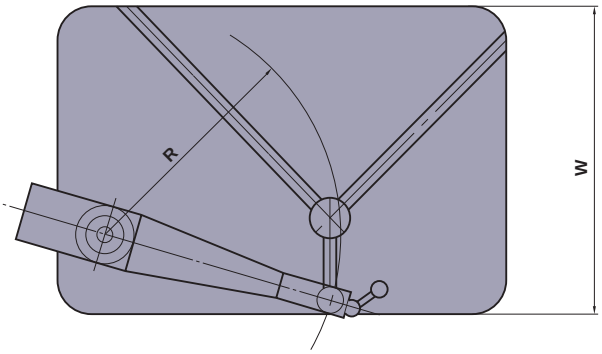
SETTING FIXTURE

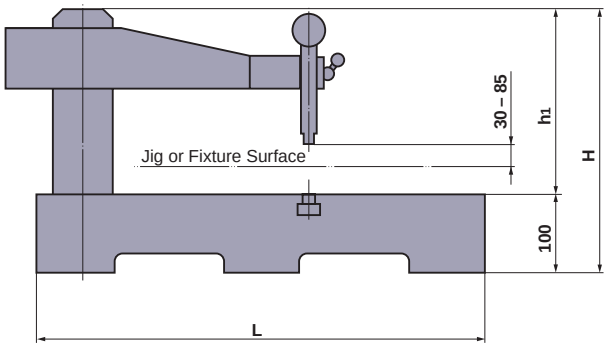
FEATURES OF SETTING FIXTURE

- **Compact design.**
- **Easy set up operation.**
- **Insert is adjusted from the cutting edge point therefore run-out accuracy is high.**



SETTING FIXTURE STANDARD

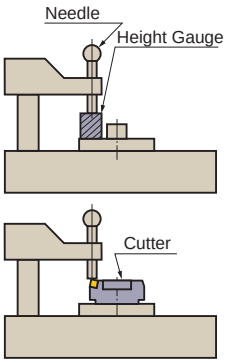




Order Number	R	L	W	H	h1	Cutter Diameter
SEF500	315	600	400	347	247	—ϕ500
SEF700	400	800	500	360	260	ϕ315—ϕ700

Note 1) Please specify the order number when ordering.
Note 2) Please contact us regarding special spare parts order.

Method of Insert Setting for One Piece Type.

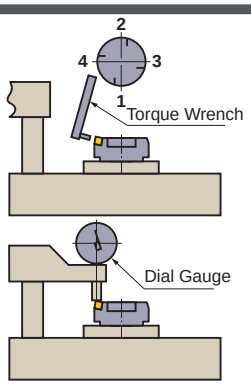


①Set the needle using a height gauge which is the same height as the cutter.

②Move the needle to an insert.

③Slide the insert to the point where it touches the needle Tighten all the inserts lightly. (Use torque wrench.) (1—2N • m)

★Screwing the inserts too tightly results in lower accuracy.



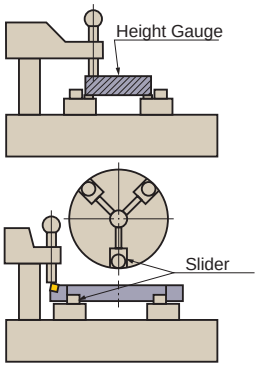
④After temporary tightening, use a torque wrench to tighten firmly. (Use torque wrench.) (8 N • m)

⑤Screw the inserts tightly according to the picture shown on the left.

⑥Check run-out of all the inserts with a dial gauge.

★For general milling, ≤10μm is the standard. For finishing,set the insert run out at≤5μm.

Method of Insert Setting for Two Piece Type.



①Set the height gauge at the same height as the cutter on the liners of slider, then set the needle.

②Put the cutter on the liners of the slider and move the rollers of the slider to the installation holes.

③Make sure that the three rollers are free, then fix the sliders.

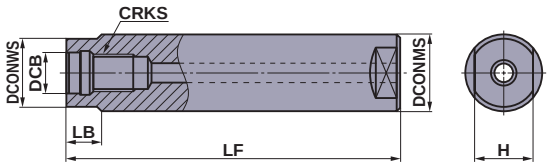
★Process of tightening the inserts is the same as the one piece type.

●Note

1. After machining, dust off chips on the cutter with air before loosening the wedge.
2. When loosening clamp screws, avoid using a damaged wrench.
3. Alien substances attached to inserts lowers run-out accuracy and damages the cutter body. Therefore, they need to be cleaned throughly.
4. After all the inserts are taken out, clean the cutter body with oil or strong air blow.
5. Use a torque wrench or special wrench for tightening the clamp screws.

ARBORS

■STRAIGHT SHANK ARBOR



Type	Order Number	Stock	Dimensions (mm)						
			DCB	DCONMS	DCONWS	LF	LB	H	CRKS
STEEL SHANK TYPE	**SC16M08S100S**	●	8.5	16	14.5	100	10	10	M8
	SC16M08S200L	●	8.5	16	14.5	200	10	10	M8
	SC20M10S120S	●	10.5	20	18.5	120	10	14	M10
	SC20M10S220L	●	10.5	20	18.5	220	10	14	M10
	SC25M12S125S	●	12.5	25	23.5	125	10	19	M12
	SC25M12S245L	●	12.5	25	23.5	245	10	19	M12
	SC32M16S140S	●	17	32	28.5	140	15	24	M16
	SC32M16S280L	●	17	32	28.5	280	15	24	M16
CARBIDE SHANK TYPE	**SC16M08S100SW**	●	8.5	16	14.5	100	10	10	M8
	SC16M08S200LW	●	8.5	16	14.5	200	10	10	M8
	SC20M10S120SW	●	10.5	20	18.5	120	10	14	M10
	SC20M10S220LW	●	10.5	20	18.5	220	10	14	M10
	SC25M12S125SW	●	12.5	25	23.5	125	10	19	M12
	SC25M12S245LW	●	12.5	25	23.5	245	10	19	M12
	SC32M16S140SW	●	17	32	28.5	140	15	24	M16
	SC32M16S280LW	●	17	32	28.5	280	15	24	M16

HOW TO INSTALL THE SCREW-IN HEAD

①Thoroughly clean the clamp section of the head and the arbor with an air blower or brush before installation.

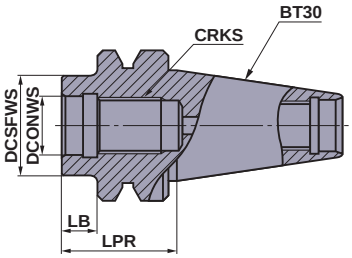
②Tighten the head at the recommended torque and ensure that there is no gap between the head and arbor.

Screw Size	Recommended Torque (N • m)	Wrench Size (mm)
M8	23	10
M10	46	14
M12	80	19
M16	90	24

●Cutting tools become extremely hot during cutting. Never touch them with bare hands after operation as this may produce risk of injuries or burns.
●Do not handle the cutting tools with bare hands as this may cause injuries.

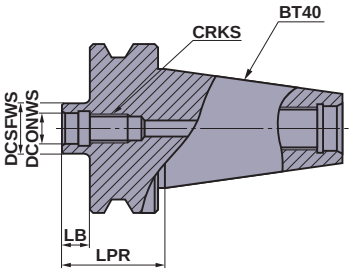
● : **Inventory maintained in Japan.**

■BT30 SHANK ARBOR



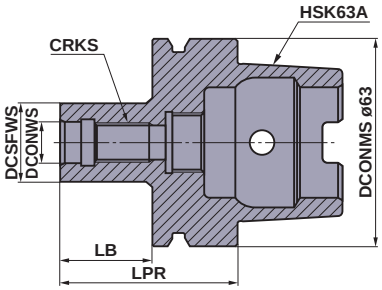
Order Number	Stock	Dimensions (mm)				
		DCONWS	DCSFWS	LPR	LB	CRKS
SC16M08S10-BT30	●	8.5	14.5	32	10	M8
SC20M10S10-BT30	●	10.5	18.5	32	10	M10
SC25M12S10-BT30	●	12.5	23.5	32	10	M12
SC32M16S10-BT30	●	17.0	28.5	32	10	M16

■BT40 SHANK ARBOR



Order Number	Stock	Dimensions (mm)				
		DCONWS	DCSFWS	LPR	LB	CRKS
SC16M08S10-BT40	●	8.5	14.5	37	10	M8
SC20M10S10-BT40	●	10.5	18.5	37	10	M10
SC25M12S10-BT40	●	12.5	23.5	37	10	M12
SC32M16S10-BT40	●	17.0	28.5	37	10	M16

■HSK63A SHANK ARBOR



Order Number	Stock	Dimensions (mm)				
		DCONWS	DCSFWS	LPR	LB	CRKS
SC16M08S22-HSK63A	●	8.5	14.5	48	22	M8
SC20M10S24-HSK63A	●	10.5	18.5	50	24	M10
SC25M12S27-HSK63A	●	12.5	23.5	53	27	M12
SC32M16S28-HSK63A	●	17.0	28.5	54	28	M16

Note 1) The HSK63A shank type has a built-in coolant pipe for installation.

● : Inventory maintained in Japan.

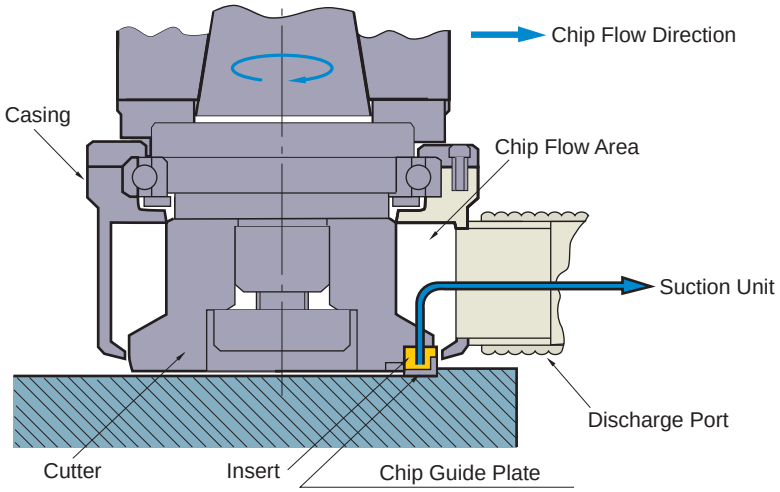
TECHNICAL DATA ➢ R001

Qing SYSTEM

STRUCTURE CHIP COLLECTION METHOD

STRUCTURE

- **Automatic continuous intake of chips while machining.**
- **Eliminates chip handing problems.**



1
Cutting is performed by a face mill.

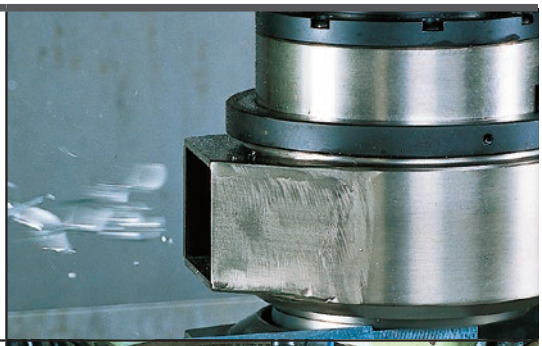
2
Chips are directed into the casing by way of the chip guide plate.

3
Chips are expelled via the discharge port.

■CHIP COLLECTION METHOD

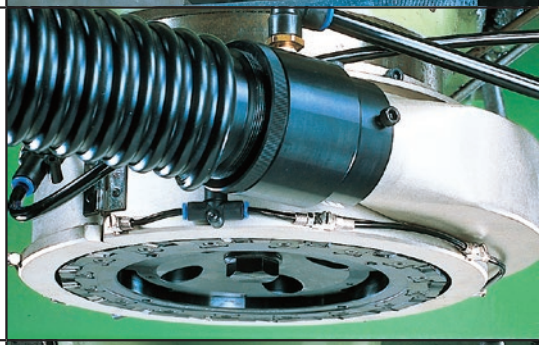
Self Expulsion Type QMC

①Chips are discharged towards the chip conveyor because of the centrifugal force created by the cutter.
②Installation with an ATC(auto tool changer) on machining centers is possible.
③Since there is no need for air or a dust collector, this method provides the lowest initial investment and running costs.
④Chips cannot be transported (carried) directly over long distances.
⑤High speed bearing required to suit high speed machining.



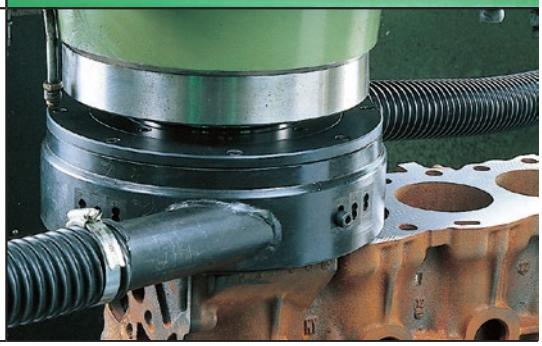
Double Air Type QWA

①Chip recovery using compressed air (factory air).
②Since air is also injected into the casing interior, wet cutting is also possible.
③Achieves the same suction capabilities as a dust collector, thereby enabling low equipment costs.
④Wet cutting is not recommended.



Vacuum Machine Type QSV

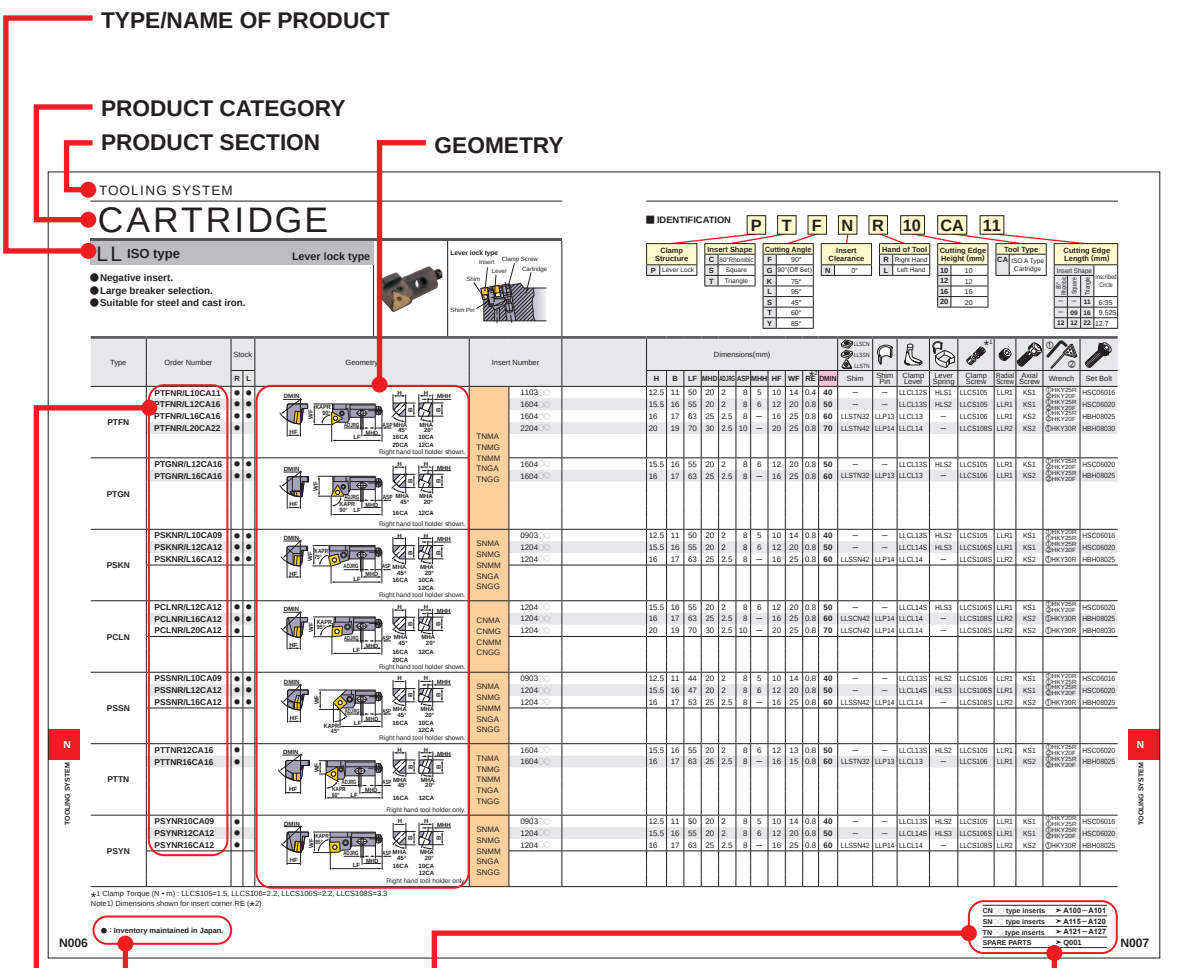
①Chip collection by use of a suction machine.
②Chip collection efficiency is high.
③Special equipment is required, such as a mist collector for wet cutting.



HOW TO READ THE STANDARD OF TOOLING SYSTEM

●How this section page is organised

①Organised by product series. (Refer to the index on the next page.)



●To Order : Please specify
①order number and hand of tool (right/left).

MILLING TOOLS

TOOLING SYSTEM

VALVE FINISHER ····· N002

CARTRIDGE

- LL TYPE CARTRIDGE ····· N006
- BC TYPE CARTRIDGE ····· N008
- SS TYPE CARTRIDGE ····· N010

BORING UNIT ····· N012

MI TYPE BORING BARS ····· N015

QUICK CHANGE TOOLING SYSTEM

- CLASSIFICATION OF QUICK CHANGE SYSTEM ····· N016
- FACE MILL ····· N017
- FACE MILLING ADAPTER ····· N018
- SIDE CUTTER ····· N020
- BORING TOOL ····· N021

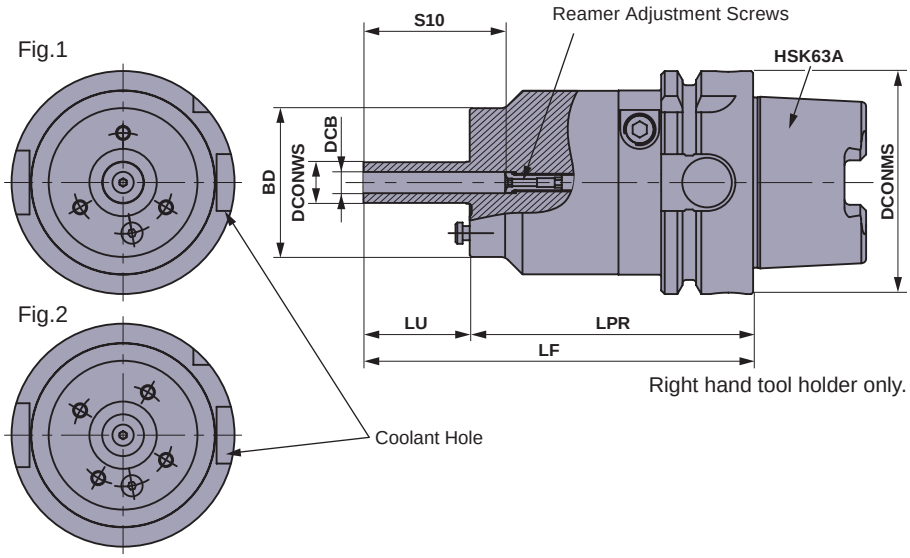
MODULAR TOOLING SYSTEM

- ABS® License KOMET® ····· N022
- HSK SYSTEM ····· N026

*Arranged by Alphabetical order

N024 **ABS○○○-ES-M**
N024 **ABS○○○-ES-M1**
N024 **ABS○○○-ES-M3**
N025 **ABS○○○-ES-M4**
N023 **ABS○○○-FS-W**
N024 **ABS○○○M**
N023 **ABS○○○W**
N024 **ABS○○-ES-M**
N024 **ABS○○-ES-M1**
N024 **ABS○○-ES-M3**
N025 **ABS○○-ES-M4**
N023 **ABS○○-FS-W**
N024 **ABS○○M**
N023 **ABS○○W**
N008 **CSKPR○○CA○○**
N008 **CSSPR○○CA○○**
N012 **FA○-FA○○○○**
N012 **FA○-FA○○○○S**
N012 **FV○-FV○○○○**
N012 **FV○-FV○○○○S**
N027 **HSK-○○○M**
N027 **HSK-○○○○M**
N002 **HVF06-HSK63A○○○○○**
N006 **PCLNR/L○○CA○○**
N006 **PSKNR/L○○CA○○**
N006 **PSSNR/L○○CA○○**
N006 **PSYNR○○CA○○**
N006 **PTFNR/L○○CA○○**
N006 **PTGNR/L○○CA○○**
N006 **PTTNR○○CA○○**
N021 **QB○○○○○○○**
N019 **QFA○○○○○○**
N018 **QFA○○○○○B○R/L**
N018 **QFA○○○○○N○R/L**
N019 **QFB○○○○○○R/L**
N025 **SBA○○○-ES-M**
N025 **SBA○○○-ES-M1**
N025 **SBA○○-ES-M**
N025 **SBA○○-ES-M1**
N015 **SBR○○○**
N010 **SSKPR○○CA○○**
N010 **SSSPR○○CA○○**
N010 **SSYPR○○CA○○**
N010 **STFPR/L○○CA○○**
N010 **STGPR○○CA○○**
N010 **STTPR○○CA○○**

VALVE FINISHER



Right hand tool holder only.

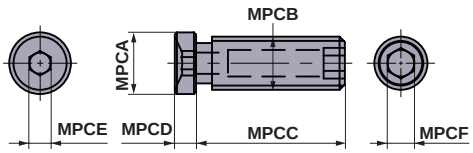
* The Mitsubishi Materials tool holder (Patent held in Japan) is manufactured under license by NT TOOL CORPORATION.

■Tool Holder

Order Number	Stock	Dimensions(mm)								Coolant Hole (Hole)	WT (kg)	Installation	Balance Accuracy
		BD	DCONWS	DCB	S10	LF	LU	LPR	DCONMS				
HVF06-HSK63A110A3	●	42	11.5	6	40	110	30	80	63	Fig.1 (3 Hole)	1.5	HSK63A (With Coolant Pipe)	G2.5 (5000min^{-1})
HVF06-HSK63A110A4	●	42	11.5	6	40	110	30	80	63	Fig.2 (4 Hole)	1.5		
HVF06-HSK63A180A3	●	42	11.5	6	40	180	30	150	63	Fig.1 (3 Hole)	2.6		
HVF06-HSK63A180A4	●	42	11.5	6	40	180	30	150	63	Fig.2 (4 Hole)	2.6		

* A variety of other tool holders, such as BT shanks with their distinctive double face contact, can be mounted as well.

Spare Parts (Reamer Adjustment Screws)

Geometry	Order Number	Stock	Dimensions (mm)					
			MPCA	MPCB	MPCC	MPCD	MPCE	MPCF
	**HSC05016HW**	●	5.8	M5×0.8	14	2	2	2.5

Reamer adjustment screws can be operated using a wrench from both the reamer insertion hole side and the mounting side.
The reamer adjustment screw is an accessory (1 piece), which can also be additionally purchased as a stand-alone item.
A hexagon socket set screw (M4) is included with the tool holder. It should be used as a stopper when discharging coolant with the use of an external oil supply.

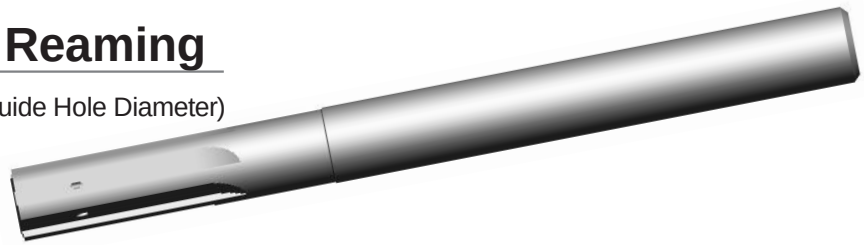
● : **Inventory maintained in Japan.**

Produced-to-Order Products

Please inquire with our Sales Department regarding production.

For Valve Guide Hole Reaming

Compatible Reamer Range : ≤ **ø6** (Guide Hole Diameter)



RT9005

Optimization and strengthening of the hard phase (WC) particle diameter and bonded phase (Co) have improved the wear resistance and fracture resistance, for the creation of a unique cemented carbide.

EF05

An ultra-high hardness, ultra micro-particle cemented carbide that contains specialized components. Just as with RT9005, its wear resistance and fracture resistance have been improved.

Coating (TiN)

The hard coating with smooth surface properties can maintain an excellent finished surface over extended periods of time.

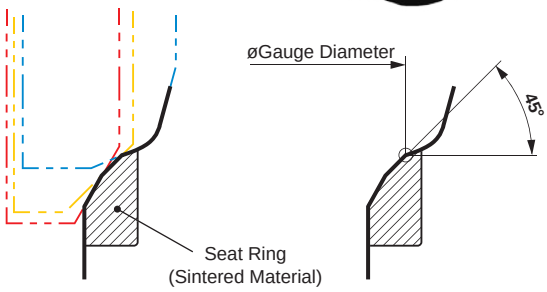
For Seat Surface Machining

Compatible Head Range : **ø20** ≤ Head Diameter < **ø35**
(Seat Hole : 45°-Surface Gauge Diameter)

Tool Bits : 3 types

MB4020

High edge toughness has been achieved with a newly-developed special binder. The even sharper cutting edge shape can suppress the creation of burrs and ensure high accuracy. CBN, which is included with a high chemical content, has outstanding welding resistance so that a constant dimensional accuracy can be maintained.



● The seat surface is composed of 3 faces at different angles (Cutting with 3 types of edges).

Relationship between number of head cutting edge grooves and tool holders

* HVF06-HSK63A110A○ : Suitable for cases with no processing beyond the angle plate
* HVF06-HSK63A180A○ : Suitable for cases with processing beyond the angle plate

Order Number	Coolant Hole (Hole)	Number of Cutting Edge Grooves on Head			
		1	2	3	4
HVF06-HSK63A110A3	**3**	○	×	○	×
HVF06-HSK63A180A3	**3**	○	×	○	×
HVF06-HSK63A110A4	**4**	○	○	×	○
HVF06-HSK63A180A4	**4**	○	○	×	○

○ = Suitable × = Unsuitable

* Hexagon socket set screws (M4) are included as separately-packaged accessories.

Important! Install screws in any unused coolant holes.

RECOMMENDED CUTTING CONDITIONS

For Valve Guide Hole Reaming

Work Material	Reamer Material			Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)
	Grade	Hardness (HRA)	Bending Strength (Gpa)		
Steel-based Sintered Alloy	**RT9005**	92.2	2.0	40 — 60	0.03 — 0.05
Cast Iron	**EF05**	94.0	2.5		

Seat Surface Machining

Work Material	Priority	CBN Material for Bits	Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)
Sintered Alloy	1	**MB4020**	60 — 120	0.05 — 0.10
	2	**MB825**		
	2	**MB835**		

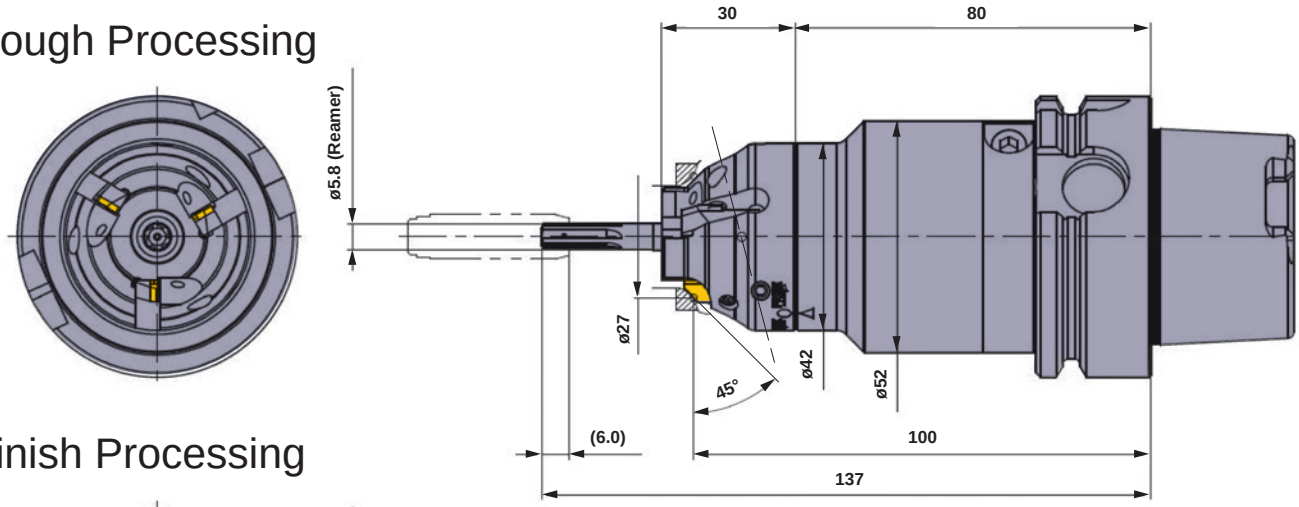
* Select materials in accordance with seat material characteristics.

Setup Reference Diagram

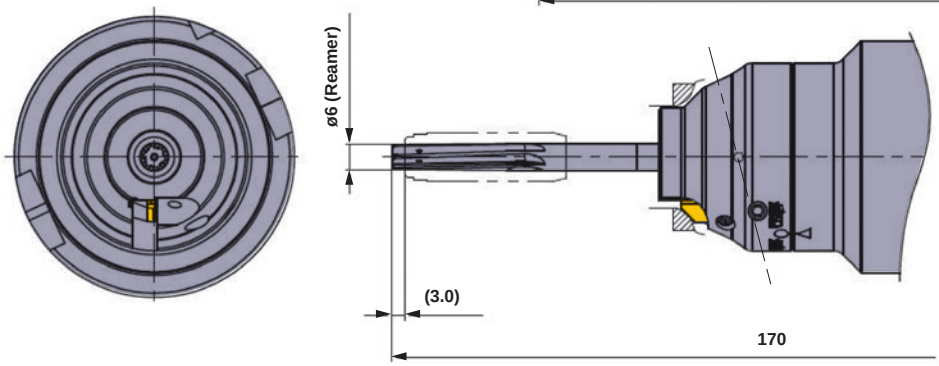
(When Tool Holder : HVF06-HSK63A110A3 is suitable)

(mm)

Rough Processing



Finish Processing



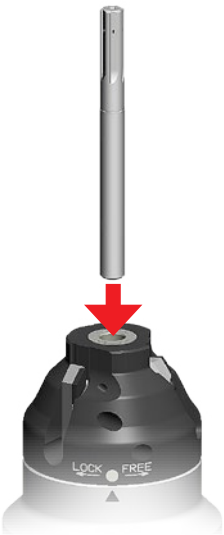
Procedure

STEP 1

Mount the head on the tool holder.

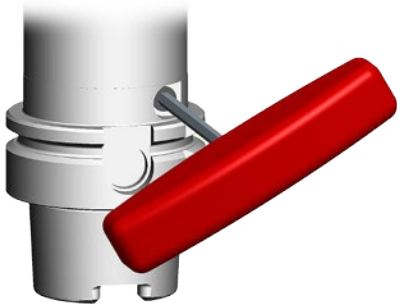
STEP 2

Attach the reamer.



STEP 3

Tightening and removing screws follow opposite procedures from the usual.



During use, line up the markings on the head and tool holder to secure them in place. When mounting and removing them, turn them to the side marked “FREE”.

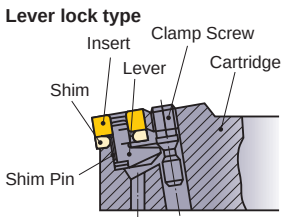
Secured Position

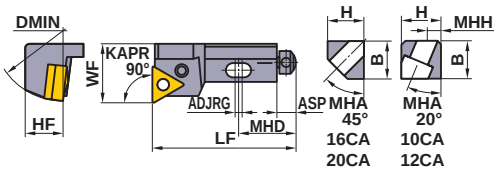
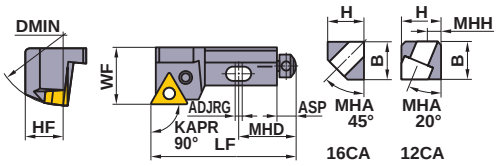
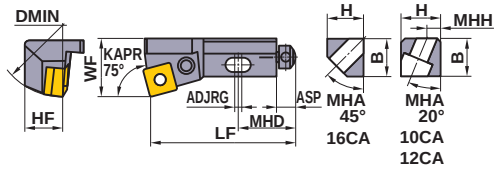
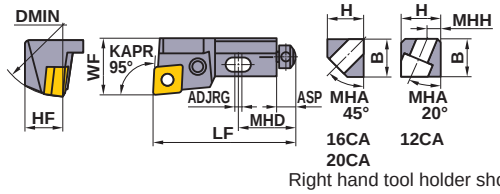
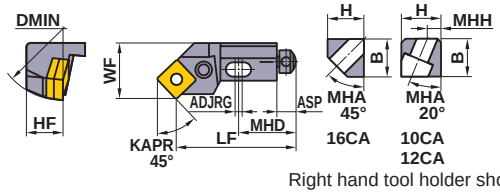
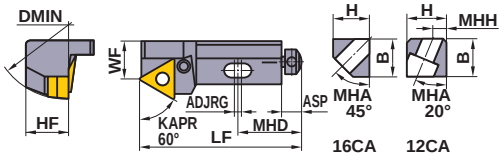
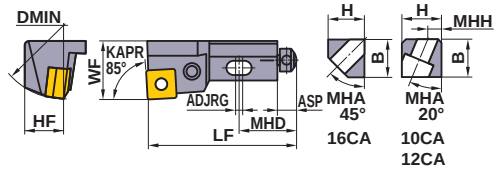
Mounting / Removal Position

CARTRIDGE

LL ISO type — Lever lock type

- **Negative insert.**
- **Large breaker selection.**
- **Suitable for steel and cast iron.**



Type	Order Number	Stock R	Stock L	Geometry	Insert Number	
PTFN	PTFNR/L10CA11	●	●	 Right hand tool holder shown.	TNMA TNMG TNMM TNGA TNGG	1103○○
	PTFNR/L12CA16	●	●			1604○○
	PTFNR/L16CA16	●	●			1604○○
	PTFNR/L20CA22	●				2204○○
PTGN	PTGNR/L12CA16	●	●	 Right hand tool holder shown.		1604○○
	PTGNR/L16CA16	●	●			1604○○
PSKN	PSKNR/L10CA09	●	●	 Right hand tool holder shown.	SNMA SNMG SNMM SNGA SNGG	0903○○
	PSKNR/L12CA12	●	●			1204○○
	PSKNR/L16CA12	●	●			1204○○
PCLN	PCLNR/L12CA12	●	●	 Right hand tool holder shown.	CNMA CNMG CNMM CNGG	1204○○
	PCLNR/L16CA12	●	●			1204○○
	PCLNR/L20CA12	●				1204○○
PSSN	PSSNR/L10CA09	●	●	 Right hand tool holder shown.	SNMA SNMG SNMM SNGA SNGG	0903○○
	PSSNR/L12CA12	●	●			1204○○
	PSSNR/L16CA12	●	●			1204○○
PTTN	PTTNR12CA16	●		 Right hand tool holder only.	TNMA TNMG TNMM TNGA TNGG	1604○○
	PTTNR16CA16	●				1604○○
PSYN	PSYNR10CA09	●		 Right hand tool holder only.	SNMA SNMG SNMM SNGA SNGG	0903○○
	PSYNR12CA12	●				1204○○
	PSYNR16CA12	●				1204○○

*1 Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS106S=2.2, LLCS108S=3.3
Note1) Dimensions shown for insert corner RE (*2).

● : **Inventory maintained in Japan.**

■ IDENTIFICATION

P T F N R 10 CA 11

Clamp Structure	
P	Lever Lock

Insert Shape	
C	80°Rhombic
S	Square
T	Triangle

Cutting Angle	
F	90°
G	90°(Off Set)
K	75°
L	95°
S	45°
T	60°
Y	85°

Insert Clearance	
N	0°

Hand of Tool	
R	Right Hand
L	Left Hand

Cutting Edge Height (mm)	
10	10
12	12
16	16
20	20

Tool Type	
CA	ISO A Type Cartridge

Cutting Edge Length (mm)			
Insert Shape			Inscribed Circle
80° Rhombic	Square	Triangle	
—	—	11	6.35
—	09	16	9.525
12	12	22	12.7

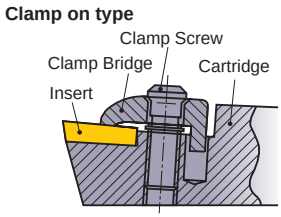
Dimensions(mm)											LLSCN LLSSN LLSTN			① ②	*1		① ②	
H	B	LF	MHD	ADJRG	ASP	MHH	HF	WF	RE *2	DMIN	Shim	Shim Pin	Clamp Lever	Lever Spring	Clamp Screw	Radial Screw	Axial Screw	Wrench	Set Bolt
12.5	11	50	20	2	8	5	10	14	0.4	**40**	—	—	LLCL12S	②HLS1	LLCS105	LLR1	KS1	①HKY25R ②HKY20F	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	25	0.8	**60**	LLSTN32	LLP13	LLCL13	—	LLCS106	LLR1	KS2	①HKY25R ②HKY20F	HBH08025
20	19	70	30	2.5	10	—	20	25	0.8	**70**	LLSTN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08030
15.5	16	55	20	2	8	6	12	20	0.8	**50**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	25	0.8	**60**	LLSTN32	LLP13	LLCL13	—	LLCS106	LLR1	KS2	①HKY25R ②HKY20F	HBH08025
12.5	11	50	20	2	8	5	10	14	0.8	**40**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY20R ①HKY25R	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	—	—	LLCL14S	①HLS3	LLCS106S	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	25	0.8	**60**	LLSSN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08025
15.5	16	55	20	2	8	6	12	20	0.8	**50**	—	—	LLCL14S	①HLS3	LLCS106S	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	25	0.8	**60**	LLSCN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08025
20	19	70	30	2.5	10	—	20	25	0.8	**70**	LLSCN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08030
12.5	11	44	20	2	8	5	10	14	0.8	**40**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY20R ①HKY25R	HSC06016
15.5	16	47	20	2	8	6	12	20	0.8	**50**	—	—	LLCL14S	①HLS3	LLCS106S	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	53	25	2.5	8	—	16	25	0.8	**60**	LLSSN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08025
15.5	16	55	20	2	8	6	12	13	0.8	**50**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	15	0.8	**60**	LLSTN32	LLP13	LLCL13	—	LLCS106	LLR1	KS2	①HKY25R ②HKY20F	HBH08025
12.5	11	50	20	2	8	5	10	14	0.8	**40**	—	—	LLCL13S	②HLS2	LLCS105	LLR1	KS1	①HKY20R ①HKY25R	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	—	—	LLCL14S	①HLS3	LLCS106S	LLR1	KS1	①HKY25R ②HKY20F	HSC06020
16	17	63	25	2.5	8	—	16	25	0.8	**60**	LLSSN42	LLP14	LLCL14	—	LLCS108S	LLR2	KS2	①HKY30R	HBH08025

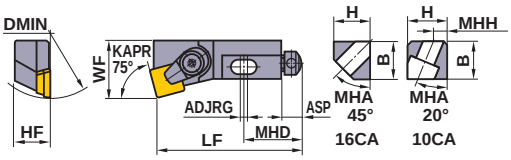
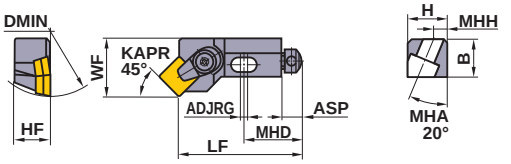
CN□□ type inserts ➤ A100—A101
SN□□ type inserts ➤ A115—A120
TN□□ type inserts ➤ A121—A127
SPARE PARTS ➤ Q001

CARTRIDGE

BC ISO type — Clamp on type

- **11°positive insert.**
- **Suitable for steel, cast iron, aluminium alloys and copper alloys.**



Type	Order Number	Stock R		Geometry	Insert Number		
CSKP	CSKPR10CA09	●		 Right hand tool holder only.	SPMN SPMR SPGN	0903○○	
	CSKPR16CA12	●				1203○○	
CSSP	CSSPR10CA09	●		 Right hand tool holder only.		0903○○	

*1 Clamp Torque (N • m) : BC4L=2.5, BC6=5.0
*2 Dimensions shown for insert corner RE0.8.

● : Inventory maintained in Japan.

■ IDENTIFICATION

C S K P R 10 CA 09

Clamp Structure	
C	Clamp On

Insert Shape	
S	Square

Cutting Angle	
K	75°
S	45°

Insert Clearance	
P	11°

Hand of Tool	
R	Right Hand

Cutting Edge Height (mm)	
10	10
16	16

Tool Type	
CA	ISO A Type Cartridge

Cutting Edge Length (mm)	
Insert Shape	Inscribed Circle
Square	
09	9.525
12	12.7

	Dimensions(mm)											PS PT				*1		
	H	B	LF	MHD	ADJRG	ASP	MHH	HF	WF	RE *2	DMIN	Shim	Shim Pin	Radial Screw	Axial Screw	Clamp Set	Wrench	Set Bolt
	12.5	11	50	20	2	8	5	10	14	0.8	**38**	–	–	TSS05006	KS1	BC4L	TKY10R	HSC06016
	16	17	63	25	2	8	–	16	25	0.8	**55**	PS42	BCP251	TSS06010	KS2	BC6	TKY20R	HBH08025
	12.5	11	44	20	2	8	5	10	14	0.8	**38**	–	–	TSS05006	KS1	BC4L	TKY10R	HSC06016

SP○○ type inserts ➤ A180
TP○○ type inserts ➤ A182
SPARE PARTS ➤ Q001

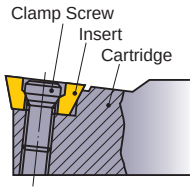
CARTRIDGE

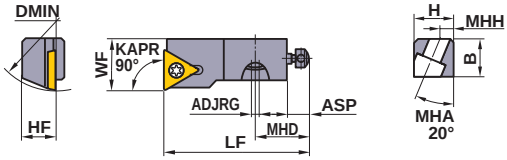
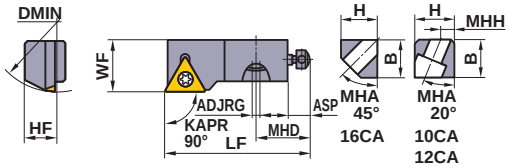
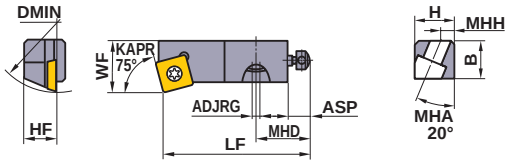
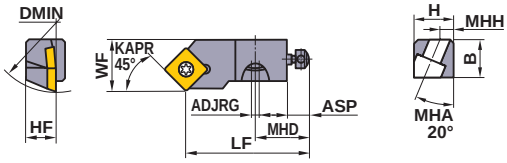
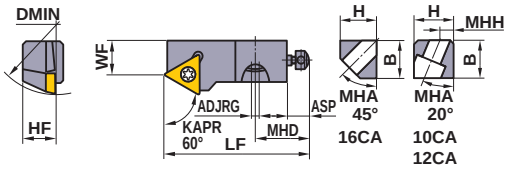
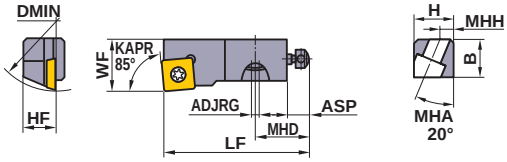
SS ISO type

Screw on type

- **11°positive insert.**
- **Suitable for steel, cast iron, aluminium alloys and copper alloys.**

Screw on type



Type	Order Number	Stock R	Stock L	Geometry	Insert Number	
STFP	STFPR/L10CA11	●	●	 Right hand tool holder shown.	TPMX TPGX	1103○○
	STFPR/L12CA16	●	●		TPMT TPGX	1603○○
STGP	STGPR10CA11	●		 Right hand tool holder only.	TPMX TPGX	1103○○
	STGPR12CA16	●			TPMT TPGX	1603○○
	STGPR16CA16	●				1603○○
SSKP	SSKPR10CA09	●		 Right hand tool holder only.	SPMT SPGX	0903○○
	SSKPR12CA12	●				1203○○
SSSP	SSSPR10CA09	●		 Right hand tool holder only.		0903○○
	SSSPR12CA12	●				1203○○
STTP	STTPR10CA11	●		 Right hand tool holder only.	TPMX TPGX	1103○○
	STTPR12CA16	●			TPMT TPGX	1603○○
	STTPR16CA16	●				1603○○
SSYP	SSYPR10CA09	●		 Right hand tool holder only.	SPMT SPGX	0903○○
	SSYPR12CA12	●				1203○○

⋆1 Clamp Torque (N • m) : CS300890T=1.0, TS4=3.5, TS5=7.5
Note1) Dimensions shown for insert corner RE (⋆2).

● : **Inventory maintained in Japan.**

■ IDENTIFICATION

S T F P R 10 CA 11

Clamp Structure	
S	Screw On

Insert Shape	
S	Square
T	Triangle

Cutting Angle	
F	90°
G	90°(Off Set)
K	75°
S	45°
T	60°
Y	85°

Insert Clearance	
P	11°

Hand of Tool	
R	Right Hand
L	Left Hand

Cutting Edge Height (mm)	
10	10
12	12
16	16

Tool Type	
CA	ISO A Type Cartridge

Cutting Edge Length (mm)		
Insert Shape		Inscribed Circle
Square	Triangle	
—	11	6.35
09	16	9.525
12	22	12.7

Dimensions(mm)											*1				
H	B	LF	MHD	ADJRG	ASP	MHH	HF	WF	RE *2	DMIN	Clamp Screw	Radial Screw	Axial Screw	Wrench	Set Bolt
12.5	11	50	20	2	8	5	10	14	0.4	**35**	CS300890T	TSS05006	KS1	TKY08F TKY10F	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	TS4	TSS06010	KS1	TKY15F TKY20F	HSC06020
12.5	11	50	20	2	8	5	10	14	0.4	**35**	CS300890T	TSS05006	KS1	TKY08F TKY10F	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	TS4	TSS06010	KS1	TKY15F TKY20F	HSC06020
16	17	63	25	2	8	—	16	25	0.8	**55**	TS4	TSS06012	KS2	TKY15F TKY20F	HBH08025
12.5	11	50	20	2	8	5	10	14	0.8	**35**	TS4	TSS05006	KS1	TKY10F TKY15F	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	TS5	TSS06010	KS1	TKY20F TKY25F	HSC06020
12.5	11	44	20	2	8	5	10	14	0.8	**35**	TS4	TSS05006	KS1	TKY10F TKY15F	HSC06016
15.5	16	47	20	2	8	6	12	20	0.8	**50**	TS5	TSS06010	KS1	TKY20F TKY25F	HSC06020
12.5	11	50	20	2	8	5	10	9	0.4	**35**	CS300890T	TSS05006	KS1	TKY08F TKY10F	HSC06016
15.5	16	55	20	2	8	6	12	13	0.8	**50**	TS4	TSS06010	KS1	TKY15F TKY20F	HSC06020
16	17	63	25	2	8	—	16	15	0.8	**55**	TS4	TSS06012	KS2	TKY15F TKY20F	HBH08025
12.5	11	50	20	2	8	5	10	14	0.8	**35**	TS4	TSS05006	KS1	TKY10F TKY15F	HSC06016
15.5	16	55	20	2	8	6	12	20	0.8	**50**	TS5	TSS06010	KS1	TKY20F TKY25F	HSC06020

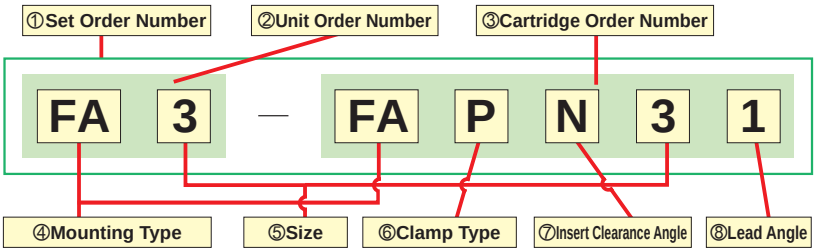
SP○○ type inserts ➤ A159
TP○○ type inserts ➤ A164—A166
SPARE PARTS ➤ Q001

BORING UNIT

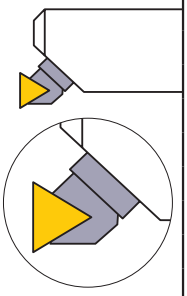
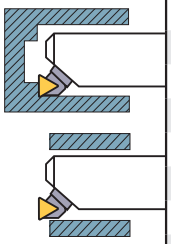
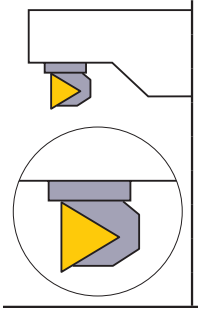
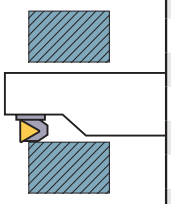
FA,FV

- Precision finish boring unit.
- Facilitates precision adjustment.
- High accuracy.

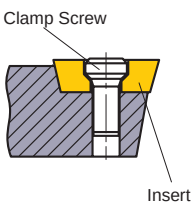
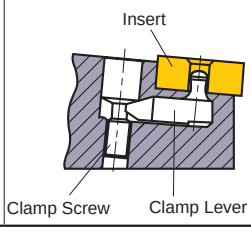
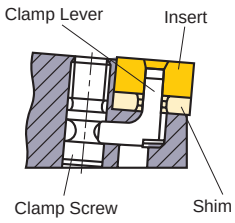
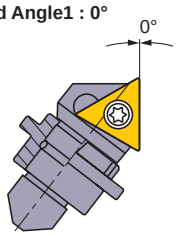
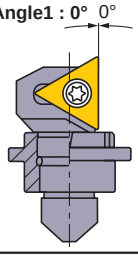
■IDENTIFICATION



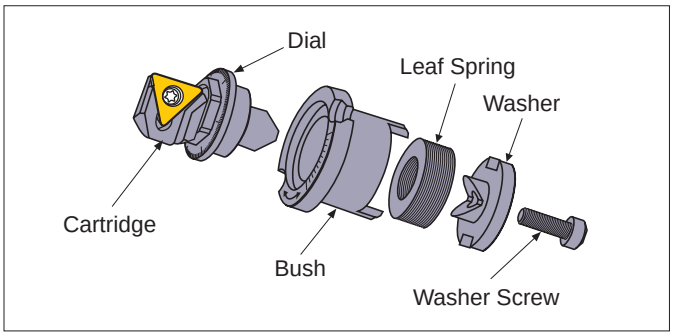
* Sets are delivered with unit and cartridge assembled.

④Mounting Type	Cutting Mode	①Set Order Number *	Stock	②Unit Order Number	Stock	③Cartridge Order Number	Stock	⑤Size		⑥Clamp Type		⑦Insert Clearance Angle	
								Symbol	Min. Cutting Diameter (mm)	Symbol	Type	Symbol	Angle
FA Type (Angular Type) 		FA0-FASC01	●	FA0	●	FASC01	●	0	19	S	Screw On	C	7
		FA0-FASC01S	●	FA0	●	FASC01S	●	0	19	S	Screw On	C	7
		FA1-FASP11	●	FA1	●	FASP11	●	1	25	S	Screw On	P	11
		FA1-FASP11S	●	FA1	●	FASP11S	●	1	25	S	Screw On	P	11
		FA2-FASP21	●	FA2	●	FASP21	●	2	36	S	Screw On	P	11
		FA2-FASP21S	●	FA2	●	FASP21S	●	2	36	S	Screw On	P	11
		FA2-FAPN21	●	FA2	●	FAPN21	●	2	36	P	Lever Lock	N	0
		FA3-FASP31	●	FA3	●	FASP31	●	3	47	S	Screw On	P	11
		FA3-FASP31S	●	FA3	●	FASP31S	●	3	47	S	Screw On	P	11
		FA3-FAPN31	●	FA3	●	FAPN31	●	3	47	P	Lever Lock	N	0
		FA4-FAPN41	●	FA4	●	FAPN41	●	4	73	P	Lever Lock	N	0
FV Type (Vertical Type) 		FV0-FVSC01	●	FV0	●	FVSC01	●	0	19	S	Screw On	C	7
		FV0-FVSC01S	●	FV0	●	FVSC01S	●	0	19	S	Screw On	C	7
		FV1-FVSP11	●	FV1	●	FVSP11	●	1	25	S	Screw On	P	11
		FV1-FVSP11S	●	FV1	●	FVSP11S	●	1	25	S	Screw On	P	11
		FV2-FVSP21	●	FV2	●	FVSP21	●	2	36	S	Screw On	P	11
		FV2-FVSP21S	●	FV2	●	FVSP21S	●	2	36	S	Screw On	P	11
		FV2-FVPN21	●	FV2	●	FVPN21	●	2	36	P	Lever Lock	N	0
		FV3-FVSP31	●	FV3	●	FVSP31	●	3	47	S	Screw On	P	11
		FV3-FVSP31S	●	FV3	●	FVSP31S	●	3	47	S	Screw On	P	11
		FV3-FVPN31	●	FV3	●	FVPN31	●	3	47	P	Lever Lock	N	0
		FV4-FVPN41	●	FV4	●	FVPN41	●	4	73	P	Lever Lock	N	0

* "S" at the end of the order number indicates left hand tool.

⑥Cartridge Clamp Structure			⑧Lead Angle	
S (Screw-on Type)	**P** (Lever Lock Type)	**P** (Lever Lock Type with Shim)	**FA**	**FV**
Applicable Size : 0,1,2,3 	**Applicable Size : 2,3** 	**Applicable Size : 4** 	**Lead Angle1 : 0°** 	**Lead Angle1 : 0°** 

● : Inventory maintained in Japan.



BORING UNIT SPARE PARTS

Unit Order Number	Washer Screw	Unit Screw	Wrench	Bush	Washer	Leaf Spring
FA0	HSC02006	S1	HKY15R	The parts above are not sold separately as accuracy can only be guaranteed by having the complete set. Please contact us for questions about parts replacement.		
FV0	HSC02006	S1	HKY15R			
FA1	HSC02506	HY-A1	HKY20R			
FV1	HSC02506	HY-V1	HKY20R			
FA2	HSC03010	HY2	HKY20R,HKY25R			
FV2	HSC03010	HY2	HS-N2,HKY25R			
FA3	HSC04012	HY3	HKY20R,HKY30R			
FV3	HSC04012	HY3	HKY20R,HKY30R			
FA4	HSC05016	HY4	HKY30R,HKY40R			
FV4	HSC05016	HY4	HKY30R,HKY40R			

CARTRIDGE SPARE PARTS

Cartridge ⋆1	Clamp Lever	Lever Spring	Clamp Screw ⋆3	Shim	Shim Pin	Spanner ⋆2	Wrench	Applicable Insert	
FASC01(S)	–	–	① TS2	–	–	HR00	① TKY06F	TCGT..L-F TCGW	060102 060104
FVSC01(S)	–	–	① TS2	–	–	HR00	① TKY06F		
FASP11(S)	–	–	① CS250T	–	–	HR12	① TKY08F	TPGX TPGX..L/R TPMX..L/R	090204
FVSP11(S)	–	–	① CS250T	–	–	HR12	① TKY08F		
FASP21(S)	–	–	① CS300890T	–	–	HR12	① TKY08F		110304 110308
FVSP21(S)	–	–	① CS300890T	–	–	HR12	① TKY08F		
FAPN21	LLCL12S	HLS1	② LLCS103	–	–	HR12	② HKY20F	TNGA TNGG..L/R	110304 110308
FVPN21	LLCL12S	HLS1	② LLCS103	–	–	HR12	② HKY20F		
FASP31(S)	–	–	① CS300890T	–	–	HR34	① TKY08F	TPGX TPGX..L/R TPMX..L/R	110304 110308
FVSP31(S)	–	–	① CS300890T	–	–	HR34	① TKY08F		
FAPN31	LLCL12S	HLS1	② LLCS103	–	–	HR34	② HKY20F	TNGA TNGG..L/R	110304 110308
FVPN31	LLCL12S	HLS1	② LLCS103	–	–	HR34	② HKY20F		
FAPN41	LLCL13	–	② LLCS106	LLSTN32	LLP13	HR34	② HKY25F		160404 160408 160412
FVPN41	LLCL13	–	② LLCS106	LLSTN32	LLP13	HR34	② HKY25F		

Note 1) Use left hand inserts in the cartridge for right hand cutting and right hand inserts in the cartridge for left hand cutting.
⋆1 "S" at the end of the cartridge number indicates left hand.
⋆2 A spanner is only provided when ordered with a set.
⋆3 Clamp Torque (N • m) : TS2=0.6, CS250T=1.0, CS300890T=1.0, LLCS103=1.5, LLCS106=2.2

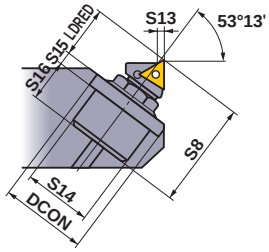
INSERTS

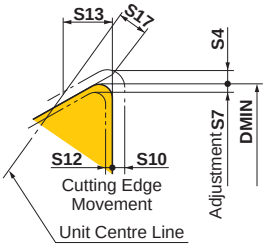
Finish Cutting			Medium Cutting	Flat Top	
TCGT..L/R-F	TPGX..L/R	TPMX..L	TNGG..L/R	TPGX	TNGA
(06) ➲A160	(09,11) ➲A165	(09,11) ➲A165	(11,16) ➲A125	(09,11) ➲A166	(11,16) ➲A127

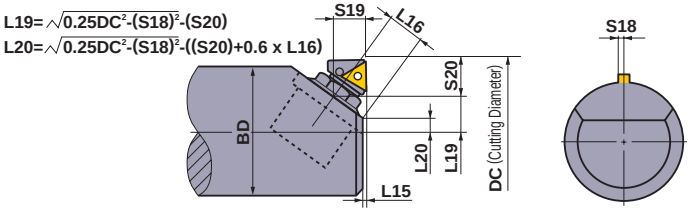
BORING UNIT

MAIN DIMENSIONS

●FA TYPE (ANGULAR TYPE)





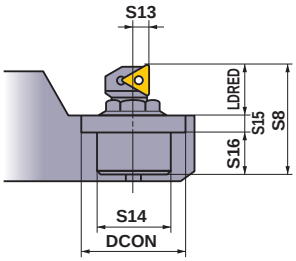


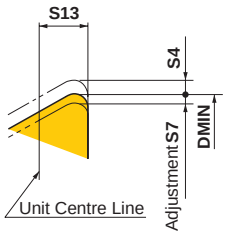
Clockwise (right hand) tool shown.
Minimum cutting diameters (DMIN) correspond to RE0.2 (0 type) and RE0.4 (1—4 type).
Unit : mm

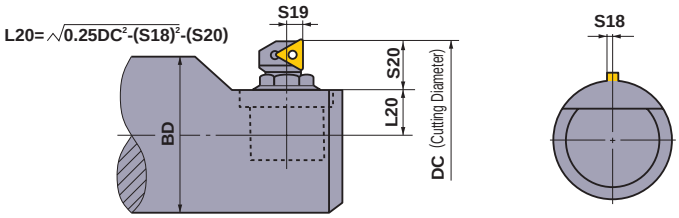
Set Order Number *1	*2 RE	DMIN	Adjustment		Dimensions (mm)															BD
			S4	S7	LDRED	S8	S10	S12	S13	S14	DCON	S15	S16	S17	S18	S19	S20	L15	L16	Max.
FA0-FASC01(S)	0.2	19	0.32	0.16	9.0	19.9	0.30	0.12	1.5	11.11	15.06	2.7	8.2	1.11	1.2	6.4	6.5	1.0	6.8	DC-2
	0.4	19	0.32	0.16	8.8	19.7	0.30	0.12	1.6	11.11	15.06	2.7	8.2	1.11	1.2	6.4	6.4	1.0	6.8	DC-2
FA1-FASP11(S)	0.4	25	0.5	0.3	11.7	23.9	0.38	0.23	0.8	15.08	19.05	3.2	9.0	0.46	1.0	7.6	9.1	0.9	8.4	DC-2
FA2-FASP21(S)	0.4	36	0.7	0.4	14.9	33.4	0.53	0.30	1.1	19.05	24.58	4.0	14.5	0.7	1.2	9.7	11.5	0.8	11.1	DC-2
	0.8	36	0.7	0.4	14.5	33.0	0.53	0.30	1.3	19.05	24.58	4.0	14.5	0.7	1.2	9.7	11.2	0.8	11.1	DC-2
FA2-FAPN21	0.4	36	0.7	0.4	14.9	33.4	0.53	0.30	1.1	19.05	24.58	4.0	14.5	0.7	2.75	9.7	11.5	0.8	11.1	DC-2
	0.8	36	0.7	0.4	14.5	33.0	0.53	0.30	1.3	19.05	24.58	4.0	14.5	0.7	2.75	9.7	11.2	0.8	11.1	DC-2
FA3-FASP31(S)	0.4	47	1.0	0.6	18.35	42.85	0.75	0.45	0.9	22.225	31.75	4.8	19.7	0.54	1.9	11.7	14.4	1.2	13.1	DC-3
	0.8	47	1.0	0.6	17.95	42.45	0.75	0.45	1.1	22.225	31.75	4.8	19.7	0.54	1.9	11.7	14.1	1.2	13.1	DC-3
FA3-FAPN31	0.4	47	1.0	0.6	18.35	42.85	0.75	0.45	0.9	22.225	31.75	4.8	19.7	0.54	3.21	11.7	14.4	1.2	13.1	DC-3
	0.8	47	1.0	0.6	17.95	42.45	0.75	0.45	1.1	22.225	31.75	4.8	19.7	0.54	3.21	11.7	14.1	1.2	13.1	DC-3
FA4-FAPN41	0.4	73	1.5	0.7	28.0	65.4	1.13	0.53	1.3	31.75	46.02	6.4	31.0	0.86	5.2	17.7	21.9	1.3	20.5	DC-3
	0.8	73	1.5	0.7	27.6	65.0	1.13	0.53	1.5	31.75	46.02	6.4	31.0	0.86	5.2	17.7	21.6	1.3	20.5	DC-3
	1.2	73	1.5	0.7	27.2	64.6	1.13	0.53	1.7	31.75	46.02	6.4	31.0	0.86	5.2	17.7	21.3	1.3	20.5	DC-3

*1 "S" at the end of the order number indicates left hand tool.
*2 Dimensions shown for insert corner RE 0.2, 0.4, 0.8, and 1.2.

●FV TYPE (VERTICAL TYPE)







Clockwise (right hand) tool shown.
Minimum cutting diameters (DMIN) correspond to RE0.2 (0 type) and RE0.4 (1—4 type).
Unit : mm

Set Order Number *1	*2 RE	DMIN	Adjustment		Dimensions (mm)										BD
			S4	S7	LDRED	S8	S13	S14	DCON	S15	S16	S18	S19	S20	Max.
FV0-FVSC01(S)	0.2	19	0.4	0.2	7.6	18.5	2.6	11.11	15.06	2.7	8.2	1.2	2.6	7.6	DC-2
	0.4	19	0.4	0.2	7.4	18.3	2.6	11.11	15.06	2.7	8.2	1.2	2.6	7.4	DC-2
FV1-FVSP11(S)	0.4	25	0.7	0.3	10.8	23.0	3.6	15.08	20.62	3.2	9.0	1.0	3.6	10.8	DC-2
FV2-FVSP21(S)	0.4	36	0.8	0.6	13.8	32.3	4.0	19.05	24.58	4.0	14.5	1.2	4.0	13.8	DC-2
	0.8	36	0.8	0.6	13.5	32.0	4.0	19.05	24.58	4.0	14.5	1.2	4.0	13.5	DC-2
FV2-FVPN21	0.4	36	0.8	0.6	13.8	32.3	4.0	19.05	24.58	4.0	14.5	2.1	4.0	13.8	DC-2
	0.8	36	0.8	0.6	13.5	32.0	4.0	19.05	24.58	4.0	14.5	2.1	4.0	13.5	DC-2
FV3-FVSP31(S)	0.4	47	1.3	0.7	16.7	41.2	4.8	22.225	31.75	4.8	19.7	1.9	4.8	16.7	DC-3
	0.8	47	1.3	0.7	16.4	40.9	4.8	22.225	31.75	4.8	19.7	1.9	4.8	16.4	DC-3
FV3-FVPN31	0.4	47	1.3	0.7	16.7	41.2	4.8	22.225	31.75	4.8	19.7	3.21	4.8	16.7	DC-3
	0.8	47	1.3	0.7	16.4	40.9	4.8	22.225	31.75	4.8	19.7	3.21	4.8	16.4	DC-3
FV4-FVPN41	0.4	73	1.8	1.0	25.0	62.4	7.1	31.75	46.02	6.4	31.0	5.2	7.1	25.0	DC-3
	0.8	73	1.8	1.0	24.7	62.1	7.1	31.75	46.02	6.4	31.0	5.2	7.1	24.7	DC-3
	1.2	73	1.8	1.0	24.4	61.8	7.1	31.75	46.02	6.4	31.0	5.2	7.1	24.4	DC-3

*1 "S" at the end of the order number indicates left hand tool.
Note1) Dimensions shown for insert corner RE (*2).

MI TYPE BORING BARS

■ IDENTIFICATION

S	B	R	1	08
①	②	③	④	⑤

①Clamp Type	
S	Screw On Type

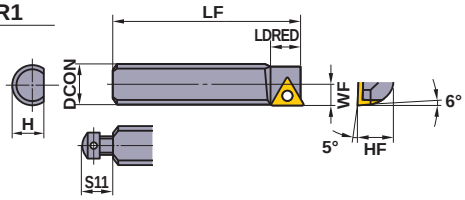
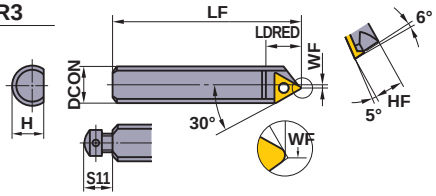
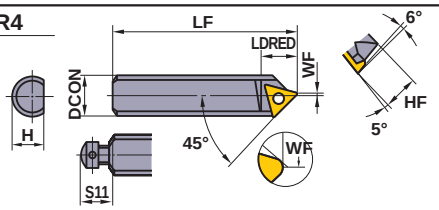
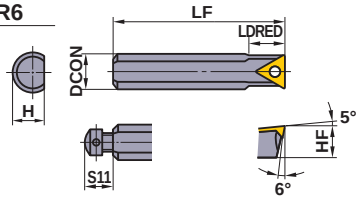
②Boring Bar Name

③Shank Shape	
R	Round Shank

④Lead Angle	
1	0°
3	30°
4	45°
6	90°

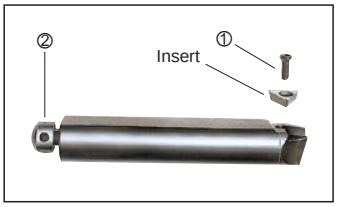
⑤Shank Size (mm)	
08	8
10	10
12	12
16	16

STANDARD HOLDER

Geometry	Order Number	Stock (For Clockwise)	Insert Number *1		H	DCON	LF	LDRED	S11	HF	WF	RE *2
SBR1 	SBR108	●	TPGX TPGX...L TPMX...L	0802○○	7	8	35	9	—	7	3.5	0.4
	SBR110	●		0902○○	9	10	50	11	—	8	4.5	0.4
	SBR112	●		1103○○	10	12	60	12	7	10	5.0	0.4
SBR3 	SBR308	●	TPGX TPGX...L TPMX...L	0802○○	7	8	35	10	—	7	0.7	0.4
	SBR310	●		0902○○	9	10	50	12	—	8	1.0	0.4
	SBR312	●		1103○○	10	12	60	13	7	10	1.0	0.4
SBR4 	SBR408	●	TPGX TPGX...L TPMX...L	0802○○	7	8	35	10	—	7	0.5	0.4
	SBR410	●		0902○○	9	10	50	12	—	8	1.0	0.4
	SBR412	●		1103○○	10	12	60	13	7	10	1.0	0.4
	SBR416	●		1103○○	14	16	80	13	9	14	0	0.8
SBR6 	SBR608	●	TPGX TPGX...L TPMX...L	0802○○	7	8	35	8.5	—	7	—	0.4
	SBR610	●		0902○○	8	10	50	10	—	8	—	0.4
	SBR612	●		1103○○	10	12	60	11	7	10	—	0.4

⁎1 When using an insert with a breaker, please use a left hand insert.
Note1) Dimensions shown for insert corner RE (⁎2).

SPARE PARTS



Order Number		①Clamp Screw	②Pre-Set Screw	Wrench
SBR1 – SBR6	08	CS200T	—	TKY06F
	10	CS250T	—	TKY08F
	12	CS300890T	KS1S	TKY08F
	16	CS300890T	KS2S	TKY08F

⁎ Clamp Torque (N • m) : CS200T=0.6, CS250T=1.0, CS300890T=1.0

● : **Inventory maintained in Japan.**

TP○○ type inserts	➤ A164—A166
SPARE PARTS	➤ Q001

CLASSIFICATION OF QUICK CHANGE MODULAR TOOLING SYSTEM

Mitsubishi's quick change system is a must for improving efficiency in mass production lines.

- Shorten tool change times and increase machine efficiency.
- Reduce tool weight. Thus, tool change is safer and easier.
- Improve cutting edge accuracy.

Face Mill and Pin Milling Cutter

QF1000 (Two Piece)

QF2000 (Small Diameter)

QF2000 (Large Diameter)

QC TYPE ADAPTER FOR PIN MILLING CUTTER

QS2000 (Arbor for Side Cutter)

MITSUBISHI's QUICK CHANGE SYSTEM

Boring Tool

QB2000 • QB3000

QB4000

Connecting System

ABS License KOMET®

HSK

Special Tooling

SPQH (Spring)

SPQS (Spring+Oil pressure)

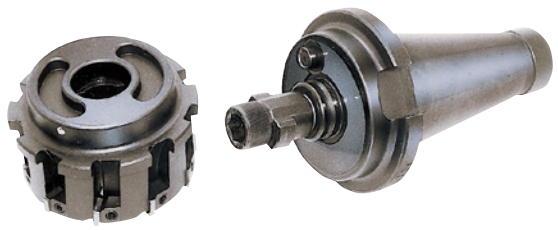
Setting Fixture

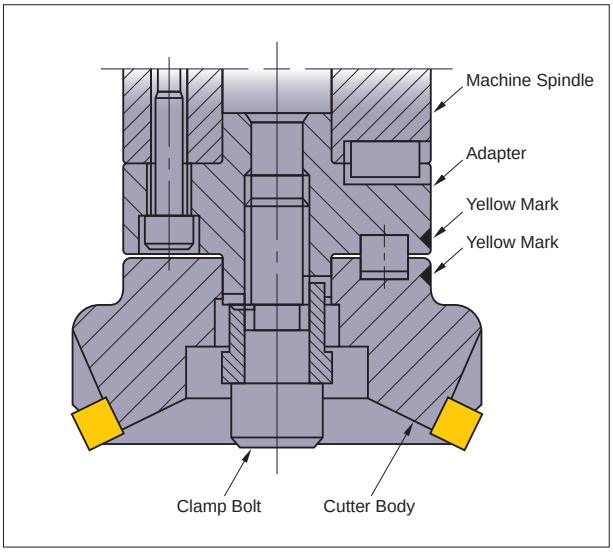
Setting Gauge

FACE MILL

QF2000 (SINGLE BOLT MOUNTING TYPE)

●One Piece Type (≤ϕ160)

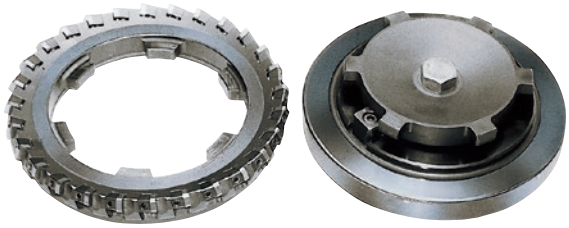


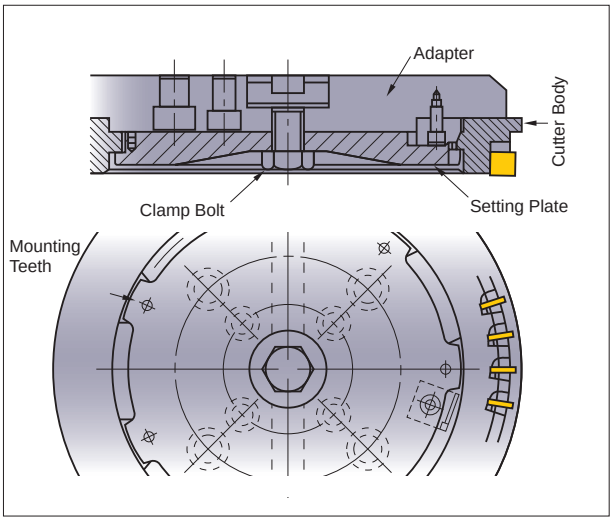


FEATURES

1. Simply turning a clamp bolt fixed to the adapter a few times enables cutter exchange.
2. The cutter needs to be turned 90° before removal. This prevents the cutter from falling free.
3. Applicable to both face milling and boring tools.
4. Cutter exchange time is less than 1 min.

●Two Piece Type (≥ϕ200)





FEATURES

1. Internal diameter of the cutter body has 4—6 mounting teeth. The adapter has the same mounting teeth and a single clamp bolt for installation.
2. The cutter needs to be turned 15° before removal. This prevents the cutter from falling free.
3. Cutter exchange time is less than 1 min.

QF1000 (GOURD SHAPED HOLE TYPE)

●One Piece Type (O Type ϕ200)

●Two Piece Type (T Type ≥ϕ250)

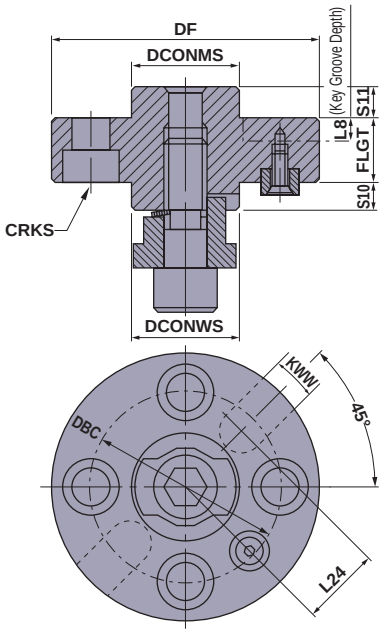
FEATURES

1. Gourd shaped hole type is employed. Turning 4—6 bolts enables cutter exchange.
2. The cutter needs to be turned 15° before removal. This prevents the cutter from falling free.
3. Cutters with ≥ø250 are made up of 2 parts. Thus, weight at the time of installation is reduced and safety is improved.
4. Standard adapters facilitate installation of cutters with the same diameter and different insert shapes.
5. Cutter exchange time is less than 3—5 min.

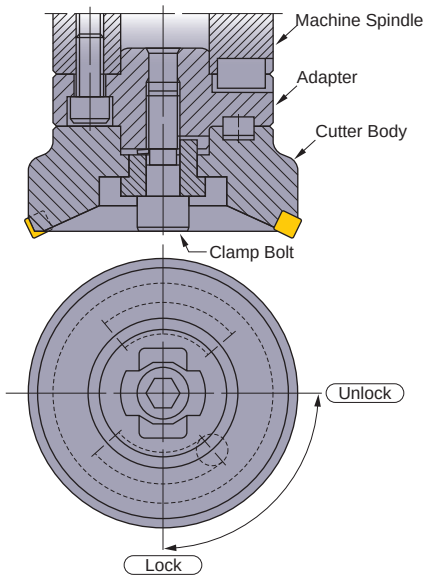
FACE MILLING ADAPTER

Q TYPE (SINGLE BOLT TYPE) φ80—φ160

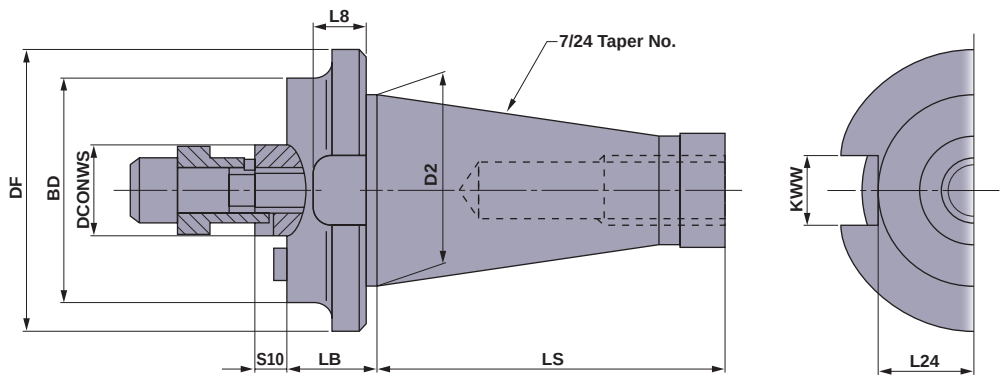
●Standard



●Installed Condition



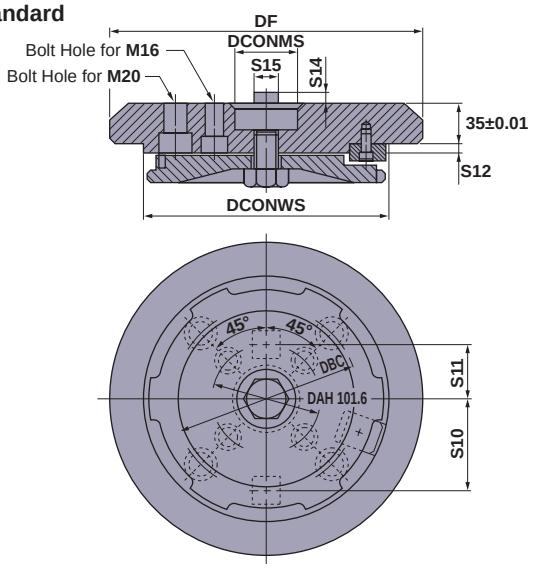
Order Number	Cutter Diameter (DC)	Cutter Dimensions (mm)			Machine Dimensions (mm)								Tool Weight
		DF	DCONWS	FLGT	DCONMS	DBC	CRKS	KWW	L8	L24	S10	S11	(kg)
QFA08025BCR/L	80	70	25.4	25	25.4	45	M12	9.5	7	18.4	13	15	0.8
QFA10025BDR/L	100	80	31.75	25	31.75	55	M16	12.7	8	23.2	13	15	1.2
QFA12530BER/L	125	100	38.1	30	38.1	70	M20	15.9	10	28	13	15	2.1
QFA16030BFR/L	160	125	50.8	30	50.8	85	M20	19	11	36	13	15	3.2



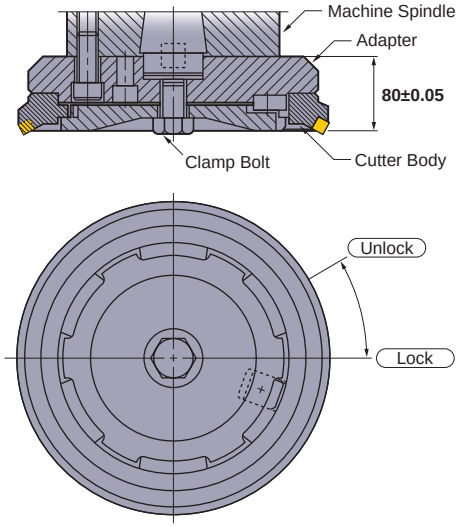
Order Number	Cutter Diameter (DC)	Cutter Dimensions (mm)			Machine Dimensions (mm)								Tool Weight
		BD	DCONWS	LB	DF	No.	D2	LS	KWW	L8	L24	S10	(kg)
QFA08025N4R/L	80	70	25.4	25	70	40	44.45	93.4	16.1	16	22.5	13	1.4
QFA10025N4R/L	100	80	31.75	25	80	40	44.45	93.4	16.1	16	22.5	13	1.7
QFA12530N4R/L	125	100	38.1	30	100	40	44.45	93.4	16.1	16	22.5	13	2.7
QFA16030N4R/L	160	125	50.8	30	125	40	44.45	93.4	16.1	16	22.5	13	3.8
QFA08025N5R/L	80	70	25.4	25	100	50	69.85	126.8	25.7	19	35.3	13	3.2
QFA10025N5R/L	100	80	31.75	25	100	50	69.85	126.8	25.7	19	35.3	13	3.4
QFA12530N5R/L	125	100	38.1	30	100	50	69.85	126.8	25.7	19	35.3	13	4.0
QFA16030N5R/L	160	125	50.8	30	125	50	69.85	126.8	25.7	19	35.3	13	5.1

Q TYPE (SINGLE BOLT TYPE) φ200−φ500

●Standard



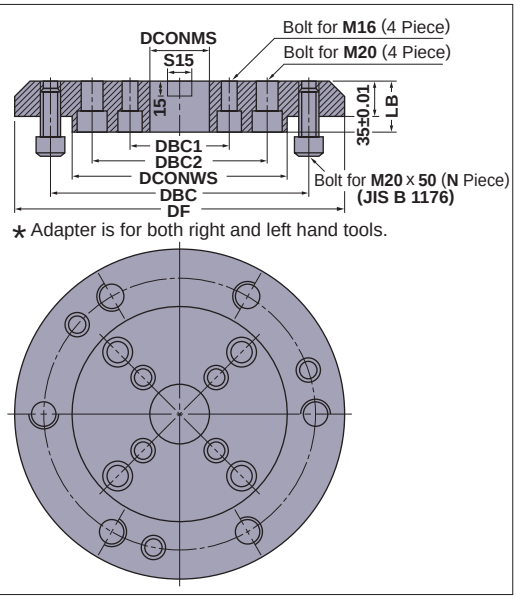
●Installed Condition



Order Number	Cutter Diameter (DC)	Cutter Dimensions (mm)		Machine Dimensions (mm)							Tool Weight (kg)
		DCONWS	DF	DCONMS	DBC	S10	S11	S12	S14	S15	
QFB20035KR/L	200	125	190	47.625	—	—	50.8	10	11	25.4	9
QFB25035KR/L	250	175	240	47.625	—	—	50.8	10	11	25.4	16
QFB31535PR/L	315	240	305	47.625	177.8	88.9	50.8	10	11	25.4	28
QFB35535PR/L	355	280	345	47.625	177.8	88.9	50.8	10	11	25.4	37
QFB40035PR/L	400	325	390	47.625	177.8	88.9	50.8	10	11	25.4	49
QFB50035PR/L	500	425	490	47.625	177.8	88.9	50.8	10	11	25.4	83

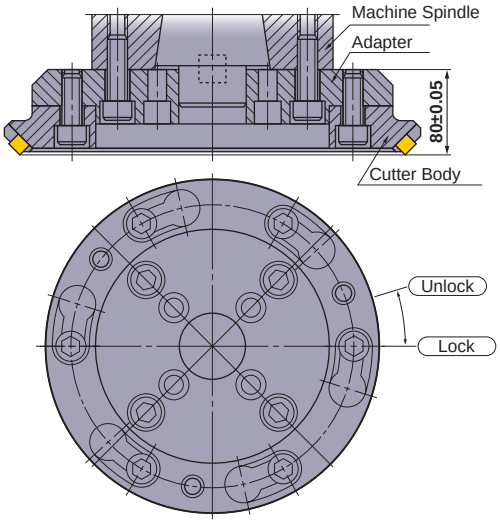
T TYPE (SIX BOLT TYPE) φ250−φ400

●Standard



* Adapter is for both right and left hand tools.

●Installed Condition



Order Number	Cutter Diameter (DC)	Cutter Dimensions (mm)					Machine Dimensions (mm)				Tool Weight (kg)
		DCONWS	DBC	DF	LB	N	DCONMS	DBC1	DBC2	S15	
QFA25035K	250	110	155	230	45	4	47.625	101.6	—	25.4	9
QFA31535P	315	175	220	295	50	6	47.625	101.6	177.8	25.4	16
QFA35535P	355	215	260	335	50	6	47.625	101.6	177.8	25.4	22
QFA40035P	400	260	305	380	50	6	47.625	101.6	177.8	25.4	29

SIDE CUTTER

QC TYPE ADAPTER FOR PIN MILLING CUTTER

●Cutter Body

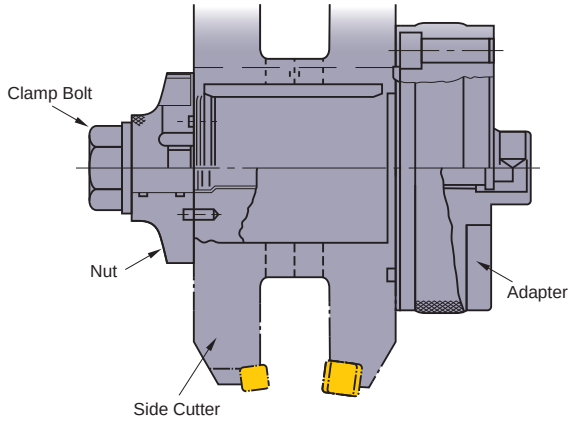
●Adapter Body

■FEATURES

1. Makes installation of Pin millng cutter easy, quick, and accurate.
2. Clamping the entire periphery of the cutter body improves rigidity and lateral run-out of the cutting edges.
3. Facilitates stable heavy cutting such as counter weight cutting and prevents sudden insert fracture.

QS2000 (INSTALLATION METHOD FOR SIDE CUTTER)

●Appearance

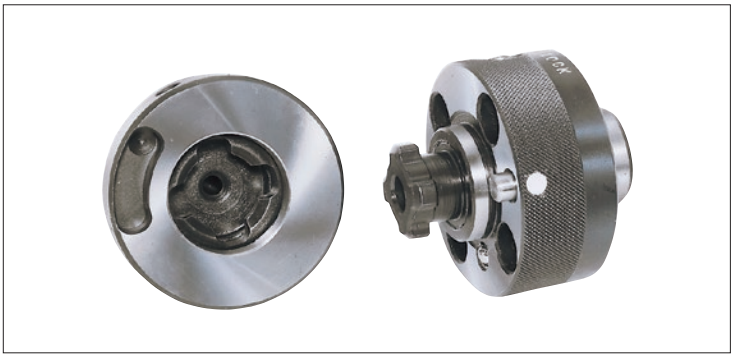


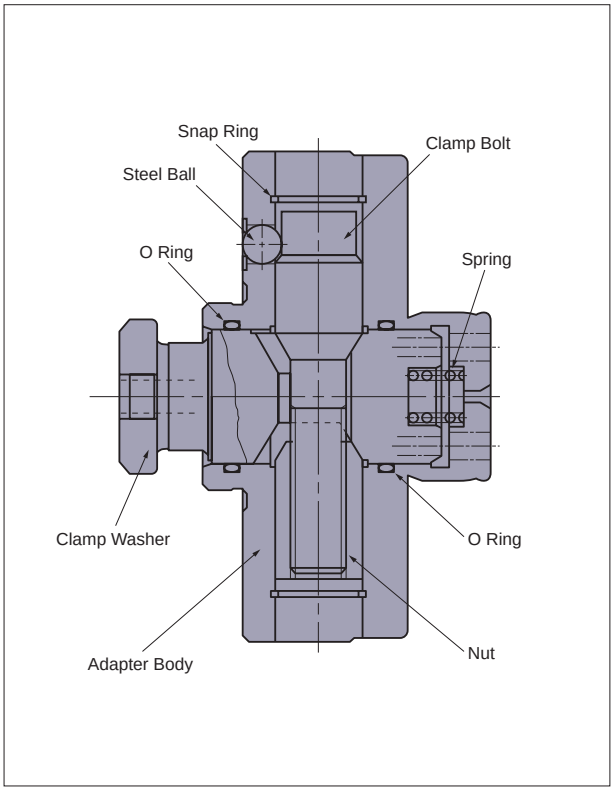
■FEATURES

1. Turning the bolt a few times turns nut 45° and enables installation and detachment of the cutter.
2. Installation and detachment of the cutter is possible without taking the bolt and nut off the adapter.
3. The cutter is a solid type. Thus, the rigidity is high.
4. Cutter exchange time is less than 1 min.

BORING TOOL

QB4000 TYPE (SIDE CLAMP TYPE)

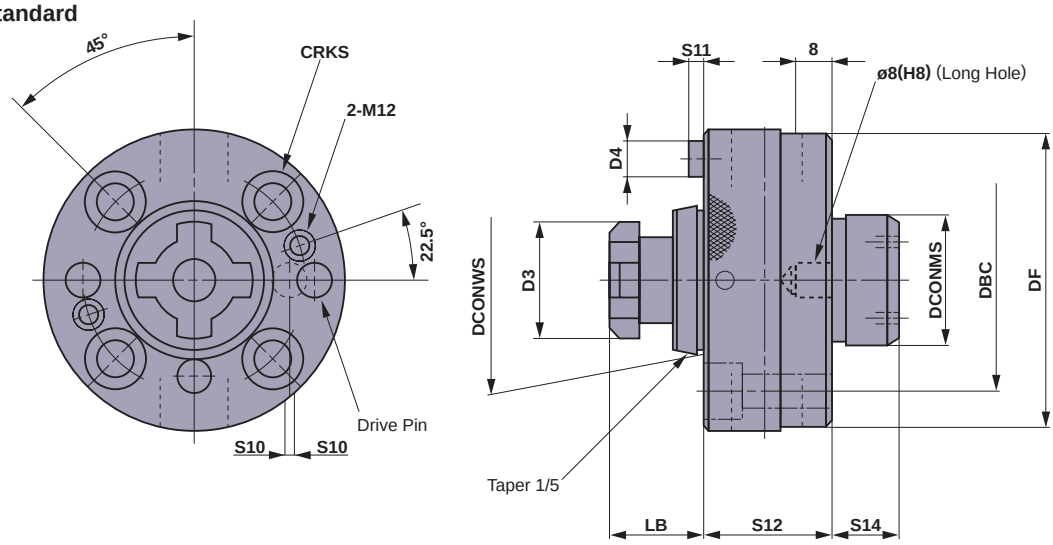




FEATURES

1. Tightening the clamp bolt (or clamp nut) draws the clamp washer in and securely holds the boring head.
2. The clamp washer has mounting teeth at the end. Turning the clamp washer 45° enables installation and detachment of the boring head.
3. Both 1/5 taper and cutter locating faces support the boring head. Thus, clamp rigidity and installation repeatability accuracy are high (2–3μm).
4. A side clamp structure is employed. Thus, a spindle turning stopper is unnecessary. This structure prevents the boring head from falling free.
5. Insert location close to the adapter body allows for convenient head exchange.
6. Suitable for a wide range of boring, from small to large diameters.
7. Head exchange time is less than 1 min.

●Installation Standard



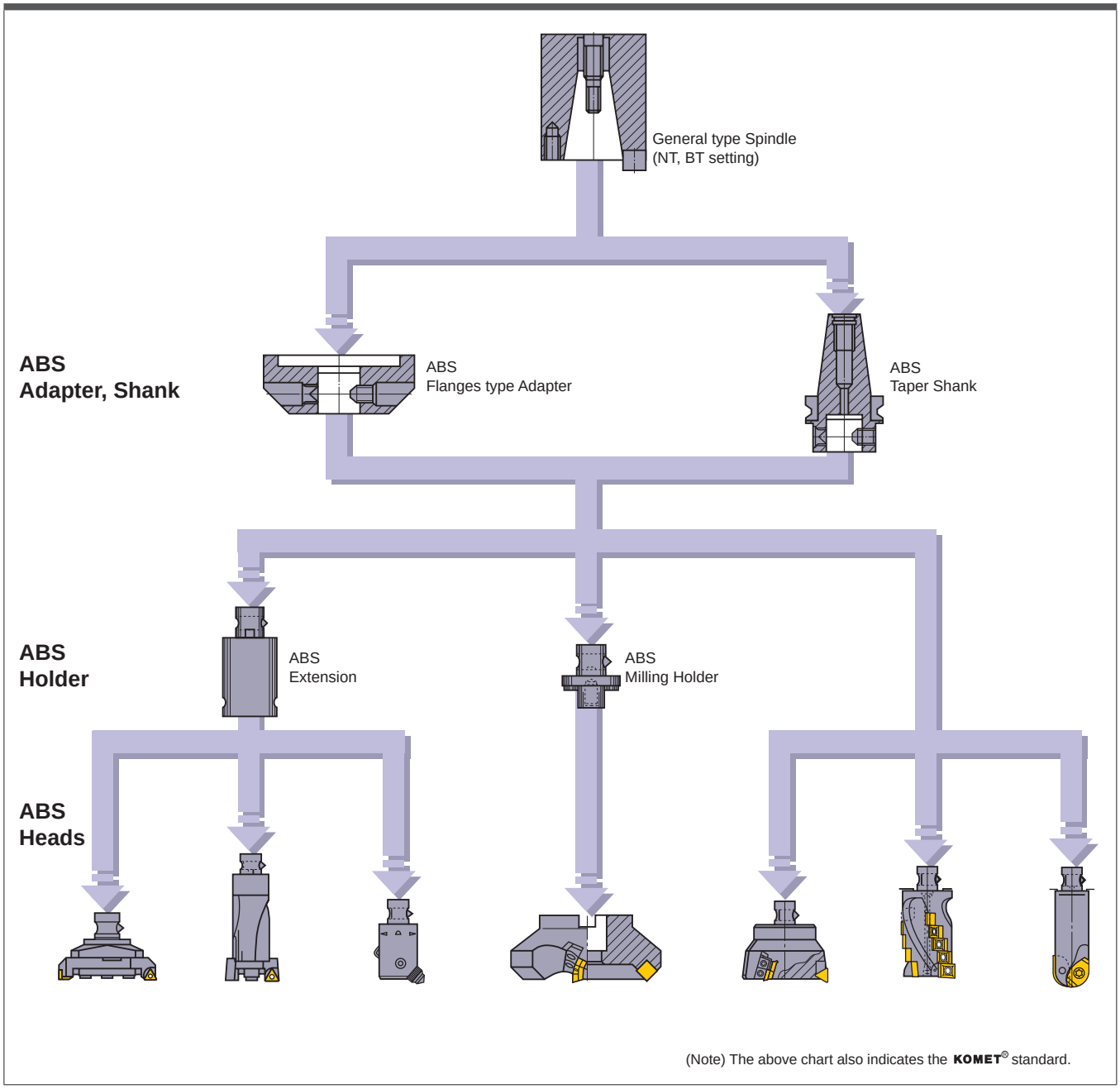
Order Number	Dimensions(mm)											
	DCONWS	DCONMS	DF	D3	DBC	CRKS	LB	D4	S10	S11	S12	S14
QB4350070	35	30	70	28	52	M8	22	8	0.5	5	30	15
QB4350088	35	30	88	28	70	M8	22	8	0.5	5	30	15
QB4400098	40	30	98	34	80	M8	24	8	0.5	5	30	15
QB4400118	40	30	118	34	90	M10	24	10	0.5	5	30	15
QB4500138	50	40	138	42	110	M12	30	12	0.5	5	30	15

ABS® License KOMET®

ABS SYSTEM CHARACTERISTIC

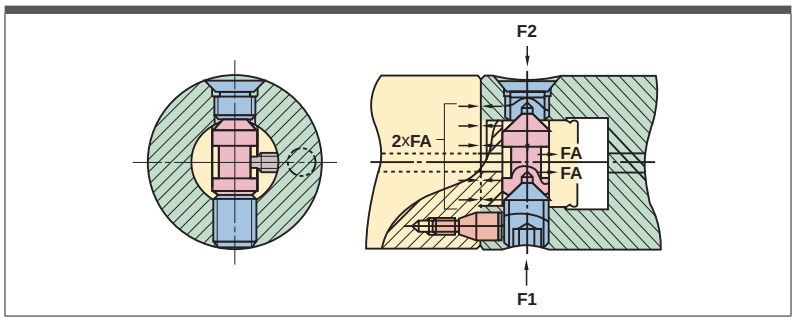
- High rigidity and high coupling strength.
  The taper wedge effects produced by the clamping screw, the taper screw, and the slide pin enable strong and firm coupling between the head and the adapter.
- As the cutting torque acts as torsion force on the axis, 50—80% improvement is achieved for the clamping strength in the coupled portion axis direction.
- High accuracy is guaranteed.
  An attachment repeat accuracy of 2—3μm is constantly maintained in the coupled portion.
- From small (ϕ20) diameter to large diameter (ϕ200), a wide range of tooling is possible.
- Internal passage of the coolant (air) is possible without modifications to standard machinary.
- Tool head extensions are easy through the use of extension pieces.
- Through the use of reducers, tool head diameters are easily set.

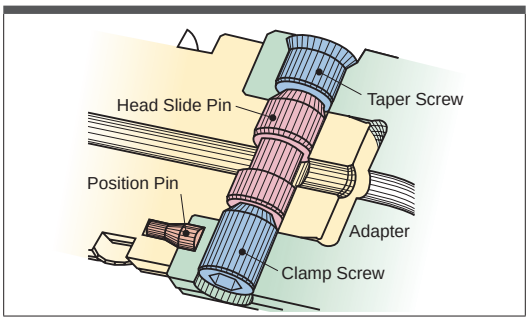
ABS SYSTEM MECHANISM



(Note) The above chart also indicates the KOMET® standard.

ABS SYSTEM COMPONENT

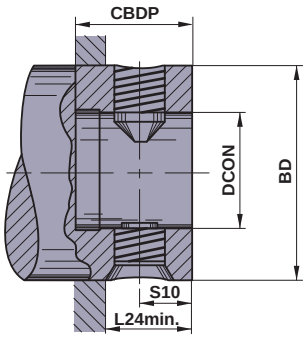




When the force F1 presses on the clamping screw, the slide pin moves in the radial direction and impinges on the taper screw, generation the reaction force F2. Since the centers of the clamping screw, the taper screw, and the slide pin are eccentric, a taper connection is made at sites separated by a 180° phase, with the clamping screw and the slide pin on the taper right impingement portion, and the slide pin and taper pin on the taper left impingement portion. The result is that, a vector analysis of those forces shows, as depicted in the diagram above, that the slides move in an identical direction, and the coupling force FA is doubled and transmitted accordingly. Further, cutting resistance generated during cutting becomes torsion stress and is transmitted accordingly. The forces F1 and F2 generated with the clamping screw and taper screw are expanded, and the coupling (jointing) force FA becomes as even greater force, and is generated accordingly.

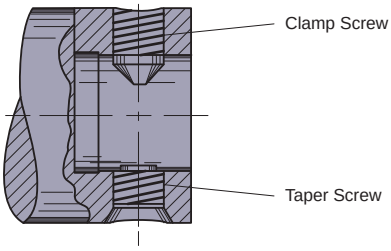
⋆ This system is licensed from KOMET© of Germany. (JP Patent NO.1328669)

ABS SYSTEM SETTING STANDARDS Adapter Dimensions



Order Number	Dimensions(mm)				
	BD	DCON	CBDP	L24	S10
ABS25W	25	13	22	13	8.3
ABS32W	32	16	25	16	10.3
ABS40W	40	20	30	18.5	11.3
ABS50W	50	28	34	22	13.3
ABS63W	63	34	41	28	17.4
ABS80W	80	46	48	34	20.4
ABS100W	100	56	58	40.5	24.4
ABS125W	125	70	76	51	30.5

●Parts for Adapter

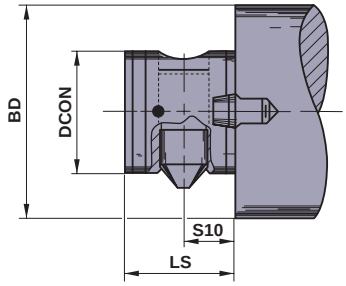


Pack Order Number ⋆	Stock	Clamp Screw	Taper Screw
ABS25-FS-W	●	ABS25-F1	ABS25-F2
ABS32-FS-W	●	ABS32-F1	ABS32-F2
ABS40-FS-W	●	ABS40-F1	ABS40-F2
ABS50-FS-W	●	ABS50-F1	ABS50-F2
ABS63-FS-W	●	ABS63-F1	ABS63-F2
ABS80-FS-W	●	ABS80-F1	ABS80-F2
ABS100-FS-W	●	ABS100-F1	ABS100-F2
ABS125-FS-W	●	ABS125-F1	ABS125-F2

⋆ An order of the above type of screw and pin needs to be included in the set. Please use a "Pack Order Number" for your order.

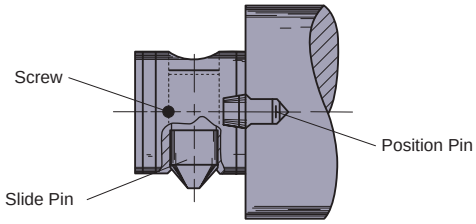
● : Inventory maintained in Japan.

●Head Dimensions



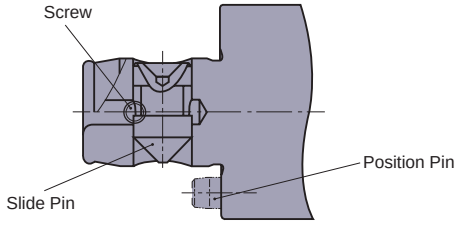
Order Number	Dimensions(mm)			
	BD	DCON	LS	S10
ABS25M	25	13	20	8
ABS32M	32	16	23	10
ABS40M	40	20	26	11
ABS50M	50	28	31	13
ABS63M	63	34	38	17
ABS80M	80	46	43	20
ABS100M	100	56	55	24
ABS125M	125	70	70	30

●Parts for Head



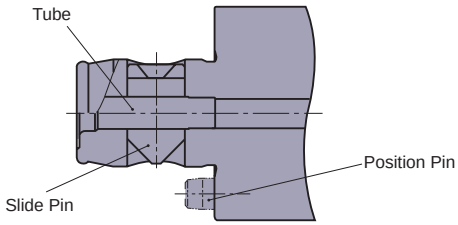
Pack Order Number *	Stock	Slide Pin	Position Pin	Screw
ABS25-ES-M	●	ABS25-E3	ABS25-E4	ABS25-E5
ABS32-ES-M	●	ABS32-E3	ABS32-E4	ABS32-E5
ABS40-ES-M	●	ABS40-E3	ABS40-E4	ABS40-E5
ABS50-ES-M	●	ABS50-E3	ABS50-E4	ABS50-E5
ABS63-ES-M	●	ABS63-E3	ABS63-E4	ABS63-E5
ABS80-ES-M	●	ABS80-E3	ABS80-E4	ABS80-E5
ABS100-ES-M	●	ABS100-E3	ABS100-E4	ABS100-E5
ABS125-ES-M	●	ABS125-E3	ABS125-E4	ABS125-E5

●Parts for Head [For Fine Boring]



Pack Order Number *	Stock	Slide Pin	Position Pin	Screw
ABS25-ES-M1	●	ABS25-E3	ABS25-E4.1	ABS25-E5
ABS32-ES-M1	●	ABS32-E3	ABS32-E4.1	ABS32-E5
ABS40-ES-M1	●	ABS40-E3	ABS40-E4.1	ABS40-E5
ABS50-ES-M1	●	ABS50-E3	ABS50-E4.1	ABS50-E5
ABS63-ES-M1	●	ABS63-E3	ABS63-E4.1	ABS63-E5
ABS80-ES-M1	●	ABS80-E3	ABS80-E4.1	ABS80-E5
ABS100-ES-M1	●	ABS100-E3	ABS100-E4.1	ABS100-E5

●Parts for Head [For Coolant Hole Type]

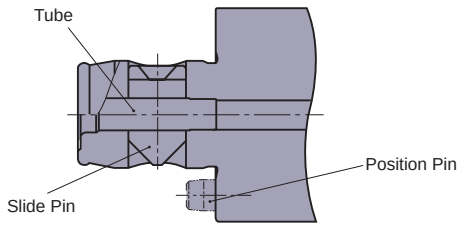


Pack Order Number *	Stock	Slide Pin	Position Pin	Tube
ABS25-ES-M3	●	ABS25-E3.2	ABS25-E4	ABS25-E6
ABS32-ES-M3	●	ABS32-E3.2	ABS32-E4	ABS32-E6
ABS40-ES-M3	●	ABS40-E3.2	ABS40-E4	ABS40-E6
ABS50-ES-M3	●	ABS50-E3.2	ABS50-E4	ABS50-E6
ABS63-ES-M3	●	ABS63-E3.2	ABS63-E4	ABS63-E6
ABS80-ES-M3	●	ABS80-E3.2	ABS80-E4	ABS80-E6
ABS100-ES-M3	●	ABS100-E3.2	ABS100-E4	ABS100-E6
ABS125-ES-M3	●	ABS125-E3.2	ABS125-E4	ABS125-E6

* An order of the above type of screw, pin and tube needs to be included in the set. Please use a "Pack Order Number" for your order.

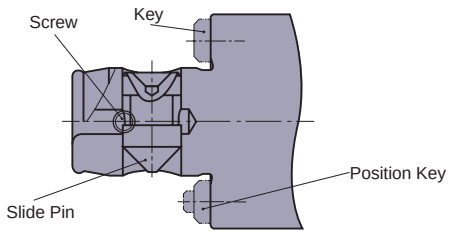
● : Inventory maintained in Japan.

●Parts for Head [For Fine Boring with Coolant Hole]



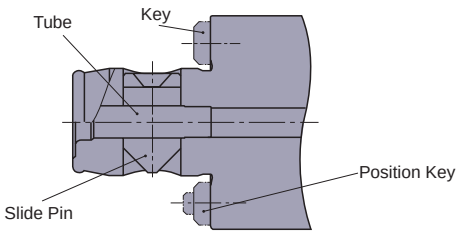
Pack Order Number *	Stock	Slide Pin	Position Pin	Tube
ABS25-ES-M4	●	ABS25-E3.2	ABS25-E4.1	ABS25-E6
ABS32-ES-M4	●	ABS32-E3.2	ABS32-E4.1	ABS32-E6
ABS40-ES-M4	●	ABS40-E3.2	ABS40-E4.1	ABS40-E6
ABS50-ES-M4	●	ABS50-E3.2	ABS50-E4.1	ABS50-E6
ABS63-ES-M4	●	ABS63-E3.2	ABS63-E4.1	ABS63-E6
ABS80-ES-M4	●	ABS80-E3.2	ABS80-E4.1	ABS80-E6
ABS100-ES-M4	●	ABS100-E3.2	ABS100-E4.1	ABS100-E6

●Parts for Head [For Key Type]



Pack Order Number *	Stock	Slide Pin	Key	Position Key	Screw
SBA25-ES-M	●	ABS25-E3	SBA25-E4	SBA25-E4.1	ABS25-E5
SBA32-ES-M	●	ABS32-E3	SBA32-E4	SBA32-E4.1	ABS32-E5
SBA40-ES-M	●	ABS40-E3	SBA40-E4	SBA40-E4.1	ABS40-E5
SBA50-ES-M	●	ABS50-E3	SBA50-E4	SBA50-E4.1	ABS50-E5
SBA63-ES-M	●	ABS63-E3	SBA63-E4	SBA63-E4.1	ABS63-E5
SBA80-ES-M	●	ABS80-E3	SBA80-E4	SBA80-E4.1	ABS80-E5
SBA100-ES-M	●	ABS100-E3	SBA100-E4	SBA100-E4.1	ABS100-E5
SBA125-ES-M	●	ABS125-E3	SBA125-E4	SBA125-E4.1	ABS125-E5

●Parts for Head [For Key Type with Coolant Hole]



Pack Order Number *	Stock	Slide Pin	Key	Position Key	Tube
SBA25-ES-M1	●	ABS25-E3.2	SBA25-E4	SBA25-E4.1	ABS25-E6
SBA32-ES-M1	●	ABS32-E3.2	SBA32-E4	SBA32-E4.1	ABS32-E6
SBA40-ES-M1	●	ABS40-E3.2	SBA40-E4	SBA40-E4.1	ABS40-E6
SBA50-ES-M1	●	ABS50-E3.2	SBA50-E4	SBA50-E4.1	ABS50-E6
SBA63-ES-M1	●	ABS63-E3.2	SBA63-E4	SBA63-E4.1	ABS63-E6
SBA80-ES-M1	●	ABS80-E3.2	SBA80-E4	SBA80-E4.1	ABS80-E6
SBA100-ES-M1	●	ABS100-E3.2	SBA100-E4	SBA100-E4.1	ABS100-E6
SBA125-ES-M1	●	ABS125-E3.2	SBA125-E4	SBA125-E4.1	ABS125-E6

* An order of the above type of screw, pin and tube needs to be included in the set. Please use a "Pack Order Number" for your order.

HSK SYSTEM

FEATURES OF THE HSK SYSTEM

●**Suitable for high speed machining.**

When the taper hole is slightly seperated during high speed machining due to centrifugal force, the taper axis is continuously in contact with the taper hole because of elastic deformation. Thus, 2 face holding is maintained.

●**Guaranteed high accuracy.**

Installation repeatability of 2μm is guaranteed.

●**High rigidity.**

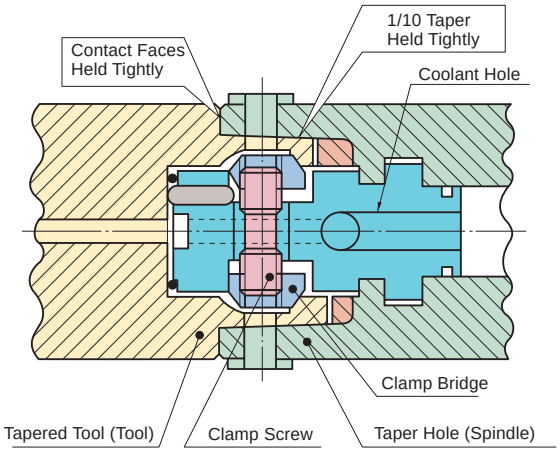
High rigidity in the radial and thrust direction due to the 2 face holding system.

●**Easy installation.**

Detachable support structure ensures separation of the tool even when the tool has undergone thermal expansion.

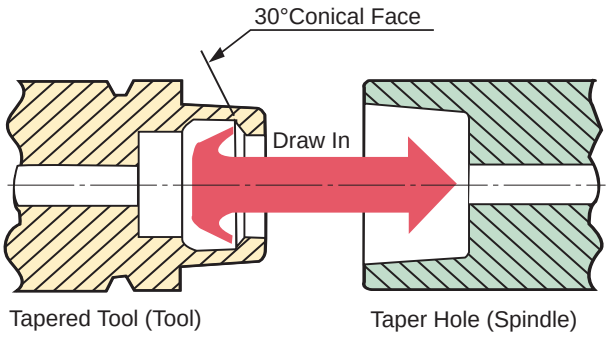
●**Coolant system selection.**

Centre coolant and anglar flow coolant type.



* HSK stands for Hole (Hollow) Schaft (axis) Kegel (taper) in German.

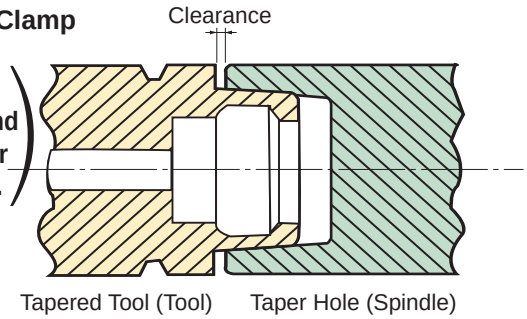
HSK CLAMPING METHOD



●The 30°conical face of the taper axis is pulled in the direction of the tapered hole to clamp.

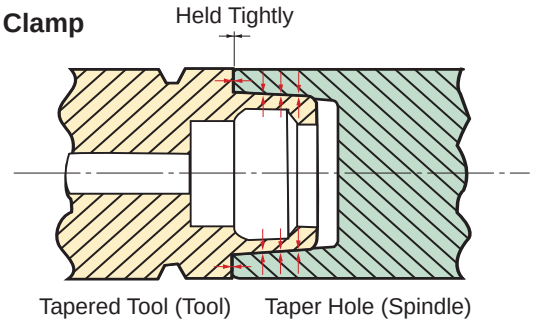
●**Temporary Clamp Position**

(The spindle taper face and the tool taper face contact.)



●Temporary clamp position has a clearance between the spindle and the tool contact faces.
●Taper clamping force increases as the diameter increases.

●**Permanent Clamp Position**



●Hollow thin taper axis holds the taper faces and the contact faces tightly due to pressurized elastic deformation.

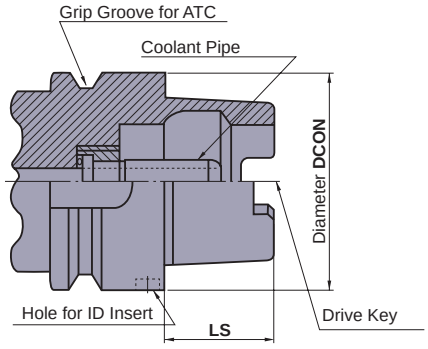
HSK SYSTEM FORM

There are various HSK types.
Mitsubishi Materials produces A, B, C, and D types of taper axis (tool size) and C and D types (manual operation) of taper hole (spindle side).

Type	Application	Tapered Tool (Tool)	Tapered Hole (Spindle)
A Type	Automatic tool change (ATC), centre coolant (mainly milling tools)	□	
B Type	Automatic tool change (ATC), angular flow coolant (mainly turning tools)	□	
C Type	Manual tool change, centre coolant (mainly milling tools)	□	□
D Type	Manual tool change, angular flow coolant (mainly turing tools)	□	□

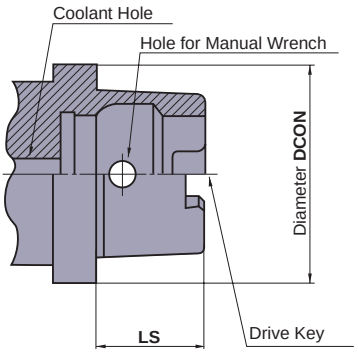
□ : Non stock, produced to order only.

Automatic Tool Change — **A Type** (Centre Coolant Type) — Milling Tool



Order Number	Dimensions (mm)	
	DCON	**LS**
HSK-A32M	32	16
HSK-A40M	40	20
HSK-A50M	50	25
HSK-A63M	63	32
HSK-A80M	80	40
HSK-A100M	100	50

Manual Tool Change — **C Type** (Centre Coolant Type) — Milling Tool



Order Number	Dimensions (mm)	
	DCON	**LS**
HSK-C32M	32	16
HSK-C40M	40	20
HSK-C50M	50	25
HSK-C63M	63	32
HSK-C80M	80	40
HSK-C100M	100	50

HOW TO READ THE STANDARD OF DRILLING TOOLS

●How this section page is organised

①Arranged in order of solid carbide drills, high-speed steel drills, indexable type drills and brazed type drills.

PHOTO OF PRODUCT

PRODUCT TITLE

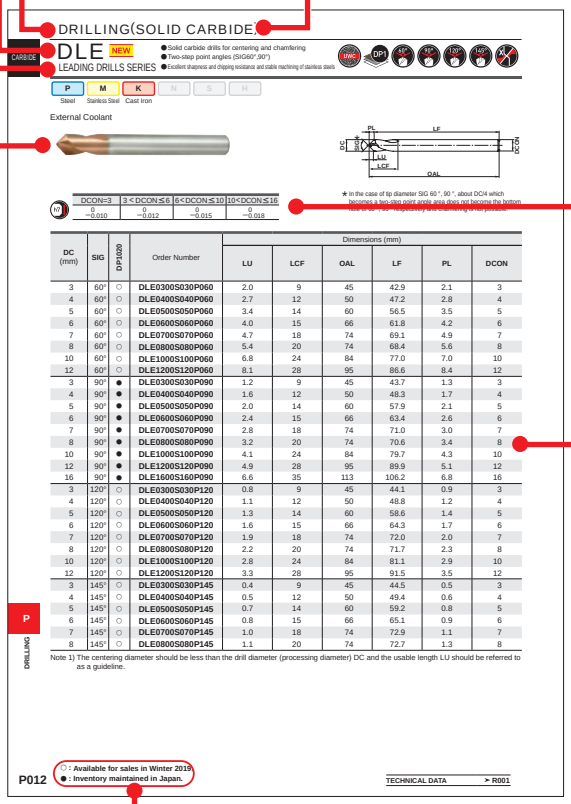
PRODUCT CODE

PRODUCT SECTION

PRODUCT TYPE

DIAMETER TOLERANCE GEOMETRY

SUITABLE WORK MATERIALS


DRILLING(SOLID CARBIDE)

CARBIDE

DLE NEW

LEADING DRILLS SERIES

●Solid carbide drills for centering and chamfering
●Two-step point angles (SIG60°,90°)
●Excellent sharpness and chipping resistance and stable machining of stainless steels

P Steel | M Stainless Steel | K Cast Iron | N | S | H

External Coolant

DCON=3	3＜DCON≤6	6＜DCON≤10	10＜DCON≤16
0 / −0.010	0 / −0.012	0 / −0.015	0 / −0.018

★In the case of tip diameter SIG 60°, 90°, about DC4 which becomes a two-step point angle area does not become the bottom hole of 90°, 118° respectively and chamfering is for purpose.

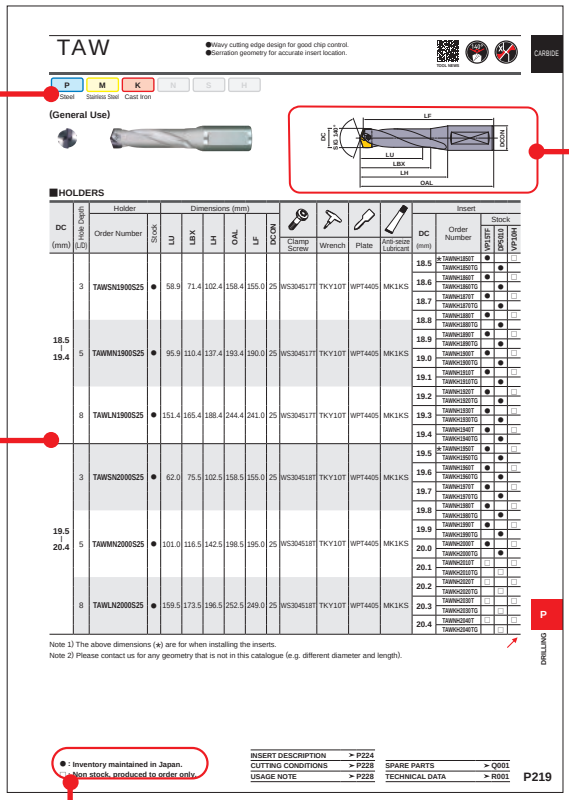
DC (mm)	SIG	DP1020	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
3	60°	○	DLE0300S030P060	2.0	9	45	42.9	2.1	3
4	60°	○	DLE0400S040P060	2.7	12	50	47.2	2.8	4
5	60°	○	DLE0500S050P060	3.4	14	60	56.5	3.5	5
6	60°	○	DLE0600S060P060	4.0	15	66	61.8	4.2	6
7	60°	○	DLE0700S070P060	4.7	18	74	69.1	4.9	7
8	60°	○	DLE0800S080P060	5.4	20	74	68.4	5.6	8
10	60°	○	DLE1000S100P060	6.8	24	84	77.0	7.0	10
12	60°	○	DLE1200S120P060	8.1	28	95	86.6	8.4	12
3	90°	●	DLE0300S030P090	1.2	9	45	43.7	1.3	3
4	90°	●	DLE0400S040P090	1.6	12	50	48.3	1.7	4
5	90°	●	DLE0500S050P090	2.0	14	60	57.9	2.1	5
6	90°	●	DLE0600S060P090	2.4	15	66	63.4	2.6	6
7	90°	●	DLE0700S070P090	2.8	18	74	71.0	3.0	7
8	90°	●	DLE0800S080P090	3.2	20	74	70.6	3.4	8
10	90°	●	DLE1000S100P090	4.1	24	84	79.7	4.3	10
12	90°	●	DLE1200S120P090	4.9	28	95	89.9	5.1	12
16	90°	●	DLE1600S160P090	6.6	35	113	106.2	6.8	16
3	120°	○	DLE0300S030P120	0.8	9	45	44.1	0.9	3
4	120°	○	DLE0400S040P120	1.1	12	50	48.8	1.2	4
5	120°	○	DLE0500S050P120	1.3	14	60	58.6	1.4	5
6	120°	○	DLE0600S060P120	1.6	15	66	64.3	1.7	6
7	120°	○	DLE0700S070P120	1.9	18	74	72.0	2.0	7
8	120°	○	DLE0800S080P120	2.2	20	74	71.7	2.3	8
10	120°	○	DLE1000S100P120	2.8	24	84	81.1	2.9	10
12	120°	○	DLE1200S120P120	3.3	28	95	91.5	3.5	12
3	145°	○	DLE0300S030P145	0.4	9	45	44.5	0.5	3
4	145°	○	DLE0400S040P145	0.5	12	50	49.4	0.6	4
5	145°	○	DLE0500S050P145	0.7	14	60	59.2	0.8	5
6	145°	○	DLE0600S060P145	0.8	15	66	65.1	0.9	6
7	145°	○	DLE0700S070P145	1.0	18	74	72.9	1.1	7
8	145°	○	DLE0800S080P145	1.1	20	74	72.7	1.3	8

Note 1) The centering diameter should be less than the drill diameter (processing diameter) DC and the usable length LU should be referred to as a guideline.

P DRILLING

P012 ○: Available for sales in Winter 2019 ●: Inventory maintained in Japan.

TECHNICAL DATA ➤R001


TAW

●Wavy cutting edge design for good chip control.
●Serration geometry for accurate insert location.

CARBIDE

P Steel | M Stainless Steel | K Cast Iron | N | S | H

(General Use)

■HOLDERS

DC (mm)	Hole Depth (LD)	Holder Order Number	Stock	Dimensions (mm) LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant
18.5	3	TAWSN1900S25	●	58.9	71.4	102.4	158.4	155.0	25	WS30451TT	TKY10T	WPT4405	MK1KS
19.4	5	TAWMN1900S25	●	95.9	110.4	137.4	193.4	190.0	25	WS30451TT	TKY10T	WPT4405	MK1KS
	8	TAWLN1900S25	●	151.4	165.4	188.4	244.4	241.0	25	WS30451TT	TKY10T	WPT4405	MK1KS
19.5	3	TAWSN2000S25	●	62.0	75.5	102.5	158.5	155.0	25	WS30451BT	TKY10T	WPT4405	MK1KS
20.4	5	TAWMN2000S25	●	101.0	116.5	142.5	198.5	195.0	25	WS30451BT	TKY10T	WPT4405	MK1KS
	8	TAWLN2000S25	●	159.5	173.5	196.5	252.5	249.0	25	WS30451BT	TKY10T	WPT4405	MK1KS

Insert DC (mm)	Order Number	Stock VP15TF	DP5010	VP10M
18.5	★TAWNH1850T	●		□
	TAWNH1850TG		●	
18.6	TAWNH1860T	●		□
	TAWNH1860TG		●	
18.7	TAWNH1870T	●		□
	TAWNH1870TG		●	
18.8	TAWNH1880T	●		□
	TAWNH1880TG		●	
18.9	TAWNH1890T	●		□
	TAWNH1890TG		●	
19.0	TAWNH1900T	●		□
	TAWNH1900TG		●	
19.1	TAWNH1910T	●		□
	TAWNH1910TG		●	
19.2	TAWNH1920T	●		□
	TAWNH1920TG		●	
19.3	TAWNH1930T	●		□
	TAWNH1930TG		●	
19.4	TAWNH1940T	●		□
	TAWNH1940TG		●	
19.5	★TAWNH1950T	●		□
	TAWNH1950TG		●	
19.6	TAWNH1960T	●		□
	TAWNH1960TG		●	
19.7	TAWNH1970T	●		□
	TAWNH1970TG		●	
19.8	TAWNH1980T	●		□
	TAWNH1980TG		●	
19.9	TAWNH1990T	●		□
	TAWNH1990TG		●	
20.0	TAWNH2000T	●		□
	TAWNH2000TG		●	
20.1	TAWNH2010T	□		□
	TAWNH2010TG		□	
20.2	TAWNH2020T	□		□
	TAWNH2020TG		□	
20.3	TAWNH2030T	□		□
	TAWNH2030TG		□	
20.4	TAWNH2040T	□		□
	TAWNH2040TG		□	

Note 1) The above dimensions (★) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

P DRILLING

●: Inventory maintained in Japan.
□: Non stock, produced to order only.

INSERT DESCRIPTION	➤P224
CUTTING CONDITIONS	➤P228
USAGE NOTE	➤P228
SPARE PARTS	➤Q001
TECHNICAL DATA	➤R001

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PRODUCT STANDARDS

indicates diameters, order numbers, stock status,numbers of teeth, dimensions, and spare parts for the title product.

LEGEND FOR STOCK STATUS MARK

●To Order : For solid-carbide or brazed drills, please specify ①order number and ②grade.
For indexable type drills, please specify ①order number for the drill.
For indexable type drill inserts, please specify ①insert number and ②insert grade.

DRILLING

IDENTIFICATION ····· P002
SYMBOL DESCRIPTIONS ····· P003
DRILLS SELECTION CHART ····· P004

DRILL STANDARD

SOLID CARBIDE

LEADING DRILLS SERIES ····· P012
SOLID CARBIDE FLAT BOTTOM DRILLS ··· P015
WSTAR DRILLS ····· P020
WSTAR DRILLS (FOR MACHINING OF STEEL AND CAST IRON) ··· P050
WSTAR DRILLS (FOR MACHINING OF STAINLESS STEEL) ··· P057
WSTAR DRILLS (FOR DIE & MOULD MACHINING) ··· P064
WSTAR DRILLS (FOR MACHINING OF ALUMINIUM ALLOYS) ··· P076
MAE/MAS DRILLS ····· P083
DRILLS FOR COMPOSITE MATERIALS ··· P090
MSE DRILLS ····· P097
WSTAR DRILLS (MWS) ····· P100
MZE/MZS DRILLS ····· P122
SOLID GUN DRILL ····· P130
MIRACLE DRILLS ····· P134
FOR NON-FERROUS MATERIAL ··· P136
DRILL FOR HARD BRITTLE MATERIALS ··· P138

HIGH-SPEED STEEL SOLID TYPE

HSS MILLING SHANK DRILLS ···· P140
VIOLET COATED PRECISION DRILLS ··· P144
VIOLET DRILLS ····· P170
STRAIGHT SHANK DRILLS ····· P174
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OTHERS

GUN DRILL • GUN REAMER ····· P250

EXCHANGEABLE HEAD

TAW DRILLS ····· P210

INDEXABLE TYPE

MVX TYPE DRILLS ····· P230
TAF TYPE DRILLS ····· P241
JUST FIT SLEEVE ····· P247

*Arranged by Alphabetical order

P207 **3KD**
P138 **DCBSS**
P136 **DCSSM**
P136 **DCSSS**
P012 **DLE**
P192 **EPSS**
P174 **GSD**
P193 **GTD**
P205 **GTTD**
P186 **GWSL**
P184 **GWSS**
P204 **GWTS**
P247 **JFS**
P182 **KSD**
P198 **KTD**
P189 **LSD**
P200 **LTD**
P087 **MAE**
P083 **MAS**
P091 **MCA**
P095 **MCAH**
P090 **MCC**
P094 **MCCH**
P092 **MCT**
P093 **MCW**
P015 **MFE**
P131 **MGD**
P130 **MGS**
P064 **MHS**
P057 **MMS**
P076 **MNS**
P050 **MQS**
P097 **MSE**
P096 **MSP**
P042 **MVE**
P020 **MVS**
P230 **MVX**
P100 **MWS**
P122 **MZE**
P176 **SD**
P178 **SD** (1/100 Straight)
P179 **SDLS**
P142 **SEPDM**
P140 **SEPDS**
P210 **STAW**
P241 **TAF**
P219 **TAW**
P194 **TD**
P206 **TTD**
P153 **VAPDJ**
P149 **VAPDM**
P161 **VAPDMSUS**
P144 **VAPDS**
P168 **VAPDSCB**
P155 **VAPDSSUS**
P135 **VCHSM**
P134 **VCSSS**
P170 **VSD**
P172 **VTDS**

IDENTIFICATION

PRODUCT CODE OF DRILLS

MV S 0300 X S

Applications

MV : General-purpose
MF : Solid Carbide Flat Bottom
MG : Micro Solid Carbide Gun Drill
MS : For Small Diameter Machining
MN : For Machining of Aluminium Alloys
MH : For Die & Mould Machining
MM : For Machining of Stainless Steel
MC : For Composite Materials
DL : For Centering and Chamfering
MA : For Aluminium Cast Iron High Precision Hole Machining

Coolant

E : External Coolant
S : Internal Coolant

Diameter

ex.
0050 → ϕ0.5
0300 → ϕ3.0

L/D

S : 2D
M : 3D
L : 5D (MAE, MAS : 6D)
X : 12D
X⋆⋆D : ⋆⋆D

Type of Shank

A : Straight Shank
B : Integral Shank
S⋆⋆⋆ : Shank Diameter

⋆Other special types can be ordered.

VC S S S D0300 ⋆⋆⋆

Product Name

VC : Miracle Drills
DC : Diamond Coated Drills
VA : Violet Coated Precision Drills (High Grade, High Speed Steel)
SE : SE High Precision Drill (High-Speed Steel)
V : Violet Drills
G : Tin Coated Drills (High-Speed Steel)
E : Co-Hss Drills
None: High-Speed Steel

Applications

SD : General-purpose Straight Drill
TD : General-purpose Taper Drill
S : For Steel
H : For High Hardness
PD : For High-precision Machining
U : For Stainless
T : For Steel Frame
W : For Deep Hole

Type of Shank

S : Straight
T : Taper
3K : Triangular
6K : Hexagonal

Flute Length

S : Short
M : Medium
J : Semi Long
L : Long

Diameter

ex.
D0050 → ϕ0.5
D0300 → ϕ3.0

Others

A⋆⋆⋆ : Overall Length
S⋆⋆ : Shank Diameter
M⋆ : Taper Size

⋆Other special types can be ordered.

SYMBOL DESCRIPTIONS

Tool Material

Ultra Micro Grain Carbide (UWC)
Ultra micro grain carbide is used as the substrate material.

High Grade High Alloy HSS (HG HSS)
High grade high alloy HSS is used as the substrate material.

Cobalt High Speed Steel (CO HSS)
Cobalt high speed steel is used as the substrate material.

D-STH Cobalt High Speed Steel (COHSS D-STH)
Cobalt high-speed steel is used as the substrate material with D-STH.

High Speed Steel (HSS)
High speed steel is used as the substrate material.

Web Thinning

X Web Thinning (X)
X web thinning is used at the drill point.

Z Web Thinning (Z)
Z web thinning is used at the drill point.

XR Web Thinning (XR)
XR web thinning is used at the drill point.

C Web Thinning (C)
C web thinning is used at the drill point.

S Web Thinning (S)
S web thinning is used at the drill point.

N Web Thinning (N)
N web thinning is used at the drill point.

Tolerance

Drill Diameter Tolerance

Shank Diameter Tolerance (h6)

Coolant Hole

Coolant Hole

Coating

Diamond Coating (DC)
Pure Diamond high performance coating excelling in film adhesion to the substrate.

Violet Coating (V)
Increased tool life of 2–3 times that of TiN coated products.

TiN Coating (G)
Increased tool life of 2–3 times that of non coated products.

PVD Coating (DP1A)
DP102A is a PVD coated cemented carbide grade specialized for small diameter drills, with greatly improved wear resistance.

PVD Coating (DP1)
Exhibits outstanding wear resistance with a wide range of work materials including mild steel, carbon steel, alloy steel, stainless steel, cast iron-based materials, and aluminium alloys.

PVD Coating (DP3)
Super multi-layer PVD coating material provides a life over 2 times longer than conventional materials.

PVD Coating (DP7)
An ultra micro-grain cemented carbide optimal for stainless steel, and a PVD coating with outstanding heat resistance and lubricity.

MIRACLE Coating (VP)
The original Miracle (Al,Ti)N coating.
Also suitable for dry cutting.

CVD Diamond Coating (DD)
Unique multi-layer micro-grain diamond crystal control technology drastically improves wear resistance and smoothness.

Angle

Point Angle (140°)
Indicates drill point angle the tip.
∗ The icon shown is an example only.

DRILLS SELECTION CHART CEMENTED CARBIDE

SOLID DRILLS

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P: Steel	M: Stainless Steel	K: Cast Iron	N: Non-ferrous Metal	S: Heat Resistant Alloy	H: Hardened Steel	Shape	Page
For Small Diameter	MVS...X02	ϕ1.0 −ϕ2.9	2	Internal	DP1	◎	◎	○	○	○			P020
	MVS...X07		7	Internal	DP1	◎	◎	○	○	○			
	MVS...X12		12	Internal	DP1	◎	◎	○	○	○			
	MVS...X20		20	Internal	DP1	◎	◎	○	○	○			
	MVS...X25		25	Internal	DP1	◎	◎	○	○	○			
	MVS...X30		30	Internal	DP1	◎	◎	○	○	○			
General Drilling	MVE...X02	ϕ3.0 −ϕ20.0	2	External	DP1	◎	○	◎	○	○	○		P042
	MVE...X03		3	External	DP1	◎	○	◎	○	○	○		
	MVS...X02	ϕ3.0 −ϕ14.0	2	Internal	DP1	◎	◎	◎	○	○			P024
	MVS...X03	ϕ3.0 −ϕ20.0	3	Internal	DP1	◎	◎	◎	○	○			
	MVS...X05		5	Internal	DP1	◎	◎	◎	○	○			
	MVS...X08	ϕ3.0 −ϕ16.0	8	Internal	DP1	◎	◎	◎	○	○			
	MVS...X10	ϕ3.0 −ϕ14.0	10	Internal	DP1	◎	◎	◎	○	○			
	MVS...X15		15	Internal	DP1	◎	◎	◎	○	○			
	MVS...X20		20	Internal	DP1	◎	◎	◎	○	○			
	MVS...X25	ϕ3.0 −ϕ12.0	25	Internal	DP1	◎	◎	◎	○	○			
	MVS...X30	ϕ3.0 −ϕ10.0	30	Internal	DP1	◎	◎	◎	○	○			
	MVS...X35		35	Internal	DP1	◎	◎	◎	○	○			
	MVS...X40	ϕ3.0 −ϕ9.0	40	Internal	DP1	◎	◎	◎	○	○			

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P: Steel	Work Material M: Stainless Steel	Work Material K: Cast Iron	Work Material N: Non-ferrous Metal	Work Material S: Heat Resistant Alloy	Work Material H: Hardened Steel	Shape	Page
For Machining of Stainless Steel	MMS...X3DB	ϕ3.0 –ϕ20.0	3	Internal	DP7		◎						P057
	MMS...X5DB		5	Internal	DP7		◎						
For Die & Mould Machining	MHS	ϕ0.95 –ϕ12.0	1 –30	Internal	VP	○	○			○	◎		P064
For Machining of Aluminium Alloys	MNS...LB	ϕ3.0 –ϕ14.0	5	Internal	–				◎				P076
	MNS...X10DB		10	Internal	–				◎				
	MNS...X20DB		20	Internal	–				◎				
	MNS...X30DB	ϕ3.0 –ϕ10.0	30	Internal	–				◎				
Aluminium Alloy, Cast Iron	MAE...MB	ϕ3.0 –ϕ16.0	3	External	–			○	◎				P087
	MAS...MB		3	Internal	–			○	◎				P083
	MAS...LB		6	Internal	–			○	◎				
Composite Materials	MCC	ϕ4.76 –ϕ11.14	3	External	DD	Composite Materials							P090
	MCA	ϕ6.38 –ϕ9.55	5	Internal	DD								P091
	MCT	ϕ6.38 –ϕ9.55	5	Internal	–								P092
	MCW	ϕ6.38 –ϕ9.55	5	Internal	DD								P093
	MCCH	ϕ2.5 –ϕ9.55	2 –15	External	–								P094
	MCAH	ϕ2.5 –ϕ9.55	3 –15	External	–								P095

DRILLS SELECTION CHART CEMENTED CARBIDE

SOLID DRILLS

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P: Steel	M: Stainless Steel	K: Cast Iron	N: Non-ferrous Metal	S: Heat Resistant Alloy	H: Hardened Steel	Shape	Page
For Centering and Chamfering	NEW DLE	ϕ3.0 –ϕ16.0	–	External	DP1	◎	◎	◎					P012
Solid Carbide Flat Bottom	NEW MFE	ϕ0.75 –ϕ2.95	2	External	DP1A	◎	◎	◎	○				P015
		ϕ3.0 –ϕ20.0	2	External	DP1	◎	◎	◎	○				P016
For Small Diameter Machining	MSE	ϕ0.1 –ϕ0.99	–	External	VP	◎	○	◎	○	○			P097
	MSP0300SB	–	–	External	VP	◎	○	◎	○	○		*MSE drill for prepared hole.	P096
Deep Hole Drilling	MGS	ϕ0.7 –ϕ3.0	–80	Internal	–	◎	◎	◎	◎				P130
For Non-ferrous Material	DCSSS	ϕ0.2 –ϕ2.0	–	External	DC				○				P136
	DCSSM	ϕ2.1 –ϕ3.0	–	External	DC				○				P136
For Hard Brittle Materials	DCBSS	ϕ0.05 –ϕ3.0	–	External	DC	Hard brittle materials such as ceramics							P138

INDEXABLE DRILLS

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	P: Steel	M: Stainless Steel	K: Cast Iron	N: Non-ferrous Metal	S: Heat Resistant Alloy	H: Hardened Steel	Shape	Page
General Drilling	MVX...X2	ϕ14.0 –ϕ63.0	2	Internal	–	◎	○	◎	○		○		P230
	MVX...X3		3	Internal	–	◎	○	◎	○		○		
	MVX...X4		4	Internal	–	◎	○	◎	○		○		
	MVX...X5		5	Internal	–	◎	○	◎	○		○		
	MVX...X6	ϕ17.0 –ϕ43.0	6	Internal	–	◎	○	◎	○		○		

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P Steel	M Stainless Steel	K Cast Iron	N Non-ferrous Metal	S Heat Resistant Alloy	H Hardened Steel	Shape	Page
General Drilling	TAFS	ϕ12.0 −ϕ56.0	2	Internal	–	◎	◎	◎					P241
	TAFM		3	Internal	–	◎	◎	◎					
	TAFL	ϕ16.0 −ϕ34.0	4	Internal	–	◎	◎	◎					

EXCHANGEABLE-HEAD DRILLS

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P Steel	M Stainless Steel	K Cast Iron	N Non-ferrous Metal	S Heat Resistant Alloy	H Hardened Steel	Shape	Page
General Drilling	STAWSS	ϕ10.0 −ϕ18.4	1.5	Internal	–	◎	○	◎					P210
	STAWSN		3	Internal	–	◎	○	◎					
	STAWMN		5	Internal	–	◎	○	◎					
	STAWLN		8	Internal	–	◎	○	◎					
	TAWSN	ϕ18.5 −ϕ30.4	3	Internal	–	◎	○	◎					P219
	TAWMN		5	Internal	–	◎	○	◎					
	TAWLN		8	Internal	–	◎	○	◎					
For Bridge Construction	TAWSB	ϕ24.5 −ϕ26.7	3	Internal	–	◎							P229
	TAWMB		5	Internal	–	◎							

BRAZED GUN REAMER

Applications	Product Code (Series Title)	Size Range	Hole Depth (L/D)	Coolant	Coating	Work Material P Steel	M Stainless Steel	K Cast Iron	N Non-ferrous Metal	S Heat Resistant Alloy	H Hardened Steel	Shape	Page
Finish Drilling	GUN REAMER	ϕ6.0 −ϕ30.0	–	Internal	–	○	○	○	○				P250
	GUN REAMER With Diamond Compound	ϕ6.0 −ϕ30.3	–	Internal	–				◎				P251

DRILLS SELECTION CHART HSS

Drill Type	Applications	Product Code (Series Title)	Size Range	Tool Material	Coolant	Coating	Work Material: P Steel	M Stainless Steel	K Cast Iron	N Non-ferrous Metal	S Heat Resistant Alloy	H Hardened Steel	Shape	Page
Violet Coated Drills	General, High Precision	VAPDS	ϕ0.5 −ϕ13.0	High Grade, High Speed Steel	External	V	◎	○	○					P144
		VAPDM	ϕ0.5 −ϕ32.0		External	V	◎	○	○					P149
		NEW VAPDJ	ϕ1.0 −ϕ10.0		External	V	◎	○	○					P153
	General, High Precision Steel	VAPDSSUS	ϕ0.5 −ϕ20.0	Cobalt High Speed Steel	External	V	○	◎	○	○	○			P155
		VAPDMSUS	ϕ0.5 −ϕ13.0		External	V	○	◎	○	○	○			P161
	Spot Milling	VAPDSCB	ϕ2.0 −ϕ32.0	High Grade, High Speed Steel	External	V	◎	○	○	○				P168
Violet Drill	General Drilling	VSD	ϕ0.5 −ϕ13.0	High Speed Steel	External	V	◎	○	○	○				P170
		VTDS	ϕ6.0 −ϕ32.0		External	V	◎	◎		○				P172
SE High Precision Drill	General Drilling	SEPDS	ϕ0.5 −ϕ4.0	High Speed Steel	External	–	◎	○	◎	◎	○			P140
		SEPDM	ϕ0.5 −ϕ4.0		External	–	◎	○	◎	◎	○			P142
Straight Shank Drill	General Drilling	GSD	ϕ0.5 −ϕ13.0	High Speed Steel	External	G	◎	○	○	○				P174
		SD	ϕ0.2 −ϕ17.5		External	–	◎	○	○	○				P176
		SD (1/100 Straight)	ϕ0.25 −ϕ5.95		External	–	◎	○	○	○				P178
	General, Long Shank	SDLS	ϕ1.0 −ϕ10.0	High Speed Steel	External	–	◎	○	○	○				P179
	General Drilling	KSD	ϕ1.0 −ϕ13.0	Cobalt High Speed Steel	External	–	◎	◎	○	○				P182

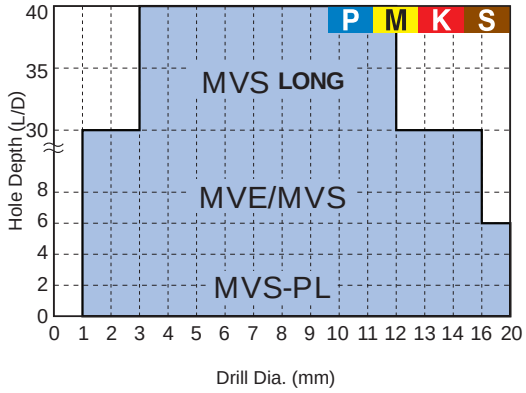
Drill Type	Applications	Product Code (Series Title)	Size Range	Tool Material	Coolant	Coating	Work Material P: Steel	Work Material M: Stainless Steel	Work Material K: Cast Iron	Work Material N: Non-ferrous Metal	Work Material S: Heat Resistant Alloy	Work Material H: Hardened Steel	Shape	Page
Straight Shank Drill	Deep Hole Drilling	GWSS	ϕ1.0 –ϕ13.0	Cobalt High Speed Steel	External	G	◎	○	○	○				P184
		GWSL	ϕ2.0 –ϕ13.0	Cobalt High Speed Steel	External	G	◎	○	○	○				P186
		LSD	ϕ1.0 –ϕ13.0	High Speed Steel	External	–	○	○	○	○				P189
	Sheet Steel	EPSS	ϕ2.0 –ϕ13.0	High Speed Steel	External	–	○	○	○	○				P192
Taper Shank Drill	General Drilling	GTD	ϕ6.0 –ϕ40.0	High Speed Steel	External	G	◎	○	○	○				P193
		TD	ϕ3.0 –ϕ75.0	High Speed Steel	External	–	◎	○	○	○				P194
		KTD	ϕ5.0 –ϕ50.0	Cobalt High Speed Steel	External	–	◎	○	○	○				P198
	Deep Hole Drilling	GWTS	ϕ6.0 –ϕ32.0	Cobalt High Speed Steel	External	G	◎	○	○	○				P204
		LTD	ϕ6.0 –ϕ40.0	High Speed Steel	External	–	○		○	○				P200
	For Steel Frame	GTTD	ϕ17.0 –ϕ32.0	High Speed Steel	External	G	◎							P205
		TTD	ϕ17.0 –ϕ32.0	High Speed Steel	External	–	○							P206
Triangular Shank Drill	For General-purpose Electric Drills	3KD	ϕ7.0 –ϕ26.0	High Speed Steel	External	–	○		○	○				P207

Memo

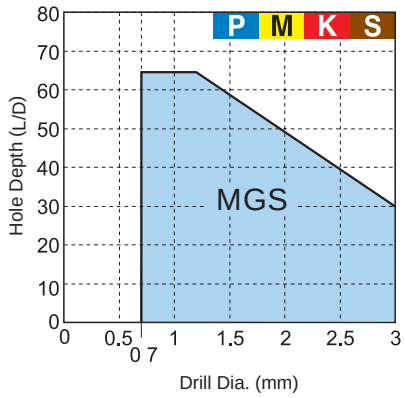
APPLICATION RANGE

■Carbide Solid Drills

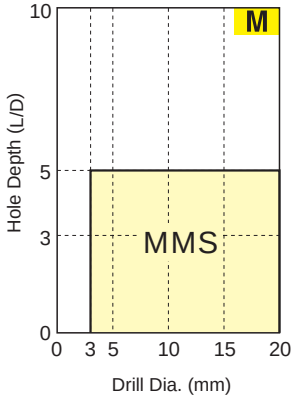
MVE/MVS
General Drilling



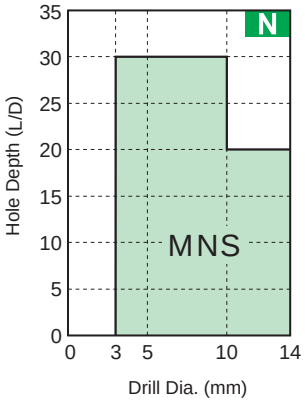
MGS
For Small Diameter And Deep Hole



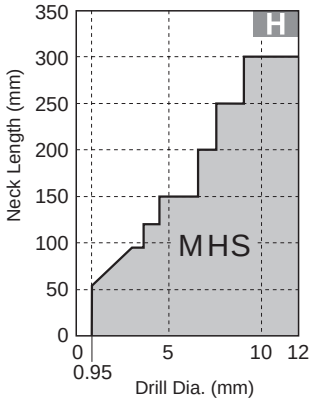
MMS
For Machining of Stainless Steel



MNS
For Machining of Aluminium Alloys

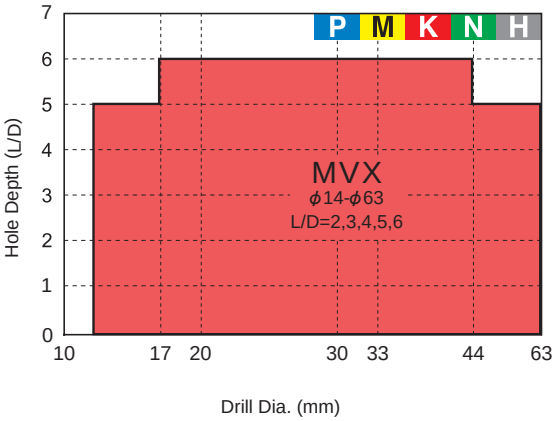


MHS
For Die & Mould Machining



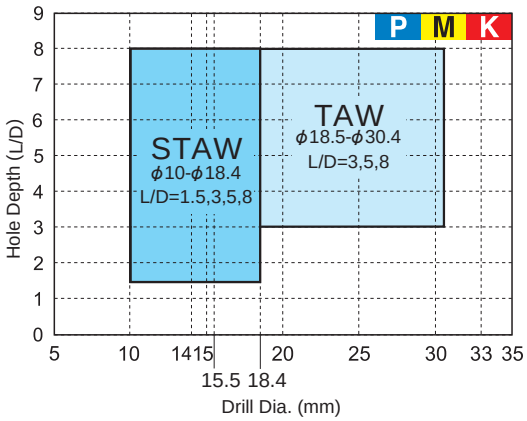
■Indexable Drills

MVX



■Exchangeable-head Drills

STAW,TAW



DLE NEW

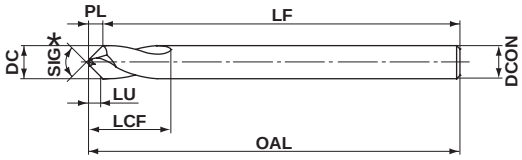
LEADING DRILLS SERIES

- Solid carbide drills for centering and chamfering
- Two-step point angles (SIG60°,90°)
- Excellent sharpness and chipping resistance and stable machining of stainless steels

UWC DP1 60° 90° 120° 145° X

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			

External Coolant



h7	DCON=3	3 < DCON ≤ 6	6 < DCON ≤ 10	10 < DCON ≤ 16
	0 −0.010	0 −0.012	0 −0.015	0 −0.018

* In the case of tip diameter SIG 60 °, 90 °, about DC/4 which becomes a two-step point angle area does not become the bottom hole of 60 °, 90 ° respectively and chamfering is not possible.

DC (mm)	SIG	DP1020	Order Number	Dimensions (mm)					
				LU	LCF	OAL	LF	PL	DCON
3	60°	○	**DLE0300S030P060**	2.0	9	45	42.9	2.1	3
4	60°	○	**DLE0400S040P060**	2.7	12	50	47.2	2.8	4
5	60°	○	**DLE0500S050P060**	3.4	14	60	56.5	3.5	5
6	60°	○	**DLE0600S060P060**	4.0	15	66	61.8	4.2	6
7	60°	○	**DLE0700S070P060**	4.7	18	74	69.1	4.9	7
8	60°	○	**DLE0800S080P060**	5.4	20	74	68.4	5.6	8
10	60°	○	**DLE1000S100P060**	6.8	24	84	77.0	7.0	10
12	60°	○	**DLE1200S120P060**	8.1	28	95	86.6	8.4	12
3	90°	●	**DLE0300S030P090**	1.2	9	45	43.7	1.3	3
4	90°	●	**DLE0400S040P090**	1.6	12	50	48.3	1.7	4
5	90°	●	**DLE0500S050P090**	2.0	14	60	57.9	2.1	5
6	90°	●	**DLE0600S060P090**	2.4	15	66	63.4	2.6	6
7	90°	●	**DLE0700S070P090**	2.8	18	74	71.0	3.0	7
8	90°	●	**DLE0800S080P090**	3.2	20	74	70.6	3.4	8
10	90°	●	**DLE1000S100P090**	4.1	24	84	79.7	4.3	10
12	90°	●	**DLE1200S120P090**	4.9	28	95	89.9	5.1	12
16	90°	●	**DLE1600S160P090**	6.6	35	113	106.2	6.8	16
3	120°	○	**DLE0300S030P120**	0.8	9	45	44.1	0.9	3
4	120°	○	**DLE0400S040P120**	1.1	12	50	48.8	1.2	4
5	120°	○	**DLE0500S050P120**	1.3	14	60	58.6	1.4	5
6	120°	○	**DLE0600S060P120**	1.6	15	66	64.3	1.7	6
7	120°	○	**DLE0700S070P120**	1.9	18	74	72.0	2.0	7
8	120°	○	**DLE0800S080P120**	2.2	20	74	71.7	2.3	8
10	120°	○	**DLE1000S100P120**	2.8	24	84	81.1	2.9	10
12	120°	○	**DLE1200S120P120**	3.3	28	95	91.5	3.5	12
3	145°	○	**DLE0300S030P145**	0.4	9	45	44.5	0.5	3
4	145°	○	**DLE0400S040P145**	0.5	12	50	49.4	0.6	4
5	145°	○	**DLE0500S050P145**	0.7	14	60	59.2	0.8	5
6	145°	○	**DLE0600S060P145**	0.8	15	66	65.1	0.9	6
7	145°	○	**DLE0700S070P145**	1.0	18	74	72.9	1.1	7
8	145°	○	**DLE0800S080P145**	1.1	20	74	72.7	1.3	8

Note 1) The centering diameter should be less than the drill diameter (processing diameter) DC and the usable length LU should be referred to as a guideline.

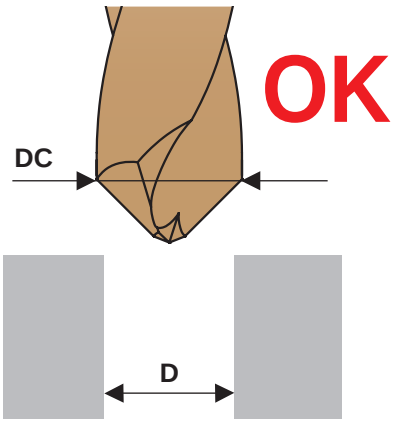
○ : **Available for sales in Winter 2019.**
● : **Inventory maintained in Japan.**

TECHNICAL DATA ➢ R001

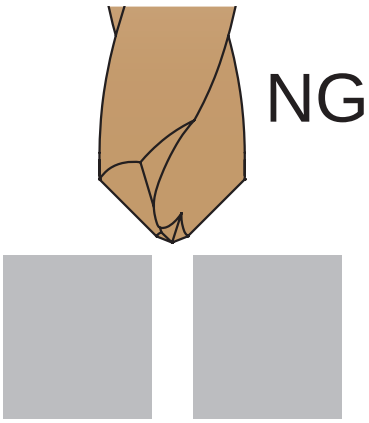
Drill Diameter Selection

■ When Chamfering

With respect to guide hole diameter D, select the drill diameter (cutting diameter) DC to be within the range of D < DC < 2D.

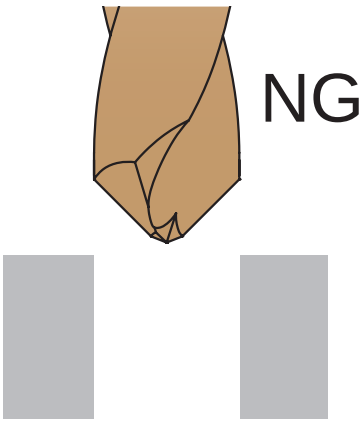


Example) If guide hole diameter D is 5 mm: Drill diameter DC should be greater than 6 mm but less than 10 mm. Select a DC of 6 mm, 7 mm, or 8 mm.



If DC is equal to or greater than 2D:

If drill diameter DC is too large compared to guide hole diameter D (equal to or greater than 2D), chamfering cannot be performed.

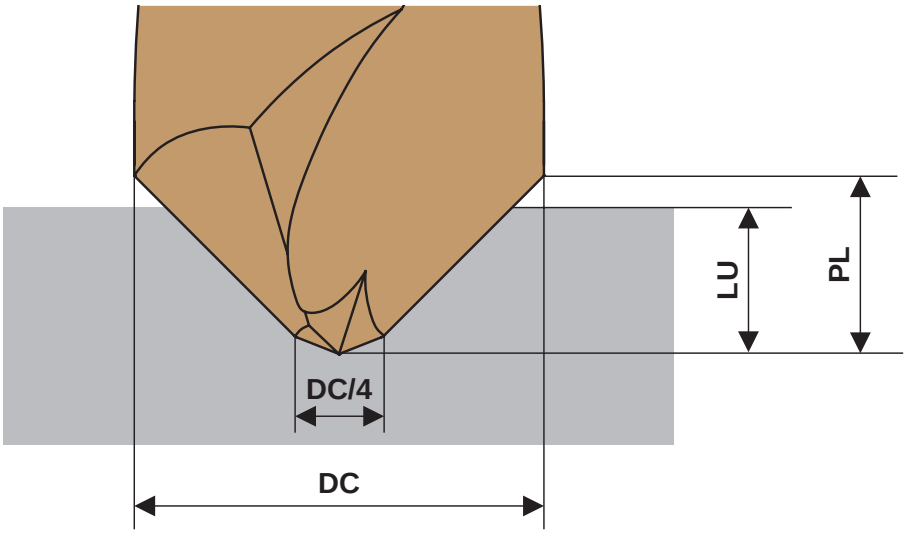


If DC is a drill diameter equal to D:

Chamfering cannot be performed if drill diameter DC is the same as guide hole diameter D.

■ When Centering

The tool cannot be used for processing if the centering diameter has the same guide hole diameter as drill diameter DC. Refer to the usable length LU as a guideline.
In the case of tip diameter SIG 60 °, 90 °, about DC/4 which becomes a two-step point angle area does not become the bottom hole of 60 °, 90 ° respectively and chamfering is not possible.



DLE NEW

LEADING DRILL SERIES

TOOL NEWS

RECOMMENDED CUTTING CONDITIONS

*Please refer to cutting conditions of SIG 60°, 120°, 145° from TOOL NEWS B223G available in Winter 2019.

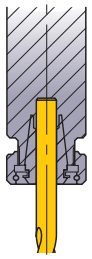
Work Material	Mild Steels (≤180HB) AISI 1010 etc.		Carbon Steels, Alloy Steels (180−280HB) AISI 1045, 4140 etc.		Carbon Steels, Alloy Steels (280−350HB) AISI 4340 etc.	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)
3	7900	0.06 (0.04−0.08)	6800	0.06 (0.04−0.08)	6300	0.05 (0.03−0.07)
4	5900	0.06 (0.04−0.08)	5100	0.06 (0.04−0.08)	4700	0.05 (0.03−0.07)
5	5000	0.07 (0.05−0.09)	4400	0.07 (0.05−0.09)	4100	0.06 (0.04−0.08)
6	4200	0.07 (0.05−0.09)	3700	0.07 (0.05−0.09)	3400	0.06 (0.04−0.08)
7	3600	0.08 (0.05−0.10)	3100	0.08 (0.05−0.10)	2900	0.06 (0.04−0.08)
8	3100	0.08 (0.05−0.10)	2700	0.08 (0.05−0.10)	2500	0.06 (0.04−0.08)
10	2700	0.09 (0.05−0.11)	2300	0.09 (0.05−0.11)	2200	0.07 (0.04−0.09)
12	2200	0.09 (0.05−0.11)	1900	0.09 (0.05−0.11)	1800	0.07 (0.04−0.09)
16	1700	0.12 (0.10−0.14)	1500	0.12 (0.10−0.14)	1400	0.08 (0.06−0.10)

Work Material	Austenitic Stainless Steels (≤200HB) AISI 304, 316 etc.		Gray Cast Irons (≤350MPa) AISI No45B etc.		Ductile Cast Irons (≤450MPa) AISI 60-40-18 etc.	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)
3	1500	0.04 (0.02−0.06)	7900	0.06 (0.04−0.08)	5800	0.06 (0.04−0.08)
4	1100	0.04 (0.02−0.06)	5900	0.06 (0.04−0.08)	4300	0.06 (0.04−0.08)
5	1200	0.06 (0.04−0.08)	5000	0.07 (0.05−0.09)	3800	0.07 (0.05−0.09)
6	1000	0.06 (0.04−0.08)	4200	0.07 (0.05−0.09)	3100	0.07 (0.05−0.09)
7	900	0.06 (0.04−0.08)	3600	0.08 (0.05−0.10)	2700	0.07 (0.05−0.09)
8	790	0.06 (0.04−0.08)	3100	0.08 (0.05−0.10)	2300	0.07 (0.05−0.09)
10	630	0.06 (0.04−0.08)	2700	0.09 (0.05−0.11)	1900	0.08 (0.05−0.10)
12	530	0.06 (0.04−0.08)	2200	0.09 (0.05−0.11)	1500	0.08 (0.05−0.10)
16	390	0.08 (0.06−0.10)	1700	0.12 (0.10−0.14)	1100	0.11 (0.09−0.13)

Note 1) When chamfering a circumference of a guide hole, make sure that the tool diameter(DC) is D <DC <2D.
Note 2) When V-grooving and chamfering, please reduce cutting conditions.

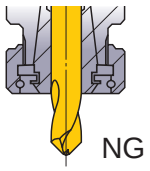
■ OPERATIONAL GUIDANCE

Drill Holding



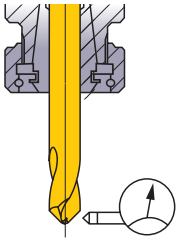
Collet chuck holds the drill securely.

Drill Length



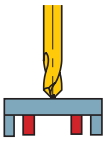
Do not clamp on the flutes.

Installation Tolerance

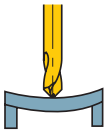


Run-out ≤ 0.03mm

Thin Workpiece

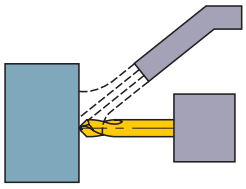


OK
Support the Workpiece



NG
If Bending Occurs

Coolant Method



Coolant positions, at the end at the center are ideal.

MFE NEW for Small Diameter

SOLID CARBIDE FLAT BOTTOM DRILLS

- Sharp cutting edges with long tool life
- Combination of different radius sizes provides strong cutting edge and excellent chip control

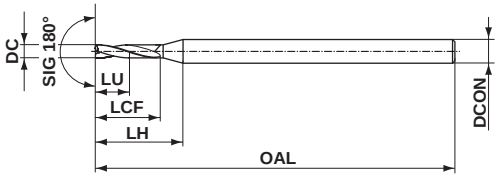
TOOL NEWS

UWC DP1A 180° XR

DP102A

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		

External Coolant



Type1

0.75≤DC≤2.95	
0 −0.014	
DCON=3	DCON=4
0 −0.006	0 −0.008

DC (mm)	Hole Depth (L/D)	DP102A	Order Number	Dimensions (mm) LU	LCF	LH	OAL	DCON	Type
0.75	2	●	MFE0075X02S030	1.5	3	7.7	45	3	1
0.8	2	●	MFE0080X02S030	1.6	3.2	7.8	45	3	1
0.85	2	●	MFE0085X02S030	1.7	3.4	7.9	45	3	1
0.9	2	●	MFE0090X02S030	1.8	3.6	8	45	3	1
0.95	2	●	MFE0095X02S030	1.9	3.8	8.1	45	3	1
1	2	●	MFE0100X02S030	2	4	8.2	45	3	1
1.05	2	●	MFE0105X02S030	2.1	4.2	8.3	45	3	1
1.1	2	●	MFE0110X02S030	2.2	4.4	8.4	45	3	1
1.15	2	●	MFE0115X02S030	2.3	4.6	8.6	45	3	1
1.2	2	●	MFE0120X02S030	2.4	4.8	8.7	45	3	1
1.25	2	●	MFE0125X02S030	2.5	5	8.8	45	3	1
1.3	2	●	MFE0130X02S030	2.6	5.2	8.9	45	3	1
1.35	2	●	MFE0135X02S030	2.7	5.4	9	45	3	1
1.4	2	●	MFE0140X02S030	2.8	5.6	9.1	45	3	1
1.45	2	●	MFE0145X02S030	2.9	5.8	9.2	45	3	1
1.5	2	●	MFE0150X02S030	3	6	9.3	45	3	1
1.55	2	●	MFE0155X02S030	3.1	6.2	9.4	45	3	1
1.6	2	●	MFE0160X02S030	3.2	6.4	9.5	45	3	1
1.65	2	●	MFE0165X02S030	3.3	6.6	9.6	45	3	1
1.7	2	●	MFE0170X02S030	3.4	6.8	9.7	45	3	1
1.75	2	●	MFE0175X02S030	3.5	7	9.8	45	3	1
1.8	2	●	MFE0180X02S030	3.6	7.2	9.9	45	3	1
1.85	2	●	MFE0185X02S030	3.7	7.4	10	45	3	1
1.9	2	●	MFE0190X02S030	3.8	7.6	10.2	45	3	1
1.95	2	●	MFE0195X02S030	3.9	7.8	10.3	45	3	1
2	2	●	MFE0200X02S040	4	8	12.2	50	4	1
2.05	2	●	MFE0205X02S040	4.1	8.2	12.3	50	4	1
2.1	2	●	MFE0210X02S040	4.2	8.4	12.4	50	4	1
2.15	2	●	MFE0215X02S040	4.3	8.6	12.6	50	4	1
2.2	2	●	MFE0220X02S040	4.4	8.8	12.7	50	4	1
2.25	2	●	MFE0225X02S040	4.5	9	12.8	50	4	1
2.3	2	●	MFE0230X02S040	4.6	9.2	12.9	50	4	1
2.35	2	●	MFE0235X02S040	4.7	9.4	13	50	4	1
2.4	2	●	MFE0240X02S040	4.8	9.6	13.1	50	4	1
2.45	2	●	MFE0245X02S040	4.9	9.8	13.2	50	4	1
2.5	2	●	MFE0250X02S040	5	10	13.3	50	4	1
2.55	2	●	MFE0255X02S040	5.1	10.2	13.4	50	4	1
2.6	2	●	MFE0260X02S040	5.2	10.4	13.5	50	4	1
2.65	2	●	MFE0265X02S040	5.3	10.6	13.6	50	4	1
2.7	2	●	MFE0270X02S040	5.4	10.8	13.7	50	4	1
2.75	2	●	MFE0275X02S040	5.5	11	13.8	50	4	1
2.8	2	●	MFE0280X02S040	5.6	11.2	13.9	50	4	1
2.85	2	●	MFE0285X02S040	5.7	11.4	14	50	4	1
2.9	2	●	MFE0290X02S040	5.8	11.6	14.2	50	4	1
2.95	2	●	MFE0295X02S040	5.9	11.8	14.3	50	4	1

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P019
TECHNICAL DATA ➤ R001

MFE

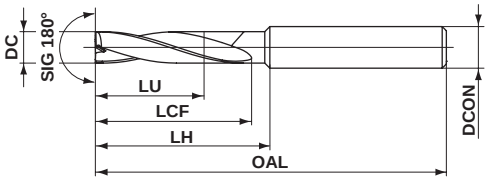
SOLID CARBIDE FLAT BOTTOM DRILLS

- Sharp cutting edges with long tool life
- Combination of different radius sizes provides strong cutting edge and excellent chip control

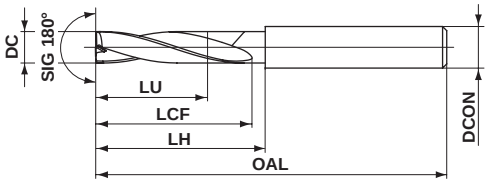
TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		

External Coolant



Type1



Type2

3≤DC≤6	6 < DC≤10	10 < DC≤18	18 < DC≤20
0 / −0.012	0 / −0.015	0 / −0.018	0 / −0.021
DCON=6	DCON=8, 10	DCON=12, 14, 16, 18	DCON=20
0 / −0.008	0 / −0.009	0 / −0.011	0 / −0.013

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm)					Type
				LU	LCF	LH	OAL	DCON	
3	2	●	MFE0300X02S060	6	12	19.6	55	6	1
3.1	2	●	MFE0310X02S060	6.2	14	21.4	55	6	1
3.2	2	●	MFE0320X02S060	6.4	14	21.2	55	6	1
3.3	2	●	MFE0330X02S060	6.6	14	21	55	6	1
3.4	2	●	MFE0340X02S060	6.8	14	20.9	55	6	1
3.5	2	●	MFE0350X02S060	7	14	20.7	55	6	1
3.6	2	●	MFE0360X02S060	7.2	16	22.5	55	6	1
3.7	2	●	MFE0370X02S060	7.4	16	22.3	55	6	1
3.8	2	●	MFE0380X02S060	7.6	16	22.1	55	6	1
3.9	2	●	MFE0390X02S060	7.8	16	21.9	55	6	1
4	2	●	MFE0400X02S060	8	16	21.7	55	6	1
4.1	2	●	MFE0410X02S060	8.2	18	23.5	62	6	1
4.2	2	●	MFE0420X02S060	8.4	18	23.4	62	6	1
4.3	2	●	MFE0430X02S060	8.6	18	23.2	62	6	1
4.4	2	●	MFE0440X02S060	8.8	18	23	62	6	1
4.5	2	●	MFE0450X02S060	9	18	22.8	62	6	1
4.6	2	●	MFE0460X02S060	9.2	20	23.7	62	6	1
4.7	2	●	MFE0470X02S060	9.4	20	23.7	62	6	1
4.8	2	●	MFE0480X02S060	9.6	20	23.6	62	6	1
4.9	2	●	MFE0490X02S060	9.8	20	23.6	62	6	1
5	2	●	MFE0500X02S060	10	20	23.5	62	6	1
5.1	2	●	MFE0510X02S060	10.2	22	25.5	62	6	1
5.2	2	●	MFE0520X02S060	10.4	22	25.4	62	6	1
5.3	2	●	MFE0530X02S060	10.6	22	25.4	62	6	1
5.4	2	●	MFE0540X02S060	10.8	22	25.3	62	6	1
5.5	2	●	MFE0550X02S060	11	22	25.3	62	6	1
5.6	2	●	MFE0560X02S060	11.2	24	27.2	62	6	1
5.7	2	●	MFE0570X02S060	11.4	24	27.2	62	6	1
5.8	2	●	MFE0580X02S060	11.6	24	27.1	62	6	1
5.9	2	●	MFE0590X02S060	11.8	24	27.1	62	6	1

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	DCON	Type
6	2	●	MFE0600X02S060	12	24	27	62	6	1
NEW 6.1	2	●	MFE0610X02S070	12.2	26	29.5	74	7	1
6.1	2	●	MFE0610X02S080	12.2	26	30	74	8	1
NEW 6.2	2	●	MFE0620X02S070	12.4	26	29.4	74	7	1
6.2	2	●	MFE0620X02S080	12.4	26	29.9	74	8	1
NEW 6.3	2	●	MFE0630X02S070	12.6	26	29.4	74	7	1
6.3	2	●	MFE0630X02S080	12.6	26	29.9	74	8	1
NEW 6.4	2	●	MFE0640X02S070	12.8	26	29.3	74	7	1
6.4	2	●	MFE0640X02S080	12.8	26	29.8	74	8	1
NEW 6.5	2	●	MFE0650X02S070	13	26	29.3	74	7	1
6.5	2	●	MFE0650X02S080	13	26	29.8	74	8	1
NEW 6.6	2	●	MFE0660X02S070	13.2	28	31.2	74	7	1
6.6	2	●	MFE0660X02S080	13.2	28	31.7	74	8	1
NEW 6.7	2	●	MFE0670X02S070	13.4	28	31.2	74	7	1
6.7	2	●	MFE0670X02S080	13.4	28	31.7	74	8	1
NEW 6.8	2	●	MFE0680X02S070	13.6	28	31.1	74	7	1
6.8	2	●	MFE0680X02S080	13.6	28	31.6	74	8	1
NEW 6.9	2	●	MFE0690X02S070	13.8	28	31.1	74	7	1
6.9	2	●	MFE0690X02S080	13.8	28	31.6	74	8	1
NEW 7	2	●	MFE0700X02S070	14	28	31	74	7	1
7	2	●	MFE0700X02S080	14	28	31.5	74	8	1
7.1	2	●	MFE0710X02S080	14.2	30	33.5	74	8	1
7.2	2	●	MFE0720X02S080	14.4	30	33.4	74	8	1
7.3	2	●	MFE0730X02S080	14.6	30	33.4	74	8	1
7.4	2	●	MFE0740X02S080	14.8	30	33.3	74	8	1
7.5	2	●	MFE0750X02S080	15	30	33.3	74	8	1
7.6	2	●	MFE0760X02S080	15.2	32	35.2	74	8	1
7.7	2	●	MFE0770X02S080	15.4	32	35.2	74	8	1
7.8	2	●	MFE0780X02S080	15.6	32	35.1	74	8	1
7.9	2	●	MFE0790X02S080	15.8	32	35.1	74	8	1
8	2	●	MFE0800X02S080	16	32	35	74	8	1
8.1	2	●	MFE0810X02S100	16.2	34	38	84	10	1
8.2	2	●	MFE0820X02S100	16.4	34	37.9	84	10	1
8.3	2	●	MFE0830X02S100	16.6	34	37.9	84	10	1
8.4	2	●	MFE0840X02S100	16.8	34	37.8	84	10	1
8.5	2	●	MFE0850X02S100	17	34	37.8	84	10	1
8.6	2	●	MFE0860X02S100	17.2	36	39.7	84	10	1
8.7	2	●	MFE0870X02S100	17.4	36	39.7	84	10	1
8.8	2	●	MFE0880X02S100	17.6	36	39.6	84	10	1
8.9	2	●	MFE0890X02S100	17.8	36	39.6	84	10	1
9	2	●	MFE0900X02S100	18	36	39.5	84	10	1
9.1	2	●	MFE0910X02S100	18.2	38	41.5	84	10	1
9.2	2	●	MFE0920X02S100	18.4	38	41.4	84	10	1
9.3	2	●	MFE0930X02S100	18.6	38	41.4	84	10	1
9.4	2	●	MFE0940X02S100	18.8	38	41.3	84	10	1
9.5	2	●	MFE0950X02S100	19	38	41.3	84	10	1
9.6	2	●	MFE0960X02S100	19.2	40	43.2	84	10	1
9.7	2	●	MFE0970X02S100	19.4	40	43.2	84	10	1

CUTTING CONDITIONS ➤ P019
TECHNICAL DATA ➤ R001

MFE

SOLID CARBIDE FLAT BOTTOM DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm)					Type
				LU	LCF	LH	OAL	DCON	
9.8	2	●	MFE0980X02S100	19.6	40	43.1	84	10	1
9.9	2	●	MFE0990X02S100	19.8	40	43.1	84	10	1
10	2	●	MFE1000X02S100	20	40	43	84	10	1
10.1	2	●	MFE1010X02S120	20.2	42	46	95	12	1
10.2	2	●	MFE1020X02S120	20.4	42	45.9	95	12	1
10.3	2	●	MFE1030X02S120	20.6	42	45.9	95	12	1
10.4	2	●	MFE1040X02S120	20.8	42	45.8	95	12	1
10.5	2	●	MFE1050X02S120	21	42	45.8	95	12	1
10.6	2	●	MFE1060X02S120	21.2	44	47.7	95	12	1
10.7	2	●	MFE1070X02S120	21.4	44	47.7	95	12	1
10.8	2	●	MFE1080X02S120	21.6	44	47.6	95	12	1
10.9	2	●	MFE1090X02S120	21.8	44	47.6	95	12	1
11	2	●	MFE1100X02S120	22	44	47.5	95	12	1
11.1	2	●	MFE1110X02S120	22.2	46	49.5	95	12	1
11.2	2	●	MFE1120X02S120	22.4	46	49.4	95	12	1
11.3	2	●	MFE1130X02S120	22.6	46	49.4	95	12	1
11.4	2	●	MFE1140X02S120	22.8	46	49.3	95	12	1
11.5	2	●	MFE1150X02S120	23	46	49.3	95	12	1
11.6	2	●	MFE1160X02S120	23.2	48	51.2	95	12	1
11.7	2	●	MFE1170X02S120	23.4	48	51.2	95	12	1
11.8	2	●	MFE1180X02S120	23.6	48	51.1	95	12	1
11.9	2	●	MFE1190X02S120	23.8	48	51.1	95	12	1
12	2	●	MFE1200X02S120	24	48	51	95	12	1
12.5	2	●	MFE1250X02S140	25	50	53	102	14	2
13	2	●	MFE1300X02S140	26	52	55	102	14	2
13.5	2	●	MFE1350X02S140	27	54	57	102	14	2
14	2	●	MFE1400X02S140	28	56	59	102	14	2
14.5	2	●	MFE1450X02S160	29	58	61	111	16	2
15	2	●	MFE1500X02S160	30	60	63	111	16	2
15.5	2	●	MFE1550X02S160	31	62	65	111	16	2
16	2	●	MFE1600X02S160	32	64	67	111	16	2
16.5	2	●	MFE1650X02S180	33	66	69	119	18	2
17	2	●	MFE1700X02S180	34	68	71	119	18	2
17.5	2	●	MFE1750X02S180	35	70	73	119	18	2
18	2	●	MFE1800X02S180	36	72	75	119	18	2
18.5	2	●	MFE1850X02S200	37	74	77	127	20	2
19	2	●	MFE1900X02S200	38	76	79	127	20	2
19.5	2	●	MFE1950X02S200	39	78	81	127	20	2
20	2	●	MFE2000X02S200	40	80	83	127	20	2

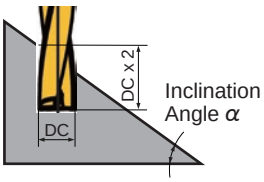
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material		Mild Steel (≤180HB) AISI 1010 etc		Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc		Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc	
Dia. **DC** (mm)	Hole Depth (L/D)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)
0.75	≤2	23300	0.030 (0.010−0.050)	19000	0.030 (0.010−0.050)	16900	0.030 (0.010−0.050)
1.0	≤2	17500	0.030 (0.010−0.050)	14300	0.030 (0.010−0.050)	12700	0.030 (0.010−0.050)
1.5	≤2	12200	0.035 (0.015−0.055)	10000	0.035 (0.015−0.055)	8400	0.035 (0.015−0.050)
2.0	≤2	9500	0.040 (0.020−0.060)	7900	0.040 (0.020−0.060)	6700	0.040 (0.020−0.060)
2.5	≤2	7900	0.050 (0.030−0.070)	6600	0.050 (0.030−0.070)	5700	0.050 (0.030−0.070)
3.0	≤2	7900	0.060 (0.040−0.080)	7900	0.060 (0.040−0.080)	6800	0.060 (0.040−0.080)
4.0	≤2	5900	0.080 (0.060−0.100)	5900	0.080 (0.060−0.100)	5100	0.080 (0.060−0.100)
5.0	≤2	4700	0.100 (0.080−0.130)	4700	0.100 (0.080−0.130)	4100	0.100 (0.080−0.130)
6.0	≤2	3900	0.130 (0.100−0.150)	3900	0.130 (0.100−0.150)	3400	0.130 (0.100−0.150)
8.0	≤2	2900	0.150 (0.130−0.170)	2900	0.150 (0.130−0.170)	2500	0.150 (0.130−0.170)
10.0	≤2	2300	0.170 (0.150−0.200)	2300	0.170 (0.150−0.200)	2000	0.170 (0.150−0.200)
12.0	≤2	1900	0.200 (0.170−0.250)	1900	0.200 (0.170−0.250)	1700	0.200 (0.170−0.250)
16.0	≤2	1400	0.250 (0.200−0.300)	1400	0.250 (0.200−0.300)	1200	0.250 (0.200−0.300)
20.0	≤2	1100	0.300 (0.250−0.350)	1100	0.300 (0.250−0.350)	1000	0.300 (0.250−0.350)

Work Material		Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc		Gray Cast Iron (≤350MPa) No 45 B etc		Ductile Cast Iron (≤450MPa) 60-40-8 etc	
Dia. **DC** (mm)	Hole Depth (L/D)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)
0.75	≤2	10600	0.007 (0.003−0.011)	23300	0.030 (0.010−0.050)	16900	0.010 (0.005−0.015)
1.0	≤2	7900	0.007 (0.003−0.011)	17500	0.030 (0.010−0.050)	12700	0.010 (0.005−0.015)
1.5	≤2	5300	0.010 (0.005−0.015)	12200	0.035 (0.015−0.055)	10000	0.020 (0.010−0.030)
2.0	≤2	4700	0.015 (0.010−0.020)	9500	0.040 (0.020−0.060)	8700	0.030 (0.015−0.045)
2.5	≤2	3800	0.015 (0.010−0.020)	7900	0.050 (0.030−0.070)	7300	0.045 (0.025−0.065)
3.0	≤2	3100	0.020 (0.010−0.030)	7900	0.060 (0.040−0.080)	6800	0.050 (0.040−0.060)
4.0	≤2	2300	0.030 (0.020−0.040)	5900	0.080 (0.060−0.100)	5500	0.060 (0.050−0.080)
5.0	≤2	1900	0.040 (0.030−0.050)	4700	0.100 (0.080−0.120)	4400	0.080 (0.060−0.100)
6.0	≤2	1500	0.050 (0.040−0.060)	3900	0.120 (0.100−0.140)	3700	0.100 (0.080−0.120)
8.0	≤2	1100	0.060 (0.050−0.080)	2900	0.140 (0.120−0.160)	2700	0.120 (0.100−0.150)
10.0	≤2	950	0.080 (0.060−0.100)	2300	0.160 (0.140−0.180)	2200	0.150 (0.120−0.180)
12.0	≤2	790	0.100 (0.080−0.120)	1900	0.180 (0.160−0.200)	1800	0.180 (0.150−0.200)
16.0	≤2	590	0.120 (0.100−0.150)	1400	0.200 (0.180−0.240)	1300	0.200 (0.180−0.250)
20.0	≤2	470	0.150 (0.120−0.200)	1100	0.240 (0.200−0.280)	1100	0.250 (0.200−0.300)

Work Material		Aluminium Alloy (Si<5%)	
Dia. **DC** (mm)	Hole Depth (L/D)	Revolution (min^{-1})	Flat Surface α=0° Feed rate (Min.−Max.) (mm/rev)
0.75	≤2	42400	0.020 (0.010−0.030)
1.0	≤2	31800	0.020 (0.010−0.030)
1.5	≤2	21200	0.020 (0.010−0.030)
2.0	≤2	17500	0.050 (0.030−0.070)
2.5	≤2	14000	0.060 (0.040−0.090)
3.0	≤2	11600	0.060 (0.040−0.090)
4.0	≤2	8700	0.080 (0.060−0.100)
5.0	≤2	7000	0.100 (0.080−0.130)
6.0	≤2	5800	0.130 (0.100−0.160)
8.0	≤2	4300	0.160 (0.130−0.200)
10.0	≤2	3500	0.200 (0.160−0.240)
12.0	≤2	2900	0.240 (0.200−0.280)
16.0	≤2	2100	0.280 (0.240−0.320)
20.0	≤2	1700	0.320 (0.280−0.360)



Note 1) The recommended hole depth is DCx2. This should be the depth from the uppermost surface of the work material when machining on an angled surface. (Refer to diagram)

Note 2) The above cutting table assumes drilling on a flat surface.
For hole drilling on an angled surface, adjust the feed rate in accordance with the inclination angle.
When the inclination angle α is 30° or less, adjust the feed rate to 70% or lower as a guideline.
When the inclination angle α is greater than 30°, adjust the feed rate to 50% or lower as a guideline.

Note 3) This product is a tool intended for hole drilling. It cannot be used for cross-feed machining or helical machining.

MVS Pilot Drill

WSTAR DRILLS

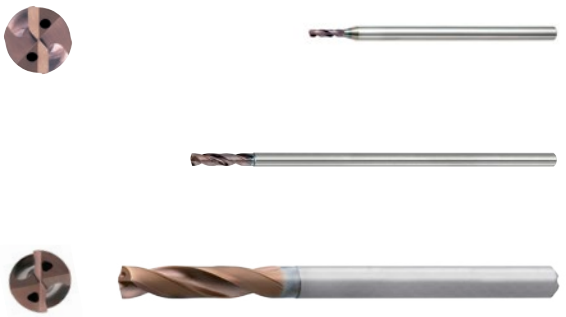
● For cutting a guide hole

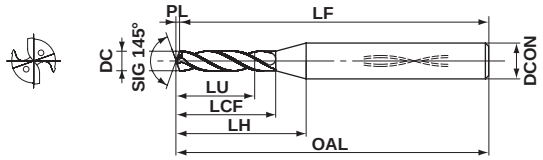
TOOL NEWS

UWC DP1 145° DC<3 DC≥3

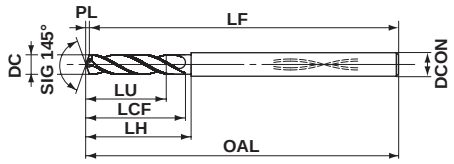
P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	

Internal Coolant





Type1



Type2

	1≤DC≤2.9	DC=3	3<DC≤6	6<DC≤10	10<DC≤14
	+0.014 / 0	0 / −0.014	0 / −0.018	0 / −0.022	0 / −0.027
		DCON=3	3<DCON≤6	6<DCON≤10	10<DCON≤14
h6		0 / −0.006	0 / −0.008	0 / −0.009	0 / −0.011

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.0	2	●	MVS0100X02S030	2.2	5.2	8.9	55.2	55	0.2	3	1
1.1	2	●	MVS0110X02S030	2.4	5.6	9.1	55.2	55	0.2	3	1
1.2	2	●	MVS0120X02S030	2.6	6.2	9.6	55.2	55	0.2	3	1
1.3	2	●	MVS0130X02S030	2.8	6.6	9.8	55.2	55	0.2	3	1
1.4	2	●	MVS0140X02S030	3.0	7.2	10.2	55.2	55	0.2	3	1
1.5	2	●	MVS0150X02S030	3.2	7.6	10.4	55.2	55	0.2	3	1
1.6	2	●	MVS0160X02S030	3.5	8.3	10.9	68.3	68	0.3	3	1
1.7	2	●	MVS0170X02S030	3.7	8.7	11.1	68.3	68	0.3	3	1
1.8	2	●	MVS0180X02S030	3.9	9.3	11.5	68.3	68	0.3	3	1
1.9	2	●	MVS0190X02S030	4.1	9.7	11.8	68.3	68	0.3	3	1
2.0	2	●	MVS0200X02S030	4.3	10.3	12.2	68.3	68	0.3	3	1
2.1	2	●	MVS0210X02S030	4.5	10.7	12.4	74.3	74	0.3	3	1
2.2	2	●	MVS0220X02S030	4.7	11.3	12.8	74.3	74	0.3	3	1
2.3	2	●	MVS0230X02S030	5.0	11.8	13.1	74.4	74	0.4	3	1
2.4	2	●	MVS0240X02S030	5.2	12.4	13.5	74.4	74	0.4	3	1
2.5	2	●	MVS0250X02S030	5.4	12.8	13.7	74.4	74	0.4	3	1
2.6	2	●	MVS0260X02S030	5.6	13.4	13.4	81.4	81	0.4	3	2
2.7	2	●	MVS0270X02S030	5.8	13.8	13.8	81.4	81	0.4	3	2
2.8	2	●	MVS0280X02S030	6.0	14.4	14.4	81.4	81	0.4	3	2
2.9	2	●	MVS0290X02S030	6.3	14.9	14.9	81.5	81	0.5	3	2
3.0	2	●	MVS0300X02S030PL	6.5	16.5	16.5	55.5	55	0.5	3	2
3.1	2	●	MVS0310X02S040PL	6.7	18.5	20.5	55.5	55	0.5	4	1
3.2	2	●	MVS0320X02S040PL	6.9	18.5	20.5	55.5	55	0.5	4	1
3.3	2	●	MVS0330X02S040PL	7.1	18.5	20.5	55.5	55	0.5	4	1
3.4	2	●	MVS0340X02S040PL	7.3	18.5	20.5	55.5	55	0.5	4	1
3.5	2	●	MVS0350X02S040PL	7.6	18.5	20.6	55.6	55	0.6	4	1

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.6	2	●	MVS0360X02S040PL	7.8	20.6	20.6	55.6	55	0.6	4	1
3.7	2	●	MVS0370X02S040PL	8.0	20.6	20.6	55.6	55	0.6	4	1
3.8	2	●	MVS0380X02S040PL	8.2	20.6	20.6	55.6	55	0.6	4	1
3.9	2	●	MVS0390X02S040PL	8.4	20.6	20.6	55.6	55	0.6	4	1
4.0	2	●	MVS0400X02S040PL	8.6	20.6	20.6	55.6	55	0.6	4	2
4.1	2	●	MVS0410X02S050PL	8.8	22.6	24.6	62.6	62	0.6	5	1
4.2	2	●	MVS0420X02S050PL	9.1	22.7	24.7	62.7	62	0.7	5	1
4.3	2	●	MVS0430X02S050PL	9.3	22.7	24.7	62.7	62	0.7	5	1
4.4	2	●	MVS0440X02S050PL	9.5	22.7	24.7	62.7	62	0.7	5	1
4.5	2	●	MVS0450X02S050PL	9.7	22.7	24.7	62.7	62	0.7	5	1
4.6	2	●	MVS0460X02S050PL	9.9	24.7	24.7	62.7	62	0.7	5	2
4.7	2	●	MVS0470X02S050PL	10.1	24.7	24.7	62.7	62	0.7	5	2
4.8	2	●	MVS0480X02S050PL	10.4	24.8	24.8	62.8	62	0.8	5	2
4.9	2	●	MVS0490X02S050PL	10.6	24.8	24.8	62.8	62	0.8	5	2
5.0	2	●	MVS0500X02S050PL	10.8	24.8	24.8	62.8	62	0.8	5	2
5.1	2	●	MVS0510X02S060PL	11.0	26.8	28.8	66.8	66	0.8	6	2
5.2	2	●	MVS0520X02S060PL	11.2	26.8	28.8	66.8	66	0.8	6	2
5.3	2	●	MVS0530X02S060PL	11.4	26.8	28.8	66.8	66	0.8	6	2
5.4	2	●	MVS0540X02S060PL	11.7	26.9	28.9	66.9	66	0.9	6	2
5.5	2	●	MVS0550X02S060PL	11.9	26.9	28.9	66.9	66	0.9	6	2
5.6	2	●	MVS0560X02S060PL	12.1	28.9	28.9	66.9	66	0.9	6	2
5.7	2	●	MVS0570X02S060PL	12.3	28.9	28.9	66.9	66	0.9	6	2
5.8	2	●	MVS0580X02S060PL	12.5	28.9	28.9	66.9	66	0.9	6	2
5.9	2	●	MVS0590X02S060PL	12.7	28.9	28.9	66.9	66	0.9	6	2
6.0	2	●	MVS0600X02S060PL	12.9	28.9	28.9	66.9	66	0.9	6	2
6.1	2	●	MVS0610X02S070PL	13.2	32.0	35.0	75.0	74	1.0	7	2

Note 1) The coolant hole of ø5mm or less will be round shape.

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.2	2	●	MVS0620X02S070PL	13.4	32.0	35.0	75.0	74	1.0	7	2
6.3	2	●	MVS0630X02S070PL	13.6	32.0	35.0	75.0	74	1.0	7	2
6.4	2	●	MVS0640X02S070PL	13.8	32.0	35.0	75.0	74	1.0	7	2
6.5	2	●	MVS0650X02S070PL	14.0	32.0	35.0	75.0	74	1.0	7	2
6.6	2	●	MVS0660X02S070PL	14.2	35.0	35.0	75.0	74	1.0	7	2
6.7	2	●	MVS0670X02S070PL	14.5	35.1	35.1	75.1	74	1.1	7	2
6.8	2	●	MVS0680X02S070PL	14.7	35.1	35.1	75.1	74	1.1	7	2
6.9	2	●	MVS0690X02S070PL	14.9	35.1	35.1	75.1	74	1.1	7	2
7.0	2	●	MVS0700X02S070PL	15.1	35.1	35.1	75.1	74	1.1	7	2
7.1	2	●	MVS0710X02S080PL	15.3	35.1	38.1	80.1	79	1.1	8	2
7.2	2	●	MVS0720X02S080PL	15.5	35.1	38.1	80.1	79	1.1	8	2
7.3	2	●	MVS0730X02S080PL	15.8	35.2	38.2	80.2	79	1.2	8	2
7.4	2	●	MVS0740X02S080PL	16.0	35.2	38.2	80.2	79	1.2	8	2
7.5	2	●	MVS0750X02S080PL	16.2	35.2	38.2	80.2	79	1.2	8	2
7.6	2	●	MVS0760X02S080PL	16.4	38.2	38.2	80.2	79	1.2	8	2
7.7	2	●	MVS0770X02S080PL	16.6	38.2	38.2	80.2	79	1.2	8	2
7.8	2	●	MVS0780X02S080PL	16.8	38.2	38.2	80.2	79	1.2	8	2
7.9	2	●	MVS0790X02S080PL	17.0	38.2	38.2	80.2	79	1.2	8	2
8.0	2	●	MVS0800X02S080PL	17.3	38.3	38.3	80.3	79	1.3	8	2
8.1	2	●	MVS0810X02S090PL	17.5	38.3	41.3	85.3	84	1.3	9	2
8.2	2	●	MVS0820X02S090PL	17.7	38.3	41.3	85.3	84	1.3	9	2
8.3	2	●	MVS0830X02S090PL	17.9	38.3	41.3	85.3	84	1.3	9	2
8.4	2	●	MVS0840X02S090PL	18.1	38.3	41.3	85.3	84	1.3	9	2
8.5	2	●	MVS0850X02S090PL	18.3	38.3	41.3	85.3	84	1.3	9	2
8.6	2	●	MVS0860X02S090PL	18.6	41.4	41.4	85.4	84	1.4	9	2
8.7	2	●	MVS0870X02S090PL	18.8	41.4	41.4	85.4	84	1.4	9	2
8.8	2	●	MVS0880X02S090PL	19.0	41.4	41.4	85.4	84	1.4	9	2
8.9	2	●	MVS0890X02S090PL	19.2	41.4	41.4	85.4	84	1.4	9	2
9.0	2	●	MVS0900X02S090PL	19.4	41.4	41.4	85.4	84	1.4	9	2
9.1	2	●	MVS0910X02S100PL	19.6	41.4	44.4	90.4	89	1.4	10	2
9.2	2	●	MVS0920X02S100PL	19.9	41.5	44.5	90.5	89	1.5	10	2
9.3	2	●	MVS0930X02S100PL	20.1	41.5	44.5	90.5	89	1.5	10	2
9.4	2	●	MVS0940X02S100PL	20.3	41.5	44.5	90.5	89	1.5	10	2
9.5	2	●	MVS0950X02S100PL	20.5	41.5	44.5	90.5	89	1.5	10	2
9.6	2	●	MVS0960X02S100PL	20.7	44.5	44.5	90.5	89	1.5	10	2
9.7	2	●	MVS0970X02S100PL	20.9	44.5	44.5	90.5	89	1.5	10	2
9.8	2	●	MVS0980X02S100PL	21.1	44.5	44.5	90.5	89	1.5	10	2
9.9	2	●	MVS0990X02S100PL	21.4	44.6	44.6	90.6	89	1.6	10	2
10.0	2	●	MVS1000X02S100PL	21.6	44.6	44.6	90.6	89	1.6	10	2
10.1	2	●	MVS1010X02S110PL	21.8	44.6	47.6	96.6	95	1.6	11	2
10.2	2	●	MVS1020X02S110PL	22.0	44.6	47.6	96.6	95	1.6	11	2
10.3	2	●	MVS1030X02S110PL	22.2	44.6	47.6	96.6	95	1.6	11	2
10.4	2	●	MVS1040X02S110PL	22.4	44.6	47.6	96.6	95	1.6	11	2
10.5	2	●	MVS1050X02S110PL	22.7	44.7	47.7	96.7	95	1.7	11	2
10.6	2	●	MVS1060X02S110PL	22.9	48.7	48.7	96.7	95	1.7	11	2
10.7	2	●	MVS1070X02S110PL	23.1	48.7	48.7	96.7	95	1.7	11	2
10.8	2	●	MVS1080X02S110PL	23.3	48.7	48.7	96.7	95	1.7	11	2
10.9	2	●	MVS1090X02S110PL	23.5	48.7	48.7	96.7	95	1.7	11	2

Note 1) The coolant hole of ø5mm or less will be round shape.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.0	2	●	MVS1100X02S110PL	23.7	48.7	48.7	96.7	95	1.7	11	2
11.1	2	●	MVS1110X02S120PL	23.9	48.7	51.7	96.7	95	1.7	12	2
11.2	2	●	MVS1120X02S120PL	24.2	48.8	51.8	96.8	95	1.8	12	2
11.3	2	●	MVS1130X02S120PL	24.4	48.8	51.8	96.8	95	1.8	12	2
11.4	2	●	MVS1140X02S120PL	24.6	48.8	51.8	96.8	95	1.8	12	2
11.5	2	●	MVS1150X02S120PL	24.8	48.8	51.8	96.8	95	1.8	12	2
11.6	2	●	MVS1160X02S120PL	25.0	48.8	48.8	96.8	95	1.8	12	2
11.7	2	●	MVS1170X02S120PL	25.2	48.8	48.8	96.8	95	1.8	12	2
11.8	2	●	MVS1180X02S120PL	25.5	48.9	48.9	96.9	95	1.9	12	2
11.9	2	●	MVS1190X02S120PL	25.7	48.9	48.9	96.9	95	1.9	12	2
12.0	2	●	MVS1200X02S120PL	25.9	48.9	48.9	96.9	95	1.9	12	2
12.1	2	●	MVS1210X02S130PL	26.1	52.9	55.9	103.9	102	1.9	13	2
12.2	2	●	MVS1220X02S130PL	26.3	52.9	55.9	103.9	102	1.9	13	2
12.3	2	●	MVS1230X02S130PL	26.5	52.9	55.9	103.9	102	1.9	13	2
12.4	2	●	MVS1240X02S130PL	26.8	53.0	56.0	104.0	102	2.0	13	2
12.5	2	●	MVS1250X02S130PL	27.0	53.0	56.0	104.0	102	2.0	13	2
12.6	2	●	MVS1260X02S130PL	27.2	53.0	53.0	104.0	102	2.0	13	2
12.7	2	●	MVS1270X02S130PL	27.4	53.0	53.0	104.0	102	2.0	13	2
12.8	2	●	MVS1280X02S130PL	27.6	53.0	53.0	104.0	102	2.0	13	2
12.9	2	●	MVS1290X02S130PL	27.8	53.0	53.0	104.0	102	2.0	13	2
13.0	2	●	MVS1300X02S130PL	28.0	53.0	53.0	104.0	102	2.0	13	2
13.1	2	●	MVS1310X02S140PL	28.3	56.1	59.1	109.1	107	2.1	14	2
13.2	2	●	MVS1320X02S140PL	28.5	56.1	59.1	109.1	107	2.1	14	2
13.3	2	●	MVS1330X02S140PL	28.7	56.1	59.1	109.1	107	2.1	14	2
13.4	2	●	MVS1340X02S140PL	28.9	56.1	59.1	109.1	107	2.1	14	2
13.5	2	●	MVS1350X02S140PL	29.1	56.1	59.1	109.1	107	2.1	14	2
13.6	2	●	MVS1360X02S140PL	29.3	56.1	56.1	109.1	107	2.1	14	2
13.7	2	●	MVS1370X02S140PL	29.6	56.2	56.2	109.2	107	2.2	14	2
13.8	2	●	MVS1380X02S140PL	29.8	56.2	56.2	109.2	107	2.2	14	2
13.9	2	●	MVS1390X02S140PL	30.0	56.2	56.2	109.2	107	2.2	14	2
14.0	2	●	MVS1400X02S140PL	30.2	56.2	56.2	109.2	107	2.2	14	2

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

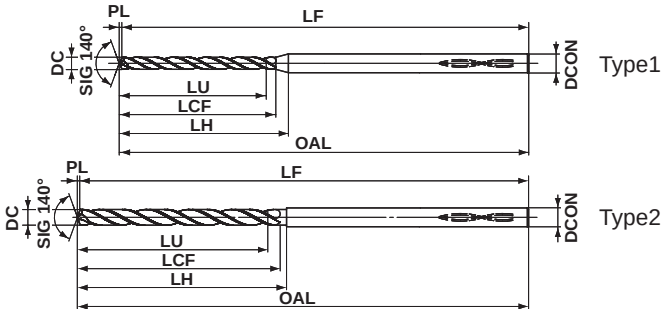
MVS for small diameter WSTAR DRILLS

- Linear tooth profile improves both chip discharge and cutting edge strength.
- Double margin specifications offer optimum balance and high precision with small drills

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	

Internal Coolant



1≤DC≤2.9
0 −0.014
DCON=3
0 −0.006

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.0	7	●	MVS0100X07S030	7.2	10.2	14.2	55.2	55	0.2	3	1
1.0	12	●	MVS0100X12S030	12.2	15.2	19.2	55.2	55	0.2	3	1
1.0	20	●	MVS0100X20S030	20.2	24.2	28.2	60.2	60	0.2	3	1
1.0	25	●	MVS0100X25S030	25.2	28.2	32.2	66.2	66	0.2	3	1
1.0	30	●	MVS0100X30S030	30.2	33.2	37.2	72.2	72	0.2	3	1
1.1	7	●	MVS0110X07S030	7.9	11.2	15.2	55.2	55	0.2	3	1
1.1	12	●	MVS0110X12S030	13.4	17.2	21.2	55.2	55	0.2	3	1
1.1	20	●	MVS0110X20S030	22.2	25.2	29.2	60.2	60	0.2	3	1
1.1	25	●	MVS0110X25S030	27.7	31.2	34.2	66.2	66	0.2	3	1
1.1	30	●	MVS0110X30S030	33.2	36.2	40.2	72.2	72	0.2	3	1
1.2	7	●	MVS0120X07S030	8.6	12.2	15.2	55.2	55	0.2	3	1
1.2	12	●	MVS0120X12S030	14.6	18.2	21.2	55.2	55	0.2	3	1
1.2	20	●	MVS0120X20S030	24.2	28.2	31.2	60.2	60	0.2	3	1
1.2	25	●	MVS0120X25S030	30.2	34.2	37.2	66.2	66	0.2	3	1
1.2	30	●	MVS0120X30S030	36.2	40.2	43.2	72.2	72	0.2	3	1
1.3	7	●	MVS0130X07S030	9.3	13.2	16.2	55.2	55	0.2	3	1
1.3	12	●	MVS0130X12S030	15.8	20.2	23.2	55.2	55	0.2	3	1
1.3	20	●	MVS0130X20S030	26.2	30.2	33.2	68.2	68	0.2	3	1
1.3	25	●	MVS0130X25S030	32.7	36.2	40.2	74.2	74	0.2	3	1
1.3	30	●	MVS0130X30S030	39.2	43.2	46.2	82.2	82	0.2	3	1
1.4	7	●	MVS0140X07S030	10.1	14.3	17.3	55.3	55	0.3	3	1
1.4	12	●	MVS0140X12S030	17.1	21.3	24.3	55.3	55	0.3	3	1
1.4	20	●	MVS0140X20S030	28.3	32.3	35.3	68.3	68	0.3	3	1
1.4	25	●	MVS0140X25S030	35.3	39.3	42.3	74.3	74	0.3	3	1
1.4	30	●	MVS0140X30S030	42.3	46.3	49.3	82.3	82	0.3	3	1
1.5	7	●	MVS0150X07S030	10.8	15.3	18.3	55.3	55	0.3	3	1
1.5	12	●	MVS0150X12S030	18.3	23.3	26.3	55.3	55	0.3	3	1
1.5	20	●	MVS0150X20S030	30.3	35.3	37.3	68.3	68	0.3	3	1
1.5	25	●	MVS0150X25S030	37.8	42.3	45.3	74.3	74	0.3	3	1
1.5	30	●	MVS0150X30S030	45.3	50.3	52.3	82.3	82	0.3	3	1

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.6	7	●	MVS0160X07S030	11.5	16.3	19.3	68.3	68	0.3	3	1
1.6	12	●	MVS0160X12S030	19.5	24.3	27.3	68.3	68	0.3	3	1
1.6	20	●	MVS0160X20S030	32.3	37.3	39.3	78.3	78	0.3	3	1
1.6	25	●	MVS0160X25S030	40.3	45.3	47.3	86.3	86	0.3	3	1
1.6	30	●	MVS0160X30S030	48.3	53.3	55.3	95.3	95	0.3	3	1
1.7	7	●	MVS0170X07S030	12.2	17.3	19.3	68.3	68	0.3	3	1
1.7	12	●	MVS0170X12S030	20.7	26.3	28.3	68.3	68	0.3	3	1
1.7	20	●	MVS0170X20S030	34.3	39.3	42.3	78.3	78	0.3	3	1
1.7	25	●	MVS0170X25S030	42.8	48.3	50.3	86.3	86	0.3	3	1
1.7	30	●	MVS0170X30S030	51.3	56.3	59.3	95.3	95	0.3	3	1
1.8	7	●	MVS0180X07S030	12.9	18.3	20.3	68.3	68	0.3	3	1
1.8	12	●	MVS0180X12S030	21.9	27.3	29.3	68.3	68	0.3	3	1
1.8	20	●	MVS0180X20S030	36.3	41.3	44.3	84.3	84	0.3	3	1
1.8	25	●	MVS0180X25S030	45.3	50.3	53.3	94.3	94	0.3	3	1
1.8	30	●	MVS0180X30S030	54.3	59.3	62.3	102.3	102	0.3	3	1
1.9	7	●	MVS0190X07S030	13.6	19.3	21.3	68.3	68	0.3	3	1
1.9	12	●	MVS0190X12S030	23.1	29.3	31.3	68.3	68	0.3	3	1
1.9	20	●	MVS0190X20S030	38.3	44.3	46.3	84.3	84	0.3	3	1
1.9	25	●	MVS0190X25S030	47.8	53.3	55.3	94.3	94	0.3	3	1
1.9	30	●	MVS0190X30S030	57.3	63.3	65.3	102.3	102	0.3	3	1
2.0	7	●	MVS0200X07S030	14.4	20.4	22.4	68.4	68	0.4	3	1
2.0	12	●	MVS0200X12S030	24.4	30.4	32.4	68.4	68	0.4	3	1
2.0	20	●	MVS0200X20S030	40.4	46.4	48.4	84.4	84	0.4	3	1
2.0	25	●	MVS0200X25S030	50.4	56.4	58.4	94.4	94	0.4	3	1
2.0	30	●	MVS0200X30S030	60.4	66.4	68.4	102.4	102	0.4	3	1
2.1	7	●	MVS0210X07S030	15.1	21.4	23.4	74.4	74	0.4	3	1
2.1	12	●	MVS0210X12S030	25.6	32.4	34.4	74.4	74	0.4	3	1
2.1	20	●	MVS0210X20S030	42.4	48.4	50.4	94.4	94	0.4	3	1
2.1	25	●	MVS0210X25S030	52.9	59.4	60.4	107.4	107	0.4	3	1
2.1	30	●	MVS0210X30S030	63.4	69.4	71.4	118.4	118	0.4	3	1

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
2.2	7	●	MVS0220X07S030	15.8	22.4	23.4	74.4	74	0.4	3	1
2.2	12	●	MVS0220X12S030	26.8	33.4	34.4	74.4	74	0.4	3	1
2.2	20	●	MVS0220X20S030	44.4	51.4	52.4	94.4	94	0.4	3	1
2.2	25	●	MVS0220X25S030	55.4	62.4	63.4	107.4	107	0.4	3	1
2.2	30	●	MVS0220X30S030	66.4	73.4	74.4	118.4	118	0.4	3	1
2.3	7	●	MVS0230X07S030	16.5	23.4	24.4	74.4	74	0.4	3	1
2.3	12	●	MVS0230X12S030	28.0	35.4	36.4	74.4	74	0.4	3	1
2.3	20	●	MVS0230X20S030	46.4	53.4	54.4	94.4	94	0.4	3	1
2.3	25	●	MVS0230X25S030	57.9	64.4	66.4	107.4	107	0.4	3	1
2.3	30	●	MVS0230X30S030	69.4	76.4	77.4	118.4	118	0.4	3	1
2.4	7	●	MVS0240X07S030	17.2	24.4	25.4	74.4	74	0.4	3	1
2.4	12	●	MVS0240X12S030	29.2	36.4	37.4	74.4	74	0.4	3	1
2.4	20	●	MVS0240X20S030	48.4	55.4	56.4	94.4	94	0.4	3	1
2.4	25	●	MVS0240X25S030	60.4	67.4	68.4	107.4	107	0.4	3	1
2.4	30	●	MVS0240X30S030	72.4	79.4	80.4	118.4	118	0.4	3	1
2.5	7	●	MVS0250X07S030	18.0	25.5	26.5	74.5	74	0.5	3	1
2.5	12	●	MVS0250X12S030	30.5	38.5	39.5	74.5	74	0.5	3	1
2.5	20	●	MVS0250X20S030	50.5	58.5	59.5	94.5	94	0.5	3	1
2.5	25	●	MVS0250X25S030	63.0	70.5	71.5	107.5	107	0.5	3	1
2.5	30	●	MVS0250X30S030	75.5	83.5	84.5	118.5	118	0.5	3	1
2.6	7	●	MVS0260X07S030	18.7	26.5	26.5	81.5	81	0.5	3	2
2.6	12	●	MVS0260X12S030	31.7	39.5	39.5	81.5	81	0.5	3	2
2.6	20	●	MVS0260X20S030	52.5	60.5	60.5	103.5	103	0.5	3	2
2.6	25	●	MVS0260X25S030	65.5	73.5	73.5	117.5	117	0.5	3	2
2.6	30	●	MVS0260X30S030	78.5	86.5	86.5	132.5	132	0.5	3	2
2.7	7	●	MVS0270X07S030	19.4	27.5	27.5	81.5	81	0.5	3	2
2.7	12	●	MVS0270X12S030	32.9	41.5	41.5	81.5	81	0.5	3	2
2.7	20	●	MVS0270X20S030	54.5	62.5	62.5	103.5	103	0.5	3	2
2.7	25	●	MVS0270X25S030	68.0	76.5	76.5	117.5	117	0.5	3	2
2.7	30	●	MVS0270X30S030	81.5	89.5	89.5	132.5	132	0.5	3	2
2.8	7	●	MVS0280X07S030	20.1	28.5	28.5	81.5	81	0.5	3	2
2.8	12	●	MVS0280X12S030	34.1	42.5	42.5	81.5	81	0.5	3	2
2.8	20	●	MVS0280X20S030	56.5	64.5	64.5	103.5	103	0.5	3	2
2.8	25	●	MVS0280X25S030	70.5	78.5	78.5	117.5	117	0.5	3	2
2.8	30	●	MVS0280X30S030	84.5	92.5	92.5	132.5	132	0.5	3	2
2.9	7	●	MVS0290X07S030	20.8	29.5	29.5	81.5	81	0.5	3	2
2.9	12	●	MVS0290X12S030	35.3	44.5	44.5	81.5	81	0.5	3	2
2.9	20	●	MVS0290X20S030	58.5	67.5	67.5	103.5	103	0.5	3	2
2.9	25	●	MVS0290X25S030	73.0	81.5	81.5	117.5	117	0.5	3	2
2.9	30	●	MVS0290X30S030	87.5	96.5	96.5	132.5	132	0.5	3	2

CUTTING CONDITIONS ➢ P039
TECHNICAL DATA ➢ R001

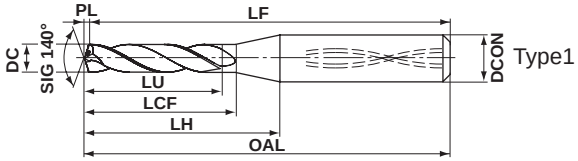
MVS
WSTAR DRILLS

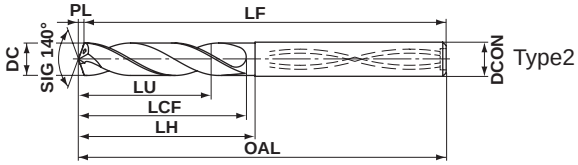
- PVD coated carbide grade DP1020 achieves long life with wide range of work materials
- Unique coolant supply technology, TRI-cooling offers high machining efficiency.

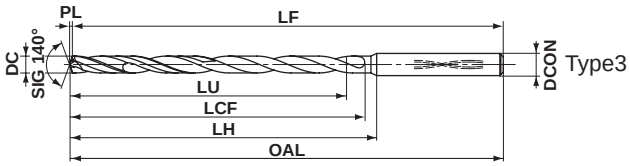
TOOL NEWS

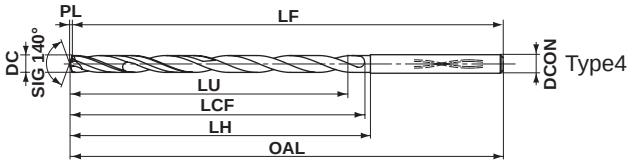
P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	

Internal Coolant









L/D	DC=3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
3,5,8	0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033
L/D≥10	−0.017 −0.031	−0.025 −0.043	−0.033 −0.055	−0.041 −0.068	–
L/D	DCON=3	3<DCON≤6	6<DCON≤10	10<DCON≤18	18<DCON≤20
h6	0 −0.006	0 −0.008	0 −0.009	0 −0.011	0 −0.013

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.0	3	●	MVS0300X03S030	9.5	21.5	21.5	72.5	72	0.5	3	2
3.0	3	●	MVS0300X03S060	9.5	21.5	24.7	72.5	72	0.5	6	1
3.0	5	●	MVS0300X05S030	15.5	28.5	28.5	81.5	81	0.5	3	2
3.0	5	●	MVS0300X05S060	15.5	28.5	31.7	81.5	81	0.5	6	1
3.0	8	●	MVS0300X08S030	24.5	35.5	35.5	81.5	81	0.5	3	2
3.0	8	●	MVS0300X08S060	24.5	35.5	38.7	81.5	81	0.5	6	1
3.0	10	●	MVS0300X10S030	30.5	39.5	42.5	90.5	90	0.5	3	3
3.0	15	●	MVS0300X15S030	45.5	54.5	57.5	105.5	105	0.5	3	3
3.0	20	●	MVS0300X20S030	60.5	69.5	72.5	120.5	120	0.5	3	3
3.0	25	●	MVS0300X25S030	75.5	84.5	87.5	135.5	135	0.5	3	3
3.0	30	●	MVS0300X30S030	90.5	99.5	102.5	150.5	150	0.5	3	3
3.0	35	●	MVS0300X35S030	105.5	115.5	118.5	166.5	166	0.5	3	3
3.0	40	●	MVS0300X40S030	120.5	130.5	133.5	181.5	181	0.5	3	3
3.1	3	●	MVS0310X03S040	9.9	21.6	23.6	76.6	76	0.6	4	2
3.1	3	●	MVS0310X03S060	9.9	21.6	24.7	76.6	76	0.6	6	1
3.1	5	●	MVS0310X05S040	16.1	32.6	32.6	87.6	87	0.6	4	2
3.1	5	●	MVS0310X05S060	16.1	32.6	35.7	87.6	87	0.6	6	1
3.1	8	●	MVS0310X08S040	25.4	41.6	41.6	87.6	87	0.6	4	2
3.1	8	●	MVS0310X08S060	25.4	41.6	44.7	87.6	87	0.6	6	1
3.1	10	●	MVS0310X10S040	31.6	46.6	49.6	97.6	97	0.6	4	3
3.1	15	●	MVS0310X15S040	47.1	63.6	66.6	114.6	114	0.6	4	3
3.1	20	●	MVS0310X20S040	62.6	81.6	84.6	132.6	132	0.6	4	3

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.1	25	●	MVS0310X25S040	78.1	98.6	101.6	149.6	149	0.6	4	3
3.1	30	●	MVS0310X30S040	93.6	116.6	119.6	167.6	167	0.6	4	3
3.1	35	□	MVS0310X35S040	109.1	134.6	137.6	185.6	185	0.6	4	3
3.1	40	□	MVS0310X40S040	124.6	150.6	153.6	201.6	201	0.6	4	3
3.2	3	●	MVS0320X03S040	10.2	21.6	23.6	76.6	76	0.6	4	2
3.2	3	●	MVS0320X03S060	10.2	21.6	24.6	76.6	76	0.6	6	1
3.2	5	●	MVS0320X05S040	16.6	32.6	32.6	87.6	87	0.6	4	2
3.2	5	●	MVS0320X05S060	16.6	32.6	35.6	87.6	87	0.6	6	1
3.2	8	●	MVS0320X08S040	26.2	41.6	41.6	87.6	87	0.6	4	2
3.2	8	●	MVS0320X08S060	26.2	41.6	44.6	87.6	87	0.6	6	1
3.2	10	●	MVS0320X10S040	32.6	46.6	49.6	97.6	97	0.6	4	3
3.2	15	●	MVS0320X15S040	48.6	63.6	66.6	114.6	114	0.6	4	3
3.2	20	●	MVS0320X20S040	64.6	81.6	84.6	132.6	132	0.6	4	3
3.2	25	●	MVS0320X25S040	80.6	98.6	101.6	149.6	149	0.6	4	3
3.2	30	●	MVS0320X30S040	96.6	116.6	119.6	167.6	167	0.6	4	3
3.2	35	□	MVS0320X35S040	112.6	134.6	137.6	185.6	185	0.6	4	3
3.2	40	□	MVS0320X40S040	128.6	150.6	153.6	201.6	201	0.6	4	3
3.3	3	●	MVS0330X03S040	10.5	21.6	23.6	76.6	76	0.6	4	2
3.3	3	●	MVS0330X03S060	10.5	21.6	24.5	76.6	76	0.6	6	1
3.3	5	●	MVS0330X05S040	17.1	32.6	32.6	87.6	87	0.6	4	2
3.3	5	●	MVS0330X05S060	17.1	32.6	35.5	87.6	87	0.6	6	1
3.3	8	●	MVS0330X08S040	27.0	41.6	41.6	87.6	87	0.6	4	2

Note 1) The coolant hole of ø5mm or less will be round shape. (L/D=3,5,8 is ø6mm or less)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.3	8	●	MVS0330X08S060	27.0	41.6	44.5	87.6	87	0.6	6	1
3.3	10	●	MVS0330X10S040	33.6	46.6	49.6	97.6	97	0.6	4	3
3.3	15	●	MVS0330X15S040	50.1	63.6	66.6	114.6	114	0.6	4	3
3.3	20	●	MVS0330X20S040	66.6	81.6	84.6	132.6	132	0.6	4	3
3.3	25	●	MVS0330X25S040	83.1	98.6	101.6	149.6	149	0.6	4	3
3.3	30	●	MVS0330X30S040	99.6	116.6	119.6	167.6	167	0.6	4	3
3.3	35	□	MVS0330X35S040	116.1	134.6	137.6	185.6	185	0.6	4	3
3.3	40	□	MVS0330X40S040	132.6	150.6	153.6	201.6	201	0.6	4	3
3.4	3	●	MVS0340X03S040	10.8	21.6	23.6	76.6	76	0.6	4	2
3.4	3	●	MVS0340X03S060	10.8	21.6	24.4	76.6	76	0.6	6	1
3.4	5	●	MVS0340X05S040	17.6	32.6	32.6	87.6	87	0.6	4	2
3.4	5	●	MVS0340X05S060	17.6	32.6	35.4	87.6	87	0.6	6	1
3.4	8	●	MVS0340X08S040	27.8	41.6	41.6	87.6	87	0.6	4	2
3.4	8	●	MVS0340X08S060	27.8	41.6	44.4	87.6	87	0.6	6	1
3.4	10	●	MVS0340X10S040	34.6	46.6	49.6	97.6	97	0.6	4	3
3.4	15	●	MVS0340X15S040	51.6	63.6	66.6	114.6	114	0.6	4	3
3.4	20	●	MVS0340X20S040	68.6	81.6	84.6	132.6	132	0.6	4	3
3.4	25	●	MVS0340X25S040	85.6	98.6	101.6	149.6	149	0.6	4	3
3.4	30	●	MVS0340X30S040	102.6	116.6	119.6	167.6	167	0.6	4	3
3.4	35	□	MVS0340X35S040	119.6	134.6	137.6	185.6	185	0.6	4	3
3.4	40	□	MVS0340X40S040	136.6	150.6	153.6	201.6	201	0.6	4	3
3.5	3	●	MVS0350X03S040	11.1	21.6	23.6	76.6	76	0.6	4	2
3.5	3	●	MVS0350X03S060	11.1	21.6	24.3	76.6	76	0.6	6	1
3.5	5	●	MVS0350X05S040	18.1	32.6	32.6	87.6	87	0.6	4	2
3.5	5	●	MVS0350X05S060	18.1	32.6	35.3	87.6	87	0.6	6	1
3.5	8	●	MVS0350X08S040	28.6	41.6	41.6	87.6	87	0.6	4	2
3.5	8	●	MVS0350X08S060	28.6	41.6	44.3	87.6	87	0.6	6	1
3.5	10	●	MVS0350X10S040	35.6	46.6	49.6	97.6	97	0.6	4	3
3.5	15	●	MVS0350X15S040	53.1	63.6	66.6	114.6	114	0.6	4	3
3.5	20	●	MVS0350X20S040	70.6	81.6	84.6	132.6	132	0.6	4	3
3.5	25	●	MVS0350X25S040	88.1	98.6	101.6	149.6	149	0.6	4	3
3.5	30	●	MVS0350X30S040	105.6	116.6	119.6	167.6	167	0.6	4	3
3.5	35	●	MVS0350X35S040	123.1	134.6	137.6	185.6	185	0.6	4	3
3.5	40	●	MVS0350X40S040	140.6	150.6	153.6	201.6	201	0.6	4	3
3.6	3	●	MVS0360X03S040	11.5	23.7	23.7	80.7	80	0.7	4	2
3.6	3	●	MVS0360X03S060	11.5	23.7	26.3	80.7	80	0.7	6	1
3.6	5	●	MVS0360X05S040	18.7	36.7	36.7	92.7	92	0.7	4	2
3.6	5	●	MVS0360X05S060	18.7	36.7	39.3	92.7	92	0.7	6	1
3.6	8	●	MVS0360X08S040	29.5	46.7	46.7	92.7	92	0.7	4	2
3.6	8	●	MVS0360X08S060	29.5	46.7	49.3	92.7	92	0.7	6	1
3.6	10	●	MVS0360X10S040	36.7	52.7	55.7	103.7	103	0.7	4	3
3.6	15	●	MVS0360X15S040	54.7	72.7	75.7	123.7	123	0.7	4	3
3.6	20	●	MVS0360X20S040	72.7	92.7	95.7	143.7	143	0.7	4	3
3.6	25	●	MVS0360X25S040	90.7	112.7	115.7	163.7	163	0.7	4	3
3.6	30	●	MVS0360X30S040	108.7	132.7	135.7	183.7	183	0.7	4	3
3.6	35	□	MVS0360X35S040	126.7	152.7	155.7	203.7	203	0.7	4	3
3.6	40	□	MVS0360X40S040	144.7	172.7	175.7	223.7	223	0.7	4	3
3.7	3	●	MVS0370X03S040	11.8	23.7	23.7	80.7	80	0.7	4	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.7	3	●	MVS0370X03S060	11.8	23.7	26.2	80.7	80	0.7	6	1
3.7	5	●	MVS0370X05S040	19.2	36.7	36.7	92.7	92	0.7	4	2
3.7	5	●	MVS0370X05S060	19.2	36.7	39.2	92.7	92	0.7	6	1
3.7	8	●	MVS0370X08S040	30.3	46.7	46.7	92.7	92	0.7	4	2
3.7	8	●	MVS0370X08S060	30.3	46.7	49.2	92.7	92	0.7	6	1
3.7	10	●	MVS0370X10S040	37.7	52.7	55.7	103.7	103	0.7	4	3
3.7	15	●	MVS0370X15S040	56.2	72.7	75.7	123.7	123	0.7	4	3
3.7	20	●	MVS0370X20S040	74.7	92.7	95.7	143.7	143	0.7	4	3
3.7	25	●	MVS0370X25S040	93.2	112.7	115.7	163.7	163	0.7	4	3
3.7	30	●	MVS0370X30S040	111.7	132.7	135.7	183.7	183	0.7	4	3
3.7	35	□	MVS0370X35S040	130.2	152.7	155.7	203.7	203	0.7	4	3
3.7	40	□	MVS0370X40S040	148.7	172.7	175.7	223.7	223	0.7	4	3
3.8	3	●	MVS0380X03S040	12.1	23.7	23.7	80.7	80	0.7	4	2
3.8	3	●	MVS0380X03S060	12.1	23.7	26.1	80.7	80	0.7	6	1
3.8	5	●	MVS0380X05S040	19.7	36.7	36.7	92.7	92	0.7	4	2
3.8	5	●	MVS0380X05S060	19.7	36.7	39.1	92.7	92	0.7	6	1
3.8	8	●	MVS0380X08S040	31.1	46.7	46.7	92.7	92	0.7	4	2
3.8	8	●	MVS0380X08S060	31.1	46.7	49.1	92.7	92	0.7	6	1
3.8	10	●	MVS0380X10S040	38.7	52.7	55.7	103.7	103	0.7	4	3
3.8	15	●	MVS0380X15S040	57.7	72.7	75.7	123.7	123	0.7	4	3
3.8	20	●	MVS0380X20S040	76.7	92.7	95.7	143.7	143	0.7	4	3
3.8	25	●	MVS0380X25S040	95.7	112.7	115.7	163.7	163	0.7	4	3
3.8	30	●	MVS0380X30S040	114.7	132.7	135.7	183.7	183	0.7	4	3
3.8	35	□	MVS0380X35S040	133.7	152.7	155.7	203.7	203	0.7	4	3
3.8	40	□	MVS0380X40S040	152.7	172.7	175.7	223.7	223	0.7	4	3
3.9	3	●	MVS0390X03S040	12.4	23.7	23.7	80.7	80	0.7	4	2
3.9	3	●	MVS0390X03S060	12.4	23.7	26.0	80.7	80	0.7	6	1
3.9	5	●	MVS0390X05S040	20.2	36.7	36.7	92.7	92	0.7	4	2
3.9	5	●	MVS0390X05S060	20.2	36.7	39.0	92.7	92	0.7	6	1
3.9	8	●	MVS0390X08S040	31.9	46.7	46.7	92.7	92	0.7	4	2
3.9	8	●	MVS0390X08S060	31.9	46.7	49.0	92.7	92	0.7	6	1
3.9	10	●	MVS0390X10S040	39.7	52.7	55.7	103.7	103	0.7	4	3
3.9	15	●	MVS0390X15S040	59.2	72.7	75.7	123.7	123	0.7	4	3
3.9	20	●	MVS0390X20S040	78.7	92.7	95.7	143.7	143	0.7	4	3
3.9	25	●	MVS0390X25S040	98.2	112.7	115.7	163.7	163	0.7	4	3
3.9	30	●	MVS0390X30S040	117.7	132.7	135.7	183.7	183	0.7	4	3
3.9	35	□	MVS0390X35S040	137.2	152.7	155.7	203.7	203	0.7	4	3
3.9	40	□	MVS0390X40S040	156.7	172.7	175.7	223.7	223	0.7	4	3
4.0	3	●	MVS0400X03S040	12.7	23.7	23.7	80.7	80	0.7	4	2
4.0	3	●	MVS0400X03S060	12.7	23.7	25.8	80.7	80	0.7	6	1
4.0	5	●	MVS0400X05S040	20.7	36.7	36.7	92.7	92	0.7	4	2
4.0	5	●	MVS0400X05S060	20.7	36.7	38.8	92.7	92	0.7	6	1
4.0	8	●	MVS0400X08S040	32.7	46.7	46.7	92.7	92	0.7	4	2
4.0	8	●	MVS0400X08S060	32.7	46.7	48.8	92.7	92	0.7	6	1
4.0	10	●	MVS0400X10S040	40.7	52.7	55.7	103.7	103	0.7	4	3
4.0	15	●	MVS0400X15S040	60.7	72.7	75.7	123.7	123	0.7	4	3
4.0	20	●	MVS0400X20S040	80.7	92.7	95.7	143.7	143	0.7	4	3
4.0	25	●	MVS0400X25S040	100.7	112.7	115.7	163.7	163	0.7	4	3

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.0	30	●	MVS0400X30S040	120.7	132.7	135.7	183.7	183	0.7	4	3
4.0	35	●	MVS0400X35S040	140.7	152.7	155.7	203.7	203	0.7	4	3
4.0	40	●	MVS0400X40S040	160.7	172.7	175.7	223.7	223	0.7	4	3
4.1	3	●	MVS0410X03S050	13.0	25.7	25.7	86.7	86	0.7	5	2
4.1	3	●	MVS0410X03S060	13.0	25.7	27.7	86.7	86	0.7	6	1
4.1	5	●	MVS0410X05S050	21.2	40.7	40.7	100.7	100	0.7	5	2
4.1	5	●	MVS0410X05S060	21.2	40.7	42.7	100.7	100	0.7	6	1
4.1	8	●	MVS0410X08S050	33.5	52.7	52.7	100.7	100	0.7	5	2
4.1	8	●	MVS0410X08S060	33.5	52.7	54.7	100.7	100	0.7	6	1
4.1	10	●	MVS0410X10S050	41.7	59.7	62.7	112.7	112	0.7	5	3
4.1	15	●	MVS0410X15S050	62.2	81.7	84.7	134.7	134	0.7	5	3
4.1	20	●	MVS0410X20S050	82.7	104.7	107.7	157.7	157	0.7	5	3
4.1	25	●	MVS0410X25S050	103.2	126.7	129.7	179.7	179	0.7	5	3
4.1	30	●	MVS0410X30S050	123.7	149.7	152.7	202.7	202	0.7	5	3
4.1	35	□	MVS0410X35S050	144.2	171.7	174.7	224.7	224	0.7	5	3
4.1	40	□	MVS0410X40S050	164.7	195.7	198.7	248.7	248	0.7	5	3
4.2	3	●	MVS0420X03S050	13.4	25.8	25.8	86.8	86	0.8	5	2
4.2	3	●	MVS0420X03S060	13.4	25.8	27.7	86.8	86	0.8	6	1
4.2	5	●	MVS0420X05S050	21.8	40.8	40.8	100.8	100	0.8	5	2
4.2	5	●	MVS0420X05S060	21.8	40.8	42.7	100.8	100	0.8	6	1
4.2	8	●	MVS0420X08S050	34.4	52.8	52.8	100.8	100	0.8	5	2
4.2	8	●	MVS0420X08S060	34.4	52.8	54.7	100.8	100	0.8	6	1
4.2	10	●	MVS0420X10S050	42.8	59.8	62.8	112.8	112	0.8	5	3
4.2	15	●	MVS0420X15S050	63.8	81.8	84.8	134.8	134	0.8	5	3
4.2	20	●	MVS0420X20S050	84.8	104.8	107.8	157.8	157	0.8	5	3
4.2	25	●	MVS0420X25S050	105.8	126.8	129.8	179.8	179	0.8	5	3
4.2	30	●	MVS0420X30S050	126.8	149.8	152.8	202.8	202	0.8	5	3
4.2	35	□	MVS0420X35S050	147.8	171.8	174.8	224.8	224	0.8	5	3
4.2	40	□	MVS0420X40S050	168.8	195.8	198.8	248.8	248	0.8	5	3
4.3	3	●	MVS0430X03S050	13.7	25.8	25.8	86.8	86	0.8	5	2
4.3	3	●	MVS0430X03S060	13.7	25.8	27.6	86.8	86	0.8	6	1
4.3	5	●	MVS0430X05S050	22.3	40.8	40.8	100.8	100	0.8	5	2
4.3	5	●	MVS0430X05S060	22.3	40.8	42.6	100.8	100	0.8	6	1
4.3	8	●	MVS0430X08S050	35.2	52.8	52.8	100.8	100	0.8	5	2
4.3	8	●	MVS0430X08S060	35.2	52.8	54.6	100.8	100	0.8	6	1
4.3	10	●	MVS0430X10S050	43.8	59.8	62.8	112.8	112	0.8	5	3
4.3	15	●	MVS0430X15S050	65.3	81.8	84.8	134.8	134	0.8	5	3
4.3	20	●	MVS0430X20S050	86.8	104.8	107.8	157.8	157	0.8	5	3
4.3	25	●	MVS0430X25S050	108.3	126.8	129.8	179.8	179	0.8	5	3
4.3	30	●	MVS0430X30S050	129.8	149.8	152.8	202.8	202	0.8	5	3
4.3	35	□	MVS0430X35S050	151.3	171.8	174.8	224.8	224	0.8	5	3
4.3	40	□	MVS0430X40S050	172.8	195.8	198.8	248.8	248	0.8	5	3
4.4	3	●	MVS0440X03S050	14.0	25.8	25.8	86.8	86	0.8	5	2
4.4	3	●	MVS0440X03S060	14.0	25.8	27.5	86.8	86	0.8	6	1
4.4	5	●	MVS0440X05S050	22.8	40.8	40.8	100.8	100	0.8	5	2
4.4	5	●	MVS0440X05S060	22.8	40.8	42.5	100.8	100	0.8	6	1
4.4	8	●	MVS0440X08S050	36.0	52.8	52.8	100.8	100	0.8	5	2
4.4	8	●	MVS0440X08S060	36.0	52.8	54.5	100.8	100	0.8	6	1

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.4	10	●	MVS0440X10S050	44.8	59.8	62.8	112.8	112	0.8	5	3
4.4	15	●	MVS0440X15S050	66.8	81.8	84.8	134.8	134	0.8	5	3
4.4	20	●	MVS0440X20S050	88.8	104.8	107.8	157.8	157	0.8	5	3
4.4	25	●	MVS0440X25S050	110.8	126.8	129.8	179.8	179	0.8	5	3
4.4	30	●	MVS0440X30S050	132.8	149.8	152.8	202.8	202	0.8	5	3
4.4	35	□	MVS0440X35S050	154.8	171.8	174.8	224.8	224	0.8	5	3
4.4	40	□	MVS0440X40S050	176.8	195.8	198.8	248.8	248	0.8	5	3
4.5	3	●	MVS0450X03S050	14.3	25.8	25.8	86.8	86	0.8	5	2
4.5	3	●	MVS0450X03S060	14.3	25.8	27.4	86.8	86	0.8	6	1
4.5	5	●	MVS0450X05S050	23.3	40.8	40.8	100.8	100	0.8	5	2
4.5	5	●	MVS0450X05S060	23.3	40.8	42.4	100.8	100	0.8	6	1
4.5	8	●	MVS0450X08S050	36.8	52.8	52.8	100.8	100	0.8	5	2
4.5	8	●	MVS0450X08S060	36.8	52.8	54.4	100.8	100	0.8	6	1
4.5	10	●	MVS0450X10S050	45.8	59.8	62.8	112.8	112	0.8	5	3
4.5	15	●	MVS0450X15S050	68.3	81.8	84.8	134.8	134	0.8	5	3
4.5	20	●	MVS0450X20S050	90.8	104.8	107.8	157.8	157	0.8	5	3
4.5	25	●	MVS0450X25S050	113.3	126.8	129.8	179.8	179	0.8	5	3
4.5	30	●	MVS0450X30S050	135.8	149.8	152.8	202.8	202	0.8	5	3
4.5	35	●	MVS0450X35S050	158.3	171.8	174.8	224.8	224	0.8	5	3
4.5	40	●	MVS0450X40S050	180.8	195.8	198.8	248.8	248	0.8	5	3
4.6	3	●	MVS0460X03S050	14.6	28.3	28.3	90.8	90	0.8	5	2
4.6	3	●	MVS0460X03S060	14.6	28.3	31.3	90.8	90	0.8	6	2
4.6	5	●	MVS0460X05S050	23.8	44.8	44.8	105.8	105	0.8	5	2
4.6	5	●	MVS0460X05S060	23.8	44.8	47.8	105.8	105	0.8	6	2
4.6	8	●	MVS0460X08S050	37.6	57.8	57.8	105.8	105	0.8	5	2
4.6	8	●	MVS0460X08S060	37.6	57.8	60.8	105.8	105	0.8	6	2
4.6	10	●	MVS0460X10S050	46.8	65.8	68.8	118.8	118	0.8	5	4
4.6	15	●	MVS0460X15S050	69.8	90.8	93.8	143.8	143	0.8	5	4
4.6	20	●	MVS0460X20S050	92.8	115.8	118.8	168.8	168	0.8	5	4
4.6	25	●	MVS0460X25S050	115.8	140.8	143.8	193.8	193	0.8	5	4
4.6	30	●	MVS0460X30S050	138.8	165.8	168.8	218.8	218	0.8	5	4
4.6	35	□	MVS0460X35S050	161.8	190.8	193.8	243.8	243	0.8	5	4
4.6	40	□	MVS0460X40S050	184.8	215.8	218.8	268.8	268	0.8	5	4
4.7	3	●	MVS0470X03S050	15.0	28.4	28.4	90.9	90	0.9	5	2
4.7	3	●	MVS0470X03S060	15.0	28.4	31.4	90.9	90	0.9	6	2
4.7	5	●	MVS0470X05S050	24.4	44.9	44.9	105.9	105	0.9	5	2
4.7	5	●	MVS0470X05S060	24.4	44.9	47.9	105.9	105	0.9	6	2
4.7	8	●	MVS0470X08S050	38.5	57.9	57.9	105.9	105	0.9	5	2
4.7	8	●	MVS0470X08S060	38.5	57.9	60.9	105.9	105	0.9	6	2
4.7	10	●	MVS0470X10S050	47.9	65.9	68.9	118.9	118	0.9	5	4
4.7	15	●	MVS0470X15S050	71.4	90.9	93.9	143.9	143	0.9	5	4
4.7	20	●	MVS0470X20S050	94.9	115.9	118.9	168.9	168	0.9	5	4
4.7	25	●	MVS0470X25S050	118.4	140.9	143.9	193.9	193	0.9	5	4
4.7	30	●	MVS0470X30S050	141.9	165.9	168.9	218.9	218	0.9	5	4
4.7	35	□	MVS0470X35S050	165.4	190.9	193.9	243.9	243	0.9	5	4
4.7	40	□	MVS0470X40S050	188.9	215.9	218.9	268.9	268	0.9	5	4
4.8	3	●	MVS0480X03S050	15.3	28.4	28.4	90.9	90	0.9	5	2
4.8	3	●	MVS0480X03S060	15.3	28.4	31.4	90.9	90	0.9	6	2

Note 1) The coolant hole of ø5mm or less will be round shape. (L/D=3,5,8 is ø6mm or less)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.8	5	●	MVS0480X05S050	24.9	44.9	44.9	105.9	105	0.9	5	2
4.8	5	●	MVS0480X05S060	24.9	44.9	47.9	105.9	105	0.9	6	2
4.8	8	●	MVS0480X08S050	39.3	57.9	57.9	105.9	105	0.9	5	2
4.8	8	●	MVS0480X08S060	39.3	57.9	60.9	105.9	105	0.9	6	2
4.8	10	●	MVS0480X10S050	48.9	65.9	68.9	118.9	118	0.9	5	4
4.8	15	●	MVS0480X15S050	72.9	90.9	93.9	143.9	143	0.9	5	4
4.8	20	●	MVS0480X20S050	96.9	115.9	118.9	168.9	168	0.9	5	4
4.8	25	●	MVS0480X25S050	120.9	140.9	143.9	193.9	193	0.9	5	4
4.8	30	●	MVS0480X30S050	144.9	165.9	168.9	218.9	218	0.9	5	4
4.8	35	□	MVS0480X35S050	168.9	190.9	193.9	243.9	243	0.9	5	4
4.8	40	□	MVS0480X40S050	192.9	215.9	218.9	268.9	268	0.9	5	4
4.9	3	●	MVS0490X03S050	15.6	28.4	28.4	90.9	90	0.9	5	2
4.9	3	●	MVS0490X03S060	15.6	28.4	31.4	90.9	90	0.9	6	2
4.9	5	●	MVS0490X05S050	25.4	44.9	44.9	105.9	105	0.9	5	2
4.9	5	●	MVS0490X05S060	25.4	44.9	47.9	105.9	105	0.9	6	2
4.9	8	●	MVS0490X08S050	40.1	57.9	57.9	105.9	105	0.9	5	2
4.9	8	●	MVS0490X08S060	40.1	57.9	60.9	105.9	105	0.9	6	2
4.9	10	●	MVS0490X10S050	49.9	65.9	68.9	118.9	118	0.9	5	4
4.9	15	●	MVS0490X15S050	74.4	90.9	93.9	143.9	143	0.9	5	4
4.9	20	●	MVS0490X20S050	98.9	115.9	118.9	168.9	168	0.9	5	4
4.9	25	●	MVS0490X25S050	123.4	140.9	143.9	193.9	193	0.9	5	4
4.9	30	●	MVS0490X30S050	147.9	165.9	168.9	218.9	218	0.9	5	4
4.9	35	□	MVS0490X35S050	172.4	190.9	193.9	243.9	243	0.9	5	4
4.9	40	□	MVS0490X40S050	196.9	215.9	218.9	268.9	268	0.9	5	4
5.0	3	●	MVS0500X03S050	15.9	28.4	28.4	90.9	90	0.9	5	2
5.0	3	●	MVS0500X03S060	15.9	28.4	31.4	90.9	90	0.9	6	2
5.0	5	●	MVS0500X05S050	25.9	44.9	44.9	105.9	105	0.9	5	2
5.0	5	●	MVS0500X05S060	25.9	44.9	47.9	105.9	105	0.9	6	2
5.0	8	●	MVS0500X08S050	40.9	57.9	57.9	105.9	105	0.9	5	2
5.0	8	●	MVS0500X08S060	40.9	57.9	60.9	105.9	105	0.9	6	2
5.0	10	●	MVS0500X10S050	50.9	65.9	68.9	118.9	118	0.9	5	4
5.0	15	●	MVS0500X15S050	75.9	90.9	93.9	143.9	143	0.9	5	4
5.0	20	●	MVS0500X20S050	100.9	115.9	118.9	168.9	168	0.9	5	4
5.0	25	●	MVS0500X25S050	125.9	140.9	143.9	193.9	193	0.9	5	4
5.0	30	●	MVS0500X30S050	150.9	165.9	168.9	218.9	218	0.9	5	4
5.0	35	●	MVS0500X35S050	175.9	190.9	193.9	243.9	243	0.9	5	4
5.0	40	●	MVS0500X40S050	200.9	215.9	218.9	268.9	268	0.9	5	4
5.1	3	●	MVS0510X03S060	16.2	28.4	30.9	82.9	82	0.9	6	2
5.1	5	●	MVS0510X05S060	26.4	44.9	48.9	100.9	100	0.9	6	2
5.1	8	●	MVS0510X08S060	41.7	61.9	66.9	118.9	118	0.9	6	2
5.1	10	●	MVS0510X10S060	51.9	72.9	75.9	127.9	127	0.9	6	4
5.1	15	●	MVS0510X15S060	77.4	99.9	102.9	154.9	154	0.9	6	4
5.1	20	●	MVS0510X20S060	102.9	127.9	130.9	182.9	182	0.9	6	4
5.1	25	●	MVS0510X25S060	128.4	154.9	157.9	209.9	209	0.9	6	4
5.1	30	●	MVS0510X30S060	153.9	182.9	185.9	237.9	237	0.9	6	4
5.1	35	□	MVS0510X35S060	179.4	209.9	212.9	264.9	264	0.9	6	4
5.1	40	□	MVS0510X40S060	204.9	240.9	243.9	295.9	295	0.9	6	4
5.2	3	●	MVS0520X03S060	16.5	28.4	30.9	82.9	82	0.9	6	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
5.2	5	●	MVS0520X05S060	26.9	44.9	48.9	100.9	100	0.9	6	2
5.2	8	●	MVS0520X08S060	42.5	61.9	66.9	118.9	118	0.9	6	2
5.2	10	●	MVS0520X10S060	52.9	72.9	75.9	127.9	127	0.9	6	4
5.2	15	●	MVS0520X15S060	78.9	99.9	102.9	154.9	154	0.9	6	4
5.2	20	●	MVS0520X20S060	104.9	127.9	130.9	182.9	182	0.9	6	4
5.2	25	●	MVS0520X25S060	130.9	154.9	157.9	209.9	209	0.9	6	4
5.2	30	●	MVS0520X30S060	156.9	182.9	185.9	237.9	237	0.9	6	4
5.2	35	□	MVS0520X35S060	182.9	209.9	212.9	264.9	264	0.9	6	4
5.2	40	□	MVS0520X40S060	208.9	240.9	243.9	295.9	295	0.9	6	4
5.3	3	●	MVS0530X03S060	16.9	28.5	31.0	83.0	82	1.0	6	2
5.3	5	●	MVS0530X05S060	27.5	45.0	49.0	101.0	100	1.0	6	2
5.3	8	●	MVS0530X08S060	43.4	62.0	67.0	119.0	118	1.0	6	2
5.3	10	●	MVS0530X10S060	54.0	73.0	76.0	128.0	127	1.0	6	4
5.3	15	●	MVS0530X15S060	80.5	100.0	103.0	155.0	154	1.0	6	4
5.3	20	●	MVS0530X20S060	107.0	128.0	131.0	183.0	182	1.0	6	4
5.3	25	●	MVS0530X25S060	133.5	155.0	158.0	210.0	209	1.0	6	4
5.3	30	●	MVS0530X30S060	160.0	183.0	186.0	238.0	237	1.0	6	4
5.3	35	□	MVS0530X35S060	186.5	210.0	213.0	265.0	264	1.0	6	4
5.3	40	□	MVS0530X40S060	213.0	241.0	244.0	296.0	295	1.0	6	4
5.4	3	●	MVS0540X03S060	17.2	28.5	31.0	83.0	82	1.0	6	2
5.4	5	●	MVS0540X05S060	28.0	45.0	49.0	101.0	100	1.0	6	2
5.4	8	●	MVS0540X08S060	44.2	62.0	67.0	119.0	118	1.0	6	2
5.4	10	●	MVS0540X10S060	55.0	73.0	76.0	128.0	127	1.0	6	4
5.4	15	●	MVS0540X15S060	82.0	100.0	103.0	155.0	154	1.0	6	4
5.4	20	●	MVS0540X20S060	109.0	128.0	131.0	183.0	182	1.0	6	4
5.4	25	●	MVS0540X25S060	136.0	155.0	158.0	210.0	209	1.0	6	4
5.4	30	●	MVS0540X30S060	163.0	183.0	186.0	238.0	237	1.0	6	4
5.4	35	□	MVS0540X35S060	190.0	210.0	213.0	265.0	264	1.0	6	4
5.4	40	□	MVS0540X40S060	217.0	241.0	244.0	296.0	295	1.0	6	4
5.5	3	●	MVS0550X03S060	17.5	28.5	31.0	83.0	82	1.0	6	2
5.5	5	●	MVS0550X05S060	28.5	45.0	49.0	101.0	100	1.0	6	2
5.5	8	●	MVS0550X08S060	45.0	62.0	67.0	119.0	118	1.0	6	2
5.5	10	●	MVS0550X10S060	56.0	73.0	76.0	128.0	127	1.0	6	4
5.5	15	●	MVS0550X15S060	83.5	100.0	103.0	155.0	154	1.0	6	4
5.5	20	●	MVS0550X20S060	111.0	128.0	131.0	183.0	182	1.0	6	4
5.5	25	●	MVS0550X25S060	138.5	155.0	158.0	210.0	209	1.0	6	4
5.5	30	●	MVS0550X30S060	166.0	183.0	186.0	238.0	237	1.0	6	4
5.5	35	●	MVS0550X35S060	193.5	210.0	213.0	265.0	264	1.0	6	4
5.5	40	●	MVS0550X40S060	221.0	241.0	244.0	296.0	295	1.0	6	4
5.6	3	●	MVS0560X03S060	17.8	31.0	31.0	83.0	82	1.0	6	2
5.6	5	●	MVS0560X05S060	29.0	49.0	49.0	101.0	100	1.0	6	2
5.6	8	●	MVS0560X08S060	45.8	67.0	67.0	119.0	118	1.0	6	2
5.6	10	●	MVS0560X10S060	57.0	79.0	82.0	134.0	133	1.0	6	4
5.6	15	●	MVS0560X15S060	85.0	109.0	112.0	164.0	163	1.0	6	4
5.6	20	●	MVS0560X20S060	113.0	139.0	142.0	194.0	193	1.0	6	4
5.6	25	●	MVS0560X25S060	141.0	169.0	172.0	224.0	223	1.0	6	4
5.6	30	●	MVS0560X30S060	169.0	199.0	202.0	254.0	253	1.0	6	4
5.6	35	□	MVS0560X35S060	197.0	229.0	232.0	284.0	283	1.0	6	4

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
5.6	40	□	MVS0560X40S060	225.0	261.0	264.0	316.0	315	1.0	6	4
5.7	3	●	MVS0570X03S060	18.1	31.0	31.0	83.0	82	1.0	6	2
5.7	5	●	MVS0570X05S060	29.5	49.0	49.0	101.0	100	1.0	6	2
5.7	8	●	MVS0570X08S060	46.6	67.0	67.0	119.0	118	1.0	6	2
5.7	10	●	MVS0570X10S060	58.0	79.0	82.0	134.0	133	1.0	6	4
5.7	15	●	MVS0570X15S060	86.5	109.0	112.0	164.0	163	1.0	6	4
5.7	20	●	MVS0570X20S060	115.0	139.0	142.0	194.0	193	1.0	6	4
5.7	25	●	MVS0570X25S060	143.5	169.0	172.0	224.0	223	1.0	6	4
5.7	30	●	MVS0570X30S060	172.0	199.0	202.0	254.0	253	1.0	6	4
5.7	35	□	MVS0570X35S060	200.5	229.0	232.0	284.0	283	1.0	6	4
5.7	40	□	MVS0570X40S060	229.0	261.0	264.0	316.0	315	1.0	6	4
5.8	3	●	MVS0580X03S060	18.5	31.1	31.1	83.1	82	1.1	6	2
5.8	5	●	MVS0580X05S060	30.1	49.1	49.1	101.1	100	1.1	6	2
5.8	8	●	MVS0580X08S060	47.5	67.1	67.1	119.1	118	1.1	6	2
5.8	10	●	MVS0580X10S060	59.1	79.1	82.1	134.1	133	1.1	6	4
5.8	15	●	MVS0580X15S060	88.1	109.1	112.1	164.1	163	1.1	6	4
5.8	20	●	MVS0580X20S060	117.1	139.1	142.1	194.1	193	1.1	6	4
5.8	25	●	MVS0580X25S060	146.1	169.1	172.1	224.1	223	1.1	6	4
5.8	30	●	MVS0580X30S060	175.1	199.1	202.1	254.1	253	1.1	6	4
5.8	35	□	MVS0580X35S060	204.1	229.1	232.1	284.1	283	1.1	6	4
5.8	40	□	MVS0580X40S060	233.1	261.1	264.1	316.1	315	1.1	6	4
5.9	3	●	MVS0590X03S060	18.8	31.1	31.1	83.1	82	1.1	6	2
5.9	5	●	MVS0590X05S060	30.6	49.1	49.1	101.1	100	1.1	6	2
5.9	8	●	MVS0590X08S060	48.3	67.1	67.1	119.1	118	1.1	6	2
5.9	10	●	MVS0590X10S060	60.1	79.1	82.1	134.1	133	1.1	6	4
5.9	15	●	MVS0590X15S060	89.6	109.1	112.1	164.1	163	1.1	6	4
5.9	20	●	MVS0590X20S060	119.1	139.1	142.1	194.1	193	1.1	6	4
5.9	25	●	MVS0590X25S060	148.6	169.1	172.1	224.1	223	1.1	6	4
5.9	30	●	MVS0590X30S060	178.1	199.1	202.1	254.1	253	1.1	6	4
5.9	35	□	MVS0590X35S060	207.6	229.1	232.1	284.1	283	1.1	6	4
5.9	40	□	MVS0590X40S060	237.1	261.1	264.1	316.1	315	1.1	6	4
6.0	3	●	MVS0600X03S060	19.1	31.1	31.1	83.1	82	1.1	6	2
6.0	5	●	MVS0600X05S060	31.1	49.1	49.1	101.1	100	1.1	6	2
6.0	8	●	MVS0600X08S060	49.1	67.1	67.1	119.1	118	1.1	6	2
6.0	10	●	MVS0600X10S060	61.1	79.1	82.1	134.1	133	1.1	6	4
6.0	15	●	MVS0600X15S060	91.1	109.1	112.1	164.1	163	1.1	6	4
6.0	20	●	MVS0600X20S060	121.1	139.1	142.1	194.1	193	1.1	6	4
6.0	25	●	MVS0600X25S060	151.1	169.1	172.1	224.1	223	1.1	6	4
6.0	30	●	MVS0600X30S060	181.1	199.1	202.1	254.1	253	1.1	6	4
6.0	35	●	MVS0600X35S060	211.1	229.1	232.1	284.1	283	1.1	6	4
6.0	40	●	MVS0600X40S060	241.1	261.1	264.1	316.1	315	1.1	6	4
6.1	3	●	MVS0610X03S070	19.4	33.6	36.1	89.1	88	1.1	7	2
6.1	3	●	MVS0610X03S080	19.4	33.6	36.1	89.1	88	1.1	8	2
6.1	5	●	MVS0610X05S070	31.6	53.1	57.1	110.1	109	1.1	7	2
6.1	5	●	MVS0610X05S080	31.6	53.1	57.1	110.1	109	1.1	8	2
6.1	8	●	MVS0610X08S070	49.9	73.1	78.1	131.1	130	1.1	7	2
6.1	8	●	MVS0610X08S080	49.9	73.1	78.1	131.1	130	1.1	8	2
6.1	10	●	MVS0610X10S070	62.1	86.1	89.1	142.1	141	1.1	7	4

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.1	15	●	MVS0610X15S070	92.6	118.1	121.1	174.1	173	1.1	7	4
6.1	20	●	MVS0610X20S070	123.1	151.1	154.1	207.1	206	1.1	7	4
6.1	25	●	MVS0610X25S070	153.6	183.1	186.1	239.1	238	1.1	7	4
6.1	30	●	MVS0610X30S070	184.1	216.1	219.1	272.1	271	1.1	7	4
6.1	35	□	MVS0610X35S070	214.6	248.1	253.1	306.1	305	1.1	7	4
6.1	40	□	MVS0610X40S070	245.1	281.1	284.1	337.1	336	1.1	7	4
6.2	3	●	MVS0620X03S070	19.7	33.6	36.1	89.1	88	1.1	7	2
6.2	3	●	MVS0620X03S080	19.7	33.6	36.1	89.1	88	1.1	8	2
6.2	5	●	MVS0620X05S070	32.1	53.1	57.1	110.1	109	1.1	7	2
6.2	5	●	MVS0620X05S080	32.1	53.1	57.1	110.1	109	1.1	8	2
6.2	8	●	MVS0620X08S070	50.7	73.1	78.1	131.1	130	1.1	7	2
6.2	8	●	MVS0620X08S080	50.7	73.1	78.1	131.1	130	1.1	8	2
6.2	10	●	MVS0620X10S070	63.1	86.1	89.1	142.1	141	1.1	7	4
6.2	15	●	MVS0620X15S070	94.1	118.1	121.1	174.1	173	1.1	7	4
6.2	20	●	MVS0620X20S070	125.1	151.1	154.1	207.1	206	1.1	7	4
6.2	25	●	MVS0620X25S070	156.1	183.1	186.1	239.1	238	1.1	7	4
6.2	30	●	MVS0620X30S070	187.1	216.1	219.1	272.1	271	1.1	7	4
6.2	35	□	MVS0620X35S070	218.1	248.1	253.1	306.1	305	1.1	7	4
6.2	40	□	MVS0620X40S070	249.1	281.1	284.1	337.1	336	1.1	7	4
6.3	3	●	MVS0630X03S070	20.0	33.6	36.1	89.1	88	1.1	7	2
6.3	3	●	MVS0630X03S080	20.0	33.6	36.1	89.1	88	1.1	8	2
6.3	5	●	MVS0630X05S070	32.6	53.1	57.1	110.1	109	1.1	7	2
6.3	5	●	MVS0630X05S080	32.6	53.1	57.1	110.1	109	1.1	8	2
6.3	8	●	MVS0630X08S070	51.5	73.1	78.1	131.1	130	1.1	7	2
6.3	8	●	MVS0630X08S080	51.5	73.1	78.1	131.1	130	1.1	8	2
6.3	10	●	MVS0630X10S070	64.1	86.1	89.1	142.1	141	1.1	7	4
6.3	15	●	MVS0630X15S070	95.6	118.1	121.1	174.1	173	1.1	7	4
6.3	20	●	MVS0630X20S070	127.1	151.1	154.1	207.1	206	1.1	7	4
6.3	25	●	MVS0630X25S070	158.6	183.1	186.1	239.1	238	1.1	7	4
6.3	30	●	MVS0630X30S070	190.1	216.1	219.1	272.1	271	1.1	7	4
6.3	35	□	MVS0630X35S070	221.6	248.1	253.1	306.1	305	1.1	7	4
6.3	40	□	MVS0630X40S070	253.1	281.1	284.1	337.1	336	1.1	7	4
6.4	3	●	MVS0640X03S070	20.4	33.7	36.2	89.2	88	1.2	7	2
6.4	3	●	MVS0640X03S080	20.4	33.7	36.2	89.2	88	1.2	8	2
6.4	5	●	MVS0640X05S070	33.2	53.2	57.2	110.2	109	1.2	7	2
6.4	5	●	MVS0640X05S080	33.2	53.2	57.2	110.2	109	1.2	8	2
6.4	8	●	MVS0640X08S070	52.4	73.2	78.2	131.2	130	1.2	7	2
6.4	8	●	MVS0640X08S080	52.4	73.2	78.2	131.2	130	1.2	8	2
6.4	10	●	MVS0640X10S070	65.2	86.2	89.2	142.2	141	1.2	7	4
6.4	15	●	MVS0640X15S070	97.2	118.2	121.2	174.2	173	1.2	7	4
6.4	20	●	MVS0640X20S070	129.2	151.2	154.2	207.2	206	1.2	7	4
6.4	25	●	MVS0640X25S070	161.2	183.2	186.2	239.2	238	1.2	7	4
6.4	30	●	MVS0640X30S070	193.2	216.2	219.2	272.2	271	1.2	7	4
6.4	35	□	MVS0640X35S070	225.2	248.2	253.2	306.2	305	1.2	7	4
6.4	40	□	MVS0640X40S070	257.2	281.2	284.2	337.2	336	1.2	7	4
6.5	3	●	MVS0650X03S070	20.7	33.7	36.2	89.2	88	1.2	7	2
6.5	3	●	MVS0650X03S080	20.7	33.7	36.2	89.2	88	1.2	8	2
6.5	5	●	MVS0650X05S070	33.7	53.2	57.2	110.2	109	1.2	7	2

Note 1) The coolant hole of ø5mm or less will be round shape. (L/D=3,5,8 is ø6mm or less)

● : Inventory maintained in Japan. **□ : Non stock, produced to order only.**

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.5	5	●	MVS0650X05S080	33.7	53.2	57.2	110.2	109	1.2	8	2
6.5	8	●	MVS0650X08S070	53.2	73.2	78.2	131.2	130	1.2	7	2
6.5	8	●	MVS0650X08S080	53.2	73.2	78.2	131.2	130	1.2	8	2
6.5	10	●	MVS0650X10S070	66.2	86.2	89.2	142.2	141	1.2	7	4
6.5	15	●	MVS0650X15S070	98.7	118.2	121.2	174.2	173	1.2	7	4
6.5	20	●	MVS0650X20S070	131.2	151.2	154.2	207.2	206	1.2	7	4
6.5	25	●	MVS0650X25S070	163.7	183.2	186.2	239.2	238	1.2	7	4
6.5	30	●	MVS0650X30S070	196.2	216.2	219.2	272.2	271	1.2	7	4
6.5	35	●	MVS0650X35S070	228.7	248.2	253.2	306.2	305	1.2	7	4
6.5	40	●	MVS0650X40S070	261.2	281.2	284.2	337.2	336	1.2	7	4
6.6	3	●	MVS0660X03S070	21.0	36.2	36.2	89.2	88	1.2	7	2
6.6	3	●	MVS0660X03S080	21.0	36.2	38.2	89.2	88	1.2	8	2
6.6	5	●	MVS0660X05S070	34.2	57.2	57.2	110.2	109	1.2	7	2
6.6	5	●	MVS0660X05S080	34.2	57.2	59.2	110.2	109	1.2	8	2
6.6	8	●	MVS0660X08S070	54.0	78.2	78.2	131.2	130	1.2	7	2
6.6	8	●	MVS0660X08S080	54.0	78.2	80.2	131.2	130	1.2	8	2
6.6	10	●	MVS0660X10S070	67.2	92.2	95.2	148.2	147	1.2	7	4
6.6	15	●	MVS0660X15S070	100.2	127.2	130.2	183.2	182	1.2	7	4
6.6	20	●	MVS0660X20S070	133.2	162.2	165.2	218.2	217	1.2	7	4
6.6	25	●	MVS0660X25S070	166.2	197.2	200.2	253.2	252	1.2	7	4
6.6	30	●	MVS0660X30S070	199.2	232.2	235.2	288.2	287	1.2	7	4
6.6	35	□	MVS0660X35S070	232.2	267.2	270.2	323.2	322	1.2	7	4
6.6	40	□	MVS0660X40S070	265.2	301.2	304.2	357.2	356	1.2	7	4
6.7	3	●	MVS0670X03S070	21.3	36.2	36.2	89.2	88	1.2	7	2
6.7	3	●	MVS0670X03S080	21.3	36.2	38.2	89.2	88	1.2	8	2
6.7	5	●	MVS0670X05S070	34.7	57.2	57.2	110.2	109	1.2	7	2
6.7	5	●	MVS0670X05S080	34.7	57.2	59.2	110.2	109	1.2	8	2
6.7	8	●	MVS0670X08S070	54.8	78.2	78.2	131.2	130	1.2	7	2
6.7	8	●	MVS0670X08S080	54.8	78.2	80.2	131.2	130	1.2	8	2
6.7	10	●	MVS0670X10S070	68.2	92.2	95.2	148.2	147	1.2	7	4
6.7	15	●	MVS0670X15S070	101.7	127.2	130.2	183.2	182	1.2	7	4
6.7	20	●	MVS0670X20S070	135.2	162.2	165.2	218.2	217	1.2	7	4
6.7	25	●	MVS0670X25S070	168.7	197.2	200.2	253.2	252	1.2	7	4
6.7	30	●	MVS0670X30S070	202.2	232.2	235.2	288.2	287	1.2	7	4
6.7	35	□	MVS0670X35S070	235.7	267.2	270.2	323.2	322	1.2	7	4
6.7	40	□	MVS0670X40S070	269.2	301.2	304.2	357.2	356	1.2	7	4
6.8	3	●	MVS0680X03S070	21.6	36.2	36.2	89.2	88	1.2	7	2
6.8	3	●	MVS0680X03S080	21.6	36.2	38.2	89.2	88	1.2	8	2
6.8	5	●	MVS0680X05S070	35.2	57.2	57.2	110.2	109	1.2	7	2
6.8	5	●	MVS0680X05S080	35.2	57.2	59.2	110.2	109	1.2	8	2
6.8	8	●	MVS0680X08S070	55.6	78.2	78.2	131.2	130	1.2	7	2
6.8	8	●	MVS0680X08S080	55.6	78.2	80.2	131.2	130	1.2	8	2
6.8	10	●	MVS0680X10S070	69.2	92.2	95.2	148.2	147	1.2	7	4
6.8	15	●	MVS0680X15S070	103.2	127.2	130.2	183.2	182	1.2	7	4
6.8	20	●	MVS0680X20S070	137.2	162.2	165.2	218.2	217	1.2	7	4
6.8	25	●	MVS0680X25S070	171.2	197.2	200.2	253.2	252	1.2	7	4
6.8	30	●	MVS0680X30S070	205.2	232.2	235.2	288.2	287	1.2	7	4
6.8	35	□	MVS0680X35S070	239.2	267.2	270.2	323.2	322	1.2	7	4

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.8	40	□	MVS0680X40S070	273.2	301.2	304.2	357.2	356	1.2	7	4
6.9	3	●	MVS0690X03S070	22.0	36.3	36.3	89.3	88	1.3	7	2
6.9	3	●	MVS0690X03S080	22.0	36.3	38.3	89.3	88	1.3	8	2
6.9	5	●	MVS0690X05S070	35.8	57.3	57.3	110.3	109	1.3	7	2
6.9	5	●	MVS0690X05S080	35.8	57.3	59.3	110.3	109	1.3	8	2
6.9	8	●	MVS0690X08S070	56.5	78.3	78.3	131.3	130	1.3	7	2
6.9	8	●	MVS0690X08S080	56.5	78.3	80.3	131.3	130	1.3	8	2
6.9	10	●	MVS0690X10S070	70.3	92.3	95.3	148.3	147	1.3	7	4
6.9	15	●	MVS0690X15S070	104.8	127.3	130.3	183.3	182	1.3	7	4
6.9	20	●	MVS0690X20S070	139.3	162.3	165.3	218.3	217	1.3	7	4
6.9	25	●	MVS0690X25S070	173.8	197.3	200.3	253.3	252	1.3	7	4
6.9	30	●	MVS0690X30S070	208.3	232.3	235.3	288.3	287	1.3	7	4
6.9	35	□	MVS0690X35S070	242.8	267.3	270.3	323.3	322	1.3	7	4
6.9	40	□	MVS0690X40S070	277.3	301.3	304.3	357.3	356	1.3	7	4
7.0	3	●	MVS0700X03S070	22.3	36.3	36.3	89.3	88	1.3	7	2
7.0	3	●	MVS0700X03S080	22.3	36.3	38.3	89.3	88	1.3	8	2
7.0	5	●	MVS0700X05S070	36.3	57.3	57.3	110.3	109	1.3	7	2
7.0	5	●	MVS0700X05S080	36.3	57.3	59.3	110.3	109	1.3	8	2
7.0	8	●	MVS0700X08S070	57.3	78.3	78.3	131.3	130	1.3	7	2
7.0	8	●	MVS0700X08S080	57.3	78.3	80.3	131.3	130	1.3	8	2
7.0	10	●	MVS0700X10S070	71.3	92.3	95.3	148.3	147	1.3	7	4
7.0	15	●	MVS0700X15S070	106.3	127.3	130.3	183.3	182	1.3	7	4
7.0	20	●	MVS0700X20S070	141.3	162.3	165.3	218.3	217	1.3	7	4
7.0	25	●	MVS0700X25S070	176.3	197.3	200.3	253.3	252	1.3	7	4
7.0	30	●	MVS0700X30S070	211.3	232.3	235.3	288.3	287	1.3	7	4
7.0	35	●	MVS0700X35S070	246.3	267.3	270.3	323.3	322	1.3	7	4
7.0	40	●	MVS0700X40S070	281.3	301.3	304.3	357.3	356	1.3	7	4
7.1	3	●	MVS0710X03S080	22.6	38.8	41.3	95.3	94	1.3	8	2
7.1	5	●	MVS0710X05S080	36.8	61.3	65.3	119.3	118	1.3	8	2
7.1	8	●	MVS0710X08S080	58.1	84.3	89.3	143.3	142	1.3	8	2
7.1	10	●	MVS0710X10S080	72.3	99.3	102.3	156.3	155	1.3	8	4
7.1	15	●	MVS0710X15S080	107.8	136.3	139.3	193.3	192	1.3	8	4
7.1	20	●	MVS0710X20S080	143.3	174.3	177.3	231.3	230	1.3	8	4
7.1	25	●	MVS0710X25S080	178.8	211.3	214.3	268.3	267	1.3	8	4
7.1	30	●	MVS0710X30S080	214.3	249.3	252.3	306.3	305	1.3	8	4
7.1	35	□	MVS0710X35S080	249.8	286.3	289.3	343.3	342	1.3	8	4
7.1	40	□	MVS0710X40S080	285.3	321.3	324.3	378.3	377	1.3	8	4
7.2	3	●	MVS0720X03S080	22.9	38.8	41.3	95.3	94	1.3	8	2
7.2	5	●	MVS0720X05S080	37.3	61.3	65.3	119.3	118	1.3	8	2
7.2	8	●	MVS0720X08S080	58.9	84.3	89.3	143.3	142	1.3	8	2
7.2	10	●	MVS0720X10S080	73.3	99.3	102.3	156.3	155	1.3	8	4
7.2	15	●	MVS0720X15S080	109.3	136.3	139.3	193.3	192	1.3	8	4
7.2	20	●	MVS0720X20S080	145.3	174.3	177.3	231.3	230	1.3	8	4
7.2	25	●	MVS0720X25S080	181.3	211.3	214.3	268.3	267	1.3	8	4
7.2	30	●	MVS0720X30S080	217.3	249.3	252.3	306.3	305	1.3	8	4
7.2	35	□	MVS0720X35S080	253.3	286.3	289.3	343.3	342	1.3	8	4
7.2	40	□	MVS0720X40S080	289.3	321.3	324.3	378.3	377	1.3	8	4
7.3	3	●	MVS0730X03S080	23.2	38.8	41.3	95.3	94	1.3	8	2

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.3	5	●	MVS0730X05S080	37.8	61.3	65.3	119.3	118	1.3	8	2
7.3	8	●	MVS0730X08S080	59.7	84.3	89.3	143.3	142	1.3	8	2
7.3	10	●	MVS0730X10S080	74.3	99.3	102.3	156.3	155	1.3	8	4
7.3	15	●	MVS0730X15S080	110.8	136.3	139.3	193.3	192	1.3	8	4
7.3	20	●	MVS0730X20S080	147.3	174.3	177.3	231.3	230	1.3	8	4
7.3	25	●	MVS0730X25S080	183.8	211.3	214.3	268.3	267	1.3	8	4
7.3	30	●	MVS0730X30S080	220.3	249.3	252.3	306.3	305	1.3	8	4
7.3	35	□	MVS0730X35S080	256.8	286.3	289.3	343.3	342	1.3	8	4
7.3	40	□	MVS0730X40S080	293.3	321.3	324.3	378.3	377	1.3	8	4
7.4	3	●	MVS0740X03S080	23.5	38.8	41.3	95.3	94	1.3	8	2
7.4	5	●	MVS0740X05S080	38.3	61.3	65.3	119.3	118	1.3	8	2
7.4	8	●	MVS0740X08S080	60.5	84.3	89.3	143.3	142	1.3	8	2
7.4	10	●	MVS0740X10S080	75.3	99.3	102.3	156.3	155	1.3	8	4
7.4	15	●	MVS0740X15S080	112.3	136.3	139.3	193.3	192	1.3	8	4
7.4	20	●	MVS0740X20S080	149.3	174.3	177.3	231.3	230	1.3	8	4
7.4	25	●	MVS0740X25S080	186.3	211.3	214.3	268.3	267	1.3	8	4
7.4	30	●	MVS0740X30S080	223.3	249.3	252.3	306.3	305	1.3	8	4
7.4	35	□	MVS0740X35S080	260.3	286.3	289.3	343.3	342	1.3	8	4
7.4	40	□	MVS0740X40S080	297.3	321.3	324.3	378.3	377	1.3	8	4
7.5	3	●	MVS0750X03S080	23.9	38.9	41.4	95.4	94	1.4	8	2
7.5	5	●	MVS0750X05S080	38.9	61.4	65.4	119.4	118	1.4	8	2
7.5	8	●	MVS0750X08S080	61.4	84.4	89.4	143.4	142	1.4	8	2
7.5	10	●	MVS0750X10S080	76.4	99.4	102.4	156.4	155	1.4	8	4
7.5	15	●	MVS0750X15S080	113.9	136.4	139.4	193.4	192	1.4	8	4
7.5	20	●	MVS0750X20S080	151.4	174.4	177.4	231.4	230	1.4	8	4
7.5	25	●	MVS0750X25S080	188.9	211.4	214.4	268.4	267	1.4	8	4
7.5	30	●	MVS0750X30S080	226.4	249.4	252.4	306.4	305	1.4	8	4
7.5	35	●	MVS0750X35S080	263.9	286.4	289.4	343.4	342	1.4	8	4
7.5	40	●	MVS0750X40S080	301.4	321.4	324.4	378.4	377	1.4	8	4
7.6	3	●	MVS0760X03S080	24.2	41.4	41.4	95.4	94	1.4	8	2
7.6	5	●	MVS0760X05S080	39.4	65.4	65.4	119.4	118	1.4	8	2
7.6	8	●	MVS0760X08S080	62.2	89.4	89.4	143.4	142	1.4	8	2
7.6	10	●	MVS0760X10S080	77.4	105.4	108.4	162.4	161	1.4	8	4
7.6	15	●	MVS0760X15S080	115.4	145.4	148.4	202.4	201	1.4	8	4
7.6	20	●	MVS0760X20S080	153.4	185.4	188.4	242.4	241	1.4	8	4
7.6	25	●	MVS0760X25S080	191.4	225.4	228.4	282.4	281	1.4	8	4
7.6	30	●	MVS0760X30S080	229.4	265.4	268.4	322.4	321	1.4	8	4
7.6	35	□	MVS0760X35S080	267.4	305.4	308.4	362.4	361	1.4	8	4
7.6	40	□	MVS0760X40S080	305.4	341.4	344.4	398.4	397	1.4	8	4
7.7	3	●	MVS0770X03S080	24.5	41.4	41.4	95.4	94	1.4	8	2
7.7	5	●	MVS0770X05S080	39.9	65.4	65.4	119.4	118	1.4	8	2
7.7	8	●	MVS0770X08S080	63.0	89.4	89.4	143.4	142	1.4	8	2
7.7	10	●	MVS0770X10S080	78.4	105.4	108.4	162.4	161	1.4	8	4
7.7	15	●	MVS0770X15S080	116.9	145.4	148.4	202.4	201	1.4	8	4
7.7	20	●	MVS0770X20S080	155.4	185.4	188.4	242.4	241	1.4	8	4
7.7	25	●	MVS0770X25S080	193.9	225.4	228.4	282.4	281	1.4	8	4
7.7	30	●	MVS0770X30S080	232.4	265.4	268.4	322.4	321	1.4	8	4
7.7	35	□	MVS0770X35S080	270.9	305.4	308.4	362.4	361	1.4	8	4
7.7	40	□	MVS0770X40S080	309.4	341.4	344.4	398.4	397	1.4	8	4
7.8	3	●	MVS0780X03S080	24.8	41.4	41.4	95.4	94	1.4	8	2
7.8	5	●	MVS0780X05S080	40.4	65.4	65.4	119.4	118	1.4	8	2
7.8	8	●	MVS0780X08S080	63.8	89.4	89.4	143.4	142	1.4	8	2
7.8	10	●	MVS0780X10S080	79.4	105.4	108.4	162.4	161	1.4	8	4
7.8	15	●	MVS0780X15S080	118.4	145.4	148.4	202.4	201	1.4	8	4
7.8	20	●	MVS0780X20S080	157.4	185.4	188.4	242.4	241	1.4	8	4
7.8	25	●	MVS0780X25S080	196.4	225.4	228.4	282.4	281	1.4	8	4
7.8	30	●	MVS0780X30S080	235.4	265.4	268.4	322.4	321	1.4	8	4
7.8	35	□	MVS0780X35S080	274.4	305.4	308.4	362.4	361	1.4	8	4
7.8	40	□	MVS0780X40S080	313.4	341.4	344.4	398.4	397	1.4	8	4
7.9	3	●	MVS0790X03S080	25.1	41.4	41.4	95.4	94	1.4	8	2
7.9	5	●	MVS0790X05S080	40.9	65.4	65.4	119.4	118	1.4	8	2
7.9	8	●	MVS0790X08S080	64.6	89.4	89.4	143.4	142	1.4	8	2
7.9	10	●	MVS0790X10S080	80.4	105.4	108.4	162.4	161	1.4	8	4
7.9	15	●	MVS0790X15S080	119.9	145.4	148.4	202.4	201	1.4	8	4
7.9	20	●	MVS0790X20S080	159.4	185.4	188.4	242.4	241	1.4	8	4
7.9	25	●	MVS0790X25S080	198.9	225.4	228.4	282.4	281	1.4	8	4
7.9	30	●	MVS0790X30S080	238.4	265.4	268.4	322.4	321	1.4	8	4
7.9	35	□	MVS0790X35S080	277.9	305.4	308.4	362.4	361	1.4	8	4
7.9	40	□	MVS0790X40S080	317.4	341.4	344.4	398.4	397	1.4	8	4
8.0	3	●	MVS0800X03S080	25.5	41.5	41.5	95.5	94	1.5	8	2
8.0	5	●	MVS0800X05S080	41.5	65.5	65.5	119.5	118	1.5	8	2
8.0	8	●	MVS0800X08S080	65.5	89.5	89.5	143.5	142	1.5	8	2
8.0	10	●	MVS0800X10S080	81.5	105.5	108.5	162.5	161	1.5	8	4
8.0	15	●	MVS0800X15S080	121.5	145.5	148.5	202.5	201	1.5	8	4
8.0	20	●	MVS0800X20S080	161.5	185.5	188.5	242.5	241	1.5	8	4
8.0	25	●	MVS0800X25S080	201.5	225.5	228.5	282.5	281	1.5	8	4
8.0	30	●	MVS0800X30S080	241.5	265.5	268.5	322.5	321	1.5	8	4
8.0	35	●	MVS0800X35S080	281.5	305.5	308.5	362.5	361	1.5	8	4
8.0	40	●	MVS0800X40S080	321.5	341.5	344.5	398.5	397	1.5	8	4
8.1	3	●	MVS0810X03S090	25.8	44.0	46.5	101.5	100	1.5	9	2
8.1	3	●	MVS0810X03S100	25.8	44.0	46.5	101.5	100	1.5	10	2
8.1	5	●	MVS0810X05S090	42.0	69.5	73.5	128.5	127	1.5	9	2
8.1	5	●	MVS0810X05S100	42.0	69.5	73.5	128.5	127	1.5	10	2
8.1	8	●	MVS0810X08S090	66.3	95.5	100.5	155.5	154	1.5	9	2
8.1	8	●	MVS0810X08S100	66.3	95.5	100.5	155.5	154	1.5	10	2
8.1	10	●	MVS0810X10S090	82.5	112.5	115.5	170.5	169	1.5	9	4
8.1	15	●	MVS0810X15S090	123.0	154.5	157.5	212.5	211	1.5	9	4
8.1	20	●	MVS0810X20S090	163.5	197.5	200.5	255.5	254	1.5	9	4
8.1	25	●	MVS0810X25S090	204.0	239.5	242.5	297.5	296	1.5	9	4
8.1	30	●	MVS0810X30S090	244.5	282.5	285.5	340.5	339	1.5	9	4
8.1	35	□	MVS0810X35S090	285.0	324.5	327.5	382.5	381	1.5	9	4
8.1	40	□	MVS0810X40S090	325.5	366.5	369.5	424.5	423	1.5	9	4
8.2	3	●	MVS0820X03S090	26.1	44.0	46.5	101.5	100	1.5	9	2
8.2	3	●	MVS0820X03S100	26.1	44.0	46.5	101.5	100	1.5	10	2
8.2	5	●	MVS0820X05S090	42.5	69.5	73.5	128.5	127	1.5	9	2
8.2	5	●	MVS0820X05S100	42.5	69.5	73.5	128.5	127	1.5	10	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.2	8	●	MVS0820X08S090	67.1	95.5	100.5	155.5	154	1.5	9	2
8.2	8	●	MVS0820X08S100	67.1	95.5	100.5	155.5	154	1.5	10	2
8.2	10	●	MVS0820X10S090	83.5	112.5	115.5	170.5	169	1.5	9	4
8.2	15	●	MVS0820X15S090	124.5	154.5	157.5	212.5	211	1.5	9	4
8.2	20	●	MVS0820X20S090	165.5	197.5	200.5	255.5	254	1.5	9	4
8.2	25	●	MVS0820X25S090	206.5	239.5	242.5	297.5	296	1.5	9	4
8.2	30	●	MVS0820X30S090	247.5	282.5	285.5	340.5	339	1.5	9	4
8.2	35	□	MVS0820X35S090	288.5	324.5	327.5	382.5	381	1.5	9	4
8.2	40	□	MVS0820X40S090	329.5	366.5	369.5	424.5	423	1.5	9	4
8.3	3	●	MVS0830X03S090	26.4	44.0	46.5	101.5	100	1.5	9	2
8.3	3	●	MVS0830X03S100	26.4	44.0	46.5	101.5	100	1.5	10	2
8.3	5	●	MVS0830X05S090	43.0	69.5	73.5	128.5	127	1.5	9	2
8.3	5	●	MVS0830X05S100	43.0	69.5	73.5	128.5	127	1.5	10	2
8.3	8	●	MVS0830X08S090	67.9	95.5	100.5	155.5	154	1.5	9	2
8.3	8	●	MVS0830X08S100	67.9	95.5	100.5	155.5	154	1.5	10	2
8.3	10	●	MVS0830X10S090	84.5	112.5	115.5	170.5	169	1.5	9	4
8.3	15	●	MVS0830X15S090	126.0	154.5	157.5	212.5	211	1.5	9	4
8.3	20	●	MVS0830X20S090	167.5	197.5	200.5	255.5	254	1.5	9	4
8.3	25	●	MVS0830X25S090	209.0	239.5	242.5	297.5	296	1.5	9	4
8.3	30	●	MVS0830X30S090	250.5	282.5	285.5	340.5	339	1.5	9	4
8.3	35	□	MVS0830X35S090	292.0	324.5	327.5	382.5	381	1.5	9	4
8.3	40	□	MVS0830X40S090	333.5	366.5	369.5	424.5	423	1.5	9	4
8.4	3	●	MVS0840X03S090	26.7	44.0	46.5	101.5	100	1.5	9	2
8.4	3	●	MVS0840X03S100	26.7	44.0	46.5	101.5	100	1.5	10	2
8.4	5	●	MVS0840X05S090	43.5	69.5	73.5	128.5	127	1.5	9	2
8.4	5	●	MVS0840X05S100	43.5	69.5	73.5	128.5	127	1.5	10	2
8.4	8	●	MVS0840X08S090	68.7	95.5	100.5	155.5	154	1.5	9	2
8.4	8	●	MVS0840X08S100	68.7	95.5	100.5	155.5	154	1.5	10	2
8.4	10	●	MVS0840X10S090	85.5	112.5	115.5	170.5	169	1.5	9	4
8.4	15	●	MVS0840X15S090	127.5	154.5	157.5	212.5	211	1.5	9	4
8.4	20	●	MVS0840X20S090	169.5	197.5	200.5	255.5	254	1.5	9	4
8.4	25	●	MVS0840X25S090	211.5	239.5	242.5	297.5	296	1.5	9	4
8.4	30	●	MVS0840X30S090	253.5	282.5	285.5	340.5	339	1.5	9	4
8.4	35	□	MVS0840X35S090	295.5	324.5	327.5	382.5	381	1.5	9	4
8.4	40	□	MVS0840X40S090	337.5	366.5	369.5	424.5	423	1.5	9	4
8.5	3	●	MVS0850X03S090	27.0	44.0	46.5	101.5	100	1.5	9	2
8.5	3	●	MVS0850X03S100	27.0	44.0	46.5	101.5	100	1.5	10	2
8.5	5	●	MVS0850X05S090	44.0	69.5	73.5	128.5	127	1.5	9	2
8.5	5	●	MVS0850X05S100	44.0	69.5	73.5	128.5	127	1.5	10	2
8.5	8	●	MVS0850X08S090	69.5	95.5	100.5	155.5	154	1.5	9	2
8.5	8	●	MVS0850X08S100	69.5	95.5	100.5	155.5	154	1.5	10	2
8.5	10	●	MVS0850X10S090	86.5	112.5	115.5	170.5	169	1.5	9	4
8.5	15	●	MVS0850X15S090	129.0	154.5	157.5	212.5	211	1.5	9	4
8.5	20	●	MVS0850X20S090	171.5	197.5	200.5	255.5	254	1.5	9	4
8.5	25	●	MVS0850X25S090	214.0	239.5	242.5	297.5	296	1.5	9	4
8.5	30	●	MVS0850X30S090	256.5	282.5	285.5	340.5	339	1.5	9	4
8.5	35	●	MVS0850X35S090	299.0	324.5	327.5	382.5	381	1.5	9	4
8.5	40	●	MVS0850X40S090	341.5	366.5	369.5	424.5	423	1.5	9	4

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.6	3	●	MVS0860X03S090	27.4	46.6	46.6	101.6	100	1.6	9	2
8.6	3	●	MVS0860X03S100	27.4	46.6	48.6	101.6	100	1.6	10	2
8.6	5	●	MVS0860X05S090	44.6	73.6	73.6	128.6	127	1.6	9	2
8.6	5	●	MVS0860X05S100	44.6	73.6	75.6	128.6	127	1.6	10	2
8.6	8	●	MVS0860X08S090	70.4	100.6	100.6	155.6	154	1.6	9	2
8.6	8	●	MVS0860X08S100	70.4	100.6	102.6	155.6	154	1.6	10	2
8.6	10	●	MVS0860X10S090	87.6	118.6	121.6	176.6	175	1.6	9	4
8.6	15	●	MVS0860X15S090	130.6	163.6	166.6	221.6	220	1.6	9	4
8.6	20	●	MVS0860X20S090	173.6	208.6	211.6	266.6	265	1.6	9	4
8.6	25	●	MVS0860X25S090	216.6	253.6	256.6	311.6	310	1.6	9	4
8.6	30	●	MVS0860X30S090	259.6	298.6	301.6	356.6	355	1.6	9	4
8.6	35	□	MVS0860X35S090	302.6	343.6	346.6	401.6	400	1.6	9	4
8.6	40	□	MVS0860X40S090	345.6	391.6	394.6	449.6	448	1.6	9	4
8.7	3	●	MVS0870X03S090	27.7	46.6	46.6	101.6	100	1.6	9	2
8.7	3	●	MVS0870X03S100	27.7	46.6	48.6	101.6	100	1.6	10	2
8.7	5	●	MVS0870X05S090	45.1	73.6	73.6	128.6	127	1.6	9	2
8.7	5	●	MVS0870X05S100	45.1	73.6	75.6	128.6	127	1.6	10	2
8.7	8	●	MVS0870X08S090	71.2	100.6	100.6	155.6	154	1.6	9	2
8.7	8	●	MVS0870X08S100	71.2	100.6	102.6	155.6	154	1.6	10	2
8.7	10	●	MVS0870X10S090	88.6	118.6	121.6	176.6	175	1.6	9	4
8.7	15	●	MVS0870X15S090	132.1	163.6	166.6	221.6	220	1.6	9	4
8.7	20	●	MVS0870X20S090	175.6	208.6	211.6	266.6	265	1.6	9	4
8.7	25	●	MVS0870X25S090	219.1	253.6	256.6	311.6	310	1.6	9	4
8.7	30	●	MVS0870X30S090	262.6	298.6	301.6	356.6	355	1.6	9	4
8.7	35	□	MVS0870X35S090	306.1	343.6	346.6	401.6	400	1.6	9	4
8.7	40	□	MVS0870X40S090	349.6	391.6	394.6	449.6	448	1.6	9	4
8.8	3	●	MVS0880X03S090	28.0	46.6	46.6	101.6	100	1.6	9	2
8.8	3	●	MVS0880X03S100	28.0	46.6	48.6	101.6	100	1.6	10	2
8.8	5	●	MVS0880X05S090	45.6	73.6	73.6	128.6	127	1.6	9	2
8.8	5	●	MVS0880X05S100	45.6	73.6	75.6	128.6	127	1.6	10	2
8.8	8	●	MVS0880X08S090	72.0	100.6	100.6	155.6	154	1.6	9	2
8.8	8	●	MVS0880X08S100	72.0	100.6	102.6	155.6	154	1.6	10	2
8.8	10	●	MVS0880X10S090	89.6	118.6	121.6	176.6	175	1.6	9	4
8.8	15	●	MVS0880X15S090	133.6	163.6	166.6	221.6	220	1.6	9	4
8.8	20	●	MVS0880X20S090	177.6	208.6	211.6	266.6	265	1.6	9	4
8.8	25	●	MVS0880X25S090	221.6	253.6	256.6	311.6	310	1.6	9	4
8.8	30	●	MVS0880X30S090	265.6	298.6	301.6	356.6	355	1.6	9	4
8.8	35	□	MVS0880X35S090	309.6	343.6	346.6	401.6	400	1.6	9	4
8.8	40	□	MVS0880X40S090	353.6	391.6	394.6	449.6	448	1.6	9	4
8.9	3	●	MVS0890X03S090	28.3	46.6	46.6	101.6	100	1.6	9	2
8.9	3	●	MVS0890X03S100	28.3	46.6	48.6	101.6	100	1.6	10	2
8.9	5	●	MVS0890X05S090	46.1	73.6	73.6	128.6	127	1.6	9	2
8.9	5	●	MVS0890X05S100	46.1	73.6	75.6	128.6	127	1.6	10	2
8.9	8	●	MVS0890X08S090	72.8	100.6	100.6	155.6	154	1.6	9	2
8.9	8	●	MVS0890X08S100	72.8	100.6	102.6	155.6	154	1.6	10	2
8.9	10	●	MVS0890X10S090	90.6	118.6	121.6	176.6	175	1.6	9	4
8.9	15	●	MVS0890X15S090	135.1	163.6	166.6	221.6	220	1.6	9	4
8.9	20	●	MVS0890X20S090	179.6	208.6	211.6	266.6	265	1.6	9	4

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.9	25	●	MVS0890X25S090	224.1	253.6	256.6	311.6	310	1.6	9	4
8.9	30	●	MVS0890X30S090	268.6	298.6	301.6	356.6	355	1.6	9	4
8.9	35	□	MVS0890X35S090	313.1	343.6	346.6	401.6	400	1.6	9	4
8.9	40	□	MVS0890X40S090	357.6	391.6	394.6	449.6	448	1.6	9	4
9.0	3	●	MVS0900X03S090	28.6	46.6	46.6	101.6	100	1.6	9	2
9.0	3	●	MVS0900X03S100	28.6	46.6	48.6	101.6	100	1.6	10	2
9.0	5	●	MVS0900X05S090	46.6	73.6	73.6	128.6	127	1.6	9	2
9.0	5	●	MVS0900X05S100	46.6	73.6	75.6	128.6	127	1.6	10	2
9.0	8	●	MVS0900X08S090	73.6	100.6	100.6	155.6	154	1.6	9	2
9.0	8	●	MVS0900X08S100	73.6	100.6	102.6	155.6	154	1.6	10	2
9.0	10	●	MVS0900X10S090	91.6	118.6	121.6	176.6	175	1.6	9	4
9.0	15	●	MVS0900X15S090	136.6	163.6	166.6	221.6	220	1.6	9	4
9.0	20	●	MVS0900X20S090	181.6	208.6	211.6	266.6	265	1.6	9	4
9.0	25	●	MVS0900X25S090	226.6	253.6	256.6	311.6	310	1.6	9	4
9.0	30	●	MVS0900X30S090	271.6	298.6	301.6	356.6	355	1.6	9	4
9.0	35	●	MVS0900X35S090	316.6	343.6	346.6	401.6	400	1.6	9	4
9.0	40	●	MVS0900X40S090	361.6	391.6	394.6	449.6	448	1.6	9	4
9.1	3	●	MVS0910X03S100	29.0	49.2	51.7	107.7	106	1.7	10	2
9.1	5	●	MVS0910X05S100	47.2	77.7	81.7	137.7	136	1.7	10	2
9.1	8	●	MVS0910X08S100	74.5	106.7	111.7	167.7	166	1.7	10	2
9.1	10	●	MVS0910X10S100	92.7	125.7	128.7	183.7	182	1.7	10	4
9.1	15	●	MVS0910X15S100	138.2	172.7	175.7	230.7	229	1.7	10	4
9.1	20	●	MVS0910X20S100	183.7	220.7	223.7	278.7	277	1.7	10	4
9.1	25	●	MVS0910X25S100	229.2	267.7	270.7	325.7	324	1.7	10	4
9.1	30	●	MVS0910X30S100	274.7	315.7	318.7	373.7	372	1.7	10	4
9.1	35	□	MVS0910X35S100	320.2	362.7	365.7	420.7	419	1.7	10	4
9.2	3	●	MVS0920X03S100	29.3	49.2	51.7	107.7	106	1.7	10	2
9.2	5	●	MVS0920X05S100	47.7	77.7	81.7	137.7	136	1.7	10	2
9.2	8	●	MVS0920X08S100	75.3	106.7	111.7	167.7	166	1.7	10	2
9.2	10	●	MVS0920X10S100	93.7	125.7	128.7	183.7	182	1.7	10	4
9.2	15	●	MVS0920X15S100	139.7	172.7	175.7	230.7	229	1.7	10	4
9.2	20	●	MVS0920X20S100	185.7	220.7	223.7	278.7	277	1.7	10	4
9.2	25	●	MVS0920X25S100	231.7	267.7	270.7	325.7	324	1.7	10	4
9.2	30	●	MVS0920X30S100	277.7	315.7	318.7	373.7	372	1.7	10	4
9.2	35	□	MVS0920X35S100	323.7	362.7	365.7	420.7	419	1.7	10	4
9.3	3	●	MVS0930X03S100	29.6	49.2	51.7	107.7	106	1.7	10	2
9.3	5	●	MVS0930X05S100	48.2	77.7	81.7	137.7	136	1.7	10	2
9.3	8	●	MVS0930X08S100	76.1	106.7	111.7	167.7	166	1.7	10	2
9.3	10	●	MVS0930X10S100	94.7	125.7	128.7	183.7	182	1.7	10	4
9.3	15	●	MVS0930X15S100	141.2	172.7	175.7	230.7	229	1.7	10	4
9.3	20	●	MVS0930X20S100	187.7	220.7	223.7	278.7	277	1.7	10	4
9.3	25	●	MVS0930X25S100	234.2	267.7	270.7	325.7	324	1.7	10	4
9.3	30	●	MVS0930X30S100	280.7	315.7	318.7	373.7	372	1.7	10	4
9.3	35	□	MVS0930X35S100	327.2	362.7	365.7	420.7	419	1.7	10	4
9.4	3	●	MVS0940X03S100	29.9	49.2	51.7	107.7	106	1.7	10	2
9.4	5	●	MVS0940X05S100	48.7	77.7	81.7	137.7	136	1.7	10	2
9.4	8	●	MVS0940X08S100	76.9	106.7	111.7	167.7	166	1.7	10	2
9.4	10	●	MVS0940X10S100	95.7	125.7	128.7	183.7	182	1.7	10	4

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.4	15	●	MVS0940X15S100	142.7	172.7	175.7	230.7	229	1.7	10	4
9.4	20	●	MVS0940X20S100	189.7	220.7	223.7	278.7	277	1.7	10	4
9.4	25	●	MVS0940X25S100	236.7	267.7	270.7	325.7	324	1.7	10	4
9.4	30	●	MVS0940X30S100	283.7	315.7	318.7	373.7	372	1.7	10	4
9.4	35	□	MVS0940X35S100	330.7	362.7	365.7	420.7	419	1.7	10	4
9.5	3	●	MVS0950X03S100	30.2	49.2	51.7	107.7	106	1.7	10	2
9.5	5	●	MVS0950X05S100	49.2	77.7	81.7	137.7	136	1.7	10	2
9.5	8	●	MVS0950X08S100	77.7	106.7	111.7	167.7	166	1.7	10	2
9.5	10	●	MVS0950X10S100	96.7	125.7	128.7	183.7	182	1.7	10	4
9.5	15	●	MVS0950X15S100	144.2	172.7	175.7	230.7	229	1.7	10	4
9.5	20	●	MVS0950X20S100	191.7	220.7	223.7	278.7	277	1.7	10	4
9.5	25	●	MVS0950X25S100	239.2	267.7	270.7	325.7	324	1.7	10	4
9.5	30	●	MVS0950X30S100	286.7	315.7	318.7	373.7	372	1.7	10	4
9.5	35	●	MVS0950X35S100	334.2	362.7	365.7	420.7	419	1.7	10	4
9.6	3	●	MVS0960X03S100	30.5	51.7	51.7	107.7	106	1.7	10	2
9.6	5	●	MVS0960X05S100	49.7	81.7	81.7	137.7	136	1.7	10	2
9.6	8	●	MVS0960X08S100	78.5	111.7	111.7	167.7	166	1.7	10	2
9.6	10	●	MVS0960X10S100	97.7	131.7	134.7	189.7	188	1.7	10	4
9.6	15	●	MVS0960X15S100	145.7	181.7	184.7	239.7	238	1.7	10	4
9.6	20	●	MVS0960X20S100	193.7	231.7	234.7	289.7	288	1.7	10	4
9.6	25	●	MVS0960X25S100	241.7	281.7	284.7	339.7	338	1.7	10	4
9.6	30	●	MVS0960X30S100	289.7	331.7	334.7	389.7	388	1.7	10	4
9.6	35	□	MVS0960X35S100	337.7	381.7	384.7	439.7	438	1.7	10	4
9.7	3	●	MVS0970X03S100	30.9	51.8	51.8	107.8	106	1.8	10	2
9.7	5	●	MVS0970X05S100	50.3	81.8	81.8	137.8	136	1.8	10	2
9.7	8	●	MVS0970X08S100	79.4	111.8	111.8	167.8	166	1.8	10	2
9.7	10	●	MVS0970X10S100	98.8	131.8	134.8	189.8	188	1.8	10	4
9.7	15	●	MVS0970X15S100	147.3	181.8	184.8	239.8	238	1.8	10	4
9.7	20	●	MVS0970X20S100	195.8	231.8	234.8	289.8	288	1.8	10	4
9.7	25	●	MVS0970X25S100	244.3	281.8	284.8	339.8	338	1.8	10	4
9.7	30	●	MVS0970X30S100	292.8	331.8	334.8	389.8	388	1.8	10	4
9.7	35	□	MVS0970X35S100	341.3	381.8	384.8	439.8	438	1.8	10	4
9.8	3	●	MVS0980X03S100	31.2	51.8	51.8	107.8	106	1.8	10	2
9.8	5	●	MVS0980X05S100	50.8	81.8	81.8	137.8	136	1.8	10	2
9.8	8	●	MVS0980X08S100	80.2	111.8	111.8	167.8	166	1.8	10	2
9.8	10	●	MVS0980X10S100	99.8	131.8	134.8	189.8	188	1.8	10	4
9.8	15	●	MVS0980X15S100	148.8	181.8	184.8	239.8	238	1.8	10	4
9.8	20	●	MVS0980X20S100	197.8	231.8	234.8	289.8	288	1.8	10	4
9.8	25	●	MVS0980X25S100	246.8	281.8	284.8	339.8	338	1.8	10	4
9.8	30	●	MVS0980X30S100	295.8	331.8	334.8	389.8	388	1.8	10	4
9.8	35	□	MVS0980X35S100	344.8	381.8	384.8	439.8	438	1.8	10	4
9.9	3	●	MVS0990X03S100	31.5	51.8	51.8	107.8	106	1.8	10	2
9.9	5	●	MVS0990X05S100	51.3	81.8	81.8	137.8	136	1.8	10	2
9.9	8	●	MVS0990X08S100	81.0	111.8	111.8	167.8	166	1.8	10	2
9.9	10	●	MVS0990X10S100	100.8	131.8	134.8	189.8	188	1.8	10	4
9.9	15	●	MVS0990X15S100	150.3	181.8	184.8	239.8	238	1.8	10	4
9.9	20	●	MVS0990X20S100	199.8	231.8	234.8	289.8	288	1.8	10	4
9.9	25	●	MVS0990X25S100	249.3	281.8	284.8	339.8	338	1.8	10	4

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.9	30	●	MVS0990X30S100	298.8	331.8	334.8	389.8	388	1.8	10	4
9.9	35	□	MVS0990X35S100	348.3	381.8	384.8	439.8	438	1.8	10	4
10.0	3	●	MVS1000X03S100	31.8	51.8	51.8	107.8	106	1.8	10	2
10.0	5	●	MVS1000X05S100	51.8	81.8	81.8	137.8	136	1.8	10	2
10.0	8	●	MVS1000X08S100	81.8	111.8	111.8	167.8	166	1.8	10	2
10.0	10	●	MVS1000X10S100	101.8	131.8	134.8	189.8	188	1.8	10	4
10.0	15	●	MVS1000X15S100	151.8	181.8	184.8	239.8	238	1.8	10	4
10.0	20	●	MVS1000X20S100	201.8	231.8	234.8	289.8	288	1.8	10	4
10.0	25	●	MVS1000X25S100	251.8	281.8	284.8	339.8	338	1.8	10	4
10.0	30	●	MVS1000X30S100	301.8	331.8	334.8	389.8	388	1.8	10	4
10.0	35	●	MVS1000X35S100	351.8	381.8	384.8	439.8	438	1.8	10	4
10.1	3	●	MVS1010X03S110	32.1	54.3	56.8	117.8	116	1.8	11	2
10.1	3	●	MVS1010X03S120	32.1	54.3	56.8	117.8	116	1.8	12	2
10.1	5	●	MVS1010X05S110	52.3	85.8	89.8	150.8	149	1.8	11	2
10.1	5	●	MVS1010X05S120	52.3	85.8	89.8	150.8	149	1.8	12	2
10.1	8	●	MVS1010X08S110	82.6	117.8	122.8	183.8	182	1.8	11	2
10.1	8	●	MVS1010X08S120	82.6	117.8	122.8	183.8	182	1.8	12	2
10.1	10	●	MVS1010X10S110	102.8	138.8	141.8	202.8	201	1.8	11	4
10.1	15	●	MVS1010X15S110	153.3	190.8	193.8	254.8	253	1.8	11	4
10.1	20	●	MVS1010X20S110	203.8	243.8	246.8	307.8	306	1.8	11	4
10.1	25	●	MVS1010X25S110	254.3	295.8	298.8	359.8	358	1.8	11	4
10.2	3	●	MVS1020X03S110	32.5	54.4	56.9	117.9	116	1.9	11	2
10.2	3	●	MVS1020X03S120	32.5	54.4	56.9	117.9	116	1.9	12	2
10.2	5	●	MVS1020X05S110	52.9	85.9	89.9	150.9	149	1.9	11	2
10.2	5	●	MVS1020X05S120	52.9	85.9	89.9	150.9	149	1.9	12	2
10.2	8	●	MVS1020X08S110	83.5	117.9	122.9	183.9	182	1.9	11	2
10.2	8	●	MVS1020X08S120	83.5	117.9	122.9	183.9	182	1.9	12	2
10.2	10	●	MVS1020X10S110	103.9	138.9	141.9	202.9	201	1.9	11	4
10.2	15	●	MVS1020X15S110	154.9	190.9	193.9	254.9	253	1.9	11	4
10.2	20	●	MVS1020X20S110	205.9	243.9	246.9	307.9	306	1.9	11	4
10.2	25	●	MVS1020X25S110	256.9	295.9	298.9	359.9	358	1.9	11	4
10.3	3	●	MVS1030X03S110	32.8	54.4	56.9	117.9	116	1.9	11	2
10.3	3	●	MVS1030X03S120	32.8	54.4	56.9	117.9	116	1.9	12	2
10.3	5	●	MVS1030X05S110	53.4	85.9	89.9	150.9	149	1.9	11	2
10.3	5	●	MVS1030X05S120	53.4	85.9	89.9	150.9	149	1.9	12	2
10.3	8	●	MVS1030X08S110	84.3	117.9	122.9	183.9	182	1.9	11	2
10.3	8	●	MVS1030X08S120	84.3	117.9	122.9	183.9	182	1.9	12	2
10.3	10	●	MVS1030X10S110	104.9	138.9	141.9	202.9	201	1.9	11	4
10.3	15	●	MVS1030X15S110	156.4	190.9	193.9	254.9	253	1.9	11	4
10.3	20	●	MVS1030X20S110	207.9	243.9	246.9	307.9	306	1.9	11	4
10.3	25	●	MVS1030X25S110	259.4	295.9	298.9	359.9	358	1.9	11	4
10.4	3	●	MVS1040X03S110	33.1	54.4	56.9	117.9	116	1.9	11	2
10.4	3	●	MVS1040X03S120	33.1	54.4	56.9	117.9	116	1.9	12	2
10.4	5	●	MVS1040X05S110	53.9	85.9	89.9	150.9	149	1.9	11	2
10.4	5	●	MVS1040X05S120	53.9	85.9	89.9	150.9	149	1.9	12	2
10.4	8	●	MVS1040X08S110	85.1	117.9	122.9	183.9	182	1.9	11	2
10.4	8	●	MVS1040X08S120	85.1	117.9	122.9	183.9	182	1.9	12	2
10.4	10	●	MVS1040X10S110	105.9	138.9	141.9	202.9	201	1.9	11	4

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.4	15	●	MVS1040X15S110	157.9	190.9	193.9	254.9	253	1.9	11	4
10.4	20	●	MVS1040X20S110	209.9	243.9	246.9	307.9	306	1.9	11	4
10.4	25	●	MVS1040X25S110	261.9	295.9	298.9	359.9	358	1.9	11	4
10.5	3	●	MVS1050X03S110	33.4	54.4	56.9	117.9	116	1.9	11	2
10.5	3	●	MVS1050X03S120	33.4	54.4	56.9	117.9	116	1.9	12	2
10.5	5	●	MVS1050X05S110	54.4	85.9	89.9	150.9	149	1.9	11	2
10.5	5	●	MVS1050X05S120	54.4	85.9	89.9	150.9	149	1.9	12	2
10.5	8	●	MVS1050X08S110	85.9	117.9	122.9	183.9	182	1.9	11	2
10.5	8	●	MVS1050X08S120	85.9	117.9	122.9	183.9	182	1.9	12	2
10.5	10	●	MVS1050X10S110	106.9	138.9	141.9	202.9	201	1.9	11	4
10.5	15	●	MVS1050X15S110	159.4	190.9	193.9	254.9	253	1.9	11	4
10.5	20	●	MVS1050X20S110	211.9	243.9	246.9	307.9	306	1.9	11	4
10.5	25	●	MVS1050X25S110	264.4	295.9	298.9	359.9	358	1.9	11	4
10.6	3	●	MVS1060X03S110	33.7	56.9	56.9	117.9	116	1.9	11	2
10.6	3	●	MVS1060X03S120	33.7	56.9	57.9	117.9	116	1.9	12	2
10.6	5	●	MVS1060X05S110	54.9	89.9	89.9	150.9	149	1.9	11	2
10.6	5	●	MVS1060X05S120	54.9	89.9	90.9	150.9	149	1.9	12	2
10.6	8	●	MVS1060X08S110	86.7	122.9	122.9	183.9	182	1.9	11	2
10.6	8	●	MVS1060X08S120	86.7	122.9	123.9	183.9	182	1.9	12	2
10.6	10	●	MVS1060X10S110	107.9	144.9	147.9	208.9	207	1.9	11	4
10.6	15	●	MVS1060X15S110	160.9	199.9	202.9	263.9	262	1.9	11	4
10.6	20	●	MVS1060X20S110	213.9	254.9	257.9	318.9	317	1.9	11	4
10.6	25	●	MVS1060X25S110	266.9	309.9	312.9	373.9	372	1.9	11	4
10.7	3	●	MVS1070X03S110	34.0	56.9	56.9	117.9	116	1.9	11	2
10.7	3	●	MVS1070X03S120	34.0	56.9	57.9	117.9	116	1.9	12	2
10.7	5	●	MVS1070X05S110	55.4	89.9	89.9	150.9	149	1.9	11	2
10.7	5	●	MVS1070X05S120	55.4	89.9	90.9	150.9	149	1.9	12	2
10.7	8	●	MVS1070X08S110	87.5	122.9	122.9	183.9	182	1.9	11	2
10.7	8	●	MVS1070X08S120	87.5	122.9	123.9	183.9	182	1.9	12	2
10.7	10	●	MVS1070X10S110	108.9	144.9	147.9	208.9	207	1.9	11	4
10.7	15	●	MVS1070X15S110	162.4	199.9	202.9	263.9	262	1.9	11	4
10.7	20	●	MVS1070X20S110	215.9	254.9	257.9	318.9	317	1.9	11	4
10.7	25	●	MVS1070X25S110	269.4	309.9	312.9	373.9	372	1.9	11	4
10.8	3	●	MVS1080X03S110	34.4	57.0	57.0	118.0	116	2.0	11	2
10.8	3	●	MVS1080X03S120	34.4	57.0	58.0	118.0	116	2.0	12	2
10.8	5	●	MVS1080X05S110	56.0	90.0	90.0	151.0	149	2.0	11	2
10.8	5	●	MVS1080X05S120	56.0	90.0	91.0	151.0	149	2.0	12	2
10.8	8	●	MVS1080X08S110	88.4	123.0	123.0	184.0	182	2.0	11	2
10.8	8	●	MVS1080X08S120	88.4	123.0	124.0	184.0	182	2.0	12	2
10.8	10	●	MVS1080X10S110	110.0	145.0	148.0	209.0	207	2.0	11	4
10.8	15	●	MVS1080X15S110	164.0	200.0	203.0	264.0	262	2.0	11	4
10.8	20	●	MVS1080X20S110	218.0	255.0	258.0	319.0	317	2.0	11	4
10.8	25	●	MVS1080X25S110	272.0	310.0	313.0	374.0	372	2.0	11	4
10.9	3	●	MVS1090X03S110	34.7	57.0	57.0	118.0	116	2.0	11	2
10.9	3	●	MVS1090X03S120	34.7	57.0	58.0	118.0	116	2.0	12	2
10.9	5	●	MVS1090X05S110	56.5	90.0	90.0	151.0	149	2.0	11	2
10.9	5	●	MVS1090X05S120	56.5	90.0	91.0	151.0	149	2.0	12	2
10.9	8	●	MVS1090X08S110	89.2	123.0	123.0	184.0	182	2.0	11	2

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.9	8	●	MVS1090X08S120	89.2	123.0	124.0	184.0	182	2.0	12	2
10.9	10	●	MVS1090X10S110	111.0	145.0	148.0	209.0	207	2.0	11	4
10.9	15	●	MVS1090X15S110	165.5	200.0	203.0	264.0	262	2.0	11	4
10.9	20	●	MVS1090X20S110	220.0	255.0	258.0	319.0	317	2.0	11	4
10.9	25	●	MVS1090X25S110	274.5	310.0	313.0	374.0	372	2.0	11	4
11.0	3	●	MVS1100X03S110	35.0	57.0	57.0	118.0	116	2.0	11	2
11.0	3	●	MVS1100X03S120	35.0	57.0	58.0	118.0	116	2.0	12	2
11.0	5	●	MVS1100X05S110	57.0	90.0	90.0	151.0	149	2.0	11	2
11.0	5	●	MVS1100X05S120	57.0	90.0	91.0	151.0	149	2.0	12	2
11.0	8	●	MVS1100X08S110	90.0	123.0	123.0	184.0	182	2.0	11	2
11.0	8	●	MVS1100X08S120	90.0	123.0	124.0	184.0	182	2.0	12	2
11.0	10	●	MVS1100X10S110	112.0	145.0	147.0	209.0	207	2.0	11	4
11.0	15	●	MVS1100X15S110	167.0	200.0	203.0	264.0	262	2.0	11	4
11.0	20	●	MVS1100X20S110	222.0	255.0	258.0	319.0	317	2.0	11	4
11.0	25	●	MVS1100X25S110	277.0	310.0	313.0	374.0	372	2.0	11	4
11.1	3	●	MVS1110X03S120	35.3	59.5	62.0	124.0	122	2.0	12	2
11.1	5	●	MVS1110X05S120	57.5	94.0	98.0	160.0	158	2.0	12	2
11.1	8	●	MVS1110X08S120	90.8	129.0	134.0	196.0	194	2.0	12	2
11.1	10	●	MVS1110X10S120	113.0	152.0	155.0	217.0	215	2.0	12	4
11.1	15	●	MVS1110X15S120	168.5	209.0	212.0	274.0	272	2.0	12	4
11.1	20	●	MVS1110X20S120	224.0	267.0	270.0	332.0	330	2.0	12	4
11.1	25	●	MVS1110X25S120	279.5	324.0	327.0	389.0	387	2.0	12	4
11.2	3	●	MVS1120X03S120	35.6	59.5	62.0	124.0	122	2.0	12	2
11.2	5	●	MVS1120X05S120	58.0	94.0	98.0	160.0	158	2.0	12	2
11.2	8	●	MVS1120X08S120	91.6	129.0	134.0	196.0	194	2.0	12	2
11.2	10	●	MVS1120X10S120	114.0	152.0	155.0	217.0	215	2.0	12	4
11.2	15	●	MVS1120X15S120	170.0	209.0	212.0	274.0	272	2.0	12	4
11.2	20	●	MVS1120X20S120	226.0	267.0	270.0	332.0	330	2.0	12	4
11.2	25	●	MVS1120X25S120	282.0	324.0	327.0	389.0	387	2.0	12	4
11.3	3	●	MVS1130X03S120	36.0	59.6	62.1	124.1	122	2.1	12	2
11.3	5	●	MVS1130X05S120	58.6	94.1	98.1	160.1	158	2.1	12	2
11.3	8	●	MVS1130X08S120	92.5	129.1	134.1	196.1	194	2.1	12	2
11.3	10	●	MVS1130X10S120	115.1	152.1	155.1	217.1	215	2.1	12	4
11.3	15	●	MVS1130X15S120	171.6	209.1	212.1	274.1	272	2.1	12	4
11.3	20	●	MVS1130X20S120	228.1	267.1	270.1	332.1	330	2.1	12	4
11.3	25	●	MVS1130X25S120	284.6	324.1	327.1	389.1	387	2.1	12	4
11.4	3	●	MVS1140X03S120	36.3	59.6	62.1	124.1	122	2.1	12	2
11.4	5	●	MVS1140X05S120	59.1	94.1	98.1	160.1	158	2.1	12	2
11.4	8	●	MVS1140X08S120	93.3	129.1	134.1	196.1	194	2.1	12	2
11.4	10	●	MVS1140X10S120	116.1	152.1	155.1	217.1	215	2.1	12	4
11.4	15	●	MVS1140X15S120	173.1	209.1	212.1	274.1	272	2.1	12	4
11.4	20	●	MVS1140X20S120	230.1	267.1	270.1	332.1	330	2.1	12	4
11.4	25	●	MVS1140X25S120	287.1	324.1	327.1	389.1	387	2.1	12	4
11.5	3	●	MVS1150X03S120	36.6	59.6	62.1	124.1	122	2.1	12	2
11.5	5	●	MVS1150X05S120	59.6	94.1	98.1	160.1	158	2.1	12	2
11.5	8	●	MVS1150X08S120	94.1	129.1	134.1	196.1	194	2.1	12	2
11.5	10	●	MVS1150X10S120	117.1	152.1	155.1	217.1	215	2.1	12	4
11.5	15	●	MVS1150X15S120	174.6	209.1	212.1	274.1	272	2.1	12	4
11.5	20	●	MVS1150X20S120	232.1	267.1	270.1	332.1	330	2.1	12	4
11.5	25	●	MVS1150X25S120	289.6	324.1	327.1	389.1	387	2.1	12	4
11.6	3	●	MVS1160X03S120	36.9	62.1	62.1	124.1	122	2.1	12	2
11.6	5	●	MVS1160X05S120	60.1	98.1	98.1	160.1	158	2.1	12	2
11.6	8	●	MVS1160X08S120	94.9	134.1	134.1	196.1	194	2.1	12	2
11.6	10	●	MVS1160X10S120	118.1	158.1	161.1	223.1	221	2.1	12	4
11.6	15	●	MVS1160X15S120	176.1	218.1	221.1	283.1	281	2.1	12	4
11.6	20	●	MVS1160X20S120	234.1	278.1	281.1	343.1	341	2.1	12	4
11.6	25	●	MVS1160X25S120	292.1	338.1	341.1	403.1	401	2.1	12	4
11.7	3	●	MVS1170X03S120	37.2	62.1	62.1	124.1	122	2.1	12	2
11.7	5	●	MVS1170X05S120	60.6	98.1	98.1	160.1	158	2.1	12	2
11.7	8	●	MVS1170X08S120	95.7	134.1	134.1	196.1	194	2.1	12	2
11.7	10	●	MVS1170X10S120	119.1	158.1	161.1	223.1	221	2.1	12	4
11.7	15	●	MVS1170X15S120	177.6	218.1	221.1	283.1	281	2.1	12	4
11.7	20	●	MVS1170X20S120	236.1	278.1	281.1	343.1	341	2.1	12	4
11.7	25	●	MVS1170X25S120	294.6	338.1	341.1	403.1	401	2.1	12	4
11.8	3	●	MVS1180X03S120	37.5	62.1	62.1	124.1	122	2.1	12	2
11.8	5	●	MVS1180X05S120	61.1	98.1	98.1	160.1	158	2.1	12	2
11.8	8	●	MVS1180X08S120	96.5	134.1	134.1	196.1	194	2.1	12	2
11.8	10	●	MVS1180X10S120	120.1	158.1	161.1	223.1	221	2.1	12	4
11.8	15	●	MVS1180X15S120	179.1	218.1	221.1	283.1	281	2.1	12	4
11.8	20	●	MVS1180X20S120	238.1	278.1	281.1	343.1	341	2.1	12	4
11.8	25	●	MVS1180X25S120	297.1	338.1	341.1	403.1	401	2.1	12	4
11.9	3	●	MVS1190X03S120	37.9	62.2	62.2	124.2	122	2.2	12	2
11.9	5	●	MVS1190X05S120	61.7	98.2	98.2	160.2	158	2.2	12	2
11.9	8	●	MVS1190X08S120	97.4	134.2	134.2	196.2	194	2.2	12	2
11.9	10	●	MVS1190X10S120	121.2	158.2	161.2	223.2	221	2.2	12	4
11.9	15	●	MVS1190X15S120	180.7	218.2	221.2	283.2	281	2.2	12	4
11.9	20	●	MVS1190X20S120	240.2	278.2	281.2	343.2	341	2.2	12	4
11.9	25	●	MVS1190X25S120	299.7	338.2	341.2	403.2	401	2.2	12	4
12.0	3	●	MVS1200X03S120	38.2	62.2	62.2	124.2	122	2.2	12	2
12.0	5	●	MVS1200X05S120	62.2	98.2	98.2	160.2	158	2.2	12	2
12.0	8	●	MVS1200X08S120	98.2	134.2	134.2	196.2	194	2.2	12	2
12.0	10	●	MVS1200X10S120	122.2	158.2	161.2	223.2	221	2.2	12	4
12.0	15	●	MVS1200X15S120	182.2	218.2	221.2	283.2	281	2.2	12	4
12.0	20	●	MVS1200X20S120	242.2	278.2	281.2	343.2	341	2.2	12	4
12.0	25	●	MVS1200X25S120	302.2	338.2	341.2	403.2	401	2.2	12	4
12.1	3	●	MVS1210X03S130	38.5	64.7	67.2	130.2	128	2.2	13	2
12.1	3	□	MVS1210X03S140	38.5	64.7	67.2	130.2	128	2.2	14	2
12.1	5	●	MVS1210X05S130	62.7	102.2	106.2	169.2	167	2.2	13	2
12.1	5	□	MVS1210X05S140	62.7	102.2	106.2	169.2	167	2.2	14	2
12.1	8	□	MVS1210X08S130	99.0	140.2	145.2	208.2	206	2.2	13	2
12.1	8	□	MVS1210X08S140	99.0	140.2	145.2	208.2	206	2.2	14	2
12.1	10	□	MVS1210X10S130	123.2	165.2	168.2	231.2	229	2.2	13	4
12.1	15	□	MVS1210X15S130	183.7	227.2	230.2	293.2	291	2.2	13	4
12.1	20	□	MVS1210X20S130	244.2	290.2	293.2	356.2	354	2.2	13	4
12.2	3	●	MVS1220X03S130	38.8	64.7	67.2	130.2	128	2.2	13	2
12.2	3	□	MVS1220X03S140	38.8	64.7	67.2	130.2	128	2.2	14	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.2	5	●	MVS1220X05S130	63.2	102.2	106.2	169.2	167	2.2	13	2
12.2	5	□	MVS1220X05S140	63.2	102.2	106.2	169.2	167	2.2	14	2
12.2	8	□	MVS1220X08S130	99.8	140.2	145.2	208.2	206	2.2	13	2
12.2	8	□	MVS1220X08S140	99.8	140.2	145.2	208.2	206	2.2	14	2
12.2	10	□	MVS1220X10S130	124.2	165.2	168.2	231.2	229	2.2	13	4
12.2	15	□	MVS1220X15S130	185.2	227.2	230.2	293.2	291	2.2	13	4
12.2	20	□	MVS1220X20S130	246.2	290.2	293.2	356.2	354	2.2	13	4
12.3	3	●	MVS1230X03S130	39.1	64.7	67.2	130.2	128	2.2	13	2
12.3	3	□	MVS1230X03S140	39.1	64.7	67.2	130.2	128	2.2	14	2
12.3	5	●	MVS1230X05S130	63.7	102.2	106.2	169.2	167	2.2	13	2
12.3	5	□	MVS1230X05S140	63.7	102.2	106.2	169.2	167	2.2	14	2
12.3	8	□	MVS1230X08S130	100.6	140.2	145.2	208.2	206	2.2	13	2
12.3	8	□	MVS1230X08S140	100.6	140.2	145.2	208.2	206	2.2	14	2
12.3	10	□	MVS1230X10S130	125.2	165.2	168.2	231.2	229	2.2	13	4
12.3	15	□	MVS1230X15S130	186.7	227.2	230.2	293.2	291	2.2	13	4
12.3	20	□	MVS1230X20S130	248.2	290.2	293.2	356.2	354	2.2	13	4
12.4	3	●	MVS1240X03S130	39.5	64.8	67.3	130.3	128	2.3	13	2
12.4	3	□	MVS1240X03S140	39.5	64.8	67.3	130.3	128	2.3	14	2
12.4	5	●	MVS1240X05S130	64.3	102.3	106.3	169.3	167	2.3	13	2
12.4	5	□	MVS1240X05S140	64.3	102.3	106.3	169.3	167	2.3	14	2
12.4	8	□	MVS1240X08S130	101.5	140.3	145.3	208.3	206	2.3	13	2
12.4	8	□	MVS1240X08S140	101.5	140.3	145.3	208.3	206	2.3	14	2
12.4	10	□	MVS1240X10S130	126.3	165.3	168.3	231.3	229	2.3	13	4
12.4	15	□	MVS1240X15S130	188.3	227.3	230.3	293.3	291	2.3	13	4
12.4	20	□	MVS1240X20S130	250.3	290.3	293.3	356.3	354	2.3	13	4
12.5	3	●	MVS1250X03S130	39.8	64.8	67.3	130.3	128	2.3	13	2
12.5	3	□	MVS1250X03S140	39.8	64.8	67.3	130.3	128	2.3	14	2
12.5	5	●	MVS1250X05S130	64.8	102.3	106.3	169.3	167	2.3	13	2
12.5	5	□	MVS1250X05S140	64.8	102.3	106.3	169.3	167	2.3	14	2
12.5	8	●	MVS1250X08S130	102.3	140.3	145.3	208.3	206	2.3	13	2
12.5	8	□	MVS1250X08S140	102.3	140.3	145.3	208.3	206	2.3	14	2
12.5	10	●	MVS1250X10S130	127.3	165.3	168.3	231.3	229	2.3	13	4
12.5	15	●	MVS1250X15S130	189.8	227.3	230.3	293.3	291	2.3	13	4
12.5	20	●	MVS1250X20S130	252.3	290.3	293.3	356.3	354	2.3	13	4
12.6	3	●	MVS1260X03S130	40.1	67.3	67.3	130.3	128	2.3	13	2
12.6	3	□	MVS1260X03S140	40.1	67.3	67.3	130.3	128	2.3	14	2
12.6	5	●	MVS1260X05S130	65.3	106.3	106.3	169.3	167	2.3	13	2
12.6	5	□	MVS1260X05S140	65.3	106.3	106.3	169.3	167	2.3	14	2
12.6	8	□	MVS1260X08S130	103.1	145.3	145.3	208.3	206	2.3	13	2
12.6	8	□	MVS1260X08S140	103.1	145.3	145.3	208.3	206	2.3	14	2
12.6	10	□	MVS1260X10S130	128.3	171.3	174.3	237.3	235	2.3	13	4
12.6	15	□	MVS1260X15S130	191.3	236.3	239.3	302.3	300	2.3	13	4
12.6	20	□	MVS1260X20S130	254.3	301.3	304.3	367.3	365	2.3	13	4
12.7	3	●	MVS1270X03S130	40.4	67.3	67.3	130.3	128	2.3	13	2
12.7	3	□	MVS1270X03S140	40.4	67.3	67.3	130.3	128	2.3	14	2
12.7	5	●	MVS1270X05S130	65.8	106.3	106.3	169.3	167	2.3	13	2
12.7	5	□	MVS1270X05S140	65.8	106.3	106.3	169.3	167	2.3	14	2
12.7	8	□	MVS1270X08S130	103.9	145.3	145.3	208.3	206	2.3	13	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.7	8	□	MVS1270X08S140	103.9	145.3	145.3	208.3	206	2.3	14	2
12.7	10	□	MVS1270X10S130	129.3	171.3	174.3	237.3	235	2.3	13	4
12.7	15	□	MVS1270X15S130	192.8	236.3	239.3	302.3	300	2.3	13	4
12.7	20	□	MVS1270X20S130	256.3	301.3	304.3	367.3	365	2.3	13	4
12.8	3	●	MVS1280X03S130	40.7	67.3	67.3	130.3	128	2.3	13	2
12.8	3	□	MVS1280X03S140	40.7	67.3	67.3	130.3	128	2.3	14	2
12.8	5	●	MVS1280X05S130	66.3	106.3	106.3	169.3	167	2.3	13	2
12.8	5	□	MVS1280X05S140	66.3	106.3	106.3	169.3	167	2.3	14	2
12.8	8	□	MVS1280X08S130	104.7	145.3	145.3	208.3	206	2.3	13	2
12.8	8	□	MVS1280X08S140	104.7	145.3	145.3	208.3	206	2.3	14	2
12.8	10	□	MVS1280X10S130	130.3	171.3	174.3	237.3	235	2.3	13	4
12.8	15	□	MVS1280X15S130	194.3	236.3	239.3	302.3	300	2.3	13	4
12.8	20	□	MVS1280X20S130	258.3	301.3	304.3	367.3	365	2.3	13	4
12.9	3	●	MVS1290X03S130	41.0	67.3	67.3	130.3	128	2.3	13	2
12.9	3	□	MVS1290X03S140	41.0	67.3	67.3	130.3	128	2.3	14	2
12.9	5	●	MVS1290X05S130	66.8	106.3	106.3	169.3	167	2.3	13	2
12.9	5	□	MVS1290X05S140	66.8	106.3	106.3	169.3	167	2.3	14	2
12.9	8	□	MVS1290X08S130	105.5	145.3	145.3	208.3	206	2.3	13	2
12.9	8	□	MVS1290X08S140	105.5	145.3	145.3	208.3	206	2.3	14	2
12.9	10	□	MVS1290X10S130	131.3	171.3	174.3	237.3	235	2.3	13	4
12.9	15	□	MVS1290X15S130	195.8	236.3	239.3	302.3	300	2.3	13	4
12.9	20	□	MVS1290X20S130	260.3	301.3	304.3	367.3	365	2.3	13	4
13.0	3	●	MVS1300X03S130	41.4	67.4	67.4	130.4	128	2.4	13	2
13.0	3	□	MVS1300X03S140	41.4	67.4	67.4	130.4	128	2.4	14	2
13.0	5	●	MVS1300X05S130	67.4	106.4	106.4	169.4	167	2.4	13	2
13.0	5	□	MVS1300X05S140	67.4	106.4	106.4	169.4	167	2.4	14	2
13.0	8	●	MVS1300X08S130	106.4	145.4	145.4	208.4	206	2.4	13	2
13.0	8	□	MVS1300X08S140	106.4	145.4	145.4	208.4	206	2.4	14	2
13.0	10	●	MVS1300X10S130	132.4	171.4	174.4	237.4	235	2.4	13	4
13.0	15	●	MVS1300X15S130	197.4	236.4	239.4	302.4	300	2.4	13	4
13.0	20	●	MVS1300X20S130	262.4	301.4	304.4	367.4	365	2.4	13	4
13.1	3	●	MVS1310X03S140	41.7	69.9	72.4	136.4	134	2.4	14	2
13.1	5	●	MVS1310X05S140	67.9	110.4	114.4	178.4	176	2.4	14	2
13.1	8	□	MVS1310X08S140	107.2	151.4	156.4	220.4	218	2.4	14	2
13.1	10	□	MVS1310X10S140	133.4	178.4	181.4	245.4	243	2.4	14	4
13.1	15	□	MVS1310X15S140	198.9	245.4	248.4	312.4	310	2.4	14	4
13.1	20	□	MVS1310X20S140	264.4	313.4	316.4	380.4	378	2.4	14	4
13.2	3	●	MVS1320X03S140	42.0	69.9	72.4	136.4	134	2.4	14	2
13.2	5	●	MVS1320X05S140	68.4	110.4	114.4	178.4	176	2.4	14	2
13.2	8	□	MVS1320X08S140	108.0	151.4	156.4	220.4	218	2.4	14	2
13.2	10	□	MVS1320X10S140	134.4	178.4	181.4	245.4	243	2.4	14	4
13.2	15	□	MVS1320X15S140	200.4	245.4	248.4	312.4	310	2.4	14	4
13.2	20	□	MVS1320X20S140	266.4	313.4	316.4	380.4	378	2.4	14	4
13.3	3	●	MVS1330X03S140	42.3	69.9	72.4	136.4	134	2.4	14	2
13.3	5	●	MVS1330X05S140	68.9	110.4	114.4	178.4	176	2.4	14	2
13.3	8	□	MVS1330X08S140	108.8	151.4	156.4	220.4	218	2.4	14	2
13.3	10	□	MVS1330X10S140	135.4	178.4	181.4	245.4	243	2.4	14	4
13.3	15	□	MVS1330X15S140	201.9	245.4	248.4	312.4	310	2.4	14	4

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
13.3	20	□	MVS1330X20S140	268.4	313.4	316.4	380.4	378	2.4	14	4
13.4	3	●	MVS1340X03S140	42.6	69.9	72.4	136.4	134	2.4	14	2
13.4	5	●	MVS1340X05S140	69.4	110.4	114.4	178.4	176	2.4	14	2
13.4	8	□	MVS1340X08S140	109.6	151.4	156.4	220.4	218	2.4	14	2
13.4	10	□	MVS1340X10S140	136.4	178.4	181.4	245.4	243	2.4	14	4
13.4	15	□	MVS1340X15S140	203.4	245.4	248.4	312.4	310	2.4	14	4
13.4	20	□	MVS1340X20S140	270.4	313.4	316.4	380.4	378	2.4	14	4
13.5	3	●	MVS1350X03S140	43.0	70.0	72.5	136.5	134	2.5	14	2
13.5	5	●	MVS1350X05S140	70.0	110.5	114.5	178.5	176	2.5	14	2
13.5	8	●	MVS1350X08S140	110.5	151.5	156.5	220.5	218	2.5	14	2
13.5	10	●	MVS1350X10S140	137.5	178.5	181.5	245.5	243	2.5	14	4
13.5	15	●	MVS1350X15S140	205.0	245.5	248.5	312.5	310	2.5	14	4
13.5	20	●	MVS1350X20S140	272.5	313.5	316.5	380.5	378	2.5	14	4
13.6	3	●	MVS1360X03S140	43.3	72.5	72.5	136.5	134	2.5	14	2
13.6	5	●	MVS1360X05S140	70.5	114.5	114.5	178.5	176	2.5	14	2
13.6	8	□	MVS1360X08S140	111.3	156.5	156.5	220.5	218	2.5	14	2
13.6	10	□	MVS1360X10S140	138.5	184.5	187.5	251.5	249	2.5	14	4
13.6	15	□	MVS1360X15S140	206.5	254.5	257.5	321.5	319	2.5	14	4
13.6	20	□	MVS1360X20S140	274.5	324.5	327.5	391.5	389	2.5	14	4
13.7	3	●	MVS1370X03S140	43.6	72.5	72.5	136.5	134	2.5	14	2
13.7	5	●	MVS1370X05S140	71.0	114.5	114.5	178.5	176	2.5	14	2
13.7	8	□	MVS1370X08S140	112.1	156.5	156.5	220.5	218	2.5	14	2
13.7	10	□	MVS1370X10S140	139.5	184.5	187.5	251.5	249	2.5	14	4
13.7	15	□	MVS1370X15S140	208.0	254.5	257.5	321.5	319	2.5	14	4
13.7	20	□	MVS1370X20S140	276.5	324.5	327.5	391.5	389	2.5	14	4
13.8	3	●	MVS1380X03S140	43.9	72.5	72.5	136.5	134	2.5	14	2
13.8	5	●	MVS1380X05S140	71.5	114.5	114.5	178.5	176	2.5	14	2
13.8	8	□	MVS1380X08S140	112.9	156.5	156.5	220.5	218	2.5	14	2
13.8	10	□	MVS1380X10S140	140.5	184.5	187.5	251.5	249	2.5	14	4
13.8	15	□	MVS1380X15S140	209.5	254.5	257.5	321.5	319	2.5	14	4
13.8	20	□	MVS1380X20S140	278.5	324.5	327.5	391.5	389	2.5	14	4
13.9	3	●	MVS1390X03S140	44.2	72.5	72.5	136.5	134	2.5	14	2
13.9	5	●	MVS1390X05S140	72.0	114.5	114.5	178.5	176	2.5	14	2
13.9	8	□	MVS1390X08S140	113.7	156.5	156.5	220.5	218	2.5	14	2
13.9	10	□	MVS1390X10S140	141.5	184.5	187.5	251.5	249	2.5	14	4
13.9	15	□	MVS1390X15S140	211.0	254.5	257.5	321.5	319	2.5	14	4
13.9	20	□	MVS1390X20S140	280.5	324.5	327.5	391.5	389	2.5	14	4
14.0	3	●	MVS1400X03S140	44.5	72.5	72.5	136.5	134	2.5	14	2
14.0	5	●	MVS1400X05S140	72.5	114.5	114.5	178.5	176	2.5	14	2
14.0	8	●	MVS1400X08S140	114.5	156.5	156.5	220.5	218	2.5	14	2
14.0	10	●	MVS1400X10S140	142.5	184.5	187.5	251.5	249	2.5	14	4
14.0	15	●	MVS1400X15S140	212.5	254.5	257.5	321.5	319	2.5	14	4
14.0	20	●	MVS1400X20S140	282.5	324.5	327.5	391.5	389	2.5	14	4
14.1	3	●	MVS1410X03S150	44.9	75.1	77.6	142.6	140	2.6	15	2
14.1	3	□	MVS1410X03S160	44.9	75.1	77.6	142.6	140	2.6	16	2
14.1	5	●	MVS1410X05S150	73.1	118.6	122.6	187.6	185	2.6	15	2
14.1	5	□	MVS1410X05S160	73.1	118.6	122.6	187.6	185	2.6	16	2
14.1	8	□	MVS1410X08S150	115.4	162.6	167.6	227.6	225	2.6	15	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
14.1	8	□	MVS1410X08S160	115.4	162.6	167.6	227.6	225	2.6	16	2
14.2	3	●	MVS1420X03S150	45.2	75.1	77.6	142.6	140	2.6	15	2
14.2	3	□	MVS1420X03S160	45.2	75.1	77.6	142.6	140	2.6	16	2
14.2	5	●	MVS1420X05S150	73.6	118.6	122.6	187.6	185	2.6	15	2
14.2	5	□	MVS1420X05S160	73.6	118.6	122.6	187.6	185	2.6	16	2
14.2	8	●	MVS1420X08S150	116.2	162.6	167.6	227.6	225	2.6	15	2
14.2	8	□	MVS1420X08S160	116.2	162.6	167.6	227.6	225	2.6	16	2
14.3	3	●	MVS1430X03S150	45.5	75.1	77.6	142.6	140	2.6	15	2
14.3	3	□	MVS1430X03S160	45.5	75.1	77.6	142.6	140	2.6	16	2
14.3	5	●	MVS1430X05S150	74.1	118.6	122.6	187.6	185	2.6	15	2
14.3	5	□	MVS1430X05S160	74.1	118.6	122.6	187.6	185	2.6	16	2
14.3	8	□	MVS1430X08S150	117.0	162.6	167.6	227.6	225	2.6	15	2
14.3	8	□	MVS1430X08S160	117.0	162.6	167.6	227.6	225	2.6	16	2
14.4	3	●	MVS1440X03S150	45.8	75.1	77.6	142.6	140	2.6	15	2
14.4	3	□	MVS1440X03S160	45.8	75.1	77.6	142.6	140	2.6	16	2
14.4	5	●	MVS1440X05S150	74.6	118.6	122.6	187.6	185	2.6	15	2
14.4	5	□	MVS1440X05S160	74.6	118.6	122.6	187.6	185	2.6	16	2
14.4	8	□	MVS1440X08S150	117.8	162.6	167.6	227.6	225	2.6	15	2
14.4	8	□	MVS1440X08S160	117.8	162.6	167.6	227.6	225	2.6	16	2
14.5	3	●	MVS1450X03S150	46.1	75.1	77.6	142.6	140	2.6	15	2
14.5	3	□	MVS1450X03S160	46.1	75.1	77.6	142.6	140	2.6	16	2
14.5	5	●	MVS1450X05S150	75.1	118.6	122.6	187.6	185	2.6	15	2
14.5	5	□	MVS1450X05S160	75.1	118.6	122.6	187.6	185	2.6	16	2
14.5	8	●	MVS1450X08S150	118.6	162.6	167.6	227.6	225	2.6	15	2
14.5	8	□	MVS1450X08S160	118.6	162.6	167.6	227.6	225	2.6	16	2
14.6	3	●	MVS1460X03S150	46.5	77.7	77.7	142.7	140	2.7	15	2
14.6	3	□	MVS1460X03S160	46.5	77.7	77.7	142.7	140	2.7	16	2
14.6	5	●	MVS1460X05S150	75.7	122.7	122.7	187.7	185	2.7	15	2
14.6	5	□	MVS1460X05S160	75.7	122.7	122.7	187.7	185	2.7	16	2
14.6	8	□	MVS1460X08S150	119.5	167.7	167.7	227.7	225	2.7	15	2
14.6	8	□	MVS1460X08S160	119.5	167.7	167.7	227.7	225	2.7	16	2
14.7	3	●	MVS1470X03S150	46.8	77.7	77.7	142.7	140	2.7	15	2
14.7	3	□	MVS1470X03S160	46.8	77.7	77.7	142.7	140	2.7	16	2
14.7	5	●	MVS1470X05S150	76.2	122.7	122.7	187.7	185	2.7	15	2
14.7	5	□	MVS1470X05S160	76.2	122.7	122.7	187.7	185	2.7	16	2
14.7	8	□	MVS1470X08S150	120.3	167.7	167.7	227.7	225	2.7	15	2
14.7	8	□	MVS1470X08S160	120.3	167.7	167.7	227.7	225	2.7	16	2
14.8	3	●	MVS1480X03S150	47.1	77.7	77.7	142.7	140	2.7	15	2
14.8	3	□	MVS1480X03S160	47.1	77.7	77.7	142.7	140	2.7	16	2
14.8	5	●	MVS1480X05S150	76.7	122.7	122.7	187.7	185	2.7	15	2
14.8	5	□	MVS1480X05S160	76.7	122.7	122.7	187.7	185	2.7	16	2
14.8	8	□	MVS1480X08S150	121.1	167.7	167.7	227.7	225	2.7	15	2
14.8	8	□	MVS1480X08S160	121.1	167.7	167.7	227.7	225	2.7	16	2
14.9	3	●	MVS1490X03S150	47.4	77.7	77.7	142.7	140	2.7	15	2
14.9	3	□	MVS1490X03S160	47.4	77.7	77.7	142.7	140	2.7	16	2
14.9	5	●	MVS1490X05S150	77.2	122.7	122.7	187.7	185	2.7	15	2
14.9	5	□	MVS1490X05S160	77.2	122.7	122.7	187.7	185	2.7	16	2
14.9	8	□	MVS1490X08S150	121.9	167.7	167.7	227.7	225	2.7	15	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
14.9	8	□	MVS1490X08S160	121.9	167.7	167.7	227.7	225	2.7	16	2
15.0	3	●	MVS1500X03S150	47.7	77.7	77.7	142.7	140	2.7	15	2
15.0	3	□	MVS1500X03S160	47.7	77.7	77.7	142.7	140	2.7	16	2
15.0	5	●	MVS1500X05S150	77.7	122.7	122.7	187.7	185	2.7	15	2
15.0	5	□	MVS1500X05S160	77.7	122.7	122.7	187.7	185	2.7	16	2
15.0	8	●	MVS1500X08S150	122.7	167.7	167.7	227.7	225	2.7	15	2
15.0	8	□	MVS1500X08S160	122.7	167.7	167.7	227.7	225	2.7	16	2
15.1	3	●	MVS1510X03S160	48.0	80.2	82.7	147.7	145	2.7	16	2
15.1	5	●	MVS1510X05S160	78.2	126.7	130.7	195.7	193	2.7	16	2
15.1	8	□	MVS1510X08S160	123.5	173.7	183.7	243.7	241	2.7	16	2
15.2	3	●	MVS1520X03S160	48.4	80.3	82.8	147.8	145	2.8	16	2
15.2	5	●	MVS1520X05S160	78.8	126.8	130.8	195.8	193	2.8	16	2
15.2	8	□	MVS1520X08S160	124.4	173.8	183.8	243.8	241	2.8	16	2
15.3	3	●	MVS1530X03S160	48.7	80.3	82.8	147.8	145	2.8	16	2
15.3	5	●	MVS1530X05S160	79.3	126.8	130.8	195.8	193	2.8	16	2
15.3	8	□	MVS1530X08S160	125.2	173.8	183.8	243.8	241	2.8	16	2
15.4	3	●	MVS1540X03S160	49.0	80.3	82.8	147.8	145	2.8	16	2
15.4	5	●	MVS1540X05S160	79.8	126.8	130.8	195.8	193	2.8	16	2
15.4	8	□	MVS1540X08S160	126.0	173.8	183.8	243.8	241	2.8	16	2
15.5	3	●	MVS1550X03S160	49.3	80.3	82.8	147.8	145	2.8	16	2
15.5	5	●	MVS1550X05S160	80.3	126.8	130.8	195.8	193	2.8	16	2
15.5	8	●	MVS1550X08S160	126.8	173.8	183.8	243.8	241	2.8	16	2
15.6	3	●	MVS1560X03S160	49.6	82.8	82.8	147.8	145	2.8	16	2
15.6	5	●	MVS1560X05S160	80.8	130.8	130.8	195.8	193	2.8	16	2
15.6	8	□	MVS1560X08S160	127.6	178.8	183.8	243.8	241	2.8	16	2
15.7	3	●	MVS1570X03S160	50.0	82.9	82.9	147.9	145	2.9	16	2
15.7	5	●	MVS1570X05S160	81.4	130.9	130.9	195.9	193	2.9	16	2
15.7	8	□	MVS1570X08S160	128.5	178.9	183.9	243.9	241	2.9	16	2
15.8	3	●	MVS1580X03S160	50.3	82.9	82.9	147.9	145	2.9	16	2
15.8	5	●	MVS1580X05S160	81.9	130.9	130.9	195.9	193	2.9	16	2
15.8	8	□	MVS1580X08S160	129.3	178.9	183.9	243.9	241	2.9	16	2
15.9	3	●	MVS1590X03S160	50.6	82.9	82.9	147.9	145	2.9	16	2
15.9	5	●	MVS1590X05S160	82.4	130.9	130.9	195.9	193	2.9	16	2
15.9	8	□	MVS1590X08S160	130.1	178.9	183.9	243.9	241	2.9	16	2
16.0	3	●	MVS1600X03S160	50.9	82.9	82.9	147.9	145	2.9	16	2
16.0	5	●	MVS1600X05S160	82.9	130.9	130.9	195.9	193	2.9	16	2
16.0	8	●	MVS1600X08S160	130.9	178.9	183.9	243.9	241	2.9	16	2
16.1	3	□	MVS1610X03S170	51.2	85.4	87.9	152.9	150	2.9	17	2
16.1	3	□	MVS1610X03S180	51.2	85.4	87.9	152.9	150	2.9	18	2
16.1	5	□	MVS1610X05S170	83.4	134.9	138.9	203.9	201	2.9	17	2
16.1	5	□	MVS1610X05S180	83.4	134.9	138.9	203.9	201	2.9	18	2
16.2	3	□	MVS1620X03S170	51.5	85.4	87.9	152.9	150	2.9	17	2
16.2	3	□	MVS1620X03S180	51.5	85.4	87.9	152.9	150	2.9	18	2
16.2	5	□	MVS1620X05S170	83.9	134.9	138.9	203.9	201	2.9	17	2
16.2	5	□	MVS1620X05S180	83.9	134.9	138.9	203.9	201	2.9	18	2
16.3	3	□	MVS1630X03S170	51.9	85.5	88.0	153.0	150	3.0	17	2
16.3	3	□	MVS1630X03S180	51.9	85.5	88.0	153.0	150	3.0	18	2
16.3	5	□	MVS1630X05S170	84.5	135.0	139.0	204.0	201	3.0	17	2
16.3	5	□	MVS1630X05S180	84.5	135.0	139.0	204.0	201	3.0	18	2
16.4	3	□	MVS1640X03S170	52.2	85.5	88.0	153.0	150	3.0	17	2
16.4	3	□	MVS1640X03S180	52.2	85.5	88.0	153.0	150	3.0	18	2
16.4	5	□	MVS1640X05S170	85.0	135.0	139.0	204.0	201	3.0	17	2
16.4	5	□	MVS1640X05S180	85.0	135.0	139.0	204.0	201	3.0	18	2
16.5	3	●	MVS1650X03S170	52.5	85.5	88.0	153.0	150	3.0	17	2
16.5	3	□	MVS1650X03S180	52.5	85.5	88.0	153.0	150	3.0	18	2
16.5	5	●	MVS1650X05S170	85.5	135.0	139.0	204.0	201	3.0	17	2
16.5	5	□	MVS1650X05S180	85.5	135.0	139.0	204.0	201	3.0	18	2
16.6	3	□	MVS1660X03S170	52.8	88.0	88.0	153.0	150	3.0	17	2
16.6	3	□	MVS1660X03S180	52.8	88.0	88.0	153.0	150	3.0	18	2
16.6	5	□	MVS1660X05S170	86.0	139.0	139.0	204.0	201	3.0	17	2
16.6	5	□	MVS1660X05S180	86.0	139.0	139.0	204.0	201	3.0	18	2
16.7	3	□	MVS1670X03S170	53.1	88.0	88.0	153.0	150	3.0	17	2
16.7	3	□	MVS1670X03S180	53.1	88.0	88.0	153.0	150	3.0	18	2
16.7	5	□	MVS1670X05S170	86.5	139.0	139.0	204.0	201	3.0	17	2
16.7	5	□	MVS1670X05S180	86.5	139.0	139.0	204.0	201	3.0	18	2
16.8	3	□	MVS1680X03S170	53.5	88.1	88.1	153.1	150	3.1	17	2
16.8	3	□	MVS1680X03S180	53.5	88.1	88.1	153.1	150	3.1	18	2
16.8	5	□	MVS1680X05S170	87.1	139.1	139.1	204.1	201	3.1	17	2
16.8	5	□	MVS1680X05S180	87.1	139.1	139.1	204.1	201	3.1	18	2
16.9	3	□	MVS1690X03S170	53.8	88.1	88.1	153.1	150	3.1	17	2
16.9	3	□	MVS1690X03S180	53.8	88.1	88.1	153.1	150	3.1	18	2
16.9	5	□	MVS1690X05S170	87.6	139.1	139.1	204.1	201	3.1	17	2
16.9	5	□	MVS1690X05S180	87.6	139.1	139.1	204.1	201	3.1	18	2
17.0	3	●	MVS1700X03S170	54.1	88.1	88.1	153.1	150	3.1	17	2
17.0	3	□	MVS1700X03S180	54.1	88.1	88.1	153.1	150	3.1	18	2
17.0	5	●	MVS1700X05S170	88.1	139.1	139.1	204.1	201	3.1	17	2
17.0	5	□	MVS1700X05S180	88.1	139.1	139.1	204.1	201	3.1	18	2
17.1	3	□	MVS1710X03S180	54.4	90.6	93.1	158.1	155	3.1	18	2
17.1	5	□	MVS1710X05S180	88.6	143.1	147.1	212.1	209	3.1	18	2
17.2	3	□	MVS1720X03S180	54.7	90.6	93.1	158.1	155	3.1	18	2
17.2	5	□	MVS1720X05S180	89.1	143.1	147.1	212.1	209	3.1	18	2
17.3	3	□	MVS1730X03S180	55.0	90.6	93.1	158.1	155	3.1	18	2
17.3	5	□	MVS1730X05S180	89.6	143.1	147.1	212.1	209	3.1	18	2
17.4	3	□	MVS1740X03S180	55.4	90.7	93.2	158.2	155	3.2	18	2
17.4	5	□	MVS1740X05S180	90.2	143.2	147.2	212.2	209	3.2	18	2
17.5	3	●	MVS1750X03S180	55.7	90.7	93.2	158.2	155	3.2	18	2
17.5	5	●	MVS1750X05S180	90.7	143.2	147.2	212.2	209	3.2	18	2
17.6	3	□	MVS1760X03S180	56.0	93.2	93.2	158.2	155	3.2	18	2
17.6	5	□	MVS1760X05S180	91.2	147.2	147.2	212.2	209	3.2	18	2
17.7	3	□	MVS1770X03S180	56.3	93.2	93.2	158.2	155	3.2	18	2
17.7	5	□	MVS1770X05S180	91.7	147.2	147.2	212.2	209	3.2	18	2
17.8	3	□	MVS1780X03S180	56.6	93.2	93.2	158.2	155	3.2	18	2
17.8	5	□	MVS1780X05S180	92.2	147.2	147.2	212.2	209	3.2	18	2
17.9	3	□	MVS1790X03S180	57.0	93.3	93.3	158.3	155	3.3	18	2
17.9	5	□	MVS1790X05S180	92.8	147.3	147.3	212.3	209	3.3	18	2
18.0	3	●	MVS1800X03S180	57.3	93.3	93.3	158.3	155	3.3	18	2

CUTTING CONDITIONS ➤ P039
TECHNICAL DATA ➤ R001

MVS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
18.0	5	●	MVS1800X05S180	93.3	147.3	147.3	212.3	209	3.3	18	2
18.1	3	□	MVS1810X03S190	57.6	95.8	98.3	163.3	160	3.3	19	2
18.1	3	□	MVS1810X03S200	57.6	95.8	98.3	163.3	160	3.3	20	2
18.1	5	□	MVS1810X05S190	93.8	151.3	155.3	220.3	217	3.3	19	2
18.1	5	□	MVS1810X05S200	93.8	151.3	155.3	220.3	217	3.3	20	2
18.2	3	□	MVS1820X03S190	57.9	95.8	98.3	163.3	160	3.3	19	2
18.2	3	□	MVS1820X03S200	57.9	95.8	98.3	163.3	160	3.3	20	2
18.2	5	□	MVS1820X05S190	94.3	151.3	155.3	220.3	217	3.3	19	2
18.2	5	□	MVS1820X05S200	94.3	151.3	155.3	220.3	217	3.3	20	2
18.3	3	□	MVS1830X03S190	58.2	95.8	98.3	163.3	160	3.3	19	2
18.3	3	□	MVS1830X03S200	58.2	95.8	98.3	163.3	160	3.3	20	2
18.3	5	□	MVS1830X05S190	94.8	151.3	155.3	220.3	217	3.3	19	2
18.3	5	□	MVS1830X05S200	94.8	151.3	155.3	220.3	217	3.3	20	2
18.4	3	□	MVS1840X03S190	58.5	95.8	98.3	163.3	160	3.3	19	2
18.4	3	□	MVS1840X03S200	58.5	95.8	98.3	163.3	160	3.3	20	2
18.4	5	□	MVS1840X05S190	95.3	151.3	155.3	220.3	217	3.3	19	2
18.4	5	□	MVS1840X05S200	95.3	151.3	155.3	220.3	217	3.3	20	2
18.5	3	●	MVS1850X03S190	58.9	95.9	98.4	163.4	160	3.4	19	2
18.5	3	□	MVS1850X03S200	58.9	95.9	98.4	163.4	160	3.4	20	2
18.5	5	●	MVS1850X05S190	95.9	151.4	155.4	220.4	217	3.4	19	2
18.5	5	□	MVS1850X05S200	95.9	151.4	155.4	220.4	217	3.4	20	2
18.6	3	□	MVS1860X03S190	59.2	98.4	98.4	163.4	160	3.4	19	2
18.6	3	□	MVS1860X03S200	59.2	98.4	98.4	163.4	160	3.4	20	2
18.6	5	□	MVS1860X05S190	96.4	155.4	155.4	220.4	217	3.4	19	2
18.6	5	□	MVS1860X05S200	96.4	155.4	155.4	220.4	217	3.4	20	2
18.7	3	□	MVS1870X03S190	59.5	98.4	98.4	163.4	160	3.4	19	2
18.7	3	□	MVS1870X03S200	59.5	98.4	98.4	163.4	160	3.4	20	2
18.7	5	□	MVS1870X05S190	96.9	155.4	155.4	220.4	217	3.4	19	2
18.7	5	□	MVS1870X05S200	96.9	155.4	155.4	220.4	217	3.4	20	2
18.8	3	□	MVS1880X03S190	59.8	98.4	98.4	163.4	160	3.4	19	2
18.8	3	□	MVS1880X03S200	59.8	98.4	98.4	163.4	160	3.4	20	2
18.8	5	□	MVS1880X05S190	97.4	155.4	155.4	220.4	217	3.4	19	2
18.8	5	□	MVS1880X05S200	97.4	155.4	155.4	220.4	217	3.4	20	2
18.9	3	□	MVS1890X03S190	60.1	98.4	98.4	163.4	160	3.4	19	2
18.9	3	□	MVS1890X03S200	60.1	98.4	98.4	163.4	160	3.4	20	2
18.9	5	□	MVS1890X05S190	97.9	155.4	155.4	220.4	217	3.4	19	2
18.9	5	□	MVS1890X05S200	97.9	155.4	155.4	220.4	217	3.4	20	2
19.0	3	●	MVS1900X03S190	60.5	98.5	98.5	163.5	160	3.5	19	2
19.0	3	□	MVS1900X03S200	60.5	98.5	98.5	163.5	160	3.5	20	2
19.0	5	●	MVS1900X05S190	98.5	155.5	155.5	220.5	217	3.5	19	2
19.0	5	□	MVS1900X05S200	98.5	155.5	155.5	220.5	217	3.5	20	2
19.1	3	□	MVS1910X03S200	60.8	101.0	103.5	168.5	165	3.5	20	2
19.1	5	□	MVS1910X05S200	99.0	159.5	163.5	228.5	225	3.5	20	2
19.2	3	□	MVS1920X03S200	61.1	101.0	103.5	168.5	165	3.5	20	2
19.2	5	□	MVS1920X05S200	99.5	159.5	163.5	228.5	225	3.5	20	2
19.3	3	□	MVS1930X03S200	61.4	101.0	103.5	168.5	165	3.5	20	2
19.3	5	□	MVS1930X05S200	100.0	159.5	163.5	228.5	225	3.5	20	2
19.4	3	□	MVS1940X03S200	61.7	101.0	103.5	168.5	165	3.5	20	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
19.4	5	□	MVS1940X05S200	100.5	159.5	163.5	228.5	225	3.5	20	2
19.5	3	●	MVS1950X03S200	62.0	101.0	103.5	168.5	165	3.5	20	2
19.5	5	●	MVS1950X05S200	101.0	159.5	163.5	228.5	225	3.5	20	2
19.6	3	□	MVS1960X03S200	62.4	103.6	103.6	168.6	165	3.6	20	2
19.6	5	□	MVS1960X05S200	101.6	163.6	163.6	228.6	225	3.6	20	2
19.7	3	□	MVS1970X03S200	62.7	103.6	103.6	168.6	165	3.6	20	2
19.7	5	□	MVS1970X05S200	102.1	163.6	163.6	228.6	225	3.6	20	2
19.8	3	□	MVS1980X03S200	63.0	103.6	103.6	168.6	165	3.6	20	2
19.8	5	□	MVS1980X05S200	102.6	163.6	163.6	228.6	225	3.6	20	2
19.9	3	□	MVS1990X03S200	63.3	103.6	103.6	168.6	165	3.6	20	2
19.9	5	□	MVS1990X05S200	103.1	163.6	163.6	228.6	225	3.6	20	2
20.0	3	●	MVS2000X03S200	63.6	103.6	103.6	168.6	165	3.6	20	2
20.0	5	●	MVS2000X05S200	103.6	163.6	163.6	228.6	225	3.6	20	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

RECOMMENDED CUTTING CONDITIONS

Work Material		Mild Steel (≤180HB) AISI 1010 etc		Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc		Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc	
Dia. **DC** (mm)	**L/D**	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)
1.0	**2DC*,7DC**	15900	0.04 (0.02—0.05)	15900	0.04 (0.02—0.05)	12700	0.04 (0.02—0.05)
1.0	**12DC - 30DC**	15900	0.02 (0.01—0.03)	12700	0.02 (0.01—0.03)	9500	0.02 (0.01—0.03)
1.5	**2DC*,7DC**	10600	0.05 (0.03—0.08)	10600	0.05 (0.03—0.08)	8400	0.05 (0.03—0.08)
1.5	**12DC - 30DC**	10600	0.05 (0.02—0.07)	8400	0.05 (0.03—0.08)	6300	0.05 (0.02—0.08)
2.0	**2DC*,7DC**	7900	0.07 (0.04—0.10)	7900	0.07 (0.04—0.10)	6300	0.07 (0.04—0.10)
2.0	**12DC - 30DC**	7900	0.07 (0.04—0.10)	7900	0.07 (0.04—0.10)	7900	0.07 (0.04—0.10)
2.5	**2DC*,7DC**	7600	0.09 (0.05—0.13)	6300	0.09 (0.05—0.13)	6300	0.09 (0.05—0.13)
2.5	**12DC - 30DC**	7600	0.09 (0.06—0.13)	6300	0.08 (0.05—0.13)	6300	0.08 (0.05—0.13)
3.0	**2DC***	9500	0.17 (0.10—0.24)	9500	0.17 (0.10—0.24)	7400	0.15 (0.09—0.22)
3.0	**3DC - 8DC**	9500	0.10 (0.06—0.13)	9500	0.10 (0.06—0.13)	7400	0.10 (0.06—0.13)
3.0	**10DC - 30DC**	9500	0.17 (0.10—0.24)	9500	0.17 (0.10—0.24)	8400	0.15 (0.09—0.22)
3.0	**35DC,40DC**	7400	0.14 (0.08—0.19)	7400	0.14 (0.08—0.19)	6300	0.13 (0.07—0.18)
4.0	**2DC***	7900	0.20 (0.12—0.30)	7100	0.20 (0.12—0.30)	6300	0.18 (0.11—0.27)
4.0	**3DC - 8DC**	7900	0.12 (0.08—0.16)	7100	0.12 (0.08—0.16)	6300	0.11 (0.07—0.14)
4.0	**10DC - 30DC**	7100	0.20 (0.12—0.30)	7100	0.20 (0.12—0.30)	6300	0.18 (0.11—0.27)
4.0	**35DC,40DC**	5900	0.16 (0.10—0.24)	5900	0.16 (0.10—0.24)	5100	0.15 (0.09—0.22)
5.0	**2DC***	6300	0.25 (0.15—0.35)	5700	0.25 (0.15—0.35)	5000	0.22 (0.14—0.32)
5.0	**3DC - 8DC**	6300	0.15 (0.10—0.20)	5700	0.15 (0.10—0.20)	5000	0.14 (0.09—0.18)
5.0	**10DC - 30DC**	5700	0.25 (0.15—0.35)	5700	0.25 (0.15—0.35)	5000	0.22 (0.14—0.32)
5.0	**35DC,40DC**	4700	0.20 (0.12—0.28)	4700	0.20 (0.12—0.28)	4100	0.18 (0.11—0.24)
6.0	**2DC***	5500	0.27 (0.17—0.37)	5000	0.27 (0.17—0.37)	4700	0.24 (0.15—0.33)
6.0	**3DC - 8DC**	5800	0.20 (0.13—0.26)	5300	0.20 (0.13—0.26)	4700	0.18 (0.11—0.24)
6.0	**10DC - 30DC**	5300	0.27 (0.17—0.37)	4700	0.27 (0.17—0.37)	4200	0.24 (0.15—0.33)
6.0	**35DC,40DC**	4500	0.22 (0.14—0.30)	3900	0.22 (0.14—0.30)	3700	0.20 (0.12—0.26)
8.0	**2DC***	4700	0.30 (0.20—0.40)	4300	0.30 (0.20—0.40)	3900	0.27 (0.18—0.36)
8.0	**3DC - 8DC**	4700	0.23 (0.18—0.28)	4300	0.23 (0.18—0.28)	3900	0.21 (0.16—0.25)
8.0	**10DC - 30DC**	4300	0.30 (0.20—0.40)	3900	0.30 (0.20—0.40)	3500	0.27 (0.18—0.36)
8.0	**35DC,40DC**	3300	0.24 (0.16—0.32)	3100	0.24 (0.16—0.32)	2700	0.22 (0.14—0.29)
10.0	**2DC***	4100	0.32 (0.22—0.42)	3800	0.32 (0.22—0.42)	3100	0.29 (0.20—0.38)
10.0	**3DC - 8DC**	4100	0.27 (0.22—0.32)	3800	0.27 (0.22—0.32)	3500	0.23 (0.19—0.27)
10.0	**10DC - 30DC**	3500	0.32 (0.22—0.42)	3100	0.32 (0.22—0.42)	2800	0.29 (0.20—0.38)
10.0	**35DC**	2800	0.26 (0.18—0.34)	2500	0.26 (0.18—0.34)	2200	0.24 (0.16—0.30)
12.0	**2DC***	3700	0.34 (0.24—0.44)	3400	0.34 (0.24—0.44)	3000	0.30 (0.22—0.40)
12.0	**3DC - 8DC**	3700	0.30 (0.26—0.34)	3400	0.30 (0.26—0.34)	3100	0.25 (0.22—0.29)
12.0	**10DC - 25DC**	3400	0.34 (0.24—0.44)	2900	0.34 (0.24—0.44)	2600	0.30 (0.22—0.40)
16.0	**3DC - 8DC**	3100	0.33 (0.27—0.38)	2700	0.33 (0.27—0.38)	2500	0.28 (0.23—0.33)
20.0	**3DC,5DC**	2500	0.35 (0.30—0.40)	2200	0.35 (0.30—0.40)	2000	0.30 (0.26—0.34)

* =2DC for cutting a guide hole

MVS

WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

Work Material		Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc		Gray Cast Iron (≤350MPa) No 45 B etc		Ductile Cast Iron (≤450MPa) 60-40-8 etc	
Dia. DC (mm)	L/D	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)
1.0	**2DC*,7DC**	9500	0.03 (0.02—0.05)	15900	0.04 (0.02—0.05)	12700	0.04 (0.02—0.05)
1.0	**12DC - 30DC**	9500	0.02 (0.01—0.03)	12700	0.02 (0.01—0.03)	9500	0.02 (0.01—0.03)
1.5	**2DC*,7DC**	6300	0.05 (0.03—0.07)	10600	0.05 (0.03—0.08)	8400	0.05 (0.03—0.08)
1.5	**12DC - 30DC**	6300	0.05 (0.02—0.08)	8400	0.05 (0.02—0.08)	6300	0.05 (0.02—0.08)
2.0	**2DC*,7DC**	4700	0.06 (0.04—0.08)	7900	0.07 (0.04—0.10)	6300	0.07 (0.04—0.10)
2.0	**12DC - 30DC**	4700	0.06 (0.04—0.10)	7900	0.07 (0.04—0.10)	7900	0.07 (0.04—0.10)
2.5	**2DC*,7DC**	5000	0.08 (0.05—0.10)	7600	0.09 (0.05—0.13)	6300	0.09 (0.05—0.13)
2.5	**12DC - 30DC**	3800	0.08 (0.05—0.12)	6300	0.09 (0.06—0.13)	6300	0.08 (0.05—0.12)
3.0	**2DC***	4200	0.08 (0.05—0.10)	9000	0.19 (0.11—0.26)	9000	0.17 (0.10—0.24)
3.0	**3DC - 8DC**	4200	0.08 (0.06—0.10)	9500	0.10 (0.06—0.13)	9000	0.10 (0.06—0.13)
3.0	**10DC - 30DC**	4200	0.08 (0.05—0.09)	8400	0.19 (0.11—0.26)	8400	0.17 (0.10—0.24)
3.0	**35DC,40DC**	2900	0.06 (0.04—0.07)	7400	0.15 (0.09—0.21)	7460	0.14 (0.08—0.19)
4.0	**2DC***	3100	0.08 (0.06—0.10)	7900	0.22 (0.13—0.33)	7100	0.20 (0.12—0.30)
4.0	**3DC - 8DC**	3100	0.09 (0.06—0.11)	7900	0.12 (0.08—0.16)	7100	0.12 (0.08—0.16)
4.0	**10DC - 30DC**	3100	0.08 (0.06—0.10)	7100	0.22 (0.13—0.33)	7100	0.20 (0.12—0.30)
4.0	**35DC,40DC**	2300	0.07 (0.05—0.08)	5900	0.18 (0.10—0.26)	5900	0.16 (0.10—0.24)
5.0	**2DC***	2500	0.10 (0.07—0.12)	6300	0.28 (0.16—0.39)	5700	0.25 (0.15—0.35)
5.0	**3DC - 8DC**	2500	0.11 (0.08—0.14)	6300	0.15 (0.10—0.20)	5700	0.15 (0.10—0.20)
5.0	**10DC - 30DC**	2500	0.10 (0.07—0.12)	5700	0.28 (0.07—0.39)	5700	0.25 (0.15—0.35)
5.0	**35DC,40DC**	1900	0.08 (0.06—0.10)	4700	0.22 (0.06—0.31)	4700	0.20 (0.12—0.28)
6.0	**2DC***	2300	0.12 (0.08—0.16)	5500	0.30 (0.19—0.41)	5000	0.27 (0.17—0.37)
6.0	**3DC - 8DC**	2600	0.13 (0.09—0.18)	5800	0.20 (0.13—0.26)	5000	0.20 (0.13—0.26)
6.0	**10DC - 30DC**	2600	0.12 (0.08—0.14)	5300	0.30 (0.19—0.41)	4700	0.27 (0.17—0.37)
6.0	**35DC,40DC**	2100	0.10 (0.06—0.13)	4500	0.24 (0.15—0.33)	4200	0.22 (0.14—0.30)
8.0	**2DC***	1900	0.14 (0.10—0.17)	4700	0.33 (0.22—0.44)	3900	0.30 (0.20—0.40)
8.0	**3DC - 8DC**	1900	0.15 (0.10—0.19)	4700	0.25 (0.18—0.31)	3900	0.23 (0.18—0.28)
8.0	**10DC - 30DC**	1900	0.14 (0.10—0.17)	4300	0.33 (0.22—0.44)	3900	0.30 (0.20—0.40)
8.0	**35DC,40DC**	1500	0.11 (0.08—0.14)	3300	0.26 (0.17—0.35)	3100	0.24 (0.16—0.32)
10.0	**2DC***	1500	0.15 (0.12—0.18)	4100	0.35 (0.24—0.46)	3100	0.32 (0.22—0.42)
10.0	**3DC - 8DC**	1500	0.16 (0.12—0.20)	4100	0.29 (0.22—0.35)	3100	0.27 (0.22—0.32)
10.0	**10DC - 30DC**	1500	0.15 (0.12—0.18)	3500	0.35 (0.24—0.46)	3100	0.32 (0.22—0.42)
10.0	**35DC**	1200	0.12 (0.10—0.14)	2800	0.28 (0.19—0.37)	2500	0.26 (0.18—0.34)
12.0	**2DC***	1400	0.17 (0.14—0.19)	3700	0.37 (0.26—0.48)	3000	0.34 (0.24—0.44)
12.0	**3DC - 8DC**	1500	0.18 (0.15—0.21)	3700	0.32 (0.26—0.37)	3000	0.30 (0.26—0.34)
12.0	**10DC - 25DC**	1500	0.17 (0.14—0.19)	3400	0.37 (0.26—0.48)	2900	0.34 (0.24—0.44)
16.0	**3DC - 8DC**	1100	0.19 (0.15—0.24)	3100	0.35 (0.28—0.42)	2500	0.33 (0.28—0.38)
20.0	**3DC,5DC**	900	0.21 (0.15—0.26)	2500	0.37 (0.30—0.44)	2300	0.35 (0.30—0.40)

* =2DC for cutting a guide hole

Work Material		Aluminium Alloy (Si<5%)		Heat Resistant Alloy Inconel718 etc	
Dia. **DC** (mm)	**L/D**	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)
1.0	**2DC*,7DC**	19000	0.05 (0.03 — 0.08)	3100	0.02 (0.01—0.03)
1.0	**12DC - 30DC**	15900	0.05 (0.03 — 0.08)	3100	0.02 (0.01—0.03)
1.5	**2DC*,7DC**	16900	0.07 (0.05 — 0.12)	2100	0.03 (0.02—0.04)
1.5	**12DC - 30DC**	14800	0.07 (0.05 — 0.12)	2100	0.03 (0.02—0.04)
2.0	**2DC*,7DC**	14300	0.10 (0.06 — 0.15)	2300	0.04 (0.03—0.05)
2.0	**12DC - 30DC**	12700	0.10 (0.06 — 0.15)	2300	0.04 (0.03—0.05)
2.5	**2DC*,7DC**	12700	0.13 (0.08 — 0.20)	1900	0.05 (0.04—0.06)
2.5	**12DC - 30DC**	11400	0.13 (0.08 — 0.20)	1900	0.05 (0.04—0.06)
3.0	**2DC***	11600	0.23 (0.10 — 0.35)	2100	0.07 (0.05—0.09)
3.0	**3DC - 8DC**	12700	0.23 (0.10 — 0.35)	2100	0.07 (0.05—0.09)
3.0	**10DC - 30DC**	10600	0.23 (0.10 — 0.35)	2100	0.07 (0.05—0.09)
3.0	**35DC,40DC**	7900	0.18 (0.08 — 0.28)	1400	0.06 (0.04—0.07)
4.0	**2DC***	9500	0.24 (0.12 — 0.35)	1500	0.09 (0.06—0.11)
4.0	**3DC - 8DC**	9500	0.24 (0.12 — 0.35)	1500	0.09 (0.06—0.11)
4.0	**10DC - 30DC**	7900	0.24 (0.12 — 0.35)	1500	0.09 (0.06—0.11)
4.0	**35DC,40DC**	6300	0.19 (0.10 — 0.28)	1100	0.07 (0.05—0.09)
5.0	**2DC***	7600	0.25 (0.15 — 0.35)	1200	0.11 (0.08—0.14)
5.0	**3DC - 8DC**	7600	0.25 (0.15 — 0.35)	1200	0.11 (0.08—0.14)
5.0	**10DC - 30DC**	7000	0.25 (0.15 — 0.35)	1200	0.11 (0.08—0.14)
5.0	**35DC,40DC**	5000	0.20 (0.12 — 0.28)	900	0.09 (0.06—0.11)
6.0	**2DC***	7400	0.35 (0.20 — 0.50)	1300	0.13 (0.09—0.16)
6.0	**3DC - 8DC**	7900	0.35 (0.20 — 0.50)	1300	0.13 (0.09—0.16)
6.0	**10DC - 30DC**	6300	0.35 (0.20 — 0.50)	1000	0.13 (0.09—0.16)
6.0	**35DC,40DC**	5300	0.28 (0.16 — 0.40)	700	0.10 (0.07—0.13)
8.0	**2DC***	5900	0.35 (0.20 — 0.50)	900	0.14 (0.11—0.16)
8.0	**3DC - 8DC**	5900	0.35 (0.20 — 0.50)	900	0.14 (0.11—0.17)
8.0	**10DC - 30DC**	5100	0.35 (0.20 — 0.50)	700	0.14 (0.11—0.16)
8.0	**35DC,40DC**	3900	0.28 (0.16 — 0.40)	500	0.11 (0.09—0.13)
10.0	**2DC***	4700	0.50 (0.20 — 0.80)	700	0.15 (0.12—0.17)
10.0	**3DC - 8DC**	4700	0.50 (0.20 — 0.80)	700	0.15 (0.12—0.18)
10.0	**10DC - 30DC**	4100	0.50 (0.20 — 0.80)	600	0.15 (0.12—0.17)
10.0	**35DC**	3300	0.40 (0.16 — 0.64)	400	0.12 (0.10—0.14)
12.0	**2DC***	4200	0.50 (0.20 — 0.80)	600	0.16 (0.13—0.18)
12.0	**3DC - 8DC**	4200	0.50 (0.20 — 0.80)	600	0.16 (0.13—0.19)
12.0	**10DC - 25DC**	3700	0.50 (0.20 — 0.80)	500	0.16 (0.13—0.18)
16.0	**3DC - 8DC**	3100	0.60 (0.20 — 1.00)	400	0.18 (0.14—0.21)
20.0	**3DC,5DC**	2700	0.60 (0.20 — 1.00)	400	0.19 (0.15—0.22)

* =2DC for cutting a guide hole

MVE

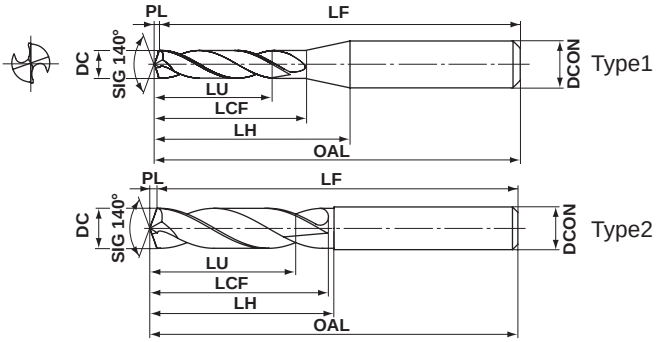
WSTAR DRILLS

- PVD coated carbide grade DP1020 achieves long life with wide range of work materials
- The unique wavy cutting edge provides excellent sharpness and rigidity and helps to control wear at the periphery.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

External Coolant



DC=3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤18**	**18<DCON≤20**
0 −0.006	0 −0.008	0 −0.009	0 −0.011	0 −0.013

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.0	2	●	MVE0300X02S030	6.5	16.5	16.5	55.5	55	0.5	3	2
3.0	2	●	MVE0300X02S060	6.5	16.5	19.7	55.5	55	0.5	6	1
3.0	3	●	MVE0300X03S030	9.5	21.5	21.5	60.5	60	0.5	3	2
3.0	3	●	MVE0300X03S060	9.5	21.5	24.7	60.5	60	0.5	6	1
3.1	2	●	MVE0310X02S040	6.8	18.6	20.6	55.6	55	0.6	4	2
3.1	2	●	MVE0310X02S060	6.8	18.6	21.7	55.6	55	0.6	6	1
3.1	3	●	MVE0310X03S040	9.9	24.6	26.6	60.6	60	0.6	4	2
3.1	3	●	MVE0310X03S060	9.9	24.6	27.7	60.6	60	0.6	6	1
3.2	2	●	MVE0320X02S040	7.0	18.6	20.6	55.6	55	0.6	4	2
3.2	2	●	MVE0320X02S060	7.0	18.6	21.6	55.6	55	0.6	6	1
3.2	3	●	MVE0320X03S040	10.2	24.6	26.6	60.6	60	0.6	4	2
3.2	3	●	MVE0320X03S060	10.2	24.6	27.6	60.6	60	0.6	6	1
3.3	2	●	MVE0330X02S040	7.2	18.6	20.6	55.6	55	0.6	4	2
3.3	2	●	MVE0330X02S060	7.2	18.6	21.5	55.6	55	0.6	6	1
3.3	3	●	MVE0330X03S040	10.5	24.6	26.6	60.6	60	0.6	4	2
3.3	3	●	MVE0330X03S060	10.5	24.6	27.5	60.6	60	0.6	6	1
3.4	2	●	MVE0340X02S040	7.4	18.6	20.6	55.6	55	0.6	4	2
3.4	2	●	MVE0340X02S060	7.4	18.6	21.4	55.6	55	0.6	6	1
3.4	3	●	MVE0340X03S040	10.8	24.6	26.6	60.6	60	0.6	4	2
3.4	3	●	MVE0340X03S060	10.8	24.6	27.4	60.6	60	0.6	6	1
3.5	2	●	MVE0350X02S040	7.6	18.6	20.6	55.6	55	0.6	4	2
3.5	2	●	MVE0350X02S060	7.6	18.6	21.3	55.6	55	0.6	6	1
3.5	3	●	MVE0350X03S040	11.1	24.6	26.6	60.6	60	0.6	4	2
3.5	3	●	MVE0350X03S060	11.1	24.6	27.3	60.6	60	0.6	6	1
3.6	2	●	MVE0360X02S040	7.9	20.7	20.7	55.7	55	0.7	4	2
3.6	2	●	MVE0360X02S060	7.9	20.7	23.3	55.7	55	0.7	6	1
3.6	3	●	MVE0360X03S040	11.5	27.7	27.7	60.7	60	0.7	4	2
3.6	3	●	MVE0360X03S060	11.5	27.7	30.3	60.7	60	0.7	6	1
3.7	2	●	MVE0370X02S040	8.1	20.7	20.7	55.7	55	0.7	4	2
3.7	2	●	MVE0370X02S060	8.1	20.7	23.2	55.7	55	0.7	6	1
3.7	3	●	MVE0370X03S040	11.8	27.7	27.7	60.7	60	0.7	4	2
3.7	3	●	MVE0370X03S060	11.8	27.7	30.2	60.7	60	0.7	6	1

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.8	2	●	MVE0380X02S040	8.3	20.7	20.7	55.7	55	0.7	4	2
3.8	2	●	MVE0380X02S060	8.3	20.7	23.1	55.7	55	0.7	6	1
3.8	3	●	MVE0380X03S040	12.1	27.7	27.7	60.7	60	0.7	4	2
3.8	3	●	MVE0380X03S060	12.1	27.7	30.1	60.7	60	0.7	6	1
3.9	2	●	MVE0390X02S040	8.5	20.7	20.7	55.7	55	0.7	4	2
3.9	2	●	MVE0390X02S060	8.5	20.7	23.0	55.7	55	0.7	6	1
3.9	3	●	MVE0390X03S040	12.4	27.7	27.7	60.7	60	0.7	4	2
3.9	3	●	MVE0390X03S060	12.4	27.7	30.0	60.7	60	0.7	6	1
4.0	2	●	MVE0400X02S040	8.7	20.7	20.7	55.7	55	0.7	4	2
4.0	2	●	MVE0400X02S060	8.7	20.7	22.8	55.7	55	0.7	6	1
4.0	3	●	MVE0400X03S040	12.7	27.7	27.7	60.7	60	0.7	4	2
4.0	3	●	MVE0400X03S060	12.7	27.7	29.8	60.7	60	0.7	6	1
4.1	2	●	MVE0410X02S050	8.9	22.7	24.7	62.7	62	0.7	5	2
4.1	2	●	MVE0410X02S060	8.9	22.7	24.7	62.7	62	0.7	6	1
4.1	3	●	MVE0410X03S050	13.0	29.7	31.7	68.7	68	0.7	5	2
4.1	3	●	MVE0410X03S060	13.0	29.7	31.7	68.7	68	0.7	6	1
4.2	2	●	MVE0420X02S050	9.2	22.8	24.8	62.8	62	0.8	5	2
4.2	2	●	MVE0420X02S060	9.2	22.8	24.7	62.8	62	0.8	6	1
4.2	3	●	MVE0420X03S050	13.4	29.8	31.8	68.8	68	0.8	5	2
4.2	3	●	MVE0420X03S060	13.4	29.8	31.7	68.8	68	0.8	6	1
4.3	2	●	MVE0430X02S050	9.4	22.8	24.8	62.8	62	0.8	5	2
4.3	2	●	MVE0430X02S060	9.4	22.8	24.6	62.8	62	0.8	6	1
4.3	3	●	MVE0430X03S050	13.7	29.8	31.8	68.8	68	0.8	5	2
4.3	3	●	MVE0430X03S060	13.7	29.8	31.6	68.8	68	0.8	6	1
4.4	2	●	MVE0440X02S050	9.6	22.8	24.8	62.8	62	0.8	5	2
4.4	2	●	MVE0440X02S060	9.6	22.8	24.5	62.8	62	0.8	6	1
4.4	3	●	MVE0440X03S050	14.0	29.8	31.8	68.8	68	0.8	5	2
4.4	3	●	MVE0440X03S060	14.0	29.8	31.5	68.8	68	0.8	6	1
4.5	2	●	MVE0450X02S050	9.8	22.8	24.8	62.8	62	0.8	5	2
4.5	2	●	MVE0450X02S060	9.8	22.8	24.4	62.8	62	0.8	6	1
4.5	3	●	MVE0450X03S050	14.3	29.8	31.8	68.8	68	0.8	5	2
4.5	3	●	MVE0450X03S060	14.3	29.8	31.4	68.8	68	0.8	6	1

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.6	2	●	MVE0460X02S050	10.0	24.8	24.8	62.8	62	0.8	5	2
4.6	2	●	MVE0460X02S060	10.0	24.8	27.8	62.8	62	0.8	6	2
4.6	3	●	MVE0460X03S050	14.6	32.8	32.8	68.8	68	0.8	5	2
4.6	3	●	MVE0460X03S060	14.6	32.8	35.8	68.8	68	0.8	6	2
4.7	2	●	MVE0470X02S050	10.3	24.9	24.9	62.9	62	0.9	5	2
4.7	2	●	MVE0470X02S060	10.3	24.9	27.9	62.9	62	0.9	6	2
4.7	3	●	MVE0470X03S050	15.0	32.9	32.9	68.9	68	0.9	5	2
4.7	3	●	MVE0470X03S060	15.0	32.9	35.9	68.9	68	0.9	6	2
4.8	2	●	MVE0480X02S050	10.5	24.9	24.9	62.9	62	0.9	5	2
4.8	2	●	MVE0480X02S060	10.5	24.9	27.9	62.9	62	0.9	6	2
4.8	3	●	MVE0480X03S050	15.3	32.9	32.9	68.9	68	0.9	5	2
4.8	3	●	MVE0480X03S060	15.3	32.9	35.9	68.9	68	0.9	6	2
4.9	2	●	MVE0490X02S050	10.7	24.9	24.9	62.9	62	0.9	5	2
4.9	2	●	MVE0490X02S060	10.7	24.9	27.9	62.9	62	0.9	6	2
4.9	3	●	MVE0490X03S050	15.6	32.9	32.9	68.9	68	0.9	5	2
4.9	3	●	MVE0490X03S060	15.6	32.9	35.9	68.9	68	0.9	6	2
5.0	2	●	MVE0500X02S050	10.9	24.9	24.9	62.9	62	0.9	5	2
5.0	2	●	MVE0500X02S060	10.9	24.9	27.9	62.9	62	0.9	6	2
5.0	3	●	MVE0500X03S050	15.9	32.9	32.9	68.9	68	0.9	5	2
5.0	3	●	MVE0500X03S060	15.9	32.9	35.9	68.9	68	0.9	6	2
5.1	2	●	MVE0510X02S060	11.1	26.9	28.9	66.9	66	0.9	6	2
5.1	3	●	MVE0510X03S060	16.2	34.9	36.9	74.9	74	0.9	6	2
5.2	2	●	MVE0520X02S060	11.3	26.9	28.9	66.9	66	0.9	6	2
5.2	3	●	MVE0520X03S060	16.5	34.9	36.9	74.9	74	0.9	6	2
5.3	2	●	MVE0530X02S060	11.6	27.0	29.0	67.0	66	1.0	6	2
5.3	3	●	MVE0530X03S060	16.9	35.0	37.0	75.0	74	1.0	6	2
5.4	2	●	MVE0540X02S060	11.8	27.0	29.0	67.0	66	1.0	6	2
5.4	3	●	MVE0540X03S060	17.2	35.0	37.0	75.0	74	1.0	6	2
5.5	2	●	MVE0550X02S060	12.0	27.0	29.0	67.0	66	1.0	6	2
5.5	3	●	MVE0550X03S060	17.5	35.0	37.0	75.0	74	1.0	6	2
5.6	2	●	MVE0560X02S060	12.2	29.0	29.0	67.0	66	1.0	6	2
5.6	3	●	MVE0560X03S060	17.8	37.0	37.0	75.0	74	1.0	6	2
5.7	2	●	MVE0570X02S060	12.4	29.0	29.0	67.0	66	1.0	6	2
5.7	3	●	MVE0570X03S060	18.1	37.0	37.0	75.0	74	1.0	6	2
5.8	2	●	MVE0580X02S060	12.7	29.1	29.1	67.1	66	1.1	6	2
5.8	3	●	MVE0580X03S060	18.5	37.1	37.1	75.1	74	1.1	6	2
5.9	2	●	MVE0590X02S060	12.9	29.1	29.1	67.1	66	1.1	6	2
5.9	3	●	MVE0590X03S060	18.8	37.1	37.1	75.1	74	1.1	6	2
6.0	2	●	MVE0600X02S060	13.1	29.1	29.1	67.1	66	1.1	6	2
6.0	3	●	MVE0600X03S060	19.1	37.1	37.1	75.1	74	1.1	6	2
6.1	2	●	MVE0610X02S070	13.3	32.1	35.1	75.1	74	1.1	7	2
6.1	2	●	MVE0610X02S080	13.3	32.1	35.1	75.1	74	1.1	8	2
6.1	3	●	MVE0610X03S070	19.4	42.1	45.1	84.1	83	1.1	7	2
6.1	3	●	MVE0610X03S080	19.4	42.1	45.1	84.1	83	1.1	8	2
6.2	2	●	MVE0620X02S070	13.5	32.1	35.1	75.1	74	1.1	7	2
6.2	2	●	MVE0620X02S080	13.5	32.1	35.1	75.1	74	1.1	8	2
6.2	3	●	MVE0620X03S070	19.7	42.1	45.1	84.1	83	1.1	7	2
6.2	3	●	MVE0620X03S080	19.7	42.1	45.1	84.1	83	1.1	8	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.3	2	●	MVE0630X02S070	13.7	32.1	35.1	75.1	74	1.1	7	2
6.3	2	●	MVE0630X02S080	13.7	32.1	35.1	75.1	74	1.1	8	2
6.3	3	●	MVE0630X03S070	20.0	42.1	45.1	84.1	83	1.1	7	2
6.3	3	●	MVE0630X03S080	20.0	42.1	45.1	84.1	83	1.1	8	2
6.4	2	●	MVE0640X02S070	14.0	32.2	35.2	75.2	74	1.2	7	2
6.4	2	●	MVE0640X02S080	14.0	32.2	35.2	75.2	74	1.2	8	2
6.4	3	●	MVE0640X03S070	20.4	42.2	45.2	84.2	83	1.2	7	2
6.4	3	●	MVE0640X03S080	20.4	42.2	45.2	84.2	83	1.2	8	2
6.5	2	●	MVE0650X02S070	14.2	32.2	35.2	75.2	74	1.2	7	2
6.5	2	●	MVE0650X02S080	14.2	32.2	35.2	75.2	74	1.2	8	2
6.5	3	●	MVE0650X03S070	20.7	42.2	45.2	84.2	83	1.2	7	2
6.5	3	●	MVE0650X03S080	20.7	42.2	45.2	84.2	83	1.2	8	2
6.6	2	●	MVE0660X02S070	14.4	35.2	35.2	75.2	74	1.2	7	2
6.6	2	●	MVE0660X02S080	14.4	35.2	37.2	75.2	74	1.2	8	2
6.6	3	●	MVE0660X03S070	21.0	44.2	44.2	84.2	83	1.2	7	2
6.6	3	●	MVE0660X03S080	21.0	44.2	46.2	84.2	83	1.2	8	2
6.7	2	●	MVE0670X02S070	14.6	35.2	35.2	75.2	74	1.2	7	2
6.7	2	●	MVE0670X02S080	14.6	35.2	37.2	75.2	74	1.2	8	2
6.7	3	●	MVE0670X03S070	21.3	44.2	44.2	84.2	83	1.2	7	2
6.7	3	●	MVE0670X03S080	21.3	44.2	46.2	84.2	83	1.2	8	2
6.8	2	●	MVE0680X02S070	14.8	35.2	35.2	75.2	74	1.2	7	2
6.8	2	●	MVE0680X02S080	14.8	35.2	37.2	75.2	74	1.2	8	2
6.8	3	●	MVE0680X03S070	21.6	44.2	44.2	84.2	83	1.2	7	2
6.8	3	●	MVE0680X03S080	21.6	44.2	46.2	84.2	83	1.2	8	2
6.9	2	●	MVE0690X02S070	15.1	35.3	35.3	75.3	74	1.3	7	2
6.9	2	●	MVE0690X02S080	15.1	35.3	37.3	75.3	74	1.3	8	2
6.9	3	●	MVE0690X03S070	22.0	44.3	44.3	84.3	83	1.3	7	2
6.9	3	●	MVE0690X03S080	22.0	44.3	46.3	84.3	83	1.3	8	2
7.0	2	●	MVE0700X02S070	15.3	35.3	35.3	75.3	74	1.3	7	2
7.0	2	●	MVE0700X02S080	15.3	35.3	37.3	75.3	74	1.3	8	2
7.0	3	●	MVE0700X03S070	22.3	44.3	44.3	84.3	83	1.3	7	2
7.0	3	●	MVE0700X03S080	22.3	44.3	46.3	84.3	83	1.3	8	2
7.1	2	●	MVE0710X02S080	15.5	35.3	38.3	80.3	79	1.3	8	2
7.1	3	●	MVE0710X03S080	22.6	46.3	49.3	91.3	90	1.3	8	2
7.2	2	●	MVE0720X02S080	15.7	35.3	38.3	80.3	79	1.3	8	2
7.2	3	●	MVE0720X03S080	22.9	46.3	49.3	91.3	90	1.3	8	2
7.3	2	●	MVE0730X02S080	15.9	35.3	38.3	80.3	79	1.3	8	2
7.3	3	●	MVE0730X03S080	23.2	46.3	49.3	91.3	90	1.3	8	2
7.4	2	●	MVE0740X02S080	16.1	35.3	38.3	80.3	79	1.3	8	2
7.4	3	●	MVE0740X03S080	23.5	46.3	49.3	91.3	90	1.3	8	2
7.5	2	●	MVE0750X02S080	16.4	35.4	38.4	80.4	79	1.4	8	2
7.5	3	●	MVE0750X03S080	23.9	46.4	49.4	91.4	90	1.4	8	2
7.6	2	●	MVE0760X02S080	16.6	38.4	38.4	80.4	79	1.4	8	2
7.6	3	●	MVE0760X03S080	24.2	49.4	49.4	91.4	90	1.4	8	2
7.7	2	●	MVE0770X02S080	16.8	38.4	38.4	80.4	79	1.4	8	2
7.7	3	●	MVE0770X03S080	24.5	49.4	49.4	91.4	90	1.4	8	2
7.8	2	●	MVE0780X02S080	17.0	38.4	38.4	80.4	79	1.4	8	2
7.8	3	●	MVE0780X03S080	24.8	49.4	49.4	91.4	90	1.4	8	2

CUTTING CONDITIONS ➤ P048
OPERATION GUIDANCE ➤ P049
TECHNICAL DATA ➤ R001

MVE

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.9	2	●	MVE0790X02S080	17.2	38.4	38.4	80.4	79	1.4	8	2
7.9	3	●	MVE0790X03S080	25.1	49.4	49.4	91.4	90	1.4	8	2
8.0	2	●	MVE0800X02S080	17.5	38.5	38.5	80.5	79	1.5	8	2
8.0	3	●	MVE0800X03S080	25.5	49.5	49.5	91.5	90	1.5	8	2
8.1	2	●	MVE0810X02S090	17.7	38.5	41.5	85.5	84	1.5	9	2
8.1	2	●	MVE0810X02S100	17.7	38.5	41.5	85.5	84	1.5	10	2
8.1	3	●	MVE0810X03S090	25.8	54.5	57.5	99.5	98	1.5	9	2
8.1	3	●	MVE0810X03S100	25.8	54.5	57.5	99.5	98	1.5	10	2
8.2	2	●	MVE0820X02S090	17.9	38.5	41.5	85.5	84	1.5	9	2
8.2	2	●	MVE0820X02S100	17.9	38.5	41.5	85.5	84	1.5	10	2
8.2	3	●	MVE0820X03S090	26.1	54.5	57.5	99.5	98	1.5	9	2
8.2	3	●	MVE0820X03S100	26.1	54.5	57.5	99.5	98	1.5	10	2
8.3	2	●	MVE0830X02S090	18.1	38.5	41.5	85.5	84	1.5	9	2
8.3	2	●	MVE0830X02S100	18.1	38.5	41.5	85.5	84	1.5	10	2
8.3	3	●	MVE0830X03S090	26.4	54.5	57.5	99.5	98	1.5	9	2
8.3	3	●	MVE0830X03S100	26.4	54.5	57.5	99.5	98	1.5	10	2
8.4	2	●	MVE0840X02S090	18.3	38.5	41.5	85.5	84	1.5	9	2
8.4	2	●	MVE0840X02S100	18.3	38.5	41.5	85.5	84	1.5	10	2
8.4	3	●	MVE0840X03S090	26.7	54.5	57.5	99.5	98	1.5	9	2
8.4	3	●	MVE0840X03S100	26.7	54.5	57.5	99.5	98	1.5	10	2
8.5	2	●	MVE0850X02S090	18.5	38.5	41.5	85.5	84	1.5	9	2
8.5	2	●	MVE0850X02S100	18.5	38.5	41.5	85.5	84	1.5	10	2
8.5	3	●	MVE0850X03S090	27.0	54.5	57.5	99.5	98	1.5	9	2
8.5	3	●	MVE0850X03S100	27.0	54.5	57.5	99.5	98	1.5	10	2
8.6	2	●	MVE0860X02S090	18.8	41.6	41.6	85.6	84	1.6	9	2
8.6	2	●	MVE0860X02S100	18.8	41.6	43.6	85.6	84	1.6	10	2
8.6	3	●	MVE0860X03S090	27.4	56.6	56.6	99.6	98	1.6	9	2
8.6	3	●	MVE0860X03S100	27.4	56.6	58.6	99.6	98	1.6	10	2
8.7	2	●	MVE0870X02S090	19.0	41.6	41.6	85.6	84	1.6	9	2
8.7	2	●	MVE0870X02S100	19.0	41.6	43.6	85.6	84	1.6	10	2
8.7	3	●	MVE0870X03S090	27.7	56.6	56.6	99.6	98	1.6	9	2
8.7	3	●	MVE0870X03S100	27.7	56.6	58.6	99.6	98	1.6	10	2
8.8	2	●	MVE0880X02S090	19.2	41.6	41.6	85.6	84	1.6	9	2
8.8	2	●	MVE0880X02S100	19.2	41.6	43.6	85.6	84	1.6	10	2
8.8	3	●	MVE0880X03S090	28.0	56.6	56.6	99.6	98	1.6	9	2
8.8	3	●	MVE0880X03S100	28.0	56.6	58.6	99.6	98	1.6	10	2
8.9	2	●	MVE0890X02S090	19.4	41.6	41.6	85.6	84	1.6	9	2
8.9	2	●	MVE0890X02S100	19.4	41.6	43.6	85.6	84	1.6	10	2
8.9	3	●	MVE0890X03S090	28.3	56.6	56.6	99.6	98	1.6	9	2
8.9	3	●	MVE0890X03S100	28.3	56.6	58.6	99.6	98	1.6	10	2
9.0	2	●	MVE0900X02S090	19.6	41.6	41.6	85.6	84	1.6	9	2
9.0	2	●	MVE0900X02S100	19.6	41.6	43.6	85.6	84	1.6	10	2
9.0	3	●	MVE0900X03S090	28.6	56.6	56.6	99.6	98	1.6	9	2
9.0	3	●	MVE0900X03S100	28.6	56.6	58.6	99.6	98	1.6	10	2
9.1	2	●	MVE0910X02S100	19.9	41.7	44.7	90.7	89	1.7	10	2
9.1	3	●	MVE0910X03S100	29.0	59.7	62.7	106.7	105	1.7	10	2
9.2	2	●	MVE0920X02S100	20.1	41.7	44.7	90.7	89	1.7	10	2
9.2	3	●	MVE0920X03S100	29.3	59.7	62.7	106.7	105	1.7	10	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.3	2	●	MVE0930X02S100	20.3	41.7	44.7	90.7	89	1.7	10	2
9.3	3	●	MVE0930X03S100	29.6	59.7	62.7	106.7	105	1.7	10	2
9.4	2	●	MVE0940X02S100	20.5	41.7	44.7	90.7	89	1.7	10	2
9.4	3	●	MVE0940X03S100	29.9	59.7	62.7	106.7	105	1.7	10	2
9.5	2	●	MVE0950X02S100	20.7	41.7	44.7	90.7	89	1.7	10	2
9.5	3	●	MVE0950X03S100	30.2	59.7	62.7	106.7	105	1.7	10	2
9.6	2	●	MVE0960X02S100	20.9	44.7	44.7	90.7	89	1.7	10	2
9.6	3	●	MVE0960X03S100	30.5	61.7	61.7	106.7	105	1.7	10	2
9.7	2	●	MVE0970X02S100	21.2	44.8	44.8	90.8	89	1.8	10	2
9.7	3	●	MVE0970X03S100	30.9	61.8	61.8	106.8	105	1.8	10	2
9.8	2	●	MVE0980X02S100	21.4	44.8	44.8	90.8	89	1.8	10	2
9.8	3	●	MVE0980X03S100	31.2	61.8	61.8	106.8	105	1.8	10	2
9.9	2	●	MVE0990X02S100	21.6	44.8	44.8	90.8	89	1.8	10	2
9.9	3	●	MVE0990X03S100	31.5	61.8	61.8	106.8	105	1.8	10	2
10.0	2	●	MVE1000X02S100	21.8	44.8	44.8	90.8	89	1.8	10	2
10.0	3	●	MVE1000X03S100	31.8	61.8	61.8	106.8	105	1.8	10	2
10.1	2	●	MVE1010X02S110	22.0	44.8	47.8	96.8	95	1.8	11	2
10.1	2	●	MVE1010X02S120	22.0	44.8	47.8	96.8	95	1.8	12	2
10.1	3	●	MVE1010X03S110	32.1	67.8	70.8	115.8	114	1.8	11	2
10.1	3	●	MVE1010X03S120	32.1	67.8	70.8	115.8	114	1.8	12	2
10.2	2	●	MVE1020X02S110	22.3	44.9	47.9	96.9	95	1.9	11	2
10.2	2	●	MVE1020X02S120	22.3	44.9	47.9	96.9	95	1.9	12	2
10.2	3	●	MVE1020X03S110	32.5	67.9	70.9	115.9	114	1.9	11	2
10.2	3	●	MVE1020X03S120	32.5	67.9	70.9	115.9	114	1.9	12	2
10.3	2	●	MVE1030X02S110	22.5	44.9	47.9	96.9	95	1.9	11	2
10.3	2	●	MVE1030X02S120	22.5	44.9	47.9	96.9	95	1.9	12	2
10.3	3	●	MVE1030X03S110	32.8	67.9	70.9	115.9	114	1.9	11	2
10.3	3	●	MVE1030X03S120	32.8	67.9	70.9	115.9	114	1.9	12	2
10.4	2	●	MVE1040X02S110	22.7	44.9	47.9	96.9	95	1.9	11	2
10.4	2	●	MVE1040X02S120	22.7	44.9	47.9	96.9	95	1.9	12	2
10.4	3	●	MVE1040X03S110	33.1	67.9	70.9	115.9	114	1.9	11	2
10.4	3	●	MVE1040X03S120	33.1	67.9	70.9	115.9	114	1.9	12	2
10.5	2	●	MVE1050X02S110	22.9	44.9	47.9	96.9	95	1.9	11	2
10.5	2	●	MVE1050X02S120	22.9	44.9	47.9	96.9	95	1.9	12	2
10.5	3	●	MVE1050X03S110	33.4	67.9	70.9	115.9	114	1.9	11	2
10.5	3	●	MVE1050X03S120	33.4	67.9	70.9	115.9	114	1.9	12	2
10.6	2	●	MVE1060X02S110	23.1	48.9	48.9	96.9	95	1.9	11	2
10.6	2	●	MVE1060X02S120	23.1	48.9	49.9	96.9	95	1.9	12	2
10.6	3	●	MVE1060X03S110	33.7	69.9	69.9	115.9	114	1.9	11	2
10.6	3	●	MVE1060X03S120	33.7	69.9	70.9	115.9	114	1.9	12	2
10.7	2	●	MVE1070X02S110	23.3	48.9	48.9	96.9	95	1.9	11	2
10.7	2	●	MVE1070X02S120	23.3	48.9	49.9	96.9	95	1.9	12	2
10.7	3	●	MVE1070X03S110	34.0	69.9	69.9	115.9	114	1.9	11	2
10.7	3	●	MVE1070X03S120	34.0	69.9	70.9	115.9	114	1.9	12	2
10.8	2	●	MVE1080X02S110	23.6	49.0	49.0	97.0	95	2.0	11	2
10.8	2	●	MVE1080X02S120	23.6	49.0	50.0	97.0	95	2.0	12	2
10.8	3	●	MVE1080X03S110	34.4	70.0	70.0	116.0	114	2.0	11	2
10.8	3	●	MVE1080X03S120	34.4	70.0	71.0	116.0	114	2.0	12	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.9	2	●	MVE1090X02S110	23.8	49.0	49.0	97.0	95	2.0	11	2
10.9	2	●	MVE1090X02S120	23.8	49.0	50.0	97.0	95	2.0	12	2
10.9	3	●	MVE1090X03S110	34.7	70.0	70.0	116.0	114	2.0	11	2
10.9	3	●	MVE1090X03S120	34.7	70.0	71.0	116.0	114	2.0	12	2
11.0	2	●	MVE1100X02S110	24.0	49.0	49.0	97.0	95	2.0	11	2
11.0	2	●	MVE1100X02S120	24.0	49.0	50.0	97.0	95	2.0	12	2
11.0	3	●	MVE1100X03S110	35.0	70.0	70.0	116.0	114	2.0	11	2
11.0	3	●	MVE1100X03S120	35.0	70.0	71.0	116.0	114	2.0	12	2
11.1	2	●	MVE1110X02S120	24.2	49.0	52.0	97.0	95	2.0	12	2
11.1	3	●	MVE1110X03S120	35.3	73.0	76.0	123.0	121	2.0	12	2
11.2	2	●	MVE1120X02S120	24.4	49.0	52.0	97.0	95	2.0	12	2
11.2	3	●	MVE1120X03S120	35.6	73.0	76.0	123.0	121	2.0	12	2
11.3	2	●	MVE1130X02S120	24.7	49.1	52.1	97.1	95	2.1	12	2
11.3	3	●	MVE1130X03S120	36.0	73.1	76.1	123.1	121	2.1	12	2
11.4	2	●	MVE1140X02S120	24.9	49.1	52.1	97.1	95	2.1	12	2
11.4	3	●	MVE1140X03S120	36.3	73.1	76.1	123.1	121	2.1	12	2
11.5	2	●	MVE1150X02S120	25.1	49.1	52.1	97.1	95	2.1	12	2
11.5	3	●	MVE1150X03S120	36.6	73.1	76.1	123.1	121	2.1	12	2
11.6	2	●	MVE1160X02S120	25.3	49.1	49.1	97.1	95	2.1	12	2
11.6	3	●	MVE1160X03S120	36.9	75.1	75.1	123.1	121	2.1	12	2
11.7	2	●	MVE1170X02S120	25.5	49.1	49.1	97.1	95	2.1	12	2
11.7	3	●	MVE1170X03S120	37.2	75.1	75.1	123.1	121	2.1	12	2
11.8	2	●	MVE1180X02S120	25.7	49.1	49.1	97.1	95	2.1	12	2
11.8	3	●	MVE1180X03S120	37.5	75.1	75.1	123.1	121	2.1	12	2
11.9	2	●	MVE1190X02S120	26.0	49.2	49.2	97.2	95	2.2	12	2
11.9	3	●	MVE1190X03S120	37.9	75.2	75.2	123.2	121	2.2	12	2
12.0	2	●	MVE1200X02S120	26.2	49.2	49.2	97.2	95	2.2	12	2
12.0	3	●	MVE1200X03S120	38.2	75.2	75.2	123.2	121	2.2	12	2
12.1	2	●	MVE1210X02S130	26.4	53.2	56.2	104.2	102	2.2	13	2
12.1	2	□	MVE1210X02S140	26.4	53.2	56.2	104.2	102	2.2	14	2
12.1	3	●	MVE1210X03S130	38.5	78.2	81.2	139.2	137	2.2	13	2
12.1	3	□	MVE1210X03S140	38.5	78.2	81.2	139.2	137	2.2	14	2
12.2	2	●	MVE1220X02S130	26.6	53.2	56.2	104.2	102	2.2	13	2
12.2	2	□	MVE1220X02S140	26.6	53.2	56.2	104.2	102	2.2	14	2
12.2	3	●	MVE1220X03S130	38.8	78.2	81.2	139.2	137	2.2	13	2
12.2	3	□	MVE1220X03S140	38.8	78.2	81.2	139.2	137	2.2	14	2
12.3	2	●	MVE1230X02S130	26.8	53.2	56.2	104.2	102	2.2	13	2
12.3	2	□	MVE1230X02S140	26.8	53.2	56.2	104.2	102	2.2	14	2
12.3	3	●	MVE1230X03S130	39.1	78.2	81.2	139.2	137	2.2	13	2
12.3	3	□	MVE1230X03S140	39.1	78.2	81.2	139.2	137	2.2	14	2
12.4	2	●	MVE1240X02S130	27.1	53.3	56.3	104.3	102	2.3	13	2
12.4	2	□	MVE1240X02S140	27.1	53.3	56.3	104.3	102	2.3	14	2
12.4	3	●	MVE1240X03S130	39.5	78.3	81.3	139.3	137	2.3	13	2
12.4	3	□	MVE1240X03S140	39.5	78.3	81.3	139.3	137	2.3	14	2
12.5	2	●	MVE1250X02S130	27.3	53.3	56.3	104.3	102	2.3	13	2
12.5	2	□	MVE1250X02S140	27.3	53.3	56.3	104.3	102	2.3	14	2
12.5	3	●	MVE1250X03S130	39.8	78.3	81.3	139.3	137	2.3	13	2
12.5	3	□	MVE1250X03S140	39.8	78.3	81.3	139.3	137	2.3	14	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.6	2	●	MVE1260X02S130	27.5	53.3	53.3	104.3	102	2.3	13	2
12.6	2	□	MVE1260X02S140	27.5	53.3	53.3	104.3	102	2.3	14	2
12.6	3	●	MVE1260X03S130	40.1	80.3	80.3	139.3	137	2.3	13	2
12.6	3	□	MVE1260X03S140	40.1	80.3	80.3	139.3	137	2.3	14	2
12.7	2	●	MVE1270X02S130	27.7	53.3	53.3	104.3	102	2.3	13	2
12.7	2	□	MVE1270X02S140	27.7	53.3	53.3	104.3	102	2.3	14	2
12.7	3	●	MVE1270X03S130	40.4	80.3	80.3	139.3	137	2.3	13	2
12.7	3	□	MVE1270X03S140	40.4	80.3	80.3	139.3	137	2.3	14	2
12.8	2	●	MVE1280X02S130	27.9	53.3	53.3	104.3	102	2.3	13	2
12.8	2	□	MVE1280X02S140	27.9	53.3	53.3	104.3	102	2.3	14	2
12.8	3	●	MVE1280X03S130	40.7	80.3	80.3	139.3	137	2.3	13	2
12.8	3	□	MVE1280X03S140	40.7	80.3	80.3	139.3	137	2.3	14	2
12.9	2	●	MVE1290X02S130	28.1	53.3	53.3	104.3	102	2.3	13	2
12.9	2	□	MVE1290X02S140	28.1	53.3	53.3	104.3	102	2.3	14	2
12.9	3	●	MVE1290X03S130	41.0	80.3	80.3	139.3	137	2.3	13	2
12.9	3	□	MVE1290X03S140	41.0	80.3	80.3	139.3	137	2.3	14	2
13.0	2	●	MVE1300X02S130	28.4	53.4	53.4	104.4	102	2.4	13	2
13.0	2	□	MVE1300X02S140	28.4	53.4	53.4	104.4	102	2.4	14	2
13.0	3	●	MVE1300X03S130	41.4	80.4	80.4	139.4	137	2.4	13	2
13.0	3	□	MVE1300X03S140	41.4	80.4	80.4	139.4	137	2.4	14	2
13.1	2	●	MVE1310X02S140	28.6	56.4	59.4	109.4	107	2.4	14	2
13.1	3	●	MVE1310X03S140	41.7	86.4	89.4	149.4	147	2.4	14	2
13.2	2	●	MVE1320X02S140	28.8	56.4	59.4	109.4	107	2.4	14	2
13.2	3	●	MVE1320X03S140	42.0	86.4	89.4	149.4	147	2.4	14	2
13.3	2	●	MVE1330X02S140	29.0	56.4	59.4	109.4	107	2.4	14	2
13.3	3	●	MVE1330X03S140	42.3	86.4	89.4	149.4	147	2.4	14	2
13.4	2	●	MVE1340X02S140	29.2	56.4	59.4	109.4	107	2.4	14	2
13.4	3	●	MVE1340X03S140	42.6	86.4	89.4	149.4	147	2.4	14	2
13.5	2	●	MVE1350X02S140	29.5	56.5	59.5	109.5	107	2.5	14	2
13.5	3	●	MVE1350X03S140	43.0	86.5	89.5	149.5	147	2.5	14	2
13.6	2	●	MVE1360X02S140	29.7	56.5	56.5	109.5	107	2.5	14	2
13.6	3	●	MVE1360X03S140	43.3	88.5	88.5	149.5	147	2.5	14	2
13.7	2	●	MVE1370X02S140	29.9	56.5	56.5	109.5	107	2.5	14	2
13.7	3	●	MVE1370X03S140	43.6	88.5	88.5	149.5	147	2.5	14	2
13.8	2	●	MVE1380X02S140	30.1	56.5	56.5	109.5	107	2.5	14	2
13.8	3	●	MVE1380X03S140	43.9	88.5	88.5	149.5	147	2.5	14	2
13.9	2	●	MVE1390X02S140	30.3	56.5	56.5	109.5	107	2.5	14	2
13.9	3	●	MVE1390X03S140	44.2	88.5	88.5	149.5	147	2.5	14	2
14.0	2	●	MVE1400X02S140	30.5	56.5	56.5	109.5	107	2.5	14	2
14.0	3	●	MVE1400X03S140	44.5	88.5	88.5	149.5	147	2.5	14	2
14.1	2	●	MVE1410X02S150	30.8	58.6	61.6	113.6	111	2.6	15	2
14.1	2	□	MVE1410X02S160	30.8	58.6	61.6	113.6	111	2.6	16	2
14.1	3	●	MVE1410X03S150	44.9	91.6	94.6	155.6	153	2.6	15	2
14.1	3	□	MVE1410X03S160	44.9	91.6	94.6	155.6	153	2.6	16	2
14.2	2	●	MVE1420X02S150	31.0	58.6	61.6	113.6	111	2.6	15	2
14.2	2	□	MVE1420X02S160	31.0	58.6	61.6	113.6	111	2.6	16	2
14.2	3	●	MVE1420X03S150	45.2	91.6	94.6	155.6	153	2.6	15	2
14.2	3	□	MVE1420X03S160	45.2	91.6	94.6	155.6	153	2.6	16	2

CUTTING CONDITIONS ➤ P048
OPERATION GUIDANCE ➤ P049
TECHNICAL DATA ➤ R001

MVE

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
14.3	2	□	MVE1430X02S150	31.2	58.6	61.6	113.6	111	2.6	15	2
14.3	2	□	MVE1430X02S160	31.2	58.6	61.6	113.6	111	2.6	16	2
14.3	3	●	MVE1430X03S150	45.5	91.6	94.6	155.6	153	2.6	15	2
14.3	3	□	MVE1430X03S160	45.5	91.6	94.6	155.6	153	2.6	16	2
14.4	2	□	MVE1440X02S150	31.4	58.6	61.6	113.6	111	2.6	15	2
14.4	2	□	MVE1440X02S160	31.4	58.6	61.6	113.6	111	2.6	16	2
14.4	3	●	MVE1440X03S150	45.8	91.6	94.6	155.6	153	2.6	15	2
14.4	3	□	MVE1440X03S160	45.8	91.6	94.6	155.6	153	2.6	16	2
14.5	2	●	MVE1450X02S150	31.6	58.6	61.6	113.6	111	2.6	15	2
14.5	2	□	MVE1450X02S160	31.6	58.6	61.6	113.6	111	2.6	16	2
14.5	3	●	MVE1450X03S150	46.1	91.6	94.6	155.6	153	2.6	15	2
14.5	3	□	MVE1450X03S160	46.1	91.6	94.6	155.6	153	2.6	16	2
14.6	2	□	MVE1460X02S150	31.9	58.7	58.7	113.7	111	2.7	15	2
14.6	2	□	MVE1460X02S160	31.9	58.7	58.7	113.7	111	2.7	16	2
14.6	3	●	MVE1460X03S150	46.5	93.7	93.7	155.7	153	2.7	15	2
14.6	3	□	MVE1460X03S160	46.5	93.7	93.7	155.7	153	2.7	16	2
14.7	2	□	MVE1470X02S150	32.1	58.7	58.7	113.7	111	2.7	15	2
14.7	2	□	MVE1470X02S160	32.1	58.7	58.7	113.7	111	2.7	16	2
14.7	3	●	MVE1470X03S150	46.8	93.7	93.7	155.7	153	2.7	15	2
14.7	3	□	MVE1470X03S160	46.8	93.7	93.7	155.7	153	2.7	16	2
14.8	2	□	MVE1480X02S150	32.3	58.7	58.7	113.7	111	2.7	15	2
14.8	2	□	MVE1480X02S160	32.3	58.7	58.7	113.7	111	2.7	16	2
14.8	3	●	MVE1480X03S150	47.1	93.7	93.7	155.7	153	2.7	15	2
14.8	3	□	MVE1480X03S160	47.1	93.7	93.7	155.7	153	2.7	16	2
14.9	2	□	MVE1490X02S150	32.5	58.7	58.7	113.7	111	2.7	15	2
14.9	2	□	MVE1490X02S160	32.5	58.7	58.7	113.7	111	2.7	16	2
14.9	3	●	MVE1490X03S150	47.4	93.7	93.7	155.7	153	2.7	15	2
14.9	3	□	MVE1490X03S160	47.4	93.7	93.7	155.7	153	2.7	16	2
15.0	2	●	MVE1500X02S150	32.7	58.7	58.7	113.7	111	2.7	15	2
15.0	2	□	MVE1500X02S160	32.7	58.7	58.7	113.7	111	2.7	16	2
15.0	3	●	MVE1500X03S150	47.7	93.7	93.7	155.7	153	2.7	15	2
15.0	3	□	MVE1500X03S160	47.7	93.7	93.7	155.7	153	2.7	16	2
15.1	2	□	MVE1510X02S160	32.9	60.7	63.7	117.7	115	2.7	16	2
15.1	3	●	MVE1510X03S160	48.0	96.7	99.7	162.7	160	2.7	16	2
15.2	2	●	MVE1520X02S160	33.2	60.8	63.8	117.8	115	2.8	16	2
15.2	3	●	MVE1520X03S160	48.4	96.8	99.8	162.8	160	2.8	16	2
15.3	2	□	MVE1530X02S160	33.4	60.8	63.8	117.8	115	2.8	16	2
15.3	3	●	MVE1530X03S160	48.7	96.8	99.8	162.8	160	2.8	16	2
15.4	2	□	MVE1540X02S160	33.6	60.8	63.8	117.8	115	2.8	16	2
15.4	3	●	MVE1540X03S160	49.0	96.8	99.8	162.8	160	2.8	16	2
15.5	2	●	MVE1550X02S160	33.8	60.8	63.8	117.8	115	2.8	16	2
15.5	3	●	MVE1550X03S160	49.3	96.8	99.8	162.8	160	2.8	16	2
15.6	2	□	MVE1560X02S160	34.0	60.8	60.8	117.8	115	2.8	16	2
15.6	3	●	MVE1560X03S160	49.6	98.8	98.8	162.8	160	2.8	16	2
15.7	2	□	MVE1570X02S160	34.3	60.9	60.9	117.9	115	2.9	16	2
15.7	3	●	MVE1570X03S160	50.0	98.9	98.9	162.9	160	2.9	16	2
15.8	2	□	MVE1580X02S160	34.5	60.9	60.9	117.9	115	2.9	16	2
15.8	3	●	MVE1580X03S160	50.3	98.9	98.9	162.9	160	2.9	16	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
15.9	2	□	MVE1590X02S160	34.7	60.9	60.9	117.9	115	2.9	16	2
15.9	3	●	MVE1590X03S160	50.6	98.9	98.9	162.9	160	2.9	16	2
16.0	2	●	MVE1600X02S160	34.9	60.9	60.9	117.9	115	2.9	16	2
16.0	3	●	MVE1600X03S160	50.9	98.9	98.9	162.9	160	2.9	16	2
16.1	2	□	MVE1610X02S170	35.1	62.9	62.9	121.9	119	2.9	17	2
16.1	2	□	MVE1610X02S180	35.1	62.9	62.9	121.9	119	2.9	18	2
16.1	3	□	MVE1610X03S170	51.2	104.9	104.9	169.9	167	2.9	17	2
16.1	3	□	MVE1610X03S180	51.2	104.9	104.9	169.9	167	2.9	18	2
16.2	2	●	MVE1620X02S170	35.3	62.9	62.9	121.9	119	2.9	17	2
16.2	2	□	MVE1620X02S180	35.3	62.9	62.9	121.9	119	2.9	18	2
16.2	3	□	MVE1620X03S170	51.5	104.9	104.9	169.9	167	2.9	17	2
16.2	3	□	MVE1620X03S180	51.5	104.9	104.9	169.9	167	2.9	18	2
16.3	2	●	MVE1630X02S170	35.6	63.0	63.0	122.0	119	3.0	17	2
16.3	2	□	MVE1630X02S180	35.6	63.0	63.0	122.0	119	3.0	18	2
16.3	3	□	MVE1630X03S170	51.9	105.0	105.0	170.0	167	3.0	17	2
16.3	3	□	MVE1630X03S180	51.9	105.0	105.0	170.0	167	3.0	18	2
16.4	2	□	MVE1640X02S170	35.8	63.0	63.0	122.0	119	3.0	17	2
16.4	2	□	MVE1640X02S180	35.8	63.0	63.0	122.0	119	3.0	18	2
16.4	3	□	MVE1640X03S170	52.2	105.0	105.0	170.0	167	3.0	17	2
16.4	3	□	MVE1640X03S180	52.2	105.0	105.0	170.0	167	3.0	18	2
16.5	2	●	MVE1650X02S170	36.0	63.0	63.0	122.0	119	3.0	17	2
16.5	2	□	MVE1650X02S180	36.0	63.0	63.0	122.0	119	3.0	18	2
16.5	3	●	MVE1650X03S170	52.5	105.0	105.0	170.0	167	3.0	17	2
16.5	3	□	MVE1650X03S180	52.5	105.0	105.0	170.0	167	3.0	18	2
16.6	2	□	MVE1660X02S170	36.2	63.0	63.0	122.0	119	3.0	17	2
16.6	2	□	MVE1660X02S180	36.2	63.0	63.0	122.0	119	3.0	18	2
16.6	3	□	MVE1660X03S170	52.8	105.0	105.0	170.0	167	3.0	17	2
16.6	3	□	MVE1660X03S180	52.8	105.0	105.0	170.0	167	3.0	18	2
16.7	2	□	MVE1670X02S170	36.4	63.0	63.0	122.0	119	3.0	17	2
16.7	2	□	MVE1670X02S180	36.4	63.0	63.0	122.0	119	3.0	18	2
16.7	3	□	MVE1670X03S170	53.1	105.0	105.0	170.0	167	3.0	17	2
16.7	3	□	MVE1670X03S180	53.1	105.0	105.0	170.0	167	3.0	18	2
16.8	2	□	MVE1680X02S170	36.7	63.1	63.1	122.1	119	3.1	17	2
16.8	2	□	MVE1680X02S180	36.7	63.1	63.1	122.1	119	3.1	18	2
16.8	3	□	MVE1680X03S170	53.5	105.1	105.1	170.1	167	3.1	17	2
16.8	3	□	MVE1680X03S180	53.5	105.1	105.1	170.1	167	3.1	18	2
16.9	2	□	MVE1690X02S170	36.9	63.1	63.1	122.1	119	3.1	17	2
16.9	2	□	MVE1690X02S180	36.9	63.1	63.1	122.1	119	3.1	18	2
16.9	3	□	MVE1690X03S170	53.8	105.1	105.1	170.1	167	3.1	17	2
16.9	3	□	MVE1690X03S180	53.8	105.1	105.1	170.1	167	3.1	18	2
17.0	2	●	MVE1700X02S170	37.1	63.1	63.1	122.1	119	3.1	17	2
17.0	2	□	MVE1700X02S180	37.1	63.1	63.1	122.1	119	3.1	18	2
17.0	3	●	MVE1700X03S170	54.1	105.1	105.1	170.1	167	3.1	17	2
17.0	3	□	MVE1700X03S180	54.1	105.1	105.1	170.1	167	3.1	18	2
17.1	2	□	MVE1710X02S180	37.3	65.1	65.1	126.1	123	3.1	18	2
17.1	3	□	MVE1710X03S180	54.4	105.1	105.1	170.1	167	3.1	18	2
17.2	2	□	MVE1720X02S180	37.5	65.1	65.1	126.1	123	3.1	18	2
17.2	3	□	MVE1720X03S180	54.7	105.1	105.1	170.1	167	3.1	18	2

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
17.3	2	□	MVE1730X02S180	37.7	65.1	65.1	126.1	123	3.1	18	2
17.3	3	□	MVE1730X03S180	55.0	105.1	105.1	170.1	167	3.1	18	2
17.4	2	□	MVE1740X02S180	38.0	65.2	65.2	126.2	123	3.2	18	2
17.4	3	□	MVE1740X03S180	55.4	105.2	105.2	170.2	167	3.2	18	2
17.5	2	●	MVE1750X02S180	38.2	65.2	65.2	126.2	123	3.2	18	2
17.5	3	●	MVE1750X03S180	55.7	105.2	105.2	170.2	167	3.2	18	2
17.6	2	□	MVE1760X02S180	38.4	65.2	65.2	126.2	123	3.2	18	2
17.6	3	□	MVE1760X03S180	56.0	105.2	105.2	170.2	167	3.2	18	2
17.7	2	□	MVE1770X02S180	38.6	65.2	65.2	126.2	123	3.2	18	2
17.7	3	□	MVE1770X03S180	56.3	105.2	105.2	170.2	167	3.2	18	2
17.8	2	●	MVE1780X02S180	38.8	65.2	65.2	126.2	123	3.2	18	2
17.8	3	□	MVE1780X03S180	56.6	105.2	105.2	170.2	167	3.2	18	2
17.9	2	□	MVE1790X02S180	39.1	65.3	65.3	126.3	123	3.3	18	2
17.9	3	□	MVE1790X03S180	57.0	105.3	105.3	170.3	167	3.3	18	2
18.0	2	●	MVE1800X02S180	39.3	65.3	65.3	126.3	123	3.3	18	2
18.0	3	●	MVE1800X03S180	57.3	105.3	105.3	170.3	167	3.3	18	2
18.1	2	□	MVE1810X02S190	39.5	67.3	67.3	130.3	127	3.3	19	2
18.1	2	□	MVE1810X02S200	39.5	67.3	67.3	130.3	127	3.3	20	2
18.1	3	□	MVE1810X03S190	57.6	117.3	117.3	182.3	179	3.3	19	2
18.1	3	□	MVE1810X03S200	57.6	117.3	117.3	182.3	179	3.3	20	2
18.2	2	□	MVE1820X02S190	39.7	67.3	67.3	130.3	127	3.3	19	2
18.2	2	□	MVE1820X02S200	39.7	67.3	67.3	130.3	127	3.3	20	2
18.2	3	□	MVE1820X03S190	57.9	117.3	117.3	182.3	179	3.3	19	2
18.2	3	□	MVE1820X03S200	57.9	117.3	117.3	182.3	179	3.3	20	2
18.3	2	□	MVE1830X02S190	39.9	67.3	67.3	130.3	127	3.3	19	2
18.3	2	□	MVE1830X02S200	39.9	67.3	67.3	130.3	127	3.3	20	2
18.3	3	□	MVE1830X03S190	58.2	117.3	117.3	182.3	179	3.3	19	2
18.3	3	□	MVE1830X03S200	58.2	117.3	117.3	182.3	179	3.3	20	2
18.4	2	□	MVE1840X02S190	40.1	67.3	67.3	130.3	127	3.3	19	2
18.4	2	□	MVE1840X02S200	40.1	67.3	67.3	130.3	127	3.3	20	2
18.4	3	□	MVE1840X03S190	58.5	117.3	117.3	182.3	179	3.3	19	2
18.4	3	□	MVE1840X03S200	58.5	117.3	117.3	182.3	179	3.3	20	2
18.5	2	●	MVE1850X02S190	40.4	67.4	67.4	130.4	127	3.4	19	2
18.5	2	□	MVE1850X02S200	40.4	67.4	67.4	130.4	127	3.4	20	2
18.5	3	●	MVE1850X03S190	58.9	117.4	117.4	182.4	179	3.4	19	2
18.5	3	□	MVE1850X03S200	58.9	117.4	117.4	182.4	179	3.4	20	2
18.6	2	□	MVE1860X02S190	40.6	67.4	67.4	130.4	127	3.4	19	2
18.6	2	□	MVE1860X02S200	40.6	67.4	67.4	130.4	127	3.4	20	2
18.6	3	□	MVE1860X03S190	59.2	117.4	117.4	182.4	179	3.4	19	2
18.6	3	□	MVE1860X03S200	59.2	117.4	117.4	182.4	179	3.4	20	2
18.7	2	□	MVE1870X02S190	40.8	67.4	67.4	130.4	127	3.4	19	2
18.7	2	□	MVE1870X02S200	40.8	67.4	67.4	130.4	127	3.4	20	2
18.7	3	□	MVE1870X03S190	59.5	117.4	117.4	182.4	179	3.4	19	2
18.7	3	□	MVE1870X03S200	59.5	117.4	117.4	182.4	179	3.4	20	2
18.8	2	□	MVE1880X02S190	41.0	67.4	67.4	130.4	127	3.4	19	2
18.8	2	□	MVE1880X02S200	41.0	67.4	67.4	130.4	127	3.4	20	2
18.8	3	□	MVE1880X03S190	59.8	117.4	117.4	182.4	179	3.4	19	2
18.8	3	□	MVE1880X03S200	59.8	117.4	117.4	182.4	179	3.4	20	2

DC (mm)	Hole Depth (L/D)	DP1020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
18.9	2	□	MVE1890X02S190	41.2	67.4	67.4	130.4	127	3.4	19	2
18.9	2	□	MVE1890X02S200	41.2	67.4	67.4	130.4	127	3.4	20	2
18.9	3	□	MVE1890X03S190	60.1	117.4	117.4	182.4	179	3.4	19	2
18.9	3	□	MVE1890X03S200	60.1	117.4	117.4	182.4	179	3.4	20	2
19.0	2	●	MVE1900X02S190	41.5	67.5	67.5	130.5	127	3.5	19	2
19.0	2	□	MVE1900X02S200	41.5	67.5	67.5	130.5	127	3.5	20	2
19.0	3	●	MVE1900X03S190	60.5	117.5	117.5	182.5	179	3.5	19	2
19.0	3	□	MVE1900X03S200	60.5	117.5	117.5	182.5	179	3.5	20	2
19.1	2	□	MVE1910X02S200	41.7	69.5	69.5	134.5	131	3.5	20	2
19.1	3	□	MVE1910X03S200	60.8	117.5	117.5	182.5	179	3.5	20	2
19.2	2	□	MVE1920X02S200	41.9	69.5	69.5	134.5	131	3.5	20	2
19.2	3	□	MVE1920X03S200	61.1	117.5	117.5	182.5	179	3.5	20	2
19.3	2	□	MVE1930X02S200	42.1	69.5	69.5	134.5	131	3.5	20	2
19.3	3	□	MVE1930X03S200	61.4	117.5	117.5	182.5	179	3.5	20	2
19.4	2	□	MVE1940X02S200	42.3	69.5	69.5	134.5	131	3.5	20	2
19.4	3	□	MVE1940X03S200	61.7	117.5	117.5	182.5	179	3.5	20	2
19.5	2	●	MVE1950X02S200	42.5	69.5	69.5	134.5	131	3.5	20	2
19.5	3	●	MVE1950X03S200	62.0	117.5	117.5	182.5	179	3.5	20	2
19.6	2	□	MVE1960X02S200	42.8	69.6	69.6	134.6	131	3.6	20	2
19.6	3	□	MVE1960X03S200	62.4	117.6	117.6	182.6	179	3.6	20	2
19.7	2	□	MVE1970X02S200	43.0	69.6	69.6	134.6	131	3.6	20	2
19.7	3	□	MVE1970X03S200	62.7	117.6	117.6	182.6	179	3.6	20	2
19.8	2	□	MVE1980X02S200	43.2	69.6	69.6	134.6	131	3.6	20	2
19.8	3	□	MVE1980X03S200	63.0	117.6	117.6	182.6	179	3.6	20	2
19.9	2	□	MVE1990X02S200	43.4	69.6	69.6	134.6	131	3.6	20	2
19.9	3	□	MVE1990X03S200	63.3	117.6	117.6	182.6	179	3.6	20	2
20.0	2	●	MVE2000X02S200	43.6	69.6	69.6	134.6	131	3.6	20	2
20.0	3	●	MVE2000X03S200	63.6	117.6	117.6	182.6	179	3.6	20	2

CUTTING CONDITIONS ➤ P048
OPERATION GUIDANCE ➤ P049
TECHNICAL DATA ➤ R001

MVE

WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

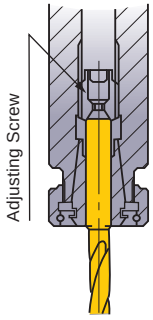
Work Material	Mild Steel (≤180HB) AISI 1010 etc			Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc			Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
3.2	6400	0.1	(0.06−0.13)	5900	0.1	(0.06−0.13)	5400	0.09	(0.06−0.12)
4.0	5500	0.12	(0.08−0.16)	5100	0.12	(0.08−0.16)	4700	0.11	(0.07−0.14)
5.0	4400	0.15	(0.10−0.20)	4100	0.15	(0.10−0.20)	3800	0.14	(0.09−0.18)
6.3	4000	0.2	(0.13−0.26)	3700	0.2	(0.13−0.26)	3500	0.18	(0.11−0.24)
8.0	3300	0.23	(0.18−0.28)	3100	0.23	(0.18−0.28)	2900	0.21	(0.16−0.25)
10.0	2800	0.27	(0.22−0.32)	2700	0.27	(0.22−0.32)	2500	0.23	(0.19−0.27)
12.0	2500	0.31	(0.28−0.34)	2300	0.31	(0.28−0.34)	2200	0.26	(0.23−0.29)
16.0	1900	0.33	(0.28−0.38)	1700	0.33	(0.28−0.38)	1600	0.29	(0.24−0.33)
20.0	1500	0.35	(0.30−0.40)	1400	0.35	(0.30−0.40)	1300	0.3	(0.26−0.34)

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc			Gray Cast Iron (≤350MPa) No 45 B etc			Ductile Cast Iron (≤450MPa) 60-40-8 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
3.2	1900	0.07	(0.05−0.08)	6900	0.1	(0.06−0.13)	6400	0.1	(0.06−0.13)
4.0	1500	0.08	(0.06−0.10)	5500	0.12	(0.08−0.16)	5100	0.12	(0.08−0.16)
5.0	1200	0.1	(0.07−0.13)	4400	0.15	(0.10−0.20)	4100	0.15	(0.10−0.20)
6.3	1200	0.13	(0.09−0.17)	3700	0.2	(0.13−0.26)	3500	0.2	(0.13−0.26)
8.0	900	0.14	(0.10−0.18)	2900	0.25	(0.18−0.31)	2700	0.23	(0.18−0.28)
10.0	700	0.16	(0.12−0.19)	2300	0.29	(0.22−0.35)	2200	0.27	(0.22−0.32)
12.0	600	0.18	(0.15−0.20)	2100	0.33	(0.28−0.37)	1900	0.31	(0.28−0.34)
16.0	400	0.19	(0.15−0.23)	1500	0.35	(0.28−0.42)	1400	0.33	(0.28−0.38)
20.0	300	0.2	(0.15−0.24)	1300	0.37	(0.30−0.44)	1200	0.35	(0.30−0.40)

Work Material	Aluminium Alloy (Si<5%)			Heat Resistant Alloy Inconel718 etc			Hardened Steel (40−55HRC) AISI H13, L6 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
3.2	7900	0.1	(0.06−0.13)	1900	0.07	(0.05−0.09)	1900	0.07	(0.05−0.09)
4.0	6300	0.12	(0.08−0.16)	1500	0.09	(0.06−0.11)	1500	0.09	(0.06−0.11)
5.0	5000	0.15	(0.10−0.20)	1200	0.11	(0.08−0.14)	1200	0.11	(0.08−0.14)
6.3	4500	0.2	(0.13−0.26)	1200	0.14	(0.09−0.19)	1200	0.14	(0.09−0.19)
8.0	3500	0.23	(0.18−0.28)	900	0.14	(0.11−0.17)	900	0.14	(0.11−0.17)
10.0	2800	0.27	(0.22−0.32)	700	0.16	(0.12−0.19)	700	0.16	(0.12−0.19)
12.0	2600	0.31	(0.28−0.34)	600	0.16	(0.13−0.18)	600	0.16	(0.13−0.18)
16.0	1900	0.33	(0.28−0.38)	400	0.18	(0.14−0.21)	400	0.18	(0.14−0.21)
20.0	1700	0.35	(0.30−0.40)	400	0.19	(0.15−0.22)	400	0.19	(0.15−0.22)

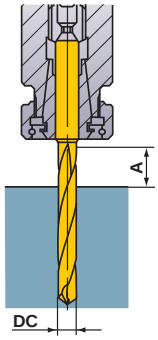
■ OPERATIONAL GUIDANCE

Drill Holding



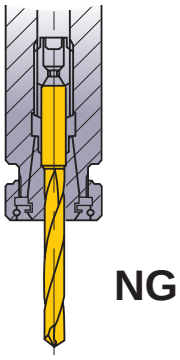
Thrust bearing type collet chuck holds the drill securely.

Drill Length



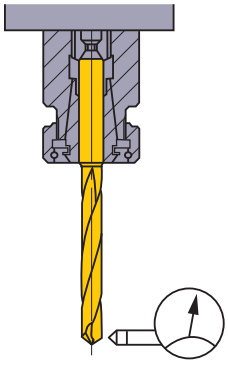
A ≥ DC x 1.5(DC×over 2.0 for DC<3)

Drill Installation



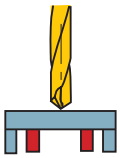
Do not clamp on the flutes.

Installation Tolerance

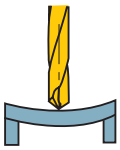


Run-out ≤ 0.03mm

Thin Workpiece

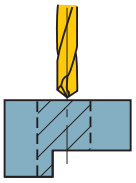


OK
Support the Workpiece

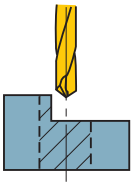


NG
If Bending Occurs

Interrupted Cutting

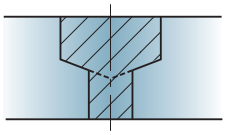


One Process
OK
①Lower the feed when drilling the interrupted part.



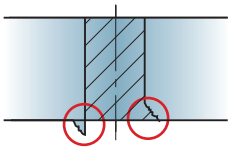
Requires Prior Machining
①Spot face with an end mill prior to drilling.

Stepped Holes



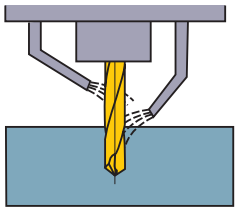
①Divide the two processes.
②Drill the larger hole first.
⋆A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping



①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

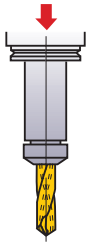
Coolant Method (MVE)



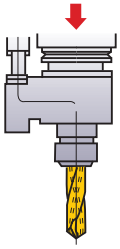
Two coolant positions, at the end and at the center are ideal.

Through Coolant Type (MVS)

Spindles Through Coolant Type



Revolving Coolant Machine Type



Less than ø3mm : 1.5MPa-7MP
More than ø3mm : 0.5MPa-7MPa
More than 3MPa is recommended.

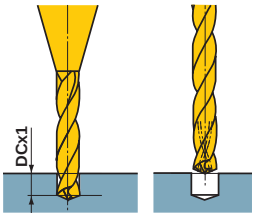
Coolant Handling

<MVS Type>

1) Small particles of swarf will jam in the oil hole of small diameter drills. Always use a fine mesh filter as a preventative measure.

2) Dirt and dust particles adhere to the oil in old coolant and prevent an efficient flow. Regular coolant exchange is recommended.

Drill Installation



①Make approx. DCx1(DC=drill diameter) pilot hole by using the MVS with the shortest flutes.
②Use the pilot hole as a guide and machine by the drill with coolant hole. Depending on the application, carry out pecking.

■ NOTES ON USE (For DC<3mm)

Please use a fine mesh filter (mesh≤3μm) for coolant to prevent jamming in the oil hole.
For deep drilling with the long type drill, machining a pilot hole is recommended.
(Otherwise, centrifugal forces may cause drill breakage.)

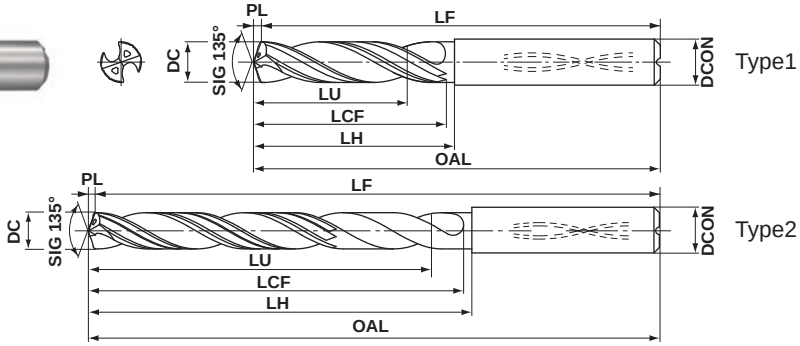
MQS
WSTAR DRILLS

●High efficiency and high accuracy machining of steel and cast iron is possible.

TOOL NEWS

P Steel | M | K Cast Iron | N | S | H

Internal Coolant



DC=3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
0 −0.012	0 −0.012	0 −0.015	0 −0.018	0 −0.021
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤18**	**18<DCON≤20**
0 −0.006	0 −0.008	0 −0.009	0 −0.011	0 −0.013

Note 1) MQS drills are suitable for use with shrink fit holders.

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.0	3	▲	MQS0300X3DB	9.6	21.6	23.6	70.6	70	0.6	3	1
3.0	5	▲	MQS0300X5DB	15.6	28.6	31.6	78.6	78	0.6	3	1
3.0	8	▲	MQS0300X8DB	24.6	35.6	35.6	81.6	81	0.6	3	1
3.1	3	▲	MQS0310X3DB	9.9	21.6	23.6	70.6	70	0.6	4	1
3.1	5	▲	MQS0310X5DB	16.1	28.6	31.6	78.6	78	0.6	4	1
3.2	3	▲	MQS0320X3DB	10.3	21.7	23.7	70.7	70	0.7	4	1
3.2	5	▲	MQS0320X5DB	16.7	28.7	31.7	78.7	78	0.7	4	1
3.3	3	▲	MQS0330X3DB	10.6	21.7	23.7	70.7	70	0.7	4	1
3.3	5	▲	MQS0330X5DB	17.2	28.7	31.7	78.7	78	0.7	4	1
3.4	3	▲	MQS0340X3DB	10.9	21.7	23.7	70.7	70	0.7	4	1
3.4	5	▲	MQS0340X5DB	17.7	28.7	31.7	78.7	78	0.7	4	1
3.5	3	▲	MQS0350X3DB	11.2	21.7	23.7	70.7	70	0.7	4	1
3.5	5	▲	MQS0350X5DB	18.2	28.7	31.7	78.7	78	0.7	4	1
3.5	8	▲	MQS0350X8DB	28.7	41.7	41.7	87.7	87	0.7	4	1
3.6	3	▲	MQS0360X3DB	11.5	22.7	23.7	70.7	70	0.7	4	1
3.6	5	▲	MQS0360X5DB	18.7	30.7	31.7	78.7	78	0.7	4	1
3.7	3	▲	MQS0370X3DB	11.9	22.8	23.8	70.8	70	0.8	4	1
3.7	5	▲	MQS0370X5DB	19.3	30.8	31.8	78.8	78	0.8	4	1
3.8	3	▲	MQS0380X3DB	12.2	22.8	23.8	70.8	70	0.8	4	1
3.8	5	▲	MQS0380X5DB	19.8	30.8	31.8	78.8	78	0.8	4	1
3.9	3	▲	MQS0390X3DB	12.5	22.8	23.8	70.8	70	0.8	4	1
3.9	5	▲	MQS0390X5DB	20.3	30.8	31.8	78.8	78	0.8	4	1
4.0	3	▲	MQS0400X3DB	12.8	22.8	23.8	70.8	70	0.8	4	1
4.0	5	▲	MQS0400X5DB	20.8	30.8	31.8	78.8	78	0.8	4	1
4.0	8	▲	MQS0400X8DB	32.8	46.8	46.8	92.8	92	0.8	4	1
4.1	3	▲	MQS0410X3DB	13.1	24.8	26.8	73.8	73	0.8	5	1
4.1	5	▲	MQS0410X5DB	21.3	33.8	35.8	82.8	82	0.8	5	1
4.2	3	▲	MQS0420X3DB	13.5	24.9	26.9	73.9	73	0.9	5	1
4.2	5	▲	MQS0420X5DB	21.9	33.9	35.9	82.9	82	0.9	5	1
4.3	3	▲	MQS0430X3DB	13.8	24.9	26.9	73.9	73	0.9	5	1
4.3	5	▲	MQS0430X5DB	22.4	33.9	35.9	82.9	82	0.9	5	1
4.4	3	▲	MQS0440X3DB	14.1	24.9	26.9	73.9	73	0.9	5	1
4.4	5	▲	MQS0440X5DB	22.9	33.9	35.9	82.9	82	0.9	5	1
4.5	3	▲	MQS0450X3DB	14.4	24.9	26.9	73.9	73	0.9	5	1

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.5	5	▲	MQS0450X5DB	23.4	33.9	35.9	82.9	82	0.9	5	1
4.5	8	▲	MQS0450X8DB	36.9	52.9	52.9	100.9	100	0.9	5	1
4.6	3	▲	MQS0460X3DB	14.8	26.0	29.0	76.0	75	1.0	5	1
4.6	5	▲	MQS0460X5DB	24.0	36.0	39.0	86.0	85	1.0	5	1
4.7	3	▲	MQS0470X3DB	15.1	26.0	29.0	76.0	75	1.0	5	1
4.7	5	▲	MQS0470X5DB	24.5	36.0	39.0	86.0	85	1.0	5	1
4.8	3	▲	MQS0480X3DB	15.4	26.0	29.0	76.0	75	1.0	5	1
4.8	5	▲	MQS0480X5DB	25.0	36.0	39.0	86.0	85	1.0	5	1
4.9	3	▲	MQS0490X3DB	15.7	26.0	29.0	76.0	75	1.0	5	1
4.9	5	▲	MQS0490X5DB	25.5	36.0	39.0	86.0	85	1.0	5	1
5.0	3	▲	MQS0500X3DB	16.0	26.0	29.0	76.0	75	1.0	5	1
5.0	5	▲	MQS0500X5DB	26.0	36.0	39.0	86.0	85	1.0	5	1
5.0	8	▲	MQS0500X8DB	41.0	58.0	58.0	106.0	105	1.0	5	1
5.1	3	▲	MQS0510X3DB	16.4	29.1	31.1	82.1	81	1.1	6	1
5.1	5	▲	MQS0510X5DB	26.6	40.1	43.1	90.1	89	1.1	6	1
5.2	3	▲	MQS0520X3DB	16.7	29.1	31.1	82.1	81	1.1	6	1
5.2	5	▲	MQS0520X5DB	27.1	40.1	43.1	90.1	89	1.1	6	1
5.3	3	▲	MQS0530X3DB	17.0	29.1	31.1	82.1	81	1.1	6	1
5.3	5	▲	MQS0530X5DB	27.6	40.1	43.1	90.1	89	1.1	6	1
5.4	3	▲	MQS0540X3DB	17.3	29.1	31.1	82.1	81	1.1	6	1
5.4	5	▲	MQS0540X5DB	28.1	40.1	43.1	90.1	89	1.1	6	1
5.5	3	▲	MQS0550X3DB	17.6	29.1	31.1	82.1	81	1.1	6	1
5.5	5	▲	MQS0550X5DB	28.6	40.1	43.1	90.1	89	1.1	6	1
5.5	8	▲	MQS0550X8DB	45.1	62.1	67.1	119.1	118	1.1	6	1
5.6	3	▲	MQS0560X3DB	18.0	31.2	31.2	82.2	81	1.2	6	1
5.6	5	▲	MQS0560X5DB	29.2	43.2	43.2	90.2	89	1.2	6	1
5.7	3	▲	MQS0570X3DB	18.3	31.2	31.2	82.2	81	1.2	6	1
5.7	5	▲	MQS0570X5DB	29.7	43.2	43.2	90.2	89	1.2	6	1
5.8	3	▲	MQS0580X3DB	18.6	31.2	31.2	82.2	81	1.2	6	1
5.8	5	▲	MQS0580X5DB	30.2	43.2	43.2	90.2	89	1.2	6	1
5.9	3	▲	MQS0590X3DB	18.9	31.2	31.2	82.2	81	1.2	6	1
5.9	5	▲	MQS0590X5DB	30.7	43.2	43.2	90.2	89	1.2	6	1
6.0	3	▲	MQS0600X3DB	19.2	31.2	31.2	82.2	81	1.2	6	1
6.0	5	▲	MQS0600X5DB	31.2	43.2	43.2	90.2	89	1.2	6	1

Note 1) The coolant hole of ø6mm or less will be round shape.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.0	8	▲	MQS0600X8DB	49.2	67.2	67.2	119.2	118	1.2	6	1
6.1	3	▲	MQS0610X3DB	19.6	34.3	36.3	87.3	86	1.3	7	1
6.1	5	▲	MQS0610X5DB	31.8	47.3	49.3	96.3	95	1.3	7	1
6.2	3	▲	MQS0620X3DB	19.9	34.3	36.3	87.3	86	1.3	7	1
6.2	5	▲	MQS0620X5DB	32.3	47.3	49.3	96.3	95	1.3	7	1
6.3	3	▲	MQS0630X3DB	20.2	34.3	36.3	87.3	86	1.3	7	1
6.3	5	▲	MQS0630X5DB	32.8	47.3	49.3	96.3	95	1.3	7	1
6.4	3	▲	MQS0640X3DB	20.5	34.3	36.3	87.3	86	1.3	7	1
6.4	5	▲	MQS0640X5DB	33.3	47.3	49.3	96.3	95	1.3	7	1
6.5	3	▲	MQS0650X3DB	20.8	34.3	36.3	87.3	86	1.3	7	1
6.5	5	▲	MQS0650X5DB	33.8	47.3	49.3	96.3	95	1.3	7	1
6.5	8	▲	MQS0650X8DB	53.3	73.3	78.3	131.3	130	1.3	7	1
6.6	3	▲	MQS0660X3DB	21.2	36.4	38.4	91.4	90	1.4	7	1
6.6	5	▲	MQS0660X5DB	34.4	50.4	52.4	99.4	98	1.4	7	1
6.7	3	▲	MQS0670X3DB	21.5	36.4	38.4	91.4	90	1.4	7	1
6.7	5	▲	MQS0670X5DB	34.9	50.4	52.4	99.4	98	1.4	7	1
6.8	3	▲	MQS0680X3DB	21.8	36.4	38.4	91.4	90	1.4	7	1
6.8	5	▲	MQS0680X5DB	35.4	50.4	52.4	99.4	98	1.4	7	1
6.9	3	▲	MQS0690X3DB	22.1	36.4	38.4	91.4	90	1.4	7	1
6.9	5	▲	MQS0690X5DB	35.9	50.4	52.4	99.4	98	1.4	7	1
7.0	3	▲	MQS0700X3DB	22.4	36.4	38.4	91.4	90	1.4	7	1
7.0	5	▲	MQS0700X5DB	36.4	50.4	52.4	99.4	98	1.4	7	1
7.0	8	▲	MQS0700X8DB	57.4	78.4	78.4	131.4	130	1.4	7	1
7.1	3	▲	MQS0710X3DB	22.8	39.5	40.5	91.5	90	1.5	8	1
7.1	5	▲	MQS0710X5DB	37.0	54.5	57.5	104.5	103	1.5	8	1
7.2	3	▲	MQS0720X3DB	23.1	39.5	40.5	91.5	90	1.5	8	1
7.2	5	▲	MQS0720X5DB	37.5	54.5	57.5	104.5	103	1.5	8	1
7.3	3	▲	MQS0730X3DB	23.4	39.5	40.5	91.5	90	1.5	8	1
7.3	5	▲	MQS0730X5DB	38.0	54.5	57.5	104.5	103	1.5	8	1
7.4	3	▲	MQS0740X3DB	23.7	39.5	40.5	91.5	90	1.5	8	1
7.4	5	▲	MQS0740X5DB	38.5	54.5	57.5	104.5	103	1.5	8	1
7.5	3	▲	MQS0750X3DB	24.1	39.6	40.6	91.6	90	1.6	8	1
7.5	5	▲	MQS0750X5DB	39.1	54.6	57.6	104.6	103	1.6	8	1
7.5	8	▲	MQS0750X8DB	61.6	84.6	89.6	143.6	142	1.6	8	2
7.6	3	▲	MQS0760X3DB	24.4	41.6	41.6	91.6	90	1.6	8	1
7.6	5	▲	MQS0760X5DB	39.6	57.6	57.6	104.6	103	1.6	8	1
7.7	3	▲	MQS0770X3DB	24.7	41.6	41.6	91.6	90	1.6	8	1
7.7	5	▲	MQS0770X5DB	40.1	57.6	57.6	104.6	103	1.6	8	1
7.8	3	▲	MQS0780X3DB	25.0	41.6	41.6	91.6	90	1.6	8	1
7.8	5	▲	MQS0780X5DB	40.6	57.6	57.6	104.6	103	1.6	8	1
7.9	3	▲	MQS0790X3DB	25.3	41.6	41.6	91.6	90	1.6	8	1
7.9	5	▲	MQS0790X5DB	41.1	57.6	57.6	104.6	103	1.6	8	1
8.0	3	▲	MQS0800X3DB	25.7	41.7	41.7	91.7	90	1.7	8	1
8.0	5	▲	MQS0800X5DB	41.7	57.7	57.7	104.7	103	1.7	8	1
8.0	8	▲	MQS0800X8DB	65.7	89.7	89.7	143.7	142	1.7	8	2
8.1	3	▲	MQS0810X3DB	26.0	44.7	46.7	97.7	96	1.7	9	1
8.1	5	▲	MQS0810X5DB	42.2	61.7	63.7	114.7	113	1.7	9	1
8.2	3	▲	MQS0820X3DB	26.3	44.7	46.7	97.7	96	1.7	9	1
8.2	5	▲	MQS0820X5DB	42.7	61.7	63.7	114.7	113	1.7	9	1
8.3	3	▲	MQS0830X3DB	26.6	44.7	46.7	97.7	96	1.7	9	1

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.3	5	▲	MQS0830X5DB	43.2	61.7	63.7	114.7	113	1.7	9	1
8.4	3	▲	MQS0840X3DB	26.9	44.7	46.7	97.7	96	1.7	9	1
8.4	5	▲	MQS0840X5DB	43.7	61.7	63.7	114.7	113	1.7	9	1
8.5	3	▲	MQS0850X3DB	27.3	44.8	46.8	97.8	96	1.8	9	1
8.5	5	▲	MQS0850X5DB	44.3	61.8	63.8	114.8	113	1.8	9	1
8.5	8	▲	MQS0850X8DB	69.8	95.8	100.8	155.8	154	1.8	9	2
8.6	3	▲	MQS0860X3DB	27.6	46.8	48.8	102.8	101	1.8	9	1
8.6	5	▲	MQS0860X5DB	44.8	64.8	66.8	117.8	116	1.8	9	1
8.7	3	▲	MQS0870X3DB	27.9	46.8	48.8	102.8	101	1.8	9	1
8.7	5	▲	MQS0870X5DB	45.3	64.8	66.8	117.8	116	1.8	9	1
8.8	3	▲	MQS0880X3DB	28.2	46.8	48.8	102.8	101	1.8	9	1
8.8	5	▲	MQS0880X5DB	45.8	64.8	66.8	117.8	116	1.8	9	1
8.9	3	▲	MQS0890X3DB	28.5	46.8	48.8	102.8	101	1.8	9	1
8.9	5	▲	MQS0890X5DB	46.3	64.8	66.8	117.8	116	1.8	9	1
9.0	3	▲	MQS0900X3DB	28.9	46.9	48.9	102.9	101	1.9	9	1
9.0	5	▲	MQS0900X5DB	46.9	64.9	66.9	117.9	116	1.9	9	1
9.0	8	▲	MQS0900X8DB	73.9	100.9	100.9	155.9	154	1.9	9	2
9.1	3	▲	MQS0910X3DB	29.2	49.9	51.9	102.9	101	1.9	10	1
9.1	5	▲	MQS0910X5DB	47.4	68.9	71.9	122.9	121	1.9	10	1
9.2	3	▲	MQS0920X3DB	29.5	49.9	51.9	102.9	101	1.9	10	1
9.2	5	▲	MQS0920X5DB	47.9	68.9	71.9	122.9	121	1.9	10	1
9.3	3	▲	MQS0930X3DB	29.8	49.9	51.9	102.9	101	1.9	10	1
9.3	5	▲	MQS0930X5DB	48.4	68.9	71.9	122.9	121	1.9	10	1
9.4	3	▲	MQS0940X3DB	30.1	49.9	51.9	102.9	101	1.9	10	1
9.4	5	▲	MQS0940X5DB	48.9	68.9	71.9	122.9	121	1.9	10	1
9.5	3	▲	MQS0950X3DB	30.5	50.0	52.0	103.0	101	2.0	10	1
9.5	5	▲	MQS0950X5DB	49.5	69.0	72.0	123.0	121	2.0	10	1
9.5	8	▲	MQS0950X8DB	78.0	107.0	112.0	168.0	166	2.0	10	2
9.6	3	▲	MQS0960X3DB	30.8	52.0	52.0	103.0	101	2.0	10	1
9.6	5	▲	MQS0960X5DB	50.0	72.0	72.0	123.0	121	2.0	10	1
9.7	3	▲	MQS0970X3DB	31.1	52.0	52.0	103.0	101	2.0	10	1
9.7	5	▲	MQS0970X5DB	50.5	72.0	72.0	123.0	121	2.0	10	1
9.8	3	▲	MQS0980X3DB	31.4	52.0	52.0	103.0	101	2.0	10	1
9.8	5	▲	MQS0980X5DB	51.0	72.0	72.0	123.0	121	2.0	10	1
9.9	3	▲	MQS0990X3DB	31.8	52.1	52.1	103.1	101	2.1	10	1
9.9	5	▲	MQS0990X5DB	51.6	72.1	72.1	123.1	121	2.1	10	1
10.0	3	▲	MQS1000X3DB	32.1	52.1	52.1	103.1	101	2.1	10	1
10.0	5	▲	MQS1000X5DB	52.1	72.1	72.1	123.1	121	2.1	10	1
10.0	8	▲	MQS1000X8DB	82.1	112.1	112.1	168.1	166	2.1	10	2
10.1	3	▲	MQS1010X3DB	32.4	55.1	57.1	113.1	111	2.1	11	1
10.1	5	▲	MQS1010X5DB	52.6	76.1	80.1	136.1	134	2.1	11	1
10.2	3	▲	MQS1020X3DB	32.7	55.1	57.1	113.1	111	2.1	11	1
10.2	5	▲	MQS1020X5DB	53.1	76.1	80.1	136.1	134	2.1	11	1
10.3	3	▲	MQS1030X3DB	33.0	55.1	57.1	113.1	111	2.1	11	1
10.3	5	▲	MQS1030X5DB	53.6	76.1	80.1	136.1	134	2.1	11	1
10.4	3	▲	MQS1040X3DB	33.4	55.2	57.2	113.2	111	2.2	11	1
10.4	5	▲	MQS1040X5DB	54.2	76.2	80.2	136.2	134	2.2	11	1
10.5	3	▲	MQS1050X3DB	33.7	55.2	57.2	113.2	111	2.2	11	1
10.5	5	▲	MQS1050X5DB	54.7	76.2	80.2	136.2	134	2.2	11	1
10.5	8	▲	MQS1050X8DB	86.2	118.2	123.2	184.2	182	2.2	11	2

CUTTING CONDITIONS ➤ P054
OPERATION GUIDANCE ➤ P056
TECHNICAL DATA ➤ R001

MQS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.6	3	▲	MQS1060X3DB	34.0	57.2	58.2	118.2	116	2.2	11	1
10.6	5	▲	MQS1060X5DB	55.2	79.2	80.2	136.2	134	2.2	11	1
10.7	3	▲	MQS1070X3DB	34.3	57.2	58.2	118.2	116	2.2	11	1
10.7	5	▲	MQS1070X5DB	55.7	79.2	80.2	136.2	134	2.2	11	1
10.8	3	▲	MQS1080X3DB	34.6	57.2	58.2	118.2	116	2.2	11	1
10.8	5	▲	MQS1080X5DB	56.2	79.2	80.2	136.2	134	2.2	11	1
10.9	3	▲	MQS1090X3DB	35.0	57.3	58.3	118.3	116	2.3	11	1
10.9	5	▲	MQS1090X5DB	56.8	79.3	80.3	136.3	134	2.3	11	1
11.0	3	▲	MQS1100X3DB	35.3	57.3	58.3	118.3	116	2.3	11	1
11.0	5	▲	MQS1100X5DB	57.3	79.3	80.3	136.3	134	2.3	11	1
11.0	8	▲	MQS1100X8DB	90.3	123.3	123.3	184.3	182	2.3	11	2
11.1	3	▲	MQS1110X3DB	35.6	60.3	62.3	118.3	116	2.3	12	1
11.1	5	▲	MQS1110X5DB	57.8	83.3	86.3	142.3	140	2.3	12	1
11.2	3	▲	MQS1120X3DB	35.9	60.3	62.3	118.3	116	2.3	12	1
11.2	5	▲	MQS1120X5DB	58.3	83.3	86.3	142.3	140	2.3	12	1
11.3	3	▲	MQS1130X3DB	36.2	60.3	62.3	118.3	116	2.3	12	1
11.3	5	▲	MQS1130X5DB	58.8	83.3	86.3	142.3	140	2.3	12	1
11.4	3	▲	MQS1140X3DB	36.6	60.4	62.4	118.4	116	2.4	12	1
11.4	5	▲	MQS1140X5DB	59.4	83.4	86.4	142.4	140	2.4	12	1
11.5	3	▲	MQS1150X3DB	36.9	60.4	62.4	118.4	116	2.4	12	1
11.5	5	▲	MQS1150X5DB	59.9	83.4	86.4	142.4	140	2.4	12	1
11.5	8	▲	MQS1150X8DB	94.4	129.4	134.4	196.4	194	2.4	12	2
11.6	3	▲	MQS1160X3DB	37.2	62.4	62.4	118.4	116	2.4	12	1
11.6	5	▲	MQS1160X5DB	60.4	86.4	86.4	142.4	140	2.4	12	1
11.7	3	▲	MQS1170X3DB	37.5	62.4	62.4	118.4	116	2.4	12	1
11.7	5	▲	MQS1170X5DB	60.9	86.4	86.4	142.4	140	2.4	12	1
11.8	3	▲	MQS1180X3DB	37.8	62.4	62.4	118.4	116	2.4	12	1
11.8	5	▲	MQS1180X5DB	61.4	86.4	86.4	142.4	140	2.4	12	1
11.9	3	▲	MQS1190X3DB	38.2	62.5	62.5	118.5	116	2.5	12	1
11.9	5	▲	MQS1190X5DB	62.0	86.5	86.5	142.5	140	2.5	12	1
12.0	3	▲	MQS1200X3DB	38.5	62.5	62.5	118.5	116	2.5	12	1
12.0	5	▲	MQS1200X5DB	62.5	86.5	86.5	142.5	140	2.5	12	1
12.0	8	▲	MQS1200X8DB	98.5	134.5	134.5	196.5	194	2.5	12	2
12.1	3	▲	MQS1210X3DB	38.8	65.5	68.5	124.5	122	2.5	13	1
12.1	5	▲	MQS1210X5DB	63.0	90.5	94.5	150.5	148	2.5	13	1
12.2	3	▲	MQS1220X3DB	39.1	65.5	68.5	124.5	122	2.5	13	1
12.2	5	▲	MQS1220X5DB	63.5	90.5	94.5	150.5	148	2.5	13	1
12.3	3	▲	MQS1230X3DB	39.4	65.5	68.5	124.5	122	2.5	13	1
12.3	5	▲	MQS1230X5DB	64.0	90.5	94.5	150.5	148	2.5	13	1
12.4	3	▲	MQS1240X3DB	39.8	65.6	68.6	124.6	122	2.6	13	1
12.4	5	▲	MQS1240X5DB	64.6	90.6	94.6	150.6	148	2.6	13	1
12.5	3	▲	MQS1250X3DB	40.1	65.6	68.6	124.6	122	2.6	13	1
12.5	5	▲	MQS1250X5DB	65.1	90.6	94.6	150.6	148	2.6	13	1
12.5	8	▲	MQS1250X8DB	102.6	140.6	145.6	208.6	206	2.6	13	2
12.6	3	▲	MQS1260X3DB	40.4	67.6	68.6	124.6	122	2.6	13	1
12.6	5	▲	MQS1260X5DB	65.6	93.6	94.6	150.6	148	2.6	13	1
12.7	3	▲	MQS1270X3DB	40.7	67.6	68.6	124.6	122	2.6	13	1
12.7	5	▲	MQS1270X5DB	66.1	93.6	94.6	150.6	148	2.6	13	1
12.8	3	▲	MQS1280X3DB	41.1	67.7	68.7	124.7	122	2.7	13	1
12.8	5	▲	MQS1280X5DB	66.7	93.7	94.7	150.7	148	2.7	13	1

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.9	3	▲	MQS1290X3DB	41.4	67.7	68.7	124.7	122	2.7	13	1
12.9	5	▲	MQS1290X5DB	67.2	93.7	94.7	150.7	148	2.7	13	1
13.0	3	▲	MQS1300X3DB	41.7	67.7	68.7	124.7	122	2.7	13	1
13.0	5	▲	MQS1300X5DB	67.7	93.7	94.7	150.7	148	2.7	13	1
13.0	8	▲	MQS1300X8DB	106.7	145.7	145.7	208.7	206	2.7	13	2
13.1	3	▲	MQS1310X3DB	42.0	70.7	72.7	128.7	126	2.7	14	1
13.1	5	▲	MQS1310X5DB	68.2	97.7	100.7	156.7	154	2.7	14	1
13.2	3	▲	MQS1320X3DB	42.3	70.7	72.7	128.7	126	2.7	14	1
13.2	5	▲	MQS1320X5DB	68.7	97.7	100.7	156.7	154	2.7	14	1
13.3	3	▲	MQS1330X3DB	42.7	70.8	72.8	128.8	126	2.8	14	1
13.3	5	▲	MQS1330X5DB	69.3	97.8	100.8	156.8	154	2.8	14	1
13.4	3	▲	MQS1340X3DB	43.0	70.8	72.8	128.8	126	2.8	14	1
13.4	5	▲	MQS1340X5DB	69.8	97.8	100.8	156.8	154	2.8	14	1
13.5	3	▲	MQS1350X3DB	43.3	70.8	72.8	128.8	126	2.8	14	1
13.5	5	▲	MQS1350X5DB	70.3	97.8	100.8	156.8	154	2.8	14	1
13.5	8	▲	MQS1350X8DB	110.8	151.8	156.8	220.8	218	2.8	14	2
13.6	3	▲	MQS1360X3DB	43.6	72.8	72.8	128.8	126	2.8	14	1
13.6	5	▲	MQS1360X5DB	70.8	100.8	100.8	156.8	154	2.8	14	1
13.7	3	▲	MQS1370X3DB	43.9	72.8	72.8	128.8	126	2.8	14	1
13.7	5	▲	MQS1370X5DB	71.3	100.8	100.8	156.8	154	2.8	14	1
13.8	3	▲	MQS1380X3DB	44.3	72.9	72.9	128.9	126	2.9	14	1
13.8	5	▲	MQS1380X5DB	71.9	100.9	100.9	156.9	154	2.9	14	1
13.9	3	▲	MQS1390X3DB	44.6	72.9	72.9	128.9	126	2.9	14	1
13.9	5	▲	MQS1390X5DB	72.4	100.9	100.9	156.9	154	2.9	14	1
14.0	3	▲	MQS1400X3DB	44.9	72.9	72.9	128.9	126	2.9	14	1
14.0	5	▲	MQS1400X5DB	72.9	100.9	100.9	156.9	154	2.9	14	1
14.0	8	▲	MQS1400X8DB	114.9	156.9	156.9	220.9	218	2.9	14	2
14.1	3	▲	MQS1410X3DB	45.2	75.9	78.9	137.9	135	2.9	15	1
14.1	5	▲	MQS1410X5DB	73.4	104.9	108.9	167.9	165	2.9	15	1
14.2	3	▲	MQS1420X3DB	45.5	75.9	78.9	137.9	135	2.9	15	1
14.2	5	▲	MQS1420X5DB	73.9	104.9	108.9	167.9	165	2.9	15	1
14.3	3	▲	MQS1430X3DB	45.9	76.0	79.0	138.0	135	3.0	15	1
14.3	5	▲	MQS1430X5DB	74.5	105.0	109.0	168.0	165	3.0	15	1
14.4	3	▲	MQS1440X3DB	46.2	76.0	79.0	138.0	135	3.0	15	1
14.4	5	▲	MQS1440X5DB	75.0	105.0	109.0	168.0	165	3.0	15	1
14.5	3	▲	MQS1450X3DB	46.5	76.0	79.0	138.0	135	3.0	15	1
14.5	5	▲	MQS1450X5DB	75.5	105.0	109.0	168.0	165	3.0	15	1
14.5	8	▲	MQS1450X8DB	119.0	163.0	168.0	228.0	225	3.0	15	2
14.6	3	▲	MQS1460X3DB	46.8	78.0	79.0	138.0	135	3.0	15	1
14.6	5	▲	MQS1460X5DB	76.0	108.0	109.0	168.0	165	3.0	15	1
14.7	3	▲	MQS1470X3DB	47.1	78.0	79.0	138.0	135	3.0	15	1
14.7	5	▲	MQS1470X5DB	76.5	108.0	109.0	168.0	165	3.0	15	1
14.8	3	▲	MQS1480X3DB	47.5	78.1	79.1	138.1	135	3.1	15	1
14.8	5	▲	MQS1480X5DB	77.1	108.1	109.1	168.1	165	3.1	15	1
14.9	3	▲	MQS1490X3DB	47.8	78.1	79.1	138.1	135	3.1	15	1
14.9	5	▲	MQS1490X5DB	77.6	108.1	109.1	168.1	165	3.1	15	1
15.0	3	▲	MQS1500X3DB	48.1	78.1	79.1	138.1	135	3.1	15	1
15.0	5	▲	MQS1500X5DB	78.1	108.1	109.1	168.1	165	3.1	15	1
15.0	8	▲	MQS1500X8DB	123.1	168.1	168.1	228.1	225	3.1	15	2
15.1	3	▲	MQS1510X3DB	48.4	81.1	83.1	142.1	139	3.1	16	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

□ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
15.1	5	▲	MQS1510X5DB	78.6	112.1	115.1	174.1	171	3.1	16	1
15.2	3	▲	MQS1520X3DB	48.7	81.1	83.1	142.1	139	3.1	16	1
15.2	5	▲	MQS1520X5DB	79.1	112.1	115.1	174.1	171	3.1	16	1
15.3	3	▲	MQS1530X3DB	49.1	81.2	83.2	142.2	139	3.2	16	1
15.3	5	▲	MQS1530X5DB	79.7	112.2	115.2	174.2	171	3.2	16	1
15.4	3	▲	MQS1540X3DB	49.4	81.2	83.2	142.2	139	3.2	16	1
15.4	5	▲	MQS1540X5DB	80.2	112.2	115.2	174.2	171	3.2	16	1
15.5	3	▲	MQS1550X3DB	49.7	81.2	83.2	142.2	139	3.2	16	1
15.5	5	▲	MQS1550X5DB	80.7	112.2	115.2	174.2	171	3.2	16	1
15.5	8	▲	MQS1550X8DB	127.2	174.2	184.2	244.2	241	3.2	16	2
15.6	3	▲	MQS1560X3DB	50.0	83.2	83.2	142.2	139	3.2	16	1
15.6	5	▲	MQS1560X5DB	81.2	115.2	115.2	174.2	171	3.2	16	1
15.7	3	▲	MQS1570X3DB	50.4	83.3	83.3	142.3	139	3.3	16	1
15.7	5	▲	MQS1570X5DB	81.8	115.3	115.3	174.3	171	3.3	16	1
15.8	3	▲	MQS1580X3DB	50.7	83.3	83.3	142.3	139	3.3	16	1
15.8	5	▲	MQS1580X5DB	82.3	115.3	115.3	174.3	171	3.3	16	1
15.9	3	▲	MQS1590X3DB	51.0	83.3	83.3	142.3	139	3.3	16	1
15.9	5	▲	MQS1590X5DB	82.8	115.3	115.3	174.3	171	3.3	16	1
16.0	3	▲	MQS1600X3DB	51.3	83.3	83.3	142.3	139	3.3	16	1
16.0	5	▲	MQS1600X5DB	83.3	115.3	115.3	174.3	171	3.3	16	1
16.0	8	▲	MQS1600X8DB	131.3	179.3	184.3	244.3	241	3.3	16	2
16.1	3	□	MQS1610X3DB	51.6	86.3	89.3	148.3	145	3.3	17	1
16.1	5	□	MQS1610X5DB	83.8	119.3	123.3	182.3	179	3.3	17	1
16.2	3	□	MQS1620X3DB	52.0	86.4	89.4	148.4	145	3.4	17	1
16.2	5	□	MQS1620X5DB	84.4	119.4	123.4	182.4	179	3.4	17	1
16.3	3	□	MQS1630X3DB	52.3	86.4	89.4	148.4	145	3.4	17	1
16.3	5	□	MQS1630X5DB	84.9	119.4	123.4	182.4	179	3.4	17	1
16.4	3	□	MQS1640X3DB	52.6	86.4	89.4	148.4	145	3.4	17	1
16.4	5	□	MQS1640X5DB	85.4	119.4	123.4	182.4	179	3.4	17	1
16.5	3	▲	MQS1650X3DB	52.9	86.4	89.4	148.4	145	3.4	17	1
16.5	5	▲	MQS1650X5DB	85.9	119.4	123.4	182.4	179	3.4	17	1
16.6	3	□	MQS1660X3DB	53.2	88.4	89.4	148.4	145	3.4	17	1
16.6	5	□	MQS1660X5DB	86.4	122.4	123.4	182.4	179	3.4	17	1
16.7	3	□	MQS1670X3DB	53.6	88.5	89.5	148.5	145	3.5	17	1
16.7	5	□	MQS1670X5DB	87.0	122.5	123.5	182.5	179	3.5	17	1
16.8	3	□	MQS1680X3DB	53.9	88.5	89.5	148.5	145	3.5	17	1
16.8	5	□	MQS1680X5DB	87.5	122.5	123.5	182.5	179	3.5	17	1
16.9	3	□	MQS1690X3DB	54.2	88.5	89.5	148.5	145	3.5	17	1
16.9	5	□	MQS1690X5DB	88.0	122.5	123.5	182.5	179	3.5	17	1
17.0	3	▲	MQS1700X3DB	54.5	88.5	89.5	148.5	145	3.5	17	1
17.0	5	▲	MQS1700X5DB	88.5	122.5	123.5	182.5	179	3.5	17	1
17.1	3	□	MQS1710X3DB	54.8	91.5	93.5	152.5	149	3.5	18	1
17.1	5	□	MQS1710X5DB	89.0	126.5	129.5	188.5	185	3.5	18	1
17.2	3	□	MQS1720X3DB	55.2	91.6	93.6	152.6	149	3.6	18	1
17.2	5	□	MQS1720X5DB	89.6	126.6	129.6	188.6	185	3.6	18	1
17.3	3	□	MQS1730X3DB	55.5	91.6	93.6	152.6	149	3.6	18	1
17.3	5	□	MQS1730X5DB	90.1	126.6	129.6	188.6	185	3.6	18	1
17.4	3	□	MQS1740X3DB	55.8	91.6	93.6	152.6	149	3.6	18	1
17.4	5	□	MQS1740X5DB	90.6	126.6	129.6	188.6	185	3.6	18	1
17.5	3	▲	MQS1750X3DB	56.1	91.6	93.6	152.6	149	3.6	18	1
17.5	5	▲	MQS1750X5DB	91.1	126.6	129.6	188.6	185	3.6	18	1

DC (mm)	Hole Depth (L/D)	DP3020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
17.6	3	□	MQS1760X3DB	56.4	93.6	93.6	152.6	149	3.6	18	1
17.6	5	□	MQS1760X5DB	91.6	129.6	129.6	188.6	185	3.6	18	1
17.7	3	□	MQS1770X3DB	56.8	93.7	93.7	152.7	149	3.7	18	1
17.7	5	□	MQS1770X5DB	92.2	129.7	129.7	188.7	185	3.7	18	1
17.8	3	□	MQS1780X3DB	57.1	93.7	93.7	152.7	149	3.7	18	1
17.8	5	□	MQS1780X5DB	92.7	129.7	129.7	188.7	185	3.7	18	1
17.9	3	□	MQS1790X3DB	57.4	93.7	93.7	152.7	149	3.7	18	1
17.9	5	□	MQS1790X5DB	93.2	129.7	129.7	188.7	185	3.7	18	1
18.0	3	▲	MQS1800X3DB	57.7	93.7	93.7	152.7	149	3.7	18	1
18.0	5	▲	MQS1800X5DB	93.7	129.7	129.7	188.7	185	3.7	18	1
18.1	3	□	MQS1810X3DB	58.0	96.7	99.7	160.7	157	3.7	19	1
18.1	5	□	MQS1810X5DB	94.2	133.7	137.7	198.7	195	3.7	19	1
18.2	3	□	MQS1820X3DB	58.4	96.8	99.8	160.8	157	3.8	19	1
18.2	5	□	MQS1820X5DB	94.8	133.8	137.8	198.8	195	3.8	19	1
18.3	3	□	MQS1830X3DB	58.7	96.8	99.8	160.8	157	3.8	19	1
18.3	5	□	MQS1830X5DB	95.3	133.8	137.8	198.8	195	3.8	19	1
18.4	3	□	MQS1840X3DB	59.0	96.8	99.8	160.8	157	3.8	19	1
18.4	5	□	MQS1840X5DB	95.8	133.8	137.8	198.8	195	3.8	19	1
18.5	3	▲	MQS1850X3DB	59.3	96.8	99.8	160.8	157	3.8	19	1
18.5	5	▲	MQS1850X5DB	96.3	133.8	137.8	198.8	195	3.8	19	1
18.6	3	□	MQS1860X3DB	59.7	98.9	99.9	160.9	157	3.9	19	1
18.6	5	□	MQS1860X5DB	96.9	136.9	137.9	198.9	195	3.9	19	1
18.7	3	□	MQS1870X3DB	60.0	98.9	99.9	160.9	157	3.9	19	1
18.7	5	□	MQS1870X5DB	97.4	136.9	137.9	198.9	195	3.9	19	1
18.8	3	□	MQS1880X3DB	60.3	98.9	99.9	160.9	157	3.9	19	1
18.8	5	□	MQS1880X5DB	97.9	136.9	137.9	198.9	195	3.9	19	1
18.9	3	□	MQS1890X3DB	60.6	98.9	99.9	160.9	157	3.9	19	1
18.9	5	□	MQS1890X5DB	98.4	136.9	137.9	198.9	195	3.9	19	1
19.0	3	▲	MQS1900X3DB	60.9	98.9	99.9	160.9	157	3.9	19	1
19.0	5	▲	MQS1900X5DB	98.9	136.9	137.9	198.9	195	3.9	19	1
19.1	3	□	MQS1910X3DB	61.3	102.0	104.0	165.0	161	4.0	20	1
19.1	5	□	MQS1910X5DB	99.5	141.0	144.0	205.0	201	4.0	20	1
19.2	3	□	MQS1920X3DB	61.6	102.0	104.0	165.0	161	4.0	20	1
19.2	5	□	MQS1920X5DB	100.0	141.0	144.0	205.0	201	4.0	20	1
19.3	3	□	MQS1930X3DB	61.9	102.0	104.0	165.0	161	4.0	20	1
19.3	5	□	MQS1930X5DB	100.5	141.0	144.0	205.0	201	4.0	20	1
19.4	3	□	MQS1940X3DB	62.2	102.0	104.0	165.0	161	4.0	20	1
19.4	5	□	MQS1940X5DB	101.0	141.0	144.0	205.0	201	4.0	20	1
19.5	3	▲	MQS1950X3DB	62.5	102.0	104.0	165.0	161	4.0	20	1
19.5	5	▲	MQS1950X5DB	101.5	141.0	144.0	205.0	201	4.0	20	1
19.6	3	□	MQS1960X3DB	62.9	104.1	104.1	165.1	161	4.1	20	1
19.6	5	□	MQS1960X5DB	102.1	144.1	144.1	205.1	201	4.1	20	1
19.7	3	□	MQS1970X3DB	63.2	104.1	104.1	165.1	161	4.1	20	1
19.7	5	□	MQS1970X5DB	102.6	144.1	144.1	205.1	201	4.1	20	1
19.8	3	□	MQS1980X3DB	63.5	104.1	104.1	165.1	161	4.1	20	1
19.8	5	□	MQS1980X5DB	103.1	144.1	144.1	205.1	201	4.1	20	1
19.9	3	□	MQS1990X3DB	63.8	104.1	104.1	165.1	161	4.1	20	1
19.9	5	□	MQS1990X5DB	103.6	144.1	144.1	205.1	201	4.1	20	1
20.0	3	▲	MQS2000X3DB	64.1	104.1	104.1	165.1	161	4.1	20	1
20.0	5	▲	MQS2000X5DB	104.1	144.1	144.1	205.1	201	4.1	20	1

CUTTING CONDITIONS ➤ P054
OPERATION GUIDANCE ➤ P056
TECHNICAL DATA ➤ R001

MQS
WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

Internal Coolant

Work Material	Mild Steel (≤180HB) AISI 1010 etc					Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)
3.2	130	12900	0.15	(0.10−0.20)	1935	100	9900	0.15	(0.10−0.20)	1485
4.0	130	10300	0.2	(0.15−0.25)	2060	100	7900	0.2	(0.15−0.25)	1580
5.0	130	8200	0.2	(0.15−0.25)	1640	100	6300	0.2	(0.15−0.25)	1260
6.3	140	7000	0.25	(0.20−0.30)	1750	130	6500	0.25	(0.20−0.30)	1625
8.0	140	5500	0.25	(0.20−0.30)	1375	130	5100	0.25	(0.20−0.30)	1275
10.0	140	4400	0.27	(0.22−0.32)	1185	130	4100	0.27	(0.22−0.32)	1105
12.0	160	4200	0.3	(0.26−0.35)	1260	140	3700	0.3	(0.26−0.35)	1110
16.0	180	3500	0.33	(0.27−0.38)	1155	150	2900	0.33	(0.27−0.38)	955
20.0	180	2800	0.35	(0.30−0.40)	980	150	2300	0.35	(0.30−0.40)	805

Work Material	Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc					Gray Cast Iron (≤350MPa) No 45 B etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)
3.2	70	6900	0.1	(0.06−0.15)	690	110	10900	0.28	(0.15−0.35)	3050
4.0	80	6300	0.11	(0.07−0.15)	690	110	8700	0.28	(0.15−0.35)	2435
5.0	80	5000	0.14	(0.09−0.18)	700	110	7000	0.3	(0.15−0.40)	2100
6.3	90	4500	0.18	(0.11−0.24)	810	120	6000	0.33	(0.20−0.45)	1980
8.0	100	3900	0.21	(0.16−0.25)	815	120	4700	0.35	(0.20−0.45)	1645
10.0	110	3500	0.23	(0.19−0.27)	805	130	4100	0.4	(0.22−0.45)	1640
12.0	120	3100	0.26	(0.22−0.30)	805	150	3900	0.45	(0.26−0.50)	1755
16.0	130	2500	0.28	(0.23−0.33)	700	160	3100	0.5	(0.28−0.60)	1550
20.0	130	2000	0.3	(0.26−0.35)	600	160	2500	0.5	(0.30−0.60)	1250

Work Material	Ductile Cast Iron (≤450MPa) 60-40-8 etc					Ductile Cast Iron (≤800MPa) 100-70-03 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)
3.2	90	8900	0.25	(0.15−0.32)	2225	75	7400	0.1	(0.06−0.15)	740
4.0	90	7100	0.25	(0.15−0.32)	1775	75	5900	0.1	(0.06−0.15)	590
5.0	90	5700	0.25	(0.15−0.32)	1425	75	4700	0.1	(0.06−0.15)	470
6.3	100	5000	0.3	(0.20−0.38)	1500	85	4200	0.15	(0.10−0.20)	630
8.0	100	3900	0.3	(0.20−0.38)	1170	85	3300	0.2	(0.10−0.25)	660
10.0	100	3100	0.3	(0.22−0.38)	930	85	2700	0.2	(0.10−0.25)	540
12.0	110	2900	0.35	(0.26−0.40)	1015	95	2500	0.25	(0.20−0.30)	625
16.0	120	2300	0.35	(0.28−0.40)	805	110	2100	0.25	(0.20−0.30)	525
20.0	120	1900	0.35	(0.30−0.40)	665	110	1700	0.3	(0.20−0.35)	510

Note 1) Spindle through & high pressure coolant system is recommended to make stable holes.
Note 2) Emulsion type of water coolant is recommended.

■ M.Q.L.

Work Material	Mild Steel (≤180HB) AISI 1010 etc					Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	100	9900	0.15	(0.10−0.20)	1485	80	7900	0.15	(0.10−0.20)	1185
4.0	100	7900	0.2	(0.15−0.25)	1580	80	6300	0.2	(0.15−0.25)	1260
5.0	100	6300	0.2	(0.15−0.25)	1260	80	5000	0.2	(0.15−0.25)	1000
6.3	110	5500	0.25	(0.20−0.30)	1375	100	5000	0.25	(0.20−0.30)	1250
8.0	110	4300	0.25	(0.20−0.30)	1075	100	3900	0.25	(0.20−0.30)	975
10.0	110	3500	0.27	(0.22−0.32)	945	100	3100	0.27	(0.22−0.32)	835
12.0	130	3400	0.3	(0.26−0.35)	1020	110	2900	0.3	(0.26−0.35)	870
16.0	140	2700	0.33	(0.27−0.38)	890	120	2300	0.33	(0.27−0.38)	755
20.0	140	2200	0.35	(0.30−0.40)	770	120	1900	0.35	(0.30−0.40)	665

Work Material	Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc					Gray Cast Iron (≤350MPa) No 45 B etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	60	5900	0.1	(0.06−0.15)	590	90	8900	0.28	(0.15−0.35)	2490
4.0	60	4700	0.11	(0.07−0.15)	515	90	7100	0.28	(0.15−0.35)	1985
5.0	60	3800	0.14	(0.09−0.18)	530	90	5700	0.3	(0.15−0.40)	1710
6.3	60	3000	0.18	(0.11−0.24)	540	100	5000	0.33	(0.20−0.45)	1650
8.0	60	2300	0.21	(0.16−0.25)	480	100	3900	0.35	(0.20−0.45)	1365
10.0	60	1900	0.23	(0.19−0.27)	435	100	3100	0.4	(0.22−0.45)	1240
12.0	80	2100	0.26	(0.22−0.30)	545	120	3100	0.45	(0.26−0.50)	1395
16.0	80	1500	0.28	(0.23−0.33)	420	130	2500	0.5	(0.28−0.60)	1250
20.0	80	1200	0.3	(0.26−0.35)	360	130	2000	0.5	(0.30−0.60)	1000

Work Material	Ductile Cast Iron (≤450MPa) 60-40-8 etc					Ductile Cast Iron (≤800MPa) 100-70-03 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	70	6900	0.25	(0.15−0.32)	1725	60	5900	0.1	(0.06−0.15)	590
4.0	70	5500	0.25	(0.15−0.32)	1375	60	4700	0.1	(0.06−0.15)	470
5.0	70	4400	0.25	(0.15−0.32)	1100	60	3800	0.1	(0.06−0.15)	380
6.3	80	4000	0.3	(0.20−0.38)	1200	70	3500	0.15	(0.10−0.20)	525
8.0	80	3100	0.3	(0.20−0.38)	930	70	2700	0.2	(0.10−0.25)	540
10.0	80	2500	0.3	(0.22−0.38)	750	70	2200	0.2	(0.10−0.25)	440
12.0	90	2300	0.35	(0.26−0.40)	805	80	2100	0.25	(0.20−0.30)	525
16.0	100	1900	0.35	(0.28−0.40)	665	90	1700	0.25	(0.20−0.30)	425
20.0	100	1500	0.35	(0.30−0.40)	525	90	1400	0.3	(0.20−0.35)	420

MQS
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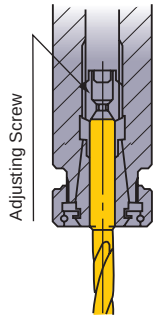
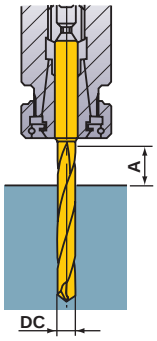
■ Operation Guidance for....X3DB....X5DB and....X8DB

Drill Holding



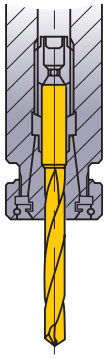
Thrust bearing type collet chuck holds the drill securely.

Drill Length



A ≥ DC x 1.5

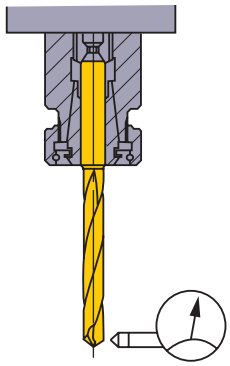
Drill Installation



NG

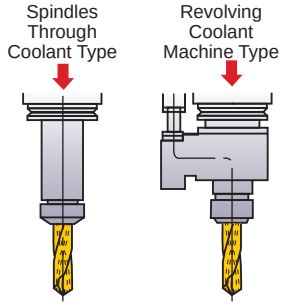
Do not clamp on the flutes.

Installation Tolerance



Run-out ≤ 0.03mm

Through Coolant Type (MQS)



Coolant pressure is approx. 0.5MPa–7MPa

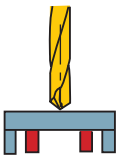
Coolant Handling

<MQS Type>

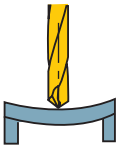
1) Small particles of swarf will jam in the oil hole of small diameter drills. Always use a fine mesh filter as a preventative measure.

2) Dirt and dust particles adhere to the oil in old coolant and prevent an efficient flow. Regular coolant exchange is recommended.

Thin Workpiece

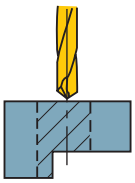


OK
Support the Workpiece

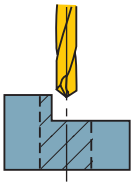


NG
If Bending Occurs

Interrupted Cutting

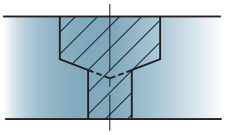


One Process
OK
①Lower the feed when drilling the interrupted part.



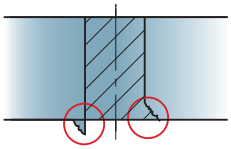
Requires Prior Machining
①Spot face with an end mill prior to drilling.

Stepped Holes



①Divide the two processes.
②Drill the larger hole first.
*A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping



①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

MMS
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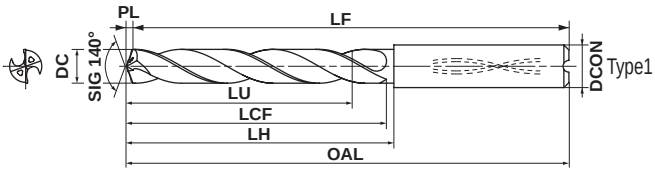
●Long tool life and high efficiency drilling for stainless steel.

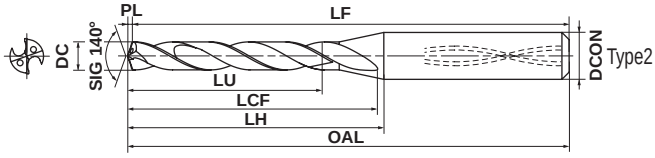
TOOL NEWS

P | **M** | K | N | S | H

Stainless Steel

Internal Coolant





*When looking at the coating the color can vary depending on the direction of viewing. This does not have any effect on the performance of the drill.

	DC=3	3<DC≦6	6<DC≦10	10<DC≦18	18<DC≦20
	0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033
h6		3<DCON≦6	6<DCON≦10	10<DCON≦18	18<DCON≦20
		0 −0.008	0 −0.009	0 −0.011	0 −0.013

Note 1) MMS drills are suitable for use with shrink fit holders.

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.0	3	●	MMS0300X3DB	9.5	21.5	23.5	70.5	70	0.5	6	2
3.0	5	●	MMS0300X5DB	15.5	28.5	31.5	78.5	78	0.5	6	2
3.1	3	●	MMS0310X3DB	9.9	21.6	23.6	70.6	70	0.6	6	2
3.1	5	●	MMS0310X5DB	16.1	28.6	31.6	78.6	78	0.6	6	2
3.2	3	●	MMS0320X3DB	10.2	21.6	23.6	70.6	70	0.6	6	2
3.2	5	●	MMS0320X5DB	16.6	28.6	31.6	78.6	78	0.6	6	2
3.3	3	●	MMS0330X3DB	10.5	21.6	23.6	70.6	70	0.6	6	2
3.3	5	●	MMS0330X5DB	17.1	28.6	31.6	78.6	78	0.6	6	2
3.4	3	●	MMS0340X3DB	10.8	21.6	23.6	70.6	70	0.6	6	2
3.4	5	●	MMS0340X5DB	17.6	28.6	31.6	78.6	78	0.6	6	2
3.5	3	●	MMS0350X3DB	11.1	21.6	23.6	70.6	70	0.6	6	2
3.5	5	●	MMS0350X5DB	18.1	28.6	31.6	78.6	78	0.6	6	2
3.6	3	●	MMS0360X3DB	11.5	22.7	23.7	70.7	70	0.7	6	2
3.6	5	●	MMS0360X5DB	18.7	30.7	31.7	78.7	78	0.7	6	2
3.7	3	●	MMS0370X3DB	11.8	22.7	23.7	70.7	70	0.7	6	2
3.7	5	●	MMS0370X5DB	19.2	30.7	31.7	78.7	78	0.7	6	2
3.8	3	●	MMS0380X3DB	12.1	22.7	23.7	70.7	70	0.7	6	2
3.8	5	●	MMS0380X5DB	19.7	30.7	31.7	78.7	78	0.7	6	2
3.9	3	●	MMS0390X3DB	12.4	22.7	23.7	70.7	70	0.7	6	2
3.9	5	●	MMS0390X5DB	20.2	30.7	31.7	78.7	78	0.7	6	2
4.0	3	●	MMS0400X3DB	12.7	22.7	23.7	70.7	70	0.7	6	2
4.0	5	●	MMS0400X5DB	20.7	30.7	31.7	78.7	78	0.7	6	2
4.1	3	●	MMS0410X3DB	13.0	24.7	26.7	73.7	73	0.7	6	2
4.1	5	●	MMS0410X5DB	21.2	33.7	35.7	82.7	82	0.7	6	2
4.2	3	●	MMS0420X3DB	13.4	24.8	26.8	73.8	73	0.8	6	2
4.2	5	●	MMS0420X5DB	21.8	33.8	35.8	82.8	82	0.8	6	2
4.3	3	●	MMS0430X3DB	13.7	24.8	26.8	73.8	73	0.8	6	2
4.3	5	●	MMS0430X5DB	22.3	33.8	35.8	82.8	82	0.8	6	2
4.4	3	●	MMS0440X3DB	14.0	24.8	26.8	73.8	73	0.8	6	2
4.4	5	●	MMS0440X5DB	22.8	33.8	35.8	82.8	82	0.8	6	2
4.5	3	●	MMS0450X3DB	14.3	24.8	26.8	73.8	73	0.8	6	2
4.5	5	●	MMS0450X5DB	23.3	33.8	35.8	82.8	82	0.8	6	2
4.6	3	●	MMS0460X3DB	14.6	25.8	28.8	75.8	75	0.8	6	1
4.6	5	●	MMS0460X5DB	23.8	35.8	38.8	85.8	85	0.8	6	1
4.7	3	●	MMS0470X3DB	15.0	25.9	28.9	75.9	75	0.9	6	1
4.7	5	●	MMS0470X5DB	24.4	35.9	38.9	85.9	85	0.9	6	1

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.8	3	●	MMS0480X3DB	15.3	25.9	28.9	75.9	75	0.9	6	1
4.8	5	●	MMS0480X5DB	24.9	35.9	38.9	85.9	85	0.9	6	1
4.9	3	●	MMS0490X3DB	15.6	25.9	28.9	75.9	75	0.9	6	1
4.9	5	●	MMS0490X5DB	25.4	35.9	38.9	85.9	85	0.9	6	1
5.0	3	●	MMS0500X3DB	15.9	25.9	28.9	75.9	75	0.9	6	1
5.0	5	●	MMS0500X5DB	25.9	35.9	38.9	85.9	85	0.9	6	1
5.1	3	●	MMS0510X3DB	16.2	28.9	30.9	81.9	81	0.9	6	1
5.1	5	●	MMS0510X5DB	26.4	39.9	42.9	89.9	89	0.9	6	1
5.2	3	●	MMS0520X3DB	16.5	28.9	30.9	81.9	81	0.9	6	1
5.2	5	●	MMS0520X5DB	26.9	39.9	42.9	89.9	89	0.9	6	1
5.3	3	●	MMS0530X3DB	16.9	29.0	31.0	82.0	81	1.0	6	1
5.3	5	●	MMS0530X5DB	27.5	40.0	43.0	90.0	89	1.0	6	1
5.4	3	●	MMS0540X3DB	17.2	29.0	31.0	82.0	81	1.0	6	1
5.4	5	●	MMS0540X5DB	28.0	40.0	43.0	90.0	89	1.0	6	1
5.5	3	●	MMS0550X3DB	17.5	29.0	31.0	82.0	81	1.0	6	1
5.5	5	●	MMS0550X5DB	28.5	40.0	43.0	90.0	89	1.0	6	1
5.6	3	●	MMS0560X3DB	17.8	31.0	31.0	82.0	81	1.0	6	1
5.6	5	●	MMS0560X5DB	29.0	43.0	43.0	90.0	89	1.0	6	1
5.7	3	●	MMS0570X3DB	18.1	31.0	31.0	82.0	81	1.0	6	1
5.7	5	●	MMS0570X5DB	29.5	43.0	43.0	90.0	89	1.0	6	1
5.8	3	●	MMS0580X3DB	18.5	31.1	31.1	82.1	81	1.1	6	1
5.8	5	●	MMS0580X5DB	30.1	43.1	43.1	90.1	89	1.1	6	1
5.9	3	●	MMS0590X3DB	18.8	31.1	31.1	82.1	81	1.1	6	1
5.9	5	●	MMS0590X5DB	30.6	43.1	43.1	90.1	89	1.1	6	1
6.0	3	●	MMS0600X3DB	19.1	31.1	31.1	82.1	81	1.1	6	1
6.0	5	●	MMS0600X5DB	31.1	43.1	43.1	90.1	89	1.1	6	1
6.1	3	●	MMS0610X3DB	19.4	34.1	36.1	87.1	86	1.1	8	1
6.1	5	●	MMS0610X5DB	31.6	47.1	49.1	96.1	95	1.1	8	1
6.2	3	●	MMS0620X3DB	19.7	34.1	36.1	87.1	86	1.1	8	1
6.2	5	●	MMS0620X5DB	32.1	47.1	49.1	96.1	95	1.1	8	1
6.3	3	●	MMS0630X3DB	20.0	34.1	36.1	87.1	86	1.1	8	1
6.3	5	●	MMS0630X5DB	32.6	47.1	49.1	96.1	95	1.1	8	1
6.4	3	●	MMS0640X3DB	20.4	34.2	36.2	87.2	86	1.2	8	1
6.4	5	●	MMS0640X5DB	33.2	47.2	49.2	96.2	95	1.2	8	1
6.5	3	●	MMS0650X3DB	20.7	34.2	36.2	87.2	86	1.2	8	1
6.5	5	●	MMS0650X5DB	33.7	47.2	49.2	96.2	95	1.2	8	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

Note 2) The coolant hole of ø6mm or less will be round shape.

● : **Inventory maintained in Japan.**

MMS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.6	3	●	MMS0660X3DB	21.0	36.2	38.2	91.2	90	1.2	8	1
6.6	5	●	MMS0660X5DB	34.2	50.2	52.2	99.2	98	1.2	8	1
6.7	3	●	MMS0670X3DB	21.3	36.2	38.2	91.2	90	1.2	8	1
6.7	5	●	MMS0670X5DB	34.7	50.2	52.2	99.2	98	1.2	8	1
6.8	3	●	MMS0680X3DB	21.6	36.2	38.2	91.2	90	1.2	8	1
6.8	5	●	MMS0680X5DB	35.2	50.2	52.2	99.2	98	1.2	8	1
6.9	3	●	MMS0690X3DB	22.0	36.3	38.3	91.3	90	1.3	8	1
6.9	5	●	MMS0690X5DB	35.8	50.3	52.3	99.3	98	1.3	8	1
7.0	3	●	MMS0700X3DB	22.3	36.3	38.3	91.3	90	1.3	8	1
7.0	5	●	MMS0700X5DB	36.3	50.3	52.3	99.3	98	1.3	8	1
7.1	3	●	MMS0710X3DB	22.6	39.3	40.3	91.3	90	1.3	8	1
7.1	5	●	MMS0710X5DB	36.8	54.3	57.3	104.3	103	1.3	8	1
7.2	3	●	MMS0720X3DB	22.9	39.3	40.3	91.3	90	1.3	8	1
7.2	5	●	MMS0720X5DB	37.3	54.3	57.3	104.3	103	1.3	8	1
7.3	3	●	MMS0730X3DB	23.2	39.3	40.3	91.3	90	1.3	8	1
7.3	5	●	MMS0730X5DB	37.8	54.3	57.3	104.3	103	1.3	8	1
7.4	3	●	MMS0740X3DB	23.5	39.3	40.3	91.3	90	1.3	8	1
7.4	5	●	MMS0740X5DB	38.3	54.3	57.3	104.3	103	1.3	8	1
7.5	3	●	MMS0750X3DB	23.9	39.4	40.4	91.4	90	1.4	8	1
7.5	5	●	MMS0750X5DB	38.9	54.4	57.4	104.4	103	1.4	8	1
7.6	3	●	MMS0760X3DB	24.2	41.4	41.4	91.4	90	1.4	8	1
7.6	5	●	MMS0760X5DB	39.4	57.4	57.4	104.4	103	1.4	8	1
7.7	3	●	MMS0770X3DB	24.5	41.4	41.4	91.4	90	1.4	8	1
7.7	5	●	MMS0770X5DB	39.9	57.4	57.4	104.4	103	1.4	8	1
7.8	3	●	MMS0780X3DB	24.8	41.4	41.4	91.4	90	1.4	8	1
7.8	5	●	MMS0780X5DB	40.4	57.4	57.4	104.4	103	1.4	8	1
7.9	3	●	MMS0790X3DB	25.1	41.4	41.4	91.4	90	1.4	8	1
7.9	5	●	MMS0790X5DB	40.9	57.4	57.4	104.4	103	1.4	8	1
8.0	3	●	MMS0800X3DB	25.5	41.5	41.5	91.5	90	1.5	8	1
8.0	5	●	MMS0800X5DB	41.5	57.5	57.5	104.5	103	1.5	8	1
8.1	3	●	MMS0810X3DB	25.8	44.5	46.5	97.5	96	1.5	10	1
8.1	5	●	MMS0810X5DB	42.0	61.5	63.5	114.5	113	1.5	10	1
8.2	3	●	MMS0820X3DB	26.1	44.5	46.5	97.5	96	1.5	10	1
8.2	5	●	MMS0820X5DB	42.5	61.5	63.5	114.5	113	1.5	10	1
8.3	3	●	MMS0830X3DB	26.4	44.5	46.5	97.5	96	1.5	10	1
8.3	5	●	MMS0830X5DB	43.0	61.5	63.5	114.5	113	1.5	10	1
8.4	3	●	MMS0840X3DB	26.7	44.5	46.5	97.5	96	1.5	10	1
8.4	5	●	MMS0840X5DB	43.5	61.5	63.5	114.5	113	1.5	10	1
8.5	3	●	MMS0850X3DB	27.0	44.5	46.5	97.5	96	1.5	10	1
8.5	5	●	MMS0850X5DB	44.0	61.5	63.5	114.5	113	1.5	10	1
8.6	3	●	MMS0860X3DB	27.4	46.6	48.6	102.6	101	1.6	10	1
8.6	5	●	MMS0860X5DB	44.6	64.6	66.6	117.6	116	1.6	10	1
8.7	3	●	MMS0870X3DB	27.7	46.6	48.6	102.6	101	1.6	10	1
8.7	5	●	MMS0870X5DB	45.1	64.6	66.6	117.6	116	1.6	10	1
8.8	3	●	MMS0880X3DB	28.0	46.6	48.6	102.6	101	1.6	10	1
8.8	5	●	MMS0880X5DB	45.6	64.6	66.6	117.6	116	1.6	10	1
8.9	3	●	MMS0890X3DB	28.3	46.6	48.6	102.6	101	1.6	10	1
8.9	5	●	MMS0890X5DB	46.1	64.6	66.6	117.6	116	1.6	10	1

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.0	3	●	MMS0900X3DB	28.6	46.6	48.6	102.6	101	1.6	10	1
9.0	5	●	MMS0900X5DB	46.6	64.6	66.6	117.6	116	1.6	10	1
9.1	3	●	MMS0910X3DB	29.0	49.7	51.7	102.7	101	1.7	10	1
9.1	5	●	MMS0910X5DB	47.2	68.7	71.7	122.7	121	1.7	10	1
9.2	3	●	MMS0920X3DB	29.3	49.7	51.7	102.7	101	1.7	10	1
9.2	5	●	MMS0920X5DB	47.7	68.7	71.7	122.7	121	1.7	10	1
9.3	3	●	MMS0930X3DB	29.6	49.7	51.7	102.7	101	1.7	10	1
9.3	5	●	MMS0930X5DB	48.2	68.7	71.7	122.7	121	1.7	10	1
9.4	3	●	MMS0940X3DB	29.9	49.7	51.7	102.7	101	1.7	10	1
9.4	5	●	MMS0940X5DB	48.7	68.7	71.7	122.7	121	1.7	10	1
9.5	3	●	MMS0950X3DB	30.2	49.7	51.7	102.7	101	1.7	10	1
9.5	5	●	MMS0950X5DB	49.2	68.7	71.7	122.7	121	1.7	10	1
9.6	3	●	MMS0960X3DB	30.5	51.7	51.7	102.7	101	1.7	10	1
9.6	5	●	MMS0960X5DB	49.7	71.7	71.7	122.7	121	1.7	10	1
9.7	3	●	MMS0970X3DB	30.9	51.8	51.8	102.8	101	1.8	10	1
9.7	5	●	MMS0970X5DB	50.3	71.8	71.8	122.8	121	1.8	10	1
9.8	3	●	MMS0980X3DB	31.2	51.8	51.8	102.8	101	1.8	10	1
9.8	5	●	MMS0980X5DB	50.8	71.8	71.8	122.8	121	1.8	10	1
9.9	3	●	MMS0990X3DB	31.5	51.8	51.8	102.8	101	1.8	10	1
9.9	5	●	MMS0990X5DB	51.3	71.8	71.8	122.8	121	1.8	10	1
10.0	3	●	MMS1000X3DB	31.8	51.8	51.8	102.8	101	1.8	10	1
10.0	5	●	MMS1000X5DB	51.8	71.8	71.8	122.8	121	1.8	10	1
10.1	3	●	MMS1010X3DB	32.1	54.8	56.8	112.8	111	1.8	12	1
10.1	5	●	MMS1010X5DB	52.3	75.8	79.8	135.8	134	1.8	12	1
10.2	3	●	MMS1020X3DB	32.5	54.9	56.9	112.9	111	1.9	12	1
10.2	5	●	MMS1020X5DB	52.9	75.9	79.9	135.9	134	1.9	12	1
10.3	3	●	MMS1030X3DB	32.8	54.9	56.9	112.9	111	1.9	12	1
10.3	5	●	MMS1030X5DB	53.4	75.9	79.9	135.9	134	1.9	12	1
10.4	3	●	MMS1040X3DB	33.1	54.9	56.9	112.9	111	1.9	12	1
10.4	5	●	MMS1040X5DB	53.9	75.9	79.9	135.9	134	1.9	12	1
10.5	3	●	MMS1050X3DB	33.4	54.9	56.9	112.9	111	1.9	12	1
10.5	5	●	MMS1050X5DB	54.4	75.9	79.9	135.9	134	1.9	12	1
10.6	3	●	MMS1060X3DB	33.7	56.9	57.9	117.9	116	1.9	12	1
10.6	5	●	MMS1060X5DB	54.9	78.9	79.9	135.9	134	1.9	12	1
10.7	3	●	MMS1070X3DB	34.0	56.9	57.9	117.9	116	1.9	12	1
10.7	5	●	MMS1070X5DB	55.4	78.9	79.9	135.9	134	1.9	12	1
10.8	3	●	MMS1080X3DB	34.4	57.0	58.0	118.0	116	2.0	12	1
10.8	5	●	MMS1080X5DB	56.0	79.0	80.0	136.0	134	2.0	12	1
10.9	3	●	MMS1090X3DB	34.7	57.0	58.0	118.0	116	2.0	12	1
10.9	5	●	MMS1090X5DB	56.5	79.0	80.0	136.0	134	2.0	12	1
11.0	3	●	MMS1100X3DB	35.0	57.0	58.0	118.0	116	2.0	12	1
11.0	5	●	MMS1100X5DB	57.0	79.0	80.0	136.0	134	2.0	12	1
11.1	3	●	MMS1110X3DB	35.3	60.0	62.0	118.0	116	2.0	12	1
11.1	5	●	MMS1110X5DB	57.5	83.0	86.0	142.0	140	2.0	12	1
11.2	3	●	MMS1120X3DB	35.6	60.0	62.0	118.0	116	2.0	12	1
11.2	5	●	MMS1120X5DB	58.0	83.0	86.0	142.0	140	2.0	12	1
11.3	3	●	MMS1130X3DB	36.0	60.1	62.1	118.1	116	2.1	12	1
11.3	5	●	MMS1130X5DB	58.6	83.1	86.1	142.1	140	2.1	12	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.4	3	●	MMS1140X3DB	36.3	60.1	62.1	118.1	116	2.1	12	1
11.4	5	●	MMS1140X5DB	59.1	83.1	86.1	142.1	140	2.1	12	1
11.5	3	●	MMS1150X3DB	36.6	60.1	62.1	118.1	116	2.1	12	1
11.5	5	●	MMS1150X5DB	59.6	83.1	86.1	142.1	140	2.1	12	1
11.6	3	●	MMS1160X3DB	36.9	62.1	62.1	118.1	116	2.1	12	1
11.6	5	●	MMS1160X5DB	60.1	86.1	86.1	142.1	140	2.1	12	1
11.7	3	●	MMS1170X3DB	37.2	62.1	62.1	118.1	116	2.1	12	1
11.7	5	●	MMS1170X5DB	60.6	86.1	86.1	142.1	140	2.1	12	1
11.8	3	●	MMS1180X3DB	37.5	62.1	62.1	118.1	116	2.1	12	1
11.8	5	●	MMS1180X5DB	61.1	86.1	86.1	142.1	140	2.1	12	1
11.9	3	●	MMS1190X3DB	37.9	62.2	62.2	118.2	116	2.2	12	1
11.9	5	●	MMS1190X5DB	61.7	86.2	86.2	142.2	140	2.2	12	1
12.0	3	●	MMS1200X3DB	38.2	62.2	62.2	118.2	116	2.2	12	1
12.0	5	●	MMS1200X5DB	62.2	86.2	86.2	142.2	140	2.2	12	1
12.1	3	●	MMS1210X3DB	38.5	65.2	68.2	124.2	122	2.2	14	1
12.1	5	●	MMS1210X5DB	62.7	90.2	94.2	150.2	148	2.2	14	1
12.2	3	●	MMS1220X3DB	38.8	65.2	68.2	124.2	122	2.2	14	1
12.2	5	●	MMS1220X5DB	63.2	90.2	94.2	150.2	148	2.2	14	1
12.3	3	●	MMS1230X3DB	39.1	65.2	68.2	124.2	122	2.2	14	1
12.3	5	●	MMS1230X5DB	63.7	90.2	94.2	150.2	148	2.2	14	1
12.4	3	●	MMS1240X3DB	39.5	65.3	68.3	124.3	122	2.3	14	1
12.4	5	●	MMS1240X5DB	64.3	90.3	94.3	150.3	148	2.3	14	1
12.5	3	●	MMS1250X3DB	39.8	65.3	68.3	124.3	122	2.3	14	1
12.5	5	●	MMS1250X5DB	64.8	90.3	94.3	150.3	148	2.3	14	1
12.6	3	●	MMS1260X3DB	40.1	67.3	68.3	124.3	122	2.3	14	1
12.6	5	●	MMS1260X5DB	65.3	93.3	94.3	150.3	148	2.3	14	1
12.7	3	●	MMS1270X3DB	40.4	67.3	68.3	124.3	122	2.3	14	1
12.7	5	●	MMS1270X5DB	65.8	93.3	94.3	150.3	148	2.3	14	1
12.8	3	●	MMS1280X3DB	40.7	67.3	68.3	124.3	122	2.3	14	1
12.8	5	●	MMS1280X5DB	66.3	93.3	94.3	150.3	148	2.3	14	1
12.9	3	●	MMS1290X3DB	41.0	67.3	68.3	124.3	122	2.3	14	1
12.9	5	●	MMS1290X5DB	66.8	93.3	94.3	150.3	148	2.3	14	1
13.0	3	●	MMS1300X3DB	41.4	67.4	68.4	124.4	122	2.4	14	1
13.0	5	●	MMS1300X5DB	67.4	93.4	94.4	150.4	148	2.4	14	1
13.1	3	●	MMS1310X3DB	41.7	70.4	72.4	128.4	126	2.4	14	1
13.1	5	●	MMS1310X5DB	67.9	97.4	100.4	156.4	154	2.4	14	1
13.2	3	●	MMS1320X3DB	42.0	70.4	72.4	128.4	126	2.4	14	1
13.2	5	●	MMS1320X5DB	68.4	97.4	100.4	156.4	154	2.4	14	1
13.3	3	●	MMS1330X3DB	42.3	70.4	72.4	128.4	126	2.4	14	1
13.3	5	●	MMS1330X5DB	68.9	97.4	100.4	156.4	154	2.4	14	1
13.4	3	●	MMS1340X3DB	42.6	70.4	72.4	128.4	126	2.4	14	1
13.4	5	●	MMS1340X5DB	69.4	97.4	100.4	156.4	154	2.4	14	1
13.5	3	●	MMS1350X3DB	43.0	70.5	72.5	128.5	126	2.5	14	1
13.5	5	●	MMS1350X5DB	70.0	97.5	100.5	156.5	154	2.5	14	1
13.6	3	●	MMS1360X3DB	43.3	72.5	72.5	128.5	126	2.5	14	1
13.6	5	●	MMS1360X5DB	70.5	100.5	100.5	156.5	154	2.5	14	1
13.7	3	●	MMS1370X3DB	43.6	72.5	72.5	128.5	126	2.5	14	1
13.7	5	●	MMS1370X5DB	71.0	100.5	100.5	156.5	154	2.5	14	1

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
13.8	3	●	MMS1380X3DB	43.9	72.5	72.5	128.5	126	2.5	14	1
13.8	5	●	MMS1380X5DB	71.5	100.5	100.5	156.5	154	2.5	14	1
13.9	3	●	MMS1390X3DB	44.2	72.5	72.5	128.5	126	2.5	14	1
13.9	5	●	MMS1390X5DB	72.0	100.5	100.5	156.5	154	2.5	14	1
14.0	3	●	MMS1400X3DB	44.5	72.5	72.5	128.5	126	2.5	14	1
14.0	5	●	MMS1400X5DB	72.5	100.5	100.5	156.5	154	2.5	14	1
14.1	3	●	MMS1410X3DB	44.9	75.6	78.6	137.6	135	2.6	16	1
14.1	5	●	MMS1410X5DB	73.1	104.6	108.6	167.6	165	2.6	16	1
14.2	3	●	MMS1420X3DB	45.2	75.6	78.6	137.6	135	2.6	16	1
14.2	5	●	MMS1420X5DB	73.6	104.6	108.6	167.6	165	2.6	16	1
14.3	3	●	MMS1430X3DB	45.5	75.6	78.6	137.6	135	2.6	16	1
14.3	5	●	MMS1430X5DB	74.1	104.6	108.6	167.6	165	2.6	16	1
14.4	3	●	MMS1440X3DB	45.8	75.6	78.6	137.6	135	2.6	16	1
14.4	5	●	MMS1440X5DB	74.6	104.6	108.6	167.6	165	2.6	16	1
14.5	3	●	MMS1450X3DB	46.1	75.6	78.6	137.6	135	2.6	16	1
14.5	5	●	MMS1450X5DB	75.1	104.6	108.6	167.6	165	2.6	16	1
14.6	3	●	MMS1460X3DB	46.5	77.7	78.7	137.7	135	2.7	16	1
14.6	5	●	MMS1460X5DB	75.7	107.7	108.7	167.7	165	2.7	16	1
14.7	3	●	MMS1470X3DB	46.8	77.7	78.7	137.7	135	2.7	16	1
14.7	5	●	MMS1470X5DB	76.2	107.7	108.7	167.7	165	2.7	16	1
14.8	3	●	MMS1480X3DB	47.1	77.7	78.7	137.7	135	2.7	16	1
14.8	5	●	MMS1480X5DB	76.7	107.7	108.7	167.7	165	2.7	16	1
14.9	3	●	MMS1490X3DB	47.4	77.7	78.7	137.7	135	2.7	16	1
14.9	5	●	MMS1490X5DB	77.2	107.7	108.7	167.7	165	2.7	16	1
15.0	3	●	MMS1500X3DB	47.7	77.7	78.7	137.7	135	2.7	16	1
15.0	5	●	MMS1500X5DB	77.7	107.7	108.7	167.7	165	2.7	16	1
15.1	3	●	MMS1510X3DB	48.0	80.7	82.7	141.7	139	2.7	16	1
15.1	5	●	MMS1510X5DB	78.2	111.7	114.7	173.7	171	2.7	16	1
15.2	3	●	MMS1520X3DB	48.4	80.8	82.8	141.8	139	2.8	16	1
15.2	5	●	MMS1520X5DB	78.8	111.8	114.8	173.8	171	2.8	16	1
15.3	3	●	MMS1530X3DB	48.7	80.8	82.8	141.8	139	2.8	16	1
15.3	5	●	MMS1530X5DB	79.3	111.8	114.8	173.8	171	2.8	16	1
15.4	3	●	MMS1540X3DB	49.0	80.8	82.8	141.8	139	2.8	16	1
15.4	5	●	MMS1540X5DB	79.8	111.8	114.8	173.8	171	2.8	16	1
15.5	3	●	MMS1550X3DB	49.3	80.8	82.8	141.8	139	2.8	16	1
15.5	5	●	MMS1550X5DB	80.3	111.8	114.8	173.8	171	2.8	16	1
15.6	3	●	MMS1560X3DB	49.6	82.8	82.8	141.8	139	2.8	16	1
15.6	5	●	MMS1560X5DB	80.8	114.8	114.8	173.8	171	2.8	16	1
15.7	3	●	MMS1570X3DB	50.0	82.9	82.9	141.9	139	2.9	16	1
15.7	5	●	MMS1570X5DB	81.4	114.9	114.9	173.9	171	2.9	16	1
15.8	3	●	MMS1580X3DB	50.3	82.9	82.9	141.9	139	2.9	16	1
15.8	5	●	MMS1580X5DB	81.9	114.9	114.9	173.9	171	2.9	16	1
15.9	3	●	MMS1590X3DB	50.6	82.9	82.9	141.9	139	2.9	16	1
15.9	5	●	MMS1590X5DB	82.4	114.9	114.9	173.9	171	2.9	16	1
16.0	3	●	MMS1600X3DB	50.9	82.9	82.9	141.9	139	2.9	16	1
16.0	5	●	MMS1600X5DB	82.9	114.9	114.9	173.9	171	2.9	16	1
16.1	3	□	MMS1610X3DB	51.2	85.9	88.9	147.9	145	2.9	18	1
16.1	5	□	MMS1610X5DB	83.4	118.9	122.9	181.9	179	2.9	18	1

CUTTING CONDITIONS ➤ P061
OPERATION GUIDANCE ➤ P063
TECHNICAL DATA ➤ R001

MMS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	DP7020	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
16.2	3	□	MMS1620X3DB	51.5	85.9	88.9	147.9	145	2.9	18	1
16.2	5	□	MMS1620X5DB	83.9	118.9	122.9	181.9	179	2.9	18	1
16.3	3	□	MMS1630X3DB	51.9	86.0	89.0	148.0	145	3.0	18	1
16.3	5	□	MMS1630X5DB	84.5	119.0	123.0	182.0	179	3.0	18	1
16.4	3	□	MMS1640X3DB	52.2	86.0	89.0	148.0	145	3.0	18	1
16.4	5	□	MMS1640X5DB	85.0	119.0	123.0	182.0	179	3.0	18	1
16.5	3	●	MMS1650X3DB	52.5	86.0	89.0	148.0	145	3.0	18	1
16.5	5	●	MMS1650X5DB	85.5	119.0	123.0	182.0	179	3.0	18	1
16.6	3	□	MMS1660X3DB	52.8	88.0	89.0	148.0	145	3.0	18	1
16.6	5	□	MMS1660X5DB	86.0	122.0	123.0	182.0	179	3.0	18	1
16.7	3	□	MMS1670X3DB	53.1	88.0	89.0	148.0	145	3.0	18	1
16.7	5	□	MMS1670X5DB	86.5	122.0	123.0	182.0	179	3.0	18	1
16.8	3	□	MMS1680X3DB	53.5	88.1	89.1	148.1	145	3.1	18	1
16.8	5	□	MMS1680X5DB	87.1	122.1	123.1	182.1	179	3.1	18	1
16.9	3	□	MMS1690X3DB	53.8	88.1	89.1	148.1	145	3.1	18	1
16.9	5	□	MMS1690X5DB	87.6	122.1	123.1	182.1	179	3.1	18	1
17.0	3	●	MMS1700X3DB	54.1	88.1	89.1	148.1	145	3.1	18	1
17.0	5	●	MMS1700X5DB	88.1	122.1	123.1	182.1	179	3.1	18	1
17.1	3	□	MMS1710X3DB	54.4	91.1	93.1	152.1	149	3.1	18	1
17.1	5	□	MMS1710X5DB	88.6	126.1	129.1	188.1	185	3.1	18	1
17.2	3	□	MMS1720X3DB	54.7	91.1	93.1	152.1	149	3.1	18	1
17.2	5	□	MMS1720X5DB	89.1	126.1	129.1	188.1	185	3.1	18	1
17.3	3	□	MMS1730X3DB	55.0	91.1	93.1	152.1	149	3.1	18	1
17.3	5	□	MMS1730X5DB	89.6	126.1	129.1	188.1	185	3.1	18	1
17.4	3	□	MMS1740X3DB	55.4	91.2	93.2	152.2	149	3.2	18	1
17.4	5	□	MMS1740X5DB	90.2	126.2	129.2	188.2	185	3.2	18	1
17.5	3	●	MMS1750X3DB	55.7	91.2	93.2	152.2	149	3.2	18	1
17.5	5	●	MMS1750X5DB	90.7	126.2	129.2	188.2	185	3.2	18	1
17.6	3	□	MMS1760X3DB	56.0	93.2	93.2	152.2	149	3.2	18	1
17.6	5	□	MMS1760X5DB	91.2	129.2	129.2	188.2	185	3.2	18	1
17.7	3	□	MMS1770X3DB	56.3	93.2	93.2	152.2	149	3.2	18	1
17.7	5	□	MMS1770X5DB	91.7	129.2	129.2	188.2	185	3.2	18	1
17.8	3	□	MMS1780X3DB	56.6	93.2	93.2	152.2	149	3.2	18	1
17.8	5	□	MMS1780X5DB	92.2	129.2	129.2	188.2	185	3.2	18	1
17.9	3	□	MMS1790X3DB	57.0	93.3	93.3	152.3	149	3.3	18	1
17.9	5	□	MMS1790X5DB	92.8	129.3	129.3	188.3	185	3.3	18	1
18.0	3	●	MMS1800X3DB	57.3	93.3	93.3	152.3	149	3.3	18	1
18.0	5	●	MMS1800X5DB	93.3	129.3	129.3	188.3	185	3.3	18	1
18.1	3	□	MMS1810X3DB	57.6	96.3	99.3	160.3	157	3.3	20	1
18.1	5	□	MMS1810X5DB	93.8	133.3	137.3	198.3	195	3.3	20	1
18.2	3	□	MMS1820X3DB	57.9	96.3	99.3	160.3	157	3.3	20	1
18.2	5	□	MMS1820X5DB	94.3	133.3	137.3	198.3	195	3.3	20	1
18.3	3	□	MMS1830X3DB	58.2	96.3	99.3	160.3	157	3.3	20	1
18.3	5	□	MMS1830X5DB	94.8	133.3	137.3	198.3	195	3.3	20	1
18.4	3	□	MMS1840X3DB	58.5	96.3	99.3	160.3	157	3.3	20	1
18.4	5	□	MMS1840X5DB	95.3	133.3	137.3	198.3	195	3.3	20	1
18.5	3	●	MMS1850X3DB	58.9	96.4	99.4	160.4	157	3.4	20	1
18.5	5	●	MMS1850X5DB	95.9	133.4	137.4	198.4	195	3.4	20	1
18.6	3	□	MMS1860X3DB	59.2	98.4	99.4	160.4	157	3.4	20	1
18.6	5	□	MMS1860X5DB	96.4	136.4	137.4	198.4	195	3.4	20	1
18.7	3	□	MMS1870X3DB	59.5	98.4	99.4	160.4	157	3.4	20	1
18.7	5	□	MMS1870X5DB	96.9	136.4	137.4	198.4	195	3.4	20	1
18.8	3	□	MMS1880X3DB	59.8	98.4	99.4	160.4	157	3.4	20	1
18.8	5	□	MMS1880X5DB	97.4	136.4	137.4	198.4	195	3.4	20	1
18.9	3	□	MMS1890X3DB	60.1	98.4	99.4	160.4	157	3.4	20	1
18.9	5	□	MMS1890X5DB	97.9	136.4	137.4	198.4	195	3.4	20	1
19.0	3	●	MMS1900X3DB	60.5	98.5	99.5	160.5	157	3.5	20	1
19.0	5	●	MMS1900X5DB	98.5	136.5	137.5	198.5	195	3.5	20	1
19.1	3	□	MMS1910X3DB	60.8	101.5	103.5	164.5	161	3.5	20	1
19.1	5	□	MMS1910X5DB	99.0	140.5	143.5	204.5	201	3.5	20	1
19.2	3	□	MMS1920X3DB	61.1	101.5	103.5	164.5	161	3.5	20	1
19.2	5	□	MMS1920X5DB	99.5	140.5	143.5	204.5	201	3.5	20	1
19.3	3	□	MMS1930X3DB	61.4	101.5	103.5	164.5	161	3.5	20	1
19.3	5	□	MMS1930X5DB	100.0	140.5	143.5	204.5	201	3.5	20	1
19.4	3	□	MMS1940X3DB	61.7	101.5	103.5	164.5	161	3.5	20	1
19.4	5	□	MMS1940X5DB	100.5	140.5	143.5	204.5	201	3.5	20	1
19.5	3	●	MMS1950X3DB	62.0	101.5	103.5	164.5	161	3.5	20	1
19.5	5	●	MMS1950X5DB	101.0	140.5	143.5	204.5	201	3.5	20	1
19.6	3	□	MMS1960X3DB	62.4	103.6	103.6	164.6	161	3.6	20	1
19.6	5	□	MMS1960X5DB	101.6	143.6	143.6	204.6	201	3.6	20	1
19.7	3	□	MMS1970X3DB	62.7	103.6	103.6	164.6	161	3.6	20	1
19.7	5	□	MMS1970X5DB	102.1	143.6	143.6	204.6	201	3.6	20	1
19.8	3	□	MMS1980X3DB	63.0	103.6	103.6	164.6	161	3.6	20	1
19.8	5	□	MMS1980X5DB	102.6	143.6	143.6	204.6	201	3.6	20	1
19.9	3	□	MMS1990X3DB	63.3	103.6	103.6	164.6	161	3.6	20	1
19.9	5	□	MMS1990X5DB	103.1	143.6	143.6	204.6	201	3.6	20	1
20.0	3	●	MMS2000X3DB	63.6	103.6	103.6	164.6	161	3.6	20	1
20.0	5	●	MMS2000X5DB	103.6	143.6	143.6	204.6	201	3.6	20	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

RECOMMENDED CUTTING CONDITIONS

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc					Austenitic Stainless Steel (>200HB) AISI 304LN, AISI 316LN etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	80	7900	0.13	(0.08—0.18)	1025	60	5900	0.1	(0.05—0.15)	590
4.0	80	6300	0.15	(0.10—0.20)	945	60	4700	0.12	(0.08—0.18)	560
5.0	80	5000	0.15	(0.10—0.20)	750	60	3800	0.12	(0.08—0.18)	455
6.3	80	4000	0.17	(0.12—0.22)	680	60	3000	0.15	(0.1—0.2)	450
8.0	80	3100	0.19	(0.14—0.24)	585	60	2300	0.17	(0.12—0.22)	390
10.0	60	1900	0.2	(0.15—0.25)	380	50	1500	0.18	(0.13—0.23)	270
12.0	60	1500	0.21	(0.16—0.26)	315	50	1300	0.19	(0.14—0.24)	245
16.0	60	1100	0.22	(0.17—0.27)	240	50	900	0.2	(0.15—0.25)	180
20.0	60	900	0.23	(0.18—0.28)	205	50	700	0.21	(0.16—0.26)	145

Work Material	Duplex Stainless Steel (≤280HB) AISI 329 etc					Ferritic and Martensitic Stainless Steel (≤200HB) AISI 410, AISI 430 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	50	4900	0.1	(0.05—0.15)	490	80	7900	0.13	(0.08—0.18)	1025
4.0	50	3900	0.12	(0.08—0.18)	465	80	6300	0.15	(0.10—0.20)	945
5.0	50	3100	0.12	(0.08—0.18)	370	80	5000	0.15	(0.10—0.20)	750
6.3	50	2500	0.15	(0.1—0.2)	375	80	4000	0.17	(0.12—0.22)	680
8.0	50	1900	0.17	(0.12—0.22)	320	80	3100	0.19	(0.14—0.24)	585
10.0	40	1200	0.18	(0.13—0.23)	215	60	1900	0.2	(0.15—0.25)	380
12.0	40	1000	0.19	(0.14—0.24)	190	60	1500	0.21	(0.16—0.26)	315
16.0	40	700	0.2	(0.15—0.25)	140	60	1100	0.22	(0.17—0.27)	240
20.0	40	600	0.21	(0.16—0.26)	125	60	900	0.23	(0.18—0.28)	205

Work Material	Ferritic and Martensitic Stainless Steel (>200HB) AISI 431, AISI 420 etc					Precipitation Hardening Stainless Steel (<450HB) ASTM 630, ASTM 631 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)		Table Feed (mm/min)
3.2	60	5900	0.1	(0.05—0.15)	590	50	4900	0.1	(0.05—0.15)	490
4.0	60	4700	0.12	(0.08—0.18)	560	50	3900	0.12	(0.08—0.18)	465
5.0	60	3800	0.12	(0.08—0.18)	455	50	3100	0.12	(0.08—0.18)	370
6.3	60	3000	0.15	(0.1—0.2)	450	50	2500	0.15	(0.1—0.2)	375
8.0	60	2300	0.17	(0.12—0.22)	390	50	1900	0.17	(0.12—0.22)	320
10.0	50	1500	0.18	(0.13—0.23)	270	40	1200	0.18	(0.13—0.23)	215
12.0	50	1300	0.19	(0.14—0.24)	245	40	1000	0.19	(0.14—0.24)	190
16.0	50	900	0.2	(0.15—0.25)	180	40	700	0.2	(0.15—0.25)	140
20.0	50	700	0.21	(0.16—0.26)	145	40	600	0.21	(0.16—0.26)	125

Note 1) For stable machining, internal coolant supply with high pressure is recommended.
Note 2) Emulsion type of water coolant is recommended.
Note 3) Recommended cutting conditions are for machining under the conditions of favourable machining environment and coolant. Please lower the cutting conditions if there is a problem in the rigidity of machine and workpiece, and coolant property or discharge amount .
Note 4) When looking at the coating the color can vary depending on the direction of viewing. This does not have any effect on the performance of the drill.

OPERATION GUIDANCE ➤ P063
TECHNICAL DATA ➤ R001

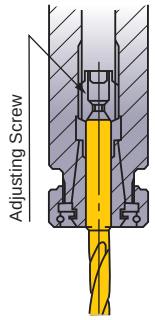
MMS
WSTAR DRILLS

■ Stainless Steel Cross Reference List

Material		Japan	Germany		USA
		JIS	W-no.	DIN	AISI/SAE
Ferritic and Martensitic Stainless Steel	≤200HB	SUS416	1.4005	X12CrS3	416
		SUS410	1.4006	X10Cr13	410
		SUS430	1.4016	X6Cr17	430
		SUS434	1.4113	X6CrMo17	434
		SUS430LX	1.4510	X6CrTi17	430Ti
		–	1.4512	X6CrTi12	409
	>200HB	SUS420J1	1.4021	X20Cr13	420
		SUS431	1.4057	X20CrNi17-2	431
		SUS420J2	1.4028	X30Cr13	420
		SUS440C	1.4125	X10CrMo17	440C
Precipitation Hardening Stainless Steel	<450HB	SUS630	1.4542	X5CrNiCuNb16 4	630 (17-4PH)
		–	1.4545	–	S15500 (15-5PH)
		SUS631	1.4568	X7CrNiAl17 7	631 (17-7PH)
Austenitic Stainless Steel	≤200HB	SUS304	1.4301	X5CrNi18 10	304
		SUS305	1.4303	X5CrNi8-12	305
		SUS303	1.4305	X12CrNiS18-9	303
		SUS304L	1.4307	X2CrNi19-11	304L
		SUS316	1.4401	X5CrNiMo17 12 2	316
	>200HB	SUS304LN	1.4311	X2CrNiN18 10	304LN
		SUS316L	1.4404	X2CrNiMo17 12 2	316L
		SUS316LN	1.4406	X2CrNiMoN17 12 2	316LN
		SUS316L	1.4435	X2CrNiMo18 14 3	–
		SUS317L	1.4438	X2CrNiMo18 15 4	317L
		–	1.4529	X1NiCrMoCuN25 20 7	N08926
		SUS321	1.4541	X6CrNiTi18-10	321
		SUS347	1.4550	X6CrNiNb18-10	347
		SUS316Ti	1.4571	X6CrNiMoTi17 12 2	316Ti
Duplex Stainless Steel	≤280HB	–	1.4362	X2CrNiN23 4	–
		SCS14A	1.4410	X2CrNiMoN25 7 4	S32750
		SUS329J1	1.4460	X3CrNiMoN27 5 2	329
		SUS329J3L	1.4462	X2CrNiMoN22 5 3	S31803

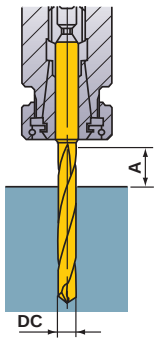
■ Operation Guidance for....X3DB and....X5DB

Drill Holding



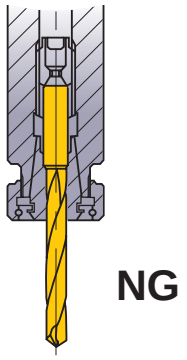
Thrust bearing type collet chuck holds the drill securely.

Drill Length



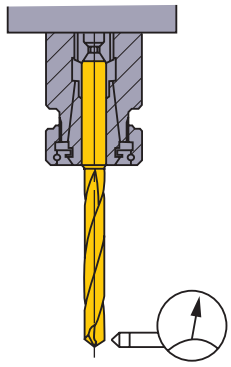
A ≥ DC x 1.5

Drill Installation



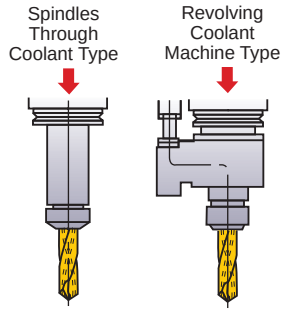
Do not clamp on the flutes.

Installation Tolerance



Run-out ≤ 0.03mm

Through Coolant Type (MMS)



Coolant pressure is approx. 0.5MPa—7MPa

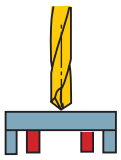
Coolant Handling

<MMS Type>

(1)Small particles of swarf will jam in the oil hole. Use a filter as a preventative measure. When using small diameter drills, use a fine mesh filter.

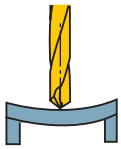
(2)Dirt and dust particles in old coolant can clog the oil hole and prevent effective flow. Regular coolant exchange is recommended.

Thin Workpiece



Support the Workpiece

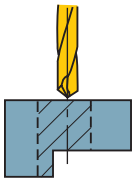
OK



If Bending Occurs

NG

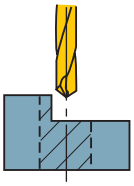
Interrupted Cutting



One Process

OK

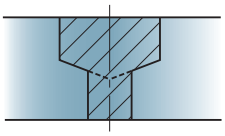
①Lower the feed when drilling the interrupted part.



Requires Prior Machining

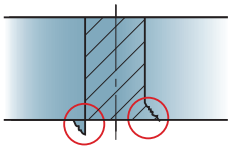
①Spot face with an end mill prior to drilling.

Stepped Holes



①Divide the two processes.
②Drill the larger hole first.
⋆A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping



①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

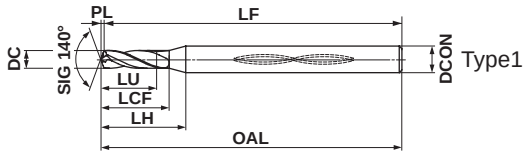
MHS
WSTAR DRILLS

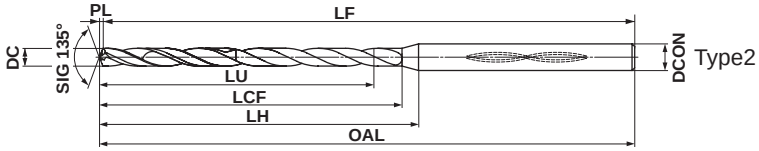
- Solid carbide drills for die & mould machining
- High backling strength and unique double margin.
- Non-step drilling with long tool life for high hardness steel, 35HRC-55HRC

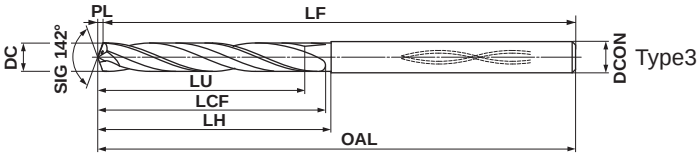
TOOL NEWS

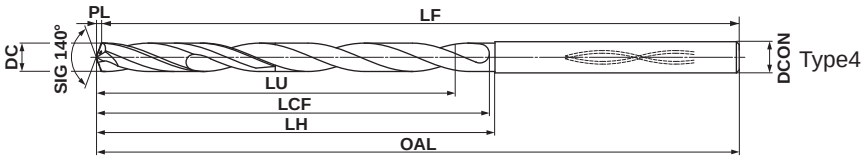
P	M	K	N	S	H
Steel	Stainless Steel			Heat Resistant Alloy	Hardened Steel

Internal Coolant









DC≤3	3<DC≤6	6<DC≤10	10<DC≤12
+0.010 −0.002	+0.010 −0.002	+0.010 −0.005	+0.010 −0.008
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤12**
0 −0.006	0 −0.008	0 −0.009	0 −0.011

Note 1) MHS drills are suitable for use with shrink fit holders.
Note 2) Use the shortest type in the respective diameter as a pilot drill.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
0.95	3	●	MHS0095L006B	3.0	6.2	10.0	60.2	60	0.17	3	1
0.95	6	●	MHS0095L009B	5.9	9.2	13.0	60.2	60	0.17	3	2
0.95	13	●	MHS0095L015B	12.5	15.2	19.0	60.2	60	0.17	3	2
0.95	23	●	MHS0095L025B	22.0	25.2	29.0	60.2	60	0.17	3	2
0.95	30	●	MHS0095L035B	28.7	35.2	39.0	80.2	80	0.17	3	2
1.00	3	●	MHS0100L006B	3.2	6.2	9.9	60.2	60	0.2	3	1
1.00	6	●	MHS0100L009B	6.2	9.2	12.9	60.2	60	0.2	3	2
1.00	12	●	MHS0100L015B	12.2	15.2	18.9	60.2	60	0.2	3	2
1.00	22	●	MHS0100L025B	22.2	25.2	28.9	60.2	60	0.2	3	2
1.00	30	●	MHS0100L035B	30.2	35.2	38.9	80.2	80	0.2	3	2
1.10	2	●	MHS0110L006B	2.4	6.2	9.7	60.2	60	0.2	3	1
1.10	5	●	MHS0110L009B	5.7	9.2	12.7	60.2	60	0.2	3	2
1.10	11	●	MHS0110L015B	12.3	15.2	18.7	60.2	60	0.2	3	2
1.10	20	●	MHS0110L025B	22.2	25.2	28.7	60.2	60	0.2	3	2
1.10	29	●	MHS0110L035B	32.1	35.2	38.7	80.2	80	0.2	3	2
1.20	2	●	MHS0120L006B	2.6	6.2	9.6	60.2	60	0.2	3	1
1.20	5	●	MHS0120L009B	6.2	9.2	12.6	60.2	60	0.2	3	2
1.20	10	●	MHS0120L015B	12.2	15.2	18.6	60.2	60	0.2	3	2
1.20	18	●	MHS0120L025B	21.8	25.2	28.6	60.2	60	0.2	3	2
1.20	26	●	MHS0120L035B	31.4	35.2	38.6	80.2	80	0.2	3	2
1.30	2	●	MHS0130L007B	2.8	7.2	10.4	60.2	60	0.2	3	1
1.30	5	●	MHS0130L011B	6.8	11.3	14.5	60.3	60	0.3	3	2
1.30	12	●	MHS0130L020B	15.9	20.3	23.5	60.3	60	0.3	3	2
1.30	20	●	MHS0130L030B	26.3	30.3	33.5	80.3	80	0.3	3	2

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.30	30	●	MHS0130L045B	39.3	45.3	48.5	80.3	80	0.3	3	2
1.40	2	●	MHS0140L007B	3.1	7.3	10.3	60.3	60	0.3	3	1
1.40	5	●	MHS0140L011B	7.3	11.3	14.3	60.3	60	0.3	3	2
1.40	11	●	MHS0140L020B	15.7	20.3	23.3	60.3	60	0.3	3	2
1.40	18	●	MHS0140L030B	25.5	30.3	33.3	80.3	80	0.3	3	2
1.40	29	●	MHS0140L045B	40.9	45.3	48.3	80.3	80	0.3	3	2
1.45	3	●	MHS0145L008B	4.7	8.3	11.2	60.3	60	0.3	3	1
1.45	6	●	MHS0145L013B	9.0	13.3	16.2	60.3	60	0.3	3	2
1.45	11	●	MHS0145L020B	16.3	20.3	23.2	60.3	60	0.3	3	2
1.45	21	●	MHS0145L035B	30.8	35.3	38.2	80.3	80	0.3	3	2
1.45	30	●	MHS0145L055B	43.8	55.3	58.2	100.3	100	0.3	3	2
1.50	2	●	MHS0150L008B	3.3	8.3	11.1	60.3	60	0.3	3	1
1.50	6	●	MHS0150L013B	9.3	13.3	16.1	60.3	60	0.3	3	2
1.50	10	●	MHS0150L020B	15.3	20.3	23.1	60.3	60	0.3	3	2
1.50	20	●	MHS0150L035B	30.3	35.3	38.1	80.3	80	0.3	3	2
1.50	30	●	MHS0150L055B	45.3	55.3	58.1	100.3	100	0.3	3	2
1.60	2	●	MHS0160L008B	3.5	8.3	10.9	60.3	60	0.3	3	1
1.60	5	●	MHS0160L013B	8.3	13.3	15.9	60.3	60	0.3	3	2
1.60	10	●	MHS0160L020B	16.3	20.3	22.9	60.3	60	0.3	3	2
1.60	19	●	MHS0160L035B	30.7	35.3	37.9	80.3	80	0.3	3	2
1.60	30	●	MHS0160L055B	48.3	55.3	57.9	100.3	100	0.3	3	2
1.70	2	●	MHS0170L008B	3.7	8.3	10.7	60.3	60	0.3	3	1
1.70	5	●	MHS0170L013B	8.9	13.4	15.8	60.4	60	0.4	3	2
1.70	9	●	MHS0170L020B	15.7	20.4	22.8	60.4	60	0.4	3	2

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.70	18	●	MHS0170L035B	31.0	35.4	37.8	80.4	80	0.4	3	2
1.70	29	●	MHS0170L055B	49.7	55.4	57.8	100.4	100	0.4	3	2
1.80	3	●	MHS0180L010B	5.7	10.3	12.5	60.3	60	0.3	3	1
1.80	5	●	MHS0180L015B	9.4	15.4	17.6	60.4	60	0.4	3	2
1.80	11	●	MHS0180L025B	20.2	25.4	27.6	60.4	60	0.4	3	2
1.80	22	●	MHS0180L045B	40.0	45.4	47.6	80.4	80	0.4	3	2
1.80	30	●	MHS0180L065B	54.4	65.4	67.6	100.4	100	0.4	3	2
1.90	2	●	MHS0190L010B	4.1	10.3	12.4	60.3	60	0.3	3	1
1.90	5	●	MHS0190L015B	9.9	15.4	17.5	60.4	60	0.4	3	2
1.90	10	●	MHS0190L025B	19.4	25.4	27.5	60.4	60	0.4	3	2
1.90	21	●	MHS0190L045B	40.3	45.4	47.5	80.4	80	0.4	3	2
1.90	30	●	MHS0190L065B	57.4	65.4	67.5	100.4	100	0.4	3	2
1.95	2	●	MHS0195L010B	4.3	10.4	12.4	60.4	60	0.4	3	1
1.95	5	●	MHS0195L015B	10.2	15.4	17.4	60.4	60	0.4	3	2
1.95	10	●	MHS0195L025B	19.9	25.4	27.4	60.4	60	0.4	3	2
1.95	20	●	MHS0195L045B	39.4	45.4	47.4	80.4	80	0.4	3	2
1.95	30	●	MHS0195L065B	58.9	65.4	67.4	100.4	100	0.4	3	2
2.00	2	●	MHS0200L010B	4.4	10.4	12.3	60.4	60	0.4	3	1
2.00	5	●	MHS0200L015B	10.4	15.4	17.3	60.4	60	0.4	3	2
2.00	9	●	MHS0200L025B	18.4	25.4	27.3	60.4	60	0.4	3	2
2.00	20	●	MHS0200L045B	40.4	45.4	47.3	80.4	80	0.4	3	2
2.00	30	●	MHS0200L065B	60.4	65.4	67.3	100.4	100	0.4	3	2
2.10	3	●	MHS0210L012B	6.7	12.4	14.1	60.4	60	0.4	3	1
2.10	7	●	MHS0210L020B	15.1	20.4	22.1	60.4	60	0.4	3	2
2.10	11	●	MHS0210L030B	23.5	30.4	32.1	80.4	80	0.4	3	2
2.10	23	●	MHS0210L055B	48.7	55.4	57.1	100.4	100	0.4	3	2
2.10	30	●	MHS0210L075B	63.4	75.4	77.1	120.4	120	0.4	3	2
2.20	2	●	MHS0220L012B	4.8	12.4	13.9	60.4	60	0.4	3	1
2.20	6	●	MHS0220L020B	13.7	20.5	22.0	60.5	60	0.5	3	2
2.20	11	●	MHS0220L030B	24.7	30.5	32.0	80.5	80	0.5	3	2
2.20	22	●	MHS0220L055B	48.9	55.5	57.0	100.5	100	0.5	3	2
2.20	30	●	MHS0220L075B	66.5	75.5	77.0	120.5	120	0.5	3	2
2.30	2	●	MHS0230L012B	5.0	12.4	13.7	60.4	60	0.4	3	1
2.30	6	●	MHS0230L020B	14.3	20.5	21.8	60.5	60	0.5	3	2
2.30	10	●	MHS0230L030B	23.5	30.5	31.8	80.5	80	0.5	3	2
2.30	21	●	MHS0230L055B	48.8	55.5	56.8	100.5	100	0.5	3	2
2.30	30	●	MHS0230L075B	69.5	75.5	76.8	120.5	120	0.5	3	2
2.40	2	●	MHS0240L012B	5.2	12.4	13.5	60.4	60	0.4	3	1
2.40	5	●	MHS0240L020B	12.5	20.5	21.6	60.5	60	0.5	3	2
2.40	9	●	MHS0240L030B	22.1	30.5	31.6	80.5	80	0.5	3	2
2.40	20	●	MHS0240L055B	48.5	55.5	56.6	100.5	100	0.5	3	2
2.40	28	●	MHS0240L075B	67.7	75.5	76.6	120.5	120	0.5	3	2
2.45	2	●	MHS0245L013B	5.3	13.4	14.4	70.4	70	0.4	4	1
2.45	5	●	MHS0245L020B	12.8	20.5	21.5	70.5	70	0.5	4	2
2.45	11	●	MHS0245L035B	27.5	35.5	36.5	90.5	90	0.5	4	2
2.45	24	●	MHS0245L065B	59.3	65.5	66.5	110.5	110	0.5	4	2
2.45	30	●	MHS0245L090B	74.0	90.5	91.5	140.5	140	0.5	4	2
2.50	2	●	MHS0250L013B	5.5	13.5	16.3	70.5	70	0.5	4	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
2.50	5	●	MHS0250L020B	13.0	20.5	23.3	70.5	70	0.5	4	2
2.50	11	●	MHS0250L035B	28.0	35.5	38.3	90.5	90	0.5	4	2
2.50	23	●	MHS0250L065B	58.0	65.5	68.3	110.5	110	0.5	4	2
2.50	30	●	MHS0250L090B	75.5	90.5	93.3	140.5	140	0.5	4	2
2.60	2	●	MHS0260L013B	5.7	13.5	16.1	70.5	70	0.5	4	1
2.60	5	●	MHS0260L020B	13.5	20.5	23.1	70.5	70	0.5	4	2
2.60	10	●	MHS0260L035B	26.5	35.5	38.1	90.5	90	0.5	4	2
2.60	22	●	MHS0260L065B	57.7	65.5	68.1	110.5	110	0.5	4	2
2.60	30	●	MHS0260L090B	78.5	90.5	93.1	140.5	140	0.5	4	2
2.70	2	●	MHS0270L013B	5.9	13.5	15.9	70.5	70	0.5	4	1
2.70	4	●	MHS0270L020B	11.4	20.6	23.0	70.6	70	0.6	4	2
2.70	10	●	MHS0270L035B	27.6	35.6	38.0	90.6	90	0.6	4	2
2.70	21	●	MHS0270L065B	57.3	65.6	68.0	110.6	110	0.6	4	2
2.70	30	●	MHS0270L090B	81.6	90.6	93.0	140.6	140	0.6	4	2
2.80	2	●	MHS0280L014B	6.1	14.5	16.7	70.5	70	0.5	4	1
2.80	4	●	MHS0280L020B	11.8	20.6	22.8	70.6	70	0.6	4	2
2.80	9	●	MHS0280L035B	25.8	35.6	37.8	90.6	90	0.6	4	2
2.80	20	●	MHS0280L065B	56.6	65.6	67.8	110.6	110	0.6	4	2
2.80	29	●	MHS0280L090B	81.8	90.6	92.8	140.6	140	0.6	4	2
2.90	2	●	MHS0290L014B	6.3	14.5	16.6	70.5	70	0.5	4	1
2.90	4	●	MHS0290L020B	12.2	20.6	22.7	70.6	70	0.6	4	2
2.90	9	●	MHS0290L035B	26.7	35.6	37.7	90.6	90	0.6	4	2
2.90	19	●	MHS0290L065B	55.7	65.6	67.7	110.6	110	0.6	4	2
2.90	28	●	MHS0290L090B	81.8	90.6	92.7	140.6	140	0.6	4	2
2.95	2	●	MHS0295L014B	6.4	14.5	16.5	70.5	70	0.5	4	1
2.95	4	●	MHS0295L020B	12.4	20.6	22.6	70.6	70	0.6	4	2
2.95	9	●	MHS0295L035B	27.2	35.6	37.6	90.6	90	0.6	4	2
2.95	19	●	MHS0295L065B	56.7	65.6	67.6	110.6	110	0.6	4	2
2.95	28	●	MHS0295L090B	83.2	90.6	92.6	140.6	140	0.6	4	2
3.0	4	●	MHS0300L020B	12.5	19.5	20.5	70.5	70	0.5	4	3
3.0	10	●	MHS0300L040B	30.5	39.5	40.5	90.5	90	0.5	4	4
3.0	17	●	MHS0300L060B	51.5	59.5	60.5	110.5	110	0.5	4	4
3.0	27	●	MHS0300L090B	81.5	89.5	90.5	140.5	140	0.5	4	4
3.1	4	□	MHS0310L020B	12.9	20.0	20.5	70.5	70	0.5	4	3
3.1	10	□	MHS0310L040B	31.6	40.1	40.6	90.6	90	0.6	4	4
3.1	17	□	MHS0310L060B	53.3	60.1	60.6	110.6	110	0.6	4	4
3.1	26	□	MHS0310L090B	81.2	90.1	90.6	140.6	140	0.6	4	4
3.2	4	□	MHS0320L020B	13.4	20.1	20.6	70.6	70	0.6	4	3
3.2	10	□	MHS0320L040B	32.6	40.1	40.6	90.6	90	0.6	4	4
3.2	16	□	MHS0320L060B	51.8	60.1	60.6	110.6	110	0.6	4	4
3.2	25	□	MHS0320L090B	80.6	90.1	90.6	140.6	140	0.6	4	4
3.3	3	□	MHS0330L020B	10.5	20.1	20.6	70.6	70	0.6	4	3
3.3	9	□	MHS0330L040B	30.3	40.1	40.6	90.6	90	0.6	4	4
3.3	16	□	MHS0330L060B	53.4	60.1	60.6	110.6	110	0.6	4	4
3.3	25	□	MHS0330L090B	83.1	90.1	90.6	140.6	140	0.6	4	4
3.4	3	□	MHS0340L020B	10.8	20.1	20.6	70.6	70	0.6	4	3
3.4	9	□	MHS0340L040B	31.2	40.1	40.6	90.6	90	0.6	4	4
3.4	15	□	MHS0340L060B	51.6	60.1	60.6	110.6	110	0.6	4	4

CUTTING CONDITIONS ➤ P072
OPERATION GUIDANCE ➤ P074
TECHNICAL DATA ➤ R001

MHS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.4	24	□	MHS0340L090B	82.2	90.1	90.6	140.6	140	0.6	4	4
3.5	3	●	MHS0350L020B	11.1	20.1	20.6	70.6	70	0.6	4	3
3.5	9	●	MHS0350L040B	32.1	40.1	40.6	90.6	90	0.6	4	4
3.5	14	●	MHS0350L060B	49.6	60.1	60.6	110.6	110	0.6	4	4
3.5	23	●	MHS0350L090B	81.1	90.1	90.6	140.6	140	0.6	4	4
3.6	3	□	MHS0360L020B	11.4	20.6	20.6	70.6	70	0.6	4	3
3.6	9	□	MHS0360L040B	33.1	40.7	40.7	90.7	90	0.7	4	4
3.6	14	□	MHS0360L060B	51.1	60.7	60.7	110.7	110	0.7	4	4
3.6	22	□	MHS0360L090B	79.9	90.7	90.7	140.7	140	0.7	4	4
3.6	30	□	MHS0360L120B	108.7	120.7	120.7	170.7	170	0.7	4	4
3.7	3	□	MHS0370L020B	11.7	20.6	20.6	70.6	70	0.6	4	3
3.7	8	□	MHS0370L040B	30.3	40.7	40.7	90.7	90	0.7	4	4
3.7	14	□	MHS0370L060B	52.5	60.7	60.7	110.7	110	0.7	4	4
3.7	22	□	MHS0370L090B	82.1	90.7	90.7	140.7	140	0.7	4	4
3.7	30	□	MHS0370L120B	111.7	120.7	120.7	170.7	170	0.7	4	4
3.8	3	●	MHS0380L020B	12.1	20.7	20.7	70.7	70	0.7	4	3
3.8	8	●	MHS0380L040B	31.1	40.7	40.7	90.7	90	0.7	4	4
3.8	13	●	MHS0380L060B	50.1	60.7	60.7	110.7	110	0.7	4	4
3.8	21	●	MHS0380L090B	80.5	90.7	90.7	140.7	140	0.7	4	4
3.8	29	●	MHS0380L120B	110.9	120.7	120.7	170.7	170	0.7	4	4
3.9	3	□	MHS0390L020B	12.4	20.7	20.7	70.7	70	0.7	4	3
3.9	8	□	MHS0390L040B	31.9	40.7	40.7	90.7	90	0.7	4	4
3.9	13	□	MHS0390L060B	51.4	60.7	60.7	110.7	110	0.7	4	4
3.9	21	□	MHS0390L090B	82.6	90.7	90.7	140.7	140	0.7	4	4
3.9	28	□	MHS0390L120B	109.9	120.7	120.7	170.7	170	0.7	4	4
4.0	2	●	MHS0400L020B	8.7	20.7	20.7	70.7	70	0.7	4	3
4.0	7	●	MHS0400L040B	28.7	40.7	40.7	90.7	90	0.7	4	4
4.0	12	●	MHS0400L060B	48.7	60.7	60.7	110.7	110	0.7	4	4
4.0	20	●	MHS0400L090B	80.7	90.7	90.7	140.7	140	0.7	4	4
4.0	27	●	MHS0400L120B	108.7	120.7	120.7	170.7	170	0.7	4	4
4.1	2	□	MHS0410L020B	8.9	19.2	20.7	70.7	70	0.7	6	3
4.1	7	□	MHS0410L040B	29.4	39.2	40.7	90.7	90	0.7	6	4
4.1	12	□	MHS0410L060B	49.9	59.2	60.7	110.7	110	0.7	6	4
4.1	19	□	MHS0410L090B	78.6	89.2	90.7	140.7	140	0.7	6	4
4.1	26	□	MHS0410L120B	107.3	119.2	120.7	170.7	170	0.7	6	4
4.2	2	□	MHS0420L020B	9.1	19.2	20.7	70.7	70	0.7	6	3
4.2	7	□	MHS0420L040B	30.2	39.3	40.8	90.8	90	0.8	6	4
4.2	11	□	MHS0420L060B	47.0	59.3	60.8	110.8	110	0.8	6	4
4.2	19	□	MHS0420L090B	80.6	89.3	90.8	140.8	140	0.8	6	4
4.2	26	□	MHS0420L120B	110.0	119.3	120.8	170.8	170	0.8	6	4
4.3	2	□	MHS0430L020B	9.3	19.2	20.7	70.7	70	0.7	6	3
4.3	6	□	MHS0430L040B	26.6	39.3	40.8	90.8	90	0.8	6	4
4.3	11	□	MHS0430L060B	48.1	59.3	60.8	110.8	110	0.8	6	4
4.3	18	□	MHS0430L090B	78.2	89.3	90.8	140.8	140	0.8	6	4
4.3	25	□	MHS0430L120B	108.3	119.3	120.8	170.8	170	0.8	6	4
4.4	2	□	MHS0440L020B	9.6	19.3	20.8	70.8	70	0.8	6	3
4.4	6	□	MHS0440L040B	27.2	39.3	40.8	90.8	90	0.8	6	4
4.4	11	□	MHS0440L060B	49.2	59.3	60.8	110.8	110	0.8	6	4
4.4	18	□	MHS0440L090B	80.0	89.3	90.8	140.8	140	0.8	6	4
4.4	24	□	MHS0440L120B	106.4	119.3	120.8	170.8	170	0.8	6	4
4.5	2	●	MHS0450L020B	9.8	19.3	20.8	70.8	70	0.8	6	3
4.5	6	●	MHS0450L040B	27.8	39.3	40.8	90.8	90	0.8	6	4
4.5	10	●	MHS0450L060B	45.8	59.3	60.8	110.8	110	0.8	6	4
4.5	17	●	MHS0450L090B	77.3	89.3	90.8	140.8	140	0.8	6	4
4.5	24	●	MHS0450L120B	108.8	119.3	120.8	170.8	170	0.8	6	4
4.6	2	□	MHS0460L020B	10.0	19.8	20.8	70.8	70	0.8	6	3
4.6	6	□	MHS0460L040B	28.4	39.8	40.8	90.8	90	0.8	6	4
4.6	10	□	MHS0460L060B	46.8	59.8	60.8	110.8	110	0.8	6	4
4.6	17	□	MHS0460L090B	79.0	89.8	90.8	140.8	140	0.8	6	4
4.6	23	□	MHS0460L120B	106.6	119.8	120.8	170.8	170	0.8	6	4
4.6	30	□	MHS0460L150B	138.8	149.8	150.8	200.8	200	0.8	6	4
4.7	2	□	MHS0470L020B	10.2	19.8	20.8	70.8	70	0.8	6	3
4.7	6	□	MHS0470L040B	29.1	39.9	40.9	90.9	90	0.9	6	4
4.7	10	□	MHS0470L060B	47.9	59.9	60.9	110.9	110	0.9	6	4
4.7	16	□	MHS0470L090B	76.1	89.9	90.9	140.9	140	0.9	6	4
4.7	23	□	MHS0470L120B	109.0	119.9	120.9	170.9	170	0.9	6	4
4.7	29	□	MHS0470L150B	137.2	149.9	150.9	200.9	200	0.9	6	4
4.8	1	●	MHS0480L020B	5.6	19.8	20.8	70.8	70	0.8	6	3
4.8	6	●	MHS0480L040B	29.7	39.9	40.9	90.9	90	0.9	6	4
4.8	10	●	MHS0480L060B	48.9	59.9	60.9	110.9	110	0.9	6	4
4.8	16	●	MHS0480L090B	77.7	89.9	90.9	140.9	140	0.9	6	4
4.8	22	●	MHS0480L120B	106.5	119.9	120.9	170.9	170	0.9	6	4
4.8	29	●	MHS0480L150B	140.1	149.9	150.9	200.9	200	0.9	6	4
4.9	1	□	MHS0490L020B	5.7	19.8	20.8	70.8	70	0.8	6	3
4.9	5	□	MHS0490L040B	25.4	39.9	40.9	90.9	90	0.9	6	4
4.9	10	□	MHS0490L060B	49.9	59.9	60.9	110.9	110	0.9	6	4
4.9	16	□	MHS0490L090B	79.3	89.9	90.9	140.9	140	0.9	6	4
4.9	22	□	MHS0490L120B	108.7	119.9	120.9	170.9	170	0.9	6	4
4.9	28	□	MHS0490L150B	138.1	149.9	150.9	200.9	200	0.9	6	4
5.0	1	●	MHS0500L020B	5.9	19.9	20.9	70.9	70	0.9	6	3
5.0	5	●	MHS0500L040B	25.9	39.9	40.9	90.9	90	0.9	6	4
5.0	9	●	MHS0500L060B	45.9	59.9	60.9	110.9	110	0.9	6	4
5.0	15	●	MHS0500L090B	75.9	89.9	90.9	140.9	140	0.9	6	4
5.0	21	●	MHS0500L120B	105.9	119.9	120.9	170.9	170	0.9	6	4
5.0	27	●	MHS0500L150B	135.9	149.9	150.9	200.9	200	0.9	6	4
5.1	3	□	MHS0510L030B	16.2	30.4	30.9	80.9	80	0.9	6	3
5.1	9	□	MHS0510L060B	46.8	60.4	60.9	110.9	110	0.9	6	4
5.1	15	□	MHS0510L090B	77.4	90.4	90.9	140.9	140	0.9	6	4
5.1	21	□	MHS0510L120B	108.0	120.4	120.9	170.9	170	0.9	6	4
5.1	27	□	MHS0510L150B	138.6	150.4	150.9	200.9	200	0.9	6	4
5.2	3	□	MHS0520L030B	16.5	30.4	30.9	80.9	80	0.9	6	3
5.2	9	□	MHS0520L060B	47.7	60.4	60.9	110.9	110	0.9	6	4
5.2	15	□	MHS0520L090B	78.9	90.4	90.9	140.9	140	0.9	6	4
5.2	20	□	MHS0520L120B	104.9	120.4	120.9	170.9	170	0.9	6	4
5.2	26	□	MHS0520L150B	136.1	150.4	150.9	200.9	200	0.9	6	4
5.3	3	□	MHS0530L030B	16.8	30.4	30.9	80.9	80	0.9	6	3

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
5.3	9	□	MHS0530L060B	48.7	60.5	61.0	111.0	110	1.0	6	4
5.3	14	□	MHS0530L090B	75.2	90.5	91.0	141.0	140	1.0	6	4
5.3	20	□	MHS0530L120B	107.0	120.5	121.0	171.0	170	1.0	6	4
5.3	26	□	MHS0530L150B	138.8	150.5	151.0	201.0	200	1.0	6	4
5.4	3	□	MHS0540L030B	17.1	30.4	30.9	80.9	80	0.9	6	3
5.4	9	□	MHS0540L060B	49.6	60.5	61.0	111.0	110	1.0	6	4
5.4	14	□	MHS0540L090B	76.6	90.5	91.0	141.0	140	1.0	6	4
5.4	20	□	MHS0540L120B	109.0	120.5	121.0	171.0	170	1.0	6	4
5.4	25	□	MHS0540L150B	136.0	150.5	151.0	201.0	200	1.0	6	4
5.5	3	●	MHS0550L030B	17.4	30.4	30.9	80.9	80	0.9	6	3
5.5	8	●	MHS0550L060B	45.0	60.5	61.0	111.0	110	1.0	6	4
5.5	14	●	MHS0550L090B	78.0	90.5	91.0	141.0	140	1.0	6	4
5.5	19	●	MHS0550L120B	105.5	120.5	121.0	171.0	170	1.0	6	4
5.5	25	●	MHS0550L150B	138.5	150.5	151.0	201.0	200	1.0	6	4
5.6	3	□	MHS0560L030B	17.8	31.0	31.0	81.0	80	1.0	6	3
5.6	8	□	MHS0560L060B	45.8	61.0	61.0	111.0	110	1.0	6	4
5.6	14	□	MHS0560L090B	79.4	91.0	91.0	141.0	140	1.0	6	4
5.6	19	□	MHS0560L120B	107.4	121.0	121.0	171.0	170	1.0	6	4
5.6	24	□	MHS0560L150B	135.4	151.0	151.0	201.0	200	1.0	6	4
5.7	3	□	MHS0570L030B	18.1	31.0	31.0	81.0	80	1.0	6	3
5.7	8	□	MHS0570L060B	46.6	61.0	61.0	111.0	110	1.0	6	4
5.7	13	□	MHS0570L090B	75.1	91.0	91.0	141.0	140	1.0	6	4
5.7	19	□	MHS0570L120B	109.3	121.0	121.0	171.0	170	1.0	6	4
5.7	24	□	MHS0570L150B	137.8	151.0	151.0	201.0	200	1.0	6	4
5.8	3	●	MHS0580L030B	18.4	31.0	31.0	81.0	80	1.0	6	3
5.8	8	●	MHS0580L060B	47.5	61.1	61.1	111.1	110	1.1	6	4
5.8	13	●	MHS0580L090B	76.5	91.1	91.1	141.1	140	1.1	6	4
5.8	18	●	MHS0580L120B	105.5	121.1	121.1	171.1	170	1.1	6	4
5.8	23	●	MHS0580L150B	134.5	151.1	151.1	201.1	200	1.1	6	4
5.9	3	□	MHS0590L030B	18.7	31.0	31.0	81.0	80	1.0	6	3
5.9	8	□	MHS0590L060B	48.3	61.1	61.1	111.1	110	1.1	6	4
5.9	13	□	MHS0590L090B	77.8	91.1	91.1	141.1	140	1.1	6	4
5.9	18	□	MHS0590L120B	107.3	121.1	121.1	171.1	170	1.1	6	4
5.9	23	□	MHS0590L150B	136.8	151.1	151.1	201.1	200	1.1	6	4
6.0	2	●	MHS0600L030B	13.0	31.0	31.0	81.0	80	1.0	6	3
6.0	7	●	MHS0600L060B	43.1	61.1	61.1	111.1	110	1.1	6	4
6.0	12	●	MHS0600L090B	73.1	91.1	91.1	141.1	140	1.1	6	4
6.0	17	●	MHS0600L120B	103.1	121.1	121.1	171.1	170	1.1	6	4
6.0	22	●	MHS0600L150B	133.1	151.1	151.1	201.1	200	1.1	6	4
6.1	2	□	MHS0610L030B	13.3	29.6	31.1	81.1	80	1.1	8	3
6.1	7	□	MHS0610L060B	43.8	59.6	61.1	111.1	110	1.1	8	4
6.1	12	□	MHS0610L090B	74.3	89.6	91.1	141.1	140	1.1	8	4
6.1	17	□	MHS0610L120B	104.8	119.6	121.1	171.1	170	1.1	8	4
6.1	22	□	MHS0610L150B	135.3	149.6	151.1	201.1	200	1.1	8	4
6.2	2	□	MHS0620L030B	13.5	29.6	31.1	81.1	80	1.1	8	3
6.2	7	□	MHS0620L060B	44.5	59.6	61.1	111.1	110	1.1	8	4
6.2	12	□	MHS0620L090B	75.5	89.6	91.1	141.1	140	1.1	8	4
6.2	17	□	MHS0620L120B	106.5	119.6	121.1	171.1	170	1.1	8	4
6.2	21	□	MHS0620L150B	131.3	149.6	151.1	201.1	200	1.1	8	4
6.3	2	□	MHS0630L030B	13.7	29.6	31.1	81.1	80	1.1	8	3
6.3	7	□	MHS0630L060B	45.2	59.6	61.1	111.1	110	1.1	8	4
6.3	12	□	MHS0630L090B	76.7	89.6	91.1	141.1	140	1.1	8	4
6.3	16	□	MHS0630L120B	101.9	119.6	121.1	171.1	170	1.1	8	4
6.3	21	□	MHS0630L150B	133.4	149.6	151.1	201.1	200	1.1	8	4
6.4	2	□	MHS0640L030B	13.9	29.6	31.1	81.1	80	1.1	8	3
6.4	7	□	MHS0640L060B	46.0	59.7	61.2	111.2	110	1.2	8	4
6.4	11	□	MHS0640L090B	71.6	89.7	91.2	141.2	140	1.2	8	4
6.4	16	□	MHS0640L120B	103.6	119.7	121.2	171.2	170	1.2	8	4
6.4	21	□	MHS0640L150B	135.6	149.7	151.2	201.2	200	1.2	8	4
6.5	2	●	MHS0650L030B	14.1	29.6	31.1	81.1	80	1.1	8	3
6.5	6	●	MHS0650L060B	40.2	59.7	61.2	111.2	110	1.2	8	4
6.5	11	●	MHS0650L090B	72.7	89.7	91.2	141.2	140	1.2	8	4
6.5	16	●	MHS0650L120B	105.2	119.7	121.2	171.2	170	1.2	8	4
6.5	20	●	MHS0650L150B	131.2	149.7	151.2	201.2	200	1.2	8	4
6.6	2	□	MHS0660L030B	14.3	30.1	31.1	81.1	80	1.1	8	3
6.6	6	□	MHS0660L060B	40.8	60.2	61.2	111.2	110	1.2	8	4
6.6	11	□	MHS0660L090B	73.8	90.2	91.2	141.2	140	1.2	8	4
6.6	16	□	MHS0660L120B	106.8	120.2	121.2	171.2	170	1.2	8	4
6.6	20	□	MHS0660L150B	133.2	150.2	151.2	201.2	200	1.2	8	4
6.6	28	□	MHS0660L200B	186.0	200.2	201.2	251.2	250	1.2	8	4
6.7	2	□	MHS0670L030B	14.6	30.2	31.2	81.2	80	1.2	8	3
6.7	6	□	MHS0670L060B	41.4	60.2	61.2	111.2	110	1.2	8	4
6.7	11	□	MHS0670L090B	74.9	90.2	91.2	141.2	140	1.2	8	4
6.7	15	□	MHS0670L120B	101.7	120.2	121.2	171.2	170	1.2	8	4
6.7	20	□	MHS0670L150B	135.2	150.2	151.2	201.2	200	1.2	8	4
6.7	27	□	MHS0670L200B	182.1	200.2	201.2	251.2	250	1.2	8	4
6.8	2	●	MHS0680L030B	14.8	30.2	31.2	81.2	80	1.2	8	3
6.8	6	●	MHS0680L060B	42.0	60.2	61.2	111.2	110	1.2	8	4
6.8	11	●	MHS0680L090B	76.0	90.2	91.2	141.2	140	1.2	8	4
6.8	15	●	MHS0680L120B	103.2	120.2	121.2	171.2	170	1.2	8	4
6.8	19	●	MHS0680L150B	130.4	150.2	151.2	201.2	200	1.2	8	4
6.8	27	●	MHS0680L200B	184.8	200.2	201.2	251.2	250	1.2	8	4
6.9	2	□	MHS0690L030B	15.0	30.2	31.2	81.2	80	1.2	8	3
6.9	6	□	MHS0690L060B	42.7	60.3	61.3	111.3	110	1.3	8	4
6.9	10	□	MHS0690L090B	70.3	90.3	91.3	141.3	140	1.3	8	4
6.9	15	□	MHS0690L120B	104.8	120.3	121.3	171.3	170	1.3	8	4
6.9	19	□	MHS0690L150B	132.4	150.3	151.3	201.3	200	1.3	8	4
6.9	26	□	MHS0690L200B	180.7	200.3	201.3	251.3	250	1.3	8	4
7.0	2	●	MHS0700L030B	15.2	30.2	31.2	81.2	80	1.2	8	3
7.0	6	●	MHS0700L060B	43.3	60.3	61.3	111.3	110	1.3	8	4
7.0	10	●	MHS0700L090B	71.3	90.3	91.3	141.3	140	1.3	8	4
7.0	14	●	MHS0700L120B	99.3	120.3	121.3	171.3	170	1.3	8	4
7.0	19	●	MHS0700L150B	134.3	150.3	151.3	201.3	200	1.3	8	4
7.0	26	●	MHS0700L200B	183.3	200.3	201.3	251.3	250	1.3	8	4
7.1	2	□	MHS0710L030B	15.4	30.7	31.2	81.2	80	1.2	8	3
7.1	6	□	MHS0710L060B	43.9	60.8	61.3	111.3	110	1.3	8	4

CUTTING CONDITIONS ➤ P072
OPERATION GUIDANCE ➤ P074
TECHNICAL DATA ➤ R001

MHS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.1	10	□	MHS0710L090B	72.3	90.8	91.3	141.3	140	1.3	8	4
7.1	14	□	MHS0710L120B	100.7	120.8	121.3	171.3	170	1.3	8	4
7.1	19	□	MHS0710L150B	136.2	150.8	151.3	201.3	200	1.3	8	4
7.1	26	□	MHS0710L200B	185.9	200.8	201.3	251.3	250	1.3	8	4
7.2	2	□	MHS0720L030B	15.6	30.7	31.2	81.2	80	1.2	8	3
7.2	6	□	MHS0720L060B	44.5	60.8	61.3	111.3	110	1.3	8	4
7.2	10	□	MHS0720L090B	73.3	90.8	91.3	141.3	140	1.3	8	4
7.2	14	□	MHS0720L120B	102.1	120.8	121.3	171.3	170	1.3	8	4
7.2	18	□	MHS0720L150B	130.9	150.8	151.3	201.3	200	1.3	8	4
7.2	25	□	MHS0720L200B	181.3	200.8	201.3	251.3	250	1.3	8	4
7.3	2	□	MHS0730L030B	15.9	30.8	31.3	81.3	80	1.3	8	3
7.3	6	□	MHS0730L060B	45.1	60.8	61.3	111.3	110	1.3	8	4
7.3	10	□	MHS0730L090B	74.3	90.8	91.3	141.3	140	1.3	8	4
7.3	14	□	MHS0730L120B	103.5	120.8	121.3	171.3	170	1.3	8	4
7.3	18	□	MHS0730L150B	132.7	150.8	151.3	201.3	200	1.3	8	4
7.3	25	□	MHS0730L200B	183.8	200.8	201.3	251.3	250	1.3	8	4
7.4	1	□	MHS0740L030B	8.7	30.8	31.3	81.3	80	1.3	8	3
7.4	6	□	MHS0740L060B	45.7	60.8	61.3	111.3	110	1.3	8	4
7.4	10	□	MHS0740L090B	75.3	90.8	91.3	141.3	140	1.3	8	4
7.4	14	□	MHS0740L120B	104.9	120.8	121.3	171.3	170	1.3	8	4
7.4	18	□	MHS0740L150B	134.5	150.8	151.3	201.3	200	1.3	8	4
7.4	24	□	MHS0740L200B	178.9	200.8	201.3	251.3	250	1.3	8	4
7.5	1	●	MHS0750L030B	8.8	30.8	31.3	81.3	80	1.3	8	3
7.5	5	●	MHS0750L060B	38.9	60.9	61.4	111.4	110	1.4	8	4
7.5	9	●	MHS0750L090B	68.9	90.9	91.4	141.4	140	1.4	8	4
7.5	13	●	MHS0750L120B	98.9	120.9	121.4	171.4	170	1.4	8	4
7.5	17	●	MHS0750L150B	128.9	150.9	151.4	201.4	200	1.4	8	4
7.5	24	●	MHS0750L200B	181.4	200.9	201.4	251.4	250	1.4	8	4
7.6	1	□	MHS0760L030B	8.9	31.3	31.3	81.3	80	1.3	8	3
7.6	5	□	MHS0760L060B	39.4	61.4	61.4	111.4	110	1.4	8	4
7.6	9	□	MHS0760L090B	69.8	91.4	91.4	141.4	140	1.4	8	4
7.6	13	□	MHS0760L120B	100.2	121.4	121.4	171.4	170	1.4	8	4
7.6	17	□	MHS0760L150B	130.6	151.4	151.4	201.4	200	1.4	8	4
7.6	24	□	MHS0760L200B	183.8	201.4	201.4	251.4	250	1.4	8	4
7.6	30	□	MHS0760L250B	229.4	251.4	251.4	301.4	300	1.4	8	4
7.7	1	□	MHS0770L030B	9.0	31.3	31.3	81.3	80	1.3	8	3
7.7	5	□	MHS0770L060B	39.9	61.4	61.4	111.4	110	1.4	8	4
7.7	9	□	MHS0770L090B	70.7	91.4	91.4	141.4	140	1.4	8	4
7.7	13	□	MHS0770L120B	101.5	121.4	121.4	171.4	170	1.4	8	4
7.7	17	□	MHS0770L150B	132.3	151.4	151.4	201.4	200	1.4	8	4
7.7	23	□	MHS0770L200B	178.5	201.4	201.4	251.4	250	1.4	8	4
7.7	30	□	MHS0770L250B	232.4	251.4	251.4	301.4	300	1.4	8	4
7.8	1	●	MHS0780L030B	9.1	31.3	31.3	81.3	80	1.3	8	3
7.8	5	●	MHS0780L060B	40.4	61.4	61.4	111.4	110	1.4	8	4
7.8	9	●	MHS0780L090B	71.6	91.4	91.4	141.4	140	1.4	8	4
7.8	13	●	MHS0780L120B	102.8	121.4	121.4	171.4	170	1.4	8	4
7.8	17	●	MHS0780L150B	134.0	151.4	151.4	201.4	200	1.4	8	4
7.8	23	●	MHS0780L200B	180.8	201.4	201.4	251.4	250	1.4	8	4

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.8	30	●	MHS0780L250B	235.4	251.4	251.4	301.4	300	1.4	8	4
7.9	1	□	MHS0790L030B	9.3	31.4	31.4	81.4	80	1.4	8	3
7.9	5	□	MHS0790L060B	40.9	61.4	61.4	111.4	110	1.4	8	4
7.9	9	□	MHS0790L090B	72.5	91.4	91.4	141.4	140	1.4	8	4
7.9	13	□	MHS0790L120B	104.1	121.4	121.4	171.4	170	1.4	8	4
7.9	16	□	MHS0790L150B	127.8	151.4	151.4	201.4	200	1.4	8	4
7.9	23	□	MHS0790L200B	183.1	201.4	201.4	251.4	250	1.4	8	4
7.9	29	□	MHS0790L250B	230.5	251.4	251.4	301.4	300	1.4	8	4
8.0	1	●	MHS0800L030B	9.4	31.4	31.4	81.4	80	1.4	8	3
8.0	5	●	MHS0800L060B	41.5	61.5	61.5	111.5	110	1.5	8	4
8.0	9	●	MHS0800L090B	73.5	91.5	91.5	141.5	140	1.5	8	4
8.0	12	●	MHS0800L120B	97.5	121.5	121.5	171.5	170	1.5	8	4
8.0	16	●	MHS0800L150B	129.5	151.5	151.5	201.5	200	1.5	8	4
8.0	22	●	MHS0800L200B	177.5	201.5	201.5	251.5	250	1.5	8	4
8.0	29	●	MHS0800L250B	233.5	251.5	251.5	301.5	300	1.5	8	4
8.1	2	□	MHS0810L040B	17.6	39.9	41.4	101.4	100	1.4	10	3
8.1	8	□	MHS0810L090B	66.3	90.0	91.5	151.5	150	1.5	10	4
8.1	12	□	MHS0810L120B	98.7	120.0	121.5	181.5	180	1.5	10	4
8.1	16	□	MHS0810L150B	131.1	150.0	151.5	211.5	210	1.5	10	4
8.1	22	□	MHS0810L200B	179.7	200.0	201.5	261.5	260	1.5	10	4
8.1	28	□	MHS0810L250B	228.3	250.0	251.5	311.5	310	1.5	10	4
8.2	2	□	MHS0820L040B	17.8	39.9	41.4	101.4	100	1.4	10	3
8.2	8	□	MHS0820L090B	67.1	90.0	91.5	151.5	150	1.5	10	4
8.2	12	□	MHS0820L120B	99.9	120.0	121.5	181.5	180	1.5	10	4
8.2	16	□	MHS0820L150B	132.7	150.0	151.5	211.5	210	1.5	10	4
8.2	22	□	MHS0820L200B	181.9	200.0	201.5	261.5	260	1.5	10	4
8.2	28	□	MHS0820L250B	231.1	250.0	251.5	311.5	310	1.5	10	4
8.3	2	□	MHS0830L040B	18.0	39.9	41.4	101.4	100	1.4	10	3
8.3	8	□	MHS0830L090B	67.9	90.0	91.5	151.5	150	1.5	10	4
8.3	12	□	MHS0830L120B	101.1	120.0	121.5	181.5	180	1.5	10	4
8.3	15	□	MHS0830L150B	126.0	150.0	151.5	211.5	210	1.5	10	4
8.3	21	□	MHS0830L200B	175.8	200.0	201.5	261.5	260	1.5	10	4
8.3	27	□	MHS0830L250B	225.6	250.0	251.5	311.5	310	1.5	10	4
8.4	2	□	MHS0840L040B	18.2	39.9	41.4	101.4	100	1.4	10	3
8.4	8	□	MHS0840L090B	68.7	90.0	91.5	151.5	150	1.5	10	4
8.4	12	□	MHS0840L120B	102.3	120.0	121.5	181.5	180	1.5	10	4
8.4	15	□	MHS0840L150B	127.5	150.0	151.5	211.5	210	1.5	10	4
8.4	21	□	MHS0840L200B	177.9	200.0	201.5	261.5	260	1.5	10	4
8.4	27	□	MHS0840L250B	228.3	250.0	251.5	311.5	310	1.5	10	4
8.5	2	●	MHS0850L040B	18.5	40.0	41.5	101.5	100	1.5	10	3
8.5	8	●	MHS0850L090B	69.5	90.0	91.5	151.5	150	1.5	10	4
8.5	11	●	MHS0850L120B	95.0	120.0	121.5	181.5	180	1.5	10	4
8.5	15	●	MHS0850L150B	129.0	150.0	151.5	211.5	210	1.5	10	4
8.5	21	●	MHS0850L200B	180.0	200.0	201.5	261.5	260	1.5	10	4
8.5	27	●	MHS0850L250B	231.0	250.0	251.5	311.5	310	1.5	10	4
8.6	2	□	MHS0860L040B	18.7	40.5	41.5	101.5	100	1.5	10	3
8.6	8	□	MHS0860L090B	70.4	90.6	91.6	151.6	150	1.6	10	4
8.6	11	□	MHS0860L120B	96.2	120.6	121.6	181.6	180	1.6	10	4

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.6	15	□	MHS0860L150B	130.6	150.6	151.6	211.6	210	1.6	10	4
8.6	21	□	MHS0860L200B	182.2	200.6	201.6	261.6	260	1.6	10	4
8.6	26	□	MHS0860L250B	225.2	250.6	251.6	311.6	310	1.6	10	4
8.7	2	□	MHS0870L040B	18.9	40.5	41.5	101.5	100	1.5	10	3
8.7	8	□	MHS0870L090B	71.2	90.6	91.6	151.6	150	1.6	10	4
8.7	11	□	MHS0870L120B	97.3	120.6	121.6	181.6	180	1.6	10	4
8.7	15	□	MHS0870L150B	132.1	150.6	151.6	211.6	210	1.6	10	4
8.7	20	□	MHS0870L200B	175.6	200.6	201.6	261.6	260	1.6	10	4
8.7	26	□	MHS0870L250B	227.8	250.6	251.6	311.6	310	1.6	10	4
8.8	2	●	MHS0880L040B	19.1	40.5	41.5	101.5	100	1.5	10	3
8.8	8	●	MHS0880L090B	72.0	90.6	91.6	151.6	150	1.6	10	4
8.8	11	●	MHS0880L120B	98.4	120.6	121.6	181.6	180	1.6	10	4
8.8	14	●	MHS0880L150B	124.8	150.6	151.6	211.6	210	1.6	10	4
8.8	20	●	MHS0880L200B	177.6	200.6	201.6	261.6	260	1.6	10	4
8.8	26	●	MHS0880L250B	230.4	250.6	251.6	311.6	310	1.6	10	4
8.9	2	□	MHS0890L040B	19.3	40.5	41.5	101.5	100	1.5	10	3
8.9	7	□	MHS0890L090B	63.9	90.6	91.6	151.6	150	1.6	10	4
8.9	11	□	MHS0890L120B	99.5	120.6	121.6	181.6	180	1.6	10	4
8.9	14	□	MHS0890L150B	126.2	150.6	151.6	211.6	210	1.6	10	4
8.9	20	□	MHS0890L200B	179.6	200.6	201.6	261.6	260	1.6	10	4
8.9	25	□	MHS0890L250B	224.1	250.6	251.6	311.6	310	1.6	10	4
9.0	2	●	MHS0900L040B	19.5	40.5	41.5	101.5	100	1.5	10	3
9.0	7	●	MHS0900L090B	64.6	90.6	91.6	151.6	150	1.6	10	4
9.0	11	●	MHS0900L120B	100.6	120.6	121.6	181.6	180	1.6	10	4
9.0	14	●	MHS0900L150B	127.6	150.6	151.6	211.6	210	1.6	10	4
9.0	20	●	MHS0900L200B	181.6	200.6	201.6	261.6	260	1.6	10	4
9.0	25	●	MHS0900L250B	226.6	250.6	251.6	311.6	310	1.6	10	4
9.1	2	□	MHS0910L040B	19.8	41.1	41.6	101.6	100	1.6	10	3
9.1	7	□	MHS0910L090B	65.4	91.2	91.7	151.7	150	1.7	10	4
9.1	11	□	MHS0910L120B	101.8	121.2	121.7	181.7	180	1.7	10	4
9.1	14	□	MHS0910L150B	129.1	151.2	151.7	211.7	210	1.7	10	4
9.1	19	□	MHS0910L200B	174.6	201.2	201.7	261.7	260	1.7	10	4
9.1	25	□	MHS0910L250B	229.2	251.2	251.7	311.7	310	1.7	10	4
9.1	30	□	MHS0910L300B	274.7	301.2	301.7	361.7	360	1.7	10	4
9.2	2	□	MHS0920L040B	20.0	41.1	41.6	101.6	100	1.6	10	3
9.2	7	□	MHS0920L090B	66.1	91.2	91.7	151.7	150	1.7	10	4
9.2	10	□	MHS0920L120B	93.7	121.2	121.7	181.7	180	1.7	10	4
9.2	14	□	MHS0920L150B	130.5	151.2	151.7	211.7	210	1.7	10	4
9.2	19	□	MHS0920L200B	176.5	201.2	201.7	261.7	260	1.7	10	4
9.2	25	□	MHS0920L250B	231.7	251.2	251.7	311.7	310	1.7	10	4
9.2	30	□	MHS0920L300B	277.7	301.2	301.7	361.7	360	1.7	10	4
9.3	2	□	MHS0930L040B	20.2	41.1	41.6	101.6	100	1.6	10	3
9.3	7	□	MHS0930L090B	66.8	91.2	91.7	151.7	150	1.7	10	4
9.3	10	□	MHS0930L120B	94.7	121.2	121.7	181.7	180	1.7	10	4
9.3	14	□	MHS0930L150B	131.9	151.2	151.7	211.7	210	1.7	10	4
9.3	19	□	MHS0930L200B	178.4	201.2	201.7	261.7	260	1.7	10	4
9.3	24	□	MHS0930L250B	224.9	251.2	251.7	311.7	310	1.7	10	4
9.3	30	□	MHS0930L300B	280.7	301.2	301.7	361.7	360	1.7	10	4

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.4	2	□	MHS0940L040B	20.4	41.1	41.6	101.6	100	1.6	10	3
9.4	7	□	MHS0940L090B	67.5	91.2	91.7	151.7	150	1.7	10	4
9.4	10	□	MHS0940L120B	95.7	121.2	121.7	181.7	180	1.7	10	4
9.4	13	□	MHS0940L150B	123.9	151.2	151.7	211.7	210	1.7	10	4
9.4	19	□	MHS0940L200B	180.3	201.2	201.7	261.7	260	1.7	10	4
9.4	24	□	MHS0940L250B	227.3	251.2	251.7	311.7	310	1.7	10	4
9.4	29	□	MHS0940L300B	274.3	301.2	301.7	361.7	360	1.7	10	4
9.5	2	●	MHS0950L040B	20.6	41.1	41.6	101.6	100	1.6	10	3
9.5	7	●	MHS0950L090B	68.2	91.2	91.7	151.7	150	1.7	10	4
9.5	10	●	MHS0950L120B	96.7	121.2	121.7	181.7	180	1.7	10	4
9.5	13	●	MHS0950L150B	125.2	151.2	151.7	211.7	210	1.7	10	4
9.5	18	●	MHS0950L200B	172.7	201.2	201.7	261.7	260	1.7	10	4
9.5	24	●	MHS0950L250B	229.7	251.2	251.7	311.7	310	1.7	10	4
9.5	29	●	MHS0950L300B	277.2	301.2	301.7	361.7	360	1.7	10	4
9.6	2	□	MHS0960L040B	20.9	41.7	41.7	101.7	100	1.7	10	3
9.6	7	□	MHS0960L090B	68.9	91.7	91.7	151.7	150	1.7	10	4
9.6	10	□	MHS0960L120B	97.7	121.7	121.7	181.7	180	1.7	10	4
9.6	13	□	MHS0960L150B	126.5	151.7	151.7	211.7	210	1.7	10	4
9.6	18	□	MHS0960L200B	174.5	201.7	201.7	261.7	260	1.7	10	4
9.6	24	□	MHS0960L250B	232.1	251.7	251.7	311.7	310	1.7	10	4
9.6	29	□	MHS0960L300B	280.1	301.7	301.7	361.7	360	1.7	10	4
9.7	2	□	MHS0970L040B	21.1	41.7	41.7	101.7	100	1.7	10	3
9.7	7	□	MHS0970L090B	69.7	91.8	91.8	151.8	150	1.8	10	4
9.7	10	□	MHS0970L120B	98.8	121.8	121.8	181.8	180	1.8	10	4
9.7	13	□	MHS0970L150B	127.9	151.8	151.8	211.8	210	1.8	10	4
9.7	18	□	MHS0970L200B	176.4	201.8	201.8	261.8	260	1.8	10	4
9.7	23	□	MHS0970L250B	224.9	251.8	251.8	311.8	310	1.8	10	4
9.7	28	□	MHS0970L300B	273.4	301.8	301.8	361.8	360	1.8	10	4
9.8	2	●	MHS0980L040B	21.3	41.7	41.7	101.7	100	1.7	10	3
9.8	7	●	MHS0980L090B	70.4	91.8	91.8	151.8	150	1.8	10	4
9.8	10	●	MHS0980L120B	99.8	121.8	121.8	181.8	180	1.8	10	4
9.8	13	●	MHS0980L150B	129.2	151.8	151.8	211.8	210	1.8	10	4
9.8	18	●	MHS0980L200B	178.2	201.8	201.8	261.8	260	1.8	10	4
9.8	23	●	MHS0980L250B	227.2	251.8	251.8	311.8	310	1.8	10	4
9.8	28	●	MHS0980L300B	276.2	301.8	301.8	361.8	360	1.8	10	4
9.9	2	□	MHS0990L040B	21.5	41.7	41.7	101.7	100	1.7	10	3
9.9	7	□	MHS0990L090B	71.1	91.8	91.8	151.8	150	1.8	10	4
9.9	10	□	MHS0990L120B	100.8	121.8	121.8	181.8	180	1.8	10	4
9.9	13	□	MHS0990L150B	130.5	151.8	151.8	211.8	210	1.8	10	4
9.9	18	□	MHS0990L200B	180.0	201.8	201.8	261.8	260	1.8	10	4
9.9	23	□	MHS0990L250B	229.5	251.8	251.8	311.8	310	1.8	10	4
9.9	28	□	MHS0990L300B	279.0	301.8	301.8	361.8	360	1.8	10	4
10.0	1	●	MHS1000L040B	11.7	41.7	41.7	101.7	100	1.7	10	3
10.0	6	●	MHS1000L090B	61.8	91.8	91.8	151.8	150	1.8	10	4
10.0	9	●	MHS1000L120B	91.8	121.8	121.8	181.8	180	1.8	10	4
10.0	12	●	MHS1000L150B	121.8	151.8	151.8	211.8	210	1.8	10	4
10.0	17	●	MHS1000L200B	171.8	201.8	201.8	261.8	260	1.8	10	4
10.0	22	●	MHS1000L250B	221.8	251.8	251.8	311.8	310	1.8	10	4

CUTTING CONDITIONS ➤ P072
OPERATION GUIDANCE ➤ P074
TECHNICAL DATA ➤ R001

MHS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.0	27	●	MHS1000L300B	271.8	301.8	301.8	361.8	360	1.8	10	4
10.1	1	□	MHS1010L040B	11.8	40.2	41.7	101.7	100	1.7	12	3
10.1	6	□	MHS1010L090B	62.4	90.3	91.8	151.8	150	1.8	12	4
10.1	9	□	MHS1010L120B	92.7	120.3	121.8	181.8	180	1.8	12	4
10.1	12	□	MHS1010L150B	123.0	150.3	151.8	211.8	210	1.8	12	4
10.1	17	□	MHS1010L200B	173.5	200.3	201.8	261.8	260	1.8	12	4
10.1	22	□	MHS1010L250B	224.0	250.3	251.8	311.8	310	1.8	12	4
10.1	27	□	MHS1010L300B	274.5	300.3	301.8	361.8	360	1.8	12	4
10.2	1	□	MHS1020L040B	12.0	40.3	41.8	101.8	100	1.8	12	3
10.2	6	□	MHS1020L090B	63.1	90.4	91.9	151.9	150	1.9	12	4
10.2	9	□	MHS1020L120B	93.7	120.4	121.9	181.9	180	1.9	12	4
10.2	12	□	MHS1020L150B	124.3	150.4	151.9	211.9	210	1.9	12	4
10.2	17	□	MHS1020L200B	175.3	200.4	201.9	261.9	260	1.9	12	4
10.2	22	□	MHS1020L250B	226.3	250.4	251.9	311.9	310	1.9	12	4
10.2	27	□	MHS1020L300B	277.3	300.4	301.9	361.9	360	1.9	12	4
10.3	1	□	MHS1030L040B	12.1	40.3	41.8	101.8	100	1.8	12	3
10.3	6	□	MHS1030L090B	63.7	90.4	91.9	151.9	150	1.9	12	4
10.3	9	□	MHS1030L120B	94.6	120.4	121.9	181.9	180	1.9	12	4
10.3	12	□	MHS1030L150B	125.5	150.4	151.9	211.9	210	1.9	12	4
10.3	17	□	MHS1030L200B	177.0	200.4	201.9	261.9	260	1.9	12	4
10.3	22	□	MHS1030L250B	228.5	250.4	251.9	311.9	310	1.9	12	4
10.3	26	□	MHS1030L300B	269.7	300.4	301.9	361.9	360	1.9	12	4
10.4	1	□	MHS1040L040B	12.2	40.3	41.8	101.8	100	1.8	12	3
10.4	6	□	MHS1040L090B	64.3	90.4	91.9	151.9	150	1.9	12	4
10.4	9	□	MHS1040L120B	95.5	120.4	121.9	181.9	180	1.9	12	4
10.4	12	□	MHS1040L150B	126.7	150.4	151.9	211.9	210	1.9	12	4
10.4	17	□	MHS1040L200B	178.7	200.4	201.9	261.9	260	1.9	12	4
10.4	21	□	MHS1040L250B	220.3	250.4	251.9	311.9	310	1.9	12	4
10.4	26	□	MHS1040L300B	272.3	300.4	301.9	361.9	360	1.9	12	4
10.5	1	●	MHS1050L040B	12.3	40.3	41.8	101.8	100	1.8	12	3
10.5	6	●	MHS1050L090B	64.9	90.4	91.9	151.9	150	1.9	12	4
10.5	9	●	MHS1050L120B	96.4	120.4	121.9	181.9	180	1.9	12	4
10.5	12	●	MHS1050L150B	127.9	150.4	151.9	211.9	210	1.9	12	4
10.5	16	●	MHS1050L200B	169.9	200.4	201.9	261.9	260	1.9	12	4
10.5	21	●	MHS1050L250B	222.4	250.4	251.9	311.9	310	1.9	12	4
10.5	26	●	MHS1050L300B	274.9	300.4	301.9	361.9	360	1.9	12	4
10.6	1	□	MHS1060L040B	12.4	40.8	41.8	101.8	100	1.8	12	3
10.6	6	□	MHS1060L090B	65.5	90.9	91.9	151.9	150	1.9	12	4
10.6	9	□	MHS1060L120B	97.3	120.9	121.9	181.9	180	1.9	12	4
10.6	12	□	MHS1060L150B	129.1	150.9	151.9	211.9	210	1.9	12	4
10.6	16	□	MHS1060L200B	171.5	200.9	201.9	261.9	260	1.9	12	4
10.6	21	□	MHS1060L250B	224.5	250.9	251.9	311.9	310	1.9	12	4
10.6	26	□	MHS1060L300B	277.5	300.9	301.9	361.9	360	1.9	12	4
10.7	1	□	MHS1070L040B	12.5	40.8	41.8	101.8	100	1.8	12	3
10.7	6	□	MHS1070L090B	66.1	90.9	91.9	151.9	150	1.9	12	4
10.7	9	□	MHS1070L120B	98.2	120.9	121.9	181.9	180	1.9	12	4
10.7	11	□	MHS1070L150B	119.6	150.9	151.9	211.9	210	1.9	12	4
10.7	16	□	MHS1070L200B	173.1	200.9	201.9	261.9	260	1.9	12	4

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.7	21	□	MHS1070L250B	226.6	250.9	251.9	311.9	310	1.9	12	4
10.7	25	□	MHS1070L300B	269.4	300.9	301.9	361.9	360	1.9	12	4
10.8	1	●	MHS1080L040B	12.7	40.9	41.9	101.9	100	1.9	12	3
10.8	6	●	MHS1080L090B	66.8	91.0	92.0	152.0	150	2.0	12	4
10.8	9	●	MHS1080L120B	99.2	121.0	122.0	182.0	180	2.0	12	4
10.8	11	●	MHS1080L150B	120.8	151.0	152.0	212.0	210	2.0	12	4
10.8	16	●	MHS1080L200B	174.8	201.0	202.0	262.0	260	2.0	12	4
10.8	21	●	MHS1080L250B	228.8	251.0	252.0	312.0	310	2.0	12	4
10.8	25	●	MHS1080L300B	272.0	301.0	302.0	362.0	360	2.0	12	4
10.9	1	□	MHS1090L040B	12.8	40.9	41.9	101.9	100	1.9	12	3
10.9	6	□	MHS1090L090B	67.4	91.0	92.0	152.0	150	2.0	12	4
10.9	8	□	MHS1090L120B	89.2	121.0	122.0	182.0	180	2.0	12	4
10.9	11	□	MHS1090L150B	121.9	151.0	152.0	212.0	210	2.0	12	4
10.9	16	□	MHS1090L200B	176.4	201.0	202.0	262.0	260	2.0	12	4
10.9	20	□	MHS1090L250B	220.0	251.0	252.0	312.0	310	2.0	12	4
10.9	25	□	MHS1090L300B	274.5	301.0	302.0	362.0	360	2.0	12	4
11.0	1	●	MHS1100L040B	12.9	40.9	41.9	101.9	100	1.9	12	3
11.0	6	●	MHS1100L090B	68.0	91.0	92.0	152.0	150	2.0	12	4
11.0	8	●	MHS1100L120B	90.0	121.0	122.0	182.0	180	2.0	12	4
11.0	11	●	MHS1100L150B	123.0	151.0	152.0	212.0	210	2.0	12	4
11.0	16	●	MHS1100L200B	178.0	201.0	202.0	262.0	260	2.0	12	4
11.0	20	●	MHS1100L250B	222.0	251.0	252.0	312.0	310	2.0	12	4
11.0	25	●	MHS1100L300B	277.0	301.0	302.0	362.0	360	2.0	12	4
11.1	1	□	MHS1110L040B	13.0	41.4	41.9	101.9	100	1.9	12	3
11.1	6	□	MHS1110L090B	68.6	91.5	92.0	152.0	150	2.0	12	4
11.1	8	□	MHS1110L120B	90.8	121.5	122.0	182.0	180	2.0	12	4
11.1	11	□	MHS1110L150B	124.1	151.5	152.0	212.0	210	2.0	12	4
11.1	15	□	MHS1110L200B	168.5	201.5	202.0	262.0	260	2.0	12	4
11.1	20	□	MHS1110L250B	224.0	251.5	252.0	312.0	310	2.0	12	4
11.1	24	□	MHS1110L300B	268.4	301.5	302.0	362.0	360	2.0	12	4
11.2	1	□	MHS1120L040B	13.1	41.4	41.9	101.9	100	1.9	12	3
11.2	5	□	MHS1120L090B	58.0	91.5	92.0	152.0	150	2.0	12	4
11.2	8	□	MHS1120L120B	91.6	121.5	122.0	182.0	180	2.0	12	4
11.2	11	□	MHS1120L150B	125.2	151.5	152.0	212.0	210	2.0	12	4
11.2	15	□	MHS1120L200B	170.0	201.5	202.0	262.0	260	2.0	12	4
11.2	20	□	MHS1120L250B	226.0	251.5	252.0	312.0	310	2.0	12	4
11.2	24	□	MHS1120L300B	270.8	301.5	302.0	362.0	360	2.0	12	4
11.3	1	□	MHS1130L040B	13.2	41.4	41.9	101.9	100	1.9	12	3
11.3	5	□	MHS1130L090B	58.6	91.6	92.1	152.1	150	2.1	12	4
11.3	8	□	MHS1130L120B	92.5	121.6	122.1	182.1	180	2.1	12	4
11.3	11	□	MHS1130L150B	126.4	151.6	152.1	212.1	210	2.1	12	4
11.3	15	□	MHS1130L200B	171.6	201.6	202.1	262.1	260	2.1	12	4
11.3	20	□	MHS1130L250B	228.1	251.6	252.1	312.1	310	2.1	12	4
11.3	24	□	MHS1130L300B	273.3	301.6	302.1	362.1	360	2.1	12	4
11.4	1	□	MHS1140L040B	13.4	41.5	42.0	102.0	100	2.0	12	3
11.4	5	□	MHS1140L090B	59.1	91.6	92.1	152.1	150	2.1	12	4
11.4	8	□	MHS1140L120B	93.3	121.6	122.1	182.1	180	2.1	12	4
11.4	11	□	MHS1140L150B	127.5	151.6	152.1	212.1	210	2.1	12	4

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.4	15	□	MHS1140L200B	173.1	201.6	202.1	262.1	260	2.1	12	4
11.4	19	□	MHS1140L250B	218.7	251.6	252.1	312.1	310	2.1	12	4
11.4	24	□	MHS1140L300B	275.7	301.6	302.1	362.1	360	2.1	12	4
11.5	1	●	MHS1150L040B	13.5	41.5	42.0	102.0	100	2.0	12	3
11.5	5	●	MHS1150L090B	59.6	91.6	92.1	152.1	150	2.1	12	4
11.5	8	●	MHS1150L120B	94.1	121.6	122.1	182.1	180	2.1	12	4
11.5	10	●	MHS1150L150B	117.1	151.6	152.1	212.1	210	2.1	12	4
11.5	15	●	MHS1150L200B	174.6	201.6	202.1	262.1	260	2.1	12	4
11.5	19	●	MHS1150L250B	220.6	251.6	252.1	312.1	310	2.1	12	4
11.5	24	●	MHS1150L300B	278.1	301.6	302.1	362.1	360	2.1	12	4
11.6	1	□	MHS1160L040B	13.6	42.0	42.0	102.0	100	2.0	12	3
11.6	5	□	MHS1160L090B	60.1	92.1	92.1	152.1	150	2.1	12	4
11.6	8	□	MHS1160L120B	94.9	122.1	122.1	182.1	180	2.1	12	4
11.6	10	□	MHS1160L150B	118.1	152.1	152.1	212.1	210	2.1	12	4
11.6	15	□	MHS1160L200B	176.1	202.1	202.1	262.1	260	2.1	12	4
11.6	19	□	MHS1160L250B	222.5	252.1	252.1	312.1	310	2.1	12	4
11.6	23	□	MHS1160L300B	268.9	302.1	302.1	362.1	360	2.1	12	4
11.7	1	□	MHS1170L040B	13.7	42.0	42.0	102.0	100	2.0	12	3
11.7	5	□	MHS1170L090B	60.6	92.1	92.1	152.1	150	2.1	12	4
11.7	8	□	MHS1170L120B	95.7	122.1	122.1	182.1	180	2.1	12	4
11.7	10	□	MHS1170L150B	119.1	152.1	152.1	212.1	210	2.1	12	4
11.7	15	□	MHS1170L200B	177.6	202.1	202.1	262.1	260	2.1	12	4
11.7	19	□	MHS1170L250B	224.4	252.1	252.1	312.1	310	2.1	12	4
11.7	23	□	MHS1170L300B	271.2	302.1	302.1	362.1	360	2.1	12	4

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.8	1	●	MHS1180L040B	13.8	42.0	42.0	102.0	100	2.0	12	3
11.8	5	●	MHS1180L090B	61.1	92.1	92.1	152.1	150	2.1	12	4
11.8	8	●	MHS1180L120B	96.5	122.1	122.1	182.1	180	2.1	12	4
11.8	10	●	MHS1180L150B	120.1	152.1	152.1	212.1	210	2.1	12	4
11.8	14	●	MHS1180L200B	167.3	202.1	202.1	262.1	260	2.1	12	4
11.8	19	●	MHS1180L250B	226.3	252.1	252.1	312.1	310	2.1	12	4
11.8	23	●	MHS1180L300B	273.5	302.1	302.1	362.1	360	2.1	12	4
11.9	1	□	MHS1190L040B	13.9	42.0	42.0	102.0	100	2.0	12	3
11.9	5	□	MHS1190L090B	61.7	92.2	92.2	152.2	150	2.2	12	4
11.9	8	□	MHS1190L120B	97.4	122.2	122.2	182.2	180	2.2	12	4
11.9	10	□	MHS1190L150B	121.2	152.2	152.2	212.2	210	2.2	12	4
11.9	14	□	MHS1190L200B	168.8	202.2	202.2	262.2	260	2.2	12	4
11.9	19	□	MHS1190L250B	228.3	252.2	252.2	312.2	310	2.2	12	4
11.9	23	□	MHS1190L300B	275.9	302.2	302.2	362.2	360	2.2	12	4
12.0	1	●	MHS1200L040B	14.1	42.1	42.1	102.1	100	2.1	12	3
12.0	5	●	MHS1200L090B	62.2	92.2	92.2	152.2	150	2.2	12	4
12.0	7	●	MHS1200L120B	86.2	122.2	122.2	182.2	180	2.2	12	4
12.0	10	●	MHS1200L150B	122.2	152.2	152.2	212.2	210	2.2	12	4
12.0	14	●	MHS1200L200B	170.2	202.2	202.2	262.2	260	2.2	12	4
12.0	18	●	MHS1200L250B	218.2	252.2	252.2	312.2	310	2.2	12	4
12.0	22	●	MHS1200L300B	266.2	302.2	302.2	362.2	360	2.2	12	4

CUTTING CONDITIONS ➢ P072
OPERATION GUIDANCE ➢ P074
TECHNICAL DATA ➢ R001

MHS

WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB), Carbon Steel, Alloy Steel (180−280HB) AISI 1010, AISI 1045, AISI 4140 etc				Ferritic and Martensitic Stainless Steel (>200HB) AISI 431, AISI 420 etc			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
1	40	12700	0.030 (0.020−0.040)	380	20	6400	0.030 (0.020−0.040)	190
1.2	50	13300	0.035 (0.025−0.050)	465	30	8000	0.035 (0.025−0.050)	280
1.6	60	11900	0.050 (0.030−0.065)	595	40	8000	0.050 (0.030−0.065)	400
2	70	11100	0.060 (0.040−0.080)	665	50	8000	0.060 (0.040−0.080)	480
2.5	80	10200	0.075 (0.050−0.100)	765	60	7600	0.075 (0.050−0.100)	570
3.2	80	8000	0.100 (0.070−0.130)	800	60	6000	0.100 (0.070−0.130)	600
4	80	6400	0.100 (0.090−0.110)	640	60	4800	0.090 (0.080−0.090)	430
5	80	5100	0.130 (0.110−0.140)	665	60	3800	0.110 (0.100−0.120)	420
6.3	80	4000	0.160 (0.140−0.180)	640	60	3000	0.140 (0.130−0.150)	420
8	80	3200	0.200 (0.180−0.230)	640	60	2400	0.170 (0.160−0.190)	410
10	80	2600	0.250 (0.220−0.280)	650	60	1900	0.220 (0.200−0.230)	420
12	80	2100	0.300 (0.270−0.340)	630	60	1600	0.260 (0.240−0.280)	415

Work Material	Pre-hardened Steel (35−45HRC), Alloy Tool Steel (≤350) AISI P21, AISI P20, ASTM H13, AISI L6 etc				Stainless Steel (40−55HRC), Precipitation Hardening Stainless Steel (<450HB) AISI 431, AISI 420, STAVAX, S17400, S17700 etc			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
1	20	6400	0.025 (0.020−0.030)	160	40	12700	0.020 (0.015−0.025)	255
1.2	30	8000	0.030 (0.020−0.035)	240	40	10600	0.025 (0.020−0.030)	265
1.6	40	8000	0.040 (0.030−0.045)	320	50	10000	0.035 (0.025−0.040)	350
2	50	8000	0.045 (0.035−0.060)	360	50	8000	0.040 (0.030−0.050)	320
2.5	60	7600	0.060 (0.045−0.075)	455	60	7600	0.050 (0.040−0.065)	380
3.2	60	6000	0.080 (0.060−0.090)	480	60	6000	0.060 (0.050−0.080)	360
4	60	4800	0.080 (0.070−0.100)	385	60	4800	0.080 (0.060−0.100)	385
5	60	3800	0.110 (0.090−0.130)	420	60	3800	0.100 (0.080−0.130)	380
6.3	60	3000	0.130 (0.110−0.160)	390	60	3000	0.110 (0.090−0.130)	330
8	60	2400	0.170 (0.140−0.200)	410	60	2400	0.140 (0.120−0.160)	335
10	60	1900	0.210 (0.170−0.250)	400	60	1900	0.170 (0.140−0.200)	325
12	60	1600	0.250 (0.210−0.300)	400	60	1600	0.210 (0.170−0.240)	335

Work Material	Hardened Steel (40－55HRC), Heat Resistant Alloy AISI H13, L6, Inconel718 etc			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
1	10	3200	0.015 (0.015－0.020)	50
1.2	10	2700	0.020 (0.015－0.025)	55
1.6	10	2000	0.025 (0.020－0.030)	50
2	20	3200	0.035 (0.025－0.040)	110
2.5	20	2600	0.040 (0.030－0.050)	105
3.2	20	2000	0.050 (0.040－0.070)	100
4	30	2400	0.070 (0.050－0.080)	170
5	30	1900	0.080 (0.060－0.100)	150
6.3	30	1500	0.090 (0.080－0.110)	135
8	40	1600	0.120 (0.100－0.130)	190
10	40	1300	0.150 (0.130－0.170)	195
12	40	1100	0.180 (0.150－0.200)	200

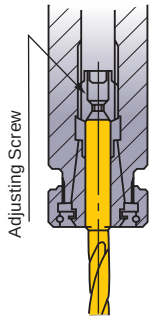
Note 1) When using the drill with a length over L/D 10, it is necessary to use a prep holes as a guide.
(If no prep-hole is used then drill breakage can occur)
Note 2) Setting of the diameter tolerance differs from general-purpose drills. MHS shortest flute drills are recommended for prep hole machining.
Note 3) MHS drills are suitable for use with shrink fit holders.
Note 4) Use the shortest type in the respective diameter as a pilot drill.

MHS

WSTAR DRILLS

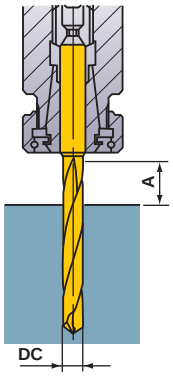
OPERATIONAL GUIDANCE

Drill Holding



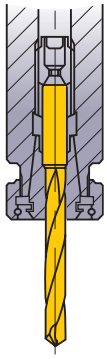
Thrust bearing type collet chuck holds the drill securely.

Drill Length



A ≥ DC x 2

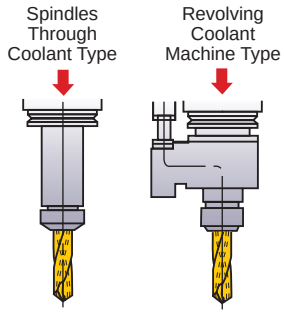
Drill Installation



NG

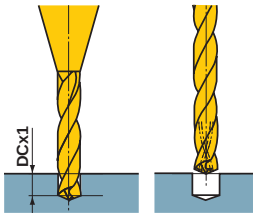
Do not clamp on the flutes.

Coolant Method



Less than ø3mm : 1.5MPa-7MP
More than ø3mm : 0.5MPa-7MPa
More than 3MPa is recommended.

Drill Installation



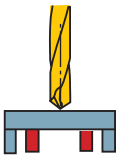
1) Make approx. DCx1(DC=drill diameter) pilot hole by using the MHS with the shortest flutes.
2) Use the pilot hole as a guide and machine by the drill with coolant hole. Depending on the application, carry out pecking.

Coolant Handling

1) Small particles of swarf will jam in the oil hole of small diameter drills. Always use a fine mesh filter as a preventative measure.

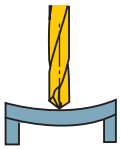
2) Dirt and dust particles adhere to the oil in old coolant and prevent an efficient flow. Regular coolant exchange is recommended.

Thin Workpiece



Support the Workpiece

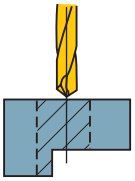
OK



If Bending Occurs

NG

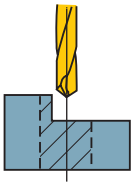
Interrupted Cutting



One Process

OK

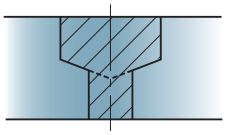
①Lower the feed when drilling the interrupted part.



Requires Prior Machining

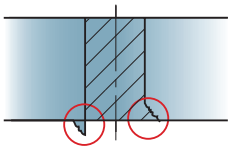
①Spot face with an end mill prior to drilling.

Stepped Holes



①Divide the two processes.
②Drill the larger hole first.
*A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping

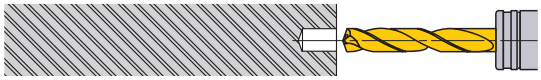


①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

■ OPERATIONAL GUIDANCE FOR THE MHS LONG TYPE DRILL (L/D≥10)

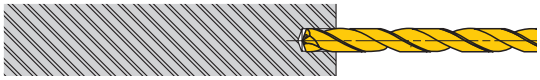
FLAT FACE DRILLING ●Drilling a blind hole

■ 1. Drilling a pilot hole



①Use a drill with a larger (flatter) point angle than the super long type. Use the shortest flute possible.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 2. Initial cutting with the long type drill



①Penetrate the guide hole at low revolution. (Revolution 1000min^{-1}, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 1—3mm short of the guide hole bottom.

■ 3. Drill the deep hole

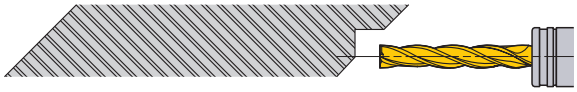
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 4. Drill retraction

①After drilling, lower the cutting revolution about 0.5—1mm short of the hole end. (Revolution of around 1000min^{-1})
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.
③Finally, clear the hole at a cutting speed of 20—30m/min and feed rate of 0.2—0.3mm/rev.

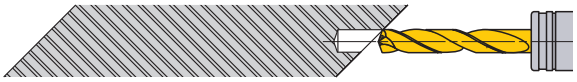
INTERRUPED DRILLING ●Drilling and breaking through on irregular faces or angles

■ 1. Spot facing



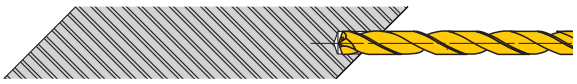
①Machine a flat or the irregular face by using an end mill or slot drill capable of spot facing. Make the spot face diameter the same size as the required deep hole diameter.

■ 2. Drilling a pilot hole



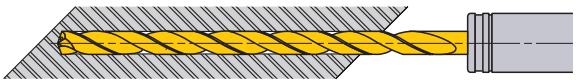
①Use a drill with a larger (flatter) point angle than the super long type. Use the shortest flute possible.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 3. Initial cutting with the long type drill



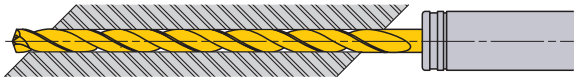
①Penetrate the guide hole at a low revolution. (Revolution 1000min^{-1}, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 0.5—1mm short of the guide hole bottom.

■ 4. Drill the deep hole



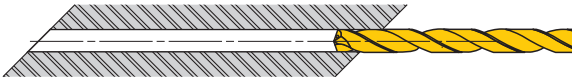
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 5. Breaking through



①When breaking through, the cutting edge can be damaged.
②Lower the feed rate when penetrating.

■ 6. Drill retraction



①Finally clear the hole at a feed rate of 0.2—0.3mm/rev. (Revolution of around 1000min^{-1})
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.

MNS

WSTAR DRILLS

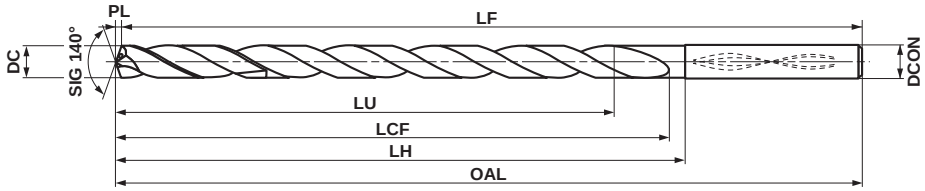
- 4 holes special coolant system, good for resistance to adhesion.
- High efficiency drilling for aluminium alloy.

TOOL NEWS

P | M | K | **N** | S | H

Non-ferrous Metal

Internal Coolant



DC=3	3<DC≤6	6<DC≤10	10<DC≤14
0 −0.014	0 −0.018	0 −0.022	0 −0.027
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤14**
0 −0.006	0 −0.008	0 −0.009	0 −0.011

Note 1) MNS drills are suitable for use with shrink fit holders.
Note 2) 4.5 or smaller diameter drills are designed with 2 colant holes.

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
3.0	5	●	MNS0300LB	15.5	33.5	33.5	81.5	81	0.5	3
3.0	10	●	MNS0300X10DB	30.5	39.5	42.5	90.5	90	0.5	3
3.0	20	●	MNS0300X20DB	60.5	69.5	72.5	120.5	120	0.5	3
3.0	30	●	MNS0300X30DB	90.5	99.5	102.5	150.5	150	0.5	3
3.1	5	●	MNS0310LB	16.1	39.6	39.6	87.6	87	0.6	4
3.1	10	□	MNS0310X10DB	31.6	46.6	49.6	97.6	97	0.6	4
3.1	20	□	MNS0310X20DB	62.6	81.6	84.6	132.6	132	0.6	4
3.1	30	□	MNS0310X30DB	93.6	116.6	119.6	167.6	167	0.6	4
3.2	5	●	MNS0320LB	16.6	39.6	39.6	87.6	87	0.6	4
3.2	10	●	MNS0320X10DB	32.6	46.6	49.6	97.6	97	0.6	4
3.2	20	●	MNS0320X20DB	64.6	81.6	84.6	132.6	132	0.6	4
3.2	30	●	MNS0320X30DB	96.6	116.6	119.6	167.6	167	0.6	4
3.3	5	●	MNS0330LB	17.1	39.6	39.6	87.6	87	0.6	4
3.3	10	□	MNS0330X10DB	33.6	46.6	49.6	97.6	97	0.6	4
3.3	20	□	MNS0330X20DB	66.6	81.6	84.6	132.6	132	0.6	4
3.3	30	□	MNS0330X30DB	99.6	116.6	119.6	167.6	167	0.6	4
3.4	5	●	MNS0340LB	17.6	39.6	39.6	87.6	87	0.6	4
3.4	10	●	MNS0340X10DB	34.6	46.6	49.6	97.6	97	0.6	4
3.4	20	●	MNS0340X20DB	68.6	81.6	84.6	132.6	132	0.6	4
3.4	30	●	MNS0340X30DB	102.6	116.6	119.6	167.6	167	0.6	4
3.5	5	●	MNS0350LB	18.1	39.6	39.6	87.6	87	0.6	4
3.5	10	□	MNS0350X10DB	35.6	46.6	49.6	97.6	97	0.6	4
3.5	20	□	MNS0350X20DB	70.6	81.6	84.6	132.6	132	0.6	4
3.5	30	□	MNS0350X30DB	105.6	116.6	119.6	167.6	167	0.6	4
3.6	5	●	MNS0360LB	18.7	44.7	44.7	92.7	92	0.7	4
3.6	10	●	MNS0360X10DB	36.7	52.7	55.7	103.7	103	0.7	4
3.6	20	●	MNS0360X20DB	72.7	92.7	95.7	143.7	143	0.7	4
3.6	30	●	MNS0360X30DB	108.7	132.7	135.7	183.7	183	0.7	4

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
3.7	5	●	MNS0370LB	19.2	44.7	44.7	92.7	92	0.7	4
3.7	10	□	MNS0370X10DB	37.7	52.7	55.7	103.7	103	0.7	4
3.7	20	□	MNS0370X20DB	74.7	92.7	95.7	143.7	143	0.7	4
3.7	30	□	MNS0370X30DB	111.7	132.7	135.7	183.7	183	0.7	4
3.8	5	●	MNS0380LB	19.7	44.7	44.7	92.7	92	0.7	4
3.8	10	□	MNS0380X10DB	38.7	52.7	55.7	103.7	103	0.7	4
3.8	20	□	MNS0380X20DB	76.7	92.7	95.7	143.7	143	0.7	4
3.8	30	□	MNS0380X30DB	114.7	132.7	135.7	183.7	183	0.7	4
3.9	5	●	MNS0390LB	20.2	44.7	44.7	92.7	92	0.7	4
3.9	10	●	MNS0390X10DB	39.7	52.7	55.7	103.7	103	0.7	4
3.9	20	●	MNS0390X20DB	78.7	92.7	95.7	143.7	143	0.7	4
3.9	30	●	MNS0390X30DB	117.7	132.7	135.7	183.7	183	0.7	4
4.0	5	●	MNS0400LB	20.7	44.7	44.7	92.7	92	0.7	4
4.0	10	●	MNS0400X10DB	40.7	52.7	55.7	103.7	103	0.7	4
4.0	20	●	MNS0400X20DB	80.7	92.7	95.7	143.7	143	0.7	4
4.0	30	●	MNS0400X30DB	120.7	132.7	135.7	183.7	183	0.7	4
4.1	5	●	MNS0410LB	21.2	50.7	50.7	100.7	100	0.7	5
4.1	10	□	MNS0410X10DB	41.7	59.7	62.7	112.7	112	0.7	5
4.1	20	□	MNS0410X20DB	82.7	104.7	107.7	157.7	157	0.7	5
4.1	30	□	MNS0410X30DB	123.7	149.7	152.7	202.7	202	0.7	5
4.2	5	●	MNS0420LB	21.8	50.8	50.8	100.8	100	0.8	5
4.2	10	□	MNS0420X10DB	42.8	59.8	62.8	112.8	112	0.8	5
4.2	20	□	MNS0420X20DB	84.8	104.8	107.8	157.8	157	0.8	5
4.2	30	□	MNS0420X30DB	126.8	149.8	152.8	202.8	202	0.8	5
4.3	5	●	MNS0430LB	22.3	50.8	50.8	100.8	100	0.8	5
4.3	10	□	MNS0430X10DB	43.8	59.8	62.8	112.8	112	0.8	5
4.3	20	□	MNS0430X20DB	86.8	104.8	107.8	157.8	157	0.8	5
4.3	30	□	MNS0430X30DB	129.8	149.8	152.8	202.8	202	0.8	5

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
4.4	5	●	MNS0440LB	22.8	50.8	50.8	100.8	100	0.8	5
4.4	10	□	MNS0440X10DB	44.8	59.8	62.8	112.8	112	0.8	5
4.4	20	□	MNS0440X20DB	88.8	104.8	107.8	157.8	157	0.8	5
4.4	30	□	MNS0440X30DB	132.8	149.8	152.8	202.8	202	0.8	5
4.5	5	●	MNS0450LB	23.3	50.8	50.8	100.8	100	0.8	5
4.5	10	□	MNS0450X10DB	45.8	59.8	62.8	112.8	112	0.8	5
4.5	20	□	MNS0450X20DB	90.8	104.8	107.8	157.8	157	0.8	5
4.5	30	□	MNS0450X30DB	135.8	149.8	152.8	202.8	202	0.8	5
4.6	5	●	MNS0460LB	23.8	55.8	55.8	105.8	105	0.8	5
4.6	10	□	MNS0460X10DB	46.8	65.8	68.8	118.8	118	0.8	5
4.6	20	□	MNS0460X20DB	92.8	115.8	118.8	168.8	168	0.8	5
4.6	30	□	MNS0460X30DB	138.8	165.8	168.8	218.8	218	0.8	5
4.7	5	●	MNS0470LB	24.4	55.9	55.9	105.9	105	0.9	5
4.7	10	□	MNS0470X10DB	47.9	65.9	68.9	118.9	118	0.9	5
4.7	20	□	MNS0470X20DB	94.9	115.9	118.9	168.9	168	0.9	5
4.7	30	□	MNS0470X30DB	141.9	165.9	168.9	218.9	218	0.9	5
4.8	5	●	MNS0480LB	24.9	55.9	55.9	105.9	105	0.9	5
4.8	10	□	MNS0480X10DB	48.9	65.9	68.9	118.9	118	0.9	5
4.8	20	□	MNS0480X20DB	96.9	115.9	118.9	168.9	168	0.9	5
4.8	30	□	MNS0480X30DB	144.9	165.9	168.9	218.9	218	0.9	5
4.9	5	●	MNS0490LB	25.4	55.9	55.9	105.9	105	0.9	5
4.9	10	●	MNS0490X10DB	49.9	65.9	68.9	118.9	118	0.9	5
4.9	20	●	MNS0490X20DB	98.9	115.9	118.9	168.9	168	0.9	5
4.9	30	●	MNS0490X30DB	147.9	165.9	168.9	218.9	218	0.9	5
5.0	5	●	MNS0500LB	25.9	44.9	44.9	100.9	100	0.9	6
5.0	10	●	MNS0500X10DB	50.9	65.9	68.9	118.9	118	0.9	5
5.0	20	●	MNS0500X20DB	100.9	115.9	118.9	168.9	168	0.9	5
5.0	30	●	MNS0500X30DB	150.9	165.9	168.9	218.9	218	0.9	5
5.1	5	●	MNS0510LB	26.4	44.9	44.9	100.9	100	0.9	6
5.1	10	●	MNS0510X10DB	51.9	72.9	75.9	127.9	127	0.9	6
5.1	20	●	MNS0510X20DB	102.9	127.9	130.9	182.9	182	0.9	6
5.1	30	●	MNS0510X30DB	153.9	182.9	185.9	237.9	237	0.9	6
5.2	5	●	MNS0520LB	26.9	44.9	44.9	100.9	100	0.9	6
5.2	10	□	MNS0520X10DB	52.9	72.9	75.9	127.9	127	0.9	6
5.2	20	□	MNS0520X20DB	104.9	127.9	130.9	182.9	182	0.9	6
5.2	30	□	MNS0520X30DB	156.9	182.9	185.9	237.9	237	0.9	6
5.3	5	●	MNS0530LB	27.5	45.0	45.0	101.0	100	1.0	6
5.3	10	□	MNS0530X10DB	54.0	73.0	76.0	128.0	127	1.0	6
5.3	20	□	MNS0530X20DB	107.0	128.0	131.0	183.0	182	1.0	6
5.3	30	□	MNS0530X30DB	160.0	183.0	186.0	238.0	237	1.0	6
5.4	5	●	MNS0540LB	28.0	45.0	45.0	101.0	100	1.0	6
5.4	10	□	MNS0540X10DB	55.0	73.0	76.0	128.0	127	1.0	6
5.4	20	□	MNS0540X20DB	109.0	128.0	131.0	183.0	182	1.0	6
5.4	30	□	MNS0540X30DB	163.0	183.0	186.0	238.0	237	1.0	6
5.5	5	●	MNS0550LB	28.5	45.0	45.0	101.0	100	1.0	6
5.5	10	●	MNS0550X10DB	56.0	73.0	76.0	128.0	127	1.0	6
5.5	20	●	MNS0550X20DB	111.0	128.0	131.0	183.0	182	1.0	6
5.5	30	●	MNS0550X30DB	166.0	183.0	186.0	238.0	237	1.0	6

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
5.6	5	●	MNS0560LB	29.0	49.0	49.0	101.0	100	1.0	6
5.6	10	□	MNS0560X10DB	57.0	79.0	82.0	134.0	133	1.0	6
5.6	20	□	MNS0560X20DB	113.0	139.0	142.0	194.0	193	1.0	6
5.6	30	□	MNS0560X30DB	169.0	199.0	202.0	254.0	253	1.0	6
5.7	5	●	MNS0570LB	29.5	49.0	49.0	101.0	100	1.0	6
5.7	10	□	MNS0570X10DB	58.0	79.0	82.0	134.0	133	1.0	6
5.7	20	□	MNS0570X20DB	115.0	139.0	142.0	194.0	193	1.0	6
5.7	30	□	MNS0570X30DB	172.0	199.0	202.0	254.0	253	1.0	6
5.8	5	●	MNS0580LB	30.1	49.1	49.1	101.1	100	1.1	6
5.8	10	□	MNS0580X10DB	59.1	79.1	82.1	134.1	133	1.1	6
5.8	20	□	MNS0580X20DB	117.1	139.1	142.1	194.1	193	1.1	6
5.8	30	□	MNS0580X30DB	175.1	199.1	202.1	254.1	253	1.1	6
5.9	5	●	MNS0590LB	30.6	49.1	49.1	101.1	100	1.1	6
5.9	10	□	MNS0590X10DB	60.1	79.1	82.1	134.1	133	1.1	6
5.9	20	□	MNS0590X20DB	119.1	139.1	142.1	194.1	193	1.1	6
5.9	30	□	MNS0590X30DB	178.1	199.1	202.1	254.1	253	1.1	6
6.0	5	●	MNS0600LB	31.1	49.1	49.1	101.1	100	1.1	6
6.0	10	●	MNS0600X10DB	61.1	79.1	82.1	134.1	133	1.1	6
6.0	20	●	MNS0600X20DB	121.1	139.1	142.1	194.1	193	1.1	6
6.0	30	●	MNS0600X30DB	181.1	199.1	202.1	254.1	253	1.1	6
6.1	5	●	MNS0610LB	31.6	53.1	53.1	110.1	109	1.1	7
6.1	10	●	MNS0610X10DB	62.1	86.1	89.1	142.1	141	1.1	7
6.1	20	●	MNS0610X20DB	123.1	151.1	154.1	207.1	206	1.1	7
6.1	30	●	MNS0610X30DB	184.1	216.1	219.1	272.1	271	1.1	7
6.2	5	●	MNS0620LB	32.1	53.1	53.1	110.1	109	1.1	7
6.2	10	□	MNS0620X10DB	63.1	86.1	89.1	142.1	141	1.1	7
6.2	20	□	MNS0620X20DB	125.1	151.1	154.1	207.1	206	1.1	7
6.2	30	□	MNS0620X30DB	187.1	216.1	219.1	272.1	271	1.1	7
6.3	5	●	MNS0630LB	32.6	53.1	53.1	110.1	109	1.1	7
6.3	10	□	MNS0630X10DB	64.1	86.1	89.1	142.1	141	1.1	7
6.3	20	□	MNS0630X20DB	127.1	151.1	154.1	207.1	206	1.1	7
6.3	30	□	MNS0630X30DB	190.1	216.1	219.1	272.1	271	1.1	7
6.4	5	●	MNS0640LB	33.2	53.2	53.2	110.2	109	1.2	7
6.4	10	□	MNS0640X10DB	65.2	86.2	89.2	142.2	141	1.2	7
6.4	20	□	MNS0640X20DB	129.2	151.2	154.2	207.2	206	1.2	7
6.4	30	□	MNS0640X30DB	193.2	216.2	219.2	272.2	271	1.2	7
6.5	5	●	MNS0650LB	33.7	53.2	53.2	110.2	109	1.2	7
6.5	10	●	MNS0650X10DB	66.2	86.2	89.2	142.2	141	1.2	7
6.5	20	●	MNS0650X20DB	131.2	151.2	154.2	207.2	206	1.2	7
6.5	30	●	MNS0650X30DB	196.2	216.2	219.2	272.2	271	1.2	7
6.6	5	●	MNS0660LB	34.2	57.2	57.2	110.2	109	1.2	7
6.6	10	□	MNS0660X10DB	67.2	92.2	95.2	148.2	147	1.2	7
6.6	20	□	MNS0660X20DB	133.2	162.2	165.2	218.2	217	1.2	7
6.6	30	□	MNS0660X30DB	199.2	232.2	235.2	288.2	287	1.2	7
6.7	5	●	MNS0670LB	34.7	57.2	57.2	110.2	109	1.2	7
6.7	10	●	MNS0670X10DB	68.2	92.2	95.2	148.2	147	1.2	7
6.7	20	●	MNS0670X20DB	135.2	162.2	165.2	218.2	217	1.2	7
6.7	30	●	MNS0670X30DB	202.2	232.2	235.2	288.2	287	1.2	7

CUTTING CONDITIONS ➤ P081
OPERATION GUIDANCE ➤ P082
TECHNICAL DATA ➤ R001

MNS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
6.8	5	●	MNS0680LB	35.2	57.2	57.2	110.2	109	1.2	7
6.8	10	□	MNS0680X10DB	69.2	92.2	95.2	148.2	147	1.2	7
6.8	20	□	MNS0680X20DB	137.2	162.2	165.2	218.2	217	1.2	7
6.8	30	□	MNS0680X30DB	205.2	232.2	235.2	288.2	287	1.2	7
6.9	5	●	MNS0690LB	35.8	57.3	57.3	110.3	109	1.3	7
6.9	10	□	MNS0690X10DB	70.3	92.3	95.3	148.3	147	1.3	7
6.9	20	□	MNS0690X20DB	139.3	162.3	165.3	218.3	217	1.3	7
6.9	30	□	MNS0690X30DB	208.3	232.3	235.3	288.3	287	1.3	7
7.0	5	●	MNS0700LB	36.3	57.3	57.3	110.3	109	1.3	7
7.0	10	●	MNS0700X10DB	71.3	92.3	95.3	148.3	147	1.3	7
7.0	20	●	MNS0700X20DB	141.3	162.3	165.3	218.3	217	1.3	7
7.0	30	●	MNS0700X30DB	211.3	232.3	235.3	288.3	287	1.3	7
7.1	5	●	MNS0710LB	36.8	61.3	65.3	119.3	118	1.3	8
7.1	10	□	MNS0710X10DB	72.3	99.3	102.3	156.3	155	1.3	8
7.1	20	□	MNS0710X20DB	143.3	174.3	177.3	231.3	230	1.3	8
7.1	30	□	MNS0710X30DB	214.3	249.3	252.3	306.3	305	1.3	8
7.2	5	●	MNS0720LB	37.3	61.3	65.3	119.3	118	1.3	8
7.2	10	●	MNS0720X10DB	73.3	99.3	102.3	156.3	155	1.3	8
7.2	20	●	MNS0720X20DB	145.3	174.3	177.3	231.3	230	1.3	8
7.2	30	●	MNS0720X30DB	217.3	249.3	252.3	306.3	305	1.3	8
7.3	5	●	MNS0730LB	37.8	61.3	65.3	119.3	118	1.3	8
7.3	10	□	MNS0730X10DB	74.3	99.3	102.3	156.3	155	1.3	8
7.3	20	□	MNS0730X20DB	147.3	174.3	177.3	231.3	230	1.3	8
7.3	30	□	MNS0730X30DB	220.3	249.3	252.3	306.3	305	1.3	8
7.4	5	●	MNS0740LB	38.3	61.3	65.3	119.3	118	1.3	8
7.4	10	□	MNS0740X10DB	75.3	99.3	102.3	156.3	155	1.3	8
7.4	20	□	MNS0740X20DB	149.3	174.3	177.3	231.3	230	1.3	8
7.4	30	□	MNS0740X30DB	223.3	249.3	252.3	306.3	305	1.3	8
7.5	5	●	MNS0750LB	38.9	61.4	65.4	119.4	118	1.4	8
7.5	10	□	MNS0750X10DB	76.4	99.4	102.4	156.4	155	1.4	8
7.5	20	□	MNS0750X20DB	151.4	174.4	177.4	231.4	230	1.4	8
7.5	30	□	MNS0750X30DB	226.4	249.4	252.4	306.4	305	1.4	8
7.6	5	●	MNS0760LB	39.4	65.4	65.4	119.4	118	1.4	8
7.6	10	□	MNS0760X10DB	77.4	105.4	108.4	162.4	161	1.4	8
7.6	20	□	MNS0760X20DB	153.4	185.4	188.4	242.4	241	1.4	8
7.6	30	□	MNS0760X30DB	229.4	265.4	268.4	322.4	321	1.4	8
7.7	5	●	MNS0770LB	39.9	65.4	65.4	119.4	118	1.4	8
7.7	10	□	MNS0770X10DB	78.4	105.4	108.4	162.4	161	1.4	8
7.7	20	□	MNS0770X20DB	155.4	185.4	188.4	242.4	241	1.4	8
7.7	30	□	MNS0770X30DB	232.4	265.4	268.4	322.4	321	1.4	8
7.8	5	●	MNS0780LB	40.4	65.4	65.4	119.4	118	1.4	8
7.8	10	●	MNS0780X10DB	79.4	105.4	108.4	162.4	161	1.4	8
7.8	20	●	MNS0780X20DB	157.4	185.4	188.4	242.4	241	1.4	8
7.8	30	●	MNS0780X30DB	235.4	265.4	268.4	322.4	321	1.4	8
7.9	5	●	MNS0790LB	40.9	65.4	65.4	119.4	118	1.4	8
7.9	10	□	MNS0790X10DB	80.4	105.4	108.4	162.4	161	1.4	8
7.9	20	□	MNS0790X20DB	159.4	185.4	188.4	242.4	241	1.4	8
7.9	30	□	MNS0790X30DB	238.4	265.4	268.4	322.4	321	1.4	8

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
8.0	5	●	MNS0800LB	41.5	65.5	65.5	119.5	118	1.5	8
8.0	10	●	MNS0800X10DB	81.5	105.5	108.5	162.5	161	1.5	8
8.0	20	●	MNS0800X20DB	161.5	185.5	188.5	242.5	241	1.5	8
8.0	30	●	MNS0800X30DB	241.5	265.5	268.5	322.5	321	1.5	8
8.1	5	●	MNS0810LB	42.0	69.5	73.5	128.5	127	1.5	9
8.1	10	□	MNS0810X10DB	82.5	112.5	115.5	170.5	169	1.5	9
8.1	20	□	MNS0810X20DB	163.5	197.5	200.5	255.5	254	1.5	9
8.1	30	□	MNS0810X30DB	244.5	282.5	285.5	340.5	339	1.5	9
8.2	5	●	MNS0820LB	42.5	69.5	73.5	128.5	127	1.5	9
8.2	10	□	MNS0820X10DB	83.5	112.5	115.5	170.5	169	1.5	9
8.2	20	□	MNS0820X20DB	165.5	197.5	200.5	255.5	254	1.5	9
8.2	30	□	MNS0820X30DB	247.5	282.5	285.5	340.5	339	1.5	9
8.3	5	●	MNS0830LB	43.0	69.5	73.5	128.5	127	1.5	9
8.3	10	□	MNS0830X10DB	84.5	112.5	115.5	170.5	169	1.5	9
8.3	20	□	MNS0830X20DB	167.5	197.5	200.5	255.5	254	1.5	9
8.3	30	□	MNS0830X30DB	250.5	282.5	285.5	340.5	339	1.5	9
8.4	5	●	MNS0840LB	43.5	69.5	73.5	128.5	127	1.5	9
8.4	10	□	MNS0840X10DB	85.5	112.5	115.5	170.5	169	1.5	9
8.4	20	□	MNS0840X20DB	169.5	197.5	200.5	255.5	254	1.5	9
8.4	30	□	MNS0840X30DB	253.5	282.5	285.5	340.5	339	1.5	9
8.5	5	●	MNS0850LB	44.0	69.5	73.5	128.5	127	1.5	9
8.5	10	□	MNS0850X10DB	86.5	112.5	115.5	170.5	169	1.5	9
8.5	20	□	MNS0850X20DB	171.5	197.5	200.5	255.5	254	1.5	9
8.5	30	□	MNS0850X30DB	256.5	282.5	285.5	340.5	339	1.5	9
8.6	5	●	MNS0860LB	44.6	73.6	73.6	128.6	127	1.6	9
8.6	10	□	MNS0860X10DB	87.6	118.6	121.6	176.6	175	1.6	9
8.6	20	□	MNS0860X20DB	173.6	208.6	211.6	266.6	265	1.6	9
8.6	30	□	MNS0860X30DB	259.6	298.6	301.6	356.6	355	1.6	9
8.7	5	●	MNS0870LB	45.1	73.6	73.6	128.6	127	1.6	9
8.7	10	□	MNS0870X10DB	88.6	118.6	121.6	176.6	175	1.6	9
8.7	20	□	MNS0870X20DB	175.6	208.6	211.6	266.6	265	1.6	9
8.7	30	□	MNS0870X30DB	262.6	298.6	301.6	356.6	355	1.6	9
8.8	5	●	MNS0880LB	45.6	73.6	73.6	128.6	127	1.6	9
8.8	10	□	MNS0880X10DB	89.6	118.6	121.6	176.6	175	1.6	9
8.8	20	□	MNS0880X20DB	177.6	208.6	211.6	266.6	265	1.6	9
8.8	30	□	MNS0880X30DB	265.6	298.6	301.6	356.6	355	1.6	9
8.9	5	●	MNS0890LB	46.1	73.6	73.6	128.6	127	1.6	9
8.9	10	□	MNS0890X10DB	90.6	118.6	121.6	176.6	175	1.6	9
8.9	20	□	MNS0890X20DB	179.6	208.6	211.6	266.6	265	1.6	9
8.9	30	□	MNS0890X30DB	268.6	298.6	301.6	356.6	355	1.6	9
9.0	5	●	MNS0900LB	46.6	73.6	73.6	128.6	127	1.6	9
9.0	10	●	MNS0900X10DB	91.6	118.6	121.6	176.6	175	1.6	9
9.0	20	●	MNS0900X20DB	181.6	208.6	211.6	266.6	265	1.6	9
9.0	30	●	MNS0900X30DB	271.6	298.6	301.6	356.6	355	1.6	9
9.1	5	●	MNS0910LB	47.2	77.7	81.7	137.7	136	1.7	10
9.1	10	□	MNS0910X10DB	92.7	125.7	128.7	183.7	182	1.7	10
9.1	20	□	MNS0910X20DB	183.7	220.7	223.7	278.7	277	1.7	10
9.1	30	□	MNS0910X30DB	274.7	315.7	318.7	373.7	372	1.7	10

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
9.2	5	●	MNS0920LB	47.7	77.7	81.7	137.7	136	1.7	10
9.2	10	□	MNS0920X10DB	93.7	125.7	128.7	183.7	182	1.7	10
9.2	20	□	MNS0920X20DB	185.7	220.7	223.7	278.7	277	1.7	10
9.2	30	□	MNS0920X30DB	277.7	315.7	318.7	373.7	372	1.7	10
9.3	5	●	MNS0930LB	48.2	77.7	81.7	137.7	136	1.7	10
9.3	10	□	MNS0930X10DB	94.7	125.7	128.7	183.7	182	1.7	10
9.3	20	□	MNS0930X20DB	187.7	220.7	223.7	278.7	277	1.7	10
9.3	30	□	MNS0930X30DB	280.7	315.7	318.7	373.7	372	1.7	10
9.4	5	●	MNS0940LB	48.7	77.7	81.7	137.7	136	1.7	10
9.4	10	□	MNS0940X10DB	95.7	125.7	128.7	183.7	182	1.7	10
9.4	20	□	MNS0940X20DB	189.7	220.7	223.7	278.7	277	1.7	10
9.4	30	□	MNS0940X30DB	283.7	315.7	318.7	373.7	372	1.7	10
9.5	5	●	MNS0950LB	49.2	77.7	81.7	137.7	136	1.7	10
9.5	10	□	MNS0950X10DB	96.7	125.7	128.7	183.7	182	1.7	10
9.5	20	□	MNS0950X20DB	191.7	220.7	223.7	278.7	277	1.7	10
9.5	30	□	MNS0950X30DB	286.7	315.7	318.7	373.7	372	1.7	10
9.6	5	●	MNS0960LB	49.7	81.7	81.7	137.7	136	1.7	10
9.6	10	□	MNS0960X10DB	97.7	131.7	134.7	189.7	188	1.7	10
9.6	20	□	MNS0960X20DB	193.7	231.7	234.7	289.7	288	1.7	10
9.6	30	□	MNS0960X30DB	289.7	331.7	334.7	389.7	388	1.7	10
9.7	5	●	MNS0970LB	50.3	81.8	81.8	137.8	136	1.8	10
9.7	10	□	MNS0970X10DB	98.8	131.8	134.8	189.8	188	1.8	10
9.7	20	□	MNS0970X20DB	195.8	231.8	234.8	289.8	288	1.8	10
9.7	30	□	MNS0970X30DB	292.8	331.8	334.8	389.8	388	1.8	10
9.8	5	●	MNS0980LB	50.8	81.8	81.8	137.8	136	1.8	10
9.8	10	●	MNS0980X10DB	99.8	131.8	134.8	189.8	188	1.8	10
9.8	20	●	MNS0980X20DB	197.8	231.8	234.8	289.8	288	1.8	10
9.8	30	●	MNS0980X30DB	295.8	331.8	334.8	389.8	388	1.8	10
9.9	5	●	MNS0990LB	51.3	81.8	81.8	137.8	136	1.8	10
9.9	10	□	MNS0990X10DB	100.8	131.8	134.8	189.8	188	1.8	10
9.9	20	□	MNS0990X20DB	199.8	231.8	234.8	289.8	288	1.8	10
9.9	30	□	MNS0990X30DB	298.8	331.8	334.8	389.8	388	1.8	10
10.0	5	●	MNS1000LB	51.8	81.8	81.8	137.8	136	1.8	10
10.0	10	●	MNS1000X10DB	101.8	131.8	134.8	189.8	188	1.8	10
10.0	20	●	MNS1000X20DB	201.8	231.8	234.8	289.8	288	1.8	10
10.0	30	●	MNS1000X30DB	301.8	331.8	334.8	389.8	388	1.8	10
10.1	5	●	MNS1010LB	52.3	85.8	89.8	150.8	149	1.8	11
10.1	10	□	MNS1010X10DB	102.8	138.8	141.8	202.8	201	1.8	11
10.1	20	□	MNS1010X20DB	203.8	243.8	246.8	307.8	306	1.8	11
10.2	5	●	MNS1020LB	52.9	85.9	89.9	150.9	149	1.9	11
10.2	10	□	MNS1020X10DB	103.9	138.9	141.9	202.9	201	1.9	11
10.2	20	□	MNS1020X20DB	205.9	243.9	246.9	307.9	306	1.9	11
10.3	5	●	MNS1030LB	53.4	85.9	89.9	150.9	149	1.9	11
10.3	10	□	MNS1030X10DB	104.9	138.9	141.9	202.9	201	1.9	11
10.3	20	□	MNS1030X20DB	207.9	243.9	246.9	307.9	306	1.9	11
10.4	5	●	MNS1040LB	53.9	85.9	89.9	150.9	149	1.9	11
10.4	10	□	MNS1040X10DB	105.9	138.9	141.9	202.9	201	1.9	11
10.4	20	□	MNS1040X20DB	209.9	243.9	246.9	307.9	306	1.9	11

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
10.5	5	●	MNS1050LB	54.4	85.9	89.9	150.9	149	1.9	11
10.5	10	●	MNS1050X10DB	106.9	138.9	141.9	202.9	201	1.9	11
10.5	20	●	MNS1050X20DB	211.9	243.9	246.9	307.9	306	1.9	11
10.6	5	●	MNS1060LB	54.9	89.9	89.9	150.9	149	1.9	11
10.6	10	□	MNS1060X10DB	107.9	144.9	147.9	208.9	207	1.9	11
10.6	20	□	MNS1060X20DB	213.9	254.9	257.9	318.9	317	1.9	11
10.7	5	●	MNS1070LB	55.4	89.9	89.9	150.9	149	1.9	11
10.7	10	□	MNS1070X10DB	108.9	144.9	147.9	208.9	207	1.9	11
10.7	20	□	MNS1070X20DB	215.9	254.9	257.9	318.9	317	1.9	11
10.8	5	●	MNS1080LB	56.0	90.0	90.0	151.0	149	2.0	11
10.8	10	□	MNS1080X10DB	110.0	145.0	148.0	209.0	207	2.0	11
10.8	20	□	MNS1080X20DB	218.0	255.0	258.0	319.0	317	2.0	11
10.9	5	●	MNS1090LB	56.5	90.0	90.0	151.0	149	2.0	11
10.9	10	□	MNS1090X10DB	111.0	145.0	148.0	209.0	207	2.0	11
10.9	20	□	MNS1090X20DB	220.0	255.0	258.0	319.0	317	2.0	11
11.0	5	●	MNS1100LB	57.0	90.0	90.0	151.0	149	2.0	11
11.0	10	●	MNS1100X10DB	112.0	145.0	148.0	209.0	207	2.0	11
11.0	20	●	MNS1100X20DB	222.0	255.0	258.0	319.0	317	2.0	11
11.1	5	●	MNS1110LB	57.5	94.0	98.0	160.0	158	2.0	12
11.1	10	□	MNS1110X10DB	113.0	152.0	155.0	217.0	215	2.0	12
11.1	20	□	MNS1110X20DB	224.0	267.0	270.0	332.0	330	2.0	12
11.2	5	●	MNS1120LB	58.0	94.0	98.0	160.0	158	2.0	12
11.2	10	□	MNS1120X10DB	114.0	152.0	155.0	217.0	215	2.0	12
11.2	20	□	MNS1120X20DB	226.0	267.0	270.0	332.0	330	2.0	12
11.3	5	●	MNS1130LB	58.6	94.1	98.1	160.1	158	2.1	12
11.3	10	□	MNS1130X10DB	115.1	152.1	155.1	217.1	215	2.1	12
11.3	20	□	MNS1130X20DB	228.1	267.1	270.1	332.1	330	2.1	12
11.4	5	●	MNS1140LB	59.1	94.1	98.1	160.1	158	2.1	12
11.4	10	□	MNS1140X10DB	116.1	152.1	155.1	217.1	215	2.1	12
11.4	20	□	MNS1140X20DB	230.1	267.1	270.1	332.1	330	2.1	12
11.5	5	●	MNS1150LB	59.6	94.1	98.1	160.1	158	2.1	12
11.5	10	□	MNS1150X10DB	117.1	152.1	155.1	217.1	215	2.1	12
11.5	20	□	MNS1150X20DB	232.1	267.1	270.1	332.1	330	2.1	12
11.6	5	●	MNS1160LB	60.1	98.1	98.1	160.1	158	2.1	12
11.6	10	□	MNS1160X10DB	118.1	158.1	161.1	223.1	221	2.1	12
11.6	20	□	MNS1160X20DB	234.1	278.1	281.1	343.1	341	2.1	12
11.7	5	●	MNS1170LB	60.6	98.1	98.1	160.1	158	2.1	12
11.7	10	□	MNS1170X10DB	119.1	158.1	161.1	223.1	221	2.1	12
11.7	20	□	MNS1170X20DB	236.1	278.1	281.1	343.1	341	2.1	12
11.8	5	●	MNS1180LB	61.1	98.1	98.1	160.1	158	2.1	12
11.8	10	□	MNS1180X10DB	120.1	158.1	161.1	223.1	221	2.1	12
11.8	20	□	MNS1180X20DB	238.1	278.1	281.1	343.1	341	2.1	12
11.9	5	●	MNS1190LB	61.7	98.2	98.2	160.2	158	2.2	12
11.9	10	□	MNS1190X10DB	121.2	158.2	161.2	223.2	221	2.2	12
11.9	20	□	MNS1190X20DB	240.2	278.2	281.2	343.2	341	2.2	12
12.0	5	●	MNS1200LB	62.2	98.2	98.2	160.2	158	2.2	12
12.0	10	●	MNS1200X10DB	122.2	158.2	161.2	223.2	221	2.2	12
12.0	20	●	MNS1200X20DB	242.2	278.2	281.2	343.2	341	2.2	12

CUTTING CONDITIONS ➤ P081
OPERATION GUIDANCE ➤ P082
TECHNICAL DATA ➤ R001

MNS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
12.1	5	●	MNS1210LB	62.7	102.2	106.2	169.2	167	2.2	13
12.1	10	□	MNS1210X10DB	123.2	165.2	168.2	231.2	229	2.2	13
12.1	20	□	MNS1210X20DB	244.2	290.2	293.2	356.2	354	2.2	13
12.2	5	●	MNS1220LB	63.2	102.2	106.2	169.2	167	2.2	13
12.2	10	□	MNS1220X10DB	124.2	165.2	168.2	231.2	229	2.2	13
12.2	20	□	MNS1220X20DB	246.2	290.2	293.2	356.2	354	2.2	13
12.3	5	●	MNS1230LB	63.7	102.2	106.2	169.2	167	2.2	13
12.3	10	□	MNS1230X10DB	125.2	165.2	168.2	231.2	229	2.2	13
12.3	20	□	MNS1230X20DB	248.2	290.2	293.2	356.2	354	2.2	13
12.4	5	●	MNS1240LB	64.3	102.3	106.3	169.3	167	2.3	13
12.4	10	□	MNS1240X10DB	126.3	165.3	168.3	231.3	229	2.3	13
12.4	20	□	MNS1240X20DB	250.3	290.3	293.3	356.3	354	2.3	13
12.5	5	●	MNS1250LB	64.8	102.3	106.3	169.3	167	2.3	13
12.5	10	□	MNS1250X10DB	127.3	165.3	168.3	231.3	229	2.3	13
12.5	20	□	MNS1250X20DB	252.3	290.3	293.3	356.3	354	2.3	13
12.6	5	●	MNS1260LB	65.3	106.3	106.3	169.3	167	2.3	13
12.6	10	□	MNS1260X10DB	128.3	171.3	174.3	237.3	235	2.3	13
12.6	20	□	MNS1260X20DB	254.3	301.3	304.3	367.3	365	2.3	13
12.7	5	●	MNS1270LB	65.8	106.3	106.3	169.3	167	2.3	13
12.7	10	□	MNS1270X10DB	129.3	171.3	174.3	237.3	235	2.3	13
12.7	20	□	MNS1270X20DB	256.3	301.3	304.3	367.3	365	2.3	13
12.8	5	●	MNS1280LB	66.3	106.3	106.3	169.3	167	2.3	13
12.8	10	□	MNS1280X10DB	130.3	171.3	174.3	237.3	235	2.3	13
12.8	20	□	MNS1280X20DB	258.3	301.3	304.3	367.3	365	2.3	13
12.9	5	●	MNS1290LB	66.8	106.3	106.3	169.3	167	2.3	13
12.9	10	□	MNS1290X10DB	131.3	171.3	174.3	237.3	235	2.3	13
12.9	20	□	MNS1290X20DB	260.3	301.3	304.3	367.3	365	2.3	13
13.0	5	●	MNS1300LB	67.4	106.4	106.4	169.4	167	2.4	13
13.0	10	●	MNS1300X10DB	132.4	171.4	174.4	237.4	235	2.4	13
13.0	20	●	MNS1300X20DB	262.4	301.4	304.4	367.4	365	2.4	13

DC (mm)	Hole Depth (L/D)	TF15	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON
13.1	5	●	MNS1310LB	67.9	110.4	114.4	178.4	176	2.4	14
13.1	10	□	MNS1310X10DB	133.4	178.4	181.4	245.4	243	2.4	14
13.1	20	□	MNS1310X20DB	264.4	313.4	316.4	380.4	378	2.4	14
13.2	5	●	MNS1320LB	68.4	110.4	114.4	178.4	176	2.4	14
13.2	10	□	MNS1320X10DB	134.4	178.4	181.4	245.4	243	2.4	14
13.2	20	□	MNS1320X20DB	266.4	313.4	316.4	380.4	378	2.4	14
13.3	5	●	MNS1330LB	68.9	110.4	114.4	178.4	176	2.4	14
13.3	10	□	MNS1330X10DB	135.4	178.4	181.4	245.4	243	2.4	14
13.3	20	□	MNS1330X20DB	268.4	313.4	316.4	380.4	378	2.4	14
13.4	5	●	MNS1340LB	69.4	110.4	114.4	178.4	176	2.4	14
13.4	10	□	MNS1340X10DB	136.4	178.4	181.4	245.4	243	2.4	14
13.4	20	□	MNS1340X20DB	270.4	313.4	316.4	380.4	378	2.4	14
13.5	5	●	MNS1350LB	70.0	110.5	114.5	178.5	176	2.5	14
13.5	10	□	MNS1350X10DB	137.5	178.5	181.5	245.5	243	2.5	14
13.5	20	□	MNS1350X20DB	272.5	313.5	316.5	380.5	378	2.5	14
13.6	5	●	MNS1360LB	70.5	114.5	114.5	178.5	176	2.5	14
13.6	10	□	MNS1360X10DB	138.5	184.5	187.5	251.5	249	2.5	14
13.6	20	□	MNS1360X20DB	274.5	324.5	327.5	391.5	389	2.5	14
13.7	5	●	MNS1370LB	71.0	114.5	114.5	178.5	176	2.5	14
13.7	10	□	MNS1370X10DB	139.5	184.5	187.5	251.5	249	2.5	14
13.7	20	□	MNS1370X20DB	276.5	324.5	327.5	391.5	389	2.5	14
13.8	5	●	MNS1380LB	71.5	114.5	114.5	178.5	176	2.5	14
13.8	10	□	MNS1380X10DB	140.5	184.5	187.5	251.5	249	2.5	14
13.8	20	□	MNS1380X20DB	278.5	324.5	327.5	391.5	389	2.5	14
13.9	5	●	MNS1390LB	72.0	114.5	114.5	178.5	176	2.5	14
13.9	10	□	MNS1390X10DB	141.5	184.5	187.5	251.5	249	2.5	14
13.9	20	□	MNS1390X20DB	280.5	324.5	327.5	391.5	389	2.5	14
14.0	5	●	MNS1400LB	72.5	114.5	114.5	178.5	176	2.5	14
14.0	10	●	MNS1400X10DB	142.5	184.5	187.5	251.5	249	2.5	14
14.0	20	●	MNS1400X20DB	282.5	324.5	327.5	391.5	389	2.5	14

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

RECOMMENDED CUTTING CONDITIONS

LB Type Drill

Work Material	Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc		Aluminium Alloy (5%≦Si≦10%) ASTM 333.0 etc		Aluminium Alloy (Si>10%) ASTM 383.0, ASTM A390.0 etc	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)
3.2	11900	0.1 (0.11—0.16)	11900	0.15 (0.16—0.21)	11900	0.15 (0.16—0.21)
4.0	9500	0.15 (0.13—0.20)	9500	0.2 (0.20—0.27)	9500	0.2 (0.20—0.27)
5.0	7600	0.2 (0.17—0.25)	7600	0.25 (0.25—0.33)	7600	0.25 (0.25—0.33)
6.3	7500	0.25 (0.21—0.32)	7500	0.35 (0.32—0.42)	7500	0.35 (0.32—0.42)
8.0	5900	0.3 (0.27—0.40)	5900	0.45 (0.40—0.53)	5900	0.45 (0.40—0.53)
10.0	4700	0.4 (0.33—0.50)	4700	0.55 (0.50—0.67)	4700	0.55 (0.50—0.67)
12.0	5300	0.5 (0.40—0.60)	5300	0.7 (0.60—0.80)	5300	0.7 (0.60—0.80)
14.0	4500	0.5 (0.40—0.60)	4500	0.7 (0.60—0.80)	4500	0.7 (0.60—0.80)

Note 1) When using the drill with a length over L/D 10, it is necessary to use a prep holes as a guide. (If no prep-hole is used then drill breakage can occur)
Note 2) For pilot hole drilling, Mitsubishi Materials MNS-LB, MAE-MB or MAS-MB drill is recommended.

DB Type Drill

Work Material	Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc		Aluminium Alloy (5%≦Si≦10%) ASTM 333.0 etc		Aluminium Alloy (Si>10%) ASTM 383.0, ASTM A390.0 etc	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)
3.2	8900	0.1 (0.11—0.16)	8900	0.15 (0.16—0.21)	8900	0.15 (0.16—0.21)
4.0	7100	0.15 (0.13—0.20)	7100	0.2 (0.20—0.27)	7100	0.2 (0.20—0.27)
5.0	5700	0.2 (0.17—0.25)	5700	0.25 (0.25—0.33)	5700	0.25 (0.25—0.33)
6.3	6000	0.25 (0.21—0.32)	6000	0.35 (0.32—0.42)	6000	0.35 (0.32—0.42)
8.0	4700	0.3 (0.27—0.40)	4700	0.45 (0.40—0.53)	4700	0.45 (0.40—0.53)
10.0	3800	0.4 (0.33—0.50)	3800	0.55 (0.50—0.67)	3800	0.55 (0.50—0.67)
12.0	4200	0.5 (0.40—0.60)	4200	0.7 (0.60—0.80)	4200	0.7 (0.60—0.80)
14.0	3600	0.5 (0.40—0.60)	3600	0.7 (0.60—0.80)	3600	0.7 (0.60—0.80)

Note 1) When using the drill with a length over L/D 10, it is necessary to use a prep holes as a guide. (If no prep-hole is used then drill breakage can occur)
Note 2) For pilot hole drilling, Mitsubishi Materials MNS-LB, MAE-MB or MAS-MB drill is recommended.

OPERATION GUIDANCE ➢ P082
TECHNICAL DATA ➢ R001

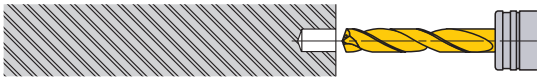
MNS

WSTAR DRILLS

■ OPERATIONAL GUIDANCE FOR MNS...DB DRILLS

FLAT FACE DRILLING ●Drilling a blind hole

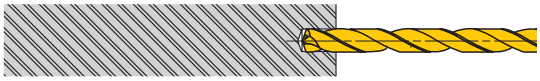
■ 1. Drilling a pilot hole



①Use a drill with a larger (flatter) point angle than the super long type.
MVS pilot drill with point angle 145˚ is recommended.

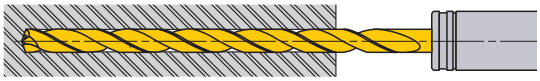
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1–2.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 2. Initial cutting with the long type drill



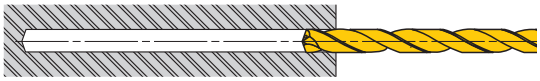
①Penetrate the guide hole at low revolution. (Cutting speed 20—30m/min, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 1—3mm short of the guide hole bottom.

■ 3. Drill the deep hole



①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

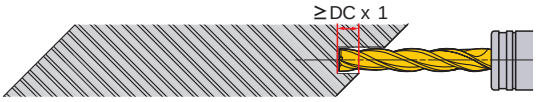
■ 4. Drill retraction



①After drilling, lower the cutting revolution about 1—2mm short of the hole end. (Cutting speed of around 20—30m/min)
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.
③Finally, clear the hole at a cutting speed of 20—30m/min and feed rate of 0.2—0.3mm/rev.

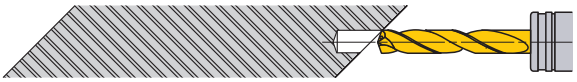
INTERRUPED DRILLING ●Drilling and breaking through on irregular faces or angles

■ 1. Spot facing



①When machining a deep hole into an inclined surface, use MFE drill as a drill for a guide hole.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.

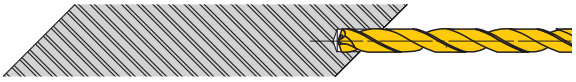
■ 2. Drilling a pilot hole



①Use a drill with a larger (flatter) point angle than the super long type.
MVS pilot drill with point angle 145° is recommended.

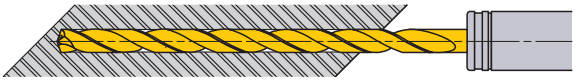
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1–2.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 3. Initial cutting with the long type drill



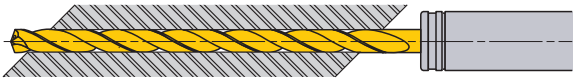
①Penetrate the guide hole at a low revolution. (Cutting speed 20—30m/min, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 1—3mm short of the guide hole bottom.

■ 4. Drill the deep hole



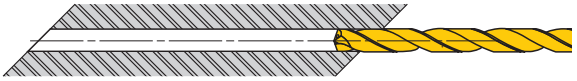
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 5. Breaking through



①When breaking through, the cutting edge can be damaged.
②A feed rate of 0.05—0.1mm/rev is recommended.

■ 6. Drill retraction



①Finally clear the hole at a cutting speed of 20—30m/min and feed rate of 0.2—0.3mm/rev.
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.

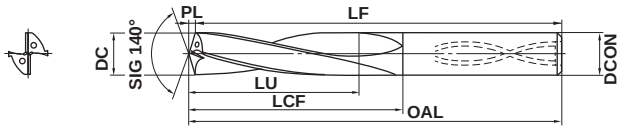
MAS

- Specially for aluminium and cast iron drilling.
- High hole accuracy.
- Pre-hole drilling for roll taps.
- Helical through coolant hole enables high speed machining.

TOOL NEWS

P	M	K	N	S	H
		Cast Iron	Non-ferrous Metal		

Internal Coolant



DC=3	3<DC≤6	6<DC≤10	10<DC≤16
+0.005 0	+0.005 0	+0.005 0	+0.005 0
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤16**
0 −0.006	0 −0.008	0 −0.009	0 −0.011

Note 1) MAS type bigger than ϕ5.0 have a recess in the end face.
Note 2) MAS drills are suitable for use with shrink fit holders.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
3.0	3	□	MAS0300MB	9.5	21.5	61.5	61	0.5	3
3.0	6	●	MAS0300LB	18.5	30.5	70.5	70	0.5	3
3.1	3	□	MAS0310MB	9.9	24.6	64.6	64	0.6	4
3.1	6	●	MAS0310LB	19.2	34.6	74.6	74	0.6	4
3.2	3	□	MAS0320MB	10.2	24.6	64.6	64	0.6	4
3.2	6	●	MAS0320LB	19.8	34.6	74.6	74	0.6	4
3.3	3	□	MAS0330MB	10.5	24.6	64.6	64	0.6	4
3.3	6	●	MAS0330LB	20.4	34.6	74.6	74	0.6	4
3.4	3	□	MAS0340MB	10.8	24.6	64.6	64	0.6	4
3.4	6	●	MAS0340LB	21.0	34.6	74.6	74	0.6	4
3.5	3	□	MAS0350MB	11.1	24.6	64.6	64	0.6	4
3.5	6	●	MAS0350LB	21.6	34.6	74.6	74	0.6	4
3.6	3	□	MAS0360MB	11.5	28.7	68.7	68	0.7	4
3.6	6	●	MAS0360LB	22.3	40.7	80.7	80	0.7	4
3.65	3	□	⁎MAS0365MB	11.7	28.7	68.7	68	0.7	4
3.65	6	●	⁎MAS0365LB	22.6	40.7	80.7	80	0.7	4
3.7	3	□	MAS0370MB	11.8	28.7	68.7	68	0.7	4
3.7	6	●	MAS0370LB	22.9	40.7	80.7	80	0.7	4
3.8	3	□	MAS0380MB	12.1	28.7	68.7	68	0.7	4
3.8	6	●	MAS0380LB	23.5	40.7	80.7	80	0.7	4
3.9	3	□	MAS0390MB	12.4	28.7	68.7	68	0.7	4
3.9	6	●	MAS0390LB	24.1	40.7	80.7	80	0.7	4
4.0	3	□	MAS0400MB	12.7	28.7	68.7	68	0.7	4
4.0	6	●	MAS0400LB	24.7	40.7	80.7	80	0.7	4
4.1	3	□	MAS0410MB	13.0	31.7	71.7	71	0.7	5
4.1	6	●	MAS0410LB	25.3	44.7	84.7	84	0.7	5
4.2	3	□	MAS0420MB	13.4	31.8	71.8	71	0.8	5
4.2	6	●	MAS0420LB	26.0	44.8	84.8	84	0.8	5
4.3	3	□	MAS0430MB	13.7	31.8	71.8	71	0.8	5
4.3	6	●	MAS0430LB	26.6	44.8	84.8	84	0.8	5
4.4	3	□	MAS0440MB	14.0	31.8	71.8	71	0.8	5
4.4	6	●	MAS0440LB	27.2	44.8	84.8	84	0.8	5

⁎ Standard hole size for rolled thread taps.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
4.5	3	□	MAS0450MB	14.3	31.8	71.8	71	0.8	5
4.5	6	●	MAS0450LB	27.8	44.8	84.8	84	0.8	5
4.6	3	□	⁎MAS0460MB	14.6	33.8	73.8	73	0.8	5
4.6	6	●	⁎MAS0460LB	28.4	48.8	88.8	88	0.8	5
4.7	3	□	MAS0470MB	15.0	33.9	73.9	73	0.9	5
4.7	6	●	MAS0470LB	29.1	48.9	88.9	88	0.9	5
4.8	3	□	MAS0480MB	15.3	33.9	73.9	73	0.9	5
4.8	6	●	MAS0480LB	29.7	48.9	88.9	88	0.9	5
4.9	3	□	MAS0490MB	15.6	33.9	73.9	73	0.9	5
4.9	6	●	MAS0490LB	30.3	48.9	88.9	88	0.9	5
5.0	3	●	MAS0500MB	15.9	33.9	73.9	73	0.9	5
5.0	6	●	MAS0500LB	30.9	48.9	88.9	88	0.9	5
5.1	3	□	MAS0510MB	16.2	36.9	76.9	76	0.9	6
5.1	6	●	MAS0510LB	31.5	52.9	92.9	92	0.9	6
5.2	3	□	MAS0520MB	16.5	36.9	76.9	76	0.9	6
5.2	6	●	MAS0520LB	32.1	52.9	92.9	92	0.9	6
5.3	3	□	MAS0530MB	16.9	37.0	77.0	76	1.0	6
5.3	6	●	MAS0530LB	32.8	53.0	93.0	92	1.0	6
5.4	3	□	MAS0540MB	17.2	37.0	77.0	76	1.0	6
5.4	6	●	MAS0540LB	33.4	53.0	93.0	92	1.0	6
5.5	3	●	⁎MAS0550MB	17.5	37.0	77.0	76	1.0	6
5.5	6	●	⁎MAS0550LB	34.0	53.0	93.0	92	1.0	6
5.6	3	□	MAS0560MB	17.8	40.0	80.0	79	1.0	6
5.6	6	●	MAS0560LB	34.6	58.0	98.0	97	1.0	6
5.7	3	□	MAS0570MB	18.1	40.0	80.0	79	1.0	6
5.7	6	●	MAS0570LB	35.2	58.0	98.0	97	1.0	6
5.8	3	□	MAS0580MB	18.5	40.1	80.1	79	1.1	6
5.8	6	●	MAS0580LB	35.9	58.1	98.1	97	1.1	6
5.9	3	□	MAS0590MB	18.8	40.1	80.1	79	1.1	6
5.9	6	●	MAS0590LB	36.5	58.1	98.1	97	1.1	6
6.0	3	●	MAS0600MB	19.1	40.1	80.1	79	1.1	6
6.0	6	●	MAS0600LB	37.1	58.1	98.1	97	1.1	6

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

CUTTING CONDITIONS ➤ P089
TECHNICAL DATA ➤ R001

MAS

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
6.1	3	□	MAS0610MB	19.4	43.1	85.1	84	1.1	7
6.1	6	●	MAS0610LB	37.7	63.1	105.1	104	1.1	7
6.2	3	□	MAS0620MB	19.7	43.1	85.1	84	1.1	7
6.2	6	●	MAS0620LB	38.3	63.1	105.1	104	1.1	7
6.3	3	□	MAS0630MB	20.0	43.1	85.1	84	1.1	7
6.3	6	●	MAS0630LB	38.9	63.1	105.1	104	1.1	7
6.4	3	□	MAS0640MB	20.4	43.2	85.2	84	1.2	7
6.4	6	●	MAS0640LB	39.6	63.2	105.2	104	1.2	7
6.5	3	●	MAS0650MB	20.7	43.2	85.2	84	1.2	7
6.5	6	●	MAS0650LB	40.2	63.2	105.2	104	1.2	7
6.6	3	□	MAS0660MB	21.0	43.2	85.2	84	1.2	7
6.6	6	●	MAS0660LB	40.8	66.2	108.2	107	1.2	7
6.7	3	□	MAS0670MB	21.3	43.2	85.2	84	1.2	7
6.7	6	●	MAS0670LB	41.4	66.2	108.2	107	1.2	7
6.8	3	●	MAS0680MB	21.6	43.2	85.2	84	1.2	7
6.8	6	●	MAS0680LB	42.0	66.2	108.2	107	1.2	7
6.9	3	□	MAS0690MB	22.0	43.3	85.3	84	1.3	7
6.9	6	●	MAS0690LB	42.7	66.3	108.3	107	1.3	7
7.0	3	●	MAS0700MB	22.3	43.3	85.3	84	1.3	7
7.0	6	●	MAS0700LB	43.3	66.3	108.3	107	1.3	7
7.1	3	□	MAS0710MB	22.6	49.3	91.3	90	1.3	8
7.1	6	●	MAS0710LB	43.9	69.3	111.3	110	1.3	8
7.2	3	□	MAS0720MB	22.9	49.3	91.3	90	1.3	8
7.2	6	●	MAS0720LB	44.5	69.3	111.3	110	1.3	8
7.3	3	□	MAS0730MB	23.2	49.3	91.3	90	1.3	8
7.3	6	●	MAS0730LB	45.1	69.3	111.3	110	1.3	8
7.35	3	●	⁎MAS0735MB	23.4	49.3	91.3	90	1.3	8
7.35	6	●	⁎MAS0735LB	45.4	69.3	111.3	110	1.3	8
7.4	3	□	MAS0740MB	23.5	49.3	91.3	90	1.3	8
7.4	6	●	MAS0740LB	45.7	69.3	111.3	110	1.3	8
7.5	3	□	MAS0750MB	23.9	49.4	91.4	90	1.4	8
7.5	6	●	MAS0750LB	46.4	69.4	111.4	110	1.4	8
7.6	3	□	MAS0760MB	24.2	49.4	91.4	90	1.4	8
7.6	6	●	MAS0760LB	47.0	73.4	115.4	114	1.4	8
7.7	3	□	MAS0770MB	24.5	49.4	91.4	90	1.4	8
7.7	6	●	MAS0770LB	47.6	73.4	115.4	114	1.4	8
7.8	3	□	MAS0780MB	24.8	49.4	91.4	90	1.4	8
7.8	6	●	MAS0780LB	48.2	73.4	115.4	114	1.4	8
7.9	3	□	MAS0790MB	25.1	49.4	91.4	90	1.4	8
7.9	6	●	MAS0790LB	48.8	73.4	115.4	114	1.4	8
8.0	3	●	MAS0800MB	25.5	49.5	91.5	90	1.5	8
8.0	6	●	MAS0800LB	49.5	73.5	115.5	114	1.5	8
8.1	3	□	MAS0810MB	25.8	51.5	95.5	94	1.5	9
8.1	6	●	MAS0810LB	50.1	76.5	120.5	119	1.5	9
8.2	3	□	MAS0820MB	26.1	51.5	95.5	94	1.5	9
8.2	6	●	MAS0820LB	50.7	76.5	120.5	119	1.5	9
8.3	3	□	MAS0830MB	26.4	51.5	95.5	94	1.5	9
8.3	6	●	MAS0830LB	51.3	76.5	120.5	119	1.5	9

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
8.4	3	□	MAS0840MB	26.7	51.5	95.5	94	1.5	9
8.4	6	●	MAS0840LB	51.9	76.5	120.5	119	1.5	9
8.5	3	●	MAS0850MB	27.0	51.5	95.5	94	1.5	9
8.5	6	●	MAS0850LB	52.5	76.5	120.5	119	1.5	9
8.6	3	□	MAS0860MB	27.4	51.6	95.6	94	1.6	9
8.6	6	●	MAS0860LB	53.2	78.6	122.6	121	1.6	9
8.7	3	□	MAS0870MB	27.7	51.6	95.6	94	1.6	9
8.7	6	●	MAS0870LB	53.8	78.6	122.6	121	1.6	9
8.8	3	□	MAS0880MB	28.0	51.6	95.6	94	1.6	9
8.8	6	●	MAS0880LB	54.4	78.6	122.6	121	1.6	9
8.9	3	□	MAS0890MB	28.3	51.6	95.6	94	1.6	9
8.9	6	●	MAS0890LB	55.0	78.6	122.6	121	1.6	9
9.0	3	●	MAS0900MB	28.6	51.6	95.6	94	1.6	9
9.0	6	●	MAS0900LB	55.6	78.6	122.6	121	1.6	9
9.1	3	□	MAS0910MB	29.0	54.7	98.7	97	1.7	10
9.1	6	●	MAS0910LB	56.3	82.7	126.7	125	1.7	10
9.2	3	□	MAS0920MB	29.3	54.7	98.7	97	1.7	10
9.2	6	●	MAS0920LB	56.9	82.7	126.7	125	1.7	10
9.21	3	●	⁎MAS0921MB	29.3	54.7	98.7	97	1.7	10
9.21	6	●	⁎MAS0921LB	57.0	82.7	126.7	125	1.7	10
9.3	3	□	MAS0930MB	29.6	54.7	98.7	97	1.7	10
9.3	6	●	MAS0930LB	57.5	82.7	126.7	125	1.7	10
9.4	3	□	MAS0940MB	29.9	54.7	98.7	97	1.7	10
9.4	6	●	MAS0940LB	58.1	82.7	126.7	125	1.7	10
9.5	3	●	MAS0950MB	30.2	54.7	98.7	97	1.7	10
9.5	6	●	MAS0950LB	58.7	82.7	126.7	125	1.7	10
9.6	3	□	MAS0960MB	30.5	54.7	98.7	97	1.7	10
9.6	6	●	MAS0960LB	59.3	82.7	126.7	125	1.7	10
9.7	3	□	MAS0970MB	30.9	54.8	98.8	97	1.8	10
9.7	6	●	MAS0970LB	60.0	82.8	126.8	125	1.8	10
9.8	3	□	MAS0980MB	31.2	54.8	98.8	97	1.8	10
9.8	6	●	MAS0980LB	60.6	82.8	126.8	125	1.8	10
9.9	3	□	MAS0990MB	31.5	54.8	98.8	97	1.8	10
9.9	6	●	MAS0990LB	61.2	82.8	126.8	125	1.8	10
10.0	3	●	MAS1000MB	31.8	54.8	98.8	97	1.8	10
10.0	6	●	MAS1000LB	61.8	82.8	126.8	125	1.8	10
10.1	3	□	MAS1010MB	32.1	56.8	102.8	101	1.8	11
10.1	6	□	MAS1010LB	62.4	90.8	136.8	135	1.8	11
10.2	3	□	MAS1020MB	32.5	56.9	102.9	101	1.9	11
10.2	6	□	MAS1020LB	63.1	90.9	136.9	135	1.9	11
10.3	3	●	MAS1030MB	32.8	56.9	102.9	101	1.9	11
10.3	6	●	MAS1030LB	63.7	90.9	136.9	135	1.9	11
10.4	3	□	MAS1040MB	33.1	56.9	102.9	101	1.9	11
10.4	6	□	MAS1040LB	64.3	90.9	136.9	135	1.9	11
10.5	3	●	MAS1050MB	33.4	56.9	102.9	101	1.9	11
10.5	6	●	MAS1050LB	64.9	90.9	136.9	135	1.9	11
10.6	3	□	MAS1060MB	33.7	56.9	102.9	101	1.9	11
10.6	6	□	MAS1060LB	65.5	90.9	136.9	135	1.9	11

⁎ Standard hole size for rolled thread taps.

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
10.7	3	□	MAS1070MB	34.0	56.9	102.9	101	1.9	11
10.7	6	□	MAS1070LB	66.1	90.9	136.9	135	1.9	11
10.8	3	□	MAS1080MB	34.4	57.0	103.0	101	2.0	11
10.8	6	□	MAS1080LB	66.8	91.0	137.0	135	2.0	11
10.9	3	□	MAS1090MB	34.7	57.0	103.0	101	2.0	11
10.9	6	□	MAS1090LB	67.4	91.0	137.0	135	2.0	11
11.0	3	●	MAS1100MB	35.0	57.0	103.0	101	2.0	11
11.0	6	●	MAS1100LB	68.0	91.0	137.0	135	2.0	11
11.08	3	●	⁎MAS1108MB	35.2	62.0	108.0	106	2.0	12
11.08	6	●	⁎MAS1108LB	68.5	96.0	142.0	140	2.0	12
11.1	3	□	MAS1110MB	35.3	62.0	108.0	106	2.0	12
11.1	6	□	MAS1110LB	68.6	96.0	142.0	140	2.0	12
11.2	3	□	MAS1120MB	35.6	62.0	108.0	106	2.0	12
11.2	6	□	MAS1120LB	69.2	96.0	142.0	140	2.0	12
11.3	3	□	MAS1130MB	36.0	62.1	108.1	106	2.1	12
11.3	6	□	MAS1130LB	69.9	96.1	142.1	140	2.1	12
11.4	3	□	MAS1140MB	36.3	62.1	108.1	106	2.1	12
11.4	6	□	MAS1140LB	70.5	96.1	142.1	140	2.1	12
11.5	3	□	MAS1150MB	36.6	62.1	108.1	106	2.1	12
11.5	6	□	MAS1150LB	71.1	96.1	142.1	140	2.1	12
11.6	3	□	MAS1160MB	36.9	62.1	108.1	106	2.1	12
11.6	6	□	MAS1160LB	71.7	96.1	142.1	140	2.1	12
11.7	3	□	MAS1170MB	37.2	62.1	108.1	106	2.1	12
11.7	6	□	MAS1170LB	72.3	96.1	142.1	140	2.1	12
11.8	3	□	MAS1180MB	37.5	62.1	108.1	106	2.1	12
11.8	6	□	MAS1180LB	72.9	96.1	142.1	140	2.1	12
11.9	3	□	MAS1190MB	37.9	62.2	108.2	106	2.2	12
11.9	6	□	MAS1190LB	73.6	96.2	142.2	140	2.2	12
12.0	3	●	MAS1200MB	38.2	62.2	108.2	106	2.2	12
12.0	6	●	MAS1200LB	74.2	96.2	142.2	140	2.2	12
12.1	3	□	MAS1210MB	38.5	67.2	117.2	115	2.2	13
12.1	6	□	MAS1210LB	74.8	102.2	152.2	150	2.2	13
12.2	3	□	MAS1220MB	38.8	67.2	117.2	115	2.2	13
12.2	6	□	MAS1220LB	75.4	102.2	152.2	150	2.2	13
12.3	3	□	MAS1230MB	39.1	67.2	117.2	115	2.2	13
12.3	6	□	MAS1230LB	76.0	102.2	152.2	150	2.2	13
12.4	3	□	MAS1240MB	39.5	67.3	117.3	115	2.3	13
12.4	6	□	MAS1240LB	76.7	102.3	152.3	150	2.3	13
12.5	3	●	MAS1250MB	39.8	67.3	117.3	115	2.3	13
12.5	6	●	MAS1250LB	77.3	102.3	152.3	150	2.3	13
12.6	3	□	MAS1260MB	40.1	67.3	117.3	115	2.3	13
12.6	6	□	MAS1260LB	77.9	102.3	152.3	150	2.3	13
12.7	3	□	MAS1270MB	40.4	67.3	117.3	115	2.3	13
12.7	6	□	MAS1270LB	78.5	102.3	152.3	150	2.3	13
12.8	3	□	MAS1280MB	40.7	67.3	117.3	115	2.3	13
12.8	6	□	MAS1280LB	79.1	102.3	152.3	150	2.3	13
12.9	3	□	MAS1290MB	41.0	67.3	117.3	115	2.3	13
12.9	6	□	MAS1290LB	79.7	102.3	152.3	150	2.3	13

⁎ Standard hole size for rolled thread taps.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
12.96	3	●	⁎MAS1296MB	41.3	67.4	117.4	115	2.4	13
12.96	6	●	⁎MAS1296LB	80.2	102.4	152.4	150	2.4	13
13.0	3	●	MAS1300MB	41.4	67.4	117.4	115	2.4	13
13.0	6	●	MAS1300LB	80.4	102.4	152.4	150	2.4	13
13.1	3	□	MAS1310MB	41.7	72.4	122.4	120	2.4	14
13.1	6	□	MAS1310LB	81.0	112.4	162.4	160	2.4	14
13.2	3	□	MAS1320MB	42.0	72.4	122.4	120	2.4	14
13.2	6	□	MAS1320LB	81.6	112.4	162.4	160	2.4	14
13.3	3	□	MAS1330MB	42.3	72.4	122.4	120	2.4	14
13.3	6	□	MAS1330LB	82.2	112.4	162.4	160	2.4	14
13.4	3	□	MAS1340MB	42.6	72.4	122.4	120	2.4	14
13.4	6	□	MAS1340LB	82.8	112.4	162.4	160	2.4	14
13.5	3	●	MAS1350MB	43.0	72.5	122.5	120	2.5	14
13.5	6	●	MAS1350LB	83.5	112.5	162.5	160	2.5	14
13.6	3	□	MAS1360MB	43.3	72.5	122.5	120	2.5	14
13.6	6	□	MAS1360LB	84.1	112.5	162.5	160	2.5	14
13.7	3	□	MAS1370MB	43.6	72.5	122.5	120	2.5	14
13.7	6	□	MAS1370LB	84.7	112.5	162.5	160	2.5	14
13.8	3	□	MAS1380MB	43.9	72.5	122.5	120	2.5	14
13.8	6	□	MAS1380LB	85.3	112.5	162.5	160	2.5	14
13.9	3	□	MAS1390MB	44.2	72.5	122.5	120	2.5	14
13.9	6	□	MAS1390LB	85.9	112.5	162.5	160	2.5	14
14.0	3	●	MAS1400MB	44.5	72.5	122.5	120	2.5	14
14.0	6	●	MAS1400LB	86.5	112.5	162.5	160	2.5	14
14.1	3	□	MAS1410MB	44.9	74.6	132.6	130	2.6	15
14.1	6	□	MAS1410LB	87.2	117.6	175.6	173	2.6	15
14.2	3	□	MAS1420MB	45.2	74.6	132.6	130	2.6	15
14.2	6	□	MAS1420LB	87.8	117.6	175.6	173	2.6	15
14.3	3	□	MAS1430MB	45.5	74.6	132.6	130	2.6	15
14.3	6	□	MAS1430LB	88.4	117.6	175.6	173	2.6	15
14.4	3	□	MAS1440MB	45.8	74.6	132.6	130	2.6	15
14.4	6	□	MAS1440LB	89.0	117.6	175.6	173	2.6	15
14.5	3	□	MAS1450MB	46.1	74.6	132.6	130	2.6	15
14.5	6	□	MAS1450LB	89.6	117.6	175.6	173	2.6	15
14.6	3	□	MAS1460MB	46.5	74.7	132.7	130	2.7	15
14.6	6	□	MAS1460LB	90.3	117.7	175.7	173	2.7	15
14.7	3	□	MAS1470MB	46.8	74.7	132.7	130	2.7	15
14.7	6	□	MAS1470LB	90.9	117.7	175.7	173	2.7	15
14.8	3	□	MAS1480MB	47.1	74.7	132.7	130	2.7	15
14.8	6	□	MAS1480LB	91.5	117.7	175.7	173	2.7	15
14.9	3	□	MAS1490MB	47.4	74.7	132.7	130	2.7	15
14.9	6	□	MAS1490LB	92.1	117.7	175.7	173	2.7	15
14.96	3	●	⁎MAS1496MB	47.6	74.7	132.7	130	2.7	15
14.96	6	●	⁎MAS1496LB	92.5	117.7	175.7	173	2.7	15
15.0	3	●	MAS1500MB	47.7	74.7	132.7	130	2.7	15
15.0	6	●	MAS1500LB	92.7	117.7	175.7	173	2.7	15
15.1	3	□	MAS1510MB	48.0	78.7	136.7	134	2.7	16
15.1	6	□	MAS1510LB	93.3	122.7	180.7	178	2.7	16

CUTTING CONDITIONS ➢ P089
TECHNICAL DATA ➢ R001

MAS

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
15.2	3	□	**MAS1520MB**	48.4	78.8	136.8	134	2.8	16
15.2	6	□	**MAS1520LB**	94.0	122.8	180.8	178	2.8	16
15.3	3	□	**MAS1530MB**	48.7	78.8	136.8	134	2.8	16
15.3	6	□	**MAS1530LB**	94.6	122.8	180.8	178	2.8	16
15.4	3	□	**MAS1540MB**	49.0	78.8	136.8	134	2.8	16
15.4	6	□	**MAS1540LB**	95.2	122.8	180.8	178	2.8	16
15.5	3	□	**MAS1550MB**	49.3	78.8	136.8	134	2.8	16
15.5	6	□	**MAS1550LB**	95.8	122.8	180.8	178	2.8	16
15.6	3	□	**MAS1560MB**	49.6	78.8	136.8	134	2.8	16
15.6	6	□	**MAS1560LB**	96.4	122.8	180.8	178	2.8	16

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
15.7	3	□	**MAS1570MB**	50.0	78.9	136.9	134	2.9	16
15.7	6	□	**MAS1570LB**	97.1	122.9	180.9	178	2.9	16
15.8	3	□	**MAS1580MB**	50.3	78.9	136.9	134	2.9	16
15.8	6	□	**MAS1580LB**	97.7	122.9	180.9	178	2.9	16
15.9	3	□	**MAS1590MB**	50.6	78.9	136.9	134	2.9	16
15.9	6	□	**MAS1590LB**	98.3	122.9	180.9	178	2.9	16
16.0	3	●	**MAS1600MB**	50.9	78.9	136.9	134	2.9	16
16.0	6	●	**MAS1600LB**	98.9	122.9	180.9	178	2.9	16

* Standard hole size for rolled thread taps.

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

CUTTING CONDITIONS ➤ P089
TECHNICAL DATA ➤ R001

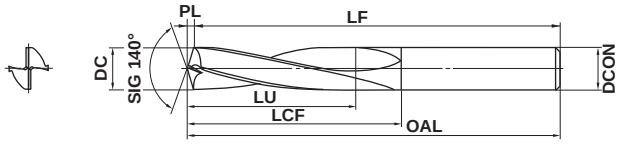
MAE

- Specially for aluminium and cast iron drilling.
- High hole accuracy.
- Pre-hole drilling for roll taps.

TOOL NEWS

P | M | **K** Cast Iron | **N** Non-ferrous Metal | S | H

External Coolant



DC=3	3<DC≤6	6<DC≤10	10<DC≤16
+0.005 0	+0.005 0	+0.005 0	+0.005 0
DCON=3	**3<DCON≤6**	**6<DCON≤10**	**10<DCON≤16**
0 −0.006	0 −0.008	0 −0.009	0 −0.011

Note 1) MAE drills are suitable for use with shrink fit holders.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
3.0	3	●	MAE0300MB	9.5	21.5	61.5	61	0.5	3
3.1	3	●	MAE0310MB	9.9	24.6	64.6	64	0.6	4
3.2	3	●	MAE0320MB	10.2	24.6	64.6	64	0.6	4
3.3	3	●	MAE0330MB	10.5	24.6	64.6	64	0.6	4
3.4	3	●	MAE0340MB	10.8	24.6	64.6	64	0.6	4
3.5	3	●	MAE0350MB	11.1	24.6	64.6	64	0.6	4
3.6	3	●	MAE0360MB	11.5	28.7	68.7	68	0.7	4
3.65	3	●	⁎MAE0365MB	11.7	28.7	68.7	68	0.7	4
3.7	3	●	MAE0370MB	11.8	28.7	68.7	68	0.7	4
3.8	3	●	MAE0380MB	12.1	28.7	68.7	68	0.7	4
3.9	3	●	MAE0390MB	12.4	28.7	68.7	68	0.7	4
4.0	3	●	MAE0400MB	12.7	28.7	68.7	68	0.7	4
4.1	3	●	MAE0410MB	13.0	31.7	71.7	71	0.7	5
4.2	3	●	MAE0420MB	13.4	31.8	71.8	71	0.8	5
4.3	3	●	MAE0430MB	13.7	31.8	71.8	71	0.8	5
4.4	3	●	MAE0440MB	14.0	31.8	71.8	71	0.8	5
4.5	3	●	MAE0450MB	14.3	31.8	71.8	71	0.8	5
4.6	3	●	⁎MAE0460MB	14.6	33.8	73.8	73	0.8	5
4.7	3	●	MAE0470MB	15.0	33.9	73.9	73	0.9	5
4.8	3	●	MAE0480MB	15.3	33.9	73.9	73	0.9	5
4.9	3	●	MAE0490MB	15.6	33.9	73.9	73	0.9	5
5.0	3	●	MAE0500MB	15.9	33.9	73.9	73	0.9	5
5.1	3	●	MAE0510MB	16.2	36.9	76.9	76	0.9	6
5.2	3	●	MAE0520MB	16.5	36.9	76.9	76	0.9	6
5.3	3	●	MAE0530MB	16.9	37.0	77.0	76	1.0	6
5.4	3	●	MAE0540MB	17.2	37.0	77.0	76	1.0	6
5.5	3	●	⁎MAE0550MB	17.5	37.0	77.0	76	1.0	6
5.6	3	●	MAE0560MB	17.8	40.0	80.0	79	1.0	6
5.7	3	●	MAE0570MB	18.1	40.0	80.0	79	1.0	6
5.8	3	●	MAE0580MB	18.5	40.1	80.1	79	1.1	6
5.9	3	●	MAE0590MB	18.8	40.1	80.1	79	1.1	6

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
6.0	3	●	MAE0600MB	19.1	40.1	80.1	79	1.1	6
6.1	3	●	MAE0610MB	19.4	43.1	85.1	84	1.1	7
6.2	3	●	MAE0620MB	19.7	43.1	85.1	84	1.1	7
6.3	3	●	MAE0630MB	20.0	43.1	85.1	84	1.1	7
6.4	3	●	MAE0640MB	20.4	43.2	85.2	84	1.2	7
6.5	3	●	MAE0650MB	20.7	43.2	85.2	84	1.2	7
6.6	3	●	MAE0660MB	21.0	43.2	85.2	84	1.2	7
6.7	3	●	MAE0670MB	21.3	43.2	85.2	84	1.2	7
6.8	3	●	MAE0680MB	21.6	43.2	85.2	84	1.2	7
6.9	3	●	MAE0690MB	22.0	43.3	85.3	84	1.3	7
7.0	3	●	MAE0700MB	22.3	43.3	85.3	84	1.3	7
7.1	3	●	MAE0710MB	22.6	49.3	91.3	90	1.3	8
7.2	3	●	MAE0720MB	22.9	49.3	91.3	90	1.3	8
7.3	3	●	MAE0730MB	23.2	49.3	91.3	90	1.3	8
7.35	3	●	⁎MAE0735MB	23.4	49.3	91.3	90	1.3	8
7.4	3	●	MAE0740MB	23.5	49.3	91.3	90	1.3	8
7.5	3	●	MAE0750MB	23.9	49.4	91.4	90	1.4	8
7.6	3	●	MAE0760MB	24.2	49.4	91.4	90	1.4	8
7.7	3	●	MAE0770MB	24.5	49.4	91.4	90	1.4	8
7.8	3	●	MAE0780MB	24.8	49.4	91.4	90	1.4	8
7.9	3	●	MAE0790MB	25.1	49.4	91.4	90	1.4	8
8.0	3	●	MAE0800MB	25.5	49.5	91.5	90	1.5	8
8.1	3	●	MAE0810MB	25.8	51.5	95.5	94	1.5	9
8.2	3	●	MAE0820MB	26.1	51.5	95.5	94	1.5	9
8.3	3	●	MAE0830MB	26.4	51.5	95.5	94	1.5	9
8.4	3	●	MAE0840MB	26.7	51.5	95.5	94	1.5	9
8.5	3	●	MAE0850MB	27.0	51.5	95.5	94	1.5	9
8.6	3	●	MAE0860MB	27.4	51.6	95.6	94	1.6	9
8.7	3	●	MAE0870MB	27.7	51.6	95.6	94	1.6	9
8.8	3	●	MAE0880MB	28.0	51.6	95.6	94	1.6	9
8.9	3	●	MAE0890MB	28.3	51.6	95.6	94	1.6	9

⁎ Standard hole size for rolled thread taps.

CUTTING CONDITIONS ➤ P089
TECHNICAL DATA ➤ R001

MAE

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
9.0	3	●	MAE0900MB	28.6	51.6	95.6	94	1.6	9
9.1	3	●	MAE0910MB	29.0	54.7	98.7	97	1.7	10
9.2	3	●	MAE0920MB	29.3	54.7	98.7	97	1.7	10
9.21	3	●	* MAE0921MB	29.3	54.7	98.7	97	1.7	10
9.3	3	●	MAE0930MB	29.6	54.7	98.7	97	1.7	10
9.4	3	●	MAE0940MB	29.9	54.7	98.7	97	1.7	10
9.5	3	●	MAE0950MB	30.2	54.7	98.7	97	1.7	10
9.6	3	●	MAE0960MB	30.5	54.7	98.7	97	1.7	10
9.7	3	●	MAE0970MB	30.9	54.8	98.8	97	1.8	10
9.8	3	●	MAE0980MB	31.2	54.8	98.8	97	1.8	10
9.9	3	●	MAE0990MB	31.5	54.8	98.8	97	1.8	10
10.0	3	●	MAE1000MB	31.8	54.8	98.8	97	1.8	10
10.1	3	□	MAE1010MB	32.1	56.8	102.8	101	1.8	11
10.2	3	□	MAE1020MB	32.5	56.9	102.9	101	1.9	11
10.3	3	●	MAE1030MB	32.8	56.9	102.9	101	1.9	11
10.4	3	□	MAE1040MB	33.1	56.9	102.9	101	1.9	11
10.5	3	●	MAE1050MB	33.4	56.9	102.9	101	1.9	11
10.6	3	□	MAE1060MB	33.7	56.9	102.9	101	1.9	11
10.7	3	□	MAE1070MB	34.0	56.9	102.9	101	1.9	11
10.8	3	□	MAE1080MB	34.4	57.0	103.0	101	2.0	11
10.9	3	□	MAE1090MB	34.7	57.0	103.0	101	2.0	11
11.0	3	●	MAE1100MB	35.0	57.0	103.0	101	2.0	11
11.08	3	●	* MAE1108MB	35.2	62.0	108.0	106	2.0	12
11.1	3	□	MAE1110MB	35.3	62.0	108.0	106	2.0	12
11.2	3	□	MAE1120MB	35.6	62.0	108.0	106	2.0	12
11.3	3	□	MAE1130MB	36.0	62.1	108.1	106	2.1	12
11.4	3	□	MAE1140MB	36.3	62.1	108.1	106	2.1	12
11.5	3	□	MAE1150MB	36.6	62.1	108.1	106	2.1	12
11.6	3	□	MAE1160MB	36.9	62.1	108.1	106	2.1	12
11.7	3	□	MAE1170MB	37.2	62.1	108.1	106	2.1	12
11.8	3	□	MAE1180MB	37.5	62.1	108.1	106	2.1	12
11.9	3	□	MAE1190MB	37.9	62.2	108.2	106	2.2	12
12.0	3	●	MAE1200MB	38.2	62.2	108.2	106	2.2	12
12.1	3	□	MAE1210MB	38.5	67.2	117.2	115	2.2	13
12.2	3	□	MAE1220MB	38.8	67.2	117.2	115	2.2	13
12.3	3	□	MAE1230MB	39.1	67.2	117.2	115	2.2	13
12.4	3	□	MAE1240MB	39.5	67.3	117.3	115	2.3	13
12.5	3	●	MAE1250MB	39.8	67.3	117.3	115	2.3	13
12.6	3	□	MAE1260MB	40.1	67.3	117.3	115	2.3	13
12.7	3	□	MAE1270MB	40.4	67.3	117.3	115	2.3	13
12.8	3	□	MAE1280MB	40.7	67.3	117.3	115	2.3	13
12.9	3	□	MAE1290MB	41.0	67.3	117.3	115	2.3	13
12.96	3	●	* MAE1296MB	41.3	67.4	117.4	115	2.4	13
13.0	3	●	MAE1300MB	41.4	67.4	117.4	115	2.4	13
13.1	3	□	MAE1310MB	41.7	72.4	122.4	120	2.4	14
13.2	3	□	MAE1320MB	42.0	72.4	122.4	120	2.4	14
13.3	3	□	MAE1330MB	42.3	72.4	122.4	120	2.4	14
13.4	3	□	MAE1340MB	42.6	72.4	122.4	120	2.4	14

* Standard hole size for rolled thread taps.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	LF	PL	DCON
13.5	3	●	MAE1350MB	43.0	72.5	122.5	120	2.5	14
13.6	3	□	MAE1360MB	43.3	72.5	122.5	120	2.5	14
13.7	3	□	MAE1370MB	43.6	72.5	122.5	120	2.5	14
13.8	3	□	MAE1380MB	43.9	72.5	122.5	120	2.5	14
13.9	3	□	MAE1390MB	44.2	72.5	122.5	120	2.5	14
14.0	3	●	MAE1400MB	44.5	72.5	122.5	120	2.5	14
14.1	3	□	MAE1410MB	44.9	74.6	132.6	130	2.6	15
14.2	3	□	MAE1420MB	45.2	74.6	132.6	130	2.6	15
14.3	3	□	MAE1430MB	45.5	74.6	132.6	130	2.6	15
14.4	3	□	MAE1440MB	45.8	74.6	132.6	130	2.6	15
14.5	3	□	MAE1450MB	46.1	74.6	132.6	130	2.6	15
14.6	3	□	MAE1460MB	46.5	74.7	132.7	130	2.7	15
14.7	3	□	MAE1470MB	46.8	74.7	132.7	130	2.7	15
14.8	3	□	MAE1480MB	47.1	74.7	132.7	130	2.7	15
14.9	3	□	MAE1490MB	47.4	74.7	132.7	130	2.7	15
14.96	3	●	* MAE1496MB	47.6	74.7	132.7	130	2.7	15
15.0	3	●	MAE1500MB	47.7	74.7	132.7	130	2.7	15
15.1	3	□	MAE1510MB	48.0	78.7	136.7	134	2.7	16
15.2	3	□	MAE1520MB	48.4	78.8	136.8	134	2.8	16
15.3	3	□	MAE1530MB	48.7	78.8	136.8	134	2.8	16
15.4	3	□	MAE1540MB	49.0	78.8	136.8	134	2.8	16
15.5	3	□	MAE1550MB	49.3	78.8	136.8	134	2.8	16
15.6	3	□	MAE1560MB	49.6	78.8	136.8	134	2.8	16
15.7	3	□	MAE1570MB	50.0	78.9	136.9	134	2.9	16
15.8	3	□	MAE1580MB	50.3	78.9	136.9	134	2.9	16
15.9	3	□	MAE1590MB	50.6	78.9	136.9	134	2.9	16
16.0	3	●	MAE1600MB	50.9	78.9	136.9	134	2.9	16

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

MAE / MAS

RECOMMENDED CUTTING CONDITIONS

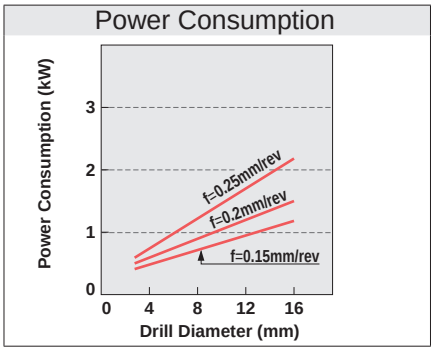
Type		Work Material	Drill Dia. ϕ3.0−ϕ6.0		Drill Dia. ϕ6.1−ϕ10.0		Drill Dia. ϕ10.1−ϕ16.0	
			Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
MAE	N	Aluminium Alloy Casting	90 (40−140)	0.15 (0.05−0.3)	100 (50−150)	0.2 (0.1−0.3)	120 (60−170)	0.25 (0.1−0.4)
		Aluminium Alloy Die Casting	100 (60−150)	0.12 (0.05−0.25)	110 (70−160)	0.15 (0.05−0.25)	130 (80−180)	0.2 (0.1−0.3)
	K	Gray Cast Iron	40 (20−60)	0.15 (0.1−0.2)	60 (40−80)	0.2 (0.1−0.3)	80 (60−100)	0.3 (0.2−0.4)
		Ductile Cast Iron	30 (20−40)	0.1 (0.05−0.15)	40 (20−60)	0.12 (0.05−0.2)	60 (40−80)	0.2 (0.1−0.3)
MAS	N	Aluminium Alloy Casting	100 (60−150)	0.15 (0.05−0.3)	120 (80−170)	0.2 (0.1−0.3)	150 (100−200)	0.25 (0.1−0.4)
		Aluminium Alloy Die Casting	120 (80−170)	0.12 (0.05−0.25)	150 (100−180)	0.15 (0.05−0.25)	160 (120−200)	0.2 (0.1−0.3)
	K	Gray Cast Iron	60 (40−80)	0.15 (0.1−0.2)	80 (60−110)	0.2 (0.1−0.3)	100 (70−130)	0.3 (0.2−0.4)
		Ductile Cast Iron	45 (30−60)	0.1 (0.05−0.15)	60 (40−80)	0.12 (0.05−0.2)	80 (60−100)	0.2 (0.1−0.3)

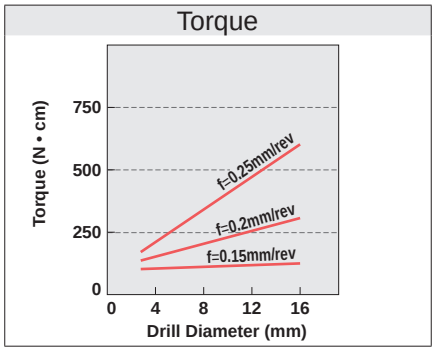
HOLE AND DRILL DIAMETERS FOR THREAD TAPPING

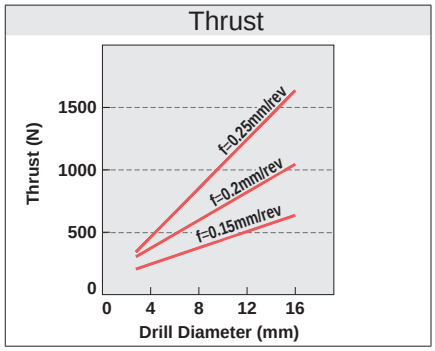
Thread Size	Thread Tapping			Rolled Thread Tapping		
	Drill Diameter (DC)	Hole Diameter Tolerance		Drill Diameter (DC)	Hole Diameter Tolerance	
		max.	min.		max.	min.
M4x0.7	**3.3**	3.242	3.422	**3.65**	3.65	3.70
M5x0.8	**4.2**	4.134	4.334	**4.60**	4.59	4.66
M6x1.0	**5.0**	4.917	5.153	**5.50**	5.48	5.57
M8x1.25	**6.8**	6.647	6.912	**7.35**	7.34	7.41
M10x1.5	**8.5**	8.376	8.676	**9.21**	9.18	9.28
M12x1.75	**10.3**	10.106	10.441	**11.08**	11.05	11.15
M14x2	**12.0**	11.835	12.210	**12.96**	12.92	13.04
M16x2	**14.0**	13.835	14.210	**14.96**	14.92	15.04

CUTTING RESISTANCE

Workpiece : JIS AC4B-T6 Drilled Depth : L/D=3(Through Hole) Cutting Speed : 100m/min WSO (10%)

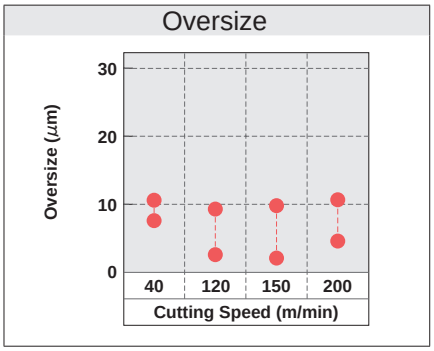


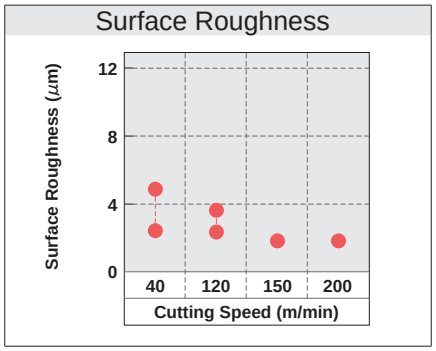


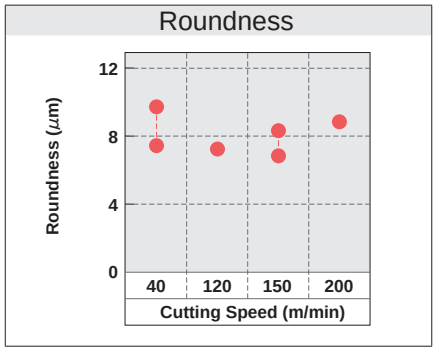


MACHINED HOLE ACCURACY

Tool : MAS1100MB Workpiece : JIS AC4B-T6 Feed : 0.35mm/rev Drilled Depth : 33mm WSO (10%)







MCC

CNC Machine/For CFRP

●The 90° cutting angle thoroughly reduces thrust and minimizes delamination.

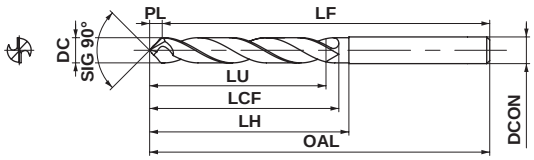
HAND BOOK

P | M | K | **N** | S | H

Non-ferrous Metal

CNC Machine × CFRP

External Coolant



3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
0 / – 0.018	0 / – 0.022	0 / – 0.027	0 / – 0.033
DCON=6	**6<DCON≤10**	**10<DCON≤12**	
0 / – 0.008	0 / – 0.009	0 / – 0.011	

Hole Diameter		Drill Diameter		Hole Depth	Order Number	DD2105	Dimensions (mm)						
* AWG	Inch (inch)	DC (mm)	Inch (inch)	(L/D)			LU	LCF	LH	OAL	LF	PL	DCON
—	3/16	4.76	.1875	3	**MCC0476X03S060**	●	16.7	40	40	80	77.6	1.3	6
—	1/4	6.38	.251	3	**MCC0638X03S080**	●	22.3	50	50	90	86.8	1.8	8
—	5/16	7.96	.3125	3	**MCC0796X03S080**	●	27.9	50	50	90	86.0	2.8	8
—	3/8	9.55	.375	3	**MCC0955X03S100**	●	33.5	50	50	100	95.2	1.8	10
—	7/16	11.14	.4375	3	**MCC1114X03S120**	●	39.0	60	60	110	104.4	2.8	12

***AWG :** American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP			
Drill Dia. **DC** (mm)	Drill Dia. **DC** (inch)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)
4.76	.1875	100	6700	0.08 (0.05—0.12)	540
6.38	.251	100	5000	0.1 (0.05—0.12)	500
7.96	.3125	100	4000	0.1 (0.05—0.12)	400
9.55	.375	100	3400	0.1 (0.05—0.12)	340
11.14	.4375	100	2900	0.1 (0.05—0.12)	290

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

MCA

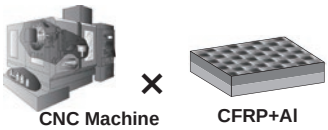
CNC Machine/For CFRP+Al

●The gap between CFPR and aluminium machining hole diameter is reduced by good chip discharge by special groove structure.

HAND BOOK

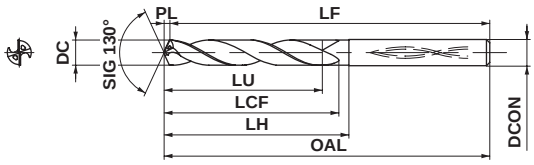
P | M | K | **N** | S | H

Non-ferrous Metal



CNC Machine × CFRP+Al

Internal Coolant



6<DC≤10	0 / – 0.022
6<DCON≤10	0 / – 0.009

Hole Diameter		Drill Diameter		Hole Depth	Order Number	DD2110	Dimensions (mm)						
AWG*	Inch (inch)	DC (mm)	Inch (inch)	(L/D)			LU	LCF	LH	OAL	LF	PL	DCON
–	1/4	6.38	.251	5	**MCA0638X05S070**	□	33.4	51	51	91	89.5	2.4	7
–	3/8	9.55	.375	5	**MCA0955X05S100**	□	50.0	77	77	118	115.8	3.2	10

*AWG : American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP				Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc			
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)
6.38	.251	100	5000	0.15 (0.10—0.20)	750	100	5000	0.03 (0.02—0.04)	150
9.55	.375	100	3400	0.15 (0.10—0.20)	680	100	3400	0.03 (0.02—0.04)	100

Note 1) We recommend to divide cutting conditions in each work materials.

MCT

CNC Machine/For CFRP+Ti

●The sharp cutting edge achieved high quality hole machining with CFRP and titanium processing.

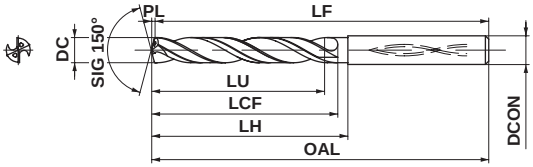
HAND BOOK

P | M | K | **N** | S | H

Non-ferrous Metal

CNC Machine × CFRP+Ti

Internal Coolant



6<DC≤10	0 / – 0.022
6<DCON≤10	0 / – 0.009

Hole Diameter		Drill Diameter		Hole Depth	Order Number	TF15	Dimensions (mm)						
AWG*	Inch (inch)	DC (mm)	Inch (inch)	(L/D)			LU	LCF	LH	OAL	LF	PL	DCON
—	1/4	6.38	.251	5	**MCT0638X05S070**	□	32.8	47	47	96	95.1	0.7	7
—	3/8	9.55	.375	5	**MCT0955X05S100**	□	49.1	71	71	122	120.7	0.9	10

*AWG : American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP				Titanium Alloy Ti-6Al-4V				
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Peck machining (mm)
6.38	.251	100	5000	0.15 (0.10—0.20)	750	15	750	0.02 (0.01—0.03)	15	1
9.55	.375	100	3400	0.15 (0.10—0.20)	680	15	500	0.02 (0.01—0.03)	10	1

Note 1) This condition is for when internal air or mist is used.
Note 2) We recommend to divide cutting conditions in each work materials.

□ : **Non stock, produced to order only.**

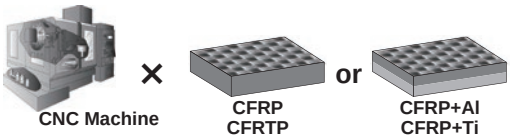
MCW

CNC Machine/CFRP and Stack Material High Precision

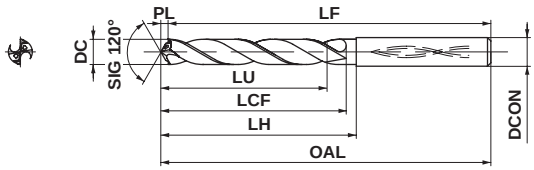
●The unique cutting edge shape suppresses the gap between the machining hole diameter of stack material and the burr on the exit side of the processing hole.

HAND BOOK

P	M	K	N	S	H
			Non-ferrous Metal		



Internal Coolant



6<DC≤10	0 / – 0.022
6<DCON≤10	0 / – 0.009

Hole Diameter		Drill Diameter		Hole Depth	Order Number	HTi10	DD2110	Dimensions (mm)						
AWG*	Inch (inch)	DC (mm)	Inch (inch)	(L/D)				LU	LCF	LH	OAL	LF	PL	DCON
—	1/4	6.38	.251	5	**MCW0638X05S070**	□	□	33.7	52	52	92	90.2	1.8	7
—	3/8	9.55	.375	5	**MCW0955X05S100**	□	□	50.6	73	73	119	116.2	2.8	10

*AWG : American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP			
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)
6.38	.251	100	5000	0.15 (0.10—0.20)	750
9.55	.375	100	3400	0.15 (0.10—0.20)	680

Work Material		Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc					Titanium Alloy Ti-6Al-4V				
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Peck Machining (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Peck Machining (mm)
6.38	.251	100	5000	0.15 (0.10—0.20)	750	3	15	750	0.02 (0.01—0.03)	15	1
9.55	.375	100	3400	0.15 (0.10—0.20)	500	3	15	500	0.02 (0.01—0.03)	10	1

Note 1) This condition is for when internal air or mist is used.
Note 2) We recommend to divide cutting conditions in each work materials.

MCCH

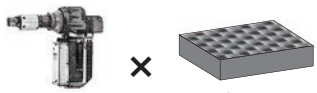
Hand Tool/For CFRP

●Highly reliable hole machining is achieved by the adoption of cemented carbide for hand tools and double angle.

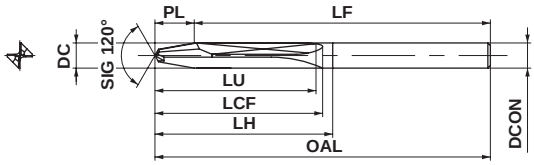
HAND BOOK

P | M | K | **N** | S | H

Non-ferrous Metal



Hand Tool × CFRP



1≤DC≤3	3<DC≤6	6<DC≤10
0 – 0.014	0 – 0.018	0 – 0.022
DCON=3	**3<DCON≤6**	**6<DCON≤10**
0 – 0.006	0 – 0.008	0 – 0.009

Hole Diameter		Drill Diameter		Hole Depth	Order Number	DT2030	Dimensions (mm)						
AWG*	Inch (inch)	DC (mm)	Inch (inch)	(L/D)			LU	LCF	LH	OAL	LF	PL	DCON
#40	—	2.5	.0985	15	**MCCH0250X15S030**	●	42.1	48	50	100	95.4	4.6	3
#30	—	3.26	.1285	10	**MCCH0326X10S040**	●	38.6	48	50	100	94.0	6.0	4
#20	—	4.1	.1615	8	**MCCH0410X08S050**	●	40.3	48	50	100	92.5	7.5	5
#11	—	4.86	.1915	5	**MCCH0486X05S050**	●	33.2	48	50	100	91.1	8.9	5
—	1/4	6.38	.251	3	**MCCH0638X03S070**	●	30.8	48	50	100	88.3	11.7	7
—	3/8	9.55	.375	2	**MCCH0955X02S100**	●	36.6	48	50	100	82.5	17.5	10

*AWG : American Wire Gage

● : Inventory maintained in Japan.

MCAH

Hand Tool/For CFRP+Al

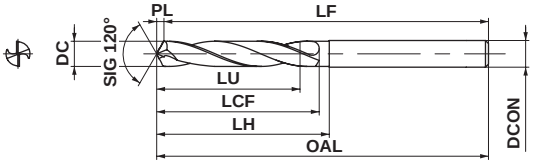
●Highly reliable hole machining is achieved by setting cemented carbide for hand tools and combination of the groove shape and optimal twisting angle.

HAND BOOK

P | M | K | **N** | S | H

Non-ferrous Metal

Hand Tool × CFRP+Al



1≤DC≤3	3<DC≤6	6<DC≤10
0 – 0.014	0 – 0.018	0 – 0.022
DCON=3	**3<DCON≤6**	**6<DCON≤10**
0 – 0.006	0 – 0.008	0 – 0.009

Hole Diameter		Drill Diameter		Hole Depth	Order Number	DT2030	Dimensions (mm)						
AWG*	Inch (inch)	DC (mm)	Inch (inch)	(L/D)			LU	LCF	LH	OAL	LF	PL	DCON
#40	–	2.5	.0985	15	**MCAH0250X15S030**	●	38.2	50	50	100	99.3	4.0	3
#30	–	3.26	.1285	15	**MCAH0326X15S040**	●	49.8	50	50	100	99.1	4.8	4
#20	–	4.1	.1615	10	**MCAH0410X10S050**	●	42.2	50	50	100	98.8	5.6	5
#11	–	4.86	.1915	8	**MCAH0486X08S050**	●	40.3	50	50	100	98.6	1.5	5
–	1/4	6.38	.251	5	**MCAH0638X05S070**	●	33.7	50	50	100	98.2	2.2	7
–	3/8	9.55	.375	3	**MCAH0955X03S100**	●	31.5	50	50	100	97.2	0.9	10

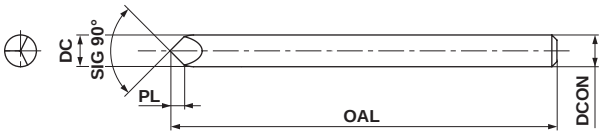
***AWG :** American Wire Gage

MSP

SPOT DRILL

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



Order Number	Grade	Stock	Dimensions (mm)				Diameter Range (mm)
			DC	OAL	DCON	PL	
MSP0300SB	**VP15TF**	●	3.0	38.0	3.0	1.5	**0.1–0.99**

RECOMMENDED CUTTING CONDITIONS

Hole Size Range (mm)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
0.1–0.99	10000	0.0005 (0.00025–0.001)	5

● : **Inventory maintained in Japan.**

MSE

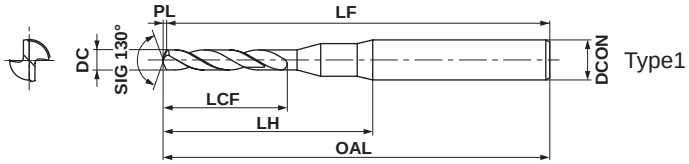
MIRACLE MINI STAR DRILL

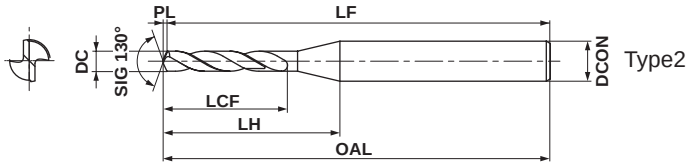
- Wide flute for preventing chip jamming.
- Stable, small diameter machining.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	

External Coolant





0.10≤DC≤0.99
0 / −0.009
DCON=3
0 / −0.006

Note 1) MSE drills are suitable for use with shrink fit holders.

DC (mm)	VP20MF	VP15TF	Order Number	Dimensions (mm) LCF	LH	OAL	LF	PL	DCON	Type
0.10	●		MSE0010SB	1.2	9.7	38.0	38	0.02	3	1
0.11	●		MSE0011SB	1.2	9.7	38.0	38	0.03	3	1
0.12	●		MSE0012SB	1.4	9.7	38.0	38	0.03	3	1
0.13	●		MSE0013SB	1.4	9.7	38.0	38	0.03	3	1
0.14	●		MSE0014SB	2.0	9.7	38.0	38	0.03	3	1
0.15	●		MSE0015SB	2.0	9.7	38.0	38	0.03	3	1
0.16	●		MSE0016SB	2.0	9.7	38.0	38	0.04	3	1
0.17	●		MSE0017SB	2.0	9.7	38.0	38	0.04	3	1
0.18	●		MSE0018SB	2.0	9.7	38.0	38	0.04	3	1
0.19	●		MSE0019SB	2.0	9.7	38.0	38	0.04	3	1
0.20	●		MSE0020SB	2.6	9.8	38.1	38	0.05	3	1
0.21	●		MSE0021SB	2.6	9.8	38.1	38	0.05	3	1
0.22	●		MSE0022SB	2.6	9.8	38.1	38	0.05	3	1
0.23	●		MSE0023SB	2.6	9.8	38.1	38	0.05	3	1
0.24	●		MSE0024SB	3.1	9.8	38.1	38	0.06	3	1
0.25	●		MSE0025SB	3.1	9.8	38.1	38	0.06	3	1
0.26	●		MSE0026SB	3.1	9.8	38.1	38	0.06	3	1
0.27	●		MSE0027SB	3.1	9.8	38.1	38	0.06	3	1
0.28	●		MSE0028SB	3.1	9.8	38.1	38	0.07	3	1
0.29	●		MSE0029SB	3.1	9.8	38.1	38	0.07	3	1
0.30		●	MSE0030SB	5.1	10.3	38.1	38	0.07	3	2
0.31		●	MSE0031SB	5.1	10.3	38.1	38	0.07	3	2
0.32		●	MSE0032SB	5.1	10.3	38.1	38	0.07	3	2
0.33		●	MSE0033SB	5.1	10.3	38.1	38	0.08	3	2
0.34		●	MSE0034SB	6.1	11.3	38.1	38	0.08	3	2
0.35		●	MSE0035SB	6.1	11.2	38.1	38	0.08	3	2
0.36		●	MSE0036SB	6.1	11.2	38.1	38	0.08	3	2
0.37		●	MSE0037SB	6.1	11.2	38.1	38	0.09	3	2

DC (mm)	VP20MF	VP15TF	Order Number	Dimensions (mm) LCF	LH	OAL	LF	PL	DCON	Type
0.38		●	MSE0038SB	6.1	11.2	38.1	38	0.09	3	2
0.39		●	MSE0039SB	6.1	11.2	38.1	38	0.09	3	2
0.40		●	MSE0040SB	7.1	12.2	38.1	38	0.09	3	2
0.41		●	MSE0041SB	7.1	12.1	38.1	38	0.10	3	2
0.42		●	MSE0042SB	7.1	12.1	38.1	38	0.10	3	2
0.43		●	MSE0043SB	7.1	12.1	38.1	38	0.10	3	2
0.44		●	MSE0044SB	7.1	12.1	38.1	38	0.10	3	2
0.45		●	MSE0045SB	7.1	12.1	38.1	38	0.10	3	2
0.46		●	MSE0046SB	7.1	12.0	38.1	38	0.11	3	2
0.47		●	MSE0047SB	7.1	12.0	38.1	38	0.11	3	2
0.48		●	MSE0048SB	7.1	12.0	38.1	38	0.11	3	2
0.49		●	MSE0049SB	7.1	12.0	38.1	38	0.11	3	2
0.50		●	MSE0050SB	7.1	12.0	38.1	38	0.12	3	2
0.51		●	MSE0051SB	7.1	11.9	38.1	38	0.12	3	2
0.52		●	MSE0052SB	7.1	11.9	38.1	38	0.12	3	2
0.53		●	MSE0053SB	7.1	11.9	38.1	38	0.12	3	2
0.54		●	MSE0054SB	7.1	11.9	38.1	38	0.13	3	2
0.55		●	MSE0055SB	7.1	11.9	38.1	38	0.13	3	2
0.56		●	MSE0056SB	7.1	11.9	38.1	38	0.13	3	2
0.57		●	MSE0057SB	7.1	11.8	38.1	38	0.13	3	2
0.58		●	MSE0058SB	7.1	11.8	38.1	38	0.14	3	2
0.59		●	MSE0059SB	7.1	11.8	38.1	38	0.14	3	2
0.60		●	MSE0060SB	7.1	11.8	38.1	38	0.14	3	2
0.61		●	MSE0061SB	7.1	11.8	38.1	38	0.14	3	2
0.62		●	MSE0062SB	7.1	11.7	38.1	38	0.14	3	2
0.63		●	MSE0063SB	7.2	11.8	38.2	38	0.15	3	2
0.64		●	MSE0064SB	7.2	11.8	38.2	38	0.15	3	2
0.65		●	MSE0065SB	7.2	11.8	38.2	38	0.15	3	2

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

MSE

MIRACLE MINI STAR DRILL

DC (mm)	VP20MF	VP15TF	Order Number	Dimensions (mm) LCF	LH	OAL	LF	PL	DCON	Type
0.66		●	**MSE0066SB**	7.2	11.8	38.2	38	0.15	3	2
0.67		●	**MSE0067SB**	7.2	11.7	38.2	38	0.16	3	2
0.68		●	**MSE0068SB**	7.2	11.7	38.2	38	0.16	3	2
0.69		●	**MSE0069SB**	7.2	11.7	38.2	38	0.16	3	2
0.70		●	**MSE0070SB**	8.2	12.7	38.2	38	0.16	3	2
0.71		●	**MSE0071SB**	8.2	12.7	38.2	38	0.17	3	2
0.72		●	**MSE0072SB**	8.2	12.7	38.2	38	0.17	3	2
0.73		●	**MSE0073SB**	8.2	12.6	38.2	38	0.17	3	2
0.74		●	**MSE0074SB**	8.2	12.6	38.2	38	0.17	3	2
0.75		●	**MSE0075SB**	8.2	12.6	38.2	38	0.17	3	2
0.76		●	**MSE0076SB**	8.2	12.6	38.2	38	0.18	3	2
0.77		●	**MSE0077SB**	8.2	12.6	38.2	38	0.18	3	2
0.78		●	**MSE0078SB**	8.2	12.5	38.2	38	0.18	3	2
0.79		●	**MSE0079SB**	8.2	12.5	38.2	38	0.18	3	2
0.80		●	**MSE0080SB**	10.2	14.5	38.2	38	0.19	3	2
0.81		●	**MSE0081SB**	10.2	14.5	38.2	38	0.19	3	2
0.82		●	**MSE0082SB**	10.2	14.5	38.2	38	0.19	3	2

DC (mm)	VP20MF	VP15TF	Order Number	Dimensions (mm) LCF	LH	OAL	LF	PL	DCON	Type
0.83		●	**MSE0083SB**	10.2	14.5	38.2	38	0.19	3	2
0.84		●	**MSE0084SB**	10.2	14.4	38.2	38	0.20	3	2
0.85		●	**MSE0085SB**	10.2	14.4	38.2	38	0.20	3	2
0.86		●	**MSE0086SB**	10.2	14.4	38.2	38	0.20	3	2
0.87		●	**MSE0087SB**	10.2	14.4	38.2	38	0.20	3	2
0.88		●	**MSE0088SB**	10.2	14.4	38.2	38	0.21	3	2
0.89		●	**MSE0089SB**	10.2	14.3	38.2	38	0.21	3	2
0.90		●	**MSE0090SB**	10.2	14.3	38.2	38	0.21	3	2
0.91		●	**MSE0091SB**	10.2	14.3	38.2	38	0.21	3	2
0.92		●	**MSE0092SB**	10.2	14.3	38.2	38	0.21	3	2
0.93		●	**MSE0093SB**	10.2	14.3	38.2	38	0.22	3	2
0.94		●	**MSE0094SB**	10.2	14.2	38.2	38	0.22	3	2
0.95		●	**MSE0095SB**	10.2	14.2	38.2	38	0.22	3	2
0.96		●	**MSE0096SB**	10.2	14.2	38.2	38	0.22	3	2
0.97		●	**MSE0097SB**	10.2	14.2	38.2	38	0.23	3	2
0.98		●	**MSE0098SB**	10.2	14.2	38.2	38	0.23	3	2
0.99		●	**MSE0099SB**	10.2	14.2	38.2	38	0.23	3	2

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB) AISI 1010 etc					Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc				
Dia. DC (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)
0.1	6	20000	0.002 (0.001−0.003)	0.02	40	6	20000	0.002 (0.001−0.003)	0.02	40
0.12	8	20000	0.002 (0.001−0.003)	0.02	40	8	20000	0.002 (0.001−0.003)	0.02	40
0.16	10	20000	0.002 (0.001−0.003)	0.02	40	10	20000	0.002 (0.001−0.003)	0.02	40
0.2	13	20000	0.003 (0.002−0.004)	0.04	60	13	20000	0.003 (0.002−0.004)	0.04	60
0.25	16	20000	0.003 (0.002−0.004)	0.04	60	16	20000	0.003 (0.002−0.004)	0.04	60
0.32	20	20000	0.004 (0.003−0.005)	0.05	80	20	20000	0.004 (0.003−0.005)	0.05	80
0.4	25	20000	0.004 (0.003−0.005)	0.05	80	25	20000	0.004 (0.003−0.005)	0.05	80
0.5	31	20000	0.006 (0.005−0.007)	0.1	120	31	20000	0.006 (0.005−0.007)	0.1	120
0.63	40	20000	0.008 (0.006−0.01)	0.1	160	40	20000	0.008 (0.006−0.01)	0.1	160
0.8	50	20000	0.02 (0.015−0.025)	0.3	400	50	20000	0.015 (0.012−0.018)	0.3	300
0.99	62	20000	0.04 (0.03−0.05)	0.3	800	62	20000	0.02 (0.015−0.025)	0.3	400

Note 1) When drilling holes up to Φ0.3mm, the use of a spot drill is recommended.
(Order number : MSP0300SB, Cutting conditions : Refer to page P096.)
Note 2) Change cutting conditions depending on your machine and workpiece rigidity.
Note 3) When machining holes over 5D, reduce the step stated above.
Note 4) The use of water-soluble fluid (diluted by 20 times) is recommended for drilling under the cutting conditions above.
Lower the revolutions if you use oil fluid or mist.

● : **Inventory maintained in Japan.**

Work Material	Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc					Pre-Hardened Steel (35−45HRC) AISI P21, AISI P20 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)
0.1	6	20000	0.002 (0.001−0.003)	0.02	40	6	20000	0.002 (0.001−0.003)	0.02	40
0.12	8	20000	0.002 (0.001−0.003)	0.02	40	8	20000	0.002 (0.001−0.003)	0.02	40
0.16	10	20000	0.002 (0.001−0.003)	0.02	40	10	20000	0.002 (0.001−0.003)	0.02	40
0.2	13	20000	0.003 (0.002−0.004)	0.04	60	13	20000	0.003 (0.002−0.004)	0.04	60
0.25	16	20000	0.003 (0.002−0.004)	0.04	60	16	20000	0.003 (0.002−0.004)	0.04	60
0.32	20	20000	0.004 (0.003−0.005)	0.05	80	20	20000	0.004 (0.003−0.005)	0.05	80
0.4	25	20000	0.004 (0.003−0.005)	0.05	80	25	20000	0.004 (0.003−0.005)	0.05	80
0.5	31	20000	0.006 (0.005−0.007)	0.1	120	31	20000	0.006 (0.005−0.007)	0.1	120
0.63	40	20000	0.008 (0.006−0.01)	0.1	160	40	20000	0.008 (0.006−0.01)	0.1	160
0.8	50	20000	0.015 (0.012−0.018)	0.3	300	50	20000	0.015 (0.012−0.018)	0.3	300
0.99	62	20000	0.02 (0.015−0.025)	0.3	400	62	20000	0.02 (0.015−0.025)	0.3	400

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc					Gray Cast Iron (≤350MPa) No 45 B etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)
0.1	6	20000	0.002 (0.001−0.003)	0.02	40	6	20000	0.002 (0.001−0.003)	0.02	40
0.12	8	20000	0.002 (0.001−0.003)	0.02	40	8	20000	0.002 (0.001−0.003)	0.02	40
0.16	10	20000	0.002 (0.001−0.003)	0.02	40	10	20000	0.002 (0.001−0.003)	0.02	40
0.2	11	18000	0.003 (0.002−0.004)	0.04	54	13	20000	0.003 (0.002−0.004)	0.04	60
0.25	14	18000	0.003 (0.002−0.004)	0.04	54	16	20000	0.003 (0.002−0.004)	0.04	60
0.32	15	15000	0.004 (0.003−0.005)	0.05	60	20	20000	0.004 (0.003−0.005)	0.05	80
0.4	19	15000	0.004 (0.003−0.005)	0.05	60	25	20000	0.004 (0.003−0.005)	0.05	80
0.5	16	10000	0.006 (0.005−0.007)	0.1	60	31	20000	0.006 (0.005−0.007)	0.1	120
0.63	20	10000	0.008 (0.006−0.01)	0.1	80	40	20000	0.008 (0.006−0.01)	0.1	160
0.8	15	6000	0.015 (0.012−0.018)	0.2	90	50	20000	0.02 (0.015−0.025)	0.3	400
0.99	19	6000	0.02 (0.015−0.025)	0.2	120	62	20000	0.04 (0.03−0.05)	0.3	800

Work Material	Aluminium Alloy (Si<5%)					Heat Resistant Alloy Inconel718 etc				
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	Step (mm)	Table Feed (mm/min)
0.1	6	20000	0.002 (0.001−0.003)	0.05	40	2	7000	0.001 (0.0005−0.001)	0.02	7
0.12	8	20000	0.003 (0.002−0.004)	0.05	60	3	7000	0.001 (0.0005−0.001)	0.02	7
0.16	10	20000	0.004 (0.003−0.005)	0.05	80	4	7000	0.001 (0.0005−0.001)	0.02	7
0.2	13	20000	0.006 (0.005−0.007)	0.1	120	3	5000	0.002 (0.001−0.002)	0.04	10
0.25	16	20000	0.008 (0.006−0.01)	0.1	160	4	5000	0.002 (0.001−0.002)	0.04	10
0.32	20	20000	0.01 (0.008−0.012)	0.3	200	4	4000	0.002 (0.001−0.002)	0.05	8
0.4	25	20000	0.02 (0.015−0.025)	0.3	400	5	4000	0.002 (0.001−0.002)	0.05	8
0.5	31	20000	0.03 (0.025−0.035)	0.5	600	5	3000	0.003 (0.001−0.003)	0.1	9
0.63	40	20000	0.04 (0.035−0.045)	0.5	800	6	3000	0.004 (0.002−0.004)	0.1	12
0.8	50	20000	0.05 (0.045−0.055)	0.8	1000	5	1800	0.006 (0.004−0.006)	0.2	10.8
0.99	62	20000	0.06 (0.055−0.065)	0.8	1200	6	1800	0.01 (0.008−0.01)	0.2	18

Note 1) When drilling holes up to ϕ0.3mm, the use of a spot drill is recommended.
(Order number : MSP0300SB, Cutting conditions : Refer to page P096.)
Note 2) Change cutting conditions depending on your machine and workpiece rigidity.
Note 3) When machining holes over 5D, reduce the step stated above.
Note 4) The use of water-soluble fluid (diluted by 20 times) is recommended for drilling under the cutting conditions above.
Lower the revolutions if you use oil fluid or mist.

MWS
WSTAR DRILLS

●For high accuracy and efficient drilling of carbon steels through to difficult-to-cut materials.

TOOL NEWS

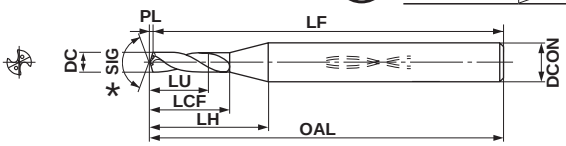
P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	

Internal Coolant

	0.5≤DC<1	1≤DC<2.95
	+0.009 0	+0.014 0
DCON=3		
h6	0 −0.006	

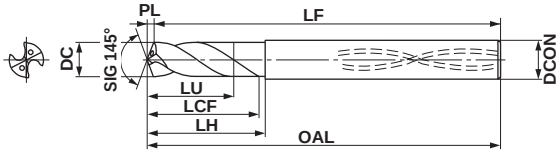
SB Type
(For pilot holes)

140° DC≤2 145° DC>2



Type1

145°

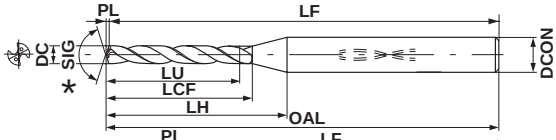


Type2

LB/XB Type (ϕ0.50−ϕ2.95)

135° DC≤2 140° DC>2

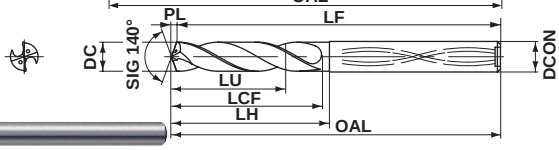
	0.5≤DC<1	1≤DC<2.95
	0 −0.009	0 −0.014
DCON=3		
h6	0 −0.006	



Type3

DB Type (ϕ0.50−ϕ2.95)

140°

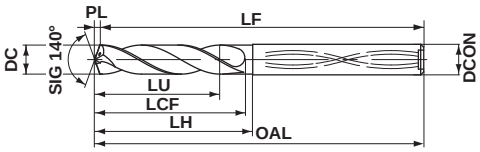


Type4

MB/LB/X8DB Type (ϕ3−ϕ25)

DC=3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤25
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033
DCON=3	3<DCON≤6	6<DCON≤10	10<DCON≤18	18<DCON≤25
0 −0.006	0 −0.008	0 −0.009	0 −0.011	0 −0.013

140°

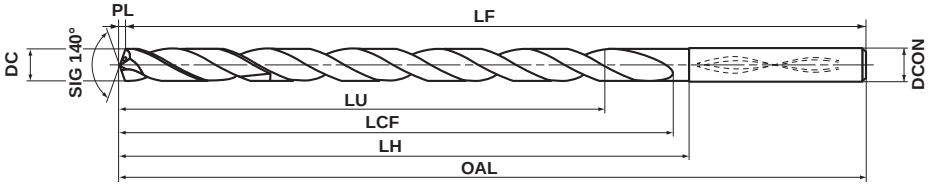


Type5

X10DB/X15DB/X20DB/X25DB/X30DB Type (ϕ3−ϕ14, L/D≥10)

DC=3	3<DC≤6	6<DC≤10	10<DC≤14
−0.017 −0.031	−0.025 −0.043	−0.033 −0.055	−0.041 −0.068
DCON=3	3<DCON≤6	6<DCON≤10	10<DCON≤14
0 −0.006	0 −0.008	0 −0.009	0 −0.011

140°



Type6

Note 1) MWS type bigger than ϕ5.0 have a recess in the end face.
Note 2) MWS drills are suitable for use with shrink fit holders.
∗ Point Anglel:Type1 140° for drill diameter ϕ 0.50-2.0 and 145° for ϕ 2.05-2.95.
Type3 135° for drill diameter ϕ 0.50-2.0 and 140° for ϕ 2.05-2.95.

★ To order non-stocked size of the DB Type (ϕ3-ϕ14, L/D>10), please provide the following.
①Drill name
②Workpiece material, drilling depth and required accuracy.
③Drilling mode (through hole, blind hole, cross hole...)
④Drill dimensions (dimensions specified in the drawing above).
Please contact us for inquiries.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
0.50	1	●	MWS0050SB	0.6	2.6	7.3	47.1	47	0.09	3	1
0.50	5	●	MWS0050LB	2.6	8.1	13.1	47.1	47	0.10	3	3
0.50	12	●	MWS0050XB	6.1	16.1	21.1	47.1	47	0.10	3	3
0.51	1	●	MWS0051SB	0.6	2.7	7.3	47.1	47	0.09	3	1
0.51	5	●	MWS0051LB	2.7	8.1	13.1	47.1	47	0.11	3	3
0.51	12	●	MWS0051XB	6.2	16.1	21.1	47.1	47	0.11	3	3
0.52	1	●	MWS0052SB	0.6	2.7	7.3	47.1	47	0.09	3	1
0.52	5	●	MWS0052LB	2.7	8.1	13.1	47.1	47	0.11	3	3
0.52	12	●	MWS0052XB	6.4	16.1	21.1	47.1	47	0.11	3	3
0.53	1	●	MWS0053SB	0.6	2.7	7.3	47.1	47	0.10	3	1
0.53	5	●	MWS0053LB	2.8	8.1	13.1	47.1	47	0.11	3	3
0.53	12	●	MWS0053XB	6.5	16.1	21.1	47.1	47	0.11	3	3
0.54	1	●	MWS0054SB	0.6	2.7	7.3	47.1	47	0.10	3	1
0.54	5	●	MWS0054LB	2.8	8.1	13.1	47.1	47	0.11	3	3
0.54	12	●	MWS0054XB	6.6	16.1	21.1	47.1	47	0.11	3	3
0.55	1	●	MWS0055SB	0.7	2.7	7.3	47.1	47	0.10	3	1
0.55	5	●	MWS0055LB	2.9	8.1	13.1	47.1	47	0.11	3	3
0.55	12	●	MWS0055XB	6.7	16.1	21.1	47.1	47	0.11	3	3
0.56	1	●	MWS0056SB	0.7	3.0	7.6	47.1	47	0.10	3	1
0.56	5	●	MWS0056LB	2.9	8.1	13.1	47.1	47	0.12	3	3
0.56	12	●	MWS0056XB	6.8	16.1	21.1	47.1	47	0.12	3	3
0.57	1	●	MWS0057SB	0.7	3.0	7.5	47.1	47	0.10	3	1
0.57	5	●	MWS0057LB	3.0	8.1	13.1	47.1	47	0.12	3	3
0.57	12	●	MWS0057XB	7.0	16.1	21.1	47.1	47	0.12	3	3
0.58	1	●	MWS0058SB	0.7	3.0	7.5	47.1	47	0.11	3	1
0.58	5	●	MWS0058LB	3.0	8.1	13.1	47.1	47	0.12	3	3
0.58	12	●	MWS0058XB	7.1	16.1	21.1	47.1	47	0.12	3	3
0.59	1	●	MWS0059SB	0.7	3.0	7.5	47.1	47	0.11	3	1
0.59	5	●	MWS0059LB	3.1	8.1	12.1	47.1	47	0.12	3	3
0.59	12	●	MWS0059XB	7.2	16.1	20.1	47.1	47	0.12	3	3
0.60	1	●	MWS0060SB	0.7	3.0	7.5	47.1	47	0.11	3	1
0.60	5	●	MWS0060LB	3.1	8.1	12.1	47.1	47	0.12	3	3
0.60	12	●	MWS0060XB	7.3	16.1	20.1	47.1	47	0.12	3	3
0.61	1	●	MWS0061SB	0.7	3.2	7.7	47.1	47	0.11	3	1
0.61	5	●	MWS0061LB	3.2	8.1	12.1	47.1	47	0.13	3	3
0.61	12	●	MWS0061XB	7.5	16.1	20.1	47.1	47	0.13	3	3
0.62	1	●	MWS0062SB	0.7	3.2	7.6	47.1	47	0.11	3	1
0.62	5	●	MWS0062LB	3.2	8.1	12.1	47.1	47	0.13	3	3
0.62	12	●	MWS0062XB	7.6	16.1	20.1	47.1	47	0.13	3	3
0.63	1	●	MWS0063SB	0.7	3.2	7.6	47.1	47	0.11	3	1
0.63	5	●	MWS0063LB	3.3	8.1	12.1	47.1	47	0.13	3	3
0.63	12	●	MWS0063XB	7.7	16.1	20.1	47.1	47	0.13	3	3
0.64	1	●	MWS0064SB	0.8	3.2	7.6	47.1	47	0.12	3	1
0.64	5	●	MWS0064LB	3.3	8.1	12.1	47.1	47	0.13	3	3
0.64	12	●	MWS0064XB	7.8	16.1	20.1	47.1	47	0.13	3	3
0.65	1	●	MWS0065SB	0.8	3.2	7.6	47.1	47	0.12	3	1
0.65	5	●	MWS0065LB	3.4	8.1	12.1	47.1	47	0.13	3	3
0.65	12	●	MWS0065XB	7.9	16.1	20.1	47.1	47	0.13	3	3

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
0.66	1	●	MWS0066SB	0.8	3.5	7.9	47.1	47	0.12	3	1
0.66	5	●	MWS0066LB	3.4	8.1	12.1	47.1	47	0.14	3	3
0.66	12	●	MWS0066XB	8.1	16.1	20.1	47.1	47	0.14	3	3
0.67	1	●	MWS0067SB	0.8	3.5	7.8	47.1	47	0.12	3	1
0.67	5	●	MWS0067LB	3.5	8.1	12.1	47.1	47	0.14	3	3
0.67	12	●	MWS0067XB	8.2	16.1	20.1	47.1	47	0.14	3	3
0.68	1	●	MWS0068SB	0.8	3.5	7.8	47.1	47	0.12	3	1
0.68	5	●	MWS0068LB	3.5	8.1	12.1	47.1	47	0.14	3	3
0.68	12	●	MWS0068XB	8.3	16.1	20.1	47.1	47	0.14	3	3
0.69	1	●	MWS0069SB	0.8	3.5	7.8	47.1	47	0.13	3	1
0.69	5	●	MWS0069LB	3.6	8.1	12.1	47.1	47	0.14	3	3
0.69	12	●	MWS0069XB	8.4	16.1	20.1	47.1	47	0.14	3	3
0.70	1	●	MWS0070SB	0.8	3.5	7.8	47.1	47	0.13	3	1
0.70	5	●	MWS0070LB	3.6	8.1	12.1	47.1	47	0.14	3	3
0.70	12	●	MWS0070XB	8.5	16.1	20.1	47.1	47	0.14	3	3
0.71	1	●	MWS0071SB	0.8	3.7	8.0	50.1	50	0.13	3	1
0.71	5	●	MWS0071LB	3.7	10.1	14.1	50.1	50	0.15	3	3
0.71	12	●	MWS0071XB	8.7	20.1	24.1	50.1	50	0.15	3	3
0.72	1	●	MWS0072SB	0.9	3.7	8.0	50.1	50	0.13	3	1
0.72	5	●	MWS0072LB	3.8	10.1	14.1	50.1	50	0.15	3	3
0.72	12	●	MWS0072XB	8.8	20.1	24.1	50.1	50	0.15	3	3
0.73	1	●	MWS0073SB	0.9	3.7	7.9	50.1	50	0.13	3	1
0.73	5	●	MWS0073LB	3.8	10.1	14.1	50.1	50	0.15	3	3
0.73	12	●	MWS0073XB	8.9	20.1	24.1	50.1	50	0.15	3	3
0.74	1	●	MWS0074SB	0.9	3.7	7.9	50.1	50	0.13	3	1
0.74	5	●	MWS0074LB	3.9	10.1	14.1	50.1	50	0.15	3	3
0.74	12	●	MWS0074XB	9.0	20.1	24.1	50.1	50	0.15	3	3
0.75	1	●	MWS0075SB	0.9	3.7	7.9	50.1	50	0.14	3	1
0.75	5	●	MWS0075LB	3.9	10.1	14.1	50.1	50	0.16	3	3
0.75	12	●	MWS0075XB	9.2	20.1	24.1	50.1	50	0.16	3	3
0.76	1	●	MWS0076SB	0.9	4.0	8.2	50.1	50	0.14	3	1
0.76	5	●	MWS0076LB	4.0	10.1	14.1	50.1	50	0.16	3	3
0.76	12	●	MWS0076XB	9.3	20.1	24.1	50.1	50	0.16	3	3
0.77	1	●	MWS0077SB	0.9	4.0	8.2	50.1	50	0.14	3	1
0.77	5	●	MWS0077LB	4.0	10.1	14.1	50.1	50	0.16	3	3
0.77	12	●	MWS0077XB	9.4	20.1	24.1	50.1	50	0.16	3	3
0.78	1	●	MWS0078SB	0.9	4.0	8.1	50.1	50	0.14	3	1
0.78	5	●	MWS0078LB	4.1	10.1	14.1	50.1	50	0.16	3	3
0.78	12	●	MWS0078XB	9.5	20.1	24.1	50.1	50	0.16	3	3
0.79	1	●	MWS0079SB	0.9	4.0	8.1	50.1	50	0.14	3	1
0.79	5	●	MWS0079LB	4.1	10.1	14.1	50.1	50	0.16	3	3
0.79	12	●	MWS0079XB	9.6	20.1	24.1	50.1	50	0.16	3	3
0.80	1	●	MWS0080SB	1.0	4.1	8.2	50.2	50	0.15	3	1
0.80	5	●	MWS0080LB	4.2	10.2	14.2	50.2	50	0.17	3	3
0.80	12	●	MWS0080XB	9.8	20.2	24.2	50.2	50	0.17	3	3
0.81	1	●	MWS0081SB	1.0	4.3	8.4	50.2	50	0.15	3	1
0.81	5	●	MWS0081LB	4.2	10.2	14.2	50.2	50	0.17	3	3
0.81	12	●	MWS0081XB	9.9	20.2	24.2	50.2	50	0.17	3	3

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
0.82	1	●	MWS0082SB	1.0	4.3	8.4	50.2	50	0.15	3	1
0.82	5	●	MWS0082LB	4.3	10.2	14.2	50.2	50	0.17	3	3
0.82	12	●	MWS0082XB	10.0	20.2	24.2	50.2	50	0.17	3	3
0.83	1	●	MWS0083SB	1.0	4.3	8.3	50.2	50	0.15	3	1
0.83	5	●	MWS0083LB	4.3	10.2	14.2	50.2	50	0.17	3	3
0.83	12	●	MWS0083XB	10.1	20.2	24.2	50.2	50	0.17	3	3
0.84	1	●	MWS0084SB	1.0	4.3	8.3	50.2	50	0.15	3	1
0.84	5	●	MWS0084LB	4.4	10.2	14.2	50.2	50	0.17	3	3
0.84	12	●	MWS0084XB	10.3	20.2	24.2	50.2	50	0.17	3	3
0.85	1	●	MWS0085SB	1.0	4.3	8.3	50.2	50	0.15	3	1
0.85	5	●	MWS0085LB	4.4	10.2	14.2	50.2	50	0.18	3	3
0.85	12	●	MWS0085XB	10.4	20.2	24.2	50.2	50	0.18	3	3
0.86	1	●	MWS0086SB	1.0	4.6	8.6	50.2	50	0.16	3	1
0.86	5	●	MWS0086LB	4.5	10.2	14.2	50.2	50	0.18	3	3
0.86	12	●	MWS0086XB	10.5	20.2	24.2	50.2	50	0.18	3	3
0.87	1	●	MWS0087SB	1.0	4.6	8.6	50.2	50	0.16	3	1
0.87	5	●	MWS0087LB	4.5	10.2	14.2	50.2	50	0.18	3	3
0.87	12	●	MWS0087XB	10.6	20.2	24.2	50.2	50	0.18	3	3
0.88	1	●	MWS0088SB	1.0	4.6	8.6	50.2	50	0.16	3	1
0.88	5	●	MWS0088LB	4.6	10.2	14.2	50.2	50	0.18	3	3
0.88	12	●	MWS0088XB	10.7	20.2	24.2	50.2	50	0.18	3	3
0.89	1	●	MWS0089SB	1.1	4.6	8.5	50.2	50	0.16	3	1
0.89	5	●	MWS0089LB	4.6	10.2	14.2	50.2	50	0.18	3	3
0.89	12	●	MWS0089XB	10.9	20.2	24.2	50.2	50	0.18	3	3
0.90	1	●	MWS0090SB	1.1	4.6	8.5	50.2	50	0.16	3	1
0.90	5	●	MWS0090LB	4.7	10.2	14.2	50.2	50	0.19	3	3
0.90	12	●	MWS0090XB	11.0	20.2	24.2	50.2	50	0.19	3	3
0.91	1	●	MWS0091SB	1.1	4.8	8.7	50.2	50	0.17	3	1
0.91	5	●	MWS0091LB	4.7	10.2	14.2	50.2	50	0.19	3	3
0.91	12	●	MWS0091XB	11.1	20.2	24.2	50.2	50	0.19	3	3
0.92	1	●	MWS0092SB	1.1	4.8	8.7	50.2	50	0.17	3	1
0.92	5	●	MWS0092LB	4.8	10.2	14.2	50.2	50	0.19	3	3
0.92	12	●	MWS0092XB	11.2	20.2	24.2	50.2	50	0.19	3	3
0.93	1	●	MWS0093SB	1.1	4.8	8.7	50.2	50	0.17	3	1
0.93	5	●	MWS0093LB	4.8	10.2	14.2	50.2	50	0.19	3	3
0.93	12	●	MWS0093XB	11.4	20.2	24.2	50.2	50	0.19	3	3
0.94	1	●	MWS0094SB	1.1	4.8	8.6	50.2	50	0.17	3	1
0.94	5	●	MWS0094LB	4.9	10.2	14.2	50.2	50	0.19	3	3
0.94	12	●	MWS0094XB	11.5	20.2	24.2	50.2	50	0.19	3	3
0.95	1	●	MWS0095SB	1.1	4.8	8.6	50.2	50	0.17	3	1
0.95	5	●	MWS0095LB	5.0	10.2	14.2	50.2	50	0.20	3	3
0.95	12	●	MWS0095XB	11.6	20.2	24.2	50.2	50	0.20	3	3
0.96	1	●	MWS0096SB	1.1	5.1	8.9	50.2	50	0.17	3	1
0.96	5	●	MWS0096LB	5.0	10.2	14.2	50.2	50	0.20	3	3
0.96	12	●	MWS0096XB	11.7	20.2	24.2	50.2	50	0.20	3	3
0.97	1	●	MWS0097SB	1.2	5.1	8.9	50.2	50	0.18	3	1
0.97	5	●	MWS0097LB	5.1	10.2	14.2	50.2	50	0.20	3	3
0.97	12	●	MWS0097XB	11.8	20.2	24.2	50.2	50	0.20	3	3

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
0.98	1	●	MWS0098SB	1.2	5.1	8.9	50.2	50	0.18	3	1
0.98	5	●	MWS0098LB	5.1	10.2	14.2	50.2	50	0.20	3	3
0.98	12	●	MWS0098XB	12.0	20.2	24.2	50.2	50	0.20	3	3
0.99	1	●	MWS0099SB	1.2	5.1	8.9	50.2	50	0.18	3	1
0.99	5	●	MWS0099LB	5.2	10.2	14.2	50.2	50	0.21	3	3
0.99	12	●	MWS0099XB	12.1	20.2	24.2	50.2	50	0.21	3	3
1.00	1	●	MWS0100SB	1.2	5.2	8.9	55.2	55	0.2	3	1
1.00	5	●	MWS0100LB	5.2	11.2	15.2	55.2	55	0.2	3	3
1.00	12	●	MWS0100XB	12.2	23.2	27.2	55.2	55	0.2	3	3
1.00	20	●	MWS0100X20DB	20.2	24.2	28.2	60.2	60	0.2	3	3
1.00	25	●	MWS0100X25DB	25.2	28.2	32.2	66.2	66	0.2	3	3
1.00	30	●	MWS0100X30DB	30.2	33.2	37.2	72.2	72	0.2	3	3
1.05	1	□	MWS0105SB	1.3	5.4	9.0	55.2	55	0.2	3	1
1.05	20	□	MWS0105X20DB	21.2	24.2	28.2	60.2	60	0.2	3	3
1.05	25	□	MWS0105X25DB	26.5	29.2	33.2	66.2	66	0.2	3	3
1.05	30	□	MWS0105X30DB	31.7	35.2	38.2	72.2	72	0.2	3	3
1.10	1	●	MWS0110SB	1.3	5.6	9.1	55.2	55	0.2	3	1
1.10	5	●	MWS0110LB	5.7	17.2	21.2	55.2	55	0.2	3	3
1.10	12	●	MWS0110XB	13.4	23.2	27.2	55.2	55	0.2	3	3
1.10	20	●	MWS0110X20DB	22.2	25.2	29.2	60.2	60	0.2	3	3
1.10	25	●	MWS0110X25DB	27.7	31.2	34.2	66.2	66	0.2	3	3
1.10	30	●	MWS0110X30DB	33.2	36.2	40.2	72.2	72	0.2	3	3
1.15	1	□	MWS0115SB	1.4	5.8	9.3	55.2	55	0.2	3	1
1.15	20	□	MWS0115X20DB	23.2	26.2	30.2	60.2	60	0.2	3	3
1.15	25	□	MWS0115X25DB	29.0	32.2	36.2	66.2	66	0.2	3	3
1.15	30	□	MWS0115X30DB	34.7	38.2	41.2	72.2	72	0.2	3	3
1.20	1	●	MWS0120SB	1.4	6.2	9.6	55.2	55	0.2	3	1
1.20	5	●	MWS0120LB	6.3	17.2	20.2	55.2	55	0.2	3	3
1.20	12	●	MWS0120XB	14.7	23.2	26.2	55.2	55	0.2	3	3
1.20	20	●	MWS0120X20DB	24.3	28.2	31.2	60.2	60	0.2	3	3
1.20	25	●	MWS0120X25DB	30.3	34.2	37.2	66.2	66	0.2	3	3
1.20	30	●	MWS0120X30DB	36.3	40.2	43.2	72.2	72	0.2	3	3
1.25	1	□	MWS0125SB	1.5	6.4	9.7	55.2	55	0.2	3	1
1.25	20	□	MWS0125X20DB	25.3	29.3	32.3	68.3	68	0.3	3	3
1.25	25	□	MWS0125X25DB	31.6	35.3	38.3	74.3	74	0.3	3	3
1.25	30	□	MWS0125X30DB	37.8	41.3	45.3	82.3	82	0.3	3	3
1.30	1	●	MWS0130SB	1.5	6.6	9.8	55.2	55	0.2	3	1
1.30	5	●	MWS0130LB	6.8	17.3	20.3	55.3	55	0.3	3	3
1.30	12	●	MWS0130XB	15.9	23.3	26.3	55.3	55	0.3	3	3
1.30	20	●	MWS0130X20DB	26.3	30.3	33.3	68.3	68	0.3	3	3
1.30	25	●	MWS0130X25DB	32.8	36.3	40.3	74.3	74	0.3	3	3
1.30	30	●	MWS0130X30DB	39.3	43.3	46.3	82.3	82	0.3	3	3
1.35	1	□	MWS0135SB	1.7	6.8	9.9	55.2	55	0.3	3	1
1.35	20	□	MWS0135X20DB	27.3	31.3	34.3	68.3	68	0.3	3	3
1.35	25	□	MWS0135X25DB	34.1	38.3	41.3	74.3	74	0.3	3	3
1.35	30	□	MWS0135X30DB	40.8	45.3	48.3	82.3	82	0.3	3	3
1.40	1	●	MWS0140SB	1.7	7.3	10.3	55.3	55	0.3	3	1
1.40	5	●	MWS0140LB	7.3	17.3	20.3	55.3	55	0.3	3	3

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.
□ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.40	12	●	MWS0140XB	17.1	23.3	26.3	55.3	55	0.3	3	3
1.40	20	●	MWS0140X20DB	28.3	32.3	35.3	68.3	68	0.3	3	3
1.40	25	●	MWS0140X25DB	35.3	39.3	42.3	74.3	74	0.3	3	3
1.40	30	●	MWS0140X30DB	42.3	46.3	49.3	82.3	82	0.3	3	3
1.45	1	□	MWS0145SB	1.8	7.5	10.4	55.3	55	0.3	3	1
1.45	20	□	MWS0145X20DB	29.3	33.3	36.3	68.3	68	0.3	3	3
1.45	25	□	MWS0145X25DB	36.6	41.3	43.3	74.3	74	0.3	3	3
1.45	30	□	MWS0145X30DB	43.8	48.3	51.3	82.3	82	0.3	3	3
1.50	1	●	MWS0150SB	1.8	7.7	10.5	55.3	55	0.3	3	1
1.50	5	●	MWS0150LB	7.8	17.3	20.3	55.3	55	0.3	3	3
1.50	12	●	MWS0150XB	18.3	23.3	26.3	55.3	55	0.3	3	3
1.50	20	●	MWS0150X20DB	30.3	35.3	37.3	68.3	68	0.3	3	3
1.50	25	●	MWS0150X25DB	37.8	42.3	45.3	74.3	74	0.3	3	3
1.50	30	●	MWS0150X30DB	45.3	50.3	52.3	82.3	82	0.3	3	3
1.55	1	□	MWS0155SB	1.9	7.9	10.6	68.3	68	0.3	3	1
1.55	20	□	MWS0155X20DB	31.3	36.3	38.3	78.3	78	0.3	3	3
1.55	25	□	MWS0155X25DB	39.1	43.3	46.3	86.3	86	0.3	3	3
1.55	30	□	MWS0155X30DB	46.8	51.3	54.3	95.3	95	0.3	3	3
1.60	1	●	MWS0160SB	1.9	8.3	10.9	68.3	68	0.3	3	1
1.60	5	●	MWS0160LB	8.3	22.3	25.3	68.3	68	0.3	3	3
1.60	12	●	MWS0160XB	19.5	30.3	33.3	68.3	68	0.3	3	3
1.60	20	●	MWS0160X20DB	32.3	37.3	39.3	78.3	78	0.3	3	3
1.60	25	●	MWS0160X25DB	40.3	45.3	47.3	86.3	86	0.3	3	3
1.60	30	●	MWS0160X30DB	48.3	53.3	55.3	95.3	95	0.3	3	3
1.65	1	□	MWS0165SB	2.0	8.5	11.0	68.3	68	0.3	3	1
1.65	20	□	MWS0165X20DB	33.3	38.3	40.3	78.3	78	0.3	3	3
1.65	25	□	MWS0165X25DB	41.6	46.3	49.3	86.3	86	0.3	3	3
1.65	30	□	MWS0165X30DB	49.8	54.3	57.3	95.3	95	0.3	3	3
1.70	1	●	MWS0170SB	2.0	8.7	11.1	68.3	68	0.3	3	1
1.70	5	●	MWS0170LB	8.9	22.4	24.4	68.4	68	0.4	3	3
1.70	12	●	MWS0170XB	20.8	30.4	32.4	68.4	68	0.4	3	3
1.70	20	●	MWS0170X20DB	34.4	39.4	42.4	78.4	78	0.4	3	3
1.70	25	●	MWS0170X25DB	42.9	48.4	50.4	86.4	86	0.4	3	3
1.70	30	●	MWS0170X30DB	51.4	56.4	59.4	95.4	95	0.4	3	3
1.75	1	□	MWS0175SB	2.1	8.9	11.2	68.3	68	0.3	3	1
1.75	20	□	MWS0175X20DB	35.4	40.4	43.4	84.4	84	0.4	3	3
1.75	25	□	MWS0175X25DB	44.2	49.4	51.4	94.4	94	0.4	3	3
1.75	30	□	MWS0175X30DB	52.9	58.4	60.4	102.4	102	0.4	3	3
1.80	1	●	MWS0180SB	2.1	9.3	11.5	68.3	68	0.3	3	1
1.80	5	●	MWS0180LB	9.4	22.4	24.4	68.4	68	0.4	3	3
1.80	12	●	MWS0180XB	22.0	30.4	32.4	68.4	68	0.4	3	3
1.80	20	●	MWS0180X20DB	36.4	41.4	44.4	84.4	84	0.4	3	3
1.80	25	●	MWS0180X25DB	45.4	50.4	53.4	94.4	94	0.4	3	3
1.80	30	●	MWS0180X30DB	54.4	59.4	62.4	102.4	102	0.4	3	3
1.85	1	□	MWS0185SB	2.2	9.5	11.6	68.3	68	0.3	3	1
1.85	20	□	MWS0185X20DB	37.4	43.4	45.4	84.4	84	0.4	3	3
1.85	25	□	MWS0185X25DB	46.7	52.4	54.4	94.4	94	0.4	3	3
1.85	30	□	MWS0185X30DB	55.9	61.4	63.4	102.4	102	0.4	3	3

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.90	1	●	MWS0190SB	2.3	9.7	11.8	68.3	68	0.3	3	1
1.90	5	●	MWS0190LB	9.9	22.4	24.4	68.4	68	0.4	3	3
1.90	12	●	MWS0190XB	23.2	30.4	32.4	68.4	68	0.4	3	3
1.90	20	●	MWS0190X20DB	38.4	44.4	46.4	84.4	84	0.4	3	3
1.90	25	●	MWS0190X25DB	47.9	53.4	55.4	94.4	94	0.4	3	3
1.90	30	●	MWS0190X30DB	57.4	63.4	65.4	102.4	102	0.4	3	3
1.95	1	□	MWS0195SB	2.4	10.0	12.0	68.4	68	0.4	3	1
1.95	20	□	MWS0195X20DB	39.4	45.4	47.4	84.4	84	0.4	3	3
1.95	25	□	MWS0195X25DB	49.2	55.4	57.4	94.4	94	0.4	3	3
1.95	30	□	MWS0195X30DB	58.9	64.4	66.4	102.4	102	0.4	3	3
2.00	1	●	MWS0200SB	2.4	10.4	12.3	68.4	68	0.4	3	1
2.00	5	●	MWS0200LB	10.4	22.4	24.4	68.4	68	0.4	3	3
2.00	12	●	MWS0200XB	24.4	30.4	32.4	68.4	68	0.4	3	3
2.00	20	●	MWS0200X20DB	40.4	46.4	48.4	84.4	84	0.4	3	3
2.00	25	●	MWS0200X25DB	50.4	56.4	58.4	94.4	94	0.4	3	3
2.00	30	●	MWS0200X30DB	60.4	66.4	68.4	102.4	102	0.4	3	3
2.05	1	□	MWS0205SB	2.4	10.5	12.3	74.3	74	0.3	3	1
2.05	20	□	MWS0205X20DB	41.4	47.4	49.4	94.4	94	0.4	3	3
2.05	25	□	MWS0205X25DB	51.7	57.4	59.4	107.4	107	0.4	3	3
2.05	30	□	MWS0205X30DB	61.9	68.4	69.4	118.4	118	0.4	3	3
2.10	1	●	MWS0210SB	2.4	10.7	12.4	74.3	74	0.3	3	1
2.10	5	●	MWS0210LB	10.9	28.4	30.4	74.4	74	0.4	3	3
2.10	12	●	MWS0210XB	25.6	38.4	40.4	74.4	74	0.4	3	3
2.10	20	●	MWS0210X20DB	42.4	48.4	50.4	94.4	94	0.4	3	3
2.10	25	●	MWS0210X25DB	52.9	59.4	60.4	107.4	107	0.4	3	3
2.10	30	●	MWS0210X30DB	63.4	69.4	71.4	118.4	118	0.4	3	3
2.15	1	□	MWS0215SB	2.5	10.9	12.5	74.3	74	0.3	3	1
2.15	20	□	MWS0215X20DB	43.4	49.4	51.4	94.4	94	0.4	3	3
2.15	25	□	MWS0215X25DB	54.2	60.4	62.4	107.4	107	0.4	3	3
2.15	30	□	MWS0215X30DB	64.9	71.4	73.4	118.4	118	0.4	3	3
2.20	1	●	MWS0220SB	2.6	11.3	12.8	74.3	74	0.3	3	1
2.20	5	●	MWS0220LB	11.4	28.4	29.4	74.4	74	0.4	3	3
2.20	12	●	MWS0220XB	26.8	38.4	39.4	74.4	74	0.4	3	3
2.20	20	●	MWS0220X20DB	44.4	51.4	52.4	94.4	94	0.4	3	3
2.20	25	●	MWS0220X25DB	55.4	62.4	63.4	107.4	107	0.4	3	3
2.20	30	●	MWS0220X30DB	66.4	73.4	74.4	118.4	118	0.4	3	3
2.25	1	□	MWS0225SB	2.7	11.6	13.0	74.4	74	0.4	3	1
2.25	20	□	MWS0225X20DB	45.4	52.4	53.4	94.4	94	0.4	3	3
2.25	25	□	MWS0225X25DB	56.7	63.4	64.4	107.4	107	0.4	3	3
2.25	30	□	MWS0225X30DB	67.9	74.4	76.4	118.4	118	0.4	3	3
2.30	1	●	MWS0230SB	2.7	11.8	13.1	74.4	74	0.4	3	1
2.30	5	●	MWS0230LB	11.9	28.4	29.4	74.4	74	0.4	3	3
2.30	12	●	MWS0230XB	28.0	38.4	39.4	74.4	74	0.4	3	3
2.30	20	●	MWS0230X20DB	46.4	53.4	54.4	94.4	94	0.4	3	3
2.30	25	●	MWS0230X25DB	57.9	64.4	66.4	107.4	107	0.4	3	3
2.30	30	●	MWS0230X30DB	69.4	76.4	77.4	118.4	118	0.4	3	3
2.35	1	□	MWS0235SB	2.8	12.0	13.2	74.4	74	0.4	3	1
2.35	20	□	MWS0235X20DB	47.4	54.4	55.4	94.4	94	0.4	3	3

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
2.35	25	□	MWS0235X25DB	59.2	66.4	67.4	107.4	107	0.4	3	3
2.35	30	□	MWS0235X30DB	70.9	78.4	79.4	118.4	118	0.4	3	3
2.40	1	●	MWS0240SB	2.8	12.4	13.5	74.4	74	0.4	3	1
2.40	5	●	MWS0240LB	12.4	28.4	29.4	74.4	74	0.4	3	3
2.40	12	●	MWS0240XB	29.2	38.4	39.4	74.4	74	0.4	3	3
2.40	20	●	MWS0240X20DB	48.4	55.4	56.4	94.4	94	0.4	3	3
2.40	25	●	MWS0240X25DB	60.4	67.4	68.4	107.4	107	0.4	3	3
2.40	30	●	MWS0240X30DB	72.4	79.4	80.4	118.4	118	0.4	3	3
2.45	1	□	MWS0245SB	2.9	12.6	13.6	74.4	74	0.4	3	1
2.45	20	□	MWS0245X20DB	49.5	56.4	57.4	94.4	94	0.4	3	3
2.45	25	□	MWS0245X25DB	61.8	69.4	70.4	107.4	107	0.4	3	3
2.45	30	□	MWS0245X30DB	74.0	81.4	82.4	118.4	118	0.4	3	3
2.50	1	●	MWS0250SB	2.9	12.8	13.7	74.4	74	0.4	3	1
2.50	5	●	MWS0250LB	13.0	28.5	29.5	74.5	74	0.5	3	3
2.50	12	●	MWS0250XB	30.5	38.5	39.5	74.5	74	0.5	3	3
2.50	20	●	MWS0250X20DB	50.5	58.5	59.5	94.5	94	0.5	3	3
2.50	25	●	MWS0250X25DB	63.0	70.5	71.5	107.5	107	0.5	3	3
2.50	30	●	MWS0250X30DB	75.5	83.5	84.5	118.5	118	0.5	3	3
2.55	1	□	MWS0255SB	3.1	13.0	13.0	81.4	81	0.4	3	2
2.55	20	□	MWS0255X20DB	51.5	59.5	59.5	103.5	103	0.5	3	4
2.55	25	□	MWS0255X25DB	64.3	71.5	71.5	117.5	117	0.5	3	4
2.55	30	□	MWS0255X30DB	77.0	84.5	84.5	132.5	132	0.5	3	4
2.60	1	●	MWS0260SB	3.1	13.4	13.4	81.4	81	0.4	3	2
2.60	5	●	MWS0260LB	13.5	33.5	33.5	81.5	81	0.5	3	4
2.60	12	●	MWS0260XB	31.7	45.5	45.5	81.5	81	0.5	3	4
2.60	20	●	MWS0260X20DB	52.5	60.5	60.5	103.5	103	0.5	3	4
2.60	25	●	MWS0260X25DB	65.5	73.5	73.5	117.5	117	0.5	3	4
2.60	30	●	MWS0260X30DB	78.5	86.5	86.5	132.5	132	0.5	3	4
2.65	1	□	MWS0265SB	3.2	13.6	13.6	81.4	81	0.4	3	2
2.65	20	□	MWS0265X20DB	53.5	61.5	61.5	103.5	103	0.5	3	4
2.65	25	□	MWS0265X25DB	66.8	74.5	74.5	117.5	117	0.5	3	4
2.65	30	□	MWS0265X30DB	80.0	87.5	87.5	132.5	132	0.5	3	4
2.70	1	●	MWS0270SB	3.2	13.8	13.8	81.4	81	0.4	3	2
2.70	5	●	MWS0270LB	14.0	33.5	33.5	81.5	81	0.5	3	4
2.70	12	●	MWS0270XB	32.9	45.5	45.5	81.5	81	0.5	3	4
2.70	20	●	MWS0270X20DB	54.5	62.5	62.5	103.5	103	0.5	3	4
2.70	25	●	MWS0270X25DB	68.0	76.5	76.5	117.5	117	0.5	3	4
2.70	30	●	MWS0270X30DB	81.5	89.5	89.5	132.5	132	0.5	3	4
2.75	1	□	MWS0275SB	3.3	14.0	14.0	81.4	81	0.4	3	2
2.75	20	□	MWS0275X20DB	55.5	63.5	63.5	103.5	103	0.5	3	4
2.75	25	□	MWS0275X25DB	69.3	77.5	77.5	117.5	117	0.5	3	4
2.75	30	□	MWS0275X30DB	83.0	91.5	91.5	132.5	132	0.5	3	4
2.80	1	●	MWS0280SB	3.3	14.4	14.4	81.4	81	0.4	3	2
2.80	5	●	MWS0280LB	14.5	33.5	33.5	81.5	81	0.5	3	4
2.80	12	●	MWS0280XB	34.1	45.5	45.5	81.5	81	0.5	3	4
2.80	20	●	MWS0280X20DB	56.5	64.5	64.5	103.5	103	0.5	3	4
2.80	25	●	MWS0280X25DB	70.5	78.5	78.5	117.5	117	0.5	3	4
2.80	30	●	MWS0280X30DB	84.5	92.5	92.5	132.5	132	0.5	3	4

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
2.85	1	□	MWS0285SB	3.4	14.6	14.6	81.4	81	0.4	3	2
2.85	20	□	MWS0285X20DB	57.5	66.5	66.5	103.5	103	0.5	3	4
2.85	25	□	MWS0285X25DB	71.8	80.5	80.5	117.5	117	0.5	3	4
2.85	30	□	MWS0285X30DB	86.0	94.5	94.5	132.5	132	0.5	3	4
2.90	1	●	MWS0290SB	3.4	14.9	14.9	81.5	81	0.5	3	2
2.90	5	●	MWS0290LB	15.0	33.5	33.5	81.5	81	0.5	3	4
2.90	12	●	MWS0290XB	35.3	45.5	45.5	81.5	81	0.5	3	4
2.90	20	●	MWS0290X20DB	58.5	67.5	67.5	103.5	103	0.5	3	4
2.90	25	●	MWS0290X25DB	73.0	81.5	81.5	117.5	117	0.5	3	4
2.90	30	●	MWS0290X30DB	87.5	96.5	96.5	132.5	132	0.5	3	4
2.95	1	□	MWS0295SB	3.5	15.1	15.1	81.5	81	0.5	3	2
2.95	20	□	MWS0295X20DB	59.5	68.5	68.5	103.5	103	0.5	3	4
2.95	25	□	MWS0295X25DB	74.3	83.5	83.5	117.5	117	0.5	3	4
2.95	30	□	MWS0295X30DB	89.0	97.5	97.5	132.5	132	0.5	3	4
3.00	3	▲	MWS0300MB	9.5	24.5	24.5	72.5	72	0.5	3	5
3.00	5	▲	MWS0300LB	15.5	33.5	33.5	81.5	81	0.5	3	5
3.00	8	▲	MWS0300X8DB	24.5	35.5	35.5	81.5	81	0.5	3	5
3.00	10	▲	MWS0300X10DB	30.5	39.5	42.5	90.5	90	0.5	3	6
3.00	15	▲	MWS0300X15DB	45.5	54.5	57.5	105.5	105	0.5	3	6
3.00	20	▲	MWS0300X20DB	60.5	69.5	72.5	120.5	120	0.5	3	6
3.00	25	▲	MWS0300X25DB	75.5	84.5	87.5	135.5	135	0.5	3	6
3.00	30	▲	MWS0300X30DB	90.5	99.5	102.5	150.5	150	0.5	3	6
3.10	3	▲	MWS0310MB	9.9	28.6	28.6	76.6	76	0.6	4	5
3.10	5	▲	MWS0310LB	16.1	39.6	39.6	87.6	87	0.6	4	5
3.10	8	▲	MWS0310X8DB	25.4	41.6	41.6	87.6	87	0.6	4	5
3.10	10	▲	MWS0310X10DB	31.6	46.6	49.6	97.6	97	0.6	4	6
3.10	15	▲	MWS0310X15DB	47.1	63.6	66.6	114.6	114	0.6	4	6
3.10	20	▲	MWS0310X20DB	62.6	81.6	84.6	132.6	132	0.6	4	6
3.10	25	▲	MWS0310X25DB	78.1	98.6	101.6	149.6	149	0.6	4	6
3.10	30	▲	MWS0310X30DB	93.6	116.6	119.6	167.6	167	0.6	4	6
3.20	3	▲	MWS0320MB	10.2	28.6	28.6	76.6	76	0.6	4	5
3.20	5	▲	MWS0320LB	16.6	39.6	39.6	87.6	87	0.6	4	5
3.20	8	▲	MWS0320X8DB	26.2	41.6	41.6	87.6	87	0.6	4	5
3.20	10	▲	MWS0320X10DB	32.6	46.6	49.6	97.6	97	0.6	4	6
3.20	15	▲	MWS0320X15DB	48.6	63.6	66.6	114.6	114	0.6	4	6
3.20	20	▲	MWS0320X20DB	64.6	81.6	84.6	132.6	132	0.6	4	6
3.20	25	▲	MWS0320X25DB	80.6	98.6	101.6	149.6	149	0.6	4	6
3.20	30	▲	MWS0320X30DB	96.6	116.6	119.6	167.6	167	0.6	4	6
3.30	3	▲	MWS0330MB	10.5	28.6	28.6	76.6	76	0.6	4	5
3.30	5	▲	MWS0330LB	17.1	39.6	39.6	87.6	87	0.6	4	5
3.30	8	▲	MWS0330X8DB	27.0	41.6	41.6	87.6	87	0.6	4	5
3.30	10	▲	MWS0330X10DB	33.6	46.6	49.6	97.6	97	0.6	4	6
3.30	15	▲	MWS0330X15DB	50.1	63.6	66.6	114.6	114	0.6	4	6
3.30	20	▲	MWS0330X20DB	66.6	81.6	84.6	132.6	132	0.6	4	6
3.30	25	▲	MWS0330X25DB	83.1	98.6	101.6	149.6	149	0.6	4	6
3.30	30	▲	MWS0330X30DB	99.6	116.6	119.6	167.6	167	0.6	4	6
3.40	3	▲	MWS0340MB	10.8	28.6	28.6	76.6	76	0.6	4	5
3.40	5	▲	MWS0340LB	17.6	39.6	39.6	87.6	87	0.6	4	5

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. ▲ : Product scheduled to be discontinued at the end of March 2020.
□ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
3.40	8	▲	MWS0340X8DB	27.8	41.6	41.6	87.6	87	0.6	4	5
3.40	10	▲	MWS0340X10DB	34.6	46.6	49.6	97.6	97	0.6	4	6
3.40	15	▲	MWS0340X15DB	51.6	63.6	66.6	114.6	114	0.6	4	6
3.40	20	▲	MWS0340X20DB	68.6	81.6	84.6	132.6	132	0.6	4	6
3.40	25	▲	MWS0340X25DB	85.6	98.6	101.6	149.6	149	0.6	4	6
3.40	30	▲	MWS0340X30DB	102.6	116.6	119.6	167.6	167	0.6	4	6
3.50	3	▲	MWS0350MB	11.1	28.6	28.6	76.6	76	0.6	4	5
3.50	5	▲	MWS0350LB	18.1	39.6	39.6	87.6	87	0.6	4	5
3.50	8	▲	MWS0350X8DB	28.6	41.6	41.6	87.6	87	0.6	4	5
3.50	10	▲	MWS0350X10DB	35.6	46.6	49.6	97.6	97	0.6	4	6
3.50	15	▲	MWS0350X15DB	53.1	63.6	66.6	114.6	114	0.6	4	6
3.50	20	▲	MWS0350X20DB	70.6	81.6	84.6	132.6	132	0.6	4	6
3.50	25	▲	MWS0350X25DB	88.1	98.6	101.6	149.6	149	0.6	4	6
3.50	30	▲	MWS0350X30DB	105.6	116.6	119.6	167.6	167	0.6	4	6
3.6	3	▲	MWS0360MB	11.5	32.7	32.7	80.7	80	0.7	4	5
3.6	5	▲	MWS0360LB	18.7	44.7	44.7	92.7	92	0.7	4	5
3.6	8	▲	MWS0360X8DB	29.5	46.7	46.7	92.7	92	0.7	4	5
3.6	10	▲	MWS0360X10DB	36.7	52.7	55.7	103.7	103	0.7	4	6
3.6	15	▲	MWS0360X15DB	54.7	72.7	75.7	123.7	123	0.7	4	6
3.6	20	▲	MWS0360X20DB	72.7	92.7	95.7	143.7	143	0.7	4	6
3.6	25	▲	MWS0360X25DB	90.7	112.7	115.7	163.7	163	0.7	4	6
3.6	30	▲	MWS0360X30DB	108.7	132.7	135.7	183.7	183	0.7	4	6
3.7	3	▲	MWS0370MB	11.8	32.7	32.7	80.7	80	0.7	4	5
3.7	5	▲	MWS0370LB	19.2	44.7	44.7	92.7	92	0.7	4	5
3.7	8	▲	MWS0370X8DB	30.3	46.7	46.7	92.7	92	0.7	4	5
3.7	10	▲	MWS0370X10DB	37.7	52.7	55.7	103.7	103	0.7	4	6
3.7	15	▲	MWS0370X15DB	56.2	72.7	75.7	123.7	123	0.7	4	6
3.7	20	▲	MWS0370X20DB	74.7	92.7	95.7	143.7	143	0.7	4	6
3.7	25	▲	MWS0370X25DB	93.2	112.7	115.7	163.7	163	0.7	4	6
3.7	30	▲	MWS0370X30DB	111.7	132.7	135.7	183.7	183	0.7	4	6
3.8	3	▲	MWS0380MB	12.1	32.7	32.7	80.7	80	0.7	4	5
3.8	5	▲	MWS0380LB	19.7	44.7	44.7	92.7	92	0.7	4	5
3.8	8	▲	MWS0380X8DB	31.1	46.7	46.7	92.7	92	0.7	4	5
3.8	10	▲	MWS0380X10DB	38.7	52.7	55.7	103.7	103	0.7	4	6
3.8	15	▲	MWS0380X15DB	57.7	72.7	75.7	123.7	123	0.7	4	6
3.8	20	▲	MWS0380X20DB	76.7	92.7	95.7	143.7	143	0.7	4	6
3.8	25	▲	MWS0380X25DB	95.7	112.7	115.7	163.7	163	0.7	4	6
3.8	30	▲	MWS0380X30DB	114.7	132.7	135.7	183.7	183	0.7	4	6
3.9	3	▲	MWS0390MB	12.4	32.7	32.7	80.7	80	0.7	4	5
3.9	5	▲	MWS0390LB	20.2	44.7	44.7	92.7	92	0.7	4	5
3.9	8	▲	MWS0390X8DB	31.9	46.7	46.7	92.7	92	0.7	4	5
3.9	10	▲	MWS0390X10DB	39.7	52.7	55.7	103.7	103	0.7	4	6
3.9	15	▲	MWS0390X15DB	59.2	72.7	75.7	123.7	123	0.7	4	6
3.9	20	▲	MWS0390X20DB	78.7	92.7	95.7	143.7	143	0.7	4	6
3.9	25	▲	MWS0390X25DB	98.2	112.7	115.7	163.7	163	0.7	4	6
3.9	30	▲	MWS0390X30DB	117.7	132.7	135.7	183.7	183	0.7	4	6
4.0	3	▲	MWS0400MB	12.7	32.7	32.7	80.7	80	0.7	4	5
4.0	5	▲	MWS0400LB	20.7	44.7	44.7	92.7	92	0.7	4	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.0	8	▲	MWS0400X8DB	32.7	46.7	46.7	92.7	92	0.7	4	5
4.0	10	▲	MWS0400X10DB	40.7	52.7	55.7	103.7	103	0.7	4	6
4.0	15	▲	MWS0400X15DB	60.7	72.7	75.7	123.7	123	0.7	4	6
4.0	20	▲	MWS0400X20DB	80.7	92.7	95.7	143.7	143	0.7	4	6
4.0	25	▲	MWS0400X25DB	100.7	112.7	115.7	163.7	163	0.7	4	6
4.0	30	▲	MWS0400X30DB	120.7	132.7	135.7	183.7	183	0.7	4	6
4.1	3	▲	MWS0410MB	13.0	36.7	36.7	86.7	86	0.7	5	5
4.1	5	▲	MWS0410LB	21.2	50.7	50.7	100.7	100	0.7	5	5
4.1	8	▲	MWS0410X8DB	33.5	52.7	52.7	100.7	100	0.7	5	5
4.1	10	▲	MWS0410X10DB	41.7	59.7	62.7	112.7	112	0.7	5	6
4.1	15	▲	MWS0410X15DB	62.2	81.7	84.7	134.7	134	0.7	5	6
4.1	20	▲	MWS0410X20DB	82.7	104.7	107.7	157.7	157	0.7	5	6
4.1	25	▲	MWS0410X25DB	103.2	126.7	129.7	179.7	179	0.7	5	6
4.1	30	▲	MWS0410X30DB	123.7	149.7	152.7	202.7	202	0.7	5	6
4.2	3	▲	MWS0420MB	13.4	36.8	36.8	86.8	86	0.8	5	5
4.2	5	▲	MWS0420LB	21.8	50.8	50.8	100.8	100	0.8	5	5
4.2	8	▲	MWS0420X8DB	34.4	52.8	52.8	100.8	100	0.8	5	5
4.2	10	▲	MWS0420X10DB	42.8	59.8	62.8	112.8	112	0.8	5	6
4.2	15	▲	MWS0420X15DB	63.8	81.8	84.8	134.8	134	0.8	5	6
4.2	20	▲	MWS0420X20DB	84.8	104.8	107.8	157.8	157	0.8	5	6
4.2	25	▲	MWS0420X25DB	105.8	126.8	129.8	179.8	179	0.8	5	6
4.2	30	▲	MWS0420X30DB	126.8	149.8	152.8	202.8	202	0.8	5	6
4.3	3	▲	MWS0430MB	13.7	36.8	36.8	86.8	86	0.8	5	5
4.3	5	▲	MWS0430LB	22.3	50.8	50.8	100.8	100	0.8	5	5
4.3	8	▲	MWS0430X8DB	35.2	52.8	52.8	100.8	100	0.8	5	5
4.3	10	▲	MWS0430X10DB	43.8	59.8	62.8	112.8	112	0.8	5	6
4.3	15	▲	MWS0430X15DB	65.3	81.8	84.8	134.8	134	0.8	5	6
4.3	20	▲	MWS0430X20DB	86.8	104.8	107.8	157.8	157	0.8	5	6
4.3	25	▲	MWS0430X25DB	108.3	126.8	129.8	179.8	179	0.8	5	6
4.3	30	▲	MWS0430X30DB	129.8	149.8	152.8	202.8	202	0.8	5	6
4.4	3	▲	MWS0440MB	14.0	36.8	36.8	86.8	86	0.8	5	5
4.4	5	▲	MWS0440LB	22.8	50.8	50.8	100.8	100	0.8	5	5
4.4	8	▲	MWS0440X8DB	36.0	52.8	52.8	100.8	100	0.8	5	5
4.4	10	▲	MWS0440X10DB	44.8	59.8	62.8	112.8	112	0.8	5	6
4.4	15	▲	MWS0440X15DB	66.8	81.8	84.8	134.8	134	0.8	5	6
4.4	20	▲	MWS0440X20DB	88.8	104.8	107.8	157.8	157	0.8	5	6
4.4	25	▲	MWS0440X25DB	110.8	126.8	129.8	179.8	179	0.8	5	6
4.4	30	▲	MWS0440X30DB	132.8	149.8	152.8	202.8	202	0.8	5	6
4.5	3	▲	MWS0450MB	14.3	36.8	36.8	86.8	86	0.8	5	5
4.5	5	▲	MWS0450LB	23.3	50.8	50.8	100.8	100	0.8	5	5
4.5	8	▲	MWS0450X8DB	36.8	52.8	52.8	100.8	100	0.8	5	5
4.5	10	▲	MWS0450X10DB	45.8	59.8	62.8	112.8	112	0.8	5	6
4.5	15	▲	MWS0450X15DB	68.3	81.8	84.8	134.8	134	0.8	5	6
4.5	20	▲	MWS0450X20DB	90.8	104.8	107.8	157.8	157	0.8	5	6
4.5	25	▲	MWS0450X25DB	113.3	126.8	129.8	179.8	179	0.8	5	6
4.5	30	▲	MWS0450X30DB	135.8	149.8	152.8	202.8	202	0.8	5	6
4.6	3	▲	MWS0460MB	14.6	40.8	40.8	90.8	90	0.8	5	5
4.6	5	▲	MWS0460LB	23.8	55.8	55.8	105.8	105	0.8	5	5

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.6	8	▲	MWS0460X8DB	37.6	57.8	57.8	105.8	105	0.8	5	5
4.6	10	▲	MWS0460X10DB	46.8	65.8	68.8	118.8	118	0.8	5	6
4.6	15	▲	MWS0460X15DB	69.8	90.8	93.8	143.8	143	0.8	5	6
4.6	20	▲	MWS0460X20DB	92.8	115.8	118.8	168.8	168	0.8	5	6
4.6	25	▲	MWS0460X25DB	115.8	140.8	143.8	193.8	193	0.8	5	6
4.6	30	▲	MWS0460X30DB	138.8	165.8	168.8	218.8	218	0.8	5	6
4.7	3	▲	MWS0470MB	15.0	40.9	40.9	90.9	90	0.9	5	5
4.7	5	▲	MWS0470LB	24.4	55.9	55.9	105.9	105	0.9	5	5
4.7	8	▲	MWS0470X8DB	38.5	57.9	57.9	105.9	105	0.9	5	5
4.7	10	▲	MWS0470X10DB	47.9	65.9	68.9	118.9	118	0.9	5	6
4.7	15	▲	MWS0470X15DB	71.4	90.9	93.9	143.9	143	0.9	5	6
4.7	20	▲	MWS0470X20DB	94.9	115.9	118.9	168.9	168	0.9	5	6
4.7	25	▲	MWS0470X25DB	118.4	140.9	143.9	193.9	193	0.9	5	6
4.7	30	▲	MWS0470X30DB	141.9	165.9	168.9	218.9	218	0.9	5	6
4.8	3	▲	MWS0480MB	15.3	40.9	40.9	90.9	90	0.9	5	5
4.8	5	▲	MWS0480LB	24.9	55.9	55.9	105.9	105	0.9	5	5
4.8	8	▲	MWS0480X8DB	39.3	57.9	57.9	105.9	105	0.9	5	5
4.8	10	▲	MWS0480X10DB	48.9	65.9	68.9	118.9	118	0.9	5	6
4.8	15	▲	MWS0480X15DB	72.9	90.9	93.9	143.9	143	0.9	5	6
4.8	20	▲	MWS0480X20DB	96.9	115.9	118.9	168.9	168	0.9	5	6
4.8	25	▲	MWS0480X25DB	120.9	140.9	143.9	193.9	193	0.9	5	6
4.8	30	▲	MWS0480X30DB	144.9	165.9	168.9	218.9	218	0.9	5	6
4.9	3	▲	MWS0490MB	15.6	40.9	40.9	90.9	90	0.9	5	5
4.9	5	▲	MWS0490LB	25.4	55.9	55.9	105.9	105	0.9	5	5
4.9	8	▲	MWS0490X8DB	40.1	57.9	57.9	105.9	105	0.9	5	5
4.9	10	▲	MWS0490X10DB	49.9	65.9	68.9	118.9	118	0.9	5	6
4.9	15	▲	MWS0490X15DB	74.4	90.9	93.9	143.9	143	0.9	5	6
4.9	20	▲	MWS0490X20DB	98.9	115.9	118.9	168.9	168	0.9	5	6
4.9	25	▲	MWS0490X25DB	123.4	140.9	143.9	193.9	193	0.9	5	6
4.9	30	▲	MWS0490X30DB	147.9	165.9	168.9	218.9	218	0.9	5	6
5.0	3	▲	MWS0500MB	15.9	28.4	30.9	82.9	82	0.9	6	5
5.0	5	▲	MWS0500LB	25.9	44.9	48.9	100.9	100	0.9	6	5
5.0	8	▲	MWS0500X8DB	40.9	57.9	57.9	105.9	105	0.9	5	5
5.0	10	▲	MWS0500X10DB	50.9	65.9	68.9	118.9	118	0.9	5	6
5.0	15	▲	MWS0500X15DB	75.9	90.9	93.9	143.9	143	0.9	5	6
5.0	20	▲	MWS0500X20DB	100.9	115.9	118.9	168.9	168	0.9	5	6
5.0	25	▲	MWS0500X25DB	125.9	140.9	143.9	193.9	193	0.9	5	6
5.0	30	▲	MWS0500X30DB	150.9	165.9	168.9	218.9	218	0.9	5	6
5.1	3	▲	MWS0510MB	16.2	28.4	30.9	82.9	82	0.9	6	5
5.1	5	▲	MWS0510LB	26.4	44.9	48.9	100.9	100	0.9	6	5
5.1	8	▲	MWS0510X8DB	41.7	61.9	66.9	118.9	118	0.9	6	5
5.1	10	▲	MWS0510X10DB	51.9	72.9	75.9	127.9	127	0.9	6	6
5.1	15	▲	MWS0510X15DB	77.4	99.9	102.9	154.9	154	0.9	6	6
5.1	20	▲	MWS0510X20DB	102.9	127.9	130.9	182.9	182	0.9	6	6
5.1	25	▲	MWS0510X25DB	128.4	154.9	157.9	209.9	209	0.9	6	6
5.1	30	▲	MWS0510X30DB	153.9	182.9	185.9	237.9	237	0.9	6	6
5.2	3	▲	MWS0520MB	16.5	28.4	30.9	82.9	82	0.9	6	5
5.2	5	▲	MWS0520LB	26.9	44.9	48.9	100.9	100	0.9	6	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
5.2	8	▲	MWS0520X8DB	42.5	61.9	66.9	118.9	118	0.9	6	5
5.2	10	▲	MWS0520X10DB	52.9	72.9	75.9	127.9	127	0.9	6	6
5.2	15	▲	MWS0520X15DB	78.9	99.9	102.9	154.9	154	0.9	6	6
5.2	20	▲	MWS0520X20DB	104.9	127.9	130.9	182.9	182	0.9	6	6
5.2	25	▲	MWS0520X25DB	130.9	154.9	157.9	209.9	209	0.9	6	6
5.2	30	▲	MWS0520X30DB	156.9	182.9	185.9	237.9	237	0.9	6	6
5.3	3	▲	MWS0530MB	16.9	28.5	31.0	83.0	82	1.0	6	5
5.3	5	▲	MWS0530LB	27.5	45.0	49.0	101.0	100	1.0	6	5
5.3	8	▲	MWS0530X8DB	43.4	62.0	67.0	119.0	118	1.0	6	5
5.3	10	▲	MWS0530X10DB	54.0	73.0	76.0	128.0	127	1.0	6	6
5.3	15	▲	MWS0530X15DB	80.5	100.0	103.0	155.0	154	1.0	6	6
5.3	20	▲	MWS0530X20DB	107.0	128.0	131.0	183.0	182	1.0	6	6
5.3	25	▲	MWS0530X25DB	133.5	155.0	158.0	210.0	209	1.0	6	6
5.3	30	▲	MWS0530X30DB	160.0	183.0	186.0	238.0	237	1.0	6	6
5.4	3	▲	MWS0540MB	17.2	28.5	31.0	83.0	82	1.0	6	5
5.4	5	▲	MWS0540LB	28.0	45.0	49.0	101.0	100	1.0	6	5
5.4	8	▲	MWS0540X8DB	44.2	62.0	67.0	119.0	118	1.0	6	5
5.4	10	▲	MWS0540X10DB	55.0	73.0	76.0	128.0	127	1.0	6	6
5.4	15	▲	MWS0540X15DB	82.0	100.0	103.0	155.0	154	1.0	6	6
5.4	20	▲	MWS0540X20DB	109.0	128.0	131.0	183.0	182	1.0	6	6
5.4	25	▲	MWS0540X25DB	136.0	155.0	158.0	210.0	209	1.0	6	6
5.4	30	▲	MWS0540X30DB	163.0	183.0	186.0	238.0	237	1.0	6	6
5.5	3	▲	MWS0550MB	17.5	28.5	31.0	83.0	82	1.0	6	5
5.5	5	▲	MWS0550LB	28.5	45.0	49.0	101.0	100	1.0	6	5
5.5	8	▲	MWS0550X8DB	45.0	62.0	67.0	119.0	118	1.0	6	5
5.5	10	▲	MWS0550X10DB	56.0	73.0	76.0	128.0	127	1.0	6	6
5.5	15	▲	MWS0550X15DB	83.5	100.0	103.0	155.0	154	1.0	6	6
5.5	20	▲	MWS0550X20DB	111.0	128.0	131.0	183.0	182	1.0	6	6
5.5	25	▲	MWS0550X25DB	138.5	155.0	158.0	210.0	209	1.0	6	6
5.5	30	▲	MWS0550X30DB	166.0	183.0	186.0	238.0	237	1.0	6	6
5.6	3	▲	MWS0560MB	17.8	31.0	31.0	83.0	82	1.0	6	5
5.6	5	▲	MWS0560LB	29.0	49.0	49.0	101.0	100	1.0	6	5
5.6	8	▲	MWS0560X8DB	45.8	67.0	67.0	119.0	118	1.0	6	5
5.6	10	▲	MWS0560X10DB	57.0	79.0	82.0	134.0	133	1.0	6	6
5.6	15	▲	MWS0560X15DB	85.0	109.0	112.0	164.0	163	1.0	6	6
5.6	20	▲	MWS0560X20DB	113.0	139.0	142.0	194.0	193	1.0	6	6
5.6	25	▲	MWS0560X25DB	141.0	169.0	172.0	224.0	223	1.0	6	6
5.6	30	▲	MWS0560X30DB	169.0	199.0	202.0	254.0	253	1.0	6	6
5.7	3	▲	MWS0570MB	18.1	31.0	31.0	83.0	82	1.0	6	5
5.7	5	▲	MWS0570LB	29.5	49.0	49.0	101.0	100	1.0	6	5
5.7	8	▲	MWS0570X8DB	46.6	67.0	67.0	119.0	118	1.0	6	5
5.7	10	▲	MWS0570X10DB	58.0	79.0	82.0	134.0	133	1.0	6	6
5.7	15	▲	MWS0570X15DB	86.5	109.0	112.0	164.0	163	1.0	6	6
5.7	20	▲	MWS0570X20DB	115.0	139.0	142.0	194.0	193	1.0	6	6
5.7	25	▲	MWS0570X25DB	143.5	169.0	172.0	224.0	223	1.0	6	6
5.7	30	▲	MWS0570X30DB	172.0	199.0	202.0	254.0	253	1.0	6	6
5.8	3	▲	MWS0580MB	18.5	31.1	31.1	83.1	82	1.1	6	5
5.8	5	▲	MWS0580LB	30.1	49.1	49.1	101.1	100	1.1	6	5

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
5.8	8	▲	MWS0580X8DB	47.5	67.1	67.1	119.1	118	1.1	6	5
5.8	10	▲	MWS0580X10DB	59.1	79.1	82.1	134.1	133	1.1	6	6
5.8	15	▲	MWS0580X15DB	88.1	109.1	112.1	164.1	163	1.1	6	6
5.8	20	▲	MWS0580X20DB	117.1	139.1	142.1	194.1	193	1.1	6	6
5.8	25	▲	MWS0580X25DB	146.1	169.1	172.1	224.1	223	1.1	6	6
5.8	30	▲	MWS0580X30DB	175.1	199.1	202.1	254.1	253	1.1	6	6
5.9	3	▲	MWS0590MB	18.8	31.1	31.1	83.1	82	1.1	6	5
5.9	5	▲	MWS0590LB	30.6	49.1	49.1	101.1	100	1.1	6	5
5.9	8	▲	MWS0590X8DB	48.3	67.1	67.1	119.1	118	1.1	6	5
5.9	10	▲	MWS0590X10DB	60.1	79.1	82.1	134.1	133	1.1	6	6
5.9	15	▲	MWS0590X15DB	89.6	109.1	112.1	164.1	163	1.1	6	6
5.9	20	▲	MWS0590X20DB	119.1	139.1	142.1	194.1	193	1.1	6	6
5.9	25	▲	MWS0590X25DB	148.6	169.1	172.1	224.1	223	1.1	6	6
5.9	30	▲	MWS0590X30DB	178.1	199.1	202.1	254.1	253	1.1	6	6
6.0	3	▲	MWS0600MB	19.1	31.1	31.1	83.1	82	1.1	6	5
6.0	5	▲	MWS0600LB	31.1	49.1	49.1	101.1	100	1.1	6	5
6.0	8	▲	MWS0600X8DB	49.1	67.1	67.1	119.1	118	1.1	6	5
6.0	10	▲	MWS0600X10DB	61.1	79.1	82.1	134.1	133	1.1	6	6
6.0	15	▲	MWS0600X15DB	91.1	109.1	112.1	164.1	163	1.1	6	6
6.0	20	▲	MWS0600X20DB	121.1	139.1	142.1	194.1	193	1.1	6	6
6.0	25	▲	MWS0600X25DB	151.1	169.1	172.1	224.1	223	1.1	6	6
6.0	30	▲	MWS0600X30DB	181.1	199.1	202.1	254.1	253	1.1	6	6
6.1	3	▲	MWS0610MB	19.4	33.6	36.1	89.1	88	1.1	7	5
6.1	5	▲	MWS0610LB	31.6	53.1	57.1	110.1	109	1.1	7	5
6.1	8	▲	MWS0610X8DB	49.9	73.1	78.1	131.1	130	1.1	7	5
6.1	10	▲	MWS0610X10DB	62.1	86.1	89.1	142.1	141	1.1	7	6
6.1	15	▲	MWS0610X15DB	92.6	118.1	121.1	174.1	173	1.1	7	6
6.1	20	▲	MWS0610X20DB	123.1	151.1	154.1	207.1	206	1.1	7	6
6.1	25	▲	MWS0610X25DB	153.6	183.1	186.1	239.1	238	1.1	7	6
6.1	30	▲	MWS0610X30DB	184.1	216.1	219.1	272.1	271	1.1	7	6
6.2	3	▲	MWS0620MB	19.7	33.6	36.1	89.1	88	1.1	7	5
6.2	5	▲	MWS0620LB	32.1	53.1	57.1	110.1	109	1.1	7	5
6.2	8	▲	MWS0620X8DB	50.7	73.1	78.1	131.1	130	1.1	7	5
6.2	10	▲	MWS0620X10DB	63.1	86.1	89.1	142.1	141	1.1	7	6
6.2	15	▲	MWS0620X15DB	94.1	118.1	121.1	174.1	173	1.1	7	6
6.2	20	▲	MWS0620X20DB	125.1	151.1	154.1	207.1	206	1.1	7	6
6.2	25	▲	MWS0620X25DB	156.1	183.1	186.1	239.1	238	1.1	7	6
6.2	30	▲	MWS0620X30DB	187.1	216.1	219.1	272.1	271	1.1	7	6
6.3	3	▲	MWS0630MB	20.0	33.6	36.1	89.1	88	1.1	7	5
6.3	5	▲	MWS0630LB	32.6	53.1	57.1	110.1	109	1.1	7	5
6.3	8	▲	MWS0630X8DB	51.5	73.1	78.1	131.1	130	1.1	7	5
6.3	10	▲	MWS0630X10DB	64.1	86.1	89.1	142.1	141	1.1	7	6
6.3	15	▲	MWS0630X15DB	95.6	118.1	121.1	174.1	173	1.1	7	6
6.3	20	▲	MWS0630X20DB	127.1	151.1	154.1	207.1	206	1.1	7	6
6.3	25	▲	MWS0630X25DB	158.6	183.1	186.1	239.1	238	1.1	7	6
6.3	30	▲	MWS0630X30DB	190.1	216.1	219.1	272.1	271	1.1	7	6
6.4	3	▲	MWS0640MB	20.4	33.7	36.2	89.2	88	1.2	7	5
6.4	5	▲	MWS0640LB	33.2	53.2	57.2	110.2	109	1.2	7	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.4	8	▲	MWS0640X8DB	52.4	73.2	78.2	131.2	130	1.2	7	5
6.4	10	▲	MWS0640X10DB	65.2	86.2	89.2	142.2	141	1.2	7	6
6.4	15	▲	MWS0640X15DB	97.2	118.2	121.2	174.2	173	1.2	7	6
6.4	20	▲	MWS0640X20DB	129.2	151.2	154.2	207.2	206	1.2	7	6
6.4	25	▲	MWS0640X25DB	161.2	183.2	186.2	239.2	238	1.2	7	6
6.4	30	▲	MWS0640X30DB	193.2	216.2	219.2	272.2	271	1.2	7	6
6.5	3	▲	MWS0650MB	20.7	33.7	36.2	89.2	88	1.2	7	5
6.5	5	▲	MWS0650LB	33.7	53.2	57.2	110.2	109	1.2	7	5
6.5	8	▲	MWS0650X8DB	53.2	73.2	78.2	131.2	130	1.2	7	5
6.5	10	▲	MWS0650X10DB	66.2	86.2	89.2	142.2	141	1.2	7	6
6.5	15	▲	MWS0650X15DB	98.7	118.2	121.2	174.2	173	1.2	7	6
6.5	20	▲	MWS0650X20DB	131.2	151.2	154.2	207.2	206	1.2	7	6
6.5	25	▲	MWS0650X25DB	163.7	183.2	186.2	239.2	238	1.2	7	6
6.5	30	▲	MWS0650X30DB	196.2	216.2	219.2	272.2	271	1.2	7	6
6.6	3	▲	MWS0660MB	21.0	36.2	36.2	89.2	88	1.2	7	5
6.6	5	▲	MWS0660LB	34.2	57.2	57.2	110.2	109	1.2	7	5
6.6	8	▲	MWS0660X8DB	54.0	78.2	78.2	131.2	130	1.2	7	5
6.6	10	▲	MWS0660X10DB	67.2	92.2	95.2	148.2	147	1.2	7	6
6.6	15	▲	MWS0660X15DB	100.2	127.2	130.2	183.2	182	1.2	7	6
6.6	20	▲	MWS0660X20DB	133.2	162.2	165.2	218.2	217	1.2	7	6
6.6	25	▲	MWS0660X25DB	166.2	197.2	200.2	253.2	252	1.2	7	6
6.6	30	▲	MWS0660X30DB	199.2	232.2	235.2	288.2	287	1.2	7	6
6.7	3	▲	MWS0670MB	21.3	36.2	36.2	89.2	88	1.2	7	5
6.7	5	▲	MWS0670LB	34.7	57.2	57.2	110.2	109	1.2	7	5
6.7	8	▲	MWS0670X8DB	54.8	78.2	78.2	131.2	130	1.2	7	5
6.7	10	▲	MWS0670X10DB	68.2	92.2	95.2	148.2	147	1.2	7	6
6.7	15	▲	MWS0670X15DB	101.7	127.2	130.2	183.2	182	1.2	7	6
6.7	20	▲	MWS0670X20DB	135.2	162.2	165.2	218.2	217	1.2	7	6
6.7	25	▲	MWS0670X25DB	168.7	197.2	200.2	253.2	252	1.2	7	6
6.7	30	▲	MWS0670X30DB	202.2	232.2	235.2	288.2	287	1.2	7	6
6.8	3	▲	MWS0680MB	21.6	36.2	36.2	89.2	88	1.2	7	5
6.8	5	▲	MWS0680LB	35.2	57.2	57.2	110.2	109	1.2	7	5
6.8	8	▲	MWS0680X8DB	55.6	78.2	78.2	131.2	130	1.2	7	5
6.8	10	▲	MWS0680X10DB	69.2	92.2	95.2	148.2	147	1.2	7	6
6.8	15	▲	MWS0680X15DB	103.2	127.2	130.2	183.2	182	1.2	7	6
6.8	20	▲	MWS0680X20DB	137.2	162.2	165.2	218.2	217	1.2	7	6
6.8	25	▲	MWS0680X25DB	171.2	197.2	200.2	253.2	252	1.2	7	6
6.8	30	▲	MWS0680X30DB	205.2	232.2	235.2	288.2	287	1.2	7	6
6.9	3	▲	MWS0690MB	22.0	36.3	36.3	89.3	88	1.3	7	5
6.9	5	▲	MWS0690LB	35.8	57.3	57.3	110.3	109	1.3	7	5
6.9	8	▲	MWS0690X8DB	56.5	78.3	78.3	131.3	130	1.3	7	5
6.9	10	▲	MWS0690X10DB	70.3	92.3	95.3	148.3	147	1.3	7	6
6.9	15	▲	MWS0690X15DB	104.8	127.3	130.3	183.3	182	1.3	7	6
6.9	20	▲	MWS0690X20DB	139.3	162.3	165.3	218.3	217	1.3	7	6
6.9	25	▲	MWS0690X25DB	173.8	197.3	200.3	253.3	252	1.3	7	6
6.9	30	▲	MWS0690X30DB	208.3	232.3	235.3	288.3	287	1.3	7	6
7.0	3	▲	MWS0700MB	22.3	36.3	36.3	89.3	88	1.3	7	5
7.0	5	▲	MWS0700LB	36.3	57.3	57.3	110.3	109	1.3	7	5

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.0	8	▲	MWS0700X8DB	57.3	78.3	78.3	131.3	130	1.3	7	5
7.0	10	▲	MWS0700X10DB	71.3	92.3	95.3	148.3	147	1.3	7	6
7.0	15	▲	MWS0700X15DB	106.3	127.3	130.3	183.3	182	1.3	7	6
7.0	20	▲	MWS0700X20DB	141.3	162.3	165.3	218.3	217	1.3	7	6
7.0	25	▲	MWS0700X25DB	176.3	197.3	200.3	253.3	252	1.3	7	6
7.0	30	▲	MWS0700X30DB	211.3	232.3	235.3	288.3	287	1.3	7	6
7.1	3	▲	MWS0710MB	22.6	38.8	41.3	95.3	94	1.3	8	5
7.1	5	▲	MWS0710LB	36.8	61.3	65.3	119.3	118	1.3	8	5
7.1	8	▲	MWS0710X8DB	58.1	84.3	89.3	143.3	142	1.3	8	5
7.1	10	▲	MWS0710X10DB	72.3	99.3	102.3	156.3	155	1.3	8	6
7.1	15	▲	MWS0710X15DB	107.8	136.3	139.3	193.3	192	1.3	8	6
7.1	20	▲	MWS0710X20DB	143.3	174.3	177.3	231.3	230	1.3	8	6
7.1	25	▲	MWS0710X25DB	178.8	211.3	214.3	268.3	267	1.3	8	6
7.1	30	▲	MWS0710X30DB	214.3	249.3	252.3	306.3	305	1.3	8	6
7.2	3	▲	MWS0720MB	22.9	38.8	41.3	95.3	94	1.3	8	5
7.2	5	▲	MWS0720LB	37.3	61.3	65.3	119.3	118	1.3	8	5
7.2	8	▲	MWS0720X8DB	58.9	84.3	89.3	143.3	142	1.3	8	5
7.2	10	▲	MWS0720X10DB	73.3	99.3	102.3	156.3	155	1.3	8	6
7.2	15	▲	MWS0720X15DB	109.3	136.3	139.3	193.3	192	1.3	8	6
7.2	20	▲	MWS0720X20DB	145.3	174.3	177.3	231.3	230	1.3	8	6
7.2	25	▲	MWS0720X25DB	181.3	211.3	214.3	268.3	267	1.3	8	6
7.2	30	▲	MWS0720X30DB	217.3	249.3	252.3	306.3	305	1.3	8	6
7.3	3	▲	MWS0730MB	23.2	38.8	41.3	95.3	94	1.3	8	5
7.3	5	▲	MWS0730LB	37.8	61.3	65.3	119.3	118	1.3	8	5
7.3	8	▲	MWS0730X8DB	59.7	84.3	89.3	143.3	142	1.3	8	5
7.3	10	▲	MWS0730X10DB	74.3	99.3	102.3	156.3	155	1.3	8	6
7.3	15	▲	MWS0730X15DB	110.8	136.3	139.3	193.3	192	1.3	8	6
7.3	20	▲	MWS0730X20DB	147.3	174.3	177.3	231.3	230	1.3	8	6
7.3	25	▲	MWS0730X25DB	183.8	211.3	214.3	268.3	267	1.3	8	6
7.3	30	▲	MWS0730X30DB	220.3	249.3	252.3	306.3	305	1.3	8	6
7.4	3	▲	MWS0740MB	23.5	38.8	41.3	95.3	94	1.3	8	5
7.4	5	▲	MWS0740LB	38.3	61.3	65.3	119.3	118	1.3	8	5
7.4	8	▲	MWS0740X8DB	60.5	84.3	89.3	143.3	142	1.3	8	5
7.4	10	▲	MWS0740X10DB	75.3	99.3	102.3	156.3	155	1.3	8	6
7.4	15	▲	MWS0740X15DB	112.3	136.3	139.3	193.3	192	1.3	8	6
7.4	20	▲	MWS0740X20DB	149.3	174.3	177.3	231.3	230	1.3	8	6
7.4	25	▲	MWS0740X25DB	186.3	211.3	214.3	268.3	267	1.3	8	6
7.4	30	▲	MWS0740X30DB	223.3	249.3	252.3	306.3	305	1.3	8	6
7.5	3	▲	MWS0750MB	23.9	38.9	41.4	95.4	94	1.4	8	5
7.5	5	▲	MWS0750LB	38.9	61.4	65.4	119.4	118	1.4	8	5
7.5	8	▲	MWS0750X8DB	61.4	84.4	89.4	143.4	142	1.4	8	5
7.5	10	▲	MWS0750X10DB	76.4	99.4	102.4	156.4	155	1.4	8	6
7.5	15	▲	MWS0750X15DB	113.9	136.4	139.4	193.4	192	1.4	8	6
7.5	20	▲	MWS0750X20DB	151.4	174.4	177.4	231.4	230	1.4	8	6
7.5	25	▲	MWS0750X25DB	188.9	211.4	214.4	268.4	267	1.4	8	6
7.5	30	▲	MWS0750X30DB	226.4	249.4	252.4	306.4	305	1.4	8	6
7.6	3	▲	MWS0760MB	24.2	41.4	41.4	95.4	94	1.4	8	5
7.6	5	▲	MWS0760LB	39.4	65.4	65.4	119.4	118	1.4	8	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
7.6	8	▲	MWS0760X8DB	62.2	89.4	89.4	143.4	142	1.4	8	5
7.6	10	▲	MWS0760X10DB	77.4	105.4	108.4	162.4	161	1.4	8	6
7.6	15	▲	MWS0760X15DB	115.4	145.4	148.4	202.4	201	1.4	8	6
7.6	20	▲	MWS0760X20DB	153.4	185.4	188.4	242.4	241	1.4	8	6
7.6	25	▲	MWS0760X25DB	191.4	225.4	228.4	282.4	281	1.4	8	6
7.6	30	▲	MWS0760X30DB	229.4	265.4	268.4	322.4	321	1.4	8	6
7.7	3	▲	MWS0770MB	24.5	41.4	41.4	95.4	94	1.4	8	5
7.7	5	▲	MWS0770LB	39.9	65.4	65.4	119.4	118	1.4	8	5
7.7	8	▲	MWS0770X8DB	63.0	89.4	89.4	143.4	142	1.4	8	5
7.7	10	▲	MWS0770X10DB	78.4	105.4	108.4	162.4	161	1.4	8	6
7.7	15	▲	MWS0770X15DB	116.9	145.4	148.4	202.4	201	1.4	8	6
7.7	20	▲	MWS0770X20DB	155.4	185.4	188.4	242.4	241	1.4	8	6
7.7	25	▲	MWS0770X25DB	193.9	225.4	228.4	282.4	281	1.4	8	6
7.7	30	▲	MWS0770X30DB	232.4	265.4	268.4	322.4	321	1.4	8	6
7.8	3	▲	MWS0780MB	24.8	41.4	41.4	95.4	94	1.4	8	5
7.8	5	▲	MWS0780LB	40.4	65.4	65.4	119.4	118	1.4	8	5
7.8	8	▲	MWS0780X8DB	63.8	89.4	89.4	143.4	142	1.4	8	5
7.8	10	▲	MWS0780X10DB	79.4	105.4	108.4	162.4	161	1.4	8	6
7.8	15	▲	MWS0780X15DB	118.4	145.4	148.4	202.4	201	1.4	8	6
7.8	20	▲	MWS0780X20DB	157.4	185.4	188.4	242.4	241	1.4	8	6
7.8	25	▲	MWS0780X25DB	196.4	225.4	228.4	282.4	281	1.4	8	6
7.8	30	▲	MWS0780X30DB	235.4	265.4	268.4	322.4	321	1.4	8	6
7.9	3	▲	MWS0790MB	25.1	41.4	41.4	95.4	94	1.4	8	5
7.9	5	▲	MWS0790LB	40.9	65.4	65.4	119.4	118	1.4	8	5
7.9	8	▲	MWS0790X8DB	64.6	89.4	89.4	143.4	142	1.4	8	5
7.9	10	▲	MWS0790X10DB	80.4	105.4	108.4	162.4	161	1.4	8	6
7.9	15	▲	MWS0790X15DB	119.9	145.4	148.4	202.4	201	1.4	8	6
7.9	20	▲	MWS0790X20DB	159.4	185.4	188.4	242.4	241	1.4	8	6
7.9	25	▲	MWS0790X25DB	198.9	225.4	228.4	282.4	281	1.4	8	6
7.9	30	▲	MWS0790X30DB	238.4	265.4	268.4	322.4	321	1.4	8	6
8.0	3	▲	MWS0800MB	25.5	41.5	41.5	95.5	94	1.5	8	5
8.0	5	▲	MWS0800LB	41.5	65.5	65.5	119.5	118	1.5	8	5
8.0	8	▲	MWS0800X8DB	65.5	89.5	89.5	143.5	142	1.5	8	5
8.0	10	▲	MWS0800X10DB	81.5	105.5	108.5	162.5	161	1.5	8	6
8.0	15	▲	MWS0800X15DB	121.5	145.5	148.5	202.5	201	1.5	8	6
8.0	20	▲	MWS0800X20DB	161.5	185.5	188.5	242.5	241	1.5	8	6
8.0	25	▲	MWS0800X25DB	201.5	225.5	228.5	282.5	281	1.5	8	6
8.0	30	▲	MWS0800X30DB	241.5	265.5	268.5	322.5	321	1.5	8	6
8.1	3	▲	MWS0810MB	25.8	44.0	46.5	101.5	100	1.5	9	5
8.1	5	▲	MWS0810LB	42.0	69.5	73.5	128.5	127	1.5	9	5
8.1	8	▲	MWS0810X8DB	66.3	95.5	100.5	155.5	154	1.5	9	5
8.1	10	▲	MWS0810X10DB	82.5	112.5	115.5	170.5	169	1.5	9	6
8.1	15	▲	MWS0810X15DB	123.0	154.5	157.5	212.5	211	1.5	9	6
8.1	20	▲	MWS0810X20DB	163.5	197.5	200.5	255.5	254	1.5	9	6
8.1	25	▲	MWS0810X25DB	204.0	239.5	242.5	297.5	296	1.5	9	6
8.1	30	▲	MWS0810X30DB	244.5	282.5	285.5	340.5	339	1.5	9	6
8.2	3	▲	MWS0820MB	26.1	44.0	46.5	101.5	100	1.5	9	5
8.2	5	▲	MWS0820LB	42.5	69.5	73.5	128.5	127	1.5	9	5

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.2	8	▲	MWS0820X8DB	67.1	95.5	100.5	155.5	154	1.5	9	5
8.2	10	▲	MWS0820X10DB	83.5	112.5	115.5	170.5	169	1.5	9	6
8.2	15	▲	MWS0820X15DB	124.5	154.5	157.5	212.5	211	1.5	9	6
8.2	20	▲	MWS0820X20DB	165.5	197.5	200.5	255.5	254	1.5	9	6
8.2	25	▲	MWS0820X25DB	206.5	239.5	242.5	297.5	296	1.5	9	6
8.2	30	▲	MWS0820X30DB	247.5	282.5	285.5	340.5	339	1.5	9	6
8.3	3	▲	MWS0830MB	26.4	44.0	46.5	101.5	100	1.5	9	5
8.3	5	▲	MWS0830LB	43.0	69.5	73.5	128.5	127	1.5	9	5
8.3	8	▲	MWS0830X8DB	67.9	95.5	100.5	155.5	154	1.5	9	5
8.3	10	▲	MWS0830X10DB	84.5	112.5	115.5	170.5	169	1.5	9	6
8.3	15	▲	MWS0830X15DB	126.0	154.5	157.5	212.5	211	1.5	9	6
8.3	20	▲	MWS0830X20DB	167.5	197.5	200.5	255.5	254	1.5	9	6
8.3	25	▲	MWS0830X25DB	209.0	239.5	242.5	297.5	296	1.5	9	6
8.3	30	▲	MWS0830X30DB	250.5	282.5	285.5	340.5	339	1.5	9	6
8.4	3	▲	MWS0840MB	26.7	44.0	46.5	101.5	100	1.5	9	5
8.4	5	▲	MWS0840LB	43.5	69.5	73.5	128.5	127	1.5	9	5
8.4	8	▲	MWS0840X8DB	68.7	95.5	100.5	155.5	154	1.5	9	5
8.4	10	▲	MWS0840X10DB	85.5	112.5	115.5	170.5	169	1.5	9	6
8.4	15	▲	MWS0840X15DB	127.5	154.5	157.5	212.5	211	1.5	9	6
8.4	20	▲	MWS0840X20DB	169.5	197.5	200.5	255.5	254	1.5	9	6
8.4	25	▲	MWS0840X25DB	211.5	239.5	242.5	297.5	296	1.5	9	6
8.4	30	▲	MWS0840X30DB	253.5	282.5	285.5	340.5	339	1.5	9	6
8.5	3	▲	MWS0850MB	27.0	44.0	46.5	101.5	100	1.5	9	5
8.5	5	▲	MWS0850LB	44.0	69.5	73.5	128.5	127	1.5	9	5
8.5	8	▲	MWS0850X8DB	69.5	95.5	100.5	155.5	154	1.5	9	5
8.5	10	▲	MWS0850X10DB	86.5	112.5	115.5	170.5	169	1.5	9	6
8.5	15	▲	MWS0850X15DB	129.0	154.5	157.5	212.5	211	1.5	9	6
8.5	20	▲	MWS0850X20DB	171.5	197.5	200.5	255.5	254	1.5	9	6
8.5	25	▲	MWS0850X25DB	214.0	239.5	242.5	297.5	296	1.5	9	6
8.5	30	▲	MWS0850X30DB	256.5	282.5	285.5	340.5	339	1.5	9	6
8.6	3	▲	MWS0860MB	27.4	46.6	46.6	101.6	100	1.6	9	5
8.6	5	▲	MWS0860LB	44.6	73.6	73.6	128.6	127	1.6	9	5
8.6	8	▲	MWS0860X8DB	70.4	100.6	100.6	155.6	154	1.6	9	5
8.6	10	▲	MWS0860X10DB	87.6	118.6	121.6	176.6	175	1.6	9	6
8.6	15	▲	MWS0860X15DB	130.6	163.6	166.6	221.6	220	1.6	9	6
8.6	20	▲	MWS0860X20DB	173.6	208.6	211.6	266.6	265	1.6	9	6
8.6	25	▲	MWS0860X25DB	216.6	253.6	256.6	311.6	310	1.6	9	6
8.6	30	▲	MWS0860X30DB	259.6	298.6	301.6	356.6	355	1.6	9	6
8.7	3	▲	MWS0870MB	27.7	46.6	46.6	101.6	100	1.6	9	5
8.7	5	▲	MWS0870LB	45.1	73.6	73.6	128.6	127	1.6	9	5
8.7	8	▲	MWS0870X8DB	71.2	100.6	100.6	155.6	154	1.6	9	5
8.7	10	▲	MWS0870X10DB	88.6	118.6	121.6	176.6	175	1.6	9	6
8.7	15	▲	MWS0870X15DB	132.1	163.6	166.6	221.6	220	1.6	9	6
8.7	20	▲	MWS0870X20DB	175.6	208.6	211.6	266.6	265	1.6	9	6
8.7	25	▲	MWS0870X25DB	219.1	253.6	256.6	311.6	310	1.6	9	6
8.7	30	▲	MWS0870X30DB	262.6	298.6	301.6	356.6	355	1.6	9	6
8.8	3	▲	MWS0880MB	28.0	46.6	46.6	101.6	100	1.6	9	5
8.8	5	▲	MWS0880LB	45.6	73.6	73.6	128.6	127	1.6	9	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.8	8	▲	MWS0880X8DB	72.0	100.6	100.6	155.6	154	1.6	9	5
8.8	10	▲	MWS0880X10DB	89.6	118.6	121.6	176.6	175	1.6	9	6
8.8	15	▲	MWS0880X15DB	133.6	163.6	166.6	221.6	220	1.6	9	6
8.8	20	▲	MWS0880X20DB	177.6	208.6	211.6	266.6	265	1.6	9	6
8.8	25	▲	MWS0880X25DB	221.6	253.6	256.6	311.6	310	1.6	9	6
8.8	30	▲	MWS0880X30DB	265.6	298.6	301.6	356.6	355	1.6	9	6
8.9	3	▲	MWS0890MB	28.3	46.6	46.6	101.6	100	1.6	9	5
8.9	5	▲	MWS0890LB	46.1	73.6	73.6	128.6	127	1.6	9	5
8.9	8	▲	MWS0890X8DB	72.8	100.6	100.6	155.6	154	1.6	9	5
8.9	10	▲	MWS0890X10DB	90.6	118.6	121.6	176.6	175	1.6	9	6
8.9	15	▲	MWS0890X15DB	135.1	163.6	166.6	221.6	220	1.6	9	6
8.9	20	▲	MWS0890X20DB	179.6	208.6	211.6	266.6	265	1.6	9	6
8.9	25	▲	MWS0890X25DB	224.1	253.6	256.6	311.6	310	1.6	9	6
8.9	30	▲	MWS0890X30DB	268.6	298.6	301.6	356.6	355	1.6	9	6
9.0	3	▲	MWS0900MB	28.6	46.6	46.6	101.6	100	1.6	9	5
9.0	5	▲	MWS0900LB	46.6	73.6	73.6	128.6	127	1.6	9	5
9.0	8	▲	MWS0900X8DB	73.6	100.6	100.6	155.6	154	1.6	9	5
9.0	10	▲	MWS0900X10DB	91.6	118.6	121.6	176.6	175	1.6	9	6
9.0	15	▲	MWS0900X15DB	136.6	163.6	166.6	221.6	220	1.6	9	6
9.0	20	▲	MWS0900X20DB	181.6	208.6	211.6	266.6	265	1.6	9	6
9.0	25	▲	MWS0900X25DB	226.6	253.6	256.6	311.6	310	1.6	9	6
9.0	30	▲	MWS0900X30DB	271.6	298.6	301.6	356.6	355	1.6	9	6
9.1	3	▲	MWS0910MB	29.0	49.2	51.7	107.7	106	1.7	10	5
9.1	5	▲	MWS0910LB	47.2	77.7	81.7	137.7	136	1.7	10	5
9.1	8	▲	MWS0910X8DB	74.5	106.7	111.7	167.7	166	1.7	10	5
9.1	10	▲	MWS0910X10DB	92.7	125.7	128.7	183.7	182	1.7	10	6
9.1	15	▲	MWS0910X15DB	138.2	172.7	175.7	230.7	229	1.7	10	6
9.1	20	▲	MWS0910X20DB	183.7	220.7	223.7	278.7	277	1.7	10	6
9.1	25	▲	MWS0910X25DB	229.2	267.7	270.7	325.7	324	1.7	10	6
9.1	30	▲	MWS0910X30DB	274.7	315.7	318.7	373.7	372	1.7	10	6
9.2	3	▲	MWS0920MB	29.3	49.2	51.7	107.7	106	1.7	10	5
9.2	5	▲	MWS0920LB	47.7	77.7	81.7	137.7	136	1.7	10	5
9.2	8	▲	MWS0920X8DB	75.3	106.7	111.7	167.7	166	1.7	10	5
9.2	10	▲	MWS0920X10DB	93.7	125.7	128.7	183.7	182	1.7	10	6
9.2	15	▲	MWS0920X15DB	139.7	172.7	175.7	230.7	229	1.7	10	6
9.2	20	▲	MWS0920X20DB	185.7	220.7	223.7	278.7	277	1.7	10	6
9.2	25	▲	MWS0920X25DB	231.7	267.7	270.7	325.7	324	1.7	10	6
9.2	30	▲	MWS0920X30DB	277.7	315.7	318.7	373.7	372	1.7	10	6
9.3	3	▲	MWS0930MB	29.6	49.2	51.7	107.7	106	1.7	10	5
9.3	5	▲	MWS0930LB	48.2	77.7	81.7	137.7	136	1.7	10	5
9.3	8	▲	MWS0930X8DB	76.1	106.7	111.7	167.7	166	1.7	10	5
9.3	10	▲	MWS0930X10DB	94.7	125.7	128.7	183.7	182	1.7	10	6
9.3	15	▲	MWS0930X15DB	141.2	172.7	175.7	230.7	229	1.7	10	6
9.3	20	▲	MWS0930X20DB	187.7	220.7	223.7	278.7	277	1.7	10	6
9.3	25	▲	MWS0930X25DB	234.2	267.7	270.7	325.7	324	1.7	10	6
9.3	30	▲	MWS0930X30DB	280.7	315.7	318.7	373.7	372	1.7	10	6
9.4	3	▲	MWS0940MB	29.9	49.2	51.7	107.7	106	1.7	10	5
9.4	5	▲	MWS0940LB	48.7	77.7	81.7	137.7	136	1.7	10	5

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
9.4	8	▲	MWS0940X8DB	76.9	106.7	111.7	167.7	166	1.7	10	5
9.4	10	▲	MWS0940X10DB	95.7	125.7	128.7	183.7	182	1.7	10	6
9.4	15	▲	MWS0940X15DB	142.7	172.7	175.7	230.7	229	1.7	10	6
9.4	20	▲	MWS0940X20DB	189.7	220.7	223.7	278.7	277	1.7	10	6
9.4	25	▲	MWS0940X25DB	236.7	267.7	270.7	325.7	324	1.7	10	6
9.4	30	▲	MWS0940X30DB	283.7	315.7	318.7	373.7	372	1.7	10	6
9.5	3	▲	MWS0950MB	30.2	49.2	51.7	107.7	106	1.7	10	5
9.5	5	▲	MWS0950LB	49.2	77.7	81.7	137.7	136	1.7	10	5
9.5	8	▲	MWS0950X8DB	77.7	106.7	111.7	167.7	166	1.7	10	5
9.5	10	▲	MWS0950X10DB	96.7	125.7	128.7	183.7	182	1.7	10	6
9.5	15	▲	MWS0950X15DB	144.2	172.7	175.7	230.7	229	1.7	10	6
9.5	20	▲	MWS0950X20DB	191.7	220.7	223.7	278.7	277	1.7	10	6
9.5	25	▲	MWS0950X25DB	239.2	267.7	270.7	325.7	324	1.7	10	6
9.5	30	▲	MWS0950X30DB	286.7	315.7	318.7	373.7	372	1.7	10	6
9.6	3	▲	MWS0960MB	30.5	51.7	51.7	107.7	106	1.7	10	5
9.6	5	▲	MWS0960LB	49.7	81.7	81.7	137.7	136	1.7	10	5
9.6	8	▲	MWS0960X8DB	78.5	111.7	111.7	167.7	166	1.7	10	5
9.6	10	▲	MWS0960X10DB	97.7	131.7	134.7	189.7	188	1.7	10	6
9.6	15	▲	MWS0960X15DB	145.7	181.7	184.7	239.7	238	1.7	10	6
9.6	20	▲	MWS0960X20DB	193.7	231.7	234.7	289.7	288	1.7	10	6
9.6	25	▲	MWS0960X25DB	241.7	281.7	284.7	339.7	338	1.7	10	6
9.6	30	▲	MWS0960X30DB	289.7	331.7	334.7	389.7	388	1.7	10	6
9.7	3	▲	MWS0970MB	30.9	51.8	51.8	107.8	106	1.8	10	5
9.7	5	▲	MWS0970LB	50.3	81.8	81.8	137.8	136	1.8	10	5
9.7	8	▲	MWS0970X8DB	79.4	111.8	111.8	167.8	166	1.8	10	5
9.7	10	▲	MWS0970X10DB	98.8	131.8	134.8	189.8	188	1.8	10	6
9.7	15	▲	MWS0970X15DB	147.3	181.8	184.8	239.8	238	1.8	10	6
9.7	20	▲	MWS0970X20DB	195.8	231.8	234.8	289.8	288	1.8	10	6
9.7	25	▲	MWS0970X25DB	244.3	281.8	284.8	339.8	338	1.8	10	6
9.7	30	▲	MWS0970X30DB	292.8	331.8	334.8	389.8	388	1.8	10	6
9.8	3	▲	MWS0980MB	31.2	51.8	51.8	107.8	106	1.8	10	5
9.8	5	▲	MWS0980LB	50.8	81.8	81.8	137.8	136	1.8	10	5
9.8	8	▲	MWS0980X8DB	80.2	111.8	111.8	167.8	166	1.8	10	5
9.8	10	▲	MWS0980X10DB	99.8	131.8	134.8	189.8	188	1.8	10	6
9.8	15	▲	MWS0980X15DB	148.8	181.8	184.8	239.8	238	1.8	10	6
9.8	20	▲	MWS0980X20DB	197.8	231.8	234.8	289.8	288	1.8	10	6
9.8	25	▲	MWS0980X25DB	246.8	281.8	284.8	339.8	338	1.8	10	6
9.8	30	▲	MWS0980X30DB	295.8	331.8	334.8	389.8	388	1.8	10	6
9.9	3	▲	MWS0990MB	31.5	51.8	51.8	107.8	106	1.8	10	5
9.9	5	▲	MWS0990LB	51.3	81.8	81.8	137.8	136	1.8	10	5
9.9	8	▲	MWS0990X8DB	81.0	111.8	111.8	167.8	166	1.8	10	5
9.9	10	▲	MWS0990X10DB	100.8	131.8	134.8	189.8	188	1.8	10	6
9.9	15	▲	MWS0990X15DB	150.3	181.8	184.8	239.8	238	1.8	10	6
9.9	20	▲	MWS0990X20DB	199.8	231.8	234.8	289.8	288	1.8	10	6
9.9	25	▲	MWS0990X25DB	249.3	281.8	284.8	339.8	338	1.8	10	6
9.9	30	▲	MWS0990X30DB	298.8	331.8	334.8	389.8	388	1.8	10	6
10.0	3	▲	MWS1000MB	31.8	51.8	51.8	107.8	106	1.8	10	5
10.0	5	▲	MWS1000LB	51.8	81.8	81.8	137.8	136	1.8	10	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.0	8	▲	MWS1000X8DB	81.8	111.8	111.8	167.8	166	1.8	10	5
10.0	10	▲	MWS1000X10DB	101.8	131.8	134.8	189.8	188	1.8	10	6
10.0	15	▲	MWS1000X15DB	151.8	181.8	184.8	239.8	238	1.8	10	6
10.0	20	▲	MWS1000X20DB	201.8	231.8	234.8	289.8	288	1.8	10	6
10.0	25	▲	MWS1000X25DB	251.8	281.8	284.8	339.8	338	1.8	10	6
10.0	30	▲	MWS1000X30DB	301.8	331.8	334.8	389.8	388	1.8	10	6
10.1	3	▲	MWS1010MB	32.1	54.3	56.8	117.8	116	1.8	11	5
10.1	5	▲	MWS1010LB	52.3	85.8	89.8	150.8	149	1.8	11	5
10.1	8	▲	MWS1010X8DB	82.6	117.8	122.8	183.8	182	1.8	11	5
10.1	10	▲	MWS1010X10DB	102.8	138.8	141.8	202.8	201	1.8	11	6
10.1	15	▲	MWS1010X15DB	153.3	190.8	193.8	254.8	253	1.8	11	6
10.1	20	▲	MWS1010X20DB	203.8	243.8	246.8	307.8	306	1.8	11	6
10.1	25	▲	MWS1010X25DB	254.3	295.8	298.8	359.8	358	1.8	11	6
10.2	3	▲	MWS1020MB	32.5	54.4	56.9	117.9	116	1.9	11	5
10.2	5	▲	MWS1020LB	52.9	85.9	89.9	150.9	149	1.9	11	5
10.2	8	▲	MWS1020X8DB	83.5	117.9	122.9	183.9	182	1.9	11	5
10.2	10	▲	MWS1020X10DB	103.9	138.9	141.9	202.9	201	1.9	11	6
10.2	15	▲	MWS1020X15DB	154.9	190.9	193.9	254.9	253	1.9	11	6
10.2	20	▲	MWS1020X20DB	205.9	243.9	246.9	307.9	306	1.9	11	6
10.2	25	▲	MWS1020X25DB	256.9	295.9	298.9	359.9	358	1.9	11	6
10.3	3	▲	MWS1030MB	32.8	54.4	56.9	117.9	116	1.9	11	5
10.3	5	▲	MWS1030LB	53.4	85.9	89.9	150.9	149	1.9	11	5
10.3	8	▲	MWS1030X8DB	84.3	117.9	122.9	183.9	182	1.9	11	5
10.3	10	▲	MWS1030X10DB	104.9	138.9	141.9	202.9	201	1.9	11	6
10.3	15	▲	MWS1030X15DB	156.4	190.9	193.9	254.9	253	1.9	11	6
10.3	20	▲	MWS1030X20DB	207.9	243.9	246.9	307.9	306	1.9	11	6
10.3	25	▲	MWS1030X25DB	259.4	295.9	298.9	359.9	358	1.9	11	6
10.4	3	▲	MWS1040MB	33.1	54.4	56.9	117.9	116	1.9	11	5
10.4	5	▲	MWS1040LB	53.9	85.9	89.9	150.9	149	1.9	11	5
10.4	8	▲	MWS1040X8DB	85.1	117.9	122.9	183.9	182	1.9	11	5
10.4	10	▲	MWS1040X10DB	105.9	138.9	141.9	202.9	201	1.9	11	6
10.4	15	▲	MWS1040X15DB	157.9	190.9	193.9	254.9	253	1.9	11	6
10.4	20	▲	MWS1040X20DB	209.9	243.9	246.9	307.9	306	1.9	11	6
10.4	25	▲	MWS1040X25DB	261.9	295.9	298.9	359.9	358	1.9	11	6
10.5	3	▲	MWS1050MB	33.4	54.4	56.9	117.9	116	1.9	11	5
10.5	5	▲	MWS1050LB	54.4	85.9	89.9	150.9	149	1.9	11	5
10.5	8	▲	MWS1050X8DB	85.9	117.9	122.9	183.9	182	1.9	11	5
10.5	10	▲	MWS1050X10DB	106.9	138.9	141.9	202.9	201	1.9	11	6
10.5	15	▲	MWS1050X15DB	159.4	190.9	193.9	254.9	253	1.9	11	6
10.5	20	▲	MWS1050X20DB	211.9	243.9	246.9	307.9	306	1.9	11	6
10.5	25	▲	MWS1050X25DB	264.4	295.9	298.9	359.9	358	1.9	11	6
10.6	3	▲	MWS1060MB	33.7	56.9	56.9	117.9	116	1.9	11	5
10.6	5	▲	MWS1060LB	54.9	89.9	89.9	150.9	149	1.9	11	5
10.6	8	▲	MWS1060X8DB	86.7	122.9	122.9	183.9	182	1.9	11	5
10.6	10	▲	MWS1060X10DB	107.9	144.9	147.9	208.9	207	1.9	11	6
10.6	15	▲	MWS1060X15DB	160.9	199.9	202.9	263.9	262	1.9	11	6
10.6	20	▲	MWS1060X20DB	213.9	254.9	257.9	318.9	317	1.9	11	6
10.6	25	▲	MWS1060X25DB	266.9	309.9	312.9	373.9	372	1.9	11	6

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
10.7	3	▲	MWS1070MB	34.0	56.9	56.9	117.9	116	1.9	11	5
10.7	5	▲	MWS1070LB	55.4	89.9	89.9	150.9	149	1.9	11	5
10.7	8	▲	MWS1070X8DB	87.5	122.9	122.9	183.9	182	1.9	11	5
10.7	10	▲	MWS1070X10DB	108.9	144.9	147.9	208.9	207	1.9	11	6
10.7	15	▲	MWS1070X15DB	162.4	199.9	202.9	263.9	262	1.9	11	6
10.7	20	▲	MWS1070X20DB	215.9	254.9	257.9	318.9	317	1.9	11	6
10.7	25	▲	MWS1070X25DB	269.4	309.9	312.9	373.9	372	1.9	11	6
10.8	3	▲	MWS1080MB	34.4	57.0	57.0	118.0	116	2.0	11	5
10.8	5	▲	MWS1080LB	56.0	90.0	90.0	151.0	149	2.0	11	5
10.8	8	▲	MWS1080X8DB	88.4	123.0	123.0	184.0	182	2.0	11	5
10.8	10	▲	MWS1080X10DB	110.0	145.0	148.0	209.0	207	2.0	11	6
10.8	15	▲	MWS1080X15DB	164.0	200.0	203.0	264.0	262	2.0	11	6
10.8	20	▲	MWS1080X20DB	218.0	255.0	258.0	319.0	317	2.0	11	6
10.8	25	▲	MWS1080X25DB	272.0	310.0	313.0	374.0	372	2.0	11	6
10.9	3	▲	MWS1090MB	34.7	57.0	57.0	118.0	116	2.0	11	5
10.9	5	▲	MWS1090LB	56.5	90.0	90.0	151.0	149	2.0	11	5
10.9	8	▲	MWS1090X8DB	89.2	123.0	123.0	184.0	182	2.0	11	5
10.9	10	▲	MWS1090X10DB	111.0	145.0	148.0	209.0	207	2.0	11	6
10.9	15	▲	MWS1090X15DB	165.5	200.0	203.0	264.0	262	2.0	11	6
10.9	20	▲	MWS1090X20DB	220.0	255.0	258.0	319.0	317	2.0	11	6
10.9	25	▲	MWS1090X25DB	274.5	310.0	313.0	374.0	372	2.0	11	6
11.0	3	▲	MWS1100MB	35.0	57.0	57.0	118.0	116	2.0	11	5
11.0	5	▲	MWS1100LB	57.0	90.0	90.0	151.0	149	2.0	11	5
11.0	8	▲	MWS1100X8DB	90.0	123.0	123.0	184.0	182	2.0	11	5
11.0	10	▲	MWS1100X10DB	112.0	145.0	148.0	209.0	207	2.0	11	6
11.0	15	▲	MWS1100X15DB	167.0	200.0	203.0	264.0	262	2.0	11	6
11.0	20	▲	MWS1100X20DB	222.0	255.0	258.0	319.0	317	2.0	11	6
11.0	25	▲	MWS1100X25DB	277.0	310.0	313.0	374.0	372	2.0	11	6
11.1	3	▲	MWS1110MB	35.3	59.5	62.0	124.0	122	2.0	12	5
11.1	5	▲	MWS1110LB	57.5	94.0	98.0	160.0	158	2.0	12	5
11.1	8	▲	MWS1110X8DB	90.8	129.0	134.0	196.0	194	2.0	12	5
11.1	10	▲	MWS1110X10DB	113.0	152.0	155.0	217.0	215	2.0	12	6
11.1	15	▲	MWS1110X15DB	168.5	209.0	212.0	274.0	272	2.0	12	6
11.1	20	▲	MWS1110X20DB	224.0	267.0	270.0	332.0	330	2.0	12	6
11.1	25	▲	MWS1110X25DB	279.5	324.0	327.0	389.0	387	2.0	12	6
11.2	3	▲	MWS1120MB	35.6	59.5	62.0	124.0	122	2.0	12	5
11.2	5	▲	MWS1120LB	58.0	94.0	98.0	160.0	158	2.0	12	5
11.2	8	▲	MWS1120X8DB	91.6	129.0	134.0	196.0	194	2.0	12	5
11.2	10	▲	MWS1120X10DB	114.0	152.0	155.0	217.0	215	2.0	12	6
11.2	15	▲	MWS1120X15DB	170.0	209.0	212.0	274.0	272	2.0	12	6
11.2	20	▲	MWS1120X20DB	226.0	267.0	270.0	332.0	330	2.0	12	6
11.2	25	▲	MWS1120X25DB	282.0	324.0	327.0	389.0	387	2.0	12	6
11.3	3	▲	MWS1130MB	36.0	59.6	62.1	124.1	122	2.1	12	5
11.3	5	▲	MWS1130LB	58.6	94.1	98.1	160.1	158	2.1	12	5
11.3	8	▲	MWS1130X8DB	92.5	129.1	134.1	196.1	194	2.1	12	5
11.3	10	▲	MWS1130X10DB	115.1	152.1	155.1	217.1	215	2.1	12	6
11.3	15	▲	MWS1130X15DB	171.6	209.1	212.1	274.1	272	2.1	12	6
11.3	20	▲	MWS1130X20DB	228.1	267.1	270.1	332.1	330	2.1	12	6

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.3	25	▲	MWS1130X25DB	284.6	324.1	327.1	389.1	387	2.1	12	6
11.4	3	▲	MWS1140MB	36.3	59.6	62.1	124.1	122	2.1	12	5
11.4	5	▲	MWS1140LB	59.1	94.1	98.1	160.1	158	2.1	12	5
11.4	8	▲	MWS1140X8DB	93.3	129.1	134.1	196.1	194	2.1	12	5
11.4	10	▲	MWS1140X10DB	116.1	152.1	155.1	217.1	215	2.1	12	6
11.4	15	▲	MWS1140X15DB	173.1	209.1	212.1	274.1	272	2.1	12	6
11.4	20	▲	MWS1140X20DB	230.1	267.1	270.1	332.1	330	2.1	12	6
11.4	25	▲	MWS1140X25DB	287.1	324.1	327.1	389.1	387	2.1	12	6
11.5	3	▲	MWS1150MB	36.6	59.6	62.1	124.1	122	2.1	12	5
11.5	5	▲	MWS1150LB	59.6	94.1	98.1	160.1	158	2.1	12	5
11.5	8	▲	MWS1150X8DB	94.1	129.1	134.1	196.1	194	2.1	12	5
11.5	10	▲	MWS1150X10DB	117.1	152.1	155.1	217.1	215	2.1	12	6
11.5	15	▲	MWS1150X15DB	174.6	209.1	212.1	274.1	272	2.1	12	6
11.5	20	▲	MWS1150X20DB	232.1	267.1	270.1	332.1	330	2.1	12	6
11.5	25	▲	MWS1150X25DB	289.6	324.1	327.1	389.1	387	2.1	12	6
11.6	3	▲	MWS1160MB	36.9	62.1	62.1	124.1	122	2.1	12	5
11.6	5	▲	MWS1160LB	60.1	98.1	98.1	160.1	158	2.1	12	5
11.6	8	▲	MWS1160X8DB	94.9	134.1	134.1	196.1	194	2.1	12	5
11.6	10	▲	MWS1160X10DB	118.1	158.1	161.1	223.1	221	2.1	12	6
11.6	15	▲	MWS1160X15DB	176.1	218.1	221.1	283.1	281	2.1	12	6
11.6	20	▲	MWS1160X20DB	234.1	278.1	281.1	343.1	341	2.1	12	6
11.6	25	▲	MWS1160X25DB	292.1	338.1	341.1	403.1	401	2.1	12	6
11.7	3	▲	MWS1170MB	37.2	62.1	62.1	124.1	122	2.1	12	5
11.7	5	▲	MWS1170LB	60.6	98.1	98.1	160.1	158	2.1	12	5
11.7	8	▲	MWS1170X8DB	95.7	134.1	134.1	196.1	194	2.1	12	5
11.7	10	▲	MWS1170X10DB	119.1	158.1	161.1	223.1	221	2.1	12	6
11.7	15	▲	MWS1170X15DB	177.6	218.1	221.1	283.1	281	2.1	12	6
11.7	20	▲	MWS1170X20DB	236.1	278.1	281.1	343.1	341	2.1	12	6
11.7	25	▲	MWS1170X25DB	294.6	338.1	341.1	403.1	401	2.1	12	6
11.8	3	▲	MWS1180MB	37.5	62.1	62.1	124.1	122	2.1	12	5
11.8	5	▲	MWS1180LB	61.1	98.1	98.1	160.1	158	2.1	12	5
11.8	8	▲	MWS1180X8DB	96.5	134.1	134.1	196.1	194	2.1	12	5
11.8	10	▲	MWS1180X10DB	120.1	158.1	161.1	223.1	221	2.1	12	6
11.8	15	▲	MWS1180X15DB	179.1	218.1	221.1	283.1	281	2.1	12	6
11.8	20	▲	MWS1180X20DB	238.1	278.1	281.1	343.1	341	2.1	12	6
11.8	25	▲	MWS1180X25DB	297.1	338.1	341.1	403.1	401	2.1	12	6
11.9	3	▲	MWS1190MB	37.9	62.2	62.2	124.2	122	2.2	12	5
11.9	5	▲	MWS1190LB	61.7	98.2	98.2	160.2	158	2.2	12	5
11.9	8	▲	MWS1190X8DB	97.4	134.2	134.2	196.2	194	2.2	12	5
11.9	10	▲	MWS1190X10DB	121.2	158.2	161.2	223.2	221	2.2	12	6
11.9	15	▲	MWS1190X15DB	180.7	218.2	221.2	283.2	281	2.2	12	6
11.9	20	▲	MWS1190X20DB	240.2	278.2	281.2	343.2	341	2.2	12	6
11.9	25	▲	MWS1190X25DB	299.7	338.2	341.2	403.2	401	2.2	12	6
12.0	3	▲	MWS1200MB	38.2	62.2	62.2	124.2	122	2.2	12	5
12.0	5	▲	MWS1200LB	62.2	98.2	98.2	160.2	158	2.2	12	5
12.0	8	▲	MWS1200X8DB	98.2	134.2	134.2	196.2	194	2.2	12	5
12.0	10	▲	MWS1200X10DB	122.2	158.2	161.2	223.2	221	2.2	12	6
12.0	15	▲	MWS1200X15DB	182.2	218.2	221.2	283.2	281	2.2	12	6

CUTTING CONDITIONS ➤ P115
OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.0	20	▲	MWS1200X20DB	242.2	278.2	281.2	343.2	341	2.2	12	6
12.0	25	▲	MWS1200X25DB	302.2	338.2	341.2	403.2	401	2.2	12	6
12.1	3	▲	MWS1210MB	38.5	64.7	67.2	130.2	128	2.2	13	5
12.1	5	▲	MWS1210LB	62.7	102.2	106.2	169.2	167	2.2	13	5
12.1	8	□	MWS1210X8DB	99.0	140.2	145.2	208.2	206	2.2	13	5
12.1	10	□	MWS1210X10DB	123.2	165.2	168.2	231.2	229	2.2	13	6
12.1	15	□	MWS1210X15DB	183.7	227.2	230.2	293.2	291	2.2	13	6
12.1	20	□	MWS1210X20DB	244.2	290.2	293.2	356.2	354	2.2	13	6
12.2	3	▲	MWS1220MB	38.8	64.7	67.2	130.2	128	2.2	13	5
12.2	5	▲	MWS1220LB	63.2	102.2	106.2	169.2	167	2.2	13	5
12.2	8	□	MWS1220X8DB	99.8	140.2	145.2	208.2	206	2.2	13	5
12.2	10	□	MWS1220X10DB	124.2	165.2	168.2	231.2	229	2.2	13	6
12.2	15	□	MWS1220X15DB	185.2	227.2	230.2	293.2	291	2.2	13	6
12.2	20	□	MWS1220X20DB	246.2	290.2	293.2	356.2	354	2.2	13	6
12.3	3	▲	MWS1230MB	39.1	64.7	67.2	130.2	128	2.2	13	5
12.3	5	▲	MWS1230LB	63.7	102.2	106.2	169.2	167	2.2	13	5
12.3	8	□	MWS1230X8DB	100.6	140.2	145.2	208.2	206	2.2	13	5
12.3	10	□	MWS1230X10DB	125.2	165.2	168.2	231.2	229	2.2	13	6
12.3	15	□	MWS1230X15DB	186.7	227.2	230.2	293.2	291	2.2	13	6
12.3	20	□	MWS1230X20DB	248.2	290.2	293.2	356.2	354	2.2	13	6
12.4	3	▲	MWS1240MB	39.5	64.8	67.3	130.3	128	2.3	13	5
12.4	5	▲	MWS1240LB	64.3	102.3	106.3	169.3	167	2.3	13	5
12.4	8	□	MWS1240X8DB	101.5	140.3	145.3	208.3	206	2.3	13	5
12.4	10	□	MWS1240X10DB	126.3	165.3	168.3	231.3	229	2.3	13	6
12.4	15	□	MWS1240X15DB	188.3	227.3	230.3	293.3	291	2.3	13	6
12.4	20	□	MWS1240X20DB	250.3	290.3	293.3	356.3	354	2.3	13	6
12.5	3	▲	MWS1250MB	39.8	64.8	67.3	130.3	128	2.3	13	5
12.5	5	▲	MWS1250LB	64.8	102.3	106.3	169.3	167	2.3	13	5
12.5	8	▲	MWS1250X8DB	102.3	140.3	145.3	208.3	206	2.3	13	5
12.5	10	▲	MWS1250X10DB	127.3	165.3	168.3	231.3	229	2.3	13	6
12.5	15	▲	MWS1250X15DB	189.8	227.3	230.3	293.3	291	2.3	13	6
12.5	20	▲	MWS1250X20DB	252.3	290.3	293.3	356.3	354	2.3	13	6
12.6	3	▲	MWS1260MB	40.1	67.3	67.3	130.3	128	2.3	13	5
12.6	5	▲	MWS1260LB	65.3	106.3	106.3	169.3	167	2.3	13	5
12.6	8	□	MWS1260X8DB	103.1	145.3	145.3	208.3	206	2.3	13	5
12.6	10	□	MWS1260X10DB	128.3	171.3	174.3	237.3	235	2.3	13	6
12.6	15	□	MWS1260X15DB	191.3	236.3	239.3	302.3	300	2.3	13	6
12.6	20	□	MWS1260X20DB	254.3	301.3	304.3	367.3	365	2.3	13	6
12.7	3	▲	MWS1270MB	40.4	67.3	67.3	130.3	128	2.3	13	5
12.7	5	▲	MWS1270LB	65.8	106.3	106.3	169.3	167	2.3	13	5
12.7	8	□	MWS1270X8DB	103.9	145.3	145.3	208.3	206	2.3	13	5
12.7	10	□	MWS1270X10DB	129.3	171.3	174.3	237.3	235	2.3	13	6
12.7	15	□	MWS1270X15DB	192.8	236.3	239.3	302.3	300	2.3	13	6
12.7	20	□	MWS1270X20DB	256.3	301.3	304.3	367.3	365	2.3	13	6
12.8	3	▲	MWS1280MB	40.7	67.3	67.3	130.3	128	2.3	13	5
12.8	5	▲	MWS1280LB	66.3	106.3	106.3	169.3	167	2.3	13	5
12.8	8	□	MWS1280X8DB	104.7	145.3	145.3	208.3	206	2.3	13	5
12.8	10	□	MWS1280X10DB	130.3	171.3	174.3	237.3	235	2.3	13	6

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
12.8	15	□	MWS1280X15DB	194.3	236.3	239.3	302.3	300	2.3	13	6
12.8	20	□	MWS1280X20DB	258.3	301.3	304.3	367.3	365	2.3	13	6
12.9	3	▲	MWS1290MB	41.0	67.3	67.3	130.3	128	2.3	13	5
12.9	5	▲	MWS1290LB	66.8	106.3	106.3	169.3	167	2.3	13	5
12.9	8	□	MWS1290X8DB	105.5	145.3	145.3	208.3	206	2.3	13	5
12.9	10	□	MWS1290X10DB	131.3	171.3	174.3	237.3	235	2.3	13	6
12.9	15	□	MWS1290X15DB	195.8	236.3	239.3	302.3	300	2.3	13	6
12.9	20	□	MWS1290X20DB	260.3	301.3	304.3	367.3	365	2.3	13	6
13.0	3	▲	MWS1300MB	41.4	67.4	67.4	130.4	128	2.4	13	5
13.0	5	▲	MWS1300LB	67.4	106.4	106.4	169.4	167	2.4	13	5
13.0	8	▲	MWS1300X8DB	106.4	145.4	145.4	208.4	206	2.4	13	5
13.0	10	▲	MWS1300X10DB	132.4	171.4	174.4	237.4	235	2.4	13	6
13.0	15	▲	MWS1300X15DB	197.4	236.4	239.4	302.4	300	2.4	13	6
13.0	20	▲	MWS1300X20DB	262.4	301.4	304.4	367.4	365	2.4	13	6
13.1	3	▲	MWS1310MB	41.7	89.9	72.4	136.4	134	2.4	14	5
13.1	5	▲	MWS1310LB	67.9	110.4	114.4	178.4	176	2.4	14	5
13.1	8	□	MWS1310X8DB	107.2	151.4	156.4	220.4	218	2.4	14	5
13.1	10	□	MWS1310X10DB	133.4	178.4	181.4	245.4	243	2.4	14	6
13.1	15	□	MWS1310X15DB	198.9	245.4	248.4	312.4	310	2.4	14	6
13.1	20	□	MWS1310X20DB	264.4	313.4	316.4	380.4	378	2.4	14	6
13.2	3	▲	MWS1320MB	42.0	69.9	72.4	136.4	134	2.4	14	5
13.2	5	▲	MWS1320LB	68.4	110.4	114.4	178.4	176	2.4	14	5
13.2	8	□	MWS1320X8DB	108.0	151.4	156.4	220.4	218	2.4	14	5
13.2	10	□	MWS1320X10DB	134.4	178.4	181.4	245.4	243	2.4	14	6
13.2	15	□	MWS1320X15DB	200.4	245.4	248.4	312.4	310	2.4	14	6
13.2	20	□	MWS1320X20DB	266.4	313.4	316.4	380.4	378	2.4	14	6
13.3	3	▲	MWS1330MB	42.3	69.9	72.4	136.4	134	2.4	14	5
13.3	5	▲	MWS1330LB	68.9	110.4	114.4	178.4	176	2.4	14	5
13.3	8	□	MWS1330X8DB	108.8	151.4	156.4	220.4	218	2.4	14	5
13.3	10	□	MWS1330X10DB	135.4	178.4	181.4	245.4	243	2.4	14	6
13.3	15	□	MWS1330X15DB	201.9	245.4	248.4	312.4	310	2.4	14	6
13.3	20	□	MWS1330X20DB	268.4	313.4	316.4	380.4	378	2.4	14	6
13.4	3	▲	MWS1340MB	42.6	69.9	72.4	136.4	134	2.4	14	5
13.4	5	▲	MWS1340LB	69.4	110.4	114.4	178.4	176	2.4	14	5
13.4	8	□	MWS1340X8DB	109.6	151.4	156.4	220.4	218	2.4	14	5
13.4	10	□	MWS1340X10DB	136.4	178.4	181.4	245.4	243	2.4	14	6
13.4	15	□	MWS1340X15DB	203.4	245.4	248.4	312.4	310	2.4	14	6
13.4	20	□	MWS1340X20DB	270.4	313.4	316.4	380.4	378	2.4	14	6
13.5	3	▲	MWS1350MB	43.0	70.0	72.5	136.5	134	2.5	14	5
13.5	5	▲	MWS1350LB	70.0	110.5	114.5	178.5	176	2.5	14	5
13.5	8	▲	MWS1350X8DB	110.5	151.5	156.5	220.5	218	2.5	14	5
13.5	10	▲	MWS1350X10DB	137.5	178.5	181.5	245.5	243	2.5	14	6
13.5	15	▲	MWS1350X15DB	205.0	245.5	248.5	312.5	310	2.5	14	6
13.5	20	▲	MWS1350X20DB	272.5	313.5	316.5	380.5	378	2.5	14	6
13.6	3	▲	MWS1360MB	43.3	72.5	72.5	136.5	134	2.5	14	5
13.6	5	▲	MWS1360LB	70.5	114.5	114.5	178.5	176	2.5	14	5
13.6	8	□	MWS1360X8DB	111.3	156.5	156.5	220.5	218	2.5	14	5
13.6	10	□	MWS1360X10DB	138.5	184.5	187.5	251.5	249	2.5	14	6

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

□ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
13.6	15	□	MWS1360X15DB	206.5	254.5	257.5	321.5	319	2.5	14	6
13.6	20	□	MWS1360X20DB	274.5	324.5	327.5	391.5	389	2.5	14	6
13.7	3	▲	MWS1370MB	43.6	72.5	72.5	136.5	134	2.5	14	5
13.7	5	▲	MWS1370LB	71.0	114.5	114.5	178.5	176	2.5	14	5
13.7	8	□	MWS1370X8DB	112.1	156.5	156.5	220.5	218	2.5	14	5
13.7	10	□	MWS1370X10DB	139.5	184.5	187.5	251.5	249	2.5	14	6
13.7	15	□	MWS1370X15DB	208.0	254.5	257.5	321.5	319	2.5	14	6
13.7	20	□	MWS1370X20DB	276.5	324.5	327.5	391.5	389	2.5	14	6
13.8	3	▲	MWS1380MB	43.9	72.5	72.5	136.5	134	2.5	14	5
13.8	5	▲	MWS1380LB	71.5	114.5	114.5	178.5	176	2.5	14	5
13.8	8	□	MWS1380X8DB	112.9	156.5	156.5	220.5	218	2.5	14	5
13.8	10	□	MWS1380X10DB	140.5	184.5	187.5	251.5	249	2.5	14	6
13.8	15	□	MWS1380X15DB	209.5	254.5	257.5	321.5	319	2.5	14	6
13.8	20	□	MWS1380X20DB	278.5	324.5	327.5	391.5	389	2.5	14	6
13.9	3	▲	MWS1390MB	44.2	72.5	72.5	136.5	134	2.5	14	5
13.9	5	▲	MWS1390LB	72.0	114.5	114.5	178.5	176	2.5	14	5
13.9	8	□	MWS1390X8DB	113.7	156.5	156.5	220.5	218	2.5	14	5
13.9	10	□	MWS1390X10DB	141.5	184.5	187.5	251.5	249	2.5	14	6
13.9	15	□	MWS1390X15DB	211.0	254.5	257.5	321.5	319	2.5	14	6
13.9	20	□	MWS1390X20DB	280.5	324.5	327.5	391.5	389	2.5	14	6
14.0	3	▲	MWS1400MB	44.5	72.5	72.5	136.5	134	2.5	14	5
14.0	5	▲	MWS1400LB	72.5	114.5	114.5	178.5	176	2.5	14	5
14.0	8	▲	MWS1400X8DB	114.5	156.5	156.5	220.5	218	2.5	14	5
14.0	10	▲	MWS1400X10DB	142.5	184.5	187.5	251.5	249	2.5	14	6
14.0	15	▲	MWS1400X15DB	212.5	254.5	257.5	321.5	319	2.5	14	6
14.0	20	▲	MWS1400X20DB	282.5	324.5	327.5	391.5	389	2.5	14	6
14.1	3	▲	MWS1410MB	44.9	75.1	77.6	142.6	140	2.6	15	5
14.1	5	▲	MWS1410LB	73.1	118.6	122.6	187.6	185	2.6	15	5
14.1	8	□	MWS1410X8DB	115.4	162.6	167.6	227.6	225	2.6	15	5
14.2	3	▲	MWS1420MB	45.2	75.1	77.6	142.6	140	2.6	15	5
14.2	5	▲	MWS1420LB	73.6	118.6	122.6	187.6	185	2.6	15	5
14.2	8	▲	MWS1420X8DB	116.2	162.6	167.6	227.6	225	2.6	15	5
14.3	3	▲	MWS1430MB	45.5	75.1	77.6	142.6	140	2.6	15	5
14.3	5	▲	MWS1430LB	74.1	118.6	122.6	187.6	185	2.6	15	5
14.3	8	□	MWS1430X8DB	117.0	162.6	167.6	227.6	225	2.6	15	5
14.4	3	▲	MWS1440MB	45.8	75.1	77.6	142.6	140	2.6	15	5
14.4	5	▲	MWS1440LB	74.6	118.6	122.6	187.6	185	2.6	15	5
14.4	8	□	MWS1440X8DB	117.8	162.6	167.6	227.6	225	2.6	15	5
14.5	3	▲	MWS1450MB	46.1	75.1	77.6	142.6	140	2.6	15	5
14.5	5	▲	MWS1450LB	75.1	118.6	122.6	187.6	185	2.6	15	5
14.5	8	▲	MWS1450X8DB	118.6	162.6	167.6	227.6	225	2.6	15	5
14.6	3	▲	MWS1460MB	46.5	77.7	77.7	142.7	140	2.7	15	5
14.6	5	▲	MWS1460LB	75.7	122.7	122.7	187.7	185	2.7	15	5
14.6	8	□	MWS1460X8DB	119.5	167.7	167.7	227.7	225	2.7	15	5
14.7	3	▲	MWS1470MB	46.8	77.7	77.7	142.7	140	2.7	15	5
14.7	5	▲	MWS1470LB	76.2	122.7	122.7	187.7	185	2.7	15	5
14.7	8	□	MWS1470X8DB	120.3	167.7	167.7	227.7	225	2.7	15	5
14.8	3	▲	MWS1480MB	47.1	77.7	77.7	142.7	140	2.7	15	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
14.8	5	▲	MWS1480LB	76.7	122.7	122.7	187.7	185	2.7	15	5
14.8	8	□	MWS1480X8DB	121.1	167.7	167.7	227.7	225	2.7	15	5
14.9	3	▲	MWS1490MB	47.4	77.7	77.7	142.7	140	2.7	15	5
14.9	5	▲	MWS1490LB	77.2	122.7	122.7	187.7	185	2.7	15	5
14.9	8	□	MWS1490X8DB	121.9	167.7	167.7	227.7	225	2.7	15	5
15.0	3	▲	MWS1500MB	47.7	77.7	77.7	142.7	140	2.7	15	5
15.0	5	▲	MWS1500LB	77.7	122.7	122.7	187.7	185	2.7	15	5
15.0	8	▲	MWS1500X8DB	122.7	167.7	167.7	227.7	225	2.7	15	5
15.1	3	▲	MWS1510MB	48.0	80.2	82.7	147.7	145	2.7	16	5
15.1	5	▲	MWS1510LB	78.2	126.7	130.7	195.7	193	2.7	16	5
15.1	8	□	MWS1510X8DB	123.5	173.7	183.7	243.7	241	2.7	16	5
15.2	3	▲	MWS1520MB	48.4	80.3	82.8	147.8	145	2.8	16	5
15.2	5	▲	MWS1520LB	78.8	126.8	130.8	195.8	193	2.8	16	5
15.2	8	□	MWS1520X8DB	124.4	173.8	183.8	243.8	241	2.8	16	5
15.3	3	▲	MWS1530MB	48.7	80.3	82.8	147.8	145	2.8	16	5
15.3	5	▲	MWS1530LB	79.3	126.8	130.8	195.8	193	2.8	16	5
15.3	8	□	MWS1530X8DB	125.2	173.8	183.8	243.8	241	2.8	16	5
15.4	3	▲	MWS1540MB	49.0	80.3	82.8	147.8	145	2.8	16	5
15.4	5	▲	MWS1540LB	79.8	126.8	130.8	195.8	193	2.8	16	5
15.4	8	□	MWS1540X8DB	126.0	173.8	183.8	243.8	241	2.8	16	5
15.5	3	▲	MWS1550MB	49.3	80.3	82.8	147.8	145	2.8	16	5
15.5	5	▲	MWS1550LB	80.3	126.8	130.8	195.8	193	2.8	16	5
15.5	8	▲	MWS1550X8DB	126.8	173.8	183.8	243.8	241	2.8	16	5
15.6	3	▲	MWS1560MB	49.6	82.8	82.8	147.8	145	2.8	16	5
15.6	5	▲	MWS1560LB	80.8	130.8	130.8	195.8	193	2.8	16	5
15.6	8	□	MWS1560X8DB	127.6	178.8	183.8	243.8	241	2.8	16	5
15.7	3	▲	MWS1570MB	50.0	82.9	82.9	147.9	145	2.9	16	5
15.7	5	▲	MWS1570LB	81.4	130.9	130.9	195.9	193	2.9	16	5
15.7	8	□	MWS1570X8DB	128.5	178.9	183.9	243.9	241	2.9	16	5
15.8	3	▲	MWS1580MB	50.3	82.9	82.9	147.9	145	2.9	16	5
15.8	5	▲	MWS1580LB	81.9	130.9	130.9	195.9	193	2.9	16	5
15.8	8	□	MWS1580X8DB	129.3	178.9	183.9	243.9	241	2.9	16	5
15.9	3	▲	MWS1590MB	50.6	82.9	82.9	147.9	145	2.9	16	5
15.9	5	▲	MWS1590LB	82.4	130.9	130.9	195.9	193	2.9	16	5
15.9	8	□	MWS1590X8DB	130.1	178.9	183.9	243.9	241	2.9	16	5
16.0	3	▲	MWS1600MB	50.9	82.9	82.9	147.9	145	2.9	16	5
16.0	5	▲	MWS1600LB	82.9	130.9	130.9	195.9	193	2.9	16	5
16.0	8	▲	MWS1600X8DB	130.9	178.9	183.9	243.9	241	2.9	16	5
16.1	3	□	MWS1610MB	51.2	85.4	87.9	152.9	150	2.9	17	5
16.1	5	□	MWS1610LB	83.4	134.9	138.9	203.9	201	2.9	17	5
16.2	3	□	MWS1620MB	51.5	85.4	87.9	152.9	150	2.9	17	5
16.2	5	□	MWS1620LB	83.9	134.9	138.9	203.9	201	2.9	17	5
16.3	3	□	MWS1630MB	51.9	85.5	88.0	153.0	150	3.0	17	5
16.3	5	□	MWS1630LB	84.5	135.0	139.0	204.0	201	3.0	17	5
16.4	3	□	MWS1640MB	52.2	85.5	88.0	153.0	150	3.0	17	5
16.4	5	□	MWS1640LB	85.0	135.0	139.0	204.0	201	3.0	17	5
16.5	3	▲	MWS1650MB	52.5	85.5	88.0	153.0	150	3.0	17	5
16.5	5	▲	MWS1650LB	85.5	135.0	139.0	204.0	201	3.0	17	5

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TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
16.6	3	□	MWS1660MB	52.8	88.0	88.0	153.0	150	3.0	17	5
16.6	5	□	MWS1660LB	86.0	139.0	139.0	204.0	201	3.0	17	5
16.7	3	□	MWS1670MB	53.1	88.0	88.0	153.0	150	3.0	17	5
16.7	5	□	MWS1670LB	86.5	139.0	139.0	204.0	201	3.0	17	5
16.8	3	□	MWS1680MB	53.5	88.1	88.1	153.1	150	3.1	17	5
16.8	5	□	MWS1680LB	87.1	139.1	139.1	204.1	201	3.1	17	5
16.9	3	□	MWS1690MB	53.8	88.1	88.1	153.1	150	3.1	17	5
16.9	5	□	MWS1690LB	87.6	139.1	139.1	204.1	201	3.1	17	5
17.0	3	▲	MWS1700MB	54.1	88.1	88.1	153.1	150	3.1	17	5
17.0	5	▲	MWS1700LB	88.1	139.1	139.1	204.1	201	3.1	17	5
17.1	3	□	MWS1710MB	54.4	90.6	93.1	158.1	155	3.1	18	5
17.1	5	□	MWS1710LB	88.6	143.1	147.1	212.1	209	3.1	18	5
17.2	3	□	MWS1720MB	54.7	90.6	93.1	158.1	155	3.1	18	5
17.2	5	□	MWS1720LB	89.1	143.1	147.1	212.1	209	3.1	18	5
17.3	3	□	MWS1730MB	55.0	90.6	93.1	158.1	155	3.1	18	5
17.3	5	□	MWS1730LB	89.6	143.1	147.1	212.1	209	3.1	18	5
17.4	3	□	MWS1740MB	55.4	90.7	93.2	158.2	155	3.2	18	5
17.4	5	□	MWS1740LB	90.2	143.2	147.2	212.2	209	3.2	18	5
17.5	3	▲	MWS1750MB	55.7	90.7	93.2	158.2	155	3.2	18	5
17.5	5	▲	MWS1750LB	90.7	143.2	147.2	212.2	209	3.2	18	5
17.6	3	□	MWS1760MB	56.0	93.2	93.2	158.2	155	3.2	18	5
17.6	5	□	MWS1760LB	91.2	147.2	147.2	212.2	209	3.2	18	5
17.7	3	□	MWS1770MB	56.3	93.2	93.2	158.2	155	3.2	18	5
17.7	5	□	MWS1770LB	91.7	147.2	147.2	212.2	209	3.2	18	5
17.8	3	□	MWS1780MB	56.6	93.2	93.2	158.2	155	3.2	18	5
17.8	5	□	MWS1780LB	92.2	147.2	147.2	212.2	209	3.2	18	5
17.9	3	□	MWS1790MB	57.0	93.3	93.3	158.3	155	3.3	18	5
17.9	5	□	MWS1790LB	92.8	147.3	147.3	212.3	209	3.3	18	5
18.0	3	▲	MWS1800MB	57.3	93.3	93.3	158.3	155	3.3	18	5
18.0	5	▲	MWS1800LB	93.3	147.3	147.3	212.3	209	3.3	18	5
18.1	3	□	MWS1810MB	57.6	95.8	98.3	163.3	160	3.3	19	5
18.1	5	□	MWS1810LB	93.8	151.3	155.3	220.3	217	3.3	19	5
18.2	3	□	MWS1820MB	57.9	95.8	98.3	163.3	160	3.3	19	5
18.2	5	□	MWS1820LB	94.3	151.3	155.3	220.3	217	3.3	19	5
18.3	3	□	MWS1830MB	58.2	95.8	98.3	163.3	160	3.3	19	5
18.3	5	□	MWS1830LB	94.8	151.3	155.3	220.3	217	3.3	19	5
18.4	3	□	MWS1840MB	58.5	95.8	98.3	163.3	160	3.3	19	5
18.4	5	□	MWS1840LB	95.3	151.3	155.3	220.3	217	3.3	19	5
18.5	3	▲	MWS1850MB	58.9	95.9	98.4	163.4	160	3.4	19	5
18.5	5	▲	MWS1850LB	95.9	151.4	155.4	220.4	217	3.4	19	5
18.6	3	□	MWS1860MB	59.2	98.4	98.4	163.4	160	3.4	19	5
18.6	5	□	MWS1860LB	96.4	155.4	155.4	220.4	217	3.4	19	5
18.7	3	□	MWS1870MB	59.5	98.4	98.4	163.4	160	3.4	19	5
18.7	5	□	MWS1870LB	96.9	155.4	155.4	220.4	217	3.4	19	5
18.8	3	□	MWS1880MB	59.8	98.4	98.4	163.4	160	3.4	19	5
18.8	5	□	MWS1880LB	97.4	155.4	155.4	220.4	217	3.4	19	5
18.9	3	□	MWS1890MB	60.1	98.4	98.4	163.4	160	3.4	19	5
18.9	5	□	MWS1890LB	97.9	155.4	155.4	220.4	217	3.4	19	5

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
19.0	3	▲	MWS1900MB	60.5	98.5	98.5	163.5	160	3.5	19	5
19.0	5	▲	MWS1900LB	98.5	155.5	155.5	220.5	217	3.5	19	5
19.1	3	□	MWS1910MB	60.8	101.0	103.5	168.5	165	3.5	20	5
19.1	5	□	MWS1910LB	99.0	159.5	163.5	228.5	225	3.5	20	5
19.2	3	□	MWS1920MB	61.1	101.0	103.5	168.5	165	3.5	20	5
19.2	5	□	MWS1920LB	99.5	159.5	163.5	228.5	225	3.5	20	5
19.3	3	□	MWS1930MB	61.4	101.0	103.5	168.5	165	3.5	20	5
19.3	5	□	MWS1930LB	100.0	159.5	163.5	228.5	225	3.5	20	5
19.4	3	□	MWS1940MB	61.7	101.0	103.5	168.5	165	3.5	20	5
19.4	5	□	MWS1940LB	100.5	159.5	163.5	228.5	225	3.5	20	5
19.5	3	▲	MWS1950MB	62.0	101.0	103.5	168.5	165	3.5	20	5
19.5	5	▲	MWS1950LB	101.0	159.5	163.5	228.5	225	3.5	20	5
19.6	3	□	MWS1960MB	62.4	103.6	103.6	168.6	165	3.6	20	5
19.6	5	□	MWS1960LB	101.6	163.6	163.6	228.6	225	3.6	20	5
19.7	3	□	MWS1970MB	62.7	103.6	103.6	168.6	165	3.6	20	5
19.7	5	□	MWS1970LB	102.1	163.6	163.6	228.6	225	3.6	20	5
19.8	3	□	MWS1980MB	63.0	103.6	103.6	168.6	165	3.6	20	5
19.8	5	□	MWS1980LB	102.6	163.6	163.6	228.6	225	3.6	20	5
19.9	3	□	MWS1990MB	63.3	103.6	103.6	168.6	165	3.6	20	5
19.9	5	□	MWS1990LB	103.1	163.6	163.6	228.6	225	3.6	20	5
20.0	3	▲	MWS2000MB	63.6	103.6	103.6	168.6	165	3.6	20	5
20.0	5	▲	MWS2000LB	103.6	163.6	163.6	228.6	225	3.6	20	5
20.5	3	▲	MWS2050MB	65.2	106.7	108.7	179.7	176	3.7	21	5
20.5	5	▲	MWS2050LB	106.2	169.7	171.7	242.7	239	3.7	21	5
21.0	3	▲	MWS2100MB	66.8	108.8	108.8	179.8	176	3.8	21	5
21.0	5	▲	MWS2100LB	108.8	171.8	171.8	242.8	239	3.8	21	5
21.5	3	▲	MWS2150MB	68.4	111.9	113.9	185.9	182	3.9	22	5
21.5	5	▲	MWS2150LB	111.4	177.9	179.9	251.9	248	3.9	22	5
22.0	3	▲	MWS2200MB	70.0	114.0	114.0	186.0	182	4.0	22	5
22.0	5	▲	MWS2200LB	114.0	180.0	180.0	252.0	248	4.0	22	5
22.5	3	▲	MWS2250MB	71.6	117.1	119.1	192.1	188	4.1	23	5
22.5	5	▲	MWS2250LB	116.6	186.1	188.1	261.1	257	4.1	23	5
23.0	3	▲	MWS2300MB	73.2	119.2	119.2	192.2	188	4.2	23	5
23.0	5	▲	MWS2300LB	119.2	188.2	188.2	261.2	257	4.2	23	5
23.5	3	▲	MWS2350MB	74.8	122.3	124.3	198.3	194	4.3	24	5
23.5	5	▲	MWS2350LB	121.8	194.3	196.3	270.3	266	4.3	24	5
24.0	3	▲	MWS2400MB	76.4	124.4	124.4	198.4	194	4.4	24	5
24.0	5	▲	MWS2400LB	124.4	196.4	196.4	270.4	266	4.4	24	5
24.5	3	▲	MWS2450MB	78.0	127.5	129.5	204.5	200	4.5	25	5
24.5	5	▲	MWS2450LB	127.0	202.5	204.5	274.5	270	4.5	25	5
25.0	3	▲	MWS2500MB	79.5	129.5	129.5	204.5	200	4.5	25	5
25.0	5	▲	MWS2500LB	129.5	204.5	204.5	274.5	270	4.5	25	5

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

▲ : Product scheduled to be discontinued at the end of March 2020.

□ : Non stock, produced to order only.

RECOMMENDED CUTTING CONDITIONS

■ SB/MB/LB/XB/DB Type Drill(L/D<10)

Work Material	Mild Steel (≤180HB) AISI 1010 etc					Carbon Steel•Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)
0.5	40	25400	0.01	(0.005−0.015)	250	40	25400	0.01	(0.005−0.015)	250
0.63	40	20200	0.014	(0.008−0.020)	280	40	20200	0.014	(0.008−0.020)	280
0.8	45	17900	0.028	(0.016−0.040)	500	45	17900	0.028	(0.016−0.040)	500
1.0	50	15900	0.035	(0.020−0.050)	555	50	15900	0.035	(0.020−0.050)	555
1.2	50	13200	0.045	(0.030−0.060)	590	50	13200	0.045	(0.030−0.060)	590
1.6	50	9900	0.055	(0.035−0.080)	540	50	9900	0.055	(0.035−0.080)	540
2.0	50	7900	0.07	(0.040−0.100)	550	50	7900	0.07	(0.040−0.100)	550
2.5	60	7600	0.085	(0.050−0.125)	645	60	7600	0.085	(0.050−0.125)	645
3.2	90	8900	0.1	(0.06−0.13)	890	80	7900	0.1	(0.06−0.13)	790
4.0	100	7900	0.12	(0.08−0.16)	945	90	7100	0.12	(0.08−0.16)	850
5.0	100	6300	0.15	(0.10−0.20)	945	90	5700	0.15	(0.10−0.20)	855
6.3	110	5500	0.2	(0.13−0.26)	1100	100	5000	0.2	(0.13−0.26)	1000
8.0	120	4700	0.23	(0.18−0.28)	1080	110	4300	0.23	(0.18−0.28)	985
10.0	130	4100	0.27	(0.22−0.32)	1105	120	3800	0.27	(0.22−0.32)	1025
12.0	140	3700	0.3	(0.26−0.34)	1110	130	3400	0.3	(0.26−0.34)	1020
16.0	160	3100	0.33	(0.27−0.38)	1020	140	2700	0.33	(0.27−0.38)	890
20.0	160	2500	0.35	(0.30−0.40)	875	140	2200	0.35	(0.30−0.40)	770
25.0	160	2000	0.35	(0.30−0.40)	700	140	1700	0.35	(0.30−0.40)	595

Work Material	Carbon Steel•Alloy Steel (280−350HB) AISI 4340 etc					Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Table Feed (mm/min)
0.5	30	19000	0.01	(0.005−0.015)	190	20	12700	0.008	(0.005−0.010)	100
0.63	30	15100	0.014	(0.008−0.020)	210	20	10100	0.01	(0.008−0.013)	100
0.8	35	13900	0.028	(0.016−0.040)	385	25	9900	0.02	(0.016−0.026)	195
1.0	40	12700	0.035	(0.020−0.050)	440	30	9500	0.03	(0.020−0.044)	285
1.2	40	10600	0.045	(0.030−0.060)	475	30	7900	0.04	(0.030−0.053)	315
1.6	40	7900	0.055	(0.035−0.080)	430	30	5900	0.05	(0.035−0.070)	295
2.0	40	6300	0.07	(0.040−0.100)	440	30	4700	0.06	(0.040−0.080)	280
2.5	50	6300	0.085	(0.050−0.125)	535	40	5000	0.075	(0.050−0.100)	375
3.2	70	6900	0.1	(0.06−0.13)	690	40	3900	0.08	(0.06−0.10)	310
4.0	80	6300	0.11	(0.07−0.14)	690	40	3100	0.09	(0.06−0.11)	275
5.0	80	5000	0.14	(0.09−0.18)	700	40	2500	0.11	(0.08−0.14)	275
6.3	90	4500	0.18	(0.11−0.24)	810	50	2500	0.14	(0.09−0.18)	350
8.0	100	3900	0.21	(0.16−0.25)	815	50	1900	0.15	(0.10−0.19)	285
10.0	110	3500	0.23	(0.19−0.27)	805	50	1500	0.16	(0.12−0.20)	240
12.0	120	3100	0.26	(0.22−0.29)	805	60	1500	0.18	(0.15−0.21)	270
16.0	130	2500	0.28	(0.23−0.33)	700	60	1100	0.19	(0.14−0.24)	205
20.0	130	2000	0.3	(0.26−0.34)	600	60	900	0.21	(0.15−0.26)	185
25.0	130	1600	0.32	(0.28−0.35)	510	60	700	0.21	(0.17−0.25)	145

OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

■ SB/MB/LB/XB/DB Type Drill(L/D<10)

Work Material	Gray Cast Iron (≤350MPa) No 45 B etc					Ductile Cast Iron (≤450MPa) 60-40-8 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
0.5	40	25400	0.01	(0.005—0.015)	250	30	19000	0.01	(0.005—0.015)	190
0.63	40	20200	0.014	(0.008—0.020)	280	30	15100	0.014	(0.008—0.020)	210
0.8	45	17900	0.028	(0.016—0.040)	500	35	13900	0.028	(0.016—0.040)	385
1.0	50	15900	0.035	(0.020—0.050)	555	40	12700	0.035	(0.020—0.050)	440
1.2	50	13200	0.045	(0.030—0.060)	590	40	10600	0.045	(0.030—0.060)	475
1.6	50	9900	0.055	(0.035—0.080)	540	40	7900	0.055	(0.035—0.080)	430
2.0	50	7900	0.07	(0.040—0.100)	550	40	6300	0.07	(0.040—0.100)	440
2.5	60	7600	0.085	(0.050—0.125)	645	50	6300	0.085	(0.050—0.125)	535
3.2	90	8900	0.1	(0.06—0.13)	890	65	6400	0.1	(0.06—0.13)	640
4.0	100	7900	0.12	(0.08—0.16)	945	65	5100	0.12	(0.08—0.16)	610
5.0	100	6300	0.15	(0.10—0.20)	945	65	4100	0.15	(0.10—0.20)	615
6.3	110	5500	0.2	(0.13—0.26)	1100	70	3500	0.2	(0.13—0.26)	700
8.0	120	4700	0.25	(0.18—0.31)	1175	70	2700	0.23	(0.18—0.28)	620
10.0	130	4100	0.29	(0.22—0.35)	1185	70	2200	0.27	(0.22—0.32)	590
12.0	140	3700	0.32	(0.26—0.37)	1180	90	2300	0.3	(0.26—0.34)	690
16.0	160	3100	0.35	(0.28—0.42)	1085	90	1700	0.33	(0.28—0.38)	560
20.0	160	2500	0.37	(0.30—0.44)	925	100	1500	0.35	(0.30—0.40)	525
25.0	160	2000	0.37	(0.30—0.44)	740	100	1200	0.35	(0.30—0.40)	420

Work Material	Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc					Heat Resistant Alloy Inconel718				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
0.5	40	25400	0.014	(0.008—0.020)	355	10	6300	0.006	(0.004—0.008)	35
0.63	40	20200	0.02	(0.012—0.030)	400	10	5000	0.008	(0.007—0.010)	40
0.8	45	17900	0.036	(0.024—0.050)	640	10	3900	0.016	(0.013—0.021)	60
1.0	60	19000	0.05	(0.030—0.075)	950	10	3100	0.02	(0.016—0.027)	60
1.2	70	18500	0.065	(0.045—0.090)	1200	10	2600	0.025	(0.022—0.032)	65
1.6	80	15900	0.085	(0.053—0.120)	1350	10	1900	0.03	(0.025—0.040)	55
2.0	90	14300	0.105	(0.060—0.150)	1500	15	2300	0.04	(0.032—0.050)	90
2.5	100	12700	0.135	(0.075—0.200)	1710	15	1900	0.05	(0.040—0.060)	95
3.2	120	11900	0.23	(0.10—0.35)	2735	20	1900	0.07	(0.05—0.09)	130
4.0	120	9500	0.24	(0.12—0.35)	2280	20	1500	0.09	(0.06—0.11)	135
5.0	120	7600	0.25	(0.15—0.35)	1900	20	1200	0.11	(0.08—0.14)	130
6.3	150	7500	0.35	(0.20—0.50)	2625	25	1200	0.13	(0.09—0.16)	155
8.0	150	5900	0.35	(0.20—0.50)	2065	25	900	0.14	(0.11—0.17)	125
10.0	150	4700	0.5	(0.20—0.80)	2350	25	700	0.15	(0.12—0.17)	105
12.0	160	4200	0.5	(0.20—0.80)	2100	25	600	0.16	(0.13—0.18)	95
16.0	160	3100	0.6	(0.20—1.00)	1860	25	400	0.18	(0.14—0.21)	70
20.0	170	2700	0.6	(0.20—1.00)	1620	30	400	0.19	(0.15—0.22)	75
25.0	170	2100	0.6	(0.20—1.00)	1260	30	300	0.19	(0.15—0.22)	55

■ DB Type Drill(L/D≥10)

Work Material	Mild Steel (≤180 HB) AISI 1010 etc					Carbon Steel•Alloy Steel (180—280HB) AISI 1045, AISI 4140 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
1.0	50	15900	0.02	(0.010—0.030)	320	40	12700	0.02	(0.010—0.030)	255
1.2	50	13200	0.025	(0.016—0.037)	330	40	10600	0.025	(0.016—0.037)	265
1.6	50	9900	0.055	(0.032—0.080)	545	40	7900	0.055	(0.032—0.080)	435
2.0	60	9500	0.07	(0.040—0.100)	665	50	7900	0.07	(0.040—0.100)	550
2.5	60	7600	0.09	(0.063—0.125)	685	50	6300	0.09	(0.055—0.125)	565
3.2	90	8900	0.1	(0.06—0.13)	890	80	7900	0.1	(0.06—0.13)	790
4.0	90	7100	0.12	(0.08—0.16)	850	80	6300	0.12	(0.08—0.16)	755
5.0	90	5700	0.15	(0.10—0.20)	855	80	5000	0.15	(0.10—0.20)	750
6.3	110	5500	0.2	(0.13—0.26)	1100	90	4500	0.2	(0.13—0.26)	900
8.0	110	4300	0.23	(0.18—0.28)	990	90	3500	0.23	(0.18—0.28)	805
10.0	110	3500	0.26	(0.20—0.32)	910	90	2800	0.26	(0.20—0.32)	730
12.0	130	3400	0.3	(0.25—0.34)	1020	110	2900	0.3	(0.25—0.34)	870
16.0	130	2500	0.31	(0.24—0.38)	775	110	2100	0.31	(0.24—0.38)	650

Work Material	Carbon Steel•Alloy Steel (280—350HB) AISI 4340 etc					Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
1.0	30	9500	0.015	(0.009—0.028)	140	30	9500	0.015	(0.009—0.028)	140
1.2	30	7900	0.02	(0.013—0.035)	160	30	7900	0.02	(0.013—0.035)	155
1.6	30	5900	0.05	(0.027—0.076)	295	30	5900	0.045	(0.025—0.065)	265
2.0	50	7900	0.065	(0.034—0.095)	515	30	4700	0.055	(0.030—0.080)	255
2.5	50	6300	0.08	(0.045—0.120)	505	40	5000	0.06	(0.035—0.085)	300
3.2	70	6900	0.09	(0.05—0.12)	620	40	3900	0.07	(0.05—0.09)	270
4.0	70	5500	0.11	(0.07—0.15)	605	40	3100	0.08	(0.06—0.10)	245
5.0	70	4400	0.14	(0.09—0.19)	615	40	2500	0.1	(0.07—0.12)	250
6.3	80	4000	0.18	(0.11—0.25)	720	50	2500	0.12	(0.08—0.16)	300
8.0	80	3100	0.21	(0.15—0.26)	650	50	1900	0.14	(0.10—0.17)	265
10.0	80	2500	0.23	(0.15—0.30)	575	50	1500	0.15	(0.12—0.18)	225
12.0	90	2300	0.25	(0.19—0.31)	575	60	1500	0.17	(0.14—0.19)	255
16.0	90	1700	0.28	(0.19—0.36)	475	60	1100	0.18	(0.13—0.22)	195

OPERATION GUIDANCE ➤ P119,P120
TECHNICAL DATA ➤ R001

MWS

WSTAR DRILLS

RECOMMENDED CUTTING CONDITIONS

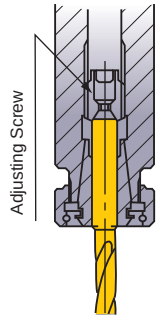
■ DB Type Drill(L/D≥10)

Work Material	Gray Cast Iron (≤350MPa) No 45 B etc					Ductile Cast Iron (≤450MPa) 60-40-8 etc				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
1.0	40	12700	0.02	(0.010—0.030)	255	30	9500	0.015	(0.009—0.028)	140
1.2	40	10600	0.025	(0.016—0.037)	265	30	7900	0.02	(0.013—0.035)	160
1.6	40	7900	0.055	(0.032—0.080)	435	30	5900	0.05	(0.027—0.076)	295
2.0	50	7900	0.07	(0.040—0.100)	550	50	7900	0.065	(0.034—0.095)	515
2.5	50	6300	0.09	(0.055—0.125)	565	50	6300	0.08	(0.045—0.120)	505
3.2	90	8900	0.1	(0.06—0.13)	890	50	4900	0.09	(0.05—0.12)	440
4.0	90	7100	0.12	(0.08—0.16)	850	50	3900	0.11	(0.07—0.15)	430
5.0	90	5700	0.15	(0.10—0.20)	855	50	3100	0.14	(0.09—0.19)	435
6.3	110	5500	0.2	(0.13—0.26)	1100	60	3000	0.18	(0.11—0.25)	540
8.0	110	4300	0.23	(0.18—0.28)	990	60	2300	0.21	(0.15—0.26)	480
10.0	110	3500	0.26	(0.20—0.32)	910	60	1900	0.23	(0.15—0.30)	435
12.0	130	3400	0.3	(0.25—0.34)	1020	80	2100	0.25	(0.19—0.31)	525
16.0	130	2500	0.31	(0.24—0.38)	775	80	1500	0.28	(0.19—0.36)	420

Work Material	Aluminium Alloy (Si<5%) ASTM A6061, ASTM A7075 etc					Heat Resistant Alloy Inconel718				
Drill Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.—Max.) (mm/rev)		Table Feed (mm/min)
1.0	50	15900	0.05	(0.030—0.075)	795	10	3100	0.02	(0.016—0.027)	60
1.2	60	15900	0.065	(0.045—0.090)	1035	10	2600	0.025	(0.022—0.032)	65
1.6	70	13900	0.085	(0.053—0.120)	1180	10	1900	0.03	(0.025—0.040)	55
2.0	80	12700	0.105	(0.060—0.150)	1335	15	2300	0.04	(0.032—0.050)	90
2.5	90	11400	0.135	(0.075—0.200)	1540	15	1900	0.05	(0.040—0.060)	95
3.2	100	9900	0.23	(0.10—0.35)	2275	20	1900	0.07	(0.05—0.09)	130
4.0	100	7900	0.24	(0.12—0.35)	1895	20	1500	0.09	(0.06—0.11)	135
5.0	100	6300	0.25	(0.15—0.35)	1575	20	1200	0.11	(0.08—0.14)	130
6.3	130	6500	0.35	(0.20—0.50)	2275	20	1000	0.13	(0.09—0.16)	130
8.0	130	5100	0.35	(0.20—0.50)	1785	20	700	0.14	(0.11—0.16)	100
10.0	130	4100	0.5	(0.20—0.80)	2050	20	600	0.15	(0.12—0.17)	90
12.0	140	3700	0.5	(0.20—0.80)	1850	20	500	0.16	(0.13—0.18)	80
16.0	140	2700	0.5	(0.20—0.80)	1350	20	300	0.17	(0.14—0.19)	50

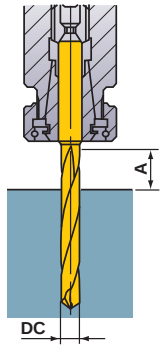
SB/MB/LB/XB TYPE DRILL OPERATIONAL GUIDANCE

Drill Holding



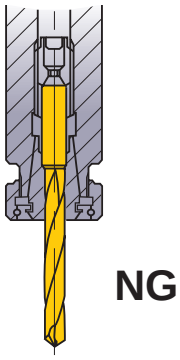
Thrust bearing type collet chuck holds the drill securely.

Drill Length



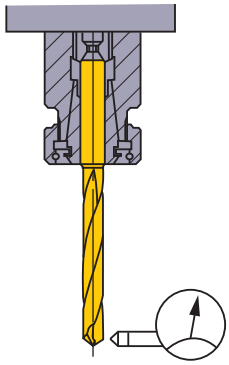
A ≥ DC x 1.5
(DC×over 2.0 for DC<3)

Drill Installation



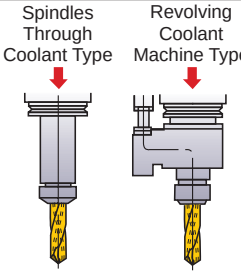
Do not clamp on the flutes.

Installation Tolerance(DC≥3)



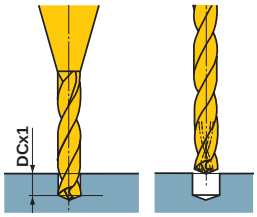
Run-out ≤ 0.03mm

Through Coolant Type(DC≥3)



Coolant pressure is approx. 0.5—1MPa (2-3MPa for DC≤5, 1.5MPa at minimum for DC<3
Recommended coolant pressure:>3Mpa).
Coolant volume is 1.5—4.0l/min. (For DC≥3)

Drill Installation



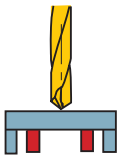
①When machining a prepared hole with the MWS-SB please set the depth to 1DC (DC=drill diameter). For pilot hole drilling when DC is up to 3, use the SB type drill.
②Use the prepared hole as a guide when using a drill with an oil hole. Depending on the cutting conditions, peck feed is recommended.

Coolant Handling

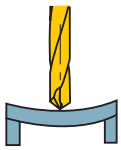
1) Small particles of swarf will jam in the oil hole of small diameter drills. Always use a fine mesh filter as a preventative measure.

2) Dirt and dust particles adhere to the oil in old coolant and prevent an efficient flow. Regular coolant exchange is recommended.

Thin Workpiece

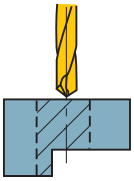


OK
Support the Workpiece

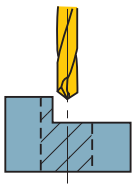


NG
If Bending Occurs

Interrupted Cutting(DC≥3)

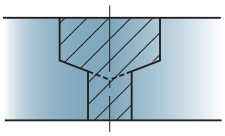


One Process
OK
①Lower the feed when drilling the interrupted part.



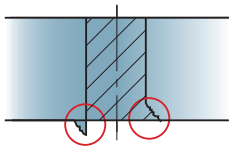
Requires Prior Machining
①Spot face with an end mill prior to drilling.

Stepped Holes(DC≥3)



①Divide the two processes.
②Drill the larger hole first.
*A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping(DC≥3)



①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

NOTES ON USE (For DC<3)

- Please use a fine mesh filter (mesh≤3μm) for coolant to prevent jamming in the oil hole.
- For deep drilling with the long type drill, machining a pilot hole is recommended. (Otherwise, centrifugal forces may cause drill breakage.)

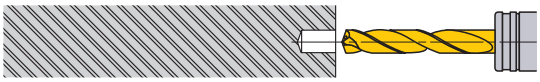
MWS

WSTAR DRILLS

■ DB TYPE DRILL(L/D≥10, DC<3) OPERATIONAL GUIDANCE

FLAT FACE DRILLING ●Drilling a blind hole

■ 1. Drilling a pilot hole



①Use the SB type drill.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 2. Initial cutting with the long type drill

①Penetrate the guide hole at low revolution. (Revolution 1000min^{-1}, feed rate 0.2–0.3mm/rev)
②Stop the long type drill 0.5–1mm short of the guide hole bottom.

■ 3. Drill the deep hole

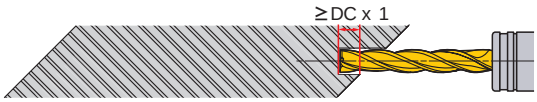
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 4. Drill retraction

①After drilling, lower the cutting revolution about 0.5–1mm short of the hole end. (Revolution of around 1000min^{-1})
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.
③Finally, clear the hole at a cutting speed of 20–30m/min and feed rate of 0.2–0.3mm/rev.

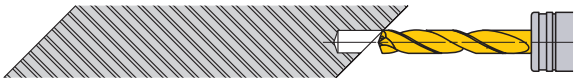
INTERRUPED DRILLING ●Drilling and breaking through on irregular faces or angles

■ 1. Spot facing



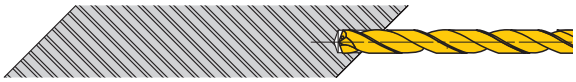
①When machining a deep hole into an inclined surface, use MFE drill as a drill for a guide hole.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.

■ 2. Drilling a pilot hole



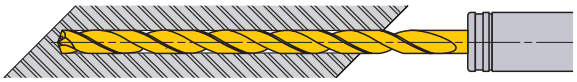
①Use a drill with a larger (flatter) point angle than the long type. TheMWS-SB type is recommended.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 3. Initial cutting with the long type drill



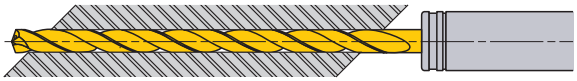
①Penetrate the guide hole at a low revolution. (Revolution 1000min-1, feed rate 0.2–0.3mm/rev)
②Stop the long type drill 0.5–1mm short of the guide hole bottom.

■ 4. Drill the deep hole



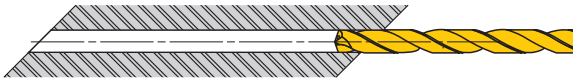
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 5. Breaking through



①When breaking through, the cutting edge can be damaged.
②Feed rate should be half the normal feed.

■ 6. Drill retraction

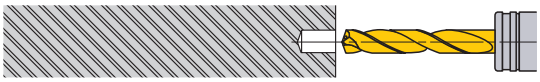


①Finally clear the hole at a revolution speed of 1000min-1 and feed rate of 0.2–0.3mm/rev.
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.

■ OPERATIONAL GUIDANCE FOR THE LONG TYPE DRILL (L/D≥3)

FLAT FACE DRILLING ●Drilling a blind hole

■ 1. Drilling a pilot hole



①Use a drill with a larger (flatter) point angle than the super long type.
MVS pilot drill with point angle 145° is recommended.

②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1—2.
(Adjust the pilot hole depth according to the length of the long type drill.)

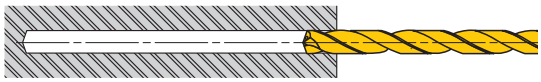
■ 2. Initial cutting with the long type drill

①Penetrate the guide hole at low revolution.
(Cutting speed 20—30m/min, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 1—3mm short of the guide hole bottom.

■ 3. Drill the deep hole

①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

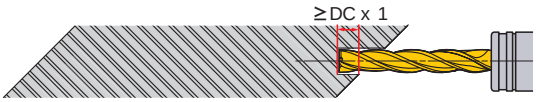
■ 4. Drill retraction



①After drilling, lower the cutting revolution about 1—2mm short of the hole end. (Cutting speed of around 20—30m/min)
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.
③Finally, clear the hole at a cutting speed of 20—30m/min and feed rate of 0.2—0.3mm/rev.

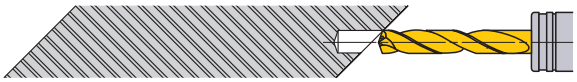
INTERRUPED DRILLING ●Drilling and breaking through on irregular faces or angles

■ 1. Spot facing



①When machining a deep hole into an inclined surface, use MFE drill as a drill for a guide hole.
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1.

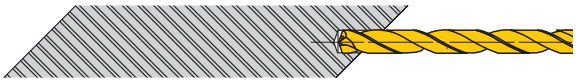
■ 2. Drilling a pilot hole



①Use a drill with a larger (flatter) point angle than the super long type.
MVS pilot drill with point angle 145° is recommended.

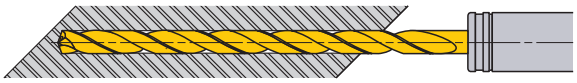
②Ensure a high precision hole is drilled for the guide.
③Drill depth : Approx DC×1—2.
(Adjust the pilot hole depth according to the length of the long type drill.)

■ 3. Initial cutting with the long type drill



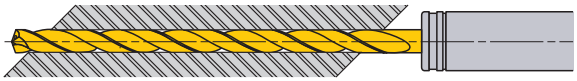
①Penetrate the guide hole at a low revolution.
(Cutting speed 20—30m/min, feed rate 0.2—0.3mm/rev)
②Stop the long type drill 1—3mm short of the guide hole bottom.

■ 4. Drill the deep hole



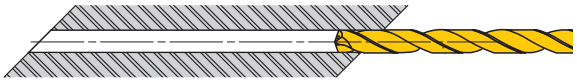
①Start cutting at the recommended speed and feed with a non-peck (continuous feed) cycle.

■ 5. Breaking through



①When breaking through, the cutting edge can be damaged.
②A feed rate of 0.05—0.1mm/rev is recommended.

■ 6. Drill retraction



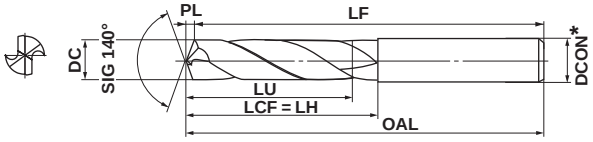
①Finally clear the hole at a cutting speed of 20—30m/min and feed rate of 0.2—0.3mm/rev.
②Retract the drill to the pilot hole depth starting point at a feed rate of 3000mm/min.

MZE

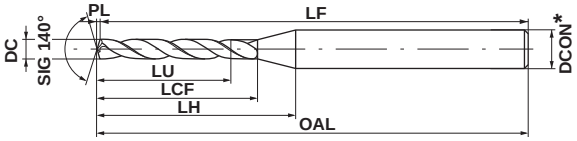
●A wide groove width provides good chip discharge.

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	Hardened Steel

External Coolant



Type1



Type2

* DCON < 2 : h6
DCON ≥ 2 : h8

DC<2	2≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
0 −0.014	0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033

	2≤DCON≤3	3<DCON≤6	6<DCON≤10	10<DCON≤18	18<DCON≤20
	0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
1.0	2	●	MZE0100SB	2.2	6.2	8.2	55.2	55	0.2	2.0	2
1.1	2	●	MZE0110SB	2.4	7.2	9.2	55.2	55	0.2	2.0	2
1.2	2	●	MZE0120SB	2.6	8.2	9.2	55.2	55	0.2	2.0	2
1.3	2	●	MZE0130SB	2.8	8.2	9.2	55.2	55	0.2	2.0	2
1.4	2	●	MZE0140SB	3.1	9.3	10.3	55.3	55	0.3	2.0	2
1.5	2	●	MZE0150SB	3.3	9.3	10.3	55.3	55	0.3	2.0	2
1.6	2	●	MZE0160SB	3.5	10.3	10.3	55.3	55	0.3	2.0	1
1.7	2	●	MZE0170SB	3.7	10.3	10.3	55.3	55	0.3	2.0	1
1.8	2	●	MZE0180SB	3.9	11.3	11.3	55.3	55	0.3	2.0	1
1.9	2	●	MZE0190SB	4.1	11.3	11.3	55.3	55	0.3	2.0	1
2.0	2	●	MZE0200SA	4.4	12.4	12.4	55.4	55	0.4	2.0	1
2.0	3	●	MZE0200MA	6.4	16.4	16.4	55.4	55	0.4	2.0	1
2.1	2	●	MZE0210SA	4.6	12.4	12.4	55.4	55	0.4	2.1	1
2.1	3	●	MZE0210MA	6.7	16.4	16.4	55.4	55	0.4	2.1	1
2.2	2	●	MZE0220SA	4.8	13.4	13.4	55.4	55	0.4	2.2	1
2.2	3	●	MZE0220MA	7.0	18.4	18.4	55.4	55	0.4	2.2	1
2.3	2	●	MZE0230SA	5.0	13.4	13.4	55.4	55	0.4	2.3	1
2.3	3	●	MZE0230MA	7.3	18.4	18.4	55.4	55	0.4	2.3	1
2.4	2	●	MZE0240SA	5.2	16.4	16.4	55.4	55	0.4	2.4	1
2.4	3	●	MZE0240MA	7.6	20.4	20.4	55.4	55	0.4	2.4	1
2.5	2	●	MZE0250SA	5.5	16.5	16.5	55.5	55	0.5	2.5	1
2.5	3	●	MZE0250MA	8.0	20.5	20.5	55.5	55	0.5	2.5	1
2.6	2	●	MZE0260SA	5.7	16.5	16.5	55.5	55	0.5	2.6	1
2.6	3	●	MZE0260MA	8.3	20.5	20.5	55.5	55	0.5	2.6	1
2.7	2	●	MZE0270SA	5.9	16.5	16.5	55.5	55	0.5	2.7	1
2.7	3	●	MZE0270MA	8.6	20.5	20.5	55.5	55	0.5	2.7	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
2.8	2	●	MZE0280SA	6.1	16.5	16.5	55.5	55	0.5	2.8	1
2.8	3	●	MZE0280MA	8.9	21.5	21.5	60.5	60	0.5	2.8	1
2.9	2	●	MZE0290SA	6.3	16.5	16.5	55.5	55	0.5	2.9	1
2.9	3	●	MZE0290MA	9.2	21.5	21.5	60.5	60	0.5	2.9	1
3.0	2	●	MZE0300SA	6.5	16.5	16.5	55.5	55	0.5	3.0	1
3.0	3	●	MZE0300MA	9.5	21.5	21.5	60.5	60	0.5	3.0	1
3.1	2	●	MZE0310SA	6.8	18.6	18.6	55.6	55	0.6	3.1	1
3.1	3	●	MZE0310MA	9.9	24.6	24.6	60.6	60	0.6	3.1	1
3.2	2	●	MZE0320SA	7.0	18.6	18.6	55.6	55	0.6	3.2	1
3.2	3	●	MZE0320MA	10.2	24.6	24.6	60.6	60	0.6	3.2	1
3.3	2	●	MZE0330SA	7.2	18.6	18.6	55.6	55	0.6	3.3	1
3.3	3	●	MZE0330MA	10.5	24.6	24.6	60.6	60	0.6	3.3	1
3.4	2	●	MZE0340SA	7.4	20.6	20.6	55.6	55	0.6	3.4	1
3.4	3	●	MZE0340MA	10.8	24.6	24.6	60.6	60	0.6	3.4	1
3.5	2	●	MZE0350SA	7.6	20.6	20.6	55.6	55	0.6	3.5	1
3.5	3	●	MZE0350MA	11.1	24.6	24.6	60.6	60	0.6	3.5	1
3.6	2	●	MZE0360SA	7.9	20.7	20.7	55.7	55	0.7	3.6	1
3.6	3	●	MZE0360MA	11.5	27.7	27.7	60.7	60	0.7	3.6	1
3.7	2	●	MZE0370SA	8.1	20.7	20.7	55.7	55	0.7	3.7	1
3.7	3	●	MZE0370MA	11.8	27.7	27.7	60.7	60	0.7	3.7	1
3.8	2	●	MZE0380SA	8.3	22.7	22.7	55.7	55	0.7	3.8	1
3.8	3	●	MZE0380MA	12.1	27.7	27.7	60.7	60	0.7	3.8	1
3.9	2	●	MZE0390SA	8.5	22.7	22.7	55.7	55	0.7	3.9	1
3.9	3	●	MZE0390MA	12.4	27.7	27.7	60.7	60	0.7	3.9	1
4.0	2	●	MZE0400SA	8.7	22.7	22.7	55.7	55	0.7	4.0	1
4.0	3	●	MZE0400MA	12.7	27.7	27.7	60.7	60	0.7	4.0	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
4.1	2	●	MZE0410SA	8.9	22.7	22.7	55.7	55	0.7	4.1	1
4.1	3	●	MZE0410MA	13.0	29.7	29.7	63.7	63	0.7	4.1	1
4.2	2	●	MZE0420SA	9.2	22.8	22.8	55.8	55	0.8	4.2	1
4.2	3	●	MZE0420MA	13.4	29.8	29.8	63.8	63	0.8	4.2	1
4.3	2	●	MZE0430SA	9.4	24.8	24.8	58.8	58	0.8	4.3	1
4.3	3	●	MZE0430MA	13.7	29.8	29.8	63.8	63	0.8	4.3	1
4.4	2	●	MZE0440SA	9.6	24.8	24.8	58.8	58	0.8	4.4	1
4.4	3	●	MZE0440MA	14.0	29.8	29.8	63.8	63	0.8	4.4	1
4.5	2	●	MZE0450SA	9.8	24.8	24.8	58.8	58	0.8	4.5	1
4.5	3	●	MZE0450MA	14.3	29.8	29.8	63.8	63	0.8	4.5	1
4.6	2	●	MZE0460SA	10.0	24.8	24.8	58.8	58	0.8	4.6	1
4.6	3	●	MZE0460MA	14.6	32.8	32.8	68.8	68	0.8	4.6	1
4.7	2	●	MZE0470SA	10.3	24.9	24.9	58.9	58	0.9	4.7	1
4.7	3	●	MZE0470MA	15.0	32.9	32.9	68.9	68	0.9	4.7	1
4.8	2	●	MZE0480SA	10.5	26.9	26.9	62.9	62	0.9	4.8	1
4.8	3	●	MZE0480MA	15.3	32.9	32.9	68.9	68	0.9	4.8	1
4.9	2	●	MZE0490SA	10.7	26.9	26.9	62.9	62	0.9	4.9	1
4.9	3	●	MZE0490MA	15.6	32.9	32.9	68.9	68	0.9	4.9	1
5.0	2	●	MZE0500SA	10.9	26.9	26.9	62.9	62	0.9	5.0	1
5.0	3	●	MZE0500MA	15.9	32.9	32.9	68.9	68	0.9	5.0	1
5.1	2	●	MZE0510SA	11.1	26.9	26.9	62.9	62	0.9	5.1	1
5.1	3	●	MZE0510MA	16.2	34.9	34.9	72.9	72	0.9	5.1	1
5.2	2	●	MZE0520SA	11.3	26.9	26.9	62.9	62	0.9	5.2	1
5.2	3	●	MZE0520MA	16.5	34.9	34.9	72.9	72	0.9	5.2	1
5.3	2	●	MZE0530SA	11.6	27.0	27.0	63.0	62	1.0	5.3	1
5.3	3	●	MZE0530MA	16.9	35.0	35.0	73.0	72	1.0	5.3	1
5.4	2	●	MZE0540SA	11.8	29.0	29.0	67.0	66	1.0	5.4	1
5.4	3	●	MZE0540MA	17.2	35.0	35.0	73.0	72	1.0	5.4	1
5.5	2	●	MZE0550SA	12.0	29.0	29.0	67.0	66	1.0	5.5	1
5.5	3	●	MZE0550MA	17.5	35.0	35.0	73.0	72	1.0	5.5	1
5.6	2	●	MZE0560SA	12.2	29.0	29.0	67.0	66	1.0	5.6	1
5.6	3	●	MZE0560MA	17.8	37.0	37.0	75.0	74	1.0	5.6	1
5.7	2	●	MZE0570SA	12.4	29.0	29.0	67.0	66	1.0	5.7	1
5.7	3	●	MZE0570MA	18.1	37.0	37.0	75.0	74	1.0	5.7	1
5.8	2	●	MZE0580SA	12.7	29.1	29.1	67.1	66	1.1	5.8	1
5.8	3	●	MZE0580MA	18.5	37.1	37.1	75.1	74	1.1	5.8	1
5.9	2	●	MZE0590SA	12.9	29.1	29.1	67.1	66	1.1	5.9	1
5.9	3	●	MZE0590MA	18.8	37.1	37.1	75.1	74	1.1	5.9	1
6.0	2	●	MZE0600SA	13.1	29.1	29.1	67.1	66	1.1	6.0	1
6.0	3	●	MZE0600MA	19.1	42.1	42.1	82.1	81	1.1	6.0	1
6.1	2	●	MZE0610SA	13.3	32.1	32.1	71.1	70	1.1	6.1	1
6.1	3	●	MZE0610MA	19.4	42.1	42.1	82.1	81	1.1	6.1	1
6.2	2	●	MZE0620SA	13.5	32.1	32.1	71.1	70	1.1	6.2	1
6.2	3	●	MZE0620MA	19.7	42.1	42.1	82.1	81	1.1	6.2	1
6.3	2	●	MZE0630SA	13.7	32.1	32.1	71.1	70	1.1	6.3	1
6.3	3	●	MZE0630MA	20.0	42.1	42.1	82.1	81	1.1	6.3	1
6.4	2	●	MZE0640SA	14.0	32.2	32.2	71.2	70	1.2	6.4	1
6.4	3	●	MZE0640MA	20.4	42.2	42.2	82.2	81	1.2	6.4	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
6.5	2	●	MZE0650SA	14.2	32.2	32.2	71.2	70	1.2	6.5	1
6.5	3	●	MZE0650MA	20.7	42.2	42.2	82.2	81	1.2	6.5	1
6.6	2	●	MZE0660SA	14.4	32.2	32.2	71.2	70	1.2	6.6	1
6.6	3	●	MZE0660MA	21.0	44.2	44.2	84.2	83	1.2	6.6	1
6.7	2	●	MZE0670SA	14.6	32.2	32.2	71.2	70	1.2	6.7	1
6.7	3	●	MZE0670MA	21.3	44.2	44.2	84.2	83	1.2	6.7	1
6.8	2	●	MZE0680SA	14.8	35.2	35.2	75.2	74	1.2	6.8	1
6.8	3	●	MZE0680MA	21.6	44.2	44.2	84.2	83	1.2	6.8	1
6.9	2	●	MZE0690SA	15.1	35.3	35.3	75.3	74	1.3	6.9	1
6.9	3	●	MZE0690MA	22.0	44.3	44.3	84.3	83	1.3	6.9	1
7.0	2	●	MZE0700SA	15.3	35.3	35.3	75.3	74	1.3	7.0	1
7.0	3	●	MZE0700MA	22.3	44.3	44.3	84.3	83	1.3	7.0	1
7.1	2	●	MZE0710SA	15.5	35.3	35.3	75.3	74	1.3	7.1	1
7.1	3	●	MZE0710MA	22.6	46.3	46.3	88.3	87	1.3	7.1	1
7.2	2	●	MZE0720SA	15.7	35.3	35.3	75.3	74	1.3	7.2	1
7.2	3	●	MZE0720MA	22.9	46.3	46.3	88.3	87	1.3	7.2	1
7.3	2	●	MZE0730SA	15.9	35.3	35.3	75.3	74	1.3	7.3	1
7.3	3	●	MZE0730MA	23.2	46.3	46.3	88.3	87	1.3	7.3	1
7.4	2	●	MZE0740SA	16.1	35.3	35.3	75.3	74	1.3	7.4	1
7.4	3	●	MZE0740MA	23.5	46.3	46.3	88.3	87	1.3	7.4	1
7.5	2	●	MZE0750SA	16.4	35.4	35.4	75.4	74	1.4	7.5	1
7.5	3	●	MZE0750MA	23.9	46.4	46.4	88.4	87	1.4	7.5	1
7.6	2	●	MZE0760SA	16.6	38.4	38.4	80.4	79	1.4	7.6	1
7.6	3	●	MZE0760MA	24.2	49.4	49.4	91.4	90	1.4	7.6	1
7.7	2	●	MZE0770SA	16.8	38.4	38.4	80.4	79	1.4	7.7	1
7.7	3	●	MZE0770MA	24.5	49.4	49.4	91.4	90	1.4	7.7	1
7.8	2	●	MZE0780SA	17.0	38.4	38.4	80.4	79	1.4	7.8	1
7.8	3	●	MZE0780MA	24.8	49.4	49.4	91.4	90	1.4	7.8	1
7.9	2	●	MZE0790SA	17.2	38.4	38.4	80.4	79	1.4	7.9	1
7.9	3	●	MZE0790MA	25.1	49.4	49.4	91.4	90	1.4	7.9	1
8.0	2	●	MZE0800SA	17.5	38.5	38.5	80.5	79	1.5	8.0	1
8.0	3	●	MZE0800MA	25.5	49.5	49.5	91.5	90	1.5	8.0	1
8.1	2	●	MZE0810SA	17.7	38.5	38.5	80.5	79	1.5	8.1	1
8.1	3	●	MZE0810MA	25.8	54.5	54.5	97.5	96	1.5	8.1	1
8.2	2	●	MZE0820SA	17.9	38.5	38.5	80.5	79	1.5	8.2	1
8.2	3	●	MZE0820MA	26.1	54.5	54.5	97.5	96	1.5	8.2	1
8.3	2	●	MZE0830SA	18.1	38.5	38.5	80.5	79	1.5	8.3	1
8.3	3	●	MZE0830MA	26.4	54.5	54.5	97.5	96	1.5	8.3	1
8.4	2	●	MZE0840SA	18.3	38.5	38.5	80.5	79	1.5	8.4	1
8.4	3	●	MZE0840MA	26.7	54.5	54.5	97.5	96	1.5	8.4	1
8.5	2	●	MZE0850SA	18.5	38.5	38.5	80.5	79	1.5	8.5	1
8.5	3	●	MZE0850MA	27.0	54.5	54.5	97.5	96	1.5	8.5	1
8.6	2	●	MZE0860SA	18.8	41.6	41.6	85.6	84	1.6	8.6	1
8.6	3	●	MZE0860MA	27.4	56.6	56.6	99.6	98	1.6	8.6	1
8.7	2	●	MZE0870SA	19.0	41.6	41.6	85.6	84	1.6	8.7	1
8.7	3	●	MZE0870MA	27.7	56.6	56.6	99.6	98	1.6	8.7	1
8.8	2	●	MZE0880SA	19.2	41.6	41.6	85.6	84	1.6	8.8	1
8.8	3	●	MZE0880MA	28.0	56.6	56.6	99.6	98	1.6	8.8	1

CUTTING CONDITIONS ➤ P127
OPERATION GUIDANCE ➤ P129
TECHNICAL DATA ➤ R001

MZE

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
8.9	2	●	MZE0890SA	19.4	41.6	41.6	85.6	84	1.6	8.9	1
8.9	3	●	MZE0890MA	28.3	56.6	56.6	99.6	98	1.6	8.9	1
9.0	2	●	MZE0900SA	19.6	41.6	41.6	85.6	84	1.6	9.0	1
9.0	3	●	MZE0900MA	28.6	56.6	56.6	99.6	98	1.6	9.0	1
9.1	2	●	MZE0910SA	19.9	41.7	41.7	85.7	84	1.7	9.1	1
9.1	3	●	MZE0910MA	29.0	59.7	59.7	103.7	102	1.7	9.1	1
9.2	2	●	MZE0920SA	20.1	41.7	41.7	85.7	84	1.7	9.2	1
9.2	3	●	MZE0920MA	29.3	59.7	59.7	103.7	102	1.7	9.2	1
9.3	2	●	MZE0930SA	20.3	41.7	41.7	85.7	84	1.7	9.3	1
9.3	3	●	MZE0930MA	29.6	59.7	59.7	103.7	102	1.7	9.3	1
9.4	2	●	MZE0940SA	20.5	41.7	41.7	85.7	84	1.7	9.4	1
9.4	3	●	MZE0940MA	29.9	59.7	59.7	103.7	102	1.7	9.4	1
9.5	2	●	MZE0950SA	20.7	41.7	41.7	85.7	84	1.7	9.5	1
9.5	3	●	MZE0950MA	30.2	59.7	59.7	103.7	102	1.7	9.5	1
9.6	2	●	MZE0960SA	20.9	44.7	44.7	90.7	89	1.7	9.6	1
9.6	3	●	MZE0960MA	30.5	61.7	61.7	106.7	105	1.7	9.6	1
9.7	2	●	MZE0970SA	21.2	44.8	44.8	90.8	89	1.8	9.7	1
9.7	3	●	MZE0970MA	30.9	61.8	61.8	106.8	105	1.8	9.7	1
9.8	2	●	MZE0980SA	21.4	44.8	44.8	90.8	89	1.8	9.8	1
9.8	3	●	MZE0980MA	31.2	61.8	61.8	106.8	105	1.8	9.8	1
9.9	2	●	MZE0990SA	21.6	44.8	44.8	90.8	89	1.8	9.9	1
9.9	3	●	MZE0990MA	31.5	61.8	61.8	106.8	105	1.8	9.9	1
10.0	2	●	MZE1000SA	21.8	44.8	44.8	90.8	89	1.8	10.0	1
10.0	3	●	MZE1000MA	31.8	61.8	61.8	106.8	105	1.8	10.0	1
10.1	2	●	MZE1010SA	22.0	44.8	44.8	90.8	89	1.8	10.1	1
10.1	3	●	MZE1010MA	32.1	67.8	67.8	113.8	112	1.8	10.1	1
10.2	2	●	MZE1020SA	22.3	44.9	44.9	90.9	89	1.9	10.2	1
10.2	3	●	MZE1020MA	32.5	67.9	67.9	113.9	112	1.9	10.2	1
10.3	2	●	MZE1030SA	22.5	44.9	44.9	90.9	89	1.9	10.3	1
10.3	3	●	MZE1030MA	32.8	67.9	67.9	113.9	112	1.9	10.3	1
10.4	2	●	MZE1040SA	22.7	44.9	44.9	90.9	89	1.9	10.4	1
10.4	3	●	MZE1040MA	33.1	67.9	67.9	113.9	112	1.9	10.4	1
10.5	2	●	MZE1050SA	22.9	44.9	44.9	90.9	89	1.9	10.5	1
10.5	3	●	MZE1050MA	33.4	67.9	67.9	113.9	112	1.9	10.5	1
10.6	2	●	MZE1060SA	23.1	44.9	44.9	90.9	89	1.9	10.6	1
10.6	3	●	MZE1060MA	33.7	69.9	69.9	115.9	114	1.9	10.6	1
10.7	2	●	MZE1070SA	23.3	48.9	48.9	96.9	95	1.9	10.7	1
10.7	3	●	MZE1070MA	34.0	69.9	69.9	115.9	114	1.9	10.7	1
10.8	2	●	MZE1080SA	23.6	49.0	49.0	97.0	95	2.0	10.8	1
10.8	3	●	MZE1080MA	34.4	70.0	70.0	116.0	114	2.0	10.8	1
10.9	2	●	MZE1090SA	23.8	49.0	49.0	97.0	95	2.0	10.9	1
10.9	3	●	MZE1090MA	34.7	70.0	70.0	116.0	114	2.0	10.9	1
11.0	2	●	MZE1100SA	24.0	49.0	49.0	97.0	95	2.0	11.0	1
11.0	3	●	MZE1100MA	35.0	70.0	70.0	116.0	114	2.0	11.0	1
11.1	2	●	MZE1110SA	24.2	49.0	49.0	97.0	95	2.0	11.1	1
11.1	3	●	MZE1110MA	35.3	73.0	73.0	120.0	118	2.0	11.1	1
11.2	2	●	MZE1120SA	24.4	49.0	49.0	97.0	95	2.0	11.2	1
11.2	3	●	MZE1120MA	35.6	73.0	73.0	120.0	118	2.0	11.2	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
11.3	2	●	MZE1130SA	24.7	49.1	49.1	97.1	95	2.1	11.3	1
11.3	3	●	MZE1130MA	36.0	73.1	73.1	120.1	118	2.1	11.3	1
11.4	2	●	MZE1140SA	24.9	49.1	49.1	97.1	95	2.1	11.4	1
11.4	3	●	MZE1140MA	36.3	73.1	73.1	120.1	118	2.1	11.4	1
11.5	2	●	MZE1150SA	25.1	49.1	49.1	97.1	95	2.1	11.5	1
11.5	3	●	MZE1150MA	36.6	73.1	73.1	120.1	118	2.1	11.5	1
11.6	2	●	MZE1160SA	25.3	49.1	49.1	97.1	95	2.1	11.6	1
11.6	3	●	MZE1160MA	36.9	75.1	75.1	123.1	121	2.1	11.6	1
11.7	2	●	MZE1170SA	25.5	49.1	49.1	97.1	95	2.1	11.7	1
11.7	3	●	MZE1170MA	37.2	75.1	75.1	123.1	121	2.1	11.7	1
11.8	2	●	MZE1180SA	25.7	49.1	49.1	97.1	95	2.1	11.8	1
11.8	3	●	MZE1180MA	37.5	75.1	75.1	123.1	121	2.1	11.8	1
11.9	2	●	MZE1190SA	26.0	53.2	53.2	104.2	102	2.2	11.9	1
11.9	3	●	MZE1190MA	37.9	75.2	75.2	123.2	121	2.2	11.9	1
12.0	2	●	MZE1200SA	26.2	53.2	53.2	104.2	102	2.2	12.0	1
12.0	3	●	MZE1200MA	38.2	75.2	75.2	123.2	121	2.2	12.0	1
12.1	2	●	MZE1210SA	26.4	53.2	53.2	104.2	102	2.2	12.1	1
12.1	3	●	MZE1210MA	38.5	78.2	78.2	137.2	135	2.2	12.1	1
12.2	2	●	MZE1220SA	26.6	53.2	53.2	104.2	102	2.2	12.2	1
12.2	3	●	MZE1220MA	38.8	78.2	78.2	137.2	135	2.2	12.2	1
12.3	2	●	MZE1230SA	26.8	53.2	53.2	104.2	102	2.2	12.3	1
12.3	3	●	MZE1230MA	39.1	78.2	78.2	137.2	135	2.2	12.3	1
12.4	2	●	MZE1240SA	27.1	53.3	53.3	104.3	102	2.3	12.4	1
12.4	3	●	MZE1240MA	39.5	78.3	78.3	137.3	135	2.3	12.4	1
12.5	2	●	MZE1250SA	27.3	53.3	53.3	104.3	102	2.3	12.5	1
12.5	3	●	MZE1250MA	39.8	78.3	78.3	137.3	135	2.3	12.5	1
12.6	2	●	MZE1260SA	27.5	53.3	53.3	104.3	102	2.3	12.6	1
12.6	3	●	MZE1260MA	40.1	80.3	80.3	139.3	137	2.3	12.6	1
12.7	2	●	MZE1270SA	27.7	53.3	53.3	104.3	102	2.3	12.7	1
12.7	3	●	MZE1270MA	40.4	80.3	80.3	139.3	137	2.3	12.7	1
12.8	2	●	MZE1280SA	27.9	53.3	53.3	104.3	102	2.3	12.8	1
12.8	3	●	MZE1280MA	40.7	80.3	80.3	139.3	137	2.3	12.8	1
12.9	2	●	MZE1290SA	28.1	53.3	53.3	104.3	102	2.3	12.9	1
12.9	3	●	MZE1290MA	41.0	80.3	80.3	139.3	137	2.3	12.9	1
13.0	2	●	MZE1300SA	28.4	53.4	53.4	104.4	102	2.4	13.0	1
13.0	3	●	MZE1300MA	41.4	80.4	80.4	139.4	137	2.4	13.0	1
13.1	2	●	MZE1310SA	28.6	53.4	53.4	104.4	102	2.4	13.1	1
13.1	3	●	MZE1310MA	41.7	86.4	86.4	146.4	144	2.4	13.1	1
13.2	2	●	MZE1320SA	28.8	53.4	53.4	104.4	102	2.4	13.2	1
13.2	3	●	MZE1320MA	42.0	86.4	86.4	146.4	144	2.4	13.2	1
13.3	2	●	MZE1330SA	29.0	56.4	56.4	109.4	107	2.4	13.3	1
13.3	3	●	MZE1330MA	42.3	86.4	86.4	146.4	144	2.4	13.3	1
13.4	2	●	MZE1340SA	29.2	56.4	56.4	109.4	107	2.4	13.4	1
13.4	3	●	MZE1340MA	42.6	86.4	86.4	146.4	144	2.4	13.4	1
13.5	2	●	MZE1350SA	29.5	56.5	56.5	109.5	107	2.5	13.5	1
13.5	3	●	MZE1350MA	43.0	86.5	86.5	146.5	144	2.5	13.5	1
13.6	2	●	MZE1360SA	29.7	56.5	56.5	109.5	107	2.5	13.6	1
13.6	3	●	MZE1360MA	43.3	88.5	88.5	149.5	147	2.5	13.6	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
13.7	2	●	MZE1370SA	29.9	56.5	56.5	109.5	107	2.5	13.7	1
13.7	3	●	MZE1370MA	43.6	88.5	88.5	149.5	147	2.5	13.7	1
13.8	2	●	MZE1380SA	30.1	56.5	56.5	109.5	107	2.5	13.8	1
13.8	3	●	MZE1380MA	43.9	88.5	88.5	149.5	147	2.5	13.8	1
13.9	2	●	MZE1390SA	30.3	56.5	56.5	109.5	107	2.5	13.9	1
13.9	3	●	MZE1390MA	44.2	88.5	88.5	149.5	147	2.5	13.9	1
14.0	2	●	MZE1400SA	30.5	56.5	56.5	109.5	107	2.5	14.0	1
14.0	3	●	MZE1400MA	44.5	88.5	88.5	149.5	147	2.5	14.0	1
14.1	2	●	MZE1410SA	30.8	58.6	58.6	113.6	111	2.6	14.1	1
14.1	3	●	MZE1410MA	44.9	91.6	91.6	153.6	151	2.6	14.1	1
14.2	2	●	MZE1420SA	31.0	58.6	58.6	113.6	111	2.6	14.2	1
14.2	3	●	MZE1420MA	45.2	91.6	91.6	153.6	151	2.6	14.2	1
14.3	2	□	MZE1430SA	31.2	58.6	58.6	113.6	111	2.6	14.3	1
14.3	3	●	MZE1430MA	45.5	91.6	91.6	153.6	151	2.6	14.3	1
14.4	2	□	MZE1440SA	31.4	58.6	58.6	113.6	111	2.6	14.4	1
14.4	3	●	MZE1440MA	45.8	91.6	91.6	153.6	151	2.6	14.4	1
14.5	2	●	MZE1450SA	31.6	58.6	58.6	113.6	111	2.6	14.5	1
14.5	3	●	MZE1450MA	46.1	91.6	91.6	153.6	151	2.6	14.5	1
14.6	2	□	MZE1460SA	31.9	58.7	58.7	113.7	111	2.7	14.6	1
14.6	3	●	MZE1460MA	46.5	93.7	93.7	155.7	153	2.7	14.6	1
14.7	2	□	MZE1470SA	32.1	58.7	58.7	113.7	111	2.7	14.7	1
14.7	3	●	MZE1470MA	46.8	93.7	93.7	155.7	153	2.7	14.7	1
14.8	2	□	MZE1480SA	32.3	58.7	58.7	113.7	111	2.7	14.8	1
14.8	3	●	MZE1480MA	47.1	93.7	93.7	155.7	153	2.7	14.8	1
14.9	2	□	MZE1490SA	32.5	58.7	58.7	113.7	111	2.7	14.9	1
14.9	3	●	MZE1490MA	47.4	93.7	93.7	155.7	153	2.7	14.9	1
15.0	2	●	MZE1500SA	32.7	58.7	58.7	113.7	111	2.7	15.0	1
15.0	3	●	MZE1500MA	47.7	93.7	93.7	155.7	153	2.7	15.0	1
15.1	2	□	MZE1510SA	32.9	60.7	60.7	117.7	115	2.7	15.1	1
15.1	3	●	MZE1510MA	48.0	96.7	96.7	159.7	157	2.7	15.1	1
15.2	2	●	MZE1520SA	33.2	60.8	60.8	117.8	115	2.8	15.2	1
15.2	3	●	MZE1520MA	48.4	96.8	96.8	159.8	157	2.8	15.2	1
15.3	2	□	MZE1530SA	33.4	60.8	60.8	117.8	115	2.8	15.3	1
15.3	3	●	MZE1530MA	48.7	96.8	96.8	159.8	157	2.8	15.3	1
15.4	2	□	MZE1540SA	33.6	60.8	60.8	117.8	115	2.8	15.4	1
15.4	3	●	MZE1540MA	49.0	96.8	96.8	159.8	157	2.8	15.4	1
15.5	2	●	MZE1550SA	33.8	60.8	60.8	117.8	115	2.8	15.5	1
15.5	3	●	MZE1550MA	49.3	96.8	96.8	159.8	157	2.8	15.5	1
15.6	2	□	MZE1560SA	34.0	60.8	60.8	117.8	115	2.8	15.6	1
15.6	3	●	MZE1560MA	49.6	98.8	98.8	162.8	160	2.8	15.6	1
15.7	2	□	MZE1570SA	34.3	60.9	60.9	117.9	115	2.9	15.7	1
15.7	3	●	MZE1570MA	50.0	98.9	98.9	162.9	160	2.9	15.7	1
15.8	2	□	MZE1580SA	34.5	60.9	60.9	117.9	115	2.9	15.8	1
15.8	3	●	MZE1580MA	50.3	98.9	98.9	162.9	160	2.9	15.8	1
15.9	2	□	MZE1590SA	34.7	60.9	60.9	117.9	115	2.9	15.9	1
15.9	3	●	MZE1590MA	50.6	98.9	98.9	162.9	160	2.9	15.9	1
16.0	2	●	MZE1600SA	34.9	60.9	60.9	117.9	115	2.9	16.0	1
16.0	3	●	MZE1600MA	50.9	98.9	98.9	162.9	160	2.9	16.0	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
16.1	2	□	MZE1610SA	35.1	62.9	62.9	121.9	119	2.9	16.1	1
16.1	3	□	MZE1610MA	51.2	104.9	104.9	169.9	167	2.9	16.1	1
16.2	2	●	MZE1620SA	35.3	62.9	62.9	121.9	119	2.9	16.2	1
16.2	3	□	MZE1620MA	51.5	104.9	104.9	169.9	167	2.9	16.2	1
16.3	2	●	MZE1630SA	35.6	63.0	63.0	122.0	119	3.0	16.3	1
16.3	3	□	MZE1630MA	51.9	105.0	105.0	170.0	167	3.0	16.3	1
16.4	2	□	MZE1640SA	35.8	63.0	63.0	122.0	119	3.0	16.4	1
16.4	3	□	MZE1640MA	52.2	105.0	105.0	170.0	167	3.0	16.4	1
16.5	2	●	MZE1650SA	36.0	63.0	63.0	122.0	119	3.0	16.5	1
16.5	3	●	MZE1650MA	52.5	105.0	105.0	170.0	167	3.0	16.5	1
16.6	2	□	MZE1660SA	36.2	63.0	63.0	122.0	119	3.0	16.6	1
16.6	3	□	MZE1660MA	52.8	105.0	105.0	170.0	167	3.0	16.6	1
16.7	2	□	MZE1670SA	36.4	63.0	63.0	122.0	119	3.0	16.7	1
16.7	3	□	MZE1670MA	53.1	105.0	105.0	170.0	167	3.0	16.7	1
16.8	2	□	MZE1680SA	36.7	63.1	63.1	122.1	119	3.1	16.8	1
16.8	3	□	MZE1680MA	53.5	105.1	105.1	170.1	167	3.1	16.8	1
16.9	2	□	MZE1690SA	36.9	63.1	63.1	122.1	119	3.1	16.9	1
16.9	3	□	MZE1690MA	53.8	105.1	105.1	170.1	167	3.1	16.9	1
17.0	2	●	MZE1700SA	37.1	63.1	63.1	122.1	119	3.1	17.0	1
17.0	3	●	MZE1700MA	54.1	105.1	105.1	170.1	167	3.1	17.0	1
17.1	2	□	MZE1710SA	37.3	65.1	65.1	126.1	123	3.1	17.1	1
17.1	3	□	MZE1710MA	54.4	105.1	105.1	170.1	167	3.1	17.1	1
17.2	2	□	MZE1720SA	37.5	65.1	65.1	126.1	123	3.1	17.2	1
17.2	3	□	MZE1720MA	54.7	105.1	105.1	170.1	167	3.1	17.2	1
17.3	2	□	MZE1730SA	37.7	65.1	65.1	126.1	123	3.1	17.3	1
17.3	3	□	MZE1730MA	55.0	105.1	105.1	170.1	167	3.1	17.3	1
17.4	2	□	MZE1740SA	38.0	65.2	65.2	126.2	123	3.2	17.4	1
17.4	3	□	MZE1740MA	55.4	105.2	105.2	170.2	167	3.2	17.4	1
17.5	2	●	MZE1750SA	38.2	65.2	65.2	126.2	123	3.2	17.5	1
17.5	3	●	MZE1750MA	55.7	105.2	105.2	170.2	167	3.2	17.5	1
17.6	2	□	MZE1760SA	38.4	65.2	65.2	126.2	123	3.2	17.6	1
17.6	3	□	MZE1760MA	56.0	105.2	105.2	170.2	167	3.2	17.6	1
17.7	2	□	MZE1770SA	38.6	65.2	65.2	126.2	123	3.2	17.7	1
17.7	3	□	MZE1770MA	56.3	105.2	105.2	170.2	167	3.2	17.7	1
17.8	2	●	MZE1780SA	38.8	65.2	65.2	126.2	123	3.2	17.8	1
17.8	3	□	MZE1780MA	56.6	105.2	105.2	170.2	167	3.2	17.8	1
17.9	2	□	MZE1790SA	39.1	65.3	65.3	126.3	123	3.3	17.9	1
17.9	3	□	MZE1790MA	57.0	105.3	105.3	170.3	167	3.3	17.9	1
18.0	2	●	MZE1800SA	39.3	65.3	65.3	126.3	123	3.3	18.0	1
18.0	3	●	MZE1800MA	57.3	105.3	105.3	170.3	167	3.3	18.0	1
18.1	2	□	MZE1810SA	39.5	67.3	67.3	130.3	127	3.3	18.1	1
18.1	3	□	MZE1810MA	57.6	117.3	117.3	182.3	179	3.3	18.1	1
18.2	2	□	MZE1820SA	39.7	67.3	67.3	130.3	127	3.3	18.2	1
18.2	3	□	MZE1820MA	57.9	117.3	117.3	182.3	179	3.3	18.2	1
18.3	2	□	MZE1830SA	39.9	67.3	67.3	130.3	127	3.3	18.3	1
18.3	3	□	MZE1830MA	58.2	117.3	117.3	182.3	179	3.3	18.3	1
18.4	2	□	MZE1840SA	40.1	67.3	67.3	130.3	127	3.3	18.4	1
18.4	3	□	MZE1840MA	58.5	117.3	117.3	182.3	179	3.3	18.4	1

CUTTING CONDITIONS ➤ P127
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TECHNICAL DATA ➤ R001

MZE

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
18.5	2	●	MZE1850SA	40.4	67.4	67.4	130.4	127	3.4	18.5	1
18.5	3	●	MZE1850MA	58.9	117.4	117.4	182.4	179	3.4	18.5	1
18.6	2	□	MZE1860SA	40.6	67.4	67.4	130.4	127	3.4	18.6	1
18.6	3	□	MZE1860MA	59.2	117.4	117.4	182.4	179	3.4	18.6	1
18.7	2	□	MZE1870SA	40.8	67.4	67.4	130.4	127	3.4	18.7	1
18.7	3	□	MZE1870MA	59.5	117.4	117.4	182.4	179	3.4	18.7	1
18.8	2	□	MZE1880SA	41.0	67.4	67.4	130.4	127	3.4	18.8	1
18.8	3	□	MZE1880MA	59.8	117.4	117.4	182.4	179	3.4	18.8	1
18.9	2	□	MZE1890SA	41.2	67.4	67.4	130.4	127	3.4	18.9	1
18.9	3	□	MZE1890MA	60.1	117.4	117.4	182.4	179	3.4	18.9	1
19.0	2	●	MZE1900SA	41.5	67.5	67.5	130.5	127	3.5	19.0	1
19.0	3	●	MZE1900MA	60.5	117.5	117.5	182.5	179	3.5	19.0	1
19.1	2	□	MZE1910SA	41.7	69.5	69.5	134.5	131	3.5	19.1	1
19.1	3	□	MZE1910MA	60.8	117.5	117.5	182.5	179	3.5	19.1	1
19.2	2	□	MZE1920SA	41.9	69.5	69.5	134.5	131	3.5	19.2	1
19.2	3	□	MZE1920MA	61.1	117.5	117.5	182.5	179	3.5	19.2	1

DC (mm)	Hole Depth (L/D)	VP15TF	Order Number	Dimensions (mm) LU	LCF	LH	OAL	LF	PL	DCON	Type
19.3	2	□	MZE1930SA	42.1	69.5	69.5	134.5	131	3.5	19.3	1
19.3	3	□	MZE1930MA	61.4	117.5	117.5	182.5	179	3.5	19.3	1
19.4	2	□	MZE1940SA	42.3	69.5	69.5	134.5	131	3.5	19.4	1
19.4	3	□	MZE1940MA	61.7	117.5	117.5	182.5	179	3.5	19.4	1
19.5	2	●	MZE1950SA	42.5	69.5	69.5	134.5	131	3.5	19.5	1
19.5	3	●	MZE1950MA	62.0	117.5	117.5	182.5	179	3.5	19.5	1
19.6	2	□	MZE1960SA	42.8	69.6	69.6	134.6	131	3.6	19.6	1
19.6	3	□	MZE1960MA	62.4	117.6	117.6	182.6	179	3.6	19.6	1
19.7	2	□	MZE1970SA	43.0	69.6	69.6	134.6	131	3.6	19.7	1
19.7	3	□	MZE1970MA	62.7	117.6	117.6	182.6	179	3.6	19.7	1
19.8	2	□	MZE1980SA	43.2	69.6	69.6	134.6	131	3.6	19.8	1
19.8	3	□	MZE1980MA	63.0	117.6	117.6	182.6	179	3.6	19.8	1
19.9	2	□	MZE1990SA	43.4	69.6	69.6	134.6	131	3.6	19.9	1
19.9	3	□	MZE1990MA	63.3	117.6	117.6	182.6	179	3.6	19.9	1
20.0	2	●	MZE2000SA	43.6	69.6	69.6	134.6	131	3.6	20.0	1
20.0	3	●	MZE2000MA	63.6	117.6	117.6	182.6	179	3.6	20.0	1

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

OPERATION GUIDANCE ➢ P129

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB) AISI 1010 etc			Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc			Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
1.0	12700	0.035	(0.020−0.050)	11100	0.035	(0.020−0.050)	9500	0.035	(0.020−0.050)
1.2	10600	0.045	(0.030−0.060)	9200	0.045	(0.030−0.060)	7900	0.045	(0.030−0.060)
1.6	8900	0.055	(0.035−0.080)	7900	0.055	(0.035−0.080)	6900	0.055	(0.035−0.080)
2.0	7100	0.07	(0.040−0.100)	6300	0.07	(0.040−0.100)	5500	0.07	(0.040−0.100)
2.5	5700	0.085	(0.050−0.125)	5000	0.085	(0.050−0.125)	4400	0.085	(0.050−0.125)
3.2	4400	0.1	(0.060−0.13)	3900	0.1	(0.06−0.13)	3400	0.09	(0.06−0.12)
4.0	3500	0.12	(0.080−0.16)	3100	0.12	(0.08−0.16)	2700	0.11	(0.07−0.14)
5.0	2800	0.15	(0.100−0.20)	2500	0.15	(0.10−0.20)	2200	0.14	(0.09−0.18)
6.3	2700	0.2	(0.13−0.26)	2500	0.2	(0.13−0.26)	2200	0.18	(0.11−0.24)
8.0	2100	0.23	(0.18−0.28)	1900	0.23	(0.18−0.28)	1700	0.21	(0.16−0.25)
10.0	1700	0.27	(0.22−0.32)	1500	0.27	(0.22−0.32)	1400	0.23	(0.19−0.27)
12.0	1700	0.31	(0.28−0.34)	1500	0.31	(0.28−0.34)	1400	0.26	(0.23−0.29)
16.0	1300	0.33	(0.28−0.38)	1200	0.33	(0.28−0.38)	1100	0.29	(0.24−0.33)
20.0	1100	0.35	(0.30−0.40)	1000	0.35	(0.30−0.40)	900	0.3	(0.26−0.34)

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc			Gray Cast Iron (≤350MPa) No 45 B etc			Ductile Cast Iron (≤450MPa) 60-40-8 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
1.0	4700	0.03	(0.020−0.044)	14300	0.035	(0.020−0.050)	12700	0.035	(0.020−0.050)
1.2	3900	0.04	(0.030−0.053)	11900	0.045	(0.030−0.060)	10600	0.045	(0.030−0.060)
1.6	3900	0.05	(0.035−0.070)	9900	0.055	(0.035−0.080)	8900	0.055	(0.035−0.080)
2.0	3100	0.06	(0.040−0.080)	7900	0.07	(0.040−0.100)	7100	0.07	(0.040−0.100)
2.5	2500	0.075	(0.050−0.100)	6300	0.085	(0.050−0.125)	5700	0.085	(0.050−0.125)
3.2	1900	0.07	(0.05−0.08)	4900	0.1	(0.06−0.13)	4400	0.1	(0.06−0.13)
4.0	1500	0.08	(0.06−0.10)	3900	0.12	(0.08−0.16)	3500	0.12	(0.08−0.16)
5.0	1200	0.1	(0.07−0.13)	3100	0.15	(0.10−0.20)	2800	0.15	(0.10−0.20)
6.3	1200	0.13	(0.09−0.17)	3000	0.2	(0.13−0.26)	2700	0.2	(0.13−0.26)
8.0	900	0.14	(0.10−0.18)	2300	0.25	(0.18−0.31)	2100	0.23	(0.18−0.28)
10.0	700	0.16	(0.12−0.19)	1900	0.29	(0.22−0.35)	1700	0.27	(0.22−0.32)
12.0	600	0.18	(0.15−0.20)	1800	0.33	(0.28−0.37)	1700	0.31	(0.28−0.34)
16.0	400	0.19	(0.15−0.23)	1300	0.35	(0.28−0.42)	1300	0.33	(0.28−0.38)
20.0	300	0.2	(0.15−0.24)	1100	0.37	(0.30−0.44)	1100	0.35	(0.30−0.40)

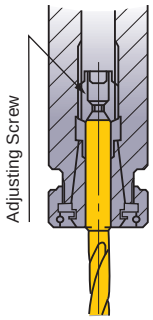
MZE

RECOMMENDED CUTTING CONDITIONS

Work Material	Aluminium Alloy (Si<5%)			Heat Resistant Alloy Inconel718 etc			Hardened Steel (40−55HRC) AISI H13, L6 etc		
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)		Revolution (min^{-1})	Feed rate (Min.−Max.) (mm/rev)	
1.0	15900	0.05	(0.030−0.075)	3100	0.02	(0.016−0.027)	3100	0.02	(0.016−0.031)
1.2	13200	0.065	(0.045−0.090)	2600	0.025	(0.022−0.032)	2600	0.03	(0.022−0.037)
1.6	11900	0.085	(0.053−0.120)	1900	0.03	(0.025−0.040)	1900	0.03	(0.025−0.040)
2.0	9500	0.105	(0.060−0.150)	2300	0.04	(0.032−0.050)	2300	0.04	(0.032−0.050)
2.5	8900	0.135	(0.075−0.200)	1900	0.05	(0.040−0.060)	1900	0.05	(0.040−0.060)
3.2	7900	0.1	(0.06−0.13)	1900	0.07	(0.05−0.09)	1900	0.07	(0.05−0.09)
4.0	6300	0.12	(0.08−0.16)	1500	0.09	(0.06−0.11)	1500	0.09	(0.06−0.11)
5.0	5000	0.15	(0.10−0.20)	1200	0.11	(0.08−0.14)	1200	0.11	(0.08−0.14)
6.3	4500	0.2	(0.13−0.26)	1200	0.14	(0.09−0.19)	1200	0.14	(0.09−0.19)
8.0	3500	0.23	(0.18−0.28)	900	0.14	(0.11−0.17)	900	0.14	(0.11−0.17)
10.0	2800	0.27	(0.22−0.32)	700	0.16	(0.12−0.19)	700	0.16	(0.12−0.19)
12.0	2600	0.31	(0.28−0.34)	600	0.16	(0.13−0.18)	600	0.16	(0.13−0.18)
16.0	2100	0.33	(0.28−0.38)	400	0.18	(0.14−0.21)	500	0.18	(0.14−0.21)
20.0	1700	0.35	(0.30−0.40)	400	0.19	(0.15−0.22)	400	0.19	(0.15−0.22)

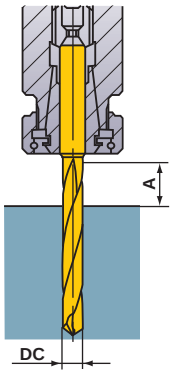
OPERATIONAL GUIDANCE

Drill Holding



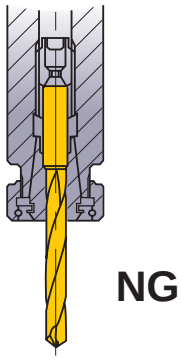
Thrust bearing type collet chuck holds the drill securely.

Drill Length



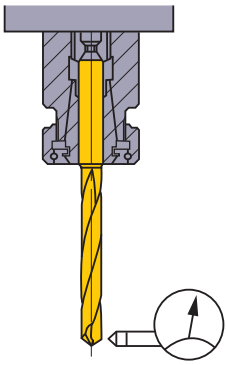
A ≥ DC x 1.5

Drill Installation



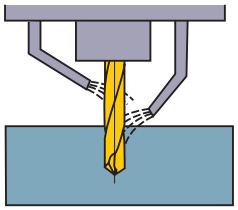
Do not clamp on the flutes.

Installation Tolerance



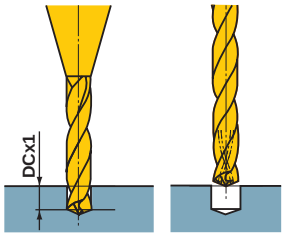
Run-out ≤ 0.03mm

Coolant Method (MZE)



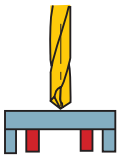
Two coolant positions, at the end and at the center are ideal.

Drill Installation



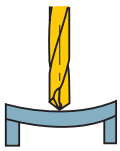
①When machining a prepared hole with the MZE-SA please set the depth to DCx1 (DC=drill diameter).
②Use the prepared hole as a guide when using a drill with an oil hole. Depending on the cutting conditions, peck feed is recommended.

Thin Workpiece



Support the Workpiece

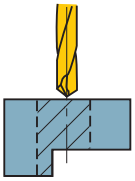
OK



If Bending Occurs

NG

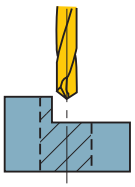
Interrupted Cutting



One Process

OK

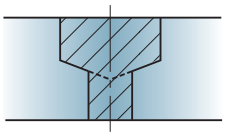
①Lower the feed when drilling the interrupted part.



Requires Prior Machining

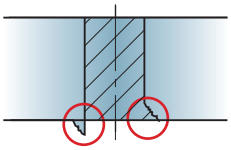
①Spot face with an end mill prior to drilling.

Stepped Holes



①Divide the two processes.
②Drill the larger hole first.
⋆A tool for machining both chamfer and spot face can be produced to order.

Burring and Workpiece Chipping



①Lower the feed rate by 50% at the end of through cutting.
②Add a 45°chamfer.
③Change the point angle.

MGS

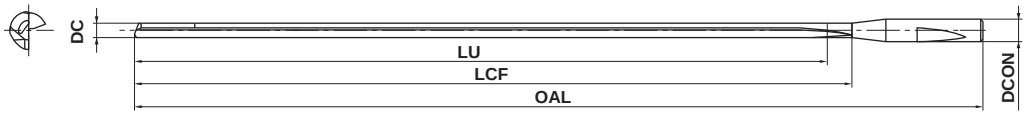
SOLID GUN DRILL

- Micro deep hole drilling is possible.
- Excellent run-out accuracy ensures high precision drilling.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		

Internal Coolant



DC≤3
0 −0.005

Note 1) MGS drills are suitable for use with shrink fit holders.

DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	DCON
0.7	50	●	**MGS0070L040B**	35.0	40	80	3
0.7	80	●	**MGS0070L060B**	56.0	60	100	3
0.8	45	●	**MGS0080L040B**	36.0	40	80	3
0.8	70	●	**MGS0080L060B**	56.0	60	100	3
0.9	40	●	**MGS0090L040B**	36.0	40	80	3
0.9	60	●	**MGS0090L060B**	54.0	60	100	3
1.0	35	●	**MGS0100L040B**	35.0	40	80	3
1.0	55	●	**MGS0100L060B**	55.0	60	100	3
1.0	75	●	**MGS0100L080B**	75.0	80	120	3
1.1	30	●	**MGS0110L040B**	33.0	40	80	3
1.1	50	●	**MGS0110L060B**	55.0	60	100	3
1.1	65	●	**MGS0110L080B**	71.5	80	120	3
1.2	30	●	**MGS0120L040B**	36.0	40	80	3
1.2	45	●	**MGS0120L060B**	54.0	60	100	3
1.2	60	●	**MGS0120L080B**	72.0	80	120	3
1.3	40	●	**MGS0130L060B**	52.0	60	100	3
1.3	55	●	**MGS0130L080B**	71.5	80	120	3
1.3	70	●	**MGS0130L100B**	91.0	100	140	3
1.4	35	●	**MGS0140L060B**	49.0	60	100	3
1.4	50	●	**MGS0140L080B**	70.0	80	120	3
1.4	65	●	**MGS0140L100B**	91.0	100	140	3
1.5	35	●	**MGS0150L060B**	52.5	60	100	3
1.5	50	●	**MGS0150L080B**	75.0	80	120	3
1.5	60	●	**MGS0150L100B**	90.0	100	140	3
1.6	30	●	**MGS0160L060B**	48.0	60	100	3
1.6	45	●	**MGS0160L080B**	72.0	80	120	3
1.6	55	●	**MGS0160L100B**	88.0	100	140	3
1.7	30	●	**MGS0170L060B**	51.0	60	100	3
1.7	40	●	**MGS0170L080B**	68.0	80	120	3
1.7	55	●	**MGS0170L100B**	93.5	100	140	3

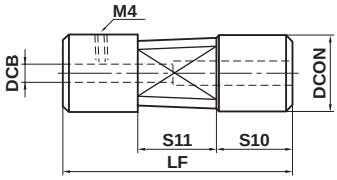
DC (mm)	Hole Depth (L/D)	HTi10	Order Number	Dimensions (mm) LU	LCF	OAL	DCON
1.8	30	●	**MGS0180L060B**	54.0	60	100	3
1.8	40	●	**MGS0180L080B**	72.0	80	120	3
1.8	50	●	**MGS0180L100B**	90.0	100	140	3
1.9	25	●	**MGS0190L060B**	47.5	60	100	3
1.9	35	●	**MGS0190L080B**	66.5	80	120	3
1.9	45	●	**MGS0190L100B**	85.5	100	140	3
2.0	25	●	**MGS0200L060B**	50.0	60	100	3
2.0	35	●	**MGS0200L080B**	70.0	80	120	3
2.0	45	●	**MGS0200L100B**	90.0	100	140	3
2.1	35	●	**MGS0210L080B**	73.5	80	120	3
2.1	40	●	**MGS0210L100B**	84.0	100	140	3
2.2	30	●	**MGS0220L080B**	66.0	80	120	3
2.2	40	●	**MGS0220L100B**	88.0	100	140	3
2.3	30	●	**MGS0230L080B**	69.0	80	120	3
2.3	40	●	**MGS0230L100B**	92.0	100	140	3
2.4	30	●	**MGS0240L080B**	72.0	80	120	3
2.4	35	●	**MGS0240L100B**	84.0	100	140	3
2.5	25	●	**MGS0250L080B**	62.5	80	120	3
2.5	35	●	**MGS0250L100B**	87.5	100	140	3
2.6	25	●	**MGS0260L080B**	65.0	80	120	3
2.6	35	●	**MGS0260L100B**	91.0	100	140	3
2.7	25	●	**MGS0270L080B**	67.5	80	120	3
2.7	30	●	**MGS0270L100B**	81.0	100	140	3
2.8	25	●	**MGS0280L080B**	70.0	80	120	3
2.8	30	●	**MGS0280L100B**	84.0	100	140	3
2.9	20	●	**MGS0290L080B**	58.0	80	120	3
2.9	30	●	**MGS0290L100B**	87.0	100	140	3
3.0	20	●	**MGS0300L080B**	60.0	80	120	3
3.0	30	●	**MGS0300L100B**	90.0	100	140	3

Note 1) Please consult us regarding coated type drills (**VP**, **GP** and **UP** coated carbide).

● : Inventory maintained in Japan.

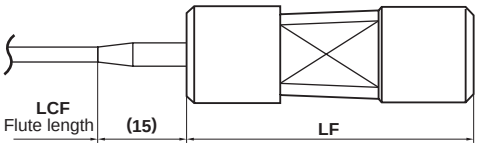
CUTTING CONDITIONS ➤ P132

■DRIVER



Order Number	Stock	Dimensions (mm)						
		DCON	DCB	LF	S10	S11	Set Screw	Wrench
MGD38	●	12.7	3.0	38.1	12.6	12.7	HSS04004	HKY20F
MGD70	●	12.7	3.0	70.0	25.0	20.0	HSS04004	HKY20F

■ WHEN CONNECTED WITH A DRIVER



MGS

SOLID GUN DRILL

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB) AISI 1010 etc				Carbon Steel, Alloy Steel (180−280HB) AISI 1045, AISI 4140 etc			
Recommended grinding fluid	Water insoluble				Water insoluble			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
0.8	50	19800	0.01 (0.005−0.016)	195	40	15900	0.01 (0.005−0.016)	155
1.0	50	15900	0.01 (0.007−0.020)	155	40	12700	0.01 (0.007−0.020)	125
1.2	60	15900	0.015 (0.008−0.024)	235	50	13200	0.015 (0.008−0.024)	195
1.6	60	11900	0.02 (0.011−0.032)	235	50	9900	0.02 (0.011−0.032)	195
2.0	60	9500	0.025 (0.013−0.040)	235	50	7900	0.025 (0.013−0.040)	195
2.5	70	8900	0.03 (0.017−0.050)	265	60	7600	0.03 (0.017−0.050)	225
3.0	70	7400	0.04 (0.020−0.060)	295	60	6300	0.04 (0.020−0.060)	250

Work Material	Carbon Steel, Alloy Steel (280−350HB) AISI 4340 etc				Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc			
Recommended grinding fluid	Water insoluble				Water insoluble			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
0.8	30	11900	0.005 (0.004−0.005)	55	30	11900	0.01 (0.005−0.016)	115
1.0	30	9500	0.005 (0.005−0.007)	45	30	9500	0.01 (0.007−0.020)	95
1.2	40	10600	0.005 (0.006−0.008)	50	30	7900	0.015 (0.008−0.024)	115
1.6	40	7900	0.01 (0.008−0.011)	75	40	7900	0.02 (0.011−0.032)	155
2.0	40	6300	0.01 (0.010−0.013)	60	40	6300	0.025 (0.013−0.040)	155
2.5	50	6300	0.015 (0.013−0.017)	90	40	5000	0.03 (0.017−0.050)	150
3.0	50	5300	0.015 (0.015−0.020)	75	40	4200	0.04 (0.020−0.060)	165

Work Material	Gray Cast Iron (≤350MPa) No 45 B etc				Ductile Cast Iron (≤450MPa) 60-40-8 etc			
Recommended grinding fluid	Water insoluble Water soluble				Water insoluble Water soluble			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
0.8	50	19800	0.01 (0.008−0.016)	195	40	15900	0.005 (0.005−0.008)	75
1.0	50	15900	0.015 (0.010−0.020)	235	40	12700	0.005 (0.007−0.010)	60
1.2	60	15900	0.015 (0.012−0.024)	235	50	13200	0.01 (0.008−0.012)	130
1.6	60	11900	0.02 (0.016−0.032)	235	50	9900	0.01 (0.011−0.016)	95
2.0	60	9500	0.03 (0.020−0.040)	285	50	7900	0.015 (0.013−0.020)	115
2.5	70	8900	0.035 (0.025−0.050)	310	60	7600	0.02 (0.017−0.025)	150
3.0	70	7400	0.045 (0.030−0.060)	330	60	6300	0.025 (0.020−0.030)	155

Work Material	Aluminium Alloy (Si<5%)				Copper, Copper alloy			
Recommended grinding fluid	Water insoluble Water soluble				Water insoluble Water soluble			
Dia. **DC** (mm)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min^{-1})	Feed rate (Min.–Max.) (mm/rev)	Table Feed (mm/min)
0.8	50	19800	0.01 (0.008−0.016)	195	40	15900	0.01 (0.008−0.016)	155
1.0	60	19000	0.015 (0.010−0.020)	285	50	15900	0.015 (0.010−0.020)	235
1.2	70	18500	0.015 (0.012−0.024)	275	60	15900	0.015 (0.012−0.024)	235
1.6	80	15900	0.02 (0.016−0.032)	315	70	13900	0.02 (0.016−0.032)	275
2.0	90	14300	0.03 (0.020−0.040)	425	80	12700	0.03 (0.020−0.040)	380
2.5	100	12700	0.035 (0.025−0.050)	440	90	11400	0.035 (0.025−0.050)	395
3.0	100	10600	0.045 (0.030−0.060)	475	100	10600	0.045 (0.030−0.060)	475

Note 1) For safety and success, high pressure coolant is required. (Minimum coolant pressure=1,000PSI)

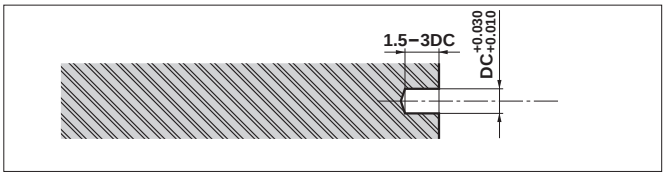
Note 2) Coolant filter must be less than 5 microns. Fine filtration is necessary to prevent blockage of the coolant holes.

Note 3) A pilot hole or guide bushing is required.

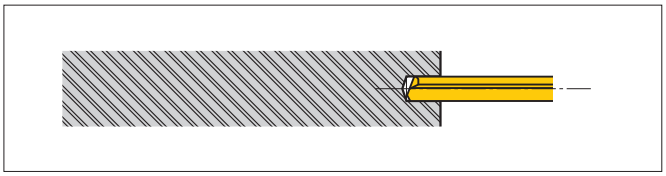
SPECIAL APPLICATION NOTES

- For safety and success, high pressure coolant is required.
  (Minimum coolant pressure=1,000PSI)
- Coolant filter must be less than 5 microns.
  Fine filtration is necessary to prevent blockage of the coolant holes.
- A pilot hole or guide bushing is required.

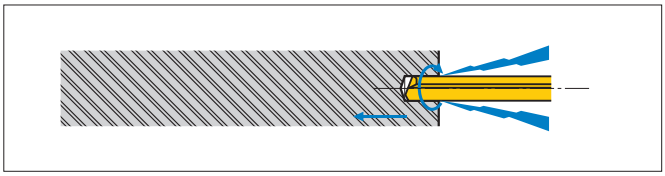
HOW TO USE



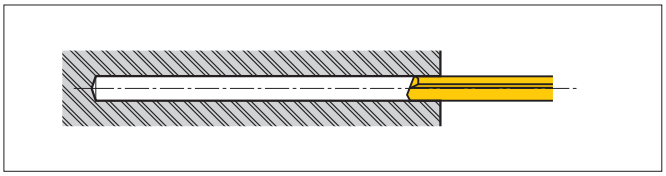
1. Pilot hole drilling.
   - The pilot hole diameter is .01-.03mm of MGS drill diameter.
   - Hole depth 1.5 to 3 times of pilot hole diameter is required.
   - Mitsubishi's MVE / MVS is recommended.



2. Drill is inserted into the pilot hole with the MSG drill rotation stopped or rotating CCW at 300rpm or less.
   - UP to 1-2mm before hole bottom.



3. Coolant is turned ON, raise cutting speed and feed to the recommended cutting condition.
   - It is extremely dangerous to start drill rotation before inserting the pilot hole, it may cause tool breakage.



4. After drilling
   - Return to "Pos 2"
   - Coolant turned OFF and drill rotation is stopped.

VCSSS

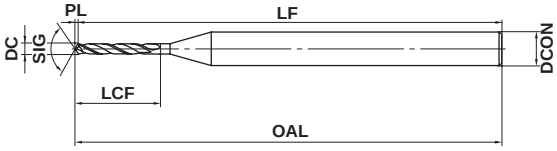
Short, For steel (3mm shank series)

UWC VC 130° 120° X

DC≤0.6 DC≥0.7

P Steel | M | K | N | S | H Hardened Steel

External Coolant



DC≤2.4
0 / −0.014

DCON=3
0 / −0.010

●First recommendation for pilot hole drilling of hardened material.

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
0.3	**VCSSSD0030**	3.1	38.1	38	0.07	3	▲
0.4	**VCSSSD0040**	4.1	38.1	38	0.09	3	▲
0.5	**VCSSSD0050**	4.1	38.1	38	0.12	3	▲
0.6	**VCSSSD0060**	5.1	38.1	38	0.14	3	▲
0.7	**VCSSSD0070**	5.2	38.2	38	0.20	3	▲
0.8	**VCSSSD0080**	6.2	38.2	38	0.23	3	▲
0.9	**VCSSSD0090**	6.3	38.3	38	0.26	3	▲
1.0	**VCSSSD0100**	8.3	38.3	38	0.3	3	▲
1.1	**VCSSSD0110**	8.3	38.3	38	0.3	3	▲
1.2	**VCSSSD0120**	8.4	38.4	38	0.4	3	▲
1.3	**VCSSSD0130**	8.4	38.4	38	0.4	3	▲

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
1.4	**VCSSSD0140**	8.4	38.4	38	0.4	3	▲
1.5	**VCSSSD0150**	10.4	45.4	45	0.4	3	▲
1.6	**VCSSSD0160**	10.5	45.5	45	0.5	3	▲
1.7	**VCSSSD0170**	10.5	45.5	45	0.5	3	▲
1.8	**VCSSSD0180**	10.5	45.5	45	0.5	3	▲
1.9	**VCSSSD0190**	10.6	45.6	45	0.6	3	▲
2.0	**VCSSSD0200**	12.6	45.6	45	0.6	3	▲
2.1	**VCSSSD0210**	12.6	45.6	45	0.6	3	▲
2.2	**VCSSSD0220**	12.6	45.6	45	0.6	3	▲
2.3	**VCSSSD0230**	12.7	45.7	45	0.7	3	▲
2.4	**VCSSSD0240**	12.7	45.7	45	0.7	3	▲

RECOMMENDED CUTTING CONDITIONS

Work Material	Heat-treated Steel AISI H13, AISI 4140 etc. (40–50HRC)			Hardened Steel AISI H13, AISI 420 etc. (50–55HRC)			Hardened Steel AISI D2, Powder High-speed Steel etc. (55–60HRC)		
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Step feed (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Step feed (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Step feed (mm)
0.3	21000	0.005	0.03	16000	0.005	0.03	11000	0.005	0.03
0.5	13000	0.005	0.05	9600	0.005	0.05	6400	0.005	0.05
0.8	8000	0.008	0.08	6000	0.008	0.08	4000	0.008	0.08
1.0	6400	0.01	0.10	4800	0.01	0.10	3200	0.01	0.10
1.2	5300	0.01	0.15	4000	0.01	0.15	2700	0.01	0.10
1.5	4200	0.02	0.20	3200	0.01	0.20	2100	0.01	0.20
1.8	3500	0.03	0.25	2700	0.01	0.25	1800	0.01	0.20
2.0	3200	0.04	0.30	2400	0.02	0.30	1600	0.02	0.30
2.2	2900	0.04	0.40	2200	0.02	0.40	1400	0.02	0.30
2.4	2700	0.05	0.50	2000	0.02	0.50	1300	0.02	0.30

Note 1) Please use a machine with a high accuracy spindle.
Note 2) A collet chuck is recommended to maintain shank condition.
Note 3) Use emulsion as a cutting fluid.

▲ : Product scheduled to be discontinued at the end of March 2020.

VCHSM

Medium, For hardened material

UWC VC 130° 140° X

DC<6 DC≥6

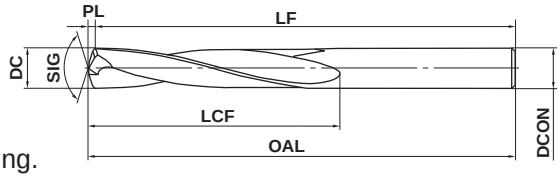
P M K N S **H**

Hardened Steel

DC≦3	3<DC≦6	6<DC≦10	10<DC≦16
0 −0.014	0 −0.018	0 −0.022	0 −0.027
DCON≦3	**3<DCON≦6**	**6<DCON≦10**	**10<DCON≦16**
0 −0.010	0 −0.012	0 −0.015	0 −0.018

h7

External Coolant



●A suitable geometry for high hardness (60 HRC) material drilling.

DC	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
2.5	**VCHSMD0250**	20.6	55.6	55	0.6	2.5	▲
2.6	**VCHSMD0260**	20.6	55.6	55	0.6	2.6	▲
2.7	**VCHSMD0270**	20.6	55.6	55	0.6	2.7	▲
2.8	**VCHSMD0280**	21.7	60.7	60	0.7	2.8	▲
2.9	**VCHSMD0290**	21.7	60.7	60	0.7	2.9	▲
3.0	**VCHSMD0300**	21.7	60.7	60	0.7	3.0	▲
3.1	**VCHSMD0310**	24.7	60.7	60	0.7	3.1	▲
3.2	**VCHSMD0320**	24.7	60.7	60	0.7	3.2	▲
3.3	**VCHSMD0330**	24.8	60.8	60	0.8	3.3	▲
3.4	**VCHSMD0340**	24.8	60.8	60	0.8	3.4	▲
3.5	**VCHSMD0350**	24.8	60.8	60	0.8	3.5	▲
3.6	**VCHSMD0360**	27.8	60.8	60	0.8	3.6	▲
3.7	**VCHSMD0370**	27.9	60.9	60	0.9	3.7	▲
3.8	**VCHSMD0380**	27.9	60.9	60	0.9	3.8	▲
3.9	**VCHSMD0390**	27.9	60.9	60	0.9	3.9	▲
4.0	**VCHSMD0400**	27.9	60.9	60	0.9	4.0	▲
4.1	**VCHSMD0410**	30.0	64.0	63	1.0	4.1	▲
4.2	**VCHSMD0420**	30.0	64.0	63	1.0	4.2	▲
4.3	**VCHSMD0430**	30.0	64.0	63	1.0	4.3	▲
4.4	**VCHSMD0440**	30.0	64.0	63	1.0	4.4	▲
4.5	**VCHSMD0450**	30.0	64.0	63	1.0	4.5	▲
4.6	**VCHSMD0460**	33.1	69.1	68	1.1	4.6	▲
4.7	**VCHSMD0470**	33.1	69.1	68	1.1	4.7	▲
4.8	**VCHSMD0480**	33.1	69.1	68	1.1	4.8	▲
4.9	**VCHSMD0490**	33.1	69.1	68	1.1	4.9	▲
5.0	**VCHSMD0500**	33.2	69.2	68	1.2	5.0	▲
5.1	**VCHSMD0510**	35.2	73.2	72	1.2	5.1	▲
5.2	**VCHSMD0520**	35.2	73.2	72	1.2	5.2	▲
5.3	**VCHSMD0530**	35.2	73.2	72	1.2	5.3	▲
5.4	**VCHSMD0540**	35.3	73.3	72	1.3	5.4	▲
5.5	**VCHSMD0550**	35.3	73.3	72	1.3	5.5	▲
5.6	**VCHSMD0560**	37.3	75.3	74	1.3	5.6	▲
5.7	**VCHSMD0570**	37.3	75.3	74	1.3	5.7	▲
5.8	**VCHSMD0580**	37.4	75.4	74	1.4	5.8	▲
5.9	**VCHSMD0590**	37.4	75.4	74	1.4	5.9	▲
6.0	**VCHSMD0600**	42.2	82.2	81	1.2	6.0	▲
6.5	**VCHSMD0650**	42.3	82.3	81	1.3	6.5	▲
6.9	**VCHSMD0690**	44.4	84.4	83	1.4	6.9	▲
7.0	**VCHSMD0700**	44.4	84.4	83	1.4	7.0	▲
7.5	**VCHSMD0750**	46.5	88.5	87	1.5	7.5	▲

DC	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
8.0	**VCHSMD0800**	49.6	91.6	90	1.6	8.0	▲
8.5	**VCHSMD0850**	54.7	97.7	96	1.7	8.5	▲
8.6	**VCHSMD0860**	56.7	99.7	98	1.7	8.6	▲
9.0	**VCHSMD0900**	56.8	99.8	98	1.8	9.0	▲
9.5	**VCHSMD0950**	59.9	103.9	102	1.9	9.5	▲
10.0	**VCHSMD1000**	62.0	107.0	105	2.0	10.0	▲
10.4	**VCHSMD1040**	68.1	114.1	112	2.1	10.4	▲
10.5	**VCHSMD1050**	68.1	114.1	112	2.1	10.5	▲
11.0	**VCHSMD1100**	70.2	116.2	114	2.2	11.0	▲
11.5	**VCHSMD1150**	73.3	120.3	118	2.3	11.5	▲
12.0	**VCHSMD1200**	75.4	123.4	121	2.4	12.0	▲
12.5	**VCHSMD1250**	78.5	137.5	135	2.5	12.5	▲
13.0	**VCHSMD1300**	80.6	139.6	137	2.6	13.0	▲
13.5	**VCHSMD1350**	86.7	146.7	144	2.7	13.5	▲
14.0	**VCHSMD1400**	88.8	149.8	147	2.8	14.0	▲
14.5	**VCHSMD1450**	91.9	153.9	151	2.9	14.5	▲
15.0	**VCHSMD1500**	94.0	156.0	153	3.0	15.0	▲
15.5	**VCHSMD1550**	97.2	160.2	157	3.2	15.5	▲
16.0	**VCHSMD1600**	99.3	163.3	160	3.3	16.0	▲

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened Steel AISI H13, AISI 420 etc. (50—55HRC)		Hardened Steel AISI D2, Powder High-speed Steel etc. (55—60HRC)	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
2.5	1900	0.06	1300	0.04
3.0	1600	0.06	1100	0.04
4.0	1200	0.06	800	0.04
5.0	1000	0.06	600	0.04
6.0	800	0.06	530	0.04
8.0	600	0.07	400	0.05
10.0	480	0.07	320	0.05
12.0	400	0.07	270	0.05
14.0	340	0.07	230	0.05
16.0	300	0.07	200	0.05

Note 1) Use rigid machines.
Note 2) Collet chuck is recommended to maintain shank condition.
Note 3) Use emulsion as cutting fluid.
Note 4) Recommended depth of drilling is DC×3 under these cutting conditions.

DCSSS

Short, For non-ferrous material

TOOL NEWS

DC<1.5 DC≥1.5 DC≥1.5

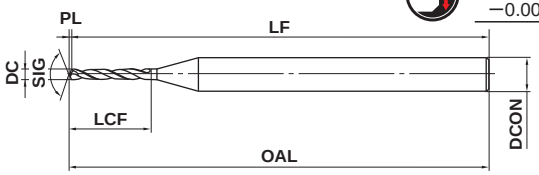
P M K **N** S H

Non-ferrous Metal

0.2≤DC≤2 $^{0}_{-0.014}$

DCON=3 $^{0}_{-0.006}$

External Coolant



● The original CVD diamond coating technology provides excellent adhesion for coating layer and enables stable drilling without peeling or chipping.

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
0.2	DCSSSD0020	2.1	38.1	38	0.05	3	●
0.3	DCSSSD0030	3.1	38.1	38	0.07	3	●
0.4	DCSSSD0040	4.1	38.1	38	0.09	3	●
0.5	DCSSSD0050	4.1	38.1	38	0.12	3	●
0.6	DCSSSD0060	5.1	38.1	38	0.14	3	●
0.7	DCSSSD0070	5.2	38.2	38	0.16	3	●
0.8	DCSSSD0080	6.2	38.2	38	0.19	3	●
0.9	DCSSSD0090	6.2	38.2	38	0.21	3	●
1.0	DCSSSD0100	8.2	38.2	38	0.2	3	●
1.1	DCSSSD0110	8.3	38.3	38	0.3	3	●

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
1.2	DCSSSD0120	8.3	38.3	38	0.3	3	●
1.3	DCSSSD0130	8.3	38.3	38	0.3	3	●
1.4	DCSSSD0140	8.3	38.3	38	0.3	3	●
1.5	DCSSSD0150	10.3	45.3	45	0.3	3	●
1.6	DCSSSD0160	10.3	45.3	45	0.3	3	●
1.7	DCSSSD0170	10.4	45.4	45	0.4	3	●
1.8	DCSSSD0180	10.4	45.4	45	0.4	3	●
1.9	DCSSSD0190	10.4	45.4	45	0.4	3	●
2.0	DCSSSD0200	12.4	45.4	45	0.4	3	●

DCSSM

Medium, For non-ferrous material

TOOL NEWS

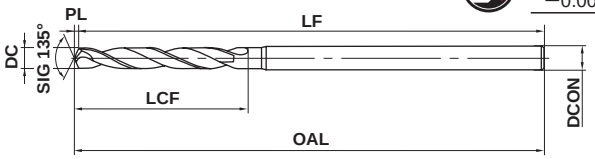
P M K **N** S H

Non-ferrous Metal

2.1≤DC≤3 $^{0}_{-0.014}$

DCON=3 $^{0}_{-0.006}$

External Coolant



● The original CVD diamond coating technology provides excellent adhesion for coating layer and enables stable drilling without peeling or chipping.

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
2.1	DCSSMD0210	17.4	60.4	60	0.4	3	●
2.2	DCSSMD0220	17.5	60.5	60	0.5	3	●
2.3	DCSSMD0230	17.5	60.5	60	0.5	3	●
2.4	DCSSMD0240	17.5	60.5	60	0.5	3	●
2.5	DCSSMD0250	21.5	60.5	60	0.5	3	●
2.6	DCSSMD0260	21.5	60.5	60	0.5	3	●

DC (mm)	Order Number	Dimensions (mm) LCF	OAL	LF	PL	DCON	Stock
2.7	DCSSMD0270	21.6	60.6	60	0.6	3	●
2.8	DCSSMD0280	21.6	60.6	60	0.6	3	●
2.9	DCSSMD0290	21.6	60.6	60	0.6	3	●
3.0	DCSSMD0300	21.6	60.6	60	0.6	3	●

● : Inventory maintained in Japan.

DCSSS
Short, For non-ferrous material

DCSSM
Medium, For non-ferrous material

RECOMMENDED CUTTING CONDITIONS

Work Material	Aluminium Alloy		Aluminium Alloy Casting		Copper Copper Alloy		Graphite Machineable Ceramics		MMC FRP	
Dia. DC (mm)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)
0.2	20000	0.006	10000	0.003	20000	0.003	20000	0.01	10000	0.003
0.5	20000	0.02	10000	0.01	20000	0.01	20000	0.03	10000	0.01
1.0	20000	0.04	10000	0.02	20000	0.02	20000	0.05	10000	0.02
1.5	20000	0.05	10000	0.02	16000	0.02	16000	0.08	10000	0.02
2.0	20000	0.06	9000	0.03	11000	0.03	11000	0.10	9000	0.03
2.5	18500	0.08	7500	0.04	10000	0.04	10000	0.12	7500	0.04
3.0	17000	0.10	6000	0.05	8500	0.05	8500	0.15	6000	0.05

Note 1) When drilling very hard work materials, reduce the feed.
Note 2) Use water soluble coolant or grinding fluid when working.
Note 3) When drilling deep holes, moderate the cutting conditions.
Note 4) The revolution can be increased by using a high speed spindle.

DCBSS

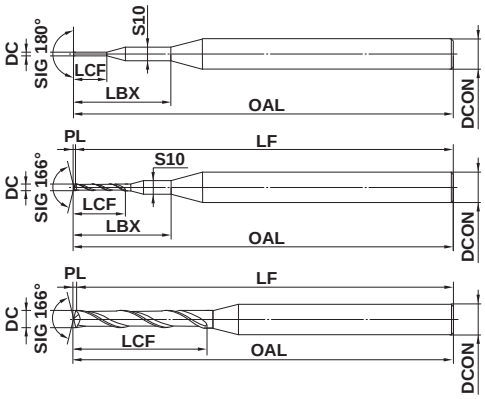
Drill for hard brittle materials

TOOL NEWS UWC DC 180° 166°
DC<0.07 DC≥0.07

P M K **N** S H
Non-ferrous Metal

External Coolant

● For machining materials such as sintered ceramics and quartz glass that cannot be machined with conventional drills.



	0.05≤DC<0.2	0.2≤DC≤3
	0 −0.009	0 −0.014
h6	0 −0.006	0 −0.006

DC (mm)	Order Number	LBX	LCF	OAL	LF	PL	S10	DCON	Stock	Type	Short Delivery
0.05	DCBSSD0005	6	0.5	38.0	38	–	1.0	3	□	1	◎
0.06	DCBSSD0006	6	0.6	38.0	38	–	1.0	3	□	1	
0.07	DCBSSD0007	6	0.7	38.004	38	0.004	1.0	3	□	2	◎
0.08	DCBSSD0008	6	0.8	38.005	38	0.005	1.0	3	□	2	◎
0.09	DCBSSD0009	6	0.9	38.006	38	0.006	1.0	3	□	2	◎
0.10	DCBSSD0010	6	1.0	38.01	38	0.01	1.0	3	●	2	
0.11	DCBSSD0011	6	1.2	38.01	38	0.01	1.0	3	●	2	
0.12	DCBSSD0012	6	1.4	38.01	38	0.01	1.0	3	●	2	
0.13	DCBSSD0013	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.14	DCBSSD0014	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.15	DCBSSD0015	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.16	DCBSSD0016	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.17	DCBSSD0017	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.18	DCBSSD0018	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.19	DCBSSD0019	6	1.5	38.01	38	0.01	1.0	3	●	2	
0.20	DCBSSD0020	–	2.0	38.01	38	0.01	–	3	●	3	
0.21	DCBSSD0021	–	2.0	38.01	38	0.01	–	3	□	3	◎
0.22	DCBSSD0022	–	2.0	38.01	38	0.01	–	3	□	3	◎
0.23	DCBSSD0023	–	2.0	38.01	38	0.01	–	3	□	3	◎
0.24	DCBSSD0024	–	2.0	38.01	38	0.01	–	3	□	3	◎
0.25	DCBSSD0025	–	2.5	38.02	38	0.02	–	3	●	3	
0.26	DCBSSD0026	–	2.5	38.02	38	0.02	–	3	□	3	◎
0.27	DCBSSD0027	–	2.5	38.02	38	0.02	–	3	□	3	◎
0.28	DCBSSD0028	–	2.5	38.02	38	0.02	–	3	□	3	◎
0.29	DCBSSD0029	–	2.5	38.02	38	0.02	–	3	□	3	◎
0.30	DCBSSD0030	–	3.0	38.02	38	0.02	–	3	●	3	
0.31	DCBSSD0031	–	3.0	38.02	38	0.02	–	3	□	3	◎
0.32	DCBSSD0032	–	3.0	38.02	38	0.02	–	3	□	3	◎
0.33	DCBSSD0033	–	3.0	38.02	38	0.02	–	3	□	3	◎
0.34	DCBSSD0034	–	3.5	38.02	38	0.02	–	3	□	3	◎
0.35	DCBSSD0035	–	3.5	38.02	38	0.02	–	3	●	3	
0.36	DCBSSD0036	–	3.5	38.02	38	0.02	–	3	□	3	◎

DC (mm)	Order Number	LBX	LCF	OAL	LF	PL	S10	DCON	Stock	Type	Short Delivery
0.40	DCBSSD0040	–	4.0	38.02	38	0.02	–	3	●	3	
0.45	DCBSSD0045	–	4.0	38.03	38	0.03	–	3	□	3	◎
0.50	DCBSSD0050	–	4.0	38.03	38	0.03	–	3	●	3	
0.55	DCBSSD0055	–	4.5	38.03	38	0.03	–	3	□	3	◎
0.60	DCBSSD0060	–	5.0	38.04	38	0.04	–	3	●	3	
0.70	DCBSSD0070	–	5.0	38.04	38	0.04	–	3	●	3	
0.80	DCBSSD0080	–	6.1	38.05	38	0.05	–	3	●	3	
0.85	DCBSSD0085	–	6.1	38.05	38	0.05	–	3	□	3	◎
0.90	DCBSSD0090	–	6.1	38.06	38	0.06	–	3	●	3	
1.00	DCBSSD0100	–	8.1	38.1	38	0.1	–	3	●	3	
1.10	DCBSSD0110	–	8.1	38.1	38	0.1	–	3	●	3	
1.20	DCBSSD0120	–	8.1	38.1	38	0.1	–	3	●	3	
1.30	DCBSSD0130	–	8.1	38.1	38	0.1	–	3	●	3	
1.40	DCBSSD0140	–	8.1	38.1	38	0.1	–	3	●	3	
1.50	DCBSSD0150	–	10.1	38.1	38	0.1	–	3	●	3	
1.60	DCBSSD0160	–	10.1	38.1	38	0.1	–	3	●	3	
1.70	DCBSSD0170	–	10.1	38.1	38	0.1	–	3	●	3	
1.80	DCBSSD0180	–	10.1	38.1	38	0.1	–	3	●	3	
1.90	DCBSSD0190	–	10.1	38.1	38	0.1	–	3	●	3	
2.00	DCBSSD0200	–	12.1	38.1	38	0.1	–	3	●	3	
2.10	DCBSSD0210	–	12.1	38.1	38	0.1	–	3	□	3	◎
2.20	DCBSSD0220	–	12.1	38.1	38	0.1	–	3	□	3	◎
2.30	DCBSSD0230	–	12.1	38.1	38	0.1	–	3	□	3	
2.40	DCBSSD0240	–	12.2	38.2	38	0.2	–	3	□	3	◎
2.50	DCBSSD0250	–	12.2	38.2	38	0.2	–	3	●	3	
2.60	DCBSSD0260	–	12.2	38.2	38	0.2	–	3	□	3	
2.70	DCBSSD0270	–	12.2	38.2	38	0.2	–	3	□	3	
2.80	DCBSSD0280	–	12.2	38.2	38	0.2	–	3	□	3	
2.90	DCBSSD0290	–	12.2	38.2	38	0.2	–	3	□	3	
3.00	DCBSSD0300	–	12.2	38.2	38	0.2	–	3	□	3	◎

Note 1) Stock mark □(produced on order products) shows the basic sizes. Consult us, if different diameters and flute lengths.
Note 2) Drills with ◎ mark can be delivered within 1-2 weeks. For the delivery of other drills, contact Mitsubishi Materials.
Note 3) DC=0.05, 0.06 are special shape specifications without groove. LCF is the neck lengths instead of the flute lengths.

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

RECOMMENDED CUTTING CONDITIONS

Work Material	Aluminium Nitride				Alumina				Zirconia			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Step (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Step (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Step (mm)
0.05	3	20000	0.000015	0.001	3	20000	0.00001	0.001	3	20000	0.00001	0.001
0.08	5	20000	0.00003	0.003	5	20000	0.00002	0.002	5	20000	0.00002	0.001
0.1	6	20000	0.0002	0.01	6	20000	0.0001	0.005	6	20000	0.0001	0.003
0.16	9	18000	0.0002	0.01	9	18000	0.0001	0.005	9	18000	0.0001	0.003
0.2	9	15000	0.0002	0.01	9	15000	0.0001	0.005	9	15000	0.0001	0.003
0.32	12	12000	0.0002	0.01	12	12000	0.0001	0.005	12	12000	0.0001	0.003
0.4	15	12000	0.0002	0.01	15	12000	0.0001	0.005	15	12000	0.0001	0.003
0.5	19	12000	0.0002	0.01	19	12000	0.0001	0.005	19	12000	0.0001	0.003
0.6	19	10000	0.0002	0.01	19	10000	0.0001	0.005	19	10000	0.0001	0.003
0.8	25	10000	0.0002	0.01	25	10000	0.0001	0.005	25	10000	0.0001	0.003
1	31	10000	0.0002	0.01	31	10000	0.0001	0.005	31	10000	0.0001	0.003
1.2	30	8000	0.00025	0.01	30	8000	0.00015	0.005	30	8000	0.00015	0.003
1.6	40	8000	0.0003	0.01	40	8000	0.0002	0.005	40	8000	0.0002	0.003
2	38	6000	0.0003	0.01	38	6000	0.0002	0.005	38	6000	0.0002	0.003
3	47	5000	0.0003	0.01	47	5000	0.0003	0.005	47	5000	0.0002	0.003

Work Material	Silicon Carbide Silicon Nitride				Quartz Glass			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Step (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Step (mm)
0.05	3	20000	0.000005	0.0005	3	20000	0.000015	0.001
0.08	5	20000	0.00001	0.001	5	20000	0.00003	0.005
0.1	6	20000	0.00005	0.002	6	20000	0.0002	0.05
0.16	9	18000	0.00005	0.002	9	18000	0.0002	0.05
0.2	9	15000	0.00005	0.002	9	15000	0.0002	0.05
0.32	12	12000	0.00005	0.002	12	12000	0.0002	0.05
0.4	15	12000	0.00005	0.002	15	12000	0.0003	0.05
0.5	19	12000	0.00005	0.002	19	12000	0.0003	0.05
0.6	19	10000	0.00005	0.002	19	10000	0.0003	0.05
0.8	25	10000	0.00005	0.002	25	10000	0.0003	0.05
1	31	10000	0.00005	0.002	31	10000	0.0003	0.05
1.2	30	8000	0.00007	0.002	30	8000	0.0004	0.05
1.6	40	8000	0.0001	0.002	40	8000	0.0004	0.05
2	38	6000	0.0001	0.002	38	6000	0.0004	0.05
3	47	5000	0.0001	0.002	47	5000	0.0005	0.05

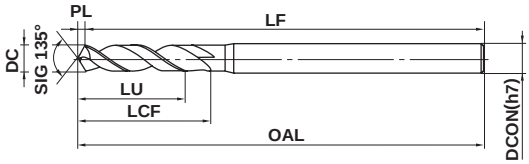
Note 1) Depending on the type of machine, it is possible to apply cutting speeds over 20000min^{-1}.
Note 2) Use water soluble coolant or grinding fluid when working.
Note 3) The intermediate diameter revolution is not tabulated. It is matched to the large diameter side and closest drill diameter conditions or by calculating the cutting speed of the closest drill diameter. Set the feedrate per revolution to a suitable value with the recommended feedrate of the closest drill diameter as the standard.

SEPDS

SE High Precision Drill (S)

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



*LU = LCF-2DC (Max 3×DC)

0.5≤DC≤3	3.1≤DC≤4
0 −0.006	0 −0.008

● Unique D-STH process dramatically improves sharpness and welding resistance and smooth chip discharge.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SEPDSD0050	0.50	3.1	50.1	50	0.10	3	●
SEPDSD0055	0.55	3.1	50.1	50	0.11	3	●
SEPDSD0060	0.60	5.1	50.1	50	0.12	3	●
SEPDSD0065	0.65	5.1	50.1	50	0.13	3	●
SEPDSD0070	0.70	5.1	50.1	50	0.14	3	●
SEPDSD0075	0.75	5.2	50.2	50	0.16	3	●
SEPDSD0080	0.80	5.2	50.2	50	0.17	3	●
SEPDSD0085	0.85	5.2	50.2	50	0.18	3	●
SEPDSD0090	0.90	6.2	50.2	50	0.19	3	●
SEPDSD0095	0.95	6.2	50.2	50	0.2	3	●
SEPDSD0100	1.0	6.2	50.2	50	0.2	3	●
SEPDSD0110	1.1	8.2	55.2	55	0.2	3	●
SEPDSD0120	1.2	8.3	55.3	55	0.3	3	●
SEPDSD0130	1.3	9.3	55.3	55	0.3	3	●
SEPDSD0140	1.4	9.3	55.3	55	0.3	3	●
SEPDSD0150	1.5	9.3	55.3	55	0.3	3	●
SEPDSD0160	1.6	11.3	55.3	55	0.3	3	●
SEPDSD0170	1.7	11.4	55.4	55	0.4	3	●
SEPDSD0180	1.8	11.4	55.4	55	0.4	3	●
SEPDSD0190	1.9	12.4	55.4	55	0.4	3	●
SEPDSD0200	2.0	12.4	60.4	60	0.4	3	●
SEPDSD0210	2.1	12.4	60.4	60	0.4	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SEPDSD0220	2.2	12.5	60.5	60	0.5	3	●
SEPDSD0230	2.3	13.5	60.5	60	0.5	3	●
SEPDSD0240	2.4	13.5	60.5	60	0.5	3	●
SEPDSD0250	2.5	13.5	60.5	60	0.5	3	●
SEPDSD0260	2.6	15.5	60.5	60	0.5	3	●
SEPDSD0270	2.7	15.6	60.6	60	0.6	3	●
SEPDSD0280	2.8	15.6	60.6	60	0.6	3	●
SEPDSD0290	2.9	15.6	60.6	60	0.6	3	●
SEPDSD0300	3.0	15.6	60.6	60	0.6	3	●
SEPDSD0310	3.1	17.6	70.6	70	0.6	4	●
SEPDSD0320	3.2	17.7	70.7	70	0.7	4	●
SEPDSD0330	3.3	19.7	70.7	70	0.7	4	●
SEPDSD0340	3.4	19.7	70.7	70	0.7	4	●
SEPDSD0350	3.5	19.7	70.7	70	0.7	4	●
SEPDSD0360	3.6	21.8	70.8	70	0.8	4	●
SEPDSD0370	3.7	21.8	70.8	70	0.8	4	●
SEPDSD0380	3.8	21.8	70.8	70	0.8	4	●
SEPDSD0390	3.9	21.8	70.8	70	0.8	4	●
SEPDSD0400	4.0	21.8	70.8	70	0.8	4	●

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB), Aluminium Alloy (Si<5%) AISI 1010 etc				Carbon Steel, Alloy Steel (180−280HB), Gray Cast Iron (≤350MPa), Copper, Copper Alloys AISI 1045, AISI 4140, No 45 B etc				Alloy Steel, Tool Steel (≤250HB) Ferritic and Martensitic Stainless Steel (≤200HB) AISI D2, AISI 410, AISI 430 etc			
Drill Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)
0.5	24	15000	0.02	300	18	11250	0.01	110	13	8000	0.01	80
0.65	28	13700	0.03	410	22	10700	0.02	210	14	6800	0.02	135
0.8	33	13100	0.04	520	27	10700	0.03	320	14	5500	0.03	165
1.0	38	12000	0.05	600	31	10000	0.05	500	16	5000	0.05	250
1.2	38	10000	0.06	600	31	8200	0.06	490	17	4500	0.05	225
1.6	40	8000	0.08	640	33	6500	0.08	520	18	3500	0.06	210
2.0	40	6400	0.09	575	35	5500	0.09	495	18	2900	0.06	170
2.5	40	5100	0.11	560	35	4400	0.11	480	18	2300	0.08	180
3.2	40	4000	0.13	520	34	3400	0.13	440	18	1800	0.09	160
4.0	40	3200	0.15	480	35	2800	0.15	420	18	1400	0.10	140

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304LN, AISI 316LN etc				Alloy Steel, Tool Steel (≤30HRC) ASTM H13, AISI L6 etc			
Drill Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)
0.5	10	6600	0.01	65	10	6600	0.01	65
0.65	11	5300	0.012	60	11	5300	0.012	60
0.8	11	4300	0.015	60	11	4300	0.015	60
1.0	12	3800	0.02	75	12	3800	0.02	75
1.2	12	3100	0.025	75	12	3100	0.023	70
1.6	14	2700	0.03	80	14	2700	0.03	80
2.0	15	2400	0.04	95	15	2400	0.04	95
2.5	15	1900	0.05	95	15	1900	0.04	75
3.2	15	1500	0.07	105	15	1500	0.05	75
4.0	15	1200	0.09	105	15	1200	0.07	80

Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) VAPDS,VAPDM is recommended for the workpiece whose hardness is over 30HRC.
Note 5) WSTAR drill(MVE, MVS) are recommended for Precipitation hardening stainless steel (JIS-SUS630/ISO-L-No58X5CrNiCuNb16-4/ ASTM-S17400, JIS-SUS631/DIN-X7CrNiAl177/ASTM-S17700)
Note 6) When drilling holes greater than 4 x drill diameter hole depths, please use a peck feed.
Note 7) The above-mentioned cutting condition is standard when using water-soluble cutting fluid. Please reduce the revolution when using water-insoluble cutting fluid.
Note 8) For the spindle revolution of diameters not shown in the table, please adjust to the conditions of larger and closest diameter, or calculate from the cutting speed of the closest diameter. For the feed rate per revolution, please set up within the recommended feed rate of the closest diameter appropriately.

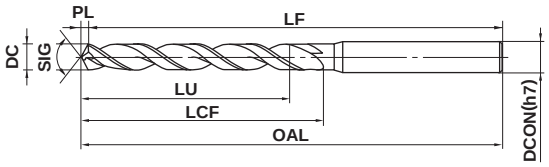
SEPDM

SE High Precision Drill (M)

TOOL NEWS

DC<4 DC=4

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



*LU = LCF-2DC (Max 5×DC)

0.5≤DC≤3	3.1≤DC≤4
0 −0.006	0 −0.008

● Unique D-STH process dramatically improves sharpness and welding resistance and smooth chip discharge.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SEPDMD0050	0.50	6.2	50.2	50	0.15	3	●
SEPDMD0055	0.55	6.2	50.2	50	0.17	3	●
SEPDMD0060	0.60	8.2	50.2	50	0.18	3	●
SEPDMD0065	0.65	8.2	50.2	50	0.20	3	●
SEPDMD0070	0.70	10.2	50.2	50	0.21	3	●
SEPDMD0075	0.75	10.2	50.2	50	0.23	3	●
SEPDMD0080	0.80	10.2	50.2	50	0.24	3	●
SEPDMD0085	0.85	10.3	50.3	50	0.26	3	●
SEPDMD0090	0.90	12.3	50.3	50	0.27	3	●
SEPDMD0095	0.95	12.3	50.3	50	0.29	3	●
SEPDMD0100	1.0	12.3	60.3	60	0.3	3	●
SEPDMD0110	1.1	16.3	60.3	60	0.3	3	●
SEPDMD0120	1.2	16.4	60.4	60	0.4	3	●
SEPDMD0130	1.3	16.4	60.4	60	0.4	3	●
SEPDMD0140	1.4	18.4	60.4	60	0.4	3	●
SEPDMD0150	1.5	18.5	60.5	60	0.5	3	●
SEPDMD0160	1.6	20.5	60.5	60	0.5	3	●
SEPDMD0170	1.7	20.5	60.5	60	0.5	3	●
SEPDMD0180	1.8	22.5	60.5	60	0.5	3	●
SEPDMD0190	1.9	22.6	60.6	60	0.6	3	●
SEPDMD0200	2.0	23.6	70.6	70	0.6	3	●
SEPDMD0210	2.1	23.6	70.6	70	0.6	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SEPDMD0220	2.2	26.7	70.7	70	0.7	3	●
SEPDMD0230	2.3	26.7	70.7	70	0.7	3	●
SEPDMD0240	2.4	29.7	70.7	70	0.7	3	●
SEPDMD0250	2.5	29.8	70.8	70	0.8	3	●
SEPDMD0260	2.6	29.8	70.8	70	0.8	3	●
SEPDMD0270	2.7	32.8	70.8	70	0.8	3	●
SEPDMD0280	2.8	32.8	70.8	70	0.8	3	●
SEPDMD0290	2.9	32.9	70.9	70	0.9	3	●
SEPDMD0300	3.0	32.9	70.9	70	0.9	3	●
SEPDMD0310	3.1	35.9	85.9	85	0.9	4	●
SEPDMD0320	3.2	36.0	86.0	85	1.0	4	●
SEPDMD0330	3.3	36.0	86.0	85	1.0	4	●
SEPDMD0340	3.4	39.0	86.0	85	1.0	4	●
SEPDMD0350	3.5	39.1	86.1	85	1.1	4	●
SEPDMD0360	3.6	39.1	86.1	85	1.1	4	●
SEPDMD0370	3.7	39.1	86.1	85	1.1	4	●
SEPDMD0380	3.8	43.1	86.1	85	1.1	4	●
SEPDMD0390	3.9	43.2	86.2	85	1.2	4	●
SEPDMD0400	4.0	42.8	85.8	85	0.8	4	●

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB), Aluminium Alloy (Si<5%) AISI 1010 etc				Carbon Steel, Alloy Steel (180−280HB), Gray Cast Iron (≤350MPa), Copper, Copper Alloys AISI 1045, AISI 4140, No 45 B etc				Alloy Steel, Tool Steel (≤250HB) Ferritic and Martensitic Stainless Steel (≤200HB) AISI D2, AISI 410, AISI 430 etc			
Drill Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)
0.5	24	15000	0.02	300	18	11250	0.01	110	13	8000	0.01	80
0.65	28	13700	0.03	410	22	10700	0.02	210	14	6800	0.02	135
0.8	33	13100	0.04	520	27	10700	0.03	320	14	5500	0.03	165
1.0	38	12000	0.05	600	31	10000	0.05	500	16	5000	0.05	250
1.2	38	10000	0.06	600	31	8200	0.06	490	17	4500	0.05	225
1.6	40	8000	0.08	640	33	6500	0.08	520	18	3500	0.06	210
2.0	40	6400	0.09	575	35	5500	0.09	495	18	2900	0.06	170
2.5	40	5100	0.11	560	35	4400	0.11	480	18	2300	0.08	180
3.2	40	4000	0.13	520	34	3400	0.13	440	18	1800	0.09	160
4.0	40	3200	0.15	480	35	2800	0.15	420	18	1400	0.10	140

Work Material	Austenitic Stainless Steel (≤200HB) AISI 304LN, AISI 316LN etc				Alloy Steel, Tool Steel (≤30HRC) ASTM H13, AISI L6 etc			
Drill Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)
0.5	10	6600	0.01	65	10	6600	0.01	65
0.65	11	5300	0.012	60	11	5300	0.012	60
0.8	11	4300	0.015	60	11	4300	0.015	60
1.0	12	3800	0.02	75	12	3800	0.02	75
1.2	12	3100	0.025	75	12	3100	0.023	70
1.6	14	2700	0.03	80	14	2700	0.03	80
2.0	15	2400	0.04	95	15	2400	0.04	95
2.5	15	1900	0.05	95	15	1900	0.04	75
3.2	15	1500	0.07	105	15	1500	0.05	75
4.0	15	1200	0.09	105	15	1200	0.07	80

Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) VAPDS,VAPDM is recommended for the workpiece whose hardness is over 30HRC.
Note 5) WSTAR drill(MVE, MVS) are recommended for Precipitation hardening stainless steel (JIS-SUS630/ISO-L-No58X5CrNiCuNb16-4/ ASTM-S17400, JIS-SUS631/DIN-X7CrNiAl177/ASTM-S17700)
Note 6) When drilling holes greater than 4 x drill diameter hole depths, please use a peck feed.
Note 7) The above-mentioned cutting condition is standard when using water-soluble cutting fluid. Please reduce the revolution when using water-insoluble cutting fluid.
Note 8) For the spindle revolution of diameters not shown in the table, please adjust to the conditions of larger and closest diameter, or calculate from the cutting speed of the closest diameter. For the feed rate per revolution, please set up within the recommended feed rate of the closest diameter appropriately.

HSS

VAPDS

Short, High precision

TOOL NEWS

HG HSS

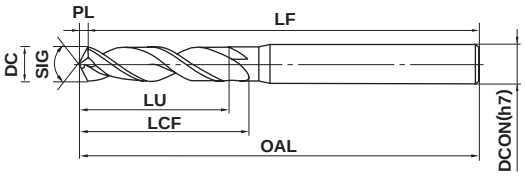
V

118° DC<2

135° DC≥2

X

P Steel | M Stainless Steel | K Cast Iron | N | S | H



*LU = LCF-2DC (Max 3×DC)

0.5≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

*All drills except those with intervals of 0.1mm and under dia. 2.0mm have a tolerance of 0−-0.009mm.

●Highly efficient drilling and long tool life have been achieved with the Violet coating.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0050	0.50	3.2	50.2	50	0.15	3	●
VAPDSD0051	0.51	3.2	50.2	50	0.15	3	●
VAPDSD0052	0.52	3.2	50.2	50	0.16	3	●
VAPDSD0053	0.53	3.2	50.2	50	0.16	3	●
VAPDSD0054	0.54	3.2	50.2	50	0.16	3	●
VAPDSD0055	0.55	3.2	50.2	50	0.17	3	●
VAPDSD0056	0.56	4.2	50.2	50	0.17	3	●
VAPDSD0057	0.57	4.2	50.2	50	0.17	3	●
VAPDSD0058	0.58	4.2	50.2	50	0.17	3	●
VAPDSD0059	0.59	4.2	50.2	50	0.18	3	●
VAPDSD0060	0.60	5.2	50.2	50	0.18	3	●
VAPDSD0061	0.61	5.2	50.2	50	0.18	3	●
VAPDSD0062	0.62	5.2	50.2	50	0.19	3	●
VAPDSD0063	0.63	5.2	50.2	50	0.19	3	●
VAPDSD0064	0.64	5.2	50.2	50	0.19	3	●
VAPDSD0065	0.65	5.2	50.2	50	0.20	3	●
VAPDSD0066	0.66	5.2	50.2	50	0.20	3	●
VAPDSD0067	0.67	5.2	50.2	50	0.20	3	●
VAPDSD0068	0.68	5.2	50.2	50	0.20	3	●
VAPDSD0069	0.69	5.2	50.2	50	0.21	3	●
VAPDSD0070	0.70	5.2	50.2	50	0.21	3	●
VAPDSD0071	0.71	5.2	50.2	50	0.21	3	●
VAPDSD0072	0.72	5.2	50.2	50	0.22	3	●
VAPDSD0073	0.73	5.2	50.2	50	0.22	3	●
VAPDSD0074	0.74	5.2	50.2	50	0.22	3	●
VAPDSD0075	0.75	5.2	50.2	50	0.23	3	●
VAPDSD0076	0.76	5.2	50.2	50	0.23	3	●
VAPDSD0077	0.77	5.2	50.2	50	0.23	3	●
VAPDSD0078	0.78	5.2	50.2	50	0.23	3	●
VAPDSD0079	0.79	5.2	50.2	50	0.24	3	●
VAPDSD0080	0.80	5.2	50.2	50	0.24	3	●
VAPDSD0081	0.81	5.2	50.2	50	0.24	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0082	0.82	5.3	50.3	50	0.25	3	●
VAPDSD0083	0.83	5.3	50.3	50	0.25	3	●
VAPDSD0084	0.84	5.3	50.3	50	0.25	3	●
VAPDSD0085	0.85	5.3	50.3	50	0.26	3	●
VAPDSD0086	0.86	6.3	50.3	50	0.26	3	●
VAPDSD0087	0.87	6.3	50.3	50	0.26	3	●
VAPDSD0088	0.88	6.3	50.3	50	0.26	3	●
VAPDSD0089	0.89	6.3	50.3	50	0.27	3	●
VAPDSD0090	0.90	6.3	50.3	50	0.27	3	●
VAPDSD0091	0.91	6.3	50.3	50	0.27	3	●
VAPDSD0092	0.92	6.3	50.3	50	0.28	3	●
VAPDSD0093	0.93	6.3	50.3	50	0.28	3	●
VAPDSD0094	0.94	6.3	50.3	50	0.28	3	●
VAPDSD0095	0.95	6.3	50.3	50	0.29	3	●
VAPDSD0096	0.96	6.3	50.3	50	0.29	3	●
VAPDSD0097	0.97	6.3	50.3	50	0.29	3	●
VAPDSD0098	0.98	6.3	50.3	50	0.29	3	●
VAPDSD0099	0.99	6.3	50.3	50	0.30	3	●
VAPDSD0100	1.00	6.3	50.3	50	0.3	3	●
VAPDSD0101	1.01	6.3	50.3	50	0.3	3	●
VAPDSD0102	1.02	6.3	50.3	50	0.3	3	●
VAPDSD0103	1.03	6.3	50.3	50	0.3	3	●
VAPDSD0104	1.04	6.3	50.3	50	0.3	3	●
VAPDSD0105	1.05	6.3	50.3	50	0.3	3	●
VAPDSD0106	1.06	6.3	50.3	50	0.3	3	●
VAPDSD0107	1.07	8.3	55.3	55	0.3	3	●
VAPDSD0108	1.08	8.3	55.3	55	0.3	3	●
VAPDSD0109	1.09	8.3	55.3	55	0.3	3	●
VAPDSD0110	1.10	8.3	55.3	55	0.3	3	●
VAPDSD0111	1.11	8.3	55.3	55	0.3	3	●
VAPDSD0112	1.12	8.3	55.3	55	0.3	3	●
VAPDSD0113	1.13	8.3	55.3	55	0.3	3	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0114	1.14	8.3	55.3	55	0.3	3	●
VAPDSD0115	1.15	8.4	55.4	55	0.4	3	●
VAPDSD0116	1.16	8.4	55.4	55	0.4	3	●
VAPDSD0117	1.17	8.4	55.4	55	0.4	3	●
VAPDSD0118	1.18	8.4	55.4	55	0.4	3	●
VAPDSD0119	1.19	8.4	55.4	55	0.4	3	●
VAPDSD0120	1.20	8.4	55.4	55	0.4	3	●
VAPDSD0121	1.21	8.4	55.4	55	0.4	3	●
VAPDSD0122	1.22	8.4	55.4	55	0.4	3	●
VAPDSD0123	1.23	8.4	55.4	55	0.4	3	●
VAPDSD0124	1.24	8.4	55.4	55	0.4	3	●
VAPDSD0125	1.25	8.4	55.4	55	0.4	3	●
VAPDSD0126	1.26	8.4	55.4	55	0.4	3	●
VAPDSD0127	1.27	8.4	55.4	55	0.4	3	●
VAPDSD0128	1.28	8.4	55.4	55	0.4	3	●
VAPDSD0129	1.29	8.4	55.4	55	0.4	3	●
VAPDSD0130	1.30	9.4	55.4	55	0.4	3	●
VAPDSD0131	1.31	9.4	55.4	55	0.4	3	●
VAPDSD0132	1.32	9.4	55.4	55	0.4	3	●
VAPDSD0133	1.33	9.4	55.4	55	0.4	3	●
VAPDSD0134	1.34	9.4	55.4	55	0.4	3	●
VAPDSD0135	1.35	9.4	55.4	55	0.4	3	●
VAPDSD0136	1.36	9.4	55.4	55	0.4	3	●
VAPDSD0137	1.37	9.4	55.4	55	0.4	3	●
VAPDSD0138	1.38	9.4	55.4	55	0.4	3	●
VAPDSD0139	1.39	9.4	55.4	55	0.4	3	●
VAPDSD0140	1.40	9.4	55.4	55	0.4	3	●
VAPDSD0141	1.41	9.4	55.4	55	0.4	3	●
VAPDSD0142	1.42	9.4	55.4	55	0.4	3	●
VAPDSD0143	1.43	9.4	55.4	55	0.4	3	●
VAPDSD0144	1.44	9.4	55.4	55	0.4	3	●
VAPDSD0145	1.45	9.4	55.4	55	0.4	3	●
VAPDSD0146	1.46	9.4	55.4	55	0.4	3	●
VAPDSD0147	1.47	9.4	55.4	55	0.4	3	●
VAPDSD0148	1.48	9.4	55.4	55	0.4	3	●
VAPDSD0149	1.49	9.5	55.5	55	0.5	3	●
VAPDSD0150	1.50	9.5	55.5	55	0.5	3	●
VAPDSD0151	1.51	11.5	55.5	55	0.5	3	●
VAPDSD0152	1.52	11.5	55.5	55	0.5	3	●
VAPDSD0153	1.53	11.5	55.5	55	0.5	3	●
VAPDSD0154	1.54	11.5	55.5	55	0.5	3	●
VAPDSD0155	1.55	11.5	55.5	55	0.5	3	●
VAPDSD0156	1.56	11.5	55.5	55	0.5	3	●
VAPDSD0157	1.57	11.5	55.5	55	0.5	3	●
VAPDSD0158	1.58	11.5	55.5	55	0.5	3	●
VAPDSD0159	1.59	11.5	55.5	55	0.5	3	●
VAPDSD0160	1.60	11.5	55.5	55	0.5	3	●
VAPDSD0161	1.61	11.5	55.5	55	0.5	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0162	1.62	11.5	55.5	55	0.5	3	●
VAPDSD0163	1.63	11.5	55.5	55	0.5	3	●
VAPDSD0164	1.64	11.5	55.5	55	0.5	3	●
VAPDSD0165	1.65	11.5	55.5	55	0.5	3	●
VAPDSD0166	1.66	11.5	55.5	55	0.5	3	●
VAPDSD0167	1.67	11.5	55.5	55	0.5	3	●
VAPDSD0168	1.68	11.5	55.5	55	0.5	3	●
VAPDSD0169	1.69	11.5	55.5	55	0.5	3	●
VAPDSD0170	1.70	11.5	55.5	55	0.5	3	●
VAPDSD0171	1.71	11.5	55.5	55	0.5	3	●
VAPDSD0172	1.72	11.5	55.5	55	0.5	3	●
VAPDSD0173	1.73	11.5	55.5	55	0.5	3	●
VAPDSD0174	1.74	11.5	55.5	55	0.5	3	●
VAPDSD0175	1.75	11.5	55.5	55	0.5	3	●
VAPDSD0176	1.76	11.5	55.5	55	0.5	3	●
VAPDSD0177	1.77	11.5	55.5	55	0.5	3	●
VAPDSD0178	1.78	11.5	55.5	55	0.5	3	●
VAPDSD0179	1.79	11.5	55.5	55	0.5	3	●
VAPDSD0180	1.80	11.5	55.5	55	0.5	3	●
VAPDSD0181	1.81	11.5	55.5	55	0.5	3	●
VAPDSD0182	1.82	11.6	55.6	55	0.6	3	●
VAPDSD0183	1.83	11.6	55.6	55	0.6	3	●
VAPDSD0184	1.84	11.6	55.6	55	0.6	3	●
VAPDSD0185	1.85	11.6	55.6	55	0.6	3	●
VAPDSD0186	1.86	11.6	55.6	55	0.6	3	●
VAPDSD0187	1.87	11.6	55.6	55	0.6	3	●
VAPDSD0188	1.88	11.6	55.6	55	0.6	3	●
VAPDSD0189	1.89	11.6	55.6	55	0.6	3	●
VAPDSD0190	1.90	12.6	55.6	55	0.6	3	●
VAPDSD0191	1.91	12.6	60.6	60	0.6	3	●
VAPDSD0192	1.92	12.6	60.6	60	0.6	3	●
VAPDSD0193	1.93	12.6	60.6	60	0.6	3	●
VAPDSD0194	1.94	12.6	60.6	60	0.6	3	●
VAPDSD0195	1.95	12.6	60.6	60	0.6	3	●
VAPDSD0196	1.96	12.6	60.6	60	0.6	3	●
VAPDSD0197	1.97	12.6	60.6	60	0.6	3	●
VAPDSD0198	1.98	12.6	60.6	60	0.6	3	●
VAPDSD0199	1.99	12.6	60.6	60	0.6	3	●
VAPDSD0200	2.00	12.4	60.4	60	0.4	3	●
VAPDSD0205	2.05	12.4	60.4	60	0.4	3	●
VAPDSD0210	2.10	12.4	60.4	60	0.4	3	●
VAPDSD0215	2.15	12.5	60.5	60	0.5	3	●
VAPDSD0220	2.20	12.5	60.5	60	0.5	3	●
VAPDSD0225	2.25	12.5	60.5	60	0.5	3	●
VAPDSD0230	2.30	13.5	60.5	60	0.5	3	●
VAPDSD0235	2.35	13.5	60.5	60	0.5	3	●
VAPDSD0240	2.40	13.5	60.5	60	0.5	3	●
VAPDSD0245	2.45	13.5	60.5	60	0.5	3	●

CUTTING CONDITIONS ➤ P148
TECHNICAL DATA ➤ R001

VAPDS

Short, High precision

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0250	2.50	13.5	60.5	60	0.5	3	●
VAPDSD0255	2.55	13.5	60.5	60	0.5	3	●
VAPDSD0260	2.60	15.5	60.5	60	0.5	3	●
VAPDSD0265	2.65	15.6	60.6	60	0.6	3	●
VAPDSD0270	2.70	15.6	60.6	60	0.6	3	●
VAPDSD0275	2.75	15.6	60.6	60	0.6	3	●
VAPDSD0280	2.80	15.6	60.6	60	0.6	3	●
VAPDSD0285	2.85	15.6	60.6	60	0.6	3	●
VAPDSD0290	2.90	15.6	60.6	60	0.6	3	●
VAPDSD0295	2.95	15.6	60.6	60	0.6	3	●
VAPDSD0300	3.00	15.6	60.6	60	0.6	3	●
VAPDSD0305	3.05	17.6	70.6	70	0.6	4	●
VAPDSD0310	3.10	17.6	70.6	70	0.6	4	●
VAPDSD0315	3.15	17.7	70.7	70	0.7	4	●
VAPDSD0320	3.20	17.7	70.7	70	0.7	4	●
VAPDSD0325	3.25	17.7	70.7	70	0.7	4	●
VAPDSD0330	3.30	19.7	70.7	70	0.7	4	●
VAPDSD0335	3.35	19.7	70.7	70	0.7	4	●
VAPDSD0340	3.40	19.7	70.7	70	0.7	4	●
VAPDSD0345	3.45	19.7	70.7	70	0.7	4	●
VAPDSD0350	3.50	19.7	70.7	70	0.7	4	●
VAPDSD0355	3.55	19.7	70.7	70	0.7	4	●
VAPDSD0360	3.60	21.8	70.8	70	0.8	4	●
VAPDSD0365	3.65	21.8	70.8	70	0.8	4	●
VAPDSD0370	3.70	21.8	70.8	70	0.8	4	●
VAPDSD0375	3.75	21.8	70.8	70	0.8	4	●
VAPDSD0380	3.80	21.8	70.8	70	0.8	4	●
VAPDSD0385	3.85	21.8	70.8	70	0.8	4	●
VAPDSD0390	3.90	21.8	70.8	70	0.8	4	●
VAPDSD0395	3.95	21.8	70.8	70	0.8	4	●
VAPDSD0400	4.00	21.8	70.8	70	0.8	4	●
VAPDSD0405	4.05	21.8	80.8	80	0.8	6	●
VAPDSD0410	4.10	21.9	80.9	80	0.9	6	●
VAPDSD0415	4.15	21.9	80.9	80	0.9	6	●
VAPDSD0420	4.20	21.9	80.9	80	0.9	6	●
VAPDSD0425	4.25	21.9	80.9	80	0.9	6	●
VAPDSD0430	4.30	23.9	80.9	80	0.9	6	●
VAPDSD0435	4.35	23.9	80.9	80	0.9	6	●
VAPDSD0440	4.40	23.9	80.9	80	0.9	6	●
VAPDSD0445	4.45	23.9	80.9	80	0.9	6	●
VAPDSD0450	4.50	23.9	80.9	80	0.9	6	●
VAPDSD0455	4.55	23.9	80.9	80	0.9	6	●
VAPDSD0460	4.60	26.0	81.0	80	1.0	6	●
VAPDSD0465	4.65	26.0	81.0	80	1.0	6	●
VAPDSD0470	4.70	26.0	81.0	80	1.0	6	●
VAPDSD0475	4.75	26.0	81.0	80	1.0	6	●
VAPDSD0480	4.80	26.0	81.0	80	1.0	6	●
VAPDSD0485	4.85	26.0	81.0	80	1.0	6	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0490	4.90	26.0	81.0	80	1.0	6	●
VAPDSD0495	4.95	26.0	81.0	80	1.0	6	●
VAPDSD0500	5.00	26.0	81.0	80	1.0	6	●
VAPDSD0505	5.05	26.1	81.1	80	1.1	6	●
VAPDSD0510	5.10	26.1	81.1	80	1.1	6	●
VAPDSD0515	5.15	26.1	81.1	80	1.1	6	●
VAPDSD0520	5.20	26.1	81.1	80	1.1	6	●
VAPDSD0525	5.25	26.1	81.1	80	1.1	6	●
VAPDSD0530	5.30	26.1	81.1	80	1.1	6	●
VAPDSD0535	5.35	28.1	81.1	80	1.1	6	●
VAPDSD0540	5.40	28.1	81.1	80	1.1	6	●
VAPDSD0545	5.45	28.1	81.1	80	1.1	6	●
VAPDSD0550	5.50	28.1	81.1	80	1.1	6	●
VAPDSD0555	5.55	28.2	81.2	80	1.2	6	●
VAPDSD0560	5.60	28.2	81.2	80	1.2	6	●
VAPDSD0565	5.65	28.2	81.2	80	1.2	6	●
VAPDSD0570	5.70	28.2	81.2	80	1.2	6	●
VAPDSD0575	5.75	28.2	81.2	80	1.2	6	●
VAPDSD0580	5.80	28.2	81.2	80	1.2	6	●
VAPDSD0585	5.85	28.2	81.2	80	1.2	6	●
VAPDSD0590	5.90	28.2	81.2	80	1.2	6	●
VAPDSD0595	5.95	28.2	81.2	80	1.2	6	●
VAPDSD0600	6.00	28.2	81.2	80	1.2	6	●
VAPDSD0605	6.05	31.3	81.3	80	1.3	8	●
VAPDSD0610	6.10	31.3	81.3	80	1.3	8	●
VAPDSD0615	6.15	31.3	81.3	80	1.3	8	●
VAPDSD0620	6.20	31.3	81.3	80	1.3	8	●
VAPDSD0625	6.25	31.3	81.3	80	1.3	8	●
VAPDSD0630	6.30	31.3	81.3	80	1.3	8	●
VAPDSD0635	6.35	31.3	81.3	80	1.3	8	●
VAPDSD0640	6.40	31.3	81.3	80	1.3	8	●
VAPDSD0645	6.45	31.3	81.3	80	1.3	8	●
VAPDSD0650	6.50	31.4	81.4	80	1.4	8	●
VAPDSD0655	6.55	31.4	81.4	80	1.4	8	●
VAPDSD0660	6.60	31.4	81.4	80	1.4	8	●
VAPDSD0665	6.65	31.4	81.4	80	1.4	8	●
VAPDSD0670	6.70	31.4	81.4	80	1.4	8	●
VAPDSD0675	6.75	33.4	81.4	80	1.4	8	●
VAPDSD0680	6.80	33.4	81.4	80	1.4	8	●
VAPDSD0685	6.85	33.4	81.4	80	1.4	8	●
VAPDSD0690	6.90	33.4	81.4	80	1.4	8	●
VAPDSD0695	6.95	33.4	81.4	80	1.4	8	●
VAPDSD0700	7.00	33.5	81.5	80	1.5	8	●
VAPDSD0705	7.05	33.5	81.5	80	1.5	8	●
VAPDSD0710	7.10	33.5	81.5	80	1.5	8	●
VAPDSD0715	7.15	33.5	81.5	80	1.5	8	●
VAPDSD0720	7.20	33.5	81.5	80	1.5	8	●
VAPDSD0725	7.25	33.5	81.5	80	1.5	8	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD0730	7.30	33.5	81.5	80	1.5	8	●
VAPDSD0735	7.35	33.5	81.5	80	1.5	8	●
VAPDSD0740	7.40	33.5	81.5	80	1.5	8	●
VAPDSD0745	7.45	33.5	81.5	80	1.5	8	●
VAPDSD0750	7.50	33.6	81.6	80	1.6	8	●
VAPDSD0755	7.55	36.6	86.6	85	1.6	8	●
VAPDSD0760	7.60	36.6	86.6	85	1.6	8	●
VAPDSD0765	7.65	36.6	86.6	85	1.6	8	●
VAPDSD0770	7.70	36.6	86.6	85	1.6	8	●
VAPDSD0775	7.75	36.6	86.6	85	1.6	8	●
VAPDSD0780	7.80	36.6	86.6	85	1.6	8	●
VAPDSD0785	7.85	36.6	86.6	85	1.6	8	●
VAPDSD0790	7.90	36.6	86.6	85	1.6	8	●
VAPDSD0795	7.95	36.7	86.7	85	1.7	8	●
VAPDSD0800	8.00	36.7	86.7	85	1.7	8	●
VAPDSD0805	8.05	36.7	91.7	90	1.7	10	●
VAPDSD0810	8.10	36.7	91.7	90	1.7	10	●
VAPDSD0815	8.15	36.7	91.7	90	1.7	10	●
VAPDSD0820	8.20	36.7	91.7	90	1.7	10	●
VAPDSD0825	8.25	36.7	91.7	90	1.7	10	●
VAPDSD0830	8.30	36.7	91.7	90	1.7	10	●
VAPDSD0835	8.35	36.7	91.7	90	1.7	10	●
VAPDSD0840	8.40	36.7	91.7	90	1.7	10	●
VAPDSD0845	8.45	36.8	91.8	90	1.8	10	●
VAPDSD0850	8.50	36.8	91.8	90	1.8	10	●
VAPDSD0855	8.55	39.8	94.8	93	1.8	10	●
VAPDSD0860	8.60	39.8	94.8	93	1.8	10	●
VAPDSD0865	8.65	39.8	94.8	93	1.8	10	●
VAPDSD0870	8.70	39.8	94.8	93	1.8	10	●
VAPDSD0875	8.75	39.8	94.8	93	1.8	10	●
VAPDSD0880	8.80	39.8	94.8	93	1.8	10	●
VAPDSD0885	8.85	39.8	94.8	93	1.8	10	●
VAPDSD0890	8.90	39.8	94.8	93	1.8	10	●
VAPDSD0895	8.95	39.9	94.9	93	1.9	10	●
VAPDSD0900	9.00	39.9	94.9	93	1.9	10	●
VAPDSD0910	9.10	39.9	94.9	93	1.9	10	●
VAPDSD0920	9.20	39.9	94.9	93	1.9	10	●
VAPDSD0930	9.30	39.9	94.9	93	1.9	10	●
VAPDSD0940	9.40	40.0	95.0	93	2.0	10	●
VAPDSD0950	9.50	40.0	95.0	93	2.0	10	●
VAPDSD0960	9.60	43.0	98.0	96	2.0	10	●
VAPDSD0970	9.70	43.0	98.0	96	2.0	10	●
VAPDSD0980	9.80	43.0	98.0	96	2.0	10	●
VAPDSD0990	9.90	43.1	98.1	96	2.1	10	●
VAPDSD1000	10.00	43.1	98.1	96	2.1	10	●
VAPDSD1010	10.10	43.1	103.1	101	2.1	12	●
VAPDSD1020	10.20	43.1	103.1	101	2.1	12	●
VAPDSD1030	10.30	43.1	103.1	101	2.1	12	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSD1040	10.40	43.2	103.2	101	2.2	12	●
VAPDSD1050	10.50	43.2	103.2	101	2.2	12	●
VAPDSD1060	10.60	43.2	103.2	101	2.2	12	●
VAPDSD1070	10.70	47.2	107.2	105	2.2	12	●
VAPDSD1080	10.80	47.2	107.2	105	2.2	12	●
VAPDSD1090	10.90	47.3	107.3	105	2.3	12	●
VAPDSD1100	11.00	47.3	107.3	105	2.3	12	●
VAPDSD1110	11.10	47.3	107.3	105	2.3	12	●
VAPDSD1120	11.20	47.3	107.3	105	2.3	12	●
VAPDSD1130	11.30	47.3	107.3	105	2.3	12	●
VAPDSD1140	11.40	47.4	107.4	105	2.4	12	●
VAPDSD1150	11.50	47.4	107.4	105	2.4	12	●
VAPDSD1160	11.60	47.4	107.4	105	2.4	12	●
VAPDSD1170	11.70	47.4	107.4	105	2.4	12	●
VAPDSD1180	11.80	47.4	107.4	105	2.4	12	●
VAPDSD1190	11.90	51.5	111.5	109	2.5	12	●
VAPDSD1200	12.0	51.5	111.5	109	2.5	12	●
VAPDSD1210	12.1	51.5	111.5	109	2.5	12	●
VAPDSD1220	12.2	51.5	111.5	109	2.5	12	●
VAPDSD1230	12.3	51.6	111.6	109	2.6	12	●
VAPDSD1240	12.4	51.6	111.6	109	2.6	12	●
VAPDSD1250	12.5	51.6	111.6	109	2.6	12	●
VAPDSD1260	12.6	51.6	111.6	109	2.6	12	●
VAPDSD1270	12.7	51.6	111.6	109	2.6	12	●
VAPDSD1280	12.8	51.7	111.7	109	2.7	12	●
VAPDSD1290	12.9	51.7	111.7	109	2.7	12	●
VAPDSD1300	13.0	51.7	111.7	109	2.7	12	●

CUTTING CONDITIONS ➤ P148
TECHNICAL DATA ➤ R001

VAPDS

Short, High precision

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel		Carbon Steel, Alloy Steel Cast Iron AISI 1049, SCM, FC		Alloy Tool Steel (Low-hardness Materials), Ferritic Stainless Steel, Martensitic Stainless Steel AISI 430, AISI 405, AISI D2, AISI 420, AISI 440		Alloy Tool Steel (−40HRC) Precipitation Hardening Stainless Steel AISI H13, ASTM 630, ASTM 631	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	18000	0.02	16000	0.02	9000	0.02	8200	0.02
1.0	12000	0.05	10000	0.05	6300	0.05	5500	0.04
2.0	6400	0.09	5500	0.09	3200	0.09	2900	0.05
3.0	4300	0.13	3700	0.13	2100	0.13	1900	0.06
4.0	3200	0.15	2800	0.15	1600	0.15	1400	0.08
5.0	2600	0.18	2200	0.18	1300	0.18	1100	0.10
6.0	2100	0.19	1800	0.19	1100	0.20	950	0.11
8.0	1600	0.24	1400	0.24	800	0.22	720	0.13
10.0	1300	0.28	1100	0.28	640	0.25	570	0.15
12.0	1100	0.34	930	0.34	530	0.30	480	0.17
13.0	980	0.36	860	0.36	490	0.32	440	0.19

Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) VAPDSSUS are recommended for austenitic stainless steels (AISI 304).
Note 5) When drilling holes greater than 4 x drill diameter hole depths, please use a peck feed.
Note 6) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

VAPDM

Medium, High precision

TOOL NEWS

HG HSS

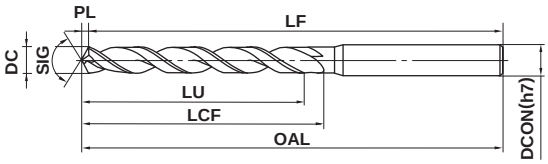
V

118° DC<2

135° DC≥2

X

P Steel | M Stainless Steel | K Cast Iron | N | S | H



*LU = LCF-2DC (Max 5×DC)

0.5≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤32
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

● Highly efficient drilling and long tool life have been achieved with the Violet coating.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD0050	0.50	6.2	50.2	50	0.15	3	●
VAPDMD0055	0.55	6.2	50.2	50	0.17	3	●
VAPDMD0060	0.60	8.2	50.2	50	0.18	3	●
VAPDMD0065	0.65	8.2	50.2	50	0.20	3	●
VAPDMD0070	0.70	10.2	50.2	50	0.21	3	●
VAPDMD0075	0.75	10.2	50.2	50	0.23	3	●
VAPDMD0080	0.80	10.2	50.2	50	0.24	3	●
VAPDMD0085	0.85	10.3	50.3	50	0.26	3	●
VAPDMD0090	0.90	12.3	50.3	50	0.27	3	●
VAPDMD0095	0.95	12.3	50.3	50	0.29	3	●
VAPDMD0100	1.00	12.3	60.3	60	0.3	3	●
VAPDMD0105	1.05	12.3	60.3	60	0.3	3	●
VAPDMD0110	1.10	16.3	60.3	60	0.3	3	●
VAPDMD0115	1.15	16.4	60.4	60	0.4	3	●
VAPDMD0120	1.20	16.4	60.4	60	0.4	3	●
VAPDMD0125	1.25	16.4	60.4	60	0.4	3	●
VAPDMD0130	1.30	16.4	60.4	60	0.4	3	●
VAPDMD0135	1.35	18.4	60.4	60	0.4	3	●
VAPDMD0140	1.40	18.4	60.4	60	0.4	3	●
VAPDMD0145	1.45	18.4	60.4	60	0.4	3	●
VAPDMD0150	1.50	18.5	60.5	60	0.5	3	●
VAPDMD0155	1.55	20.5	60.5	60	0.5	3	●
VAPDMD0160	1.60	20.5	60.5	60	0.5	3	●
VAPDMD0165	1.65	20.5	60.5	60	0.5	3	●
VAPDMD0170	1.70	20.5	60.5	60	0.5	3	●
VAPDMD0175	1.75	20.5	60.5	60	0.5	3	●
VAPDMD0180	1.80	22.5	60.5	60	0.5	3	●
VAPDMD0185	1.85	22.6	60.6	60	0.6	3	●
VAPDMD0190	1.90	22.6	60.6	60	0.6	3	●
VAPDMD0195	1.95	23.6	60.6	60	0.6	3	●
VAPDMD0200	2.00	23.4	70.4	70	0.4	3	●
VAPDMD0205	2.05	23.4	70.4	70	0.4	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD0210	2.10	23.4	70.4	70	0.4	3	●
VAPDMD0215	2.15	23.5	70.5	70	0.5	3	●
VAPDMD0220	2.20	26.5	70.5	70	0.5	3	●
VAPDMD0225	2.25	26.5	70.5	70	0.5	3	●
VAPDMD0230	2.30	26.5	70.5	70	0.5	3	●
VAPDMD0235	2.35	26.5	70.5	70	0.5	3	●
VAPDMD0240	2.40	29.5	70.5	70	0.5	3	●
VAPDMD0245	2.45	29.5	70.5	70	0.5	3	●
VAPDMD0250	2.50	29.5	70.5	70	0.5	3	●
VAPDMD0255	2.55	29.5	70.5	70	0.5	3	●
VAPDMD0260	2.60	29.5	70.5	70	0.5	3	●
VAPDMD0265	2.65	29.6	70.6	70	0.6	3	●
VAPDMD0270	2.70	32.6	70.6	70	0.6	3	●
VAPDMD0275	2.75	32.6	70.6	70	0.6	3	●
VAPDMD0280	2.80	32.6	70.6	70	0.6	3	●
VAPDMD0285	2.85	32.6	70.6	70	0.6	3	●
VAPDMD0290	2.90	32.6	70.6	70	0.6	3	●
VAPDMD0295	2.95	32.6	70.6	70	0.6	3	●
VAPDMD0300	3.00	32.6	70.6	70	0.6	3	●
VAPDMD0305	3.05	35.6	85.6	85	0.6	4	●
VAPDMD0310	3.10	35.6	85.6	85	0.6	4	●
VAPDMD0315	3.15	35.7	85.7	85	0.7	4	●
VAPDMD0320	3.20	35.7	85.7	85	0.7	4	●
VAPDMD0325	3.25	35.7	85.7	85	0.7	4	●
VAPDMD0330	3.30	35.7	85.7	85	0.7	4	●
VAPDMD0335	3.35	35.7	85.7	85	0.7	4	●
VAPDMD0340	3.40	38.7	85.7	85	0.7	4	●
VAPDMD0345	3.45	38.7	85.7	85	0.7	4	●
VAPDMD0350	3.50	38.7	85.7	85	0.7	4	●
VAPDMD0355	3.55	38.7	85.7	85	0.7	4	●
VAPDMD0360	3.60	38.8	85.8	85	0.8	4	●
VAPDMD0365	3.65	38.8	85.8	85	0.8	4	●

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P152
TECHNICAL DATA ➤ R001

VAPDM

Medium, High precision

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD0370	3.70	38.8	85.8	85	0.8	4	●
VAPDMD0375	3.75	42.8	85.8	85	0.8	4	●
VAPDMD0380	3.80	42.8	85.8	85	0.8	4	●
VAPDMD0385	3.85	42.8	85.8	85	0.8	4	●
VAPDMD0390	3.90	42.8	85.8	85	0.8	4	●
VAPDMD0395	3.95	42.8	85.8	85	0.8	4	●
VAPDMD0400	4.00	42.8	85.8	85	0.8	4	●
VAPDMD0405	4.05	42.8	100.8	100	0.8	6	●
VAPDMD0410	4.10	42.9	100.9	100	0.9	6	●
VAPDMD0415	4.15	42.9	100.9	100	0.9	6	●
VAPDMD0420	4.20	42.9	100.9	100	0.9	6	●
VAPDMD0425	4.25	46.9	100.9	100	0.9	6	●
VAPDMD0430	4.30	46.9	100.9	100	0.9	6	●
VAPDMD0435	4.35	46.9	100.9	100	0.9	6	●
VAPDMD0440	4.40	46.9	100.9	100	0.9	6	●
VAPDMD0445	4.45	46.9	100.9	100	0.9	6	●
VAPDMD0450	4.50	46.9	100.9	100	0.9	6	●
VAPDMD0455	4.55	46.9	100.9	100	0.9	6	●
VAPDMD0460	4.60	47.0	101.0	100	1.0	6	●
VAPDMD0465	4.65	47.0	101.0	100	1.0	6	●
VAPDMD0470	4.70	47.0	101.0	100	1.0	6	●
VAPDMD0475	4.75	47.0	101.0	100	1.0	6	●
VAPDMD0480	4.80	52.0	101.0	100	1.0	6	●
VAPDMD0485	4.85	52.0	101.0	100	1.0	6	●
VAPDMD0490	4.90	52.0	101.0	100	1.0	6	●
VAPDMD0495	4.95	52.0	101.0	100	1.0	6	●
VAPDMD0500	5.00	52.0	101.0	100	1.0	6	●
VAPDMD0505	5.05	52.1	101.1	100	1.1	6	●
VAPDMD0510	5.10	52.1	101.1	100	1.1	6	●
VAPDMD0515	5.15	52.1	101.1	100	1.1	6	●
VAPDMD0520	5.20	52.1	101.1	100	1.1	6	●
VAPDMD0525	5.25	52.1	101.1	100	1.1	6	●
VAPDMD0530	5.30	52.1	101.1	100	1.1	6	●
VAPDMD0535	5.35	57.1	107.1	106	1.1	6	●
VAPDMD0540	5.40	57.1	107.1	106	1.1	6	●
VAPDMD0545	5.45	57.1	107.1	106	1.1	6	●
VAPDMD0550	5.50	57.1	107.1	106	1.1	6	●
VAPDMD0555	5.55	57.2	107.2	106	1.2	6	●
VAPDMD0560	5.60	57.2	107.2	106	1.2	6	●
VAPDMD0565	5.65	57.2	107.2	106	1.2	6	●
VAPDMD0570	5.70	57.2	107.2	106	1.2	6	●
VAPDMD0575	5.75	57.2	107.2	106	1.2	6	●
VAPDMD0580	5.80	57.2	107.2	106	1.2	6	●
VAPDMD0585	5.85	57.2	107.2	106	1.2	6	●
VAPDMD0590	5.90	57.2	107.2	106	1.2	6	●
VAPDMD0595	5.95	57.2	107.2	106	1.2	6	●
VAPDMD0600	6.00	57.2	107.2	106	1.2	6	●
VAPDMD0605	6.05	63.3	113.3	112	1.3	8	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD0610	6.10	63.3	113.3	112	1.3	8	●
VAPDMD0615	6.15	63.3	113.3	112	1.3	8	●
VAPDMD0620	6.20	63.3	113.3	112	1.3	8	●
VAPDMD0625	6.25	63.3	113.3	112	1.3	8	●
VAPDMD0630	6.30	63.3	113.3	112	1.3	8	●
VAPDMD0635	6.35	63.3	113.3	112	1.3	8	●
VAPDMD0640	6.40	63.3	113.3	112	1.3	8	●
VAPDMD0645	6.45	63.3	113.3	112	1.3	8	●
VAPDMD0650	6.50	63.4	113.4	112	1.4	8	●
VAPDMD0655	6.55	63.4	113.4	112	1.4	8	●
VAPDMD0660	6.60	63.4	113.4	112	1.4	8	●
VAPDMD0665	6.65	63.4	113.4	112	1.4	8	●
VAPDMD0670	6.70	63.4	113.4	112	1.4	8	●
VAPDMD0675	6.75	68.4	118.4	117	1.4	8	●
VAPDMD0680	6.80	68.4	118.4	117	1.4	8	●
VAPDMD0685	6.85	68.4	118.4	117	1.4	8	●
VAPDMD0690	6.90	68.4	118.4	117	1.4	8	●
VAPDMD0695	6.95	68.4	118.4	117	1.4	8	●
VAPDMD0700	7.00	68.5	118.5	117	1.5	8	●
VAPDMD0705	7.05	68.5	118.5	117	1.5	8	●
VAPDMD0710	7.10	68.5	118.5	117	1.5	8	●
VAPDMD0715	7.15	68.5	118.5	117	1.5	8	●
VAPDMD0720	7.20	68.5	118.5	117	1.5	8	●
VAPDMD0725	7.25	68.5	118.5	117	1.5	8	●
VAPDMD0730	7.30	68.5	118.5	117	1.5	8	●
VAPDMD0735	7.35	68.5	118.5	117	1.5	8	●
VAPDMD0740	7.40	68.5	118.5	117	1.5	8	●
VAPDMD0745	7.45	68.5	118.5	117	1.5	8	●
VAPDMD0750	7.50	68.6	118.6	117	1.6	8	●
VAPDMD0755	7.55	74.6	124.6	123	1.6	8	●
VAPDMD0760	7.60	74.6	124.6	123	1.6	8	●
VAPDMD0765	7.65	74.6	124.6	123	1.6	8	●
VAPDMD0770	7.70	74.6	124.6	123	1.6	8	●
VAPDMD0775	7.75	74.6	124.6	123	1.6	8	●
VAPDMD0780	7.80	74.6	124.6	123	1.6	8	●
VAPDMD0785	7.85	74.6	124.6	123	1.6	8	●
VAPDMD0790	7.90	74.6	124.6	123	1.6	8	●
VAPDMD0795	7.95	74.7	124.7	123	1.7	8	●
VAPDMD0800	8.00	74.7	124.7	123	1.7	8	●
VAPDMD0805	8.05	74.7	129.7	128	1.7	10	●
VAPDMD0810	8.10	74.7	129.7	128	1.7	10	●
VAPDMD0815	8.15	74.7	129.7	128	1.7	10	●
VAPDMD0820	8.20	74.7	129.7	128	1.7	10	●
VAPDMD0825	8.25	74.7	129.7	128	1.7	10	●
VAPDMD0830	8.30	74.7	129.7	128	1.7	10	●
VAPDMD0835	8.35	74.7	129.7	128	1.7	10	●
VAPDMD0840	8.40	74.7	129.7	128	1.7	10	●
VAPDMD0845	8.45	74.8	129.8	128	1.8	10	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD0850	8.50	74.8	129.8	128	1.8	10	●
VAPDMD0855	8.55	80.8	135.8	134	1.8	10	●
VAPDMD0860	8.60	80.8	135.8	134	1.8	10	●
VAPDMD0865	8.65	80.8	135.8	134	1.8	10	●
VAPDMD0870	8.70	80.8	135.8	134	1.8	10	●
VAPDMD0875	8.75	80.8	135.8	134	1.8	10	●
VAPDMD0880	8.80	80.8	135.8	134	1.8	10	●
VAPDMD0885	8.85	80.8	135.8	134	1.8	10	●
VAPDMD0890	8.90	80.8	135.8	134	1.8	10	●
VAPDMD0895	8.95	80.9	135.9	134	1.9	10	●
VAPDMD0900	9.00	80.9	135.9	134	1.9	10	●
VAPDMD0910	9.10	80.9	135.9	134	1.9	10	●
VAPDMD0920	9.20	80.9	135.9	134	1.9	10	●
VAPDMD0930	9.30	80.9	135.9	134	1.9	10	●
VAPDMD0940	9.40	81.0	136.0	134	2.0	10	●
VAPDMD0950	9.50	81.0	136.0	134	2.0	10	●
VAPDMD0960	9.60	87.0	142.0	140	2.0	10	●
VAPDMD0970	9.70	87.0	142.0	140	2.0	10	●
VAPDMD0980	9.80	87.0	142.0	140	2.0	10	●
VAPDMD0990	9.90	87.1	142.1	140	2.1	10	●
VAPDMD1000	10.0	87.1	142.1	140	2.1	10	●
VAPDMD1010	10.1	87.1	147.1	145	2.1	12	●
VAPDMD1020	10.2	87.1	147.1	145	2.1	12	●
VAPDMD1030	10.3	87.1	147.1	145	2.1	12	●
VAPDMD1040	10.4	87.2	147.2	145	2.2	12	●
VAPDMD1050	10.5	87.2	147.2	145	2.2	12	●
VAPDMD1060	10.6	87.2	147.2	145	2.2	12	●
VAPDMD1070	10.7	94.2	154.2	152	2.2	12	●
VAPDMD1080	10.8	94.2	154.2	152	2.2	12	●
VAPDMD1090	10.9	94.3	154.3	152	2.3	12	●
VAPDMD1100	11.0	94.3	154.3	152	2.3	12	●
VAPDMD1110	11.1	94.3	154.3	152	2.3	12	●
VAPDMD1120	11.2	94.3	154.3	152	2.3	12	●
VAPDMD1130	11.3	94.3	154.3	152	2.3	12	●
VAPDMD1140	11.4	94.4	154.4	152	2.4	12	●
VAPDMD1150	11.5	94.4	154.4	152	2.4	12	●
VAPDMD1160	11.6	94.4	154.4	152	2.4	12	●
VAPDMD1170	11.7	94.4	154.4	152	2.4	12	●
VAPDMD1180	11.8	94.4	154.4	152	2.4	12	●
VAPDMD1190	11.9	101.5	161.5	159	2.5	12	●
VAPDMD1200	12.0	101.5	161.5	159	2.5	12	●
VAPDMD1210	12.1	101.5	161.5	159	2.5	12	●
VAPDMD1220	12.2	101.5	161.5	159	2.5	12	●
VAPDMD1230	12.3	101.6	161.6	159	2.6	12	●
VAPDMD1240	12.4	101.6	161.6	159	2.6	12	●
VAPDMD1250	12.5	101.6	161.6	159	2.6	12	●
VAPDMD1260	12.6	101.6	161.6	159	2.6	12	●
VAPDMD1270	12.7	101.6	161.6	159	2.6	12	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMD1280	12.8	101.7	161.7	159	2.7	12	●
VAPDMD1290	12.9	101.7	161.7	159	2.7	12	●
VAPDMD1300	13.0	101.7	161.7	159	2.7	12	●
VAPDMD1350	13.5	102.8	162.8	160	2.8	16	●
VAPDMD1400	14.0	102.9	162.9	160	2.9	16	●
VAPDMD1410	14.1	107.9	167.9	165	2.9	16	●
VAPDMD1420	14.2	107.9	167.9	165	2.9	16	●
VAPDMD1450	14.5	108.0	168.0	165	3.0	16	●
VAPDMD1500	15.0	108.1	168.1	165	3.1	16	●
VAPDMD1550	15.5	113.2	173.2	170	3.2	16	●
VAPDMD1560	15.6	113.2	173.2	170	3.2	16	●
VAPDMD1570	15.7	113.3	173.3	170	3.3	16	●
VAPDMD1600	16.0	113.3	173.3	170	3.3	16	●
VAPDMD1650	16.5	113.4	178.4	175	3.4	20	●
VAPDMD1700	17.0	113.5	178.5	175	3.5	20	●
VAPDMD1750	17.5	118.6	183.6	180	3.6	20	●
VAPDMD1760	17.6	118.7	183.7	180	3.7	20	●
VAPDMD1770	17.7	118.7	183.7	180	3.7	20	●
VAPDMD1800	18.0	118.7	183.7	180	3.7	20	●
VAPDMD1850	18.5	123.8	188.8	185	3.8	20	●
VAPDMD1900	19.0	123.9	188.9	185	3.9	20	●
VAPDMD1950	19.5	124.0	189.0	185	4.0	20	●
VAPDMD1960	19.6	124.1	189.1	185	4.1	20	●
VAPDMD1970	19.7	124.1	189.1	185	4.1	20	●
VAPDMD2000	20.0	124.1	189.1	185	4.1	20	●
VAPDMD2050	20.5	129.3	204.3	200	4.3	25	●
VAPDMD2100	21.0	129.4	204.4	200	4.4	25	●
VAPDMD2110	21.1	129.4	204.4	200	4.4	25	●
VAPDMD2120	21.2	129.4	204.4	200	4.4	25	●
VAPDMD2150	21.5	129.5	204.5	200	4.5	25	●
VAPDMD2200	22.0	129.6	204.6	200	4.6	25	●
VAPDMD2250	22.5	134.7	209.7	205	4.7	25	●
VAPDMD2300	23.0	134.8	209.8	205	4.8	25	●
VAPDMD2350	23.5	134.9	209.9	205	4.9	25	●
VAPDMD2400	24.0	140.0	215.0	210	5.0	25	●
VAPDMD2450	24.5	140.1	215.1	210	5.1	25	●
VAPDMD2500	25.0	140.2	215.2	210	5.2	25	●
VAPDMD2550	25.5	145.3	225.3	220	5.3	32	●
VAPDMD2600	26.0	145.4	225.4	220	5.4	32	●
VAPDMD2650	26.5	145.5	225.5	220	5.5	32	●
VAPDMD2700	27.0	145.6	225.6	220	5.6	32	●
VAPDMD2800	28.0	145.8	225.8	220	5.8	32	●
VAPDMD2900	29.0	151.0	231.0	225	6.0	32	●
VAPDMD3000	30.0	151.2	231.2	225	6.2	32	●
VAPDMD3100	31.0	156.4	236.4	230	6.4	32	●
VAPDMD3200	32.0	161.6	241.6	235	6.6	32	●

CUTTING CONDITIONS ➤ P152
TECHNICAL DATA ➤ R001

VAPDM

Medium, High precision

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel		Carbon Steel, Alloy Steel Cast Iron AISI 1049, SCM, FC		Alloy Tool Steel (Low-hardness Materials), Ferritic Stainless Steel, Martensitic Stainless Steel AISI 430, AISI 405, AISI D2, AISI 420, AISI 440		Alloy Tool Steel (−40HRC) Precipitation Hardening Stainless Steel AISI H13, ASTM 630, ASTM 631	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	17000	0.01	12800	0.01	8000	0.01	6600	0.01
1.0	11000	0.05	8300	0.05	5000	0.05	4100	0.04
2.0	6400	0.09	4800	0.09	2900	0.06	2400	0.05
3.0	4300	0.13	3200	0.13	1900	0.10	1600	0.06
4.0	3200	0.15	2400	0.15	1400	0.10	1200	0.08
5.0	2600	0.18	1900	0.18	1100	0.13	950	0.10
6.0	2100	0.19	1600	0.20	950	0.15	800	0.11
8.0	1600	0.24	1200	0.22	720	0.18	600	0.13
10.0	1300	0.28	950	0.25	570	0.21	480	0.15
12.0	1100	0.34	800	0.30	480	0.25	400	0.17
14.0	910	0.39	680	0.35	410	0.30	340	0.21
15.0	850	0.40	640	0.36	380	0.31	320	0.22
16.0	800	0.42	600	0.38	360	0.32	300	0.23
18.0	710	0.44	530	0.40	320	0.34	270	0.24
20.0	570	0.44	450	0.40	250	0.34	220	0.24
22.0	520	0.46	410	0.42	230	0.36	200	0.25
24.0	480	0.48	370	0.44	210	0.37	190	0.26
26.0	440	0.51	340	0.46	200	0.39	170	0.28
28.0	410	0.53	320	0.48	180	0.41	160	0.29
30.0	380	0.55	300	0.50	170	0.43	150	0.30
32.0	360	0.55	280	0.50	160	0.43	140	0.30

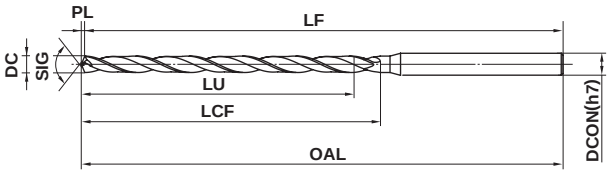
Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) VAPDMSUS are recommended for austenitic stainless steels (AISI 304).
Note 5) When drilling holes greater than 4 x drill diameter hole depths, please use a peck feed.
Note 6) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

VAPDJ NEW

Semi long, High precision

HG HSS | V | 118° DC<2 | 135° 2≤DC | X

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			



*LU = LCF-2DC (Max 10×DC)

0.5≤DC≤3	3<DC≤6	6<DC≤10
0 −0.014	0 −0.018	0 −0.022

● Long-lasting drill bits for stable, high accuracy, non-step drilling of deep L/D=10 holes

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDJD0100	1.0	18.3	66.3	66	0.3	3	●
VAPDJD0110	1.1	22.3	66.3	66	0.3	3	●
VAPDJD0120	1.2	22.4	66.4	66	0.4	3	●
VAPDJD0130	1.3	22.4	66.4	66	0.4	3	●
VAPDJD0140	1.4	24.4	66.4	66	0.4	3	●
VAPDJD0150	1.5	24.5	66.5	66	0.5	3	●
VAPDJD0160	1.6	30.5	71.5	71	0.5	3	●
VAPDJD0170	1.7	30.5	71.5	71	0.5	3	●
VAPDJD0180	1.8	33.5	71.5	71	0.5	3	●
VAPDJD0190	1.9	33.6	71.6	71	0.6	3	●
VAPDJD0200	2.0	36.4	81.4	81	0.4	3	●
VAPDJD0210	2.1	36.4	81.4	81	0.4	3	●
VAPDJD0220	2.2	36.5	81.5	81	0.5	3	●
VAPDJD0230	2.3	36.5	81.5	81	0.5	3	●
VAPDJD0240	2.4	39.5	81.5	81	0.5	3	●
VAPDJD0250	2.5	39.5	81.5	81	0.5	3	●
VAPDJD0260	2.6	39.5	81.5	81	0.5	3	●
VAPDJD0270	2.7	45.6	81.6	81	0.6	3	●
VAPDJD0280	2.8	45.6	81.6	81	0.6	3	●
VAPDJD0290	2.9	45.6	81.6	81	0.6	3	●
VAPDJD0300	3.0	45.6	81.6	81	0.6	3	●
VAPDJD0310	3.1	51.6	102.6	102	0.6	4	●
VAPDJD0320	3.2	51.7	102.7	102	0.7	4	●
VAPDJD0330	3.3	51.7	102.7	102	0.7	4	●
VAPDJD0340	3.4	54.7	102.7	102	0.7	4	●
VAPDJD0350	3.5	54.7	102.7	102	0.7	4	●
VAPDJD0360	3.6	57.8	102.8	102	0.8	4	●
VAPDJD0370	3.7	57.8	102.8	102	0.8	4	●
VAPDJD0380	3.8	60.8	102.8	102	0.8	4	●
VAPDJD0390	3.9	60.8	102.8	102	0.8	4	●
VAPDJD0400	4.0	60.8	102.8	102	0.8	4	●
VAPDJD0410	4.1	60.9	118.9	118	0.9	6	●
VAPDJD0420	4.2	60.9	118.9	118	0.9	6	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDJD0430	4.3	66.9	118.9	118	0.9	6	●
VAPDJD0440	4.4	66.9	118.9	118	0.9	6	●
VAPDJD0450	4.5	66.9	118.9	118	0.9	6	●
VAPDJD0460	4.6	67.0	122.0	121	1.0	6	●
VAPDJD0470	4.7	67.0	122.0	121	1.0	6	●
VAPDJD0480	4.8	73.0	122.0	121	1.0	6	●
VAPDJD0490	4.9	73.0	122.0	121	1.0	6	●
VAPDJD0500	5.0	73.0	122.0	121	1.0	6	●
VAPDJD0510	5.1	73.1	122.1	121	1.1	6	●
VAPDJD0520	5.2	73.1	122.1	121	1.1	6	●
VAPDJD0530	5.3	73.1	122.1	121	1.1	6	●
VAPDJD0540	5.4	79.1	129.1	128	1.1	6	●
VAPDJD0550	5.5	79.1	129.1	128	1.1	6	●
VAPDJD0560	5.6	79.2	129.2	128	1.2	6	●
VAPDJD0570	5.7	79.2	129.2	128	1.2	6	●
VAPDJD0580	5.8	79.2	129.2	128	1.2	6	●
VAPDJD0590	5.9	79.2	129.2	128	1.2	6	●
VAPDJD0600	6.0	79.2	129.2	128	1.2	6	●
VAPDJD0650	6.5	85.4	135.4	134	1.4	8	●
VAPDJD0680	6.8	91.4	141.4	140	1.4	8	●
VAPDJD0690	6.9	91.4	141.4	140	1.4	8	●
VAPDJD0700	7.0	91.5	141.5	140	1.5	8	●
VAPDJD0710	7.1	91.5	141.5	140	1.5	8	●
VAPDJD0750	7.5	91.6	141.6	140	1.6	8	●
VAPDJD0780	7.8	97.6	147.6	146	1.6	8	●
VAPDJD0790	7.9	97.6	147.6	146	1.6	8	●
VAPDJD0800	8.0	97.7	147.7	146	1.7	8	●
VAPDJD0850	8.5	103.8	158.8	157	1.8	10	●
VAPDJD0860	8.6	115.8	170.8	169	1.8	10	●
VAPDJD0900	9.0	115.9	170.9	169	1.9	10	●
VAPDJD0950	9.5	116.0	171.0	169	2.0	10	●
VAPDJD0960	9.6	122.0	177.0	175	2.0	10	●
VAPDJD1000	10.0	122.1	177.1	175	2.1	10	●

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P154
TECHNICAL DATA ➤ R001

VAPDJ

Semi long, High precision

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB) AISI 1010 etc.		Carbon Steel, Alloy Steel Gray Cast Iron AISI 1045, AISI 4140, AISI No 45 B etc.		Alloy Tool Steel (Low-hardness Materials) Ferritic Stainless Steel Martensitic Stainless Steel AISI D2, AISI 430, AISI 420, AISI 440 etc.		Alloy Tool Steel (—40HRC) AISI H13 etc.	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
1.0	7800	0.030	6000	0.030	3600	0.026	2400	0.018
1.2	6500	0.036	5000	0.036	3200	0.030	2000	0.022
1.6	5700	0.045	4400	0.045	2800	0.034	1760	0.024
2.0	5200	0.060	4000	0.060	2400	0.040	1600	0.030
2.5	4200	0.075	3200	0.075	1900	0.050	1280	0.037
3.2	3200	0.100	2500	0.100	1500	0.070	1000	0.050
4.0	2600	0.120	2000	0.120	1200	0.084	800	0.060
5.0	2100	0.150	1600	0.150	960	0.110	640	0.075
6.5	1600	0.180	1200	0.160	720	0.130	480	0.080
8.0	1300	0.200	1000	0.180	600	0.150	400	0.090
10.0	1000	0.240	800	0.220	480	0.180	320	0.110

Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) Depending on machining conditions, non-step machining may make chip ejection difficult, or cause chip elongation. In these cases, please use step processing. Step amount should be between DCx1 - DCx3.
Note 5) The cutting conditions mentioned above are standard when using water soluble coolant.
Lower the revolution when insoluble cutting fluid is used.
Note 6) If the revolution speed the intermediate diameter is not listed in the table, match it to the large diameter side and closest drill diameter conditions. Set the feed rate per revolution to a suitable value with the recommended feed rate of the closest drill diameter as the standard.

VAPDSSUS

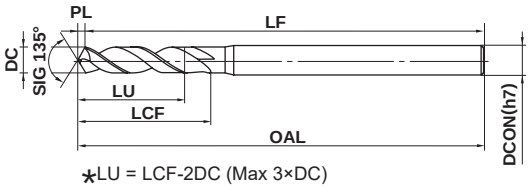
Short, High precision, For stainless steel

TOOL NEWS

DC≥1

HSS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



*LU = LCF-2DC (Max 3×DC)

0.5≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033

*All drills except those with intervals of 0.1mm and under dia. 4.0mm have a tolerance of 0—-0.009mm.

● Violet coating combination enable high efficiency drilling and long tool life for drilling of stainless steels.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0050	0.50	3.1	50.1	50	0.10	3	●
VAPDSSUSD0051	0.51	3.1	50.1	50	0.11	3	●
VAPDSSUSD0052	0.52	3.1	50.1	50	0.11	3	●
VAPDSSUSD0053	0.53	3.1	50.1	50	0.11	3	●
VAPDSSUSD0054	0.54	3.1	50.1	50	0.11	3	●
VAPDSSUSD0055	0.55	3.1	50.1	50	0.11	3	●
VAPDSSUSD0056	0.56	4.1	50.1	50	0.12	3	●
VAPDSSUSD0057	0.57	4.1	50.1	50	0.12	3	●
VAPDSSUSD0058	0.58	4.1	50.1	50	0.12	3	●
VAPDSSUSD0059	0.59	4.1	50.1	50	0.12	3	●
VAPDSSUSD0060	0.60	5.1	50.1	50	0.12	3	●
VAPDSSUSD0061	0.61	5.1	50.1	50	0.13	3	●
VAPDSSUSD0062	0.62	5.1	50.1	50	0.13	3	●
VAPDSSUSD0063	0.63	5.1	50.1	50	0.13	3	●
VAPDSSUSD0064	0.64	5.1	50.1	50	0.13	3	●
VAPDSSUSD0065	0.65	5.1	50.1	50	0.13	3	●
VAPDSSUSD0066	0.66	5.1	50.1	50	0.14	3	●
VAPDSSUSD0067	0.67	5.1	50.1	50	0.14	3	●
VAPDSSUSD0068	0.68	5.1	50.1	50	0.14	3	●
VAPDSSUSD0069	0.69	5.1	50.1	50	0.14	3	●
VAPDSSUSD0070	0.70	5.1	50.1	50	0.14	3	●
VAPDSSUSD0071	0.71	5.2	50.2	50	0.15	3	●
VAPDSSUSD0072	0.72	5.2	50.2	50	0.15	3	●
VAPDSSUSD0073	0.73	5.2	50.2	50	0.15	3	●
VAPDSSUSD0074	0.74	5.2	50.2	50	0.15	3	●
VAPDSSUSD0075	0.75	5.2	50.2	50	0.16	3	●
VAPDSSUSD0076	0.76	5.2	50.2	50	0.16	3	●
VAPDSSUSD0077	0.77	5.2	50.2	50	0.16	3	●
VAPDSSUSD0078	0.78	5.2	50.2	50	0.16	3	●
VAPDSSUSD0079	0.79	5.2	50.2	50	0.16	3	●
VAPDSSUSD0080	0.80	5.2	50.2	50	0.17	3	●
VAPDSSUSD0081	0.81	5.2	50.2	50	0.17	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0082	0.82	5.2	50.2	50	0.17	3	●
VAPDSSUSD0083	0.83	5.2	50.2	50	0.17	3	●
VAPDSSUSD0084	0.84	5.2	50.2	50	0.17	3	●
VAPDSSUSD0085	0.85	5.2	50.2	50	0.18	3	●
VAPDSSUSD0086	0.86	6.2	50.2	50	0.18	3	●
VAPDSSUSD0087	0.87	6.2	50.2	50	0.18	3	●
VAPDSSUSD0088	0.88	6.2	50.2	50	0.18	3	●
VAPDSSUSD0089	0.89	6.2	50.2	50	0.18	3	●
VAPDSSUSD0090	0.90	6.2	50.2	50	0.19	3	●
VAPDSSUSD0091	0.91	6.2	50.2	50	0.19	3	●
VAPDSSUSD0092	0.92	6.2	50.2	50	0.19	3	●
VAPDSSUSD0093	0.93	6.2	50.2	50	0.19	3	●
VAPDSSUSD0094	0.94	6.2	50.2	50	0.19	3	●
VAPDSSUSD0095	0.95	6.2	50.2	50	0.20	3	●
VAPDSSUSD0096	0.96	6.2	50.2	50	0.20	3	●
VAPDSSUSD0097	0.97	6.2	50.2	50	0.20	3	●
VAPDSSUSD0098	0.98	6.2	50.2	50	0.20	3	●
VAPDSSUSD0099	0.99	6.2	50.2	50	0.21	3	●
VAPDSSUSD0100	1.00	6.2	50.2	50	0.2	3	●
VAPDSSUSD0101	1.01	6.2	50.2	50	0.2	3	●
VAPDSSUSD0102	1.02	6.2	50.2	50	0.2	3	●
VAPDSSUSD0103	1.03	6.2	50.2	50	0.2	3	●
VAPDSSUSD0104	1.04	6.2	50.2	50	0.2	3	●
VAPDSSUSD0105	1.05	6.2	50.2	50	0.2	3	●
VAPDSSUSD0106	1.06	6.2	50.2	50	0.2	3	●
VAPDSSUSD0107	1.07	8.2	55.2	55	0.2	3	●
VAPDSSUSD0108	1.08	8.2	55.2	55	0.2	3	●
VAPDSSUSD0109	1.09	8.2	55.2	55	0.2	3	●
VAPDSSUSD0110	1.10	8.2	55.2	55	0.2	3	●
VAPDSSUSD0111	1.11	8.2	55.2	55	0.2	3	●
VAPDSSUSD0112	1.12	8.2	55.2	55	0.2	3	●
VAPDSSUSD0113	1.13	8.2	55.2	55	0.2	3	●

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDSSUS

Short, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0114	1.14	8.2	55.2	55	0.2	3	●
VAPDSSUSD0115	1.15	8.2	55.2	55	0.2	3	●
VAPDSSUSD0116	1.16	8.2	55.2	55	0.2	3	●
VAPDSSUSD0117	1.17	8.2	55.2	55	0.2	3	●
VAPDSSUSD0118	1.18	8.2	55.2	55	0.2	3	●
VAPDSSUSD0119	1.19	8.3	55.3	55	0.3	3	●
VAPDSSUSD0120	1.20	8.3	55.3	55	0.3	3	●
VAPDSSUSD0121	1.21	8.3	55.3	55	0.3	3	●
VAPDSSUSD0122	1.22	8.3	55.3	55	0.3	3	●
VAPDSSUSD0123	1.23	8.3	55.3	55	0.3	3	●
VAPDSSUSD0124	1.24	8.3	55.3	55	0.3	3	●
VAPDSSUSD0125	1.25	8.3	55.3	55	0.3	3	●
VAPDSSUSD0126	1.26	8.3	55.3	55	0.3	3	●
VAPDSSUSD0127	1.27	8.3	55.3	55	0.3	3	●
VAPDSSUSD0128	1.28	8.3	55.3	55	0.3	3	●
VAPDSSUSD0129	1.29	8.3	55.3	55	0.3	3	●
VAPDSSUSD0130	1.30	9.3	55.3	55	0.3	3	●
VAPDSSUSD0131	1.31	9.3	55.3	55	0.3	3	●
VAPDSSUSD0132	1.32	9.3	55.3	55	0.3	3	●
VAPDSSUSD0133	1.33	9.3	55.3	55	0.3	3	●
VAPDSSUSD0134	1.34	9.3	55.3	55	0.3	3	●
VAPDSSUSD0135	1.35	9.3	55.3	55	0.3	3	●
VAPDSSUSD0136	1.36	9.3	55.3	55	0.3	3	●
VAPDSSUSD0137	1.37	9.3	55.3	55	0.3	3	●
VAPDSSUSD0138	1.38	9.3	55.3	55	0.3	3	●
VAPDSSUSD0139	1.39	9.3	55.3	55	0.3	3	●
VAPDSSUSD0140	1.40	9.3	55.3	55	0.3	3	●
VAPDSSUSD0141	1.41	9.3	55.3	55	0.3	3	●
VAPDSSUSD0142	1.42	9.3	55.3	55	0.3	3	●
VAPDSSUSD0143	1.43	9.3	55.3	55	0.3	3	●
VAPDSSUSD0144	1.44	9.3	55.3	55	0.3	3	●
VAPDSSUSD0145	1.45	9.3	55.3	55	0.3	3	●
VAPDSSUSD0146	1.46	9.3	55.3	55	0.3	3	●
VAPDSSUSD0147	1.47	9.3	55.3	55	0.3	3	●
VAPDSSUSD0148	1.48	9.3	55.3	55	0.3	3	●
VAPDSSUSD0149	1.49	9.3	55.3	55	0.3	3	●
VAPDSSUSD0150	1.50	9.3	55.3	55	0.3	3	●
VAPDSSUSD0151	1.51	11.3	55.3	55	0.3	3	●
VAPDSSUSD0152	1.52	11.3	55.3	55	0.3	3	●
VAPDSSUSD0153	1.53	11.3	55.3	55	0.3	3	●
VAPDSSUSD0154	1.54	11.3	55.3	55	0.3	3	●
VAPDSSUSD0155	1.55	11.3	55.3	55	0.3	3	●
VAPDSSUSD0156	1.56	11.3	55.3	55	0.3	3	●
VAPDSSUSD0157	1.57	11.3	55.3	55	0.3	3	●
VAPDSSUSD0158	1.58	11.3	55.3	55	0.3	3	●
VAPDSSUSD0159	1.59	11.3	55.3	55	0.3	3	●
VAPDSSUSD0160	1.60	11.3	55.3	55	0.3	3	●
VAPDSSUSD0161	1.61	11.3	55.3	55	0.3	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0162	1.62	11.3	55.3	55	0.3	3	●
VAPDSSUSD0163	1.63	11.3	55.3	55	0.3	3	●
VAPDSSUSD0164	1.64	11.3	55.3	55	0.3	3	●
VAPDSSUSD0165	1.65	11.3	55.3	55	0.3	3	●
VAPDSSUSD0166	1.66	11.3	55.3	55	0.3	3	●
VAPDSSUSD0167	1.67	11.4	55.4	55	0.4	3	●
VAPDSSUSD0168	1.68	11.4	55.4	55	0.4	3	●
VAPDSSUSD0169	1.69	11.4	55.4	55	0.4	3	●
VAPDSSUSD0170	1.70	11.4	55.4	55	0.4	3	●
VAPDSSUSD0171	1.71	11.4	55.4	55	0.4	3	●
VAPDSSUSD0172	1.72	11.4	55.4	55	0.4	3	●
VAPDSSUSD0173	1.73	11.4	55.4	55	0.4	3	●
VAPDSSUSD0174	1.74	11.4	55.4	55	0.4	3	●
VAPDSSUSD0175	1.75	11.4	55.4	55	0.4	3	●
VAPDSSUSD0176	1.76	11.4	55.4	55	0.4	3	●
VAPDSSUSD0177	1.77	11.4	55.4	55	0.4	3	●
VAPDSSUSD0178	1.78	11.4	55.4	55	0.4	3	●
VAPDSSUSD0179	1.79	11.4	55.4	55	0.4	3	●
VAPDSSUSD0180	1.80	11.4	55.4	55	0.4	3	●
VAPDSSUSD0181	1.81	11.4	55.4	55	0.4	3	●
VAPDSSUSD0182	1.82	11.4	55.4	55	0.4	3	●
VAPDSSUSD0183	1.83	11.4	55.4	55	0.4	3	●
VAPDSSUSD0184	1.84	11.4	55.4	55	0.4	3	●
VAPDSSUSD0185	1.85	11.4	55.4	55	0.4	3	●
VAPDSSUSD0186	1.86	11.4	55.4	55	0.4	3	●
VAPDSSUSD0187	1.87	11.4	55.4	55	0.4	3	●
VAPDSSUSD0188	1.88	11.4	55.4	55	0.4	3	●
VAPDSSUSD0189	1.89	11.4	55.4	55	0.4	3	●
VAPDSSUSD0190	1.90	12.4	55.4	55	0.4	3	●
VAPDSSUSD0191	1.91	12.4	60.4	60	0.4	3	●
VAPDSSUSD0192	1.92	12.4	60.4	60	0.4	3	●
VAPDSSUSD0193	1.93	12.4	60.4	60	0.4	3	●
VAPDSSUSD0194	1.94	12.4	60.4	60	0.4	3	●
VAPDSSUSD0195	1.95	12.4	60.4	60	0.4	3	●
VAPDSSUSD0196	1.96	12.4	60.4	60	0.4	3	●
VAPDSSUSD0197	1.97	12.4	60.4	60	0.4	3	●
VAPDSSUSD0198	1.98	12.4	60.4	60	0.4	3	●
VAPDSSUSD0199	1.99	12.4	60.4	60	0.4	3	●
VAPDSSUSD0200	2.00	12.4	60.4	60	0.4	3	●
VAPDSSUSD0201	2.01	12.4	60.4	60	0.4	3	●
VAPDSSUSD0202	2.02	12.4	60.4	60	0.4	3	●
VAPDSSUSD0203	2.03	12.4	60.4	60	0.4	3	●
VAPDSSUSD0204	2.04	12.4	60.4	60	0.4	3	●
VAPDSSUSD0205	2.05	12.4	60.4	60	0.4	3	●
VAPDSSUSD0206	2.06	12.4	60.4	60	0.4	3	●
VAPDSSUSD0207	2.07	12.4	60.4	60	0.4	3	●
VAPDSSUSD0208	2.08	12.4	60.4	60	0.4	3	●
VAPDSSUSD0209	2.09	12.4	60.4	60	0.4	3	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0210	2.10	12.4	60.4	60	0.4	3	●
VAPDSSUSD0211	2.11	12.4	60.4	60	0.4	3	●
VAPDSSUSD0212	2.12	12.4	60.4	60	0.4	3	●
VAPDSSUSD0213	2.13	12.4	60.4	60	0.4	3	●
VAPDSSUSD0214	2.14	12.4	60.4	60	0.4	3	●
VAPDSSUSD0215	2.15	12.5	60.5	60	0.5	3	●
VAPDSSUSD0216	2.16	12.5	60.5	60	0.5	3	●
VAPDSSUSD0217	2.17	12.5	60.5	60	0.5	3	●
VAPDSSUSD0218	2.18	12.5	60.5	60	0.5	3	●
VAPDSSUSD0219	2.19	12.5	60.5	60	0.5	3	●
VAPDSSUSD0220	2.20	12.5	60.5	60	0.5	3	●
VAPDSSUSD0221	2.21	12.5	60.5	60	0.5	3	●
VAPDSSUSD0222	2.22	12.5	60.5	60	0.5	3	●
VAPDSSUSD0223	2.23	12.5	60.5	60	0.5	3	●
VAPDSSUSD0224	2.24	12.5	60.5	60	0.5	3	●
VAPDSSUSD0225	2.25	12.5	60.5	60	0.5	3	●
VAPDSSUSD0226	2.26	12.5	60.5	60	0.5	3	●
VAPDSSUSD0227	2.27	12.5	60.5	60	0.5	3	●
VAPDSSUSD0228	2.28	12.5	60.5	60	0.5	3	●
VAPDSSUSD0229	2.29	12.5	60.5	60	0.5	3	●
VAPDSSUSD0230	2.30	13.5	60.5	60	0.5	3	●
VAPDSSUSD0231	2.31	13.5	60.5	60	0.5	3	●
VAPDSSUSD0232	2.32	13.5	60.5	60	0.5	3	●
VAPDSSUSD0233	2.33	13.5	60.5	60	0.5	3	●
VAPDSSUSD0234	2.34	13.5	60.5	60	0.5	3	●
VAPDSSUSD0235	2.35	13.5	60.5	60	0.5	3	●
VAPDSSUSD0236	2.36	13.5	60.5	60	0.5	3	●
VAPDSSUSD0237	2.37	13.5	60.5	60	0.5	3	●
VAPDSSUSD0238	2.38	13.5	60.5	60	0.5	3	●
VAPDSSUSD0239	2.39	13.5	60.5	60	0.5	3	●
VAPDSSUSD0240	2.40	13.5	60.5	60	0.5	3	●
VAPDSSUSD0241	2.41	13.5	60.5	60	0.5	3	●
VAPDSSUSD0242	2.42	13.5	60.5	60	0.5	3	●
VAPDSSUSD0243	2.43	13.5	60.5	60	0.5	3	●
VAPDSSUSD0244	2.44	13.5	60.5	60	0.5	3	●
VAPDSSUSD0245	2.45	13.5	60.5	60	0.5	3	●
VAPDSSUSD0246	2.46	13.5	60.5	60	0.5	3	●
VAPDSSUSD0247	2.47	13.5	60.5	60	0.5	3	●
VAPDSSUSD0248	2.48	13.5	60.5	60	0.5	3	●
VAPDSSUSD0249	2.49	13.5	60.5	60	0.5	3	●
VAPDSSUSD0250	2.50	13.5	60.5	60	0.5	3	●
VAPDSSUSD0251	2.51	13.5	60.5	60	0.5	3	●
VAPDSSUSD0252	2.52	13.5	60.5	60	0.5	3	●
VAPDSSUSD0253	2.53	13.5	60.5	60	0.5	3	●
VAPDSSUSD0254	2.54	13.5	60.5	60	0.5	3	●
VAPDSSUSD0255	2.55	13.5	60.5	60	0.5	3	●
VAPDSSUSD0256	2.56	13.5	60.5	60	0.5	3	●
VAPDSSUSD0257	2.57	13.5	60.5	60	0.5	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0258	2.58	13.5	60.5	60	0.5	3	●
VAPDSSUSD0259	2.59	13.5	60.5	60	0.5	3	●
VAPDSSUSD0260	2.60	15.5	60.5	60	0.5	3	●
VAPDSSUSD0261	2.61	15.5	60.5	60	0.5	3	●
VAPDSSUSD0262	2.62	15.5	60.5	60	0.5	3	●
VAPDSSUSD0263	2.63	15.5	60.5	60	0.5	3	●
VAPDSSUSD0264	2.64	15.6	60.6	60	0.6	3	●
VAPDSSUSD0265	2.65	15.6	60.6	60	0.6	3	●
VAPDSSUSD0266	2.66	15.6	60.6	60	0.6	3	●
VAPDSSUSD0267	2.67	15.6	60.6	60	0.6	3	●
VAPDSSUSD0268	2.68	15.6	60.6	60	0.6	3	●
VAPDSSUSD0269	2.69	15.6	60.6	60	0.6	3	●
VAPDSSUSD0270	2.70	15.6	60.6	60	0.6	3	●
VAPDSSUSD0271	2.71	15.6	60.6	60	0.6	3	●
VAPDSSUSD0272	2.72	15.6	60.6	60	0.6	3	●
VAPDSSUSD0273	2.73	15.6	60.6	60	0.6	3	●
VAPDSSUSD0274	2.74	15.6	60.6	60	0.6	3	●
VAPDSSUSD0275	2.75	15.6	60.6	60	0.6	3	●
VAPDSSUSD0276	2.76	15.6	60.6	60	0.6	3	●
VAPDSSUSD0277	2.77	15.6	60.6	60	0.6	3	●
VAPDSSUSD0278	2.78	15.6	60.6	60	0.6	3	●
VAPDSSUSD0279	2.79	15.6	60.6	60	0.6	3	●
VAPDSSUSD0280	2.80	15.6	60.6	60	0.6	3	●
VAPDSSUSD0281	2.81	15.6	60.6	60	0.6	3	●
VAPDSSUSD0282	2.82	15.6	60.6	60	0.6	3	●
VAPDSSUSD0283	2.83	15.6	60.6	60	0.6	3	●
VAPDSSUSD0284	2.84	15.6	60.6	60	0.6	3	●
VAPDSSUSD0285	2.85	15.6	60.6	60	0.6	3	●
VAPDSSUSD0286	2.86	15.6	60.6	60	0.6	3	●
VAPDSSUSD0287	2.87	15.6	60.6	60	0.6	3	●
VAPDSSUSD0288	2.88	15.6	60.6	60	0.6	3	●
VAPDSSUSD0289	2.89	15.6	60.6	60	0.6	3	●
VAPDSSUSD0290	2.90	15.6	60.6	60	0.6	3	●
VAPDSSUSD0291	2.91	15.6	60.6	60	0.6	3	●
VAPDSSUSD0292	2.92	15.6	60.6	60	0.6	3	●
VAPDSSUSD0293	2.93	15.6	60.6	60	0.6	3	●
VAPDSSUSD0294	2.94	15.6	60.6	60	0.6	3	●
VAPDSSUSD0295	2.95	15.6	60.6	60	0.6	3	●
VAPDSSUSD0296	2.96	15.6	60.6	60	0.6	3	●
VAPDSSUSD0297	2.97	15.6	60.6	60	0.6	3	●
VAPDSSUSD0298	2.98	15.6	60.6	60	0.6	3	●
VAPDSSUSD0299	2.99	15.6	60.6	60	0.6	3	●
VAPDSSUSD0300	3.00	15.6	60.6	60	0.6	3	●
VAPDSSUSD0301	3.01	17.6	70.6	70	0.6	4	●
VAPDSSUSD0302	3.02	17.6	70.6	70	0.6	4	●
VAPDSSUSD0303	3.03	17.6	70.6	70	0.6	4	●
VAPDSSUSD0304	3.04	17.6	70.6	70	0.6	4	●
VAPDSSUSD0305	3.05	17.6	70.6	70	0.6	4	●

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDSSUS

Short, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0306	3.06	17.6	70.6	70	0.6	4	●
VAPDSSUSD0307	3.07	17.6	70.6	70	0.6	4	●
VAPDSSUSD0308	3.08	17.6	70.6	70	0.6	4	●
VAPDSSUSD0309	3.09	17.6	70.6	70	0.6	4	●
VAPDSSUSD0310	3.10	17.6	70.6	70	0.6	4	●
VAPDSSUSD0311	3.11	17.6	70.6	70	0.6	4	●
VAPDSSUSD0312	3.12	17.7	70.7	70	0.7	4	●
VAPDSSUSD0313	3.13	17.7	70.7	70	0.7	4	●
VAPDSSUSD0314	3.14	17.7	70.7	70	0.7	4	●
VAPDSSUSD0315	3.15	17.7	70.7	70	0.7	4	●
VAPDSSUSD0316	3.16	17.7	70.7	70	0.7	4	●
VAPDSSUSD0317	3.17	17.7	70.7	70	0.7	4	●
VAPDSSUSD0318	3.18	17.7	70.7	70	0.7	4	●
VAPDSSUSD0319	3.19	17.7	70.7	70	0.7	4	●
VAPDSSUSD0320	3.20	17.7	70.7	70	0.7	4	●
VAPDSSUSD0321	3.21	17.7	70.7	70	0.7	4	●
VAPDSSUSD0322	3.22	17.7	70.7	70	0.7	4	●
VAPDSSUSD0323	3.23	17.7	70.7	70	0.7	4	●
VAPDSSUSD0324	3.24	17.7	70.7	70	0.7	4	●
VAPDSSUSD0325	3.25	17.7	70.7	70	0.7	4	●
VAPDSSUSD0326	3.26	17.7	70.7	70	0.7	4	●
VAPDSSUSD0327	3.27	17.7	70.7	70	0.7	4	●
VAPDSSUSD0328	3.28	17.7	70.7	70	0.7	4	●
VAPDSSUSD0329	3.29	17.7	70.7	70	0.7	4	●
VAPDSSUSD0330	3.30	19.7	70.7	70	0.7	4	●
VAPDSSUSD0331	3.31	19.7	70.7	70	0.7	4	●
VAPDSSUSD0332	3.32	19.7	70.7	70	0.7	4	●
VAPDSSUSD0333	3.33	19.7	70.7	70	0.7	4	●
VAPDSSUSD0334	3.34	19.7	70.7	70	0.7	4	●
VAPDSSUSD0335	3.35	19.7	70.7	70	0.7	4	●
VAPDSSUSD0336	3.36	19.7	70.7	70	0.7	4	●
VAPDSSUSD0337	3.37	19.7	70.7	70	0.7	4	●
VAPDSSUSD0338	3.38	19.7	70.7	70	0.7	4	●
VAPDSSUSD0339	3.39	19.7	70.7	70	0.7	4	●
VAPDSSUSD0340	3.40	19.7	70.7	70	0.7	4	●
VAPDSSUSD0341	3.41	19.7	70.7	70	0.7	4	●
VAPDSSUSD0342	3.42	19.7	70.7	70	0.7	4	●
VAPDSSUSD0343	3.43	19.7	70.7	70	0.7	4	●
VAPDSSUSD0344	3.44	19.7	70.7	70	0.7	4	●
VAPDSSUSD0345	3.45	19.7	70.7	70	0.7	4	●
VAPDSSUSD0346	3.46	19.7	70.7	70	0.7	4	●
VAPDSSUSD0347	3.47	19.7	70.7	70	0.7	4	●
VAPDSSUSD0348	3.48	19.7	70.7	70	0.7	4	●
VAPDSSUSD0349	3.49	19.7	70.7	70	0.7	4	●
VAPDSSUSD0350	3.50	19.7	70.7	70	0.7	4	●
VAPDSSUSD0351	3.51	19.7	70.7	70	0.7	4	●
VAPDSSUSD0352	3.52	19.7	70.7	70	0.7	4	●
VAPDSSUSD0353	3.53	19.7	70.7	70	0.7	4	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0354	3.54	19.7	70.7	70	0.7	4	●
VAPDSSUSD0355	3.55	19.7	70.7	70	0.7	4	●
VAPDSSUSD0356	3.56	19.7	70.7	70	0.7	4	●
VAPDSSUSD0357	3.57	19.7	70.7	70	0.7	4	●
VAPDSSUSD0358	3.58	19.7	70.7	70	0.7	4	●
VAPDSSUSD0359	3.59	19.7	70.7	70	0.7	4	●
VAPDSSUSD0360	3.60	21.8	70.8	70	0.8	4	●
VAPDSSUSD0361	3.61	21.8	70.8	70	0.8	4	●
VAPDSSUSD0362	3.62	21.8	70.8	70	0.8	4	●
VAPDSSUSD0363	3.63	21.8	70.8	70	0.8	4	●
VAPDSSUSD0364	3.64	21.8	70.8	70	0.8	4	●
VAPDSSUSD0365	3.65	21.8	70.8	70	0.8	4	●
VAPDSSUSD0366	3.66	21.8	70.8	70	0.8	4	●
VAPDSSUSD0367	3.67	21.8	70.8	70	0.8	4	●
VAPDSSUSD0368	3.68	21.8	70.8	70	0.8	4	●
VAPDSSUSD0369	3.69	21.8	70.8	70	0.8	4	●
VAPDSSUSD0370	3.70	21.8	70.8	70	0.8	4	●
VAPDSSUSD0371	3.71	21.8	70.8	70	0.8	4	●
VAPDSSUSD0372	3.72	21.8	70.8	70	0.8	4	●
VAPDSSUSD0373	3.73	21.8	70.8	70	0.8	4	●
VAPDSSUSD0374	3.74	21.8	70.8	70	0.8	4	●
VAPDSSUSD0375	3.75	21.8	70.8	70	0.8	4	●
VAPDSSUSD0376	3.76	21.8	70.8	70	0.8	4	●
VAPDSSUSD0377	3.77	21.8	70.8	70	0.8	4	●
VAPDSSUSD0378	3.78	21.8	70.8	70	0.8	4	●
VAPDSSUSD0379	3.79	21.8	70.8	70	0.8	4	●
VAPDSSUSD0380	3.80	21.8	70.8	70	0.8	4	●
VAPDSSUSD0381	3.81	21.8	70.8	70	0.8	4	●
VAPDSSUSD0382	3.82	21.8	70.8	70	0.8	4	●
VAPDSSUSD0383	3.83	21.8	70.8	70	0.8	4	●
VAPDSSUSD0384	3.84	21.8	70.8	70	0.8	4	●
VAPDSSUSD0385	3.85	21.8	70.8	70	0.8	4	●
VAPDSSUSD0386	3.86	21.8	70.8	70	0.8	4	●
VAPDSSUSD0387	3.87	21.8	70.8	70	0.8	4	●
VAPDSSUSD0388	3.88	21.8	70.8	70	0.8	4	●
VAPDSSUSD0389	3.89	21.8	70.8	70	0.8	4	●
VAPDSSUSD0390	3.90	21.8	70.8	70	0.8	4	●
VAPDSSUSD0391	3.91	21.8	70.8	70	0.8	4	●
VAPDSSUSD0392	3.92	21.8	70.8	70	0.8	4	●
VAPDSSUSD0393	3.93	21.8	70.8	70	0.8	4	●
VAPDSSUSD0394	3.94	21.8	70.8	70	0.8	4	●
VAPDSSUSD0395	3.95	21.8	70.8	70	0.8	4	●
VAPDSSUSD0396	3.96	21.8	70.8	70	0.8	4	●
VAPDSSUSD0397	3.97	21.8	70.8	70	0.8	4	●
VAPDSSUSD0398	3.98	21.8	70.8	70	0.8	4	●
VAPDSSUSD0399	3.99	21.8	70.8	70	0.8	4	●
VAPDSSUSD0400	4.00	21.8	70.8	70	0.8	4	●
VAPDSSUSD0405	4.05	21.8	80.8	80	0.8	6	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0410	4.10	21.9	80.9	80	0.9	6	●
VAPDSSUSD0415	4.15	21.9	80.9	80	0.9	6	●
VAPDSSUSD0420	4.20	21.9	80.9	80	0.9	6	●
VAPDSSUSD0425	4.25	21.9	80.9	80	0.9	6	●
VAPDSSUSD0430	4.30	23.9	80.9	80	0.9	6	●
VAPDSSUSD0435	4.35	23.9	80.9	80	0.9	6	●
VAPDSSUSD0440	4.40	23.9	80.9	80	0.9	6	●
VAPDSSUSD0445	4.45	23.9	80.9	80	0.9	6	●
VAPDSSUSD0450	4.50	23.9	80.9	80	0.9	6	●
VAPDSSUSD0455	4.55	23.9	80.9	80	0.9	6	●
VAPDSSUSD0460	4.60	26.0	81.0	80	1.0	6	●
VAPDSSUSD0465	4.65	26.0	81.0	80	1.0	6	●
VAPDSSUSD0470	4.70	26.0	81.0	80	1.0	6	●
VAPDSSUSD0475	4.75	26.0	81.0	80	1.0	6	●
VAPDSSUSD0480	4.80	26.0	81.0	80	1.0	6	●
VAPDSSUSD0485	4.85	26.0	81.0	80	1.0	6	●
VAPDSSUSD0490	4.90	26.0	81.0	80	1.0	6	●
VAPDSSUSD0495	4.95	26.0	81.0	80	1.0	6	●
VAPDSSUSD0500	5.00	26.0	81.0	80	1.0	6	●
VAPDSSUSD0505	5.05	26.1	81.1	80	1.1	6	●
VAPDSSUSD0510	5.10	26.1	81.1	80	1.1	6	●
VAPDSSUSD0515	5.15	26.1	81.1	80	1.1	6	●
VAPDSSUSD0520	5.20	26.1	81.1	80	1.1	6	●
VAPDSSUSD0525	5.25	26.1	81.1	80	1.1	6	●
VAPDSSUSD0530	5.30	26.1	81.1	80	1.1	6	●
VAPDSSUSD0535	5.35	28.1	81.1	80	1.1	6	●
VAPDSSUSD0540	5.40	28.1	81.1	80	1.1	6	●
VAPDSSUSD0545	5.45	28.1	81.1	80	1.1	6	●
VAPDSSUSD0550	5.50	28.1	81.1	80	1.1	6	●
VAPDSSUSD0555	5.55	28.2	81.2	80	1.2	6	●
VAPDSSUSD0560	5.60	28.2	81.2	80	1.2	6	●
VAPDSSUSD0565	5.65	28.2	81.2	80	1.2	6	●
VAPDSSUSD0570	5.70	28.2	81.2	80	1.2	6	●
VAPDSSUSD0575	5.75	28.2	81.2	80	1.2	6	●
VAPDSSUSD0580	5.80	28.2	81.2	80	1.2	6	●
VAPDSSUSD0585	5.85	28.2	81.2	80	1.2	6	●
VAPDSSUSD0590	5.90	28.2	81.2	80	1.2	6	●
VAPDSSUSD0595	5.95	28.2	81.2	80	1.2	6	●
VAPDSSUSD0600	6.00	28.2	81.2	80	1.2	6	●
VAPDSSUSD0605	6.05	31.3	81.3	80	1.3	8	●
VAPDSSUSD0610	6.10	31.3	81.3	80	1.3	8	●
VAPDSSUSD0615	6.15	31.3	81.3	80	1.3	8	●
VAPDSSUSD0620	6.20	31.3	81.3	80	1.3	8	●
VAPDSSUSD0625	6.25	31.3	81.3	80	1.3	8	●
VAPDSSUSD0630	6.30	31.3	81.3	80	1.3	8	●
VAPDSSUSD0635	6.35	31.3	81.3	80	1.3	8	●
VAPDSSUSD0640	6.40	31.3	81.3	80	1.3	8	●
VAPDSSUSD0645	6.45	31.3	81.3	80	1.3	8	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0650	6.50	31.4	81.4	80	1.4	8	●
VAPDSSUSD0655	6.55	31.4	81.4	80	1.4	8	●
VAPDSSUSD0660	6.60	31.4	81.4	80	1.4	8	●
VAPDSSUSD0665	6.65	31.4	81.4	80	1.4	8	●
VAPDSSUSD0670	6.70	31.4	81.4	80	1.4	8	●
VAPDSSUSD0675	6.75	33.4	81.4	80	1.4	8	●
VAPDSSUSD0680	6.80	33.4	81.4	80	1.4	8	●
VAPDSSUSD0685	6.85	33.4	81.4	80	1.4	8	●
VAPDSSUSD0690	6.90	33.4	81.4	80	1.4	8	●
VAPDSSUSD0695	6.95	33.4	81.4	80	1.4	8	●
VAPDSSUSD0700	7.00	33.5	81.5	80	1.5	8	●
VAPDSSUSD0705	7.05	33.5	81.5	80	1.5	8	●
VAPDSSUSD0710	7.10	33.5	81.5	80	1.5	8	●
VAPDSSUSD0715	7.15	33.5	81.5	80	1.5	8	●
VAPDSSUSD0720	7.20	33.5	81.5	80	1.5	8	●
VAPDSSUSD0725	7.25	33.5	81.5	80	1.5	8	●
VAPDSSUSD0730	7.30	33.5	81.5	80	1.5	8	●
VAPDSSUSD0735	7.35	33.5	81.5	80	1.5	8	●
VAPDSSUSD0740	7.40	33.5	81.5	80	1.5	8	●
VAPDSSUSD0745	7.45	33.5	81.5	80	1.5	8	●
VAPDSSUSD0750	7.50	33.6	81.6	80	1.6	8	●
VAPDSSUSD0755	7.55	36.6	86.6	85	1.6	8	●
VAPDSSUSD0760	7.60	36.6	86.6	85	1.6	8	●
VAPDSSUSD0765	7.65	36.6	86.6	85	1.6	8	●
VAPDSSUSD0770	7.70	36.6	86.6	85	1.6	8	●
VAPDSSUSD0775	7.75	36.6	86.6	85	1.6	8	●
VAPDSSUSD0780	7.80	36.6	86.6	85	1.6	8	●
VAPDSSUSD0785	7.85	36.6	86.6	85	1.6	8	●
VAPDSSUSD0790	7.90	36.6	86.6	85	1.6	8	●
VAPDSSUSD0795	7.95	36.7	86.7	85	1.7	8	●
VAPDSSUSD0800	8.00	36.7	86.7	85	1.7	8	●
VAPDSSUSD0805	8.05	36.7	91.7	90	1.7	10	●
VAPDSSUSD0810	8.10	36.7	91.7	90	1.7	10	●
VAPDSSUSD0815	8.15	36.7	91.7	90	1.7	10	●
VAPDSSUSD0820	8.20	36.7	91.7	90	1.7	10	●
VAPDSSUSD0825	8.25	36.7	91.7	90	1.7	10	●
VAPDSSUSD0830	8.30	36.7	91.7	90	1.7	10	●
VAPDSSUSD0835	8.35	36.7	91.7	90	1.7	10	●
VAPDSSUSD0840	8.40	36.7	91.7	90	1.7	10	●
VAPDSSUSD0845	8.45	36.8	91.8	90	1.8	10	●
VAPDSSUSD0850	8.50	36.8	91.8	90	1.8	10	●
VAPDSSUSD0855	8.55	39.8	94.8	93	1.8	10	●
VAPDSSUSD0860	8.60	39.8	94.8	93	1.8	10	●
VAPDSSUSD0865	8.65	39.8	94.8	93	1.8	10	●
VAPDSSUSD0870	8.70	39.8	94.8	93	1.8	10	●
VAPDSSUSD0875	8.75	39.8	94.8	93	1.8	10	●
VAPDSSUSD0880	8.80	39.8	94.8	93	1.8	10	●
VAPDSSUSD0885	8.85	39.8	94.8	93	1.8	10	●

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDSSUS

Short, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD0890	8.90	39.8	94.8	93	1.8	10	●
VAPDSSUSD0895	8.95	39.9	94.9	93	1.9	10	●
VAPDSSUSD0900	9.00	39.9	94.9	93	1.9	10	●
VAPDSSUSD0910	9.10	39.9	94.9	93	1.9	10	●
VAPDSSUSD0920	9.20	39.9	94.9	93	1.9	10	●
VAPDSSUSD0930	9.30	39.9	94.9	93	1.9	10	●
VAPDSSUSD0940	9.40	40.0	95.0	93	2.0	10	●
VAPDSSUSD0950	9.50	40.0	95.0	93	2.0	10	●
VAPDSSUSD0960	9.60	43.0	98.0	96	2.0	10	●
VAPDSSUSD0970	9.70	43.0	98.0	96	2.0	10	●
VAPDSSUSD0980	9.80	43.0	98.0	96	2.0	10	●
VAPDSSUSD0990	9.90	43.1	98.1	96	2.1	10	●
VAPDSSUSD1000	10.0	43.1	98.1	96	2.1	10	●
VAPDSSUSD1010	10.1	43.1	103.1	101	2.1	12	●
VAPDSSUSD1020	10.2	43.1	103.1	101	2.1	12	●
VAPDSSUSD1030	10.3	43.1	103.1	101	2.1	12	●
VAPDSSUSD1040	10.4	43.2	103.2	101	2.2	12	●
VAPDSSUSD1050	10.5	43.2	103.2	101	2.2	12	●
VAPDSSUSD1060	10.6	43.2	103.2	101	2.2	12	●
VAPDSSUSD1070	10.7	47.2	107.2	105	2.2	12	●
VAPDSSUSD1080	10.8	47.2	107.2	105	2.2	12	●
VAPDSSUSD1090	10.9	47.3	107.3	105	2.3	12	●
VAPDSSUSD1100	11.0	47.3	107.3	105	2.3	12	●
VAPDSSUSD1110	11.1	47.3	107.3	105	2.3	12	●
VAPDSSUSD1120	11.2	47.3	107.3	105	2.3	12	●
VAPDSSUSD1130	11.3	47.3	107.3	105	2.3	12	●
VAPDSSUSD1140	11.4	47.4	107.4	105	2.4	12	●
VAPDSSUSD1150	11.5	47.4	107.4	105	2.4	12	●
VAPDSSUSD1160	11.6	47.4	107.4	105	2.4	12	●
VAPDSSUSD1170	11.7	47.4	107.4	105	2.4	12	●
VAPDSSUSD1180	11.8	47.4	107.4	105	2.4	12	●
VAPDSSUSD1190	11.9	51.5	111.5	109	2.5	12	●
VAPDSSUSD1200	12.0	51.5	111.5	109	2.5	12	●
VAPDSSUSD1210	12.1	51.5	111.5	109	2.5	12	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDSSUSD1220	12.2	51.5	111.5	109	2.5	12	●
VAPDSSUSD1230	12.3	51.6	111.6	109	2.6	12	●
VAPDSSUSD1240	12.4	51.6	111.6	109	2.6	12	●
VAPDSSUSD1250	12.5	51.6	111.6	109	2.6	12	●
VAPDSSUSD1260	12.6	51.6	111.6	109	2.6	12	●
VAPDSSUSD1270	12.7	51.6	111.6	109	2.6	12	●
VAPDSSUSD1280	12.8	51.7	111.7	109	2.7	12	●
VAPDSSUSD1290	12.9	51.7	111.7	109	2.7	12	●
VAPDSSUSD1300	13.0	51.7	111.7	109	2.7	12	●
VAPDSSUSD1350	13.5	53.8	113.8	111	2.8	16	●
VAPDSSUSD1400	14.0	53.9	113.9	111	2.9	16	●
VAPDSSUSD1410	14.1	55.9	115.9	113	2.9	16	●
VAPDSSUSD1420	14.2	55.9	115.9	113	2.9	16	●
VAPDSSUSD1450	14.5	56.0	116.0	113	3.0	16	●
VAPDSSUSD1500	15.0	56.1	116.1	113	3.1	16	●
VAPDSSUSD1550	15.5	58.2	118.2	115	3.2	16	●
VAPDSSUSD1560	15.6	58.2	118.2	115	3.2	16	●
VAPDSSUSD1570	15.7	58.3	118.3	115	3.3	16	●
VAPDSSUSD1600	16.0	58.3	118.3	115	3.3	16	●
VAPDSSUSD1650	16.5	60.4	125.4	122	3.4	20	●
VAPDSSUSD1700	17.0	60.5	125.5	122	3.5	20	●
VAPDSSUSD1750	17.5	61.6	126.6	123	3.6	20	●
VAPDSSUSD1760	17.6	61.7	126.7	123	3.7	20	●
VAPDSSUSD1770	17.7	61.7	126.7	123	3.7	20	●
VAPDSSUSD1800	18.0	61.7	126.7	123	3.7	20	●
VAPDSSUSD1850	18.5	63.8	128.8	125	3.8	20	●
VAPDSSUSD1900	19.0	63.9	128.9	125	3.9	20	●
VAPDSSUSD1950	19.5	66.0	131.0	127	4.0	20	●
VAPDSSUSD1960	19.6	66.1	131.1	127	4.1	20	●
VAPDSSUSD1970	19.7	66.1	131.1	127	4.1	20	●
VAPDSSUSD2000	20.0	66.1	131.1	127	4.1	20	●

● : Inventory maintained in Japan.

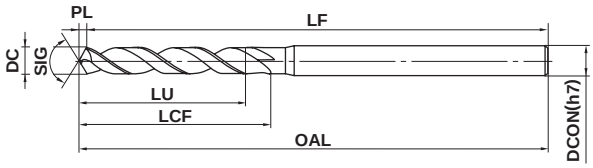
CUTTING CONDITIONS ➢ P167

VAPDMSUS

Medium, High precision, For stainless steel

TOOL NEWS | CO HSS | V | 118° DC<4 | 135° DC≥4 | X DC≥1

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat Resistant Alloy	



*LU = LCF-2DC (Max 5×DC)

0.5≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

*All drills except those with intervals of 0.1mm and under dia. 4.0mm have a tolerance of 0—-0.009mm.

● Violet coating combination enable high efficiency drilling and long tool life for drilling of stainless steels.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0050	0.50	6.2	50.2	50	0.15	3	●
VAPDMSUSD0051	0.51	6.2	50.2	50	0.15	3	●
VAPDMSUSD0052	0.52	6.2	50.2	50	0.16	3	●
VAPDMSUSD0053	0.53	6.2	50.2	50	0.16	3	●
VAPDMSUSD0054	0.54	6.2	50.2	50	0.16	3	●
VAPDMSUSD0055	0.55	6.2	50.2	50	0.17	3	●
VAPDMSUSD0056	0.56	8.2	50.2	50	0.17	3	●
VAPDMSUSD0057	0.57	8.2	50.2	50	0.17	3	●
VAPDMSUSD0058	0.58	8.2	50.2	50	0.17	3	●
VAPDMSUSD0059	0.59	8.2	50.2	50	0.18	3	●
VAPDMSUSD0060	0.60	8.2	50.2	50	0.18	3	●
VAPDMSUSD0061	0.61	8.2	50.2	50	0.18	3	●
VAPDMSUSD0062	0.62	8.2	50.2	50	0.19	3	●
VAPDMSUSD0063	0.63	8.2	50.2	50	0.19	3	●
VAPDMSUSD0064	0.64	8.2	50.2	50	0.19	3	●
VAPDMSUSD0065	0.65	8.2	50.2	50	0.20	3	●
VAPDMSUSD0066	0.66	8.2	50.2	50	0.20	3	●
VAPDMSUSD0067	0.67	8.2	50.2	50	0.20	3	●
VAPDMSUSD0068	0.68	8.2	50.2	50	0.20	3	●
VAPDMSUSD0069	0.69	8.2	50.2	50	0.21	3	●
VAPDMSUSD0070	0.70	10.2	50.2	50	0.21	3	●
VAPDMSUSD0071	0.71	10.2	50.2	50	0.21	3	●
VAPDMSUSD0072	0.72	10.2	50.2	50	0.22	3	●
VAPDMSUSD0073	0.73	10.2	50.2	50	0.22	3	●
VAPDMSUSD0074	0.74	10.2	50.2	50	0.22	3	●
VAPDMSUSD0075	0.75	10.2	50.2	50	0.23	3	●
VAPDMSUSD0076	0.76	10.2	50.2	50	0.23	3	●
VAPDMSUSD0077	0.77	10.2	50.2	50	0.23	3	●
VAPDMSUSD0078	0.78	10.2	50.2	50	0.23	3	●
VAPDMSUSD0079	0.79	10.2	50.2	50	0.24	3	●
VAPDMSUSD0080	0.80	10.2	50.2	50	0.24	3	●
VAPDMSUSD0081	0.81	10.2	50.2	50	0.24	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0082	0.82	10.3	50.3	50	0.25	3	●
VAPDMSUSD0083	0.83	10.3	50.3	50	0.25	3	●
VAPDMSUSD0084	0.84	10.3	50.3	50	0.25	3	●
VAPDMSUSD0085	0.85	10.3	50.3	50	0.26	3	●
VAPDMSUSD0086	0.86	12.3	50.3	50	0.26	3	●
VAPDMSUSD0087	0.87	12.3	50.3	50	0.26	3	●
VAPDMSUSD0088	0.88	12.3	50.3	50	0.26	3	●
VAPDMSUSD0089	0.89	12.3	50.3	50	0.27	3	●
VAPDMSUSD0090	0.90	12.3	50.3	50	0.27	3	●
VAPDMSUSD0091	0.91	12.3	50.3	50	0.27	3	●
VAPDMSUSD0092	0.92	12.3	50.3	50	0.28	3	●
VAPDMSUSD0093	0.93	12.3	50.3	50	0.28	3	●
VAPDMSUSD0094	0.94	12.3	50.3	50	0.28	3	●
VAPDMSUSD0095	0.95	12.3	50.3	50	0.29	3	●
VAPDMSUSD0096	0.96	12.3	50.3	50	0.29	3	●
VAPDMSUSD0097	0.97	12.3	50.3	50	0.29	3	●
VAPDMSUSD0098	0.98	12.3	50.3	50	0.29	3	●
VAPDMSUSD0099	0.99	12.3	50.3	50	0.3	3	●
VAPDMSUSD0100	1.00	12.3	60.3	60	0.3	3	●
VAPDMSUSD0101	1.01	12.3	60.3	60	0.3	3	●
VAPDMSUSD0102	1.02	12.3	60.3	60	0.3	3	●
VAPDMSUSD0103	1.03	12.3	60.3	60	0.3	3	●
VAPDMSUSD0104	1.04	12.3	60.3	60	0.3	3	●
VAPDMSUSD0105	1.05	12.3	60.3	60	0.3	3	●
VAPDMSUSD0106	1.06	12.3	60.3	60	0.3	3	●
VAPDMSUSD0107	1.07	16.3	60.3	60	0.3	3	●
VAPDMSUSD0108	1.08	16.3	60.3	60	0.3	3	●
VAPDMSUSD0109	1.09	16.3	60.3	60	0.3	3	●
VAPDMSUSD0110	1.10	16.3	60.3	60	0.3	3	●
VAPDMSUSD0111	1.11	16.3	60.3	60	0.3	3	●
VAPDMSUSD0112	1.12	16.3	60.3	60	0.3	3	●
VAPDMSUSD0113	1.13	16.3	60.3	60	0.3	3	●

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDMSUS

Medium, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0114	1.14	16.3	60.3	60	0.3	3	●
VAPDMSUSD0115	1.15	16.4	60.4	60	0.4	3	●
VAPDMSUSD0116	1.16	16.4	60.4	60	0.4	3	●
VAPDMSUSD0117	1.17	16.4	60.4	60	0.4	3	●
VAPDMSUSD0118	1.18	16.4	60.4	60	0.4	3	●
VAPDMSUSD0119	1.19	16.4	60.4	60	0.4	3	●
VAPDMSUSD0120	1.20	16.4	60.4	60	0.4	3	●
VAPDMSUSD0121	1.21	16.4	60.4	60	0.4	3	●
VAPDMSUSD0122	1.22	16.4	60.4	60	0.4	3	●
VAPDMSUSD0123	1.23	16.4	60.4	60	0.4	3	●
VAPDMSUSD0124	1.24	16.4	60.4	60	0.4	3	●
VAPDMSUSD0125	1.25	16.4	60.4	60	0.4	3	●
VAPDMSUSD0126	1.26	16.4	60.4	60	0.4	3	●
VAPDMSUSD0127	1.27	16.4	60.4	60	0.4	3	●
VAPDMSUSD0128	1.28	16.4	60.4	60	0.4	3	●
VAPDMSUSD0129	1.29	16.4	60.4	60	0.4	3	●
VAPDMSUSD0130	1.30	16.4	60.4	60	0.4	3	●
VAPDMSUSD0131	1.31	18.4	60.4	60	0.4	3	●
VAPDMSUSD0132	1.32	18.4	60.4	60	0.4	3	●
VAPDMSUSD0133	1.33	18.4	60.4	60	0.4	3	●
VAPDMSUSD0134	1.34	18.4	60.4	60	0.4	3	●
VAPDMSUSD0135	1.35	18.4	60.4	60	0.4	3	●
VAPDMSUSD0136	1.36	18.4	60.4	60	0.4	3	●
VAPDMSUSD0137	1.37	18.4	60.4	60	0.4	3	●
VAPDMSUSD0138	1.38	18.4	60.4	60	0.4	3	●
VAPDMSUSD0139	1.39	18.4	60.4	60	0.4	3	●
VAPDMSUSD0140	1.40	18.4	60.4	60	0.4	3	●
VAPDMSUSD0141	1.41	18.4	60.4	60	0.4	3	●
VAPDMSUSD0142	1.42	18.4	60.4	60	0.4	3	●
VAPDMSUSD0143	1.43	18.4	60.4	60	0.4	3	●
VAPDMSUSD0144	1.44	18.4	60.4	60	0.4	3	●
VAPDMSUSD0145	1.45	18.4	60.4	60	0.4	3	●
VAPDMSUSD0146	1.46	18.4	60.4	60	0.4	3	●
VAPDMSUSD0147	1.47	18.4	60.4	60	0.4	3	●
VAPDMSUSD0148	1.48	18.4	60.4	60	0.4	3	●
VAPDMSUSD0149	1.49	18.5	60.5	60	0.5	3	●
VAPDMSUSD0150	1.50	18.5	60.5	60	0.5	3	●
VAPDMSUSD0151	1.51	20.5	60.5	60	0.5	3	●
VAPDMSUSD0152	1.52	20.5	60.5	60	0.5	3	●
VAPDMSUSD0153	1.53	20.5	60.5	60	0.5	3	●
VAPDMSUSD0154	1.54	20.5	60.5	60	0.5	3	●
VAPDMSUSD0155	1.55	20.5	60.5	60	0.5	3	●
VAPDMSUSD0156	1.56	20.5	60.5	60	0.5	3	●
VAPDMSUSD0157	1.57	20.5	60.5	60	0.5	3	●
VAPDMSUSD0158	1.58	20.5	60.5	60	0.5	3	●
VAPDMSUSD0159	1.59	20.5	60.5	60	0.5	3	●
VAPDMSUSD0160	1.60	20.5	60.5	60	0.5	3	●
VAPDMSUSD0161	1.61	20.5	60.5	60	0.5	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0162	1.62	20.5	60.5	60	0.5	3	●
VAPDMSUSD0163	1.63	20.5	60.5	60	0.5	3	●
VAPDMSUSD0164	1.64	20.5	60.5	60	0.5	3	●
VAPDMSUSD0165	1.65	20.5	60.5	60	0.5	3	●
VAPDMSUSD0166	1.66	20.5	60.5	60	0.5	3	●
VAPDMSUSD0167	1.67	20.5	60.5	60	0.5	3	●
VAPDMSUSD0168	1.68	20.5	60.5	60	0.5	3	●
VAPDMSUSD0169	1.69	20.5	60.5	60	0.5	3	●
VAPDMSUSD0170	1.70	20.5	60.5	60	0.5	3	●
VAPDMSUSD0171	1.71	20.5	60.5	60	0.5	3	●
VAPDMSUSD0172	1.72	20.5	60.5	60	0.5	3	●
VAPDMSUSD0173	1.73	20.5	60.5	60	0.5	3	●
VAPDMSUSD0174	1.74	20.5	60.5	60	0.5	3	●
VAPDMSUSD0175	1.75	20.5	60.5	60	0.5	3	●
VAPDMSUSD0176	1.76	20.5	60.5	60	0.5	3	●
VAPDMSUSD0177	1.77	20.5	60.5	60	0.5	3	●
VAPDMSUSD0178	1.78	20.5	60.5	60	0.5	3	●
VAPDMSUSD0179	1.79	20.5	60.5	60	0.5	3	●
VAPDMSUSD0180	1.80	22.5	60.5	60	0.5	3	●
VAPDMSUSD0181	1.81	22.5	60.5	60	0.5	3	●
VAPDMSUSD0182	1.82	22.6	60.6	60	0.6	3	●
VAPDMSUSD0183	1.83	22.6	60.6	60	0.6	3	●
VAPDMSUSD0184	1.84	22.6	60.6	60	0.6	3	●
VAPDMSUSD0185	1.85	22.6	60.6	60	0.6	3	●
VAPDMSUSD0186	1.86	22.6	60.6	60	0.6	3	●
VAPDMSUSD0187	1.87	22.6	60.6	60	0.6	3	●
VAPDMSUSD0188	1.88	22.6	60.6	60	0.6	3	●
VAPDMSUSD0189	1.89	22.6	60.6	60	0.6	3	●
VAPDMSUSD0190	1.90	22.6	60.6	60	0.6	3	●
VAPDMSUSD0191	1.91	23.6	60.6	60	0.6	3	●
VAPDMSUSD0192	1.92	23.6	60.6	60	0.6	3	●
VAPDMSUSD0193	1.93	23.6	60.6	60	0.6	3	●
VAPDMSUSD0194	1.94	23.6	60.6	60	0.6	3	●
VAPDMSUSD0195	1.95	23.6	60.6	60	0.6	3	●
VAPDMSUSD0196	1.96	23.6	60.6	60	0.6	3	●
VAPDMSUSD0197	1.97	23.6	60.6	60	0.6	3	●
VAPDMSUSD0198	1.98	23.6	60.6	60	0.6	3	●
VAPDMSUSD0199	1.99	23.6	60.6	60	0.6	3	●
VAPDMSUSD0200	2.00	23.6	70.6	70	0.6	3	●
VAPDMSUSD0201	2.01	23.6	70.6	70	0.6	3	●
VAPDMSUSD0202	2.02	23.6	70.6	70	0.6	3	●
VAPDMSUSD0203	2.03	23.6	70.6	70	0.6	3	●
VAPDMSUSD0204	2.04	23.6	70.6	70	0.6	3	●
VAPDMSUSD0205	2.05	23.6	70.6	70	0.6	3	●
VAPDMSUSD0206	2.06	23.6	70.6	70	0.6	3	●
VAPDMSUSD0207	2.07	23.6	70.6	70	0.6	3	●
VAPDMSUSD0208	2.08	23.6	70.6	70	0.6	3	●
VAPDMSUSD0209	2.09	23.6	70.6	70	0.6	3	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0210	2.10	23.6	70.6	70	0.6	3	●
VAPDMSUSD0211	2.11	23.6	70.6	70	0.6	3	●
VAPDMSUSD0212	2.12	23.6	70.6	70	0.6	3	●
VAPDMSUSD0213	2.13	23.6	70.6	70	0.6	3	●
VAPDMSUSD0214	2.14	23.6	70.6	70	0.6	3	●
VAPDMSUSD0215	2.15	23.7	70.7	70	0.7	3	●
VAPDMSUSD0216	2.16	23.7	70.7	70	0.7	3	●
VAPDMSUSD0217	2.17	23.7	70.7	70	0.7	3	●
VAPDMSUSD0218	2.18	23.7	70.7	70	0.7	3	●
VAPDMSUSD0219	2.19	23.7	70.7	70	0.7	3	●
VAPDMSUSD0220	2.20	26.7	70.7	70	0.7	3	●
VAPDMSUSD0221	2.21	26.7	70.7	70	0.7	3	●
VAPDMSUSD0222	2.22	26.7	70.7	70	0.7	3	●
VAPDMSUSD0223	2.23	26.7	70.7	70	0.7	3	●
VAPDMSUSD0224	2.24	26.7	70.7	70	0.7	3	●
VAPDMSUSD0225	2.25	26.7	70.7	70	0.7	3	●
VAPDMSUSD0226	2.26	26.7	70.7	70	0.7	3	●
VAPDMSUSD0227	2.27	26.7	70.7	70	0.7	3	●
VAPDMSUSD0228	2.28	26.7	70.7	70	0.7	3	●
VAPDMSUSD0229	2.29	26.7	70.7	70	0.7	3	●
VAPDMSUSD0230	2.30	26.7	70.7	70	0.7	3	●
VAPDMSUSD0231	2.31	26.7	70.7	70	0.7	3	●
VAPDMSUSD0232	2.32	26.7	70.7	70	0.7	3	●
VAPDMSUSD0233	2.33	26.7	70.7	70	0.7	3	●
VAPDMSUSD0234	2.34	26.7	70.7	70	0.7	3	●
VAPDMSUSD0235	2.35	26.7	70.7	70	0.7	3	●
VAPDMSUSD0236	2.36	26.7	70.7	70	0.7	3	●
VAPDMSUSD0237	2.37	26.7	70.7	70	0.7	3	●
VAPDMSUSD0238	2.38	26.7	70.7	70	0.7	3	●
VAPDMSUSD0239	2.39	26.7	70.7	70	0.7	3	●
VAPDMSUSD0240	2.40	29.7	70.7	70	0.7	3	●
VAPDMSUSD0241	2.41	29.7	70.7	70	0.7	3	●
VAPDMSUSD0242	2.42	29.7	70.7	70	0.7	3	●
VAPDMSUSD0243	2.43	29.7	70.7	70	0.7	3	●
VAPDMSUSD0244	2.44	29.7	70.7	70	0.7	3	●
VAPDMSUSD0245	2.45	29.7	70.7	70	0.7	3	●
VAPDMSUSD0246	2.46	29.7	70.7	70	0.7	3	●
VAPDMSUSD0247	2.47	29.7	70.7	70	0.7	3	●
VAPDMSUSD0248	2.48	29.8	70.8	70	0.8	3	●
VAPDMSUSD0249	2.49	29.8	70.8	70	0.8	3	●
VAPDMSUSD0250	2.50	29.8	70.8	70	0.8	3	●
VAPDMSUSD0251	2.51	29.8	70.8	70	0.8	3	●
VAPDMSUSD0252	2.52	29.8	70.8	70	0.8	3	●
VAPDMSUSD0253	2.53	29.8	70.8	70	0.8	3	●
VAPDMSUSD0254	2.54	29.8	70.8	70	0.8	3	●
VAPDMSUSD0255	2.55	29.8	70.8	70	0.8	3	●
VAPDMSUSD0256	2.56	29.8	70.8	70	0.8	3	●
VAPDMSUSD0257	2.57	29.8	70.8	70	0.8	3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0258	2.58	29.8	70.8	70	0.8	3	●
VAPDMSUSD0259	2.59	29.8	70.8	70	0.8	3	●
VAPDMSUSD0260	2.60	29.8	70.8	70	0.8	3	●
VAPDMSUSD0261	2.61	29.8	70.8	70	0.8	3	●
VAPDMSUSD0262	2.62	29.8	70.8	70	0.8	3	●
VAPDMSUSD0263	2.63	29.8	70.8	70	0.8	3	●
VAPDMSUSD0264	2.64	29.8	70.8	70	0.8	3	●
VAPDMSUSD0265	2.65	29.8	70.8	70	0.8	3	●
VAPDMSUSD0266	2.66	29.8	70.8	70	0.8	3	●
VAPDMSUSD0267	2.67	29.8	70.8	70	0.8	3	●
VAPDMSUSD0268	2.68	29.8	70.8	70	0.8	3	●
VAPDMSUSD0269	2.69	29.8	70.8	70	0.8	3	●
VAPDMSUSD0270	2.70	32.8	70.8	70	0.8	3	●
VAPDMSUSD0271	2.71	32.8	70.8	70	0.8	3	●
VAPDMSUSD0272	2.72	32.8	70.8	70	0.8	3	●
VAPDMSUSD0273	2.73	32.8	70.8	70	0.8	3	●
VAPDMSUSD0274	2.74	32.8	70.8	70	0.8	3	●
VAPDMSUSD0275	2.75	32.8	70.8	70	0.8	3	●
VAPDMSUSD0276	2.76	32.8	70.8	70	0.8	3	●
VAPDMSUSD0277	2.77	32.8	70.8	70	0.8	3	●
VAPDMSUSD0278	2.78	32.8	70.8	70	0.8	3	●
VAPDMSUSD0279	2.79	32.8	70.8	70	0.8	3	●
VAPDMSUSD0280	2.80	32.8	70.8	70	0.8	3	●
VAPDMSUSD0281	2.81	32.8	70.8	70	0.8	3	●
VAPDMSUSD0282	2.82	32.9	70.9	70	0.9	3	●
VAPDMSUSD0283	2.83	32.9	70.9	70	0.9	3	●
VAPDMSUSD0284	2.84	32.9	70.9	70	0.9	3	●
VAPDMSUSD0285	2.85	32.9	70.9	70	0.9	3	●
VAPDMSUSD0286	2.86	32.9	70.9	70	0.9	3	●
VAPDMSUSD0287	2.87	32.9	70.9	70	0.9	3	●
VAPDMSUSD0288	2.88	32.9	70.9	70	0.9	3	●
VAPDMSUSD0289	2.89	32.9	70.9	70	0.9	3	●
VAPDMSUSD0290	2.90	32.9	70.9	70	0.9	3	●
VAPDMSUSD0291	2.91	32.9	70.9	70	0.9	3	●
VAPDMSUSD0292	2.92	32.9	70.9	70	0.9	3	●
VAPDMSUSD0293	2.93	32.9	70.9	70	0.9	3	●
VAPDMSUSD0294	2.94	32.9	70.9	70	0.9	3	●
VAPDMSUSD0295	2.95	32.9	70.9	70	0.9	3	●
VAPDMSUSD0296	2.96	32.9	70.9	70	0.9	3	●
VAPDMSUSD0297	2.97	32.9	70.9	70	0.9	3	●
VAPDMSUSD0298	2.98	32.9	70.9	70	0.9	3	●
VAPDMSUSD0299	2.99	32.9	70.9	70	0.9	3	●
VAPDMSUSD0300	3.00	32.9	70.9	70	0.9	3	●
VAPDMSUSD0301	3.01	35.9	85.9	85	0.9	4	●
VAPDMSUSD0302	3.02	35.9	85.9	85	0.9	4	●
VAPDMSUSD0303	3.03	35.9	85.9	85	0.9	4	●
VAPDMSUSD0304	3.04	35.9	85.9	85	0.9	4	●
VAPDMSUSD0305	3.05	35.9	85.9	85	0.9	4	●

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDMSUS

Medium, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0306	3.06	35.9	85.9	85	0.9	4	●
VAPDMSUSD0307	3.07	35.9	85.9	85	0.9	4	●
VAPDMSUSD0308	3.08	35.9	85.9	85	0.9	4	●
VAPDMSUSD0309	3.09	35.9	85.9	85	0.9	4	●
VAPDMSUSD0310	3.10	35.9	85.9	85	0.9	4	●
VAPDMSUSD0311	3.11	35.9	85.9	85	0.9	4	●
VAPDMSUSD0312	3.12	35.9	85.9	85	0.9	4	●
VAPDMSUSD0313	3.13	35.9	85.9	85	0.9	4	●
VAPDMSUSD0314	3.14	35.9	85.9	85	0.9	4	●
VAPDMSUSD0315	3.15	36.0	86.0	85	1.0	4	●
VAPDMSUSD0316	3.16	36.0	86.0	85	1.0	4	●
VAPDMSUSD0317	3.17	36.0	86.0	85	1.0	4	●
VAPDMSUSD0318	3.18	36.0	86.0	85	1.0	4	●
VAPDMSUSD0319	3.19	36.0	86.0	85	1.0	4	●
VAPDMSUSD0320	3.20	36.0	86.0	85	1.0	4	●
VAPDMSUSD0321	3.21	36.0	86.0	85	1.0	4	●
VAPDMSUSD0322	3.22	36.0	86.0	85	1.0	4	●
VAPDMSUSD0323	3.23	36.0	86.0	85	1.0	4	●
VAPDMSUSD0324	3.24	36.0	86.0	85	1.0	4	●
VAPDMSUSD0325	3.25	36.0	86.0	85	1.0	4	●
VAPDMSUSD0326	3.26	36.0	86.0	85	1.0	4	●
VAPDMSUSD0327	3.27	36.0	86.0	85	1.0	4	●
VAPDMSUSD0328	3.28	36.0	86.0	85	1.0	4	●
VAPDMSUSD0329	3.29	36.0	86.0	85	1.0	4	●
VAPDMSUSD0330	3.30	36.0	86.0	85	1.0	4	●
VAPDMSUSD0331	3.31	39.0	86.0	85	1.0	4	●
VAPDMSUSD0332	3.32	39.0	86.0	85	1.0	4	●
VAPDMSUSD0333	3.33	39.0	86.0	85	1.0	4	●
VAPDMSUSD0334	3.34	39.0	86.0	85	1.0	4	●
VAPDMSUSD0335	3.35	39.0	86.0	85	1.0	4	●
VAPDMSUSD0336	3.36	39.0	86.0	85	1.0	4	●
VAPDMSUSD0337	3.37	39.0	86.0	85	1.0	4	●
VAPDMSUSD0338	3.38	39.0	86.0	85	1.0	4	●
VAPDMSUSD0339	3.39	39.0	86.0	85	1.0	4	●
VAPDMSUSD0340	3.40	39.0	86.0	85	1.0	4	●
VAPDMSUSD0341	3.41	39.0	86.0	85	1.0	4	●
VAPDMSUSD0342	3.42	39.0	86.0	85	1.0	4	●
VAPDMSUSD0343	3.43	39.0	86.0	85	1.0	4	●
VAPDMSUSD0344	3.44	39.0	86.0	85	1.0	4	●
VAPDMSUSD0345	3.45	39.0	86.0	85	1.0	4	●
VAPDMSUSD0346	3.46	39.0	86.0	85	1.0	4	●
VAPDMSUSD0347	3.47	39.0	86.0	85	1.0	4	●
VAPDMSUSD0348	3.48	39.1	86.1	85	1.1	4	●
VAPDMSUSD0349	3.49	39.1	86.1	85	1.1	4	●
VAPDMSUSD0350	3.50	39.1	86.1	85	1.1	4	●
VAPDMSUSD0351	3.51	39.1	86.1	85	1.1	4	●
VAPDMSUSD0352	3.52	39.1	86.1	85	1.1	4	●
VAPDMSUSD0353	3.53	39.1	86.1	85	1.1	4	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0354	3.54	39.1	86.1	85	1.1	4	●
VAPDMSUSD0355	3.55	39.1	86.1	85	1.1	4	●
VAPDMSUSD0356	3.56	39.1	86.1	85	1.1	4	●
VAPDMSUSD0357	3.57	39.1	86.1	85	1.1	4	●
VAPDMSUSD0358	3.58	39.1	86.1	85	1.1	4	●
VAPDMSUSD0359	3.59	39.1	86.1	85	1.1	4	●
VAPDMSUSD0360	3.60	39.1	86.1	85	1.1	4	●
VAPDMSUSD0361	3.61	39.1	86.1	85	1.1	4	●
VAPDMSUSD0362	3.62	39.1	86.1	85	1.1	4	●
VAPDMSUSD0363	3.63	39.1	86.1	85	1.1	4	●
VAPDMSUSD0364	3.64	39.1	86.1	85	1.1	4	●
VAPDMSUSD0365	3.65	39.1	86.1	85	1.1	4	●
VAPDMSUSD0366	3.66	39.1	86.1	85	1.1	4	●
VAPDMSUSD0367	3.67	39.1	86.1	85	1.1	4	●
VAPDMSUSD0368	3.68	39.1	86.1	85	1.1	4	●
VAPDMSUSD0369	3.69	39.1	86.1	85	1.1	4	●
VAPDMSUSD0370	3.70	39.1	86.1	85	1.1	4	●
VAPDMSUSD0371	3.71	43.1	86.1	85	1.1	4	●
VAPDMSUSD0372	3.72	43.1	86.1	85	1.1	4	●
VAPDMSUSD0373	3.73	43.1	86.1	85	1.1	4	●
VAPDMSUSD0374	3.74	43.1	86.1	85	1.1	4	●
VAPDMSUSD0375	3.75	43.1	86.1	85	1.1	4	●
VAPDMSUSD0376	3.76	43.1	86.1	85	1.1	4	●
VAPDMSUSD0377	3.77	43.1	86.1	85	1.1	4	●
VAPDMSUSD0378	3.78	43.1	86.1	85	1.1	4	●
VAPDMSUSD0379	3.79	43.1	86.1	85	1.1	4	●
VAPDMSUSD0380	3.80	43.1	86.1	85	1.1	4	●
VAPDMSUSD0381	3.81	43.1	86.1	85	1.1	4	●
VAPDMSUSD0382	3.82	43.2	86.2	85	1.2	4	●
VAPDMSUSD0383	3.83	43.2	86.2	85	1.2	4	●
VAPDMSUSD0384	3.84	43.2	86.2	85	1.2	4	●
VAPDMSUSD0385	3.85	43.2	86.2	85	1.2	4	●
VAPDMSUSD0386	3.86	43.2	86.2	85	1.2	4	●
VAPDMSUSD0387	3.87	43.2	86.2	85	1.2	4	●
VAPDMSUSD0388	3.88	43.2	86.2	85	1.2	4	●
VAPDMSUSD0389	3.89	43.2	86.2	85	1.2	4	●
VAPDMSUSD0390	3.90	43.2	86.2	85	1.2	4	●
VAPDMSUSD0391	3.91	43.2	86.2	85	1.2	4	●
VAPDMSUSD0392	3.92	43.2	86.2	85	1.2	4	●
VAPDMSUSD0393	3.93	43.2	86.2	85	1.2	4	●
VAPDMSUSD0394	3.94	43.2	86.2	85	1.2	4	●
VAPDMSUSD0395	3.95	43.2	86.2	85	1.2	4	●
VAPDMSUSD0396	3.96	43.2	86.2	85	1.2	4	●
VAPDMSUSD0397	3.97	43.2	86.2	85	1.2	4	●
VAPDMSUSD0398	3.98	43.2	86.2	85	1.2	4	●
VAPDMSUSD0399	3.99	43.2	86.2	85	1.2	4	●
VAPDMSUSD0400	4.00	42.8	85.8	85	0.8	4	●
VAPDMSUSD0405	4.05	42.8	100.8	100	0.8	6	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0410	4.10	42.9	100.9	100	0.9	6	●
VAPDMSUSD0415	4.15	42.9	100.9	100	0.9	6	●
VAPDMSUSD0420	4.20	42.9	100.9	100	0.9	6	●
VAPDMSUSD0425	4.25	46.9	100.9	100	0.9	6	●
VAPDMSUSD0430	4.30	46.9	100.9	100	0.9	6	●
VAPDMSUSD0435	4.35	46.9	100.9	100	0.9	6	●
VAPDMSUSD0440	4.40	46.9	100.9	100	0.9	6	●
VAPDMSUSD0445	4.45	46.9	100.9	100	0.9	6	●
VAPDMSUSD0450	4.50	46.9	100.9	100	0.9	6	●
VAPDMSUSD0455	4.55	46.9	100.9	100	0.9	6	●
VAPDMSUSD0460	4.60	47.0	101.0	100	1.0	6	●
VAPDMSUSD0465	4.65	47.0	101.0	100	1.0	6	●
VAPDMSUSD0470	4.70	47.0	101.0	100	1.0	6	●
VAPDMSUSD0475	4.75	47.0	101.0	100	1.0	6	●
VAPDMSUSD0480	4.80	52.0	101.0	100	1.0	6	●
VAPDMSUSD0485	4.85	52.0	101.0	100	1.0	6	●
VAPDMSUSD0490	4.90	52.0	101.0	100	1.0	6	●
VAPDMSUSD0495	4.95	52.0	101.0	100	1.0	6	●
VAPDMSUSD0500	5.00	52.0	101.0	100	1.0	6	●
VAPDMSUSD0505	5.05	52.1	101.1	100	1.1	6	●
VAPDMSUSD0510	5.10	52.1	101.1	100	1.1	6	●
VAPDMSUSD0515	5.15	52.1	101.1	100	1.1	6	●
VAPDMSUSD0520	5.20	52.1	101.1	100	1.1	6	●
VAPDMSUSD0525	5.25	52.1	101.1	100	1.1	6	●
VAPDMSUSD0530	5.30	52.1	101.1	100	1.1	6	●
VAPDMSUSD0535	5.35	57.1	107.1	106	1.1	6	●
VAPDMSUSD0540	5.40	57.1	107.1	106	1.1	6	●
VAPDMSUSD0545	5.45	57.1	107.1	106	1.1	6	●
VAPDMSUSD0550	5.50	57.1	107.1	106	1.1	6	●
VAPDMSUSD0555	5.55	57.2	107.2	106	1.2	6	●
VAPDMSUSD0560	5.60	57.2	107.2	106	1.2	6	●
VAPDMSUSD0565	5.65	57.2	107.2	106	1.2	6	●
VAPDMSUSD0570	5.70	57.2	107.2	106	1.2	6	●
VAPDMSUSD0575	5.75	57.2	107.2	106	1.2	6	●
VAPDMSUSD0580	5.80	57.2	107.2	106	1.2	6	●
VAPDMSUSD0585	5.85	57.2	107.2	106	1.2	6	●
VAPDMSUSD0590	5.90	57.2	107.2	106	1.2	6	●
VAPDMSUSD0595	5.95	57.2	107.2	106	1.2	6	●
VAPDMSUSD0600	6.00	57.2	107.2	106	1.2	6	●
VAPDMSUSD0605	6.05	63.3	113.3	112	1.3	8	●
VAPDMSUSD0610	6.10	63.3	113.3	112	1.3	8	●
VAPDMSUSD0615	6.15	63.3	113.3	112	1.3	8	●
VAPDMSUSD0620	6.20	63.3	113.3	112	1.3	8	●
VAPDMSUSD0625	6.25	63.3	113.3	112	1.3	8	●
VAPDMSUSD0630	6.30	63.3	113.3	112	1.3	8	●
VAPDMSUSD0635	6.35	63.3	113.3	112	1.3	8	●
VAPDMSUSD0640	6.40	63.3	113.3	112	1.3	8	●
VAPDMSUSD0645	6.45	63.3	113.3	112	1.3	8	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0650	6.50	63.4	113.4	112	1.4	8	●
VAPDMSUSD0655	6.55	63.4	113.4	112	1.4	8	●
VAPDMSUSD0660	6.60	63.4	113.4	112	1.4	8	●
VAPDMSUSD0665	6.65	63.4	113.4	112	1.4	8	●
VAPDMSUSD0670	6.70	63.4	113.4	112	1.4	8	●
VAPDMSUSD0675	6.75	68.4	118.4	117	1.4	8	●
VAPDMSUSD0680	6.80	68.4	118.4	117	1.4	8	●
VAPDMSUSD0685	6.85	68.4	118.4	117	1.4	8	●
VAPDMSUSD0690	6.90	68.4	118.4	117	1.4	8	●
VAPDMSUSD0695	6.95	68.4	118.4	117	1.4	8	●
VAPDMSUSD0700	7.00	68.5	118.5	117	1.5	8	●
VAPDMSUSD0705	7.05	68.5	118.5	117	1.5	8	●
VAPDMSUSD0710	7.10	68.5	118.5	117	1.5	8	●
VAPDMSUSD0715	7.15	68.5	118.5	117	1.5	8	●
VAPDMSUSD0720	7.20	68.5	118.5	117	1.5	8	●
VAPDMSUSD0725	7.25	68.5	118.5	117	1.5	8	●
VAPDMSUSD0730	7.30	68.5	118.5	117	1.5	8	●
VAPDMSUSD0735	7.35	68.5	118.5	117	1.5	8	●
VAPDMSUSD0740	7.40	68.5	118.5	117	1.5	8	●
VAPDMSUSD0745	7.45	68.5	118.5	117	1.5	8	●
VAPDMSUSD0750	7.50	68.6	118.6	117	1.6	8	●
VAPDMSUSD0755	7.55	74.6	124.6	123	1.6	8	●
VAPDMSUSD0760	7.60	74.6	124.6	123	1.6	8	●
VAPDMSUSD0765	7.65	74.6	124.6	123	1.6	8	●
VAPDMSUSD0770	7.70	74.6	124.6	123	1.6	8	●
VAPDMSUSD0775	7.75	74.6	124.6	123	1.6	8	●
VAPDMSUSD0780	7.80	74.6	124.6	123	1.6	8	●
VAPDMSUSD0785	7.85	74.6	124.6	123	1.6	8	●
VAPDMSUSD0790	7.90	74.6	124.6	123	1.6	8	●
VAPDMSUSD0795	7.95	74.7	124.7	123	1.7	8	●
VAPDMSUSD0800	8.00	74.7	124.7	123	1.7	8	●
VAPDMSUSD0805	8.05	74.7	129.7	128	1.7	10	●
VAPDMSUSD0810	8.10	74.7	129.7	128	1.7	10	●
VAPDMSUSD0815	8.15	74.7	129.7	128	1.7	10	●
VAPDMSUSD0820	8.20	74.7	129.7	128	1.7	10	●
VAPDMSUSD0825	8.25	74.7	129.7	128	1.7	10	●
VAPDMSUSD0830	8.30	74.7	129.7	128	1.7	10	●
VAPDMSUSD0835	8.35	74.7	129.7	128	1.7	10	●
VAPDMSUSD0840	8.40	74.7	129.7	128	1.7	10	●
VAPDMSUSD0845	8.45	74.8	129.8	128	1.8	10	●
VAPDMSUSD0850	8.50	74.8	129.8	128	1.8	10	●
VAPDMSUSD0855	8.55	80.8	135.8	134	1.8	10	●
VAPDMSUSD0860	8.60	80.8	135.8	134	1.8	10	●
VAPDMSUSD0865	8.65	80.8	135.8	134	1.8	10	●
VAPDMSUSD0870	8.70	80.8	135.8	134	1.8	10	●
VAPDMSUSD0875	8.75	80.8	135.8	134	1.8	10	●
VAPDMSUSD0880	8.80	80.8	135.8	134	1.8	10	●
VAPDMSUSD0885	8.85	80.8	135.8	134	1.8	10	●

CUTTING CONDITIONS ➤ P167
TECHNICAL DATA ➤ R001

VAPDMSUS

Medium, High precision, For stainless steel

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD0890	8.90	80.8	135.8	134	1.8	10	●
VAPDMSUSD0895	8.95	80.9	135.9	134	1.9	10	●
VAPDMSUSD0900	9.00	80.9	135.9	134	1.9	10	●
VAPDMSUSD0910	9.10	80.9	135.9	134	1.9	10	●
VAPDMSUSD0920	9.20	80.9	135.9	134	1.9	10	●
VAPDMSUSD0930	9.30	80.9	135.9	134	1.9	10	●
VAPDMSUSD0940	9.40	81.0	136.0	134	2.0	10	●
VAPDMSUSD0950	9.50	81.0	136.0	134	2.0	10	●
VAPDMSUSD0960	9.60	87.0	142.0	140	2.0	10	●
VAPDMSUSD0970	9.70	87.0	142.0	140	2.0	10	●
VAPDMSUSD0980	9.80	87.0	142.0	140	2.0	10	●
VAPDMSUSD0990	9.90	87.1	142.1	140	2.1	10	●
VAPDMSUSD1000	10.0	87.1	142.1	140	2.1	10	●
VAPDMSUSD1010	10.1	87.1	147.1	145	2.1	12	●
VAPDMSUSD1020	10.2	87.1	147.1	145	2.1	12	●
VAPDMSUSD1030	10.3	87.1	147.1	145	2.1	12	●
VAPDMSUSD1040	10.4	87.2	147.2	145	2.2	12	●
VAPDMSUSD1050	10.5	87.2	147.2	145	2.2	12	●
VAPDMSUSD1060	10.6	87.2	147.2	145	2.2	12	●
VAPDMSUSD1070	10.7	94.2	154.2	152	2.2	12	●
VAPDMSUSD1080	10.8	94.2	154.2	152	2.2	12	●
VAPDMSUSD1090	10.9	94.3	154.3	152	2.3	12	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VAPDMSUSD1100	11.0	94.3	154.3	152	2.3	12	●
VAPDMSUSD1110	11.1	94.3	154.3	152	2.3	12	●
VAPDMSUSD1120	11.2	94.3	154.3	152	2.3	12	●
VAPDMSUSD1130	11.3	94.3	154.3	152	2.3	12	●
VAPDMSUSD1140	11.4	94.4	154.4	152	2.4	12	●
VAPDMSUSD1150	11.5	94.4	154.4	152	2.4	12	●
VAPDMSUSD1160	11.6	94.4	154.4	152	2.4	12	●
VAPDMSUSD1170	11.7	94.4	154.4	152	2.4	12	●
VAPDMSUSD1180	11.8	94.4	154.4	152	2.4	12	●
VAPDMSUSD1190	11.9	101.5	161.5	159	2.5	12	●
VAPDMSUSD1200	12.0	101.5	161.5	159	2.5	12	●
VAPDMSUSD1210	12.1	101.5	161.5	159	2.5	12	●
VAPDMSUSD1220	12.2	101.5	161.5	159	2.5	12	●
VAPDMSUSD1230	12.3	101.6	161.6	159	2.6	12	●
VAPDMSUSD1240	12.4	101.6	161.6	159	2.6	12	●
VAPDMSUSD1250	12.5	101.6	161.6	159	2.6	12	●
VAPDMSUSD1260	12.6	101.6	161.6	159	2.6	12	●
VAPDMSUSD1270	12.7	101.6	161.6	159	2.6	12	●
VAPDMSUSD1280	12.8	101.7	161.7	159	2.7	12	●
VAPDMSUSD1290	12.9	101.7	161.7	159	2.7	12	●
VAPDMSUSD1300	13.0	101.7	161.7	159	2.7	12	●

● : Inventory maintained in Japan.

VAPDSSUS VAPDMSUS

VIOLET DRILLS, High precision, For stainless steel, Short/medium

RECOMMENDED CUTTING CONDITIONS

Work Material	Stainless Steel				Carbon Steel, Alloy Steel Cast Iron Copper, Copper Alloy		Structural Steel Aluminium Alloy	
	Austenitic AISI 304, AISI 316		Martensitic Ferritic AISI 430		AISI 1049, SCM, FC			
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	7600	0.01	8800	0.01	11250	0.01	15000	0.02
1.0	4800	0.02	6300	0.05	10000	0.05	12000	0.05
2.0	2400	0.04	3200	0.06	5500	0.09	6400	0.09
3.0	1600	0.07	2100	0.10	3700	0.13	4300	0.13
4.0	1200	0.09	1600	0.10	2800	0.15	3200	0.15
5.0	950	0.12	1300	0.13	2200	0.18	2600	0.18
6.0	800	0.14	1100	0.15	1800	0.20	2100	0.19
8.0	600	0.18	800	0.18	1400	0.22	1600	0.24
10.0	480	0.22	640	0.21	1100	0.25	1300	0.28
12.0	400	0.24	530	0.25	930	0.30	1100	0.34
13.0	370	0.26	490	0.28	860	0.32	1000	0.36
14.0	340	0.30	450	0.27	730	0.31	930	0.36
15.0	320	0.31	425	0.28	680	0.32	870	0.38
16.0	300	0.32	400	0.30	640	0.34	820	0.42
18.0	270	0.34	350	0.32	570	0.36	725	0.43
20.0	240	0.36	320	0.35	510	0.38	660	0.45

Note 1) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 2) Please use a collet type drill chuck or a milling chuck.
Note 3) Use sufficient cutting fluid.
Note 4) For precipitation-hardened stainless steels (JIS SUS630 and SUS631), MVE, MVS and MMS are recommended.
Note 5) When drilling holes greater than 4 x drill diameter hole depths, please use a peck feed.
Note 6) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

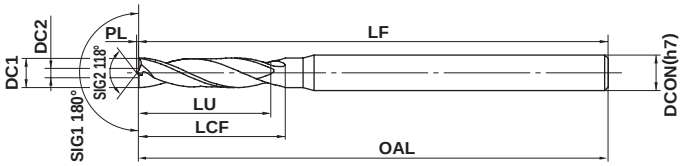
HSS

VAPDSCB

Short flute length, High precision, For counter boring

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC (Max 3×DC)

DC≤3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤32
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

●Unique geometry offers high efficiency counter boring.
Excellent chip breaking and flat counterbored surface.

Order Number	Dimensions (mm)							Stock
	DC1	DC2	LCF	OAL	LF	PL	DCON	
VAPDSCBD0200	2.0	0.7	12	60.2	60	0.2	3	●
VAPDSCBD0210	2.1	0.7	12	60.2	60	0.2	3	●
VAPDSCBD0220	2.2	0.7	12	60.2	60	0.2	3	●
VAPDSCBD0230	2.3	0.7	13	60.2	60	0.2	3	●
VAPDSCBD0240	2.4	0.7	13	60.2	60	0.2	3	●
VAPDSCBD0250	2.5	0.7	13	60.2	60	0.2	3	●
VAPDSCBD0260	2.6	0.8	15	60.2	60	0.2	3	●
VAPDSCBD0270	2.7	0.8	15	60.2	60	0.2	3	●
VAPDSCBD0280	2.8	0.8	15	60.2	60	0.2	3	●
VAPDSCBD0290	2.9	0.8	15	60.2	60	0.2	3	●
VAPDSCBD0300	3.0	0.8	15	60.2	60	0.2	3	●
VAPDSCBD0310	3.1	0.8	17	70.2	70	0.2	4	●
VAPDSCBD0320	3.2	0.8	17	70.2	70	0.2	4	●
VAPDSCBD0330	3.3	0.8	19	70.2	70	0.2	4	●
VAPDSCBD0340	3.4	0.8	19	70.2	70	0.2	4	●
VAPDSCBD0350	3.5	0.8	19	70.2	70	0.2	4	●
VAPDSCBD0360	3.6	1.0	21	70.2	70	0.2	4	●
VAPDSCBD0370	3.7	1.0	21	70.2	70	0.2	4	●
VAPDSCBD0380	3.8	1.0	21	70.2	70	0.2	4	●
VAPDSCBD0390	3.9	1.0	21	70.2	70	0.2	4	●
VAPDSCBD0400	4.0	1.0	21	70.3	70	0.3	4	●
VAPDSCBD0410	4.1	1.0	21	80.3	80	0.3	6	●
VAPDSCBD0420	4.2	1.0	21	80.3	80	0.3	6	●
VAPDSCBD0430	4.3	1.0	23	80.3	80	0.3	6	●
VAPDSCBD0440	4.4	1.0	23	80.3	80	0.3	6	●
VAPDSCBD0450	4.5	1.0	23	80.3	80	0.3	6	●
VAPDSCBD0460	4.6	1.4	25	80.3	80	0.3	6	●
VAPDSCBD0470	4.7	1.4	25	80.3	80	0.3	6	●
VAPDSCBD0480	4.8	1.4	25	80.3	80	0.3	6	●
VAPDSCBD0490	4.9	1.4	25	80.3	80	0.3	6	●
VAPDSCBD0500	5.0	1.4	25	80.4	80	0.4	6	●
VAPDSCBD0510	5.1	1.4	25	80.4	80	0.4	6	●
VAPDSCBD0520	5.2	1.4	25	80.4	80	0.4	6	●
VAPDSCBD0530	5.3	1.4	25	80.4	80	0.4	6	●
VAPDSCBD0540	5.4	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0550	5.5	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0560	5.6	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0570	5.7	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0580	5.8	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0590	5.9	1.4	27	80.4	80	0.4	6	●

Order Number	Dimensions (mm)							Stock
	DC1	DC2	LCF	OAL	LF	PL	DCON	
VAPDSCBD0600	6.0	1.4	27	80.4	80	0.4	6	●
VAPDSCBD0610	6.1	1.4	30	80.4	80	0.4	8	●
VAPDSCBD0620	6.2	1.4	30	80.4	80	0.4	8	●
VAPDSCBD0630	6.3	1.4	30	80.4	80	0.4	8	●
VAPDSCBD0640	6.4	1.4	30	80.4	80	0.4	8	●
VAPDSCBD0650	6.5	1.4	30	80.4	80	0.4	8	●
VAPDSCBD0660	6.6	1.8	30	80.4	80	0.4	8	●
VAPDSCBD0670	6.7	1.8	30	80.4	80	0.4	8	●
VAPDSCBD0680	6.8	1.8	32	80.4	80	0.4	8	●
VAPDSCBD0690	6.9	1.8	32	80.4	80	0.4	8	●
VAPDSCBD0700	7.0	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0710	7.1	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0720	7.2	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0730	7.3	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0740	7.4	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0750	7.5	1.8	32	80.6	80	0.6	8	●
VAPDSCBD0760	7.6	2.0	35	85.6	85	0.6	8	●
VAPDSCBD0770	7.7	2.0	35	85.6	85	0.6	8	●
VAPDSCBD0780	7.8	2.0	35	85.6	85	0.6	8	●
VAPDSCBD0790	7.9	2.0	35	85.6	85	0.6	8	●
VAPDSCBD0800	8.0	2.0	35	85.6	85	0.6	8	●
VAPDSCBD0810	8.1	2.0	35	90.6	90	0.6	10	●
VAPDSCBD0850	8.5	2.0	35	90.6	90	0.6	10	●
VAPDSCBD0860	8.6	2.8	38	93.6	93	0.6	10	●
VAPDSCBD0880	8.8	2.8	38	93.6	93	0.6	10	●
VAPDSCBD0900	9.0	2.8	38	93.8	93	0.8	10	●
VAPDSCBD0910	9.1	2.8	38	93.8	93	0.8	10	●
VAPDSCBD0950	9.5	2.8	38	93.8	93	0.8	10	●
VAPDSCBD0960	9.6	3.2	41	96.8	96	0.8	10	●
VAPDSCBD0980	9.8	3.2	41	96.8	96	0.8	10	●
VAPDSCBD1000	10.0	3.2	41	96.9	96	0.9	10	●
VAPDSCBD1010	10.1	3.2	41	101.9	101	0.9	12	●
VAPDSCBD1030	10.3	3.2	41	101.9	101	0.9	12	●
VAPDSCBD1050	10.5	3.2	41	101.9	101	0.9	12	●
VAPDSCBD1080	10.8	3.7	45	105.9	105	0.9	12	●
VAPDSCBD1100	11.0	3.7	45	105.9	105	0.9	12	●
VAPDSCBD1110	11.1	3.7	45	105.9	105	0.9	12	●
VAPDSCBD1150	11.5	3.7	45	105.9	105	0.9	12	●
VAPDSCBD1180	11.8	3.7	45	105.9	105	0.9	12	●
VAPDSCBD1200	12.0	3.7	49	109.9	109	0.9	12	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)							Stock
	DC1	DC2	LCF	OAL	LF	PL	DCON	
VAPDSCBD1250	12.5	3.7	49	109.9	109	0.9	12	●
VAPDSCBD1300	13.0	4.2	49	110.1	109	1.1	12	●
VAPDSCBD1350	13.5	4.2	51	122.1	121	1.1	16	●
VAPDSCBD1380	13.8	4.2	51	122.1	121	1.1	16	●
VAPDSCBD1400	14.0	4.2	51	122.1	121	1.1	16	●
VAPDSCBD1410	14.1	5.5	58	124.1	123	1.1	16	●
VAPDSCBD1420	14.2	5.5	58	124.1	123	1.1	16	●
VAPDSCBD1450	14.5	5.5	58	124.1	123	1.1	16	●
VAPDSCBD1480	14.8	5.5	58	124.1	123	1.1	16	●
VAPDSCBD1500	15.0	5.5	58	124.3	123	1.3	16	●
VAPDSCBD1550	15.5	5.5	60	126.3	125	1.3	16	●
VAPDSCBD1570	15.7	5.5	60	126.3	125	1.3	16	●
VAPDSCBD1580	15.8	5.5	60	126.3	125	1.3	16	●
VAPDSCBD1600	16.0	5.5	60	126.3	125	1.3	16	●
VAPDSCBD1700	17.0	5.5	62	133.3	132	1.3	20	●
VAPDSCBD1750	17.5	5.5	63	134.6	133	1.6	20	●
VAPDSCBD1760	17.6	6.5	63	134.6	133	1.6	20	●
VAPDSCBD1770	17.7	6.5	63	134.6	133	1.6	20	●
VAPDSCBD1780	17.8	6.5	63	134.6	133	1.6	20	●
VAPDSCBD1800	18.0	6.5	63	134.6	133	1.6	20	●

Order Number	Dimensions (mm)							Stock
	DC1	DC2	LCF	OAL	LF	PL	DCON	
VAPDSCBD1810	18.1	6.5	65	136.6	135	1.6	20	●
VAPDSCBD1900	19.0	6.5	65	136.6	135	1.6	20	●
VAPDSCBD1980	19.8	7.5	67	138.6	137	1.6	20	●
VAPDSCBD2000	20.0	7.5	67	138.8	137	1.8	20	●
VAPDSCBD2010	20.1	7.5	67	138.8	137	1.8	20	●
VAPDSCBD2100	21.0	7.5	75	166.8	165	1.8	25	●
VAPDSCBD2200	22.0	7.5	75	166.8	165	1.8	25	●
VAPDSCBD2300	23.0	7.5	80	171.8	170	1.8	25	●
VAPDSCBD2400	24.0	8.5	80	172.2	170	2.2	25	●
VAPDSCBD2500	25.0	8.5	85	182.2	180	2.2	25	●
VAPDSCBD2600	26.0	9.0	85	182.2	180	2.2	32	●
VAPDSCBD2700	27.0	9.0	95	192.2	190	2.2	32	●
VAPDSCBD2800	28.0	10.0	95	192.6	190	2.6	32	●
VAPDSCBD2900	29.0	10.0	100	197.6	195	2.6	32	●
VAPDSCBD3000	30.0	11.0	100	197.6	195	2.6	32	●
VAPDSCBD3100	31.0	11.0	105	202.6	200	2.6	32	●
VAPDSCBD3200	32.0	13.0	105	202.6	200	2.6	32	●

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel Aluminium Alloy		Carbon Steel, Alloy Steel Cast Iron AISI 1049, SCM, FCD		Alloy Tool Steel (Low-hardness Materials) Ferritic Stainless Steel Martensitic Stainless Steel AISI D2, AISI 430, AISI 405, AISI 420, AISI 440		Alloy Tool Steel (−40HRC) Precipitation Hardening Stainless Steel AISI H13, ASTM 630, ASTM 631	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
2.0	5600	0.07	4800	0.07	3200	0.07	2800	0.04
3.0	3700	0.10	3200	0.10	2100	0.10	1900	0.05
4.0	2800	0.12	2400	0.12	1600	0.12	1400	0.06
5.0	2200	0.14	1900	0.14	1300	0.14	1150	0.07
6.0	1850	0.15	1600	0.15	1050	0.15	950	0.08
8.0	1400	0.20	1200	0.20	800	0.20	720	0.10
10.0	1100	0.23	960	0.23	640	0.21	570	0.11
12.0	950	0.26	800	0.26	530	0.24	470	0.12
14.0	800	0.27	680	0.27	450	0.25	410	0.13
16.0	700	0.28	500	0.28	360	0.26	300	0.14
18.0	620	0.29	450	0.29	320	0.27	260	0.15
20.0	560	0.30	400	0.30	290	0.27	240	0.15
22.0	510	0.32	360	0.32	260	0.29	220	0.16
24.0	460	0.33	330	0.33	240	0.30	200	0.16
26.0	430	0.35	310	0.35	220	0.31	180	0.17
28.0	400	0.36	290	0.36	210	0.33	170	0.18
30.0	370	0.37	270	0.37	190	0.34	160	0.18
32.0	350	0.38	250	0.38	180	0.35	150	0.19

Note 1) The above cutting conditions are for drilling DCx3 hole depths without a pilot hole. When drilling holes smaller than DCx1 hole depths, it is possible to increase the revolution speed by 20%.
Note 2) Drilling without a pilot hole is recommended. If there is a pilot hole, chips are not broken. Use a pick feed when chip breaking is necessary.
Note 3) For counter boring of a sloped face, a carbide end mill is recommended.
Note 4) When machining austenitic stainless steels (JIS SUS304, SUS316), set the revolution at 40%-70% and the feed rate 40%-60%.
Note 5) Please use a collet type drill chuck or a milling chuck.
Note 6) Please reduce the revolution and feed rate depending on the drilling situation when the installation of workpiece or machine lacks rigidity.
Note 7) Use sufficient cutting fluid.
Note 8) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

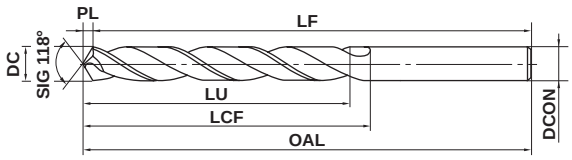
HSS

VSD

Straight shank

HSS | V | 110° DC<0.7 | 118° DC≥0.7 | X DC<2 | XR DC≥2

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

0.5≤DC<1	1≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.010	0 −0.014	0 −0.018	0 −0.022	0 −0.027

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VSDD0050	0.5	6.2	27.2	27	0.18	0.5	●
VSDD0060	0.6	7.2	30.2	30	0.21	0.6	●
VSDD0070	0.7	9.2	32.2	32	0.21	0.7	●
VSDD0080	0.8	10.2	34.2	34	0.24	0.8	●
VSDD0090	0.9	11.3	36.3	36	0.27	0.9	●
VSDD0100	1.0	12.3	40.3	40	0.3	1.0	●
VSDD0110	1.1	14.3	42.3	42	0.3	1.1	●
VSDD0120	1.2	16.4	42.4	42	0.4	1.2	●
VSDD0130	1.3	16.4	45.4	45	0.4	1.3	●
VSDD0140	1.4	18.4	48.4	48	0.4	1.4	●
VSDD0150	1.5	18.5	48.5	48	0.5	1.5	●
VSDD0160	1.6	20.5	50.5	50	0.5	1.6	●
VSDD0170	1.7	20.5	50.5	50	0.5	1.7	●
VSDD0180	1.8	22.5	52.5	52	0.5	1.8	●
VSDD0190	1.9	22.6	52.6	52	0.6	1.9	●
VSDD0200	2.0	23.6	55.6	55	0.6	2.0	●
VSDD0210	2.1	23.6	55.6	55	0.6	2.1	●
VSDD0220	2.2	26.7	58.7	58	0.7	2.2	●
VSDD0230	2.3	26.7	58.7	58	0.7	2.3	●
VSDD0240	2.4	29.7	61.7	61	0.7	2.4	●
VSDD0250	2.5	29.8	61.8	61	0.8	2.5	●
VSDD0260	2.6	29.8	64.8	64	0.8	2.6	●
VSDD0270	2.7	32.8	64.8	64	0.8	2.7	●
VSDD0280	2.8	32.8	67.8	67	0.8	2.8	●
VSDD0290	2.9	32.9	71.9	71	0.9	2.9	●
VSDD0300	3.0	32.9	71.9	71	0.9	3.0	●
VSDD0310	3.1	35.9	71.9	71	0.9	3.1	●
VSDD0320	3.2	36.0	72.0	71	1.0	3.2	●
VSDD0330	3.3	36.0	74.0	73	1.0	3.3	●
VSDD0340	3.4	39.0	74.0	73	1.0	3.4	●
VSDD0350	3.5	39.1	74.1	73	1.1	3.5	●
VSDD0360	3.6	39.1	77.1	76	1.1	3.6	●
VSDD0370	3.7	39.1	77.1	76	1.1	3.7	●
VSDD0380	3.8	43.1	77.1	76	1.1	3.8	●
VSDD0390	3.9	43.2	80.2	79	1.2	3.9	●
VSDD0400	4.0	43.2	84.2	83	1.2	4.0	●
VSDD0410	4.1	43.2	84.2	83	1.2	4.1	●
VSDD0420	4.2	43.3	84.3	83	1.3	4.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VSDD0430	4.3	47.3	84.3	83	1.3	4.3	●
VSDD0440	4.4	47.3	87.3	86	1.3	4.4	●
VSDD0450	4.5	47.4	87.4	86	1.4	4.5	●
VSDD0460	4.6	47.4	87.4	86	1.4	4.6	●
VSDD0470	4.7	47.4	90.4	89	1.4	4.7	●
VSDD0480	4.8	52.4	90.4	89	1.4	4.8	●
VSDD0490	4.9	52.5	93.5	92	1.5	4.9	●
VSDD0500	5.0	52.5	93.5	92	1.5	5.0	●
VSDD0510	5.1	52.5	93.5	92	1.5	5.1	●
VSDD0520	5.2	52.6	96.6	95	1.6	5.2	●
VSDD0530	5.3	52.6	96.6	95	1.6	5.3	●
VSDD0540	5.4	57.6	96.6	95	1.6	5.4	●
VSDD0550	5.5	57.7	96.7	95	1.7	5.5	●
VSDD0560	5.6	57.7	99.7	98	1.7	5.6	●
VSDD0570	5.7	57.7	99.7	98	1.7	5.7	●
VSDD0580	5.8	57.7	99.7	98	1.7	5.8	●
VSDD0590	5.9	57.8	99.8	98	1.8	5.9	●
VSDD0600	6.0	57.8	103.8	102	1.8	6.0	●
VSDD0610	6.1	63.8	103.8	102	1.8	6.1	●
VSDD0620	6.2	63.9	103.9	102	1.9	6.2	●
VSDD0630	6.3	63.9	103.9	102	1.9	6.3	●
VSDD0640	6.4	63.9	106.9	105	1.9	6.4	●
VSDD0650	6.5	64.0	107.0	105	2.0	6.5	●
VSDD0660	6.6	64.0	107.0	105	2.0	6.6	●
VSDD0670	6.7	64.0	107.0	105	2.0	6.7	●
VSDD0680	6.8	69.0	107.0	105	2.0	6.8	●
VSDD0690	6.9	69.1	107.1	105	2.1	6.9	●
VSDD0700	7.0	69.1	107.1	105	2.1	7.0	●
VSDD0710	7.1	69.1	110.1	108	2.1	7.1	●
VSDD0720	7.2	69.2	110.2	108	2.2	7.2	●
VSDD0730	7.3	69.2	110.2	108	2.2	7.3	●
VSDD0740	7.4	69.2	113.2	111	2.2	7.4	●
VSDD0750	7.5	69.3	113.3	111	2.3	7.5	●
VSDD0760	7.6	75.3	113.3	111	2.3	7.6	●
VSDD0770	7.7	75.3	116.3	114	2.3	7.7	●
VSDD0780	7.8	75.3	116.3	114	2.3	7.8	●
VSDD0790	7.9	75.4	116.4	114	2.4	7.9	●
VSDD0800	8.0	75.4	116.4	114	2.4	8.0	●

Note 1) Less than ø5-ø1.9mm : 5 pcs/case, More than ø2mm : 1 pcs/case.

● : Inventory maintained in Japan.

P

DRILLING

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VSDD0810	8.1	75.4	119.4	117	2.4	8.1	●
VSDD0820	8.2	75.5	119.5	117	2.5	8.2	●
VSDD0830	8.3	75.5	119.5	117	2.5	8.3	●
VSDD0840	8.4	75.5	123.5	121	2.5	8.4	●
VSDD0850	8.5	75.6	123.6	121	2.6	8.5	●
VSDD0860	8.6	81.6	123.6	121	2.6	8.6	●
VSDD0870	8.7	81.6	123.6	121	2.6	8.7	●
VSDD0880	8.8	81.6	126.6	124	2.6	8.8	●
VSDD0890	8.9	81.7	126.7	124	2.7	8.9	●
VSDD0900	9.0	81.7	126.7	124	2.7	9.0	●
VSDD0910	9.1	81.7	126.7	124	2.7	9.1	●
VSDD0920	9.2	81.8	129.8	127	2.8	9.2	●
VSDD0930	9.3	81.8	129.8	127	2.8	9.3	●
VSDD0940	9.4	81.8	129.8	127	2.8	9.4	●
VSDD0950	9.5	81.9	129.9	127	2.9	9.5	●
VSDD0960	9.6	87.9	132.9	130	2.9	9.6	●
VSDD0970	9.7	87.9	132.9	130	2.9	9.7	●
VSDD0980	9.8	87.9	132.9	130	2.9	9.8	●
VSDD0990	9.9	88.0	133.0	130	3.0	9.9	●
VSDD1000	10.0	88.0	133.0	130	3.0	10.0	●
VSDD1010	10.1	88.0	136.0	133	3.0	10.1	●
VSDD1020	10.2	88.1	136.1	133	3.1	10.2	●
VSDD1030	10.3	88.1	136.1	133	3.1	10.3	●
VSDD1040	10.4	88.1	136.1	133	3.1	10.4	●
VSDD1050	10.5	88.2	140.2	137	3.2	10.5	●
VSDD1060	10.6	88.2	140.2	137	3.2	10.6	●
VSDD1070	10.7	95.2	140.2	137	3.2	10.7	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
VSDD1080	10.8	95.2	143.2	140	3.2	10.8	●
VSDD1090	10.9	95.3	143.3	140	3.3	10.9	●
VSDD1100	11.0	95.3	143.3	140	3.3	11.0	●
VSDD1110	11.1	95.3	143.3	140	3.3	11.1	●
VSDD1120	11.2	95.4	146.4	143	3.4	11.2	●
VSDD1130	11.3	95.4	146.4	143	3.4	11.3	●
VSDD1140	11.4	95.4	146.4	143	3.4	11.4	●
VSDD1150	11.5	95.5	146.5	143	3.5	11.5	●
VSDD1160	11.6	95.5	149.5	146	3.5	11.6	●
VSDD1170	11.7	95.5	149.5	146	3.5	11.7	●
VSDD1180	11.8	95.5	149.5	146	3.5	11.8	●
VSDD1190	11.9	102.6	149.6	146	3.6	11.9	●
VSDD1200	12.0	102.6	152.6	149	3.6	12.0	●
VSDD1210	12.1	102.6	152.6	149	3.6	12.1	●
VSDD1220	12.2	102.7	152.7	149	3.7	12.2	●
VSDD1230	12.3	102.7	152.7	149	3.7	12.3	●
VSDD1240	12.4	102.7	155.7	152	3.7	12.4	●
VSDD1250	12.5	102.8	155.8	152	3.8	12.5	●
VSDD1260	12.6	102.8	155.8	152	3.8	12.6	●
VSDD1270	12.7	102.8	155.8	152	3.8	12.7	●
VSDD1280	12.8	102.8	155.8	152	3.8	12.8	●
VSDD1290	12.9	102.9	155.9	152	3.9	12.9	●
VSDD1300	13.0	102.9	155.9	152	3.9	13.0	●

RECOMMENDED CUTTING CONDITIONS

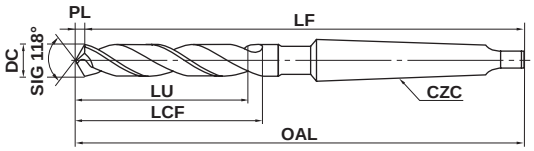
Work Material	Structural Steel		Carbon Steel AISI 1049		Stainless Steel AISI 420		Stainless Steel, Tool Steel (Low-hardness Materials) Heat-treated Steel (−40HRC) AISI 304, AISI D2, AISI H13	
Cutting Speed	40m/min		30m/min		20m/min		10−14m/min	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	15000	0.01	11250	0.01	7500	0.01	5620	0.01
1.0	10000	0.02	7500	0.02	5000	0.02	3750	0.02
1.5	8200	0.03	6150	0.03	4100	0.03	2800	0.03
2.0	6370	0.05	4780	0.05	3180	0.05	2200	0.04
3.0	4250	0.10	3180	0.10	2120	0.07	1400	0.06
4.0	3180	0.13	2390	0.13	1590	0.09	1100	0.08
5.0	2550	0.15	1910	0.15	1270	0.11	860	0.10
6.0	2120	0.18	1590	0.18	1060	0.13	720	0.11
7.0	1820	0.20	1360	0.20	910	0.14	610	0.12
8.0	1590	0.22	1190	0.21	800	0.15	540	0.13
9.0	1420	0.24	1060	0.22	710	0.17	480	0.14
10.0	1270	0.26	960	0.23	640	0.18	430	0.15
11.0	1160	0.28	870	0.24	580	0.19	390	0.16
12.0	1060	0.30	800	0.25	530	0.20	360	0.17
13.0	980	0.30	730	0.26	490	0.20	330	0.17

Note 1) Please reduce the revolution depending on drilling situation when the application lacks rigidity.
Note 2) Please use step drilling and reduce the cutting conditions in the case when the drilling depth exceeds DC×3.
Note 3) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

VTDS

Short, Taper shank

P Steel | M Stainless Steel | K | N Non-ferrous Metal | S | H



*LU = LCF-2DC

DC=6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤32
0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

Order Number	Dimensions (mm)					CZC	Stock
	DC	LCF	OAL	LF	PL		
VTDSD0600M1	6.0	45.8	127.8	126	1.8	MT.1	●
VTDSD0650M1	6.5	46.0	128.0	126	2.0	MT.1	●
VTDSD0660M1	6.6	46.0	128.0	126	2.0	MT.1	●
VTDSD0680M1	6.8	46.0	128.0	126	2.0	MT.1	●
VTDSD0700M1	7.0	46.1	128.1	126	2.1	MT.1	●
VTDSD0720M1	7.2	46.2	128.2	126	2.2	MT.1	●
VTDSD0750M1	7.5	46.3	128.3	126	2.3	MT.1	●
VTDSD0770M1	7.7	50.3	132.3	130	2.3	MT.1	●
VTDSD0780M1	7.8	50.3	132.3	130	2.3	MT.1	●
VTDSD0800M1	8.0	50.4	132.4	130	2.4	MT.1	●
VTDSD0820M1	8.2	50.5	132.5	130	2.5	MT.1	●
VTDSD0850M1	8.5	50.6	132.6	130	2.6	MT.1	●
VTDSD0880M1	8.8	54.6	135.6	133	2.6	MT.1	●
VTDSD0900M1	9.0	54.7	135.7	133	2.7	MT.1	●
VTDSD0950M1	9.5	54.9	135.9	133	2.9	MT.1	●
VTDSD0970M1	9.7	58.9	139.9	137	2.9	MT.1	●
VTDSD0980M1	9.8	58.9	139.9	137	2.9	MT.1	●
VTDSD1000M1	10.0	59.0	140.0	137	3.0	MT.1	●
VTDSD1030M1	10.3	59.1	140.1	137	3.1	MT.1	●
VTDSD1050M1	10.5	59.2	140.2	137	3.2	MT.1	●
VTDSD1080M1	10.8	64.2	145.2	142	3.2	MT.1	●
VTDSD1100M1	11.0	64.3	145.3	142	3.3	MT.1	●
VTDSD1150M1	11.5	64.5	145.5	142	3.5	MT.1	●
VTDSD1200M1	12.0	69.6	149.6	146	3.6	MT.1	●
VTDSD1250M2	12.5	69.8	166.8	163	3.8	MT.2	●
VTDSD1300M2	13.0	69.9	166.9	163	3.9	MT.2	●
VTDSD1350M2	13.5	74.1	172.1	168	4.1	MT.2	●
VTDSD1400M2	14.0	74.2	172.2	168	4.2	MT.2	●
VTDSD1450M2	14.5	77.4	175.4	171	4.4	MT.2	●
VTDSD1500M2	15.0	77.5	175.5	171	4.5	MT.2	●
VTDSD1550M2	15.5	81.7	179.7	175	4.7	MT.2	●
VTDSD1600M2	16.0	81.8	179.8	175	4.8	MT.2	●

Order Number	Dimensions (mm)					CZC	Stock
	DC	LCF	OAL	LF	PL		
VTDSD1650M2	16.5	85.0	183.0	178	5.0	MT.2	●
VTDSD1700M2	17.0	85.1	183.1	178	5.1	MT.2	●
VTDSD1750M2	17.5	89.3	187.3	182	5.3	MT.2	●
VTDSD1800M2	18.0	89.4	187.4	182	5.4	MT.2	●
VTDSD1850M2	18.5	91.6	189.6	184	5.6	MT.2	●
VTDSD1900M2	19.0	91.7	189.7	184	5.7	MT.2	●
VTDSD1950M2	19.5	95.9	193.9	188	5.9	MT.2	●
VTDSD2000M2	20.0	96.0	194.0	188	6.0	MT.2	●
VTDSD2050M2	20.5	99.2	197.2	191	6.2	MT.2	●
VTDSD2100M2	21.0	99.3	197.3	191	6.3	MT.2	●
VTDSD2150M2	21.5	102.5	200.5	194	6.5	MT.2	●
VTDSD2200M2	22.0	102.6	200.6	194	6.6	MT.2	●
VTDSD2250M2	22.5	106.8	204.8	198	6.8	MT.2	●
VTDSD2300M2	23.0	106.9	204.9	198	6.9	MT.2	●
VTDSD2350M3	23.5	109.1	231.1	224	7.1	MT.3	●
VTDSD2400M3	24.0	109.2	231.2	224	7.2	MT.3	●
VTDSD2450M3	24.5	109.4	231.4	224	7.4	MT.3	●
VTDSD2500M3	25.0	109.5	231.5	224	7.5	MT.3	●
VTDSD2550M3	25.5	112.7	233.7	226	7.7	MT.3	●
VTDSD2600M3	26.0	112.8	233.8	226	7.8	MT.3	●
VTDSD2650M3	26.5	113.0	234.0	226	8.0	MT.3	●
VTDSD2700M3	27.0	116.1	238.1	230	8.1	MT.3	●
VTDSD2750M3	27.5	116.3	238.3	230	8.3	MT.3	●
VTDSD2800M3	28.0	116.4	238.4	230	8.4	MT.3	●
VTDSD2850M3	28.5	119.6	240.6	232	8.6	MT.3	●
VTDSD2900M3	29.0	119.7	240.7	232	8.7	MT.3	●
VTDSD2950M3	29.5	119.9	240.9	232	8.9	MT.3	●
VTDSD3000M3	30.0	120.0	241.0	232	9.0	MT.3	●
VTDSD3050M3	30.5	123.2	244.2	235	9.2	MT.3	●
VTDSD3100M3	31.0	123.3	244.3	235	9.3	MT.3	●
VTDSD3150M3	31.5	123.5	244.5	235	9.5	MT.3	●
VTDSD3200M3	32.0	123.6	244.6	235	9.6	MT.3	●

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel		Carbon Steel AISI 1049		Stainless Steel AISI 420 Copper Alloy, Brass		Stainless Steel AISI 304 Tool Steel AISI D2 (Low-hardness Materials)		Heat-treated Steel AISI H13 (35−40HRC)	
Cutting Speed	33−38m/min		28−33m/min		20m/min		15m/min		18m/min	
Drill Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
6.0	2000	0.18	1750	0.18	1060	0.15	800	0.12	950	0.12
8.0	1400	0.22	1270	0.22	800	0.20	600	0.15	720	0.15
10.0	1100	0.25	960	0.25	640	0.22	480	0.18	570	0.18
14.0	790	0.30	680	0.28	450	0.25	340	0.23	410	0.23
18.0	610	0.35	530	0.34	350	0.30	270	0.27	320	0.27
20.0	540	0.40	480	0.38	320	0.33	240	0.30	280	0.30
22.0	480	0.42	430	0.40	290	0.35	220	0.30	260	0.30
24.0	430	0.42	380	0.40	260	0.35	200	0.30	240	0.30
28.0	370	0.45	330	0.42	220	0.38	170	0.33	200	0.33
32.0	320	0.45	280	0.42	200	0.38	150	0.33	180	0.33

Note 1) The above-mentioned cutting condition is standard when using water-soluble cutting fluid.
Please reduce the revolution when using non-water-soluble cutting fluid.

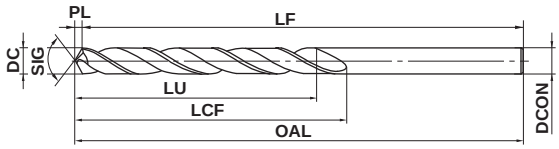
HSS

GSD

TiN, Straight shank

HSS | G | 110° DC<0.7 | 118° DC≥0.7 | X DC<2 | XR DC≥2

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

0.5≤DC<1	1≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.010	0 −0.014	0 −0.018	0 −0.022	0 −0.027

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GSDD0050	0.5	6.2	27.2	27	0.18	0.5	●
GSDD0060	0.6	7.2	30.2	30	0.21	0.6	●
GSDD0070	0.7	9.2	32.2	32	0.21	0.7	●
GSDD0080	0.8	10.2	34.2	34	0.24	0.8	●
GSDD0090	0.9	11.3	36.3	36	0.27	0.9	●
GSDD0100	1.0	12.3	40.3	40	0.3	1.0	●
GSDD0110	1.1	14.3	42.3	42	0.3	1.1	●
GSDD0120	1.2	16.4	42.4	42	0.4	1.2	●
GSDD0130	1.3	16.4	45.4	45	0.4	1.3	●
GSDD0140	1.4	18.4	48.4	48	0.4	1.4	●
GSDD0150	1.5	18.5	48.5	48	0.5	1.5	●
GSDD0160	1.6	20.5	50.5	50	0.5	1.6	●
GSDD0170	1.7	20.5	50.5	50	0.5	1.7	●
GSDD0180	1.8	22.5	52.5	52	0.5	1.8	●
GSDD0190	1.9	22.6	52.6	52	0.6	1.9	●
GSDD0200	2.0	23.6	55.6	55	0.6	2.0	●
GSDD0210	2.1	23.6	55.6	55	0.6	2.1	●
GSDD0220	2.2	26.7	58.7	58	0.7	2.2	●
GSDD0230	2.3	26.7	58.7	58	0.7	2.3	●
GSDD0240	2.4	29.7	61.7	61	0.7	2.4	●
GSDD0250	2.5	29.8	61.8	61	0.8	2.5	●
GSDD0260	2.6	29.8	64.8	64	0.8	2.6	●
GSDD0270	2.7	32.8	64.8	64	0.8	2.7	●
GSDD0280	2.8	32.8	67.8	67	0.8	2.8	●
GSDD0290	2.9	32.9	71.9	71	0.9	2.9	●
GSDD0300	3.0	32.9	71.9	71	0.9	3.0	●
GSDD0310	3.1	35.9	71.9	71	0.9	3.1	●
GSDD0320	3.2	36.0	72.0	71	1.0	3.2	●
GSDD0330	3.3	36.0	74.0	73	1.0	3.3	●
GSDD0340	3.4	39.0	74.0	73	1.0	3.4	●
GSDD0350	3.5	39.1	74.1	73	1.1	3.5	●
GSDD0360	3.6	39.1	77.1	76	1.1	3.6	●
GSDD0370	3.7	39.1	77.1	76	1.1	3.7	●
GSDD0380	3.8	43.1	77.1	76	1.1	3.8	●
GSDD0390	3.9	43.2	80.2	79	1.2	3.9	●
GSDD0400	4.0	43.2	84.2	83	1.2	4.0	●
GSDD0410	4.1	43.2	84.2	83	1.2	4.1	●
GSDD0420	4.2	43.3	84.3	83	1.3	4.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GSDD0430	4.3	47.3	84.3	83	1.3	4.3	●
GSDD0440	4.4	47.3	87.3	86	1.3	4.4	●
GSDD0450	4.5	47.4	87.4	86	1.4	4.5	●
GSDD0460	4.6	47.4	87.4	86	1.4	4.6	●
GSDD0470	4.7	47.4	90.4	89	1.4	4.7	●
GSDD0480	4.8	52.4	90.4	89	1.4	4.8	●
GSDD0490	4.9	52.5	93.5	92	1.5	4.9	●
GSDD0500	5.0	52.5	93.5	92	1.5	5.0	●
GSDD0510	5.1	52.5	93.5	92	1.5	5.1	●
GSDD0520	5.2	52.6	96.6	95	1.6	5.2	●
GSDD0530	5.3	52.6	96.6	95	1.6	5.3	●
GSDD0540	5.4	57.6	96.6	95	1.6	5.4	●
GSDD0550	5.5	57.7	96.7	95	1.7	5.5	●
GSDD0560	5.6	57.7	99.7	98	1.7	5.6	●
GSDD0570	5.7	57.7	99.7	98	1.7	5.7	●
GSDD0580	5.8	57.7	99.7	98	1.7	5.8	●
GSDD0590	5.9	57.8	99.8	98	1.8	5.9	●
GSDD0600	6.0	57.8	103.8	102	1.8	6.0	●
GSDD0610	6.1	63.8	103.8	102	1.8	6.1	●
GSDD0620	6.2	63.9	103.9	102	1.9	6.2	●
GSDD0630	6.3	63.9	103.9	102	1.9	6.3	●
GSDD0640	6.4	63.9	106.9	105	1.9	6.4	●
GSDD0650	6.5	64.0	107.0	105	2.0	6.5	●
GSDD0660	6.6	64.0	107.0	105	2.0	6.6	●
GSDD0670	6.7	64.0	107.0	105	2.0	6.7	●
GSDD0680	6.8	69.0	107.0	105	2.0	6.8	●
GSDD0690	6.9	69.1	107.1	105	2.1	6.9	●
GSDD0700	7.0	69.1	107.1	105	2.1	7.0	●
GSDD0710	7.1	69.1	110.1	108	2.1	7.1	●
GSDD0720	7.2	69.2	110.2	108	2.2	7.2	●
GSDD0730	7.3	69.2	110.2	108	2.2	7.3	●
GSDD0740	7.4	69.2	113.2	111	2.2	7.4	●
GSDD0750	7.5	69.3	113.3	111	2.3	7.5	●
GSDD0760	7.6	75.3	113.3	111	2.3	7.6	●
GSDD0770	7.7	75.3	116.3	114	2.3	7.7	●
GSDD0780	7.8	75.3	116.3	114	2.3	7.8	●
GSDD0790	7.9	75.4	116.4	114	2.4	7.9	●
GSDD0800	8.0	75.4	116.4	114	2.4	8.0	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GSDD0810	8.1	75.4	119.4	117	2.4	8.1	●
GSDD0820	8.2	75.5	119.5	117	2.5	8.2	●
GSDD0830	8.3	75.5	119.5	117	2.5	8.3	●
GSDD0840	8.4	75.5	123.5	121	2.5	8.4	●
GSDD0850	8.5	75.6	123.6	121	2.6	8.5	●
GSDD0860	8.6	81.6	123.6	121	2.6	8.6	●
GSDD0870	8.7	81.6	123.6	121	2.6	8.7	●
GSDD0880	8.8	81.6	126.6	124	2.6	8.8	●
GSDD0890	8.9	81.7	126.7	124	2.7	8.9	●
GSDD0900	9.0	81.7	126.7	124	2.7	9.0	●
GSDD0910	9.1	81.7	126.7	124	2.7	9.1	●
GSDD0920	9.2	81.8	129.8	127	2.8	9.2	●
GSDD0930	9.3	81.8	129.8	127	2.8	9.3	●
GSDD0940	9.4	81.8	129.8	127	2.8	9.4	●
GSDD0950	9.5	81.9	129.9	127	2.9	9.5	●
GSDD0960	9.6	87.9	132.9	130	2.9	9.6	●
GSDD0970	9.7	87.9	132.9	130	2.9	9.7	●
GSDD0980	9.8	87.9	132.9	130	2.9	9.8	●
GSDD0990	9.9	88.0	133.0	130	3.0	9.9	●
GSDD1000	10.0	88.0	133.0	130	3.0	10.0	●
GSDD1010	10.1	88.0	136.0	133	3.0	10.1	●
GSDD1020	10.2	88.1	136.1	133	3.1	10.2	●
GSDD1030	10.3	88.1	136.1	133	3.1	10.3	●
GSDD1040	10.4	88.1	136.1	133	3.1	10.4	●
GSDD1050	10.5	88.2	140.2	137	3.2	10.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GSDD1060	10.6	88.2	140.2	137	3.2	10.6	●
GSDD1070	10.7	95.2	140.2	137	3.2	10.7	●
GSDD1080	10.8	95.2	143.2	140	3.2	10.8	●
GSDD1090	10.9	95.3	143.3	140	3.3	10.9	●
GSDD1100	11.0	95.3	143.3	140	3.3	11.0	●
GSDD1110	11.1	95.3	143.3	140	3.3	11.1	●
GSDD1120	11.2	95.4	146.4	143	3.4	11.2	●
GSDD1130	11.3	95.4	146.4	143	3.4	11.3	●
GSDD1140	11.4	95.4	146.4	143	3.4	11.4	●
GSDD1150	11.5	95.5	146.5	143	3.5	11.5	●
GSDD1160	11.6	95.5	149.5	146	3.5	11.6	●
GSDD1170	11.7	95.5	149.5	146	3.5	11.7	●
GSDD1180	11.8	95.6	149.6	146	3.6	11.8	●
GSDD1190	11.9	102.6	149.6	146	3.6	11.9	●
GSDD1200	12.0	102.6	152.6	149	3.6	12.0	●
GSDD1210	12.1	102.6	152.6	149	3.6	12.1	●
GSDD1220	12.2	102.7	152.7	149	3.7	12.2	●
GSDD1230	12.3	102.7	152.7	149	3.7	12.3	●
GSDD1240	12.4	102.7	155.7	152	3.7	12.4	●
GSDD1250	12.5	102.8	155.8	152	3.8	12.5	●
GSDD1260	12.6	102.8	155.8	152	3.8	12.6	●
GSDD1270	12.7	102.8	155.8	152	3.8	12.7	●
GSDD1280	12.8	102.9	155.9	152	3.9	12.8	●
GSDD1290	12.9	102.9	155.9	152	3.9	12.9	●
GSDD1300	13.0	102.9	155.9	152	3.9	13.0	●

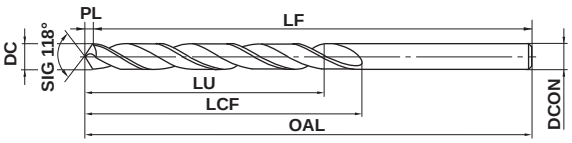
CUTTING CONDITIONS ➢ P208
TECHNICAL DATA ➢ R001

HSS

SD

Straight shank

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

0.2≦DC<1	1≦DC≦3	3<DC≦6	6<DC≦10	10<DC≦17.5
0 −0.012	0 −0.014	0 −0.018	0 −0.022	0 −0.027

●For general drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD0020	0.2	2.6	19.1	19	0.06	0.2	●
SDD0030	0.3	3.1	19.1	19	0.09	0.3	●
SDD0040	0.4	5.1	20.1	20	0.12	0.4	●
SDD0050	0.5	6.2	22.2	22	0.15	0.5	●
SDD0060	0.6	7.2	24.2	24	0.18	0.6	●
SDD0070	0.7	10.2	32.2	32	0.21	0.7	●
SDD0080	0.8	11.2	34.2	34	0.24	0.8	●
SDD0090	0.9	13.3	36.3	36	0.27	0.9	●
SDD0100	1.0	18.3	40.3	40	0.3	1.0	●
SDD0110	1.1	20.3	42.3	42	0.3	1.1	●
SDD0120	1.2	20.4	42.4	42	0.4	1.2	●
SDD0130	1.3	22.4	45.4	45	0.4	1.3	●
SDD0140	1.4	23.4	48.4	48	0.4	1.4	●
SDD0150	1.5	23.5	48.5	48	0.5	1.5	●
SDD0160	1.6	25.5	50.5	50	0.5	1.6	●
SDD0170	1.7	25.5	50.5	50	0.5	1.7	●
SDD0180	1.8	28.5	52.5	52	0.5	1.8	●
SDD0190	1.9	28.6	52.6	52	0.6	1.9	●
SDD0200	2.0	29.6	55.6	55	0.6	2.0	●
SDD0210	2.1	29.6	55.6	55	0.6	2.1	●
SDD0220	2.2	33.7	58.7	58	0.7	2.2	●
SDD0230	2.3	33.7	58.7	58	0.7	2.3	●
SDD0240	2.4	35.7	61.7	61	0.7	2.4	●
SDD0250	2.5	35.8	61.8	61	0.8	2.5	●
SDD0260	2.6	37.8	64.8	64	0.8	2.6	●
SDD0270	2.7	37.8	64.8	64	0.8	2.7	●
SDD0280	2.8	39.8	67.8	67	0.8	2.8	●
SDD0290	2.9	42.9	71.9	71	0.9	2.9	●
SDD0300	3.0	42.9	71.9	71	0.9	3.0	●
SDD0310	3.1	42.9	71.9	71	0.9	3.1	●
SDD0320	3.2	43.0	72.0	71	1.0	3.2	●
SDD0330	3.3	46.0	74.0	73	1.0	3.3	●
SDD0340	3.4	46.0	74.0	73	1.0	3.4	●
SDD0350	3.5	46.1	74.1	73	1.1	3.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD0360	3.6	49.1	77.1	76	1.1	3.6	●
SDD0370	3.7	49.1	77.1	76	1.1	3.7	●
SDD0380	3.8	49.1	77.1	76	1.1	3.8	●
SDD0390	3.9	52.2	80.2	79	1.2	3.9	●
SDD0400	4.0	55.2	84.2	83	1.2	4.0	●
SDD0410	4.1	55.2	84.2	83	1.2	4.1	●
SDD0420	4.2	55.3	84.3	83	1.3	4.2	●
SDD0430	4.3	55.3	84.3	83	1.3	4.3	●
SDD0440	4.4	57.3	87.3	86	1.3	4.4	●
SDD0450	4.5	57.4	87.4	86	1.4	4.5	●
SDD0460	4.6	57.4	87.4	86	1.4	4.6	●
SDD0470	4.7	60.4	90.4	89	1.4	4.7	●
SDD0480	4.8	60.4	90.4	89	1.4	4.8	●
SDD0490	4.9	63.5	93.5	92	1.5	4.9	●
SDD0500	5.0	63.5	93.5	92	1.5	5.0	●
SDD0510	5.1	63.5	93.5	92	1.5	5.1	●
SDD0520	5.2	65.6	96.6	95	1.6	5.2	●
SDD0530	5.3	65.6	96.6	95	1.6	5.3	●
SDD0540	5.4	65.6	96.6	95	1.6	5.4	●
SDD0550	5.5	65.7	96.7	95	1.7	5.5	●
SDD0560	5.6	68.7	99.7	98	1.7	5.6	●
SDD0570	5.7	68.7	99.7	98	1.7	5.7	●
SDD0580	5.8	68.7	99.7	98	1.7	5.8	●
SDD0590	5.9	68.8	99.8	98	1.8	5.9	●
SDD0600	6.0	71.8	103.8	102	1.8	6.0	●
SDD0610	6.1	71.8	103.8	102	1.8	6.1	●
SDD0620	6.2	71.9	103.9	102	1.9	6.2	●
SDD0630	6.3	71.9	103.9	102	1.9	6.3	●
SDD0640	6.4	74.9	106.9	105	1.9	6.4	●
SDD0650	6.5	75.0	107.0	105	2.0	6.5	●
SDD0660	6.6	75.0	107.0	105	2.0	6.6	●
SDD0670	6.7	75.0	107.0	105	2.0	6.7	●
SDD0680	6.8	75.0	107.0	105	2.0	6.8	●
SDD0690	6.9	75.1	107.1	105	2.1	6.9	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD0700	7.0	75.1	107.1	105	2.1	7.0	●
SDD0710	7.1	77.1	110.1	108	2.1	7.1	●
SDD0720	7.2	77.2	110.2	108	2.2	7.2	●
SDD0730	7.3	77.2	110.2	108	2.2	7.3	●
SDD0740	7.4	80.2	113.2	111	2.2	7.4	●
SDD0750	7.5	80.3	113.3	111	2.3	7.5	●
SDD0760	7.6	80.3	113.3	111	2.3	7.6	●
SDD0770	7.7	83.3	116.3	114	2.3	7.7	●
SDD0780	7.8	83.3	116.3	114	2.3	7.8	●
SDD0790	7.9	83.4	116.4	114	2.4	7.9	●
SDD0800	8.0	83.4	116.4	114	2.4	8.0	●
SDD0810	8.1	86.4	119.4	117	2.4	8.1	●
SDD0820	8.2	86.5	119.5	117	2.5	8.2	●
SDD0830	8.3	86.5	119.5	117	2.5	8.3	●
SDD0840	8.4	89.5	123.5	121	2.5	8.4	●
SDD0850	8.5	89.6	123.6	121	2.6	8.5	●
SDD0860	8.6	89.6	123.6	121	2.6	8.6	●
SDD0870	8.7	89.6	123.6	121	2.6	8.7	●
SDD0880	8.8	91.6	126.6	124	2.6	8.8	●
SDD0890	8.9	91.7	126.7	124	2.7	8.9	●
SDD0900	9.0	91.7	126.7	124	2.7	9.0	●
SDD0910	9.1	91.7	126.7	124	2.7	9.1	●
SDD0920	9.2	94.8	129.8	127	2.8	9.2	●
SDD0930	9.3	94.8	129.8	127	2.8	9.3	●
SDD0940	9.4	94.8	129.8	127	2.8	9.4	●
SDD0950	9.5	94.9	129.9	127	2.9	9.5	●
SDD0960	9.6	97.9	132.9	130	2.9	9.6	●
SDD0970	9.7	97.9	132.9	130	2.9	9.7	●
SDD0980	9.8	97.9	132.9	130	2.9	9.8	●
SDD0990	9.9	98.0	133.0	130	3.0	9.9	●
SDD1000	10.0	98.0	133.0	130	3.0	10.0	●
SDD1010	10.1	101.0	136.0	133	3.0	10.1	●
SDD1020	10.2	101.1	136.1	133	3.1	10.2	●
SDD1030	10.3	101.1	136.1	133	3.1	10.3	●
SDD1040	10.4	101.1	136.1	133	3.1	10.4	●
SDD1050	10.5	103.2	140.2	137	3.2	10.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD1060	10.6	103.2	140.2	137	3.2	10.6	●
SDD1070	10.7	103.2	140.2	137	3.2	10.7	●
SDD1080	10.8	106.2	143.2	140	3.2	10.8	●
SDD1090	10.9	106.3	143.3	140	3.3	10.9	●
SDD1100	11.0	106.3	143.3	140	3.3	11.0	●
SDD1110	11.1	106.3	143.3	140	3.3	11.1	●
SDD1120	11.2	109.4	146.4	143	3.4	11.2	●
SDD1130	11.3	109.4	146.4	143	3.4	11.3	●
SDD1140	11.4	109.4	146.4	143	3.4	11.4	●
SDD1150	11.5	109.5	146.5	143	3.5	11.5	●
SDD1160	11.6	112.5	149.5	146	3.5	11.6	●
SDD1170	11.7	112.5	149.5	146	3.5	11.7	●
SDD1180	11.8	112.6	149.6	146	3.6	11.8	●
SDD1190	11.9	112.6	149.6	146	3.6	11.9	●
SDD1200	12.0	114.6	152.6	149	3.6	12.0	●
SDD1210	12.1	114.6	152.6	149	3.6	12.1	●
SDD1220	12.2	114.7	152.7	149	3.7	12.2	●
SDD1230	12.3	114.7	152.7	149	3.7	12.3	●
SDD1240	12.4	117.7	155.7	152	3.7	12.4	●
SDD1250	12.5	117.8	155.8	152	3.8	12.5	●
SDD1260	12.6	117.8	155.8	152	3.8	12.6	●
SDD1270	12.7	117.8	155.8	152	3.8	12.7	●
SDD1280	12.8	117.9	155.9	152	3.9	12.8	●
SDD1290	12.9	117.9	155.9	152	3.9	12.9	●
SDD1300	13.0	117.9	155.9	152	3.9	13.0	●
SDD1350	13.5	126.1	172.1	168	4.1	13.5	●
SDD1400	14.0	126.2	172.2	168	4.2	14.0	●
SDD1450	14.5	126.4	172.4	168	4.4	14.5	●
SDD1500	15.0	136.5	185.5	181	4.5	15.0	●
SDD1550	15.5	136.7	185.7	181	4.7	15.5	●
SDD1600	16.0	136.8	185.8	181	4.8	16.0	●
SDD1650	16.5	137.0	186.0	181	5.0	16.5	●
SDD1700	17.0	148.1	199.1	194	5.1	17.0	●
SDD1750	17.5	148.3	199.3	194	5.3	17.5	●

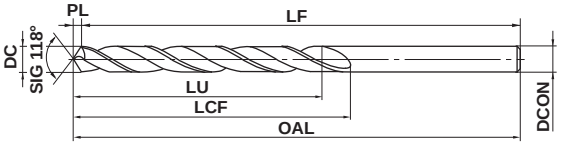
CUTTING CONDITIONS ➢ P209
TECHNICAL DATA ➢ R001

HSS

SD

Straight shank, 1/100mm

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

$0.25 \leq DC \leq 5.95$ $\frac{0}{-0.007}$

●The diameter tolerance is $^{0}_{-0.007}$ mm.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD0025	0.25	3.1	19.1	19	0.08	0.25	●
SDD0035	0.35	4.1	19.1	19	0.11	0.35	●
SDD0045	0.45	5.1	20.1	20	0.14	0.45	●
SDD0055	0.55	7.2	24.2	24	0.17	0.55	●
SDD0065	0.65	8.2	26.2	26	0.20	0.65	●
SDD0075	0.75	11.2	34.2	34	0.23	0.75	●
SDD0085	0.85	13.3	36.3	36	0.26	0.85	●
SDD0095	0.95	18.3	40.3	40	0.29	0.95	●
SDD0105	1.05	20.3	42.3	42	0.3	1.05	●
SDD0115	1.15	20.4	42.4	42	0.4	1.15	●
SDD0125	1.25	22.4	45.4	45	0.4	1.25	●
SDD0135	1.35	23.4	48.4	48	0.4	1.35	●
SDD0145	1.45	23.4	48.4	48	0.4	1.45	●
SDD0155	1.55	25.5	50.5	50	0.5	1.55	●
SDD0165	1.65	25.5	50.5	50	0.5	1.65	●
SDD0175	1.75	28.5	52.5	52	0.5	1.75	●
SDD0185	1.85	28.6	52.6	52	0.6	1.85	●
SDD0195	1.95	29.6	55.6	55	0.6	1.95	●
SDD0205	2.05	29.6	55.6	55	0.6	2.05	●
SDD0215	2.15	29.7	55.7	55	0.7	2.15	●
SDD0225	2.25	33.7	58.7	58	0.7	2.25	●
SDD0235	2.35	33.7	58.7	58	0.7	2.35	●
SDD0245	2.45	35.7	61.7	61	0.7	2.45	●
SDD0255	2.55	37.8	64.8	64	0.8	2.55	●
SDD0265	2.65	37.8	64.8	64	0.8	2.65	●
SDD0275	2.75	39.8	67.8	67	0.8	2.75	●
SDD0285	2.85	39.9	67.9	67	0.9	2.85	●
SDD0295	2.95	42.9	71.9	71	0.9	2.95	●
SDD0305	3.05	42.9	71.9	71	0.9	3.05	●
SDD0315	3.15	43.0	72.0	71	1.0	3.15	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDD0325	3.25	43.0	72.0	71	1.0	3.25	●
SDD0335	3.35	46.0	74.0	73	1.0	3.35	●
SDD0345	3.45	46.0	74.0	73	1.0	3.45	●
SDD0355	3.55	46.1	74.1	73	1.1	3.55	●
SDD0365	3.65	49.1	77.1	76	1.1	3.65	●
SDD0375	3.75	49.1	77.1	76	1.1	3.75	●
SDD0385	3.85	52.2	80.2	79	1.2	3.85	●
SDD0395	3.95	52.2	80.2	79	1.2	3.95	●
SDD0405	4.05	55.2	84.2	83	1.2	4.05	●
SDD0415	4.15	55.3	84.3	83	1.3	4.15	●
SDD0425	4.25	55.3	84.3	83	1.3	4.25	●
SDD0435	4.35	55.3	84.3	83	1.3	4.35	●
SDD0445	4.45	57.3	87.3	86	1.3	4.45	●
SDD0455	4.55	57.4	87.4	86	1.4	4.55	●
SDD0465	4.65	60.4	90.4	89	1.4	4.65	●
SDD0475	4.75	60.4	90.4	89	1.4	4.75	●
SDD0485	4.85	60.5	90.5	89	1.5	4.85	●
SDD0495	4.95	63.5	93.5	92	1.5	4.95	●
SDD0505	5.05	63.5	93.5	92	1.5	5.05	●
SDD0515	5.15	63.6	93.6	92	1.6	5.15	●
SDD0525	5.25	65.6	96.6	95	1.6	5.25	●
SDD0535	5.35	65.6	96.6	95	1.6	5.35	●
SDD0545	5.45	65.6	96.6	95	1.6	5.45	●
SDD0555	5.55	65.7	96.7	95	1.7	5.55	●
SDD0565	5.65	68.7	99.7	98	1.7	5.65	●
SDD0575	5.75	68.7	99.7	98	1.7	5.75	●
SDD0585	5.85	68.8	99.8	98	1.8	5.85	●
SDD0595	5.95	68.8	99.8	98	1.8	5.95	●

● : Inventory maintained in Japan.

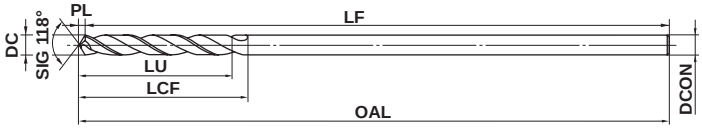
CUTTING CONDITIONS ➤ P209
TECHNICAL DATA ➤ R001

SDLS

Long shank straight drill

HSS 118° DC≥2

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

1≤DC≤3	3<DC≤6	6<DC≤10
0 −0.014	0 −0.018	0 −0.022

- It is recommended to use when long overall length is demanded for preventing collision with workpiece with high rigidity.
- For both machining center and manually operated machines.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDLSD0100A100	1.0	12.3	100.3	100	0.3	1.0	●
SDLSD0110A100	1.1	14.3	100.3	100	0.3	1.1	●
SDLSD0120A100	1.2	16.4	100.4	100	0.4	1.2	●
SDLSD0130A100	1.3	16.4	100.4	100	0.4	1.3	●
SDLSD0140A100	1.4	18.4	100.4	100	0.4	1.4	●
SDLSD0150A100	1.5	18.5	100.5	100	0.5	1.5	●
SDLSD0160A100	1.6	20.5	100.5	100	0.5	1.6	●
SDLSD0170A100	1.7	20.5	100.5	100	0.5	1.7	●
SDLSD0180A100	1.8	22.5	100.5	100	0.5	1.8	●
SDLSD0190A100	1.9	22.6	100.6	100	0.6	1.9	●
SDLSD0200A100	2.0	23.6	100.6	100	0.6	2.0	●
SDLSD0210A150	2.1	23.6	150.6	150	0.6	2.1	●
SDLSD0220A150	2.2	26.7	150.7	150	0.7	2.2	●
SDLSD0230A150	2.3	26.7	150.7	150	0.7	2.3	●
SDLSD0240A150	2.4	29.7	150.7	150	0.7	2.4	●
SDLSD0250A150	2.5	29.8	150.8	150	0.8	2.5	●
SDLSD0260A150	2.6	29.8	150.8	150	0.8	2.6	●
SDLSD0270A150	2.7	32.8	150.8	150	0.8	2.7	●
SDLSD0280A150	2.8	32.8	150.8	150	0.8	2.8	●
SDLSD0290A150	2.9	32.9	150.9	150	0.9	2.9	●
SDLSD0300A150	3.0	32.9	150.9	150	0.9	3.0	●
SDLSD0310A150	3.1	35.9	150.9	150	0.9	3.1	●
SDLSD0320A150	3.2	36.0	151.0	150	1.0	3.2	●
SDLSD0330A150	3.3	36.0	151.0	150	1.0	3.3	●
SDLSD0340A150	3.4	39.0	151.0	150	1.0	3.4	●
SDLSD0350A150	3.5	39.1	151.1	150	1.1	3.5	●
SDLSD0360A200	3.6	39.1	201.1	200	1.1	3.6	●
SDLSD0370A200	3.7	39.1	201.1	200	1.1	3.7	●
SDLSD0380A200	3.8	43.1	201.1	200	1.1	3.8	●
SDLSD0390A200	3.9	43.2	201.2	200	1.2	3.9	●
SDLSD0400A200	4.0	43.2	201.2	200	1.2	4.0	●
SDLSD0410A200	4.1	43.2	201.2	200	1.2	4.1	●
SDLSD0420A200	4.2	43.3	201.3	200	1.3	4.2	●
SDLSD0430A200	4.3	47.3	201.3	200	1.3	4.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDLSD0440A200	4.4	47.3	201.3	200	1.3	4.4	●
SDLSD0450A200	4.5	47.4	201.4	200	1.4	4.5	●
SDLSD0460A200	4.6	47.4	201.4	200	1.4	4.6	●
SDLSD0470A200	4.7	47.4	201.4	200	1.4	4.7	●
SDLSD0480A200	4.8	52.4	201.4	200	1.4	4.8	●
SDLSD0490A200	4.9	52.5	201.5	200	1.5	4.9	●
SDLSD0500A200	5.0	52.5	201.5	200	1.5	5.0	●
SDLSD0510A200	5.1	52.5	201.5	200	1.5	5.1	●
SDLSD0520A200	5.2	52.6	201.6	200	1.6	5.2	●
SDLSD0530A200	5.3	52.6	201.6	200	1.6	5.3	●
SDLSD0540A200	5.4	57.6	201.6	200	1.6	5.4	●
SDLSD0550A200	5.5	57.7	201.7	200	1.7	5.5	●
SDLSD0560A200	5.6	57.7	201.7	200	1.7	5.6	●
SDLSD0570A200	5.7	57.7	201.7	200	1.7	5.7	●
SDLSD0580A200	5.8	57.7	201.7	200	1.7	5.8	●
SDLSD0590A200	5.9	57.8	201.8	200	1.8	5.9	●
SDLSD0600A200	6.0	57.8	201.8	200	1.8	6.0	●
SDLSD0610A250	6.1	63.8	251.8	250	1.8	6.1	●
SDLSD0620A250	6.2	63.9	251.9	250	1.9	6.2	●
SDLSD0630A250	6.3	63.9	251.9	250	1.9	6.3	●
SDLSD0640A250	6.4	63.9	251.9	250	1.9	6.4	●
SDLSD0650A250	6.5	64.0	252.0	250	2.0	6.5	●
SDLSD0660A250	6.6	64.0	252.0	250	2.0	6.6	●
SDLSD0670A250	6.7	64.0	252.0	250	2.0	6.7	●
SDLSD0680A250	6.8	69.0	252.0	250	2.0	6.8	●
SDLSD0690A250	6.9	69.1	252.1	250	2.1	6.9	●
SDLSD0700A250	7.0	69.1	252.1	250	2.1	7.0	●
SDLSD0710A250	7.1	69.1	252.1	250	2.1	7.1	●
SDLSD0720A250	7.2	69.2	252.2	250	2.2	7.2	●
SDLSD0730A250	7.3	69.2	252.2	250	2.2	7.3	●
SDLSD0740A250	7.4	69.2	252.2	250	2.2	7.4	●
SDLSD0750A250	7.5	69.3	252.3	250	2.3	7.5	●
SDLSD0760A250	7.6	75.3	252.3	250	2.3	7.6	●
SDLSD0770A250	7.7	75.3	252.3	250	2.3	7.7	●

CUTTING CONDITIONS ➤ P181
TECHNICAL DATA ➤ R001

SDLS

Long shank straight drill

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDLSD0780A250	7.8	75.3	252.3	250	2.3	7.8	●
SDLSD0790A250	7.9	75.4	252.4	250	2.4	7.9	●
SDLSD0800A250	8.0	75.4	252.4	250	2.4	8.0	●
SDLSD0810A250	8.1	75.4	252.4	250	2.4	8.1	●
SDLSD0820A250	8.2	75.5	252.5	250	2.5	8.2	●
SDLSD0830A250	8.3	75.5	252.5	250	2.5	8.3	●
SDLSD0840A250	8.4	75.5	252.5	250	2.5	8.4	●
SDLSD0850A250	8.5	75.6	252.6	250	2.6	8.5	●
SDLSD0860A250	8.6	81.6	252.6	250	2.6	8.6	●
SDLSD0870A250	8.7	81.6	252.6	250	2.6	8.7	●
SDLSD0880A250	8.8	81.6	252.6	250	2.6	8.8	●
SDLSD0890A250	8.9	81.7	252.7	250	2.7	8.9	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
SDLSD0900A250	9.0	81.7	252.7	250	2.7	9.0	●
SDLSD0910A250	9.1	81.7	252.7	250	2.7	9.1	●
SDLSD0920A250	9.2	81.8	252.8	250	2.8	9.2	●
SDLSD0930A250	9.3	81.8	252.8	250	2.8	9.3	●
SDLSD0940A250	9.4	81.8	252.8	250	2.8	9.4	●
SDLSD0950A250	9.5	81.9	252.9	250	2.9	9.5	●
SDLSD0960A250	9.6	87.9	252.9	250	2.9	9.6	●
SDLSD0970A250	9.7	87.9	252.9	250	2.9	9.7	●
SDLSD0980A250	9.8	87.9	252.9	250	2.9	9.8	●
SDLSD0990A250	9.9	88.0	253.0	250	3.0	9.9	●
SDLSD1000A250	10.0	88.0	253.0	250	3.0	10.0	●

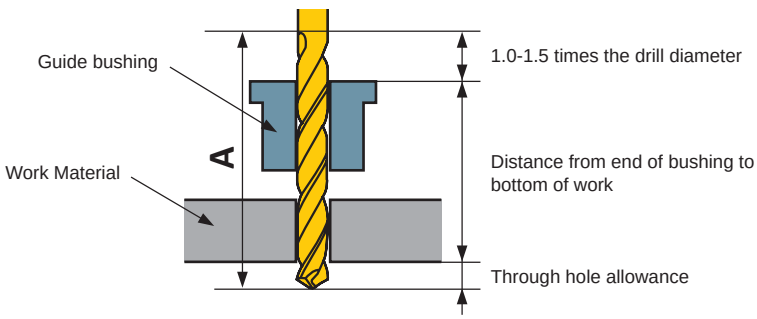
● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Mild Steel (≤180HB), Carbon Steel, Alloy Steel(180−250HB) ASTM A36, AISI 1010 AISI 1045, AISI 4140 etc				Alloy Tool Steel (≤30HRC) AISI H13, AISI L6 etc				Alloy Tool Steel (<40HRC) AISI H13, AISI L6 etc				Gray Cast Iron (≤350MPa) No 45 B etc			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)
1.0	16	5000	0.02	100	13	4000	0.01	40	9	2800	0.007	15	16	5000	0.02	100
1.5	20	4200	0.03	125	15	3200	0.02	60	10	2100	0.01	20	20	4200	0.03	125
2.0	20	3200	0.05	160	16	2500	0.03	75	11	1800	0.02	35	20	3200	0.05	160
3.0	20	2100	0.1	210	17	1800	0.06	105	11	1200	0.04	45	22	2300	0.1	230
4.0	20	1600	0.12	190	17	1350	0.08	105	11	900	0.06	50	22	1750	0.12	210
5.0	20	1300	0.14	180	17	1100	0.1	110	11	700	0.08	55	22	1400	0.14	195
6.0	20	1050	0.17	175	17	900	0.12	105	11	600	0.1	60	22	1150	0.18	205
7.0	20	900	0.19	170	17	780	0.14	105	11	500	0.11	55	22	1000	0.19	190
8.0	20	800	0.2	160	17	670	0.15	100	11	450	0.12	50	22	890	0.2	175
9.0	20	700	0.21	145	17	600	0.16	95	11	400	0.13	50	22	780	0.21	160
10.0	20	650	0.22	140	17	540	0.17	90	11	350	0.14	45	22	700	0.22	150

Work Material	Ferritic and Martensitic Stainless Steel (≤200HB) AISI 410, AISI 430 etc				Austenitic Stainless Steel (≤200HB) AISI 304, AISI 316 etc				Copper, Copper Alloy				Aluminium Alloy (Si<5%)			
Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed rate (mm/rev)	Table Feed (mm/min)
1.0	13	4000	0.02	80	9	3000	0.02	60	16	5000	0.02	100	22	7000	0.04	280
1.5	14	3000	0.03	90	9	2000	0.03	60	20	4200	0.03	125	28	6000	0.06	360
2.0	14	2200	0.05	110	9	1500	0.04	60	20	3200	0.05	160	30	4800	0.08	380
3.0	15	1600	0.07	110	9	1000	0.06	60	20	2100	0.1	210	40	4200	0.13	545
4.0	15	1200	0.11	130	9	700	0.08	55	20	1600	0.12	190	40	3200	0.16	510
5.0	15	950	0.13	120	9	600	0.09	50	20	1300	0.14	180	40	2550	0.2	510
6.0	15	800	0.14	110	10	530	0.1	50	20	1050	0.18	185	40	2100	0.23	480
7.0	15	700	0.15	105	10	450	0.11	45	20	900	0.19	170	40	1800	0.25	450
8.0	15	600	0.16	95	10	400	0.13	50	20	800	0.2	160	40	1600	0.28	445
9.0	15	520	0.17	85	10	360	0.14	50	20	700	0.21	145	40	1400	0.3	420
10.0	15	480	0.18	85	10	310	0.15	45	20	650	0.22	140	40	1280	0.33	420

Note 1) The intermediate diameter revolution is not tabulated. It is matched to the large diameter side and closest drill diameter conditions or by calculating the cutting speed of the closest drill diameter. Set the feedrate per revolution to a suitable value with the recommended feedrate of the closest drill diameter as the standard.
Note 2) Lower the revolution and feedrate accordingly, when the work material is not rigid or there are restrictions on the machine.
Note 3) When drilling holes greater than 3 x drill diameter hole depths, please use a peck feed.
Note 4) The cutting conditions mentioned above arevstandard with the tool protrusion length was made 2 times the flute length.
Note 5) Use of water-soluble cutting fluid is recommended. Please reduce the revolution when using water-insoluble cutting fluid.
Note 6) Use sufficient cutting fluid. Please reduce the revolution when insufficient cutting fluid.
Note 7) When using a guide bush, please confirm the flute length > A. In case of short flute length, please conduct machining without the bush. And, when not being able to dismount the bush, please use LSD or GWSL.



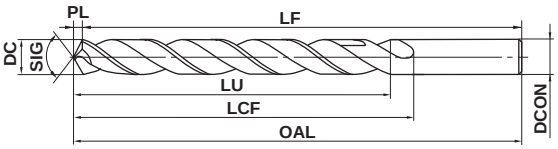
HSS

KSD

Cobalt HSS, For stainless steel

CO HSS | 125° DC<2 | 118° DC≥2 | XR DC≥2

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

1≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

●Sharp edge geometry for stainless steels up to 200HB.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
KSDD0100	1.0	12.3	40.3	40	0.3	1.0	●
KSDD0110	1.1	14.3	42.3	42	0.3	1.1	●
KSDD0120	1.2	16.3	42.3	42	0.3	1.2	●
KSDD0130	1.3	16.3	45.3	45	0.3	1.3	●
KSDD0140	1.4	18.4	48.4	48	0.4	1.4	●
KSDD0150	1.5	18.4	48.4	48	0.4	1.5	●
KSDD0160	1.6	20.4	50.4	50	0.4	1.6	●
KSDD0170	1.7	20.4	50.4	50	0.4	1.7	●
KSDD0180	1.8	22.5	52.5	52	0.5	1.8	●
KSDD0190	1.9	22.5	52.5	52	0.5	1.9	●
KSDD0200	2.0	29.6	55.6	55	0.6	2.0	●
KSDD0210	2.1	29.6	55.6	55	0.6	2.1	●
KSDD0220	2.2	33.7	58.7	58	0.7	2.2	●
KSDD0230	2.3	33.7	58.7	58	0.7	2.3	●
KSDD0240	2.4	35.7	61.7	61	0.7	2.4	●
KSDD0250	2.5	35.8	61.8	61	0.8	2.5	●
KSDD0260	2.6	37.8	64.8	64	0.8	2.6	●
KSDD0270	2.7	37.8	64.8	64	0.8	2.7	●
KSDD0280	2.8	39.8	67.8	67	0.8	2.8	●
KSDD0290	2.9	42.9	71.9	71	0.9	2.9	●
KSDD0300	3.0	42.9	71.9	71	0.9	3.0	●
KSDD0310	3.1	42.9	71.9	71	0.9	3.1	●
KSDD0320	3.2	43.0	72.0	71	1.0	3.2	●
KSDD0330	3.3	46.0	74.0	73	1.0	3.3	●
KSDD0340	3.4	46.0	74.0	73	1.0	3.4	●
KSDD0350	3.5	46.1	74.1	73	1.1	3.5	●
KSDD0360	3.6	49.1	77.1	76	1.1	3.6	●
KSDD0370	3.7	49.1	77.1	76	1.1	3.7	●
KSDD0380	3.8	49.1	77.1	76	1.1	3.8	●
KSDD0390	3.9	52.2	80.2	79	1.2	3.9	●
KSDD0400	4.0	55.2	84.2	83	1.2	4.0	●
KSDD0410	4.1	55.2	84.2	83	1.2	4.1	●
KSDD0420	4.2	55.3	84.3	83	1.3	4.2	●
KSDD0430	4.3	55.3	84.3	83	1.3	4.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
KSDD0440	4.4	57.3	87.3	86	1.3	4.4	●
KSDD0450	4.5	57.4	87.4	86	1.4	4.5	●
KSDD0460	4.6	57.4	87.4	86	1.4	4.6	●
KSDD0470	4.7	60.4	90.4	89	1.4	4.7	●
KSDD0480	4.8	60.4	90.4	89	1.4	4.8	●
KSDD0490	4.9	63.5	93.5	92	1.5	4.9	●
KSDD0500	5.0	63.5	93.5	92	1.5	5.0	●
KSDD0510	5.1	63.5	93.5	92	1.5	5.1	●
KSDD0520	5.2	65.6	96.6	95	1.6	5.2	●
KSDD0530	5.3	65.6	96.6	95	1.6	5.3	●
KSDD0540	5.4	65.6	96.6	95	1.6	5.4	●
KSDD0550	5.5	65.7	96.7	95	1.7	5.5	●
KSDD0560	5.6	68.7	99.7	98	1.7	5.6	●
KSDD0570	5.7	68.7	99.7	98	1.7	5.7	●
KSDD0580	5.8	68.7	99.7	98	1.7	5.8	●
KSDD0590	5.9	68.8	99.8	98	1.8	5.9	●
KSDD0600	6.0	71.8	103.8	102	1.8	6.0	●
KSDD0610	6.1	71.8	103.8	102	1.8	6.1	●
KSDD0620	6.2	71.9	103.9	102	1.9	6.2	●
KSDD0630	6.3	71.9	103.9	102	1.9	6.3	●
KSDD0640	6.4	74.9	106.9	105	1.9	6.4	●
KSDD0650	6.5	75.0	107.0	105	2.0	6.5	●
KSDD0660	6.6	75.0	107.0	105	2.0	6.6	●
KSDD0670	6.7	75.0	107.0	105	2.0	6.7	●
KSDD0680	6.8	75.0	107.0	105	2.0	6.8	●
KSDD0690	6.9	75.1	107.1	105	2.1	6.9	●
KSDD0700	7.0	75.1	107.1	105	2.1	7.0	●
KSDD0710	7.1	77.1	110.1	108	2.1	7.1	●
KSDD0720	7.2	77.2	110.2	108	2.2	7.2	●
KSDD0730	7.3	77.2	110.2	108	2.2	7.3	●
KSDD0740	7.4	80.2	113.2	111	2.2	7.4	●
KSDD0750	7.5	80.3	113.3	111	2.3	7.5	●
KSDD0760	7.6	80.3	113.3	111	2.3	7.6	●
KSDD0770	7.7	83.3	116.3	114	2.3	7.7	●

● : **Inventory maintained in Japan.**

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
KSDD0780	7.8	83.3	116.3	114	2.3	7.8	●
KSDD0790	7.9	83.4	116.4	114	2.4	7.9	●
KSDD0800	8.0	83.4	116.4	114	2.4	8.0	●
KSDD0810	8.1	86.4	119.4	117	2.4	8.1	●
KSDD0820	8.2	86.5	119.5	117	2.5	8.2	●
KSDD0830	8.3	86.5	119.5	117	2.5	8.3	●
KSDD0840	8.4	89.5	123.5	121	2.5	8.4	●
KSDD0850	8.5	89.6	123.6	121	2.6	8.5	●
KSDD0860	8.6	89.6	123.6	121	2.6	8.6	●
KSDD0870	8.7	89.6	123.6	121	2.6	8.7	●
KSDD0880	8.8	91.6	126.6	124	2.6	8.8	●
KSDD0890	8.9	91.7	126.7	124	2.7	8.9	●
KSDD0900	9.0	91.7	126.7	124	2.7	9.0	●
KSDD0910	9.1	91.7	126.7	124	2.7	9.1	●
KSDD0920	9.2	94.8	129.8	127	2.8	9.2	●
KSDD0930	9.3	94.8	129.8	127	2.8	9.3	●
KSDD0940	9.4	94.8	129.8	127	2.8	9.4	●
KSDD0950	9.5	94.9	129.9	127	2.9	9.5	●
KSDD0960	9.6	97.9	132.9	130	2.9	9.6	●
KSDD0970	9.7	97.9	132.9	130	2.9	9.7	●
KSDD0980	9.8	97.9	132.9	130	2.9	9.8	●
KSDD0990	9.9	98.0	133.0	130	3.0	9.9	●
KSDD1000	10.0	98.0	133.0	130	3.0	10.0	●
KSDD1010	10.1	101.0	136.0	133	3.0	10.1	●
KSDD1020	10.2	101.1	136.1	133	3.1	10.2	●
KSDD1030	10.3	101.1	136.1	133	3.1	10.3	●
KSDD1040	10.4	101.1	136.1	133	3.1	10.4	●
KSDD1050	10.5	103.2	140.2	137	3.2	10.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
KSDD1060	10.6	103.2	140.2	137	3.2	10.6	●
KSDD1070	10.7	103.2	140.2	137	3.2	10.7	●
KSDD1080	10.8	106.2	143.2	140	3.2	10.8	●
KSDD1090	10.9	106.3	143.3	140	3.3	10.9	●
KSDD1100	11.0	106.3	143.3	140	3.3	11.0	●
KSDD1110	11.1	106.3	143.3	140	3.3	11.1	●
KSDD1120	11.2	109.4	146.4	143	3.4	11.2	●
KSDD1130	11.3	109.4	146.4	143	3.4	11.3	●
KSDD1140	11.4	109.4	146.4	143	3.4	11.4	●
KSDD1150	11.5	109.5	146.5	143	3.5	11.5	●
KSDD1160	11.6	112.5	149.5	146	3.5	11.6	●
KSDD1170	11.7	112.5	149.5	146	3.5	11.7	●
KSDD1180	11.8	112.5	149.5	146	3.5	11.8	●
KSDD1190	11.9	112.6	149.6	146	3.6	11.9	●
KSDD1200	12.0	114.6	152.6	149	3.6	12.0	●
KSDD1210	12.1	114.6	152.6	149	3.6	12.1	●
KSDD1220	12.2	114.7	152.7	149	3.7	12.2	●
KSDD1230	12.3	114.7	152.7	149	3.7	12.3	●
KSDD1240	12.4	117.7	155.7	152	3.7	12.4	●
KSDD1250	12.5	117.8	155.8	152	3.8	12.5	●
KSDD1260	12.6	117.8	155.8	152	3.8	12.6	●
KSDD1270	12.7	117.8	155.8	152	3.8	12.7	●
KSDD1280	12.8	117.8	155.8	152	3.8	12.8	●
KSDD1290	12.9	117.9	155.9	152	3.9	12.9	●
KSDD1300	13.0	117.9	155.9	152	3.9	13.0	●

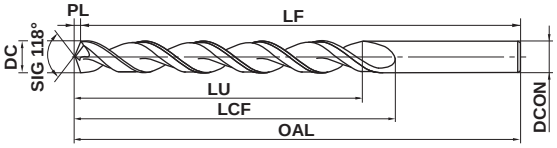
CUTTING CONDITIONS ➢ P209
TECHNICAL DATA ➢ R001

HSS

GWSS

TiN, For deep hole, Convolute flute

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

1≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

●Suitable for general and deep hole drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSSD0100	1.0	18.3	40.3	40	0.3	1.0	●
GWSSD0110	1.1	20.3	42.3	42	0.3	1.1	●
GWSSD0120	1.2	20.4	42.4	42	0.4	1.2	●
GWSSD0130	1.3	22.4	45.4	45	0.4	1.3	●
GWSSD0140	1.4	23.4	48.4	48	0.4	1.4	●
GWSSD0150	1.5	23.5	48.5	48	0.5	1.5	●
GWSSD0160	1.6	25.5	50.5	50	0.5	1.6	●
GWSSD0170	1.7	25.5	50.5	50	0.5	1.7	●
GWSSD0180	1.8	28.5	52.5	52	0.5	1.8	●
GWSSD0190	1.9	28.6	52.6	52	0.6	1.9	●
GWSSD0200	2.0	29.6	55.6	55	0.6	2.0	●
GWSSD0210	2.1	29.6	55.6	55	0.6	2.1	●
GWSSD0220	2.2	33.7	58.7	58	0.7	2.2	●
GWSSD0230	2.3	33.7	58.7	58	0.7	2.3	●
GWSSD0240	2.4	35.7	61.7	61	0.7	2.4	●
GWSSD0250	2.5	35.8	61.8	61	0.8	2.5	●
GWSSD0260	2.6	37.8	64.8	64	0.8	2.6	●
GWSSD0270	2.7	37.8	64.8	64	0.8	2.7	●
GWSSD0280	2.8	39.8	67.8	67	0.8	2.8	●
GWSSD0290	2.9	42.9	71.9	71	0.9	2.9	●
GWSSD0300	3.0	42.9	71.9	71	0.9	3.0	●
GWSSD0310	3.1	42.9	71.9	71	0.9	3.1	●
GWSSD0320	3.2	43.0	72.0	71	1.0	3.2	●
GWSSD0330	3.3	46.0	74.0	73	1.0	3.3	●
GWSSD0340	3.4	46.0	74.0	73	1.0	3.4	●
GWSSD0350	3.5	46.1	74.1	73	1.1	3.5	●
GWSSD0360	3.6	49.1	77.1	76	1.1	3.6	●
GWSSD0370	3.7	49.1	77.1	76	1.1	3.7	●
GWSSD0380	3.8	49.1	77.1	76	1.1	3.8	●
GWSSD0390	3.9	52.2	80.2	79	1.2	3.9	●
GWSSD0400	4.0	55.2	84.2	83	1.2	4.0	●
GWSSD0410	4.1	55.2	84.2	83	1.2	4.1	●
GWSSD0420	4.2	55.3	84.3	83	1.3	4.2	●
GWSSD0430	4.3	55.3	84.3	83	1.3	4.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSSD0440	4.4	57.3	87.3	86	1.3	4.4	●
GWSSD0450	4.5	57.4	87.4	86	1.4	4.5	●
GWSSD0460	4.6	57.4	87.4	86	1.4	4.6	●
GWSSD0470	4.7	60.4	90.4	89	1.4	4.7	●
GWSSD0480	4.8	60.4	90.4	89	1.4	4.8	●
GWSSD0490	4.9	63.5	93.5	92	1.5	4.9	●
GWSSD0500	5.0	63.5	93.5	92	1.5	5.0	●
GWSSD0510	5.1	63.5	93.5	92	1.5	5.1	●
GWSSD0520	5.2	65.6	96.6	95	1.6	5.2	●
GWSSD0530	5.3	65.6	96.6	95	1.6	5.3	●
GWSSD0540	5.4	65.6	96.6	95	1.6	5.4	●
GWSSD0550	5.5	65.7	96.7	95	1.7	5.5	●
GWSSD0560	5.6	68.7	99.7	98	1.7	5.6	●
GWSSD0570	5.7	68.7	99.7	98	1.7	5.7	●
GWSSD0580	5.8	68.7	99.7	98	1.7	5.8	●
GWSSD0590	5.9	68.8	99.8	98	1.8	5.9	●
GWSSD0600	6.0	71.8	103.8	102	1.8	6.0	●
GWSSD0610	6.1	71.8	103.8	102	1.8	6.1	●
GWSSD0620	6.2	71.9	103.9	102	1.9	6.2	●
GWSSD0630	6.3	71.9	103.9	102	1.9	6.3	●
GWSSD0640	6.4	74.9	106.9	105	1.9	6.4	●
GWSSD0650	6.5	75.0	107.0	105	2.0	6.5	●
GWSSD0660	6.6	75.0	107.0	105	2.0	6.6	●
GWSSD0670	6.7	75.0	107.0	105	2.0	6.7	●
GWSSD0680	6.8	75.0	107.0	105	2.0	6.8	●
GWSSD0690	6.9	75.1	107.1	105	2.1	6.9	●
GWSSD0700	7.0	75.1	107.1	105	2.1	7.0	●
GWSSD0710	7.1	77.1	110.1	108	2.1	7.1	●
GWSSD0720	7.2	77.2	110.2	108	2.2	7.2	●
GWSSD0730	7.3	77.2	110.2	108	2.2	7.3	●
GWSSD0740	7.4	80.2	113.2	111	2.2	7.4	●
GWSSD0750	7.5	80.3	113.3	111	2.3	7.5	●
GWSSD0760	7.6	80.3	113.3	111	2.3	7.6	●
GWSSD0770	7.7	83.3	116.3	114	2.3	7.7	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSSD0780	7.8	83.3	116.3	114	2.3	7.8	●
GWSSD0790	7.9	83.4	116.4	114	2.4	7.9	●
GWSSD0800	8.0	83.4	116.4	114	2.4	8.0	●
GWSSD0810	8.1	86.4	119.4	117	2.4	8.1	●
GWSSD0820	8.2	86.5	119.5	117	2.5	8.2	●
GWSSD0830	8.3	86.5	119.5	117	2.5	8.3	●
GWSSD0840	8.4	89.5	123.5	121	2.5	8.4	●
GWSSD0850	8.5	89.6	123.6	121	2.6	8.5	●
GWSSD0860	8.6	89.6	123.6	121	2.6	8.6	●
GWSSD0870	8.7	89.6	123.6	121	2.6	8.7	●
GWSSD0880	8.8	91.6	126.6	124	2.6	8.8	●
GWSSD0890	8.9	91.7	126.7	124	2.7	8.9	●
GWSSD0900	9.0	91.7	126.7	124	2.7	9.0	●
GWSSD0910	9.1	91.7	126.7	124	2.7	9.1	●
GWSSD0920	9.2	94.8	129.8	127	2.8	9.2	●
GWSSD0930	9.3	94.8	129.8	127	2.8	9.3	●
GWSSD0940	9.4	94.8	129.8	127	2.8	9.4	●
GWSSD0950	9.5	94.9	129.9	127	2.9	9.5	●
GWSSD0960	9.6	97.9	132.9	130	2.9	9.6	●
GWSSD0970	9.7	97.9	132.9	130	2.9	9.7	●
GWSSD0980	9.8	97.9	132.9	130	2.9	9.8	●
GWSSD0990	9.9	98.0	133.0	130	3.0	9.9	●
GWSSD1000	10.0	98.0	133.0	130	3.0	10.0	●
GWSSD1010	10.1	101.0	136.0	133	3.0	10.1	●
GWSSD1020	10.2	101.1	136.1	133	3.1	10.2	●
GWSSD1030	10.3	101.1	136.1	133	3.1	10.3	●
GWSSD1040	10.4	101.1	136.1	133	3.1	10.4	●
GWSSD1050	10.5	103.2	140.2	137	3.2	10.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSSD1060	10.6	103.2	140.2	137	3.2	10.6	●
GWSSD1070	10.7	103.2	140.2	137	3.2	10.7	●
GWSSD1080	10.8	106.2	143.2	140	3.2	10.8	●
GWSSD1090	10.9	106.3	143.3	140	3.3	10.9	●
GWSSD1100	11.0	106.3	143.3	140	3.3	11.0	●
GWSSD1110	11.1	106.3	143.3	140	3.3	11.1	●
GWSSD1120	11.2	109.4	146.4	143	3.4	11.2	●
GWSSD1130	11.3	109.4	146.4	143	3.4	11.3	●
GWSSD1140	11.4	109.4	146.4	143	3.4	11.4	●
GWSSD1150	11.5	109.5	146.5	143	3.5	11.5	●
GWSSD1160	11.6	112.5	149.5	146	3.5	11.6	●
GWSSD1170	11.7	112.5	149.5	146	3.5	11.7	●
GWSSD1180	11.8	112.5	149.5	146	3.5	11.8	●
GWSSD1190	11.9	112.6	149.6	146	3.6	11.9	●
GWSSD1200	12.0	114.6	152.6	149	3.6	12.0	●
GWSSD1210	12.1	114.6	152.6	149	3.6	12.1	●
GWSSD1220	12.2	114.7	152.7	149	3.7	12.2	●
GWSSD1230	12.3	114.7	152.7	149	3.7	12.3	●
GWSSD1240	12.4	117.7	155.7	152	3.7	12.4	●
GWSSD1250	12.5	117.8	155.8	152	3.8	12.5	●
GWSSD1260	12.6	117.8	155.8	152	3.8	12.6	●
GWSSD1270	12.7	117.8	155.8	152	3.8	12.7	●
GWSSD1280	12.8	117.8	155.8	152	3.8	12.8	●
GWSSD1290	12.9	117.9	155.9	152	3.9	12.9	●
GWSSD1300	13.0	117.9	155.9	152	3.9	13.0	●

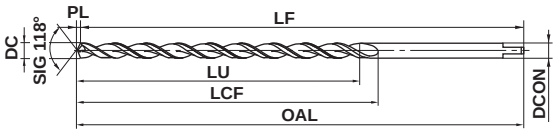
CUTTING CONDITIONS ➢ P208
TECHNICAL DATA ➢ R001

HSS

GWSL

TiN, Extra long

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

2≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

●Suitable for extra deep hole drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSLD0200A125	2.0	80.6	125.6	125	0.6	2.0	●
GWSLD0200A160	2.0	100.6	160.6	160	0.6	2.0	●
GWSLD0210A125	2.1	80.6	125.6	125	0.6	2.1	●
GWSLD0210A160	2.1	100.6	160.6	160	0.6	2.1	●
GWSLD0220A125	2.2	80.7	125.7	125	0.7	2.2	●
GWSLD0220A160	2.2	100.7	160.7	160	0.7	2.2	●
GWSLD0230A125	2.3	80.7	125.7	125	0.7	2.3	●
GWSLD0230A160	2.3	100.7	160.7	160	0.7	2.3	●
GWSLD0240A125	2.4	80.7	125.7	125	0.7	2.4	●
GWSLD0240A160	2.4	100.7	160.7	160	0.7	2.4	●
GWSLD0250A125	2.5	80.8	125.8	125	0.8	2.5	●
GWSLD0250A160	2.5	100.8	160.8	160	0.8	2.5	●
GWSLD0260A125	2.6	80.8	125.8	125	0.8	2.6	●
GWSLD0260A160	2.6	100.8	160.8	160	0.8	2.6	●
GWSLD0270A125	2.7	80.8	125.8	125	0.8	2.7	●
GWSLD0270A160	2.7	100.8	160.8	160	0.8	2.7	●
GWSLD0280A125	2.8	80.8	125.8	125	0.8	2.8	●
GWSLD0280A160	2.8	100.8	160.8	160	0.8	2.8	●
GWSLD0290A125	2.9	80.9	125.9	125	0.9	2.9	●
GWSLD0290A160	2.9	100.9	160.9	160	0.9	2.9	●
GWSLD0300A125	3.0	80.9	125.9	125	0.9	3.0	●
GWSLD0300A160	3.0	100.9	160.9	160	0.9	3.0	●
GWSLD0300A200	3.0	125.9	200.9	200	0.9	3.0	●
GWSLD0310A160	3.1	100.9	160.9	160	0.9	3.1	●
GWSLD0310A200	3.1	125.9	200.9	200	0.9	3.1	●
GWSLD0320A160	3.2	101.0	161.0	160	1.0	3.2	●
GWSLD0320A200	3.2	126.0	201.0	200	1.0	3.2	●
GWSLD0330A160	3.3	101.0	161.0	160	1.0	3.3	●
GWSLD0330A200	3.3	126.0	201.0	200	1.0	3.3	●
GWSLD0340A160	3.4	101.0	161.0	160	1.0	3.4	●
GWSLD0340A200	3.4	126.0	201.0	200	1.0	3.4	●
GWSLD0350A160	3.5	101.1	161.1	160	1.1	3.5	●
GWSLD0350A200	3.5	126.1	201.1	200	1.1	3.5	●
GWSLD0360A160	3.6	101.1	161.1	160	1.1	3.6	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSLD0360A200	3.6	126.1	201.1	200	1.1	3.6	●
GWSLD0370A160	3.7	101.1	161.1	160	1.1	3.7	●
GWSLD0370A200	3.7	126.1	201.1	200	1.1	3.7	●
GWSLD0380A160	3.8	101.1	161.1	160	1.1	3.8	●
GWSLD0380A200	3.8	126.1	201.1	200	1.1	3.8	●
GWSLD0390A160	3.9	101.2	161.2	160	1.2	3.9	●
GWSLD0390A200	3.9	126.2	201.2	200	1.2	3.9	●
GWSLD0400A160	4.0	101.2	161.2	160	1.2	4.0	●
GWSLD0400A200	4.0	126.2	201.2	200	1.2	4.0	●
GWSLD0400A250	4.0	161.2	251.2	250	1.2	4.0	●
GWSLD0410A160	4.1	101.2	161.2	160	1.2	4.1	●
GWSLD0410A200	4.1	126.2	201.2	200	1.2	4.1	●
GWSLD0410A250	4.1	161.2	251.2	250	1.2	4.1	●
GWSLD0420A160	4.2	101.3	161.3	160	1.3	4.2	●
GWSLD0420A200	4.2	126.3	201.3	200	1.3	4.2	●
GWSLD0420A250	4.2	161.3	251.3	250	1.3	4.2	●
GWSLD0430A160	4.3	101.3	161.3	160	1.3	4.3	●
GWSLD0430A200	4.3	126.3	201.3	200	1.3	4.3	●
GWSLD0430A250	4.3	161.3	251.3	250	1.3	4.3	●
GWSLD0440A160	4.4	101.3	161.3	160	1.3	4.4	●
GWSLD0440A200	4.4	126.3	201.3	200	1.3	4.4	●
GWSLD0440A250	4.4	161.3	251.3	250	1.3	4.4	●
GWSLD0450A160	4.5	101.4	161.4	160	1.4	4.5	●
GWSLD0450A200	4.5	126.4	201.4	200	1.4	4.5	●
GWSLD0450A250	4.5	161.4	251.4	250	1.4	4.5	●
GWSLD0460A160	4.6	101.4	161.4	160	1.4	4.6	●
GWSLD0460A200	4.6	126.4	201.4	200	1.4	4.6	●
GWSLD0460A250	4.6	161.4	251.4	250	1.4	4.6	●
GWSLD0470A160	4.7	101.4	161.4	160	1.4	4.7	●
GWSLD0470A200	4.7	126.4	201.4	200	1.4	4.7	●
GWSLD0470A250	4.7	161.4	251.4	250	1.4	4.7	●
GWSLD0480A160	4.8	101.4	161.4	160	1.4	4.8	●
GWSLD0480A200	4.8	126.4	201.4	200	1.4	4.8	●
GWSLD0480A250	4.8	161.4	251.4	250	1.4	4.8	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSLD0490A160	4.9	101.5	161.5	160	1.5	4.9	●
GWSLD0490A200	4.9	126.5	201.5	200	1.5	4.9	●
GWSLD0490A250	4.9	161.5	251.5	250	1.5	4.9	●
GWSLD0500A160	5.0	101.5	161.5	160	1.5	5.0	●
GWSLD0500A200	5.0	126.5	201.5	200	1.5	5.0	●
GWSLD0500A250	5.0	161.5	251.5	250	1.5	5.0	●
GWSLD0510A160	5.1	101.5	161.5	160	1.5	5.1	●
GWSLD0510A200	5.1	126.5	201.5	200	1.5	5.1	●
GWSLD0510A250	5.1	161.5	251.5	250	1.5	5.1	●
GWSLD0520A160	5.2	101.6	161.6	160	1.6	5.2	●
GWSLD0520A200	5.2	126.6	201.6	200	1.6	5.2	●
GWSLD0520A250	5.2	161.6	251.6	250	1.6	5.2	●
GWSLD0530A160	5.3	101.6	161.6	160	1.6	5.3	●
GWSLD0530A200	5.3	126.6	201.6	200	1.6	5.3	●
GWSLD0530A250	5.3	161.6	251.6	250	1.6	5.3	●
GWSLD0540A160	5.4	101.6	161.6	160	1.6	5.4	●
GWSLD0540A200	5.4	126.6	201.6	200	1.6	5.4	●
GWSLD0540A250	5.4	161.6	251.6	250	1.6	5.4	●
GWSLD0550A160	5.5	101.7	161.7	160	1.7	5.5	●
GWSLD0550A200	5.5	126.7	201.7	200	1.7	5.5	●
GWSLD0550A250	5.5	161.7	251.7	250	1.7	5.5	●
GWSLD0560A160	5.6	101.7	161.7	160	1.7	5.6	●
GWSLD0560A200	5.6	126.7	201.7	200	1.7	5.6	●
GWSLD0560A250	5.6	161.7	251.7	250	1.7	5.6	●
GWSLD0570A160	5.7	101.7	161.7	160	1.7	5.7	●
GWSLD0570A200	5.7	126.7	201.7	200	1.7	5.7	●
GWSLD0570A250	5.7	161.7	251.7	250	1.7	5.7	●
GWSLD0580A160	5.8	101.7	161.7	160	1.7	5.8	●
GWSLD0580A200	5.8	126.7	201.7	200	1.7	5.8	●
GWSLD0580A250	5.8	161.7	251.7	250	1.7	5.8	●
GWSLD0590A160	5.9	101.8	161.8	160	1.8	5.9	●
GWSLD0590A200	5.9	126.8	201.8	200	1.8	5.9	●
GWSLD0590A250	5.9	161.8	251.8	250	1.8	5.9	●
GWSLD0600A160	6.0	101.8	161.8	160	1.8	6.0	●
GWSLD0600A200	6.0	126.8	201.8	200	1.8	6.0	●
GWSLD0600A250	6.0	161.8	251.8	250	1.8	6.0	●
GWSLD0600A315	6.0	201.8	316.8	315	1.8	6.0	●
GWSLD0650A160	6.5	102.0	162.0	160	2.0	6.5	●
GWSLD0650A200	6.5	127.0	202.0	200	2.0	6.5	●
GWSLD0650A250	6.5	162.0	252.0	250	2.0	6.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
GWSLD0650A315	6.5	202.0	317.0	315	2.0	6.5	●
GWSLD0680A160	6.8	102.0	162.0	160	2.0	6.8	●
GWSLD0680A200	6.8	127.0	202.0	200	2.0	6.8	●
GWSLD0680A250	6.8	162.0	252.0	250	2.0	6.8	●
GWSLD0680A315	6.8	202.0	317.0	315	2.0	6.8	●
GWSLD0700A160	7.0	102.1	162.1	160	2.1	7.0	●
GWSLD0700A200	7.0	127.1	202.1	200	2.1	7.0	●
GWSLD0700A250	7.0	162.1	252.1	250	2.1	7.0	●
GWSLD0700A315	7.0	202.1	317.1	315	2.1	7.0	●
GWSLD0750A200	7.5	127.3	202.3	200	2.3	7.5	●
GWSLD0750A250	7.5	162.3	252.3	250	2.3	7.5	●
GWSLD0750A315	7.5	202.3	317.3	315	2.3	7.5	●
GWSLD0800A200	8.0	127.4	202.4	200	2.4	8.0	●
GWSLD0800A250	8.0	162.4	252.4	250	2.4	8.0	●
GWSLD0800A315	8.0	202.4	317.4	315	2.4	8.0	●
GWSLD0850A200	8.5	142.6	202.6	200	2.6	8.5	●
GWSLD0850A250	8.5	162.6	252.6	250	2.6	8.5	●
GWSLD0850A315	8.5	202.6	317.6	315	2.6	8.5	●
GWSLD0900A200	9.0	142.7	202.7	200	2.7	9.0	●
GWSLD0900A250	9.0	162.7	252.7	250	2.7	9.0	●
GWSLD0900A315	9.0	202.7	317.7	315	2.7	9.0	●
GWSLD0950A200	9.5	142.9	202.9	200	2.9	9.5	●
GWSLD0950A250	9.5	162.9	252.9	250	2.9	9.5	●
GWSLD0950A315	9.5	202.9	317.9	315	2.9	9.5	●
GWSLD1000A200	10.0	143.0	203.0	200	3.0	10.0	●
GWSLD1000A250	10.0	163.0	253.0	250	3.0	10.0	●
GWSLD1000A315	10.0	203.0	318.0	315	3.0	10.0	●
GWSLD1050A250	10.5	163.2	253.2	250	3.2	10.5	●
GWSLD1050A315	10.5	203.2	318.2	315	3.2	10.5	●
GWSLD1100A250	11.0	163.3	253.3	250	3.3	11.0	●
GWSLD1100A315	11.0	203.3	318.3	315	3.3	11.0	●
GWSLD1150A250	11.5	163.5	253.5	250	3.5	11.5	●
GWSLD1150A315	11.5	203.5	318.5	315	3.5	11.5	●
GWSLD1200A250	12.0	163.6	253.6	250	3.6	12.0	●
GWSLD1200A315	12.0	203.6	318.6	315	3.6	12.0	●
GWSLD1250A250	12.5	163.8	253.8	250	3.8	12.5	●
GWSLD1250A315	12.5	203.8	318.8	315	3.8	12.5	●
GWSLD1300A250	13.0	163.9	253.9	250	3.9	13.0	●
GWSLD1300A315	13.0	203.9	318.9	315	3.9	13.0	●

CUTTING CONDITIONS ➢ P188
TECHNICAL DATA ➢ R001

GWSL

TiN, Extra long

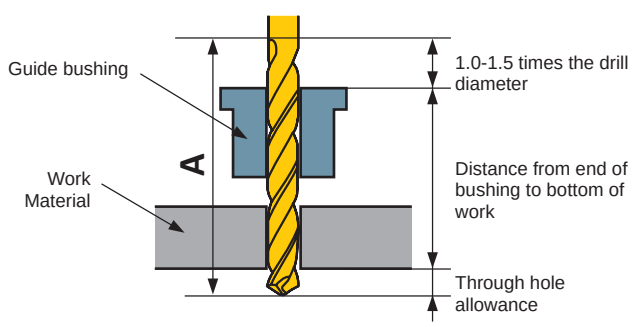
RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel SS Carbon Steel S-C (−25HRC)		Alloy Steel SCM Tool Steel SK (−35HRC)		Alloy Steel SCM Die Steel SKD (−40HRC)		Cast Iron FC	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
2.0	4700	0.05	3600	0.03	2400	0.02	4700	0.05
3.0	3200	0.10	2400	0.08	1800	0.05	3500	0.10
6.0	1600	0.18	1200	0.15	900	0.13	1750	0.18
8.0	1200	0.20	900	0.18	680	0.15	1300	0.20
10.0	960	0.22	720	0.20	550	0.18	1100	0.22
12.0	800	0.24	600	0.22	450	0.20	880	0.24
13.0	730	0.26	550	0.23	400	0.21	800	0.26

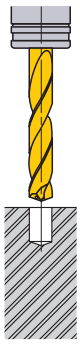
Work Material	Stainless steel				Copper Alloy, Brass		Aluminium Alloy	
	Martensitic Ferritic AISI 430		Austenitic AISI 304 Precipitation Hardening ASTM 630					
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
2.0	2500	0.05	2300	0.04	4700	0.05	6000	0.08
3.0	1900	0.10	1500	0.07	3200	0.10	5500	0.13
6.0	950	0.18	750	0.10	1600	0.18	3100	0.23
8.0	700	0.20	530	0.13	1200	0.20	2300	0.28
10.0	560	0.22	420	0.15	960	0.22	1900	0.33
12.0	460	0.24	340	0.17	800	0.24	1600	0.38
13.0	420	0.25	300	0.18	730	0.25	1450	0.40

Note 1) Please reduce the cutting conditions when drilling a deep hole.
Note 2) This table only shows standard cutting conditions with water-soluble cutting fluids. Please make corrections or adjustments depending on the application.
Note 3) High-speed drills have lower rigidity than long carbide drills, and to prevent problems due to drill deflection and bending, please use guide bushes and guide holes (about 1 to 2 DC).
Note 4) When using guide bushes, please select a drill so that the groove length > A dimension (shown below).

Guide Bushing



Drilling a Pilot Hole



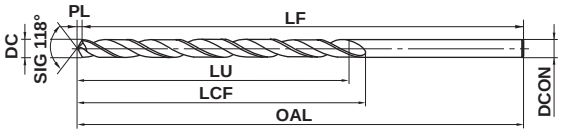
①Use a drill with a larger (flatter) point angle than the super long type. VAPDS is recommended.

②Ensure a high precision hole is drilled for the guide.

③Drill depth : Approx DC×1—2.

LSD
Extra long

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

1≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

●Widely used for deep hole drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
LSDD0100A100	1.0	25.3	100.3	100	0.3	1.0	●
LSDD0100A150	1.0	25.3	150.3	150	0.3	1.0	●
LSDD0110A100	1.1	25.3	100.3	100	0.3	1.1	●
LSDD0110A150	1.1	25.3	150.3	150	0.3	1.1	●
LSDD0120A100	1.2	25.4	100.4	100	0.4	1.2	●
LSDD0120A150	1.2	25.4	150.4	150	0.4	1.2	●
LSDD0130A100	1.3	30.4	100.4	100	0.4	1.3	●
LSDD0130A150	1.3	30.4	150.4	150	0.4	1.3	●
LSDD0140A100	1.4	30.4	100.4	100	0.4	1.4	●
LSDD0140A150	1.4	30.4	150.4	150	0.4	1.4	●
LSDD0150A100	1.5	30.5	100.5	100	0.5	1.5	●
LSDD0150A150	1.5	30.5	150.5	150	0.5	1.5	●
LSDD0160A100	1.6	40.5	100.5	100	0.5	1.6	●
LSDD0160A150	1.6	40.5	150.5	150	0.5	1.6	●
LSDD0170A100	1.7	40.5	100.5	100	0.5	1.7	●
LSDD0170A150	1.7	40.5	150.5	150	0.5	1.7	●
LSDD0180A100	1.8	40.5	100.5	100	0.5	1.8	●
LSDD0180A150	1.8	40.5	150.5	150	0.5	1.8	●
LSDD0190A100	1.9	40.6	100.6	100	0.6	1.9	●
LSDD0190A150	1.9	40.6	150.6	150	0.6	1.9	●
LSDD0200A100	2.0	50.6	100.6	100	0.6	2.0	●
LSDD0200A125	2.0	65.6	125.6	125	0.6	2.0	●
LSDD0200A150	2.0	75.6	150.6	150	0.6	2.0	●
LSDD0210A100	2.1	50.6	100.6	100	0.6	2.1	●
LSDD0210A150	2.1	75.6	150.6	150	0.6	2.1	●
LSDD0220A100	2.2	50.7	100.7	100	0.7	2.2	●
LSDD0220A150	2.2	75.7	150.7	150	0.7	2.2	●
LSDD0230A100	2.3	50.7	100.7	100	0.7	2.3	●
LSDD0230A150	2.3	75.7	150.7	150	0.7	2.3	●
LSDD0240A100	2.4	50.7	100.7	100	0.7	2.4	●
LSDD0240A150	2.4	75.7	150.7	150	0.7	2.4	●
LSDD0250A100	2.5	50.8	100.8	100	0.8	2.5	●
LSDD0250A125	2.5	65.8	125.8	125	0.8	2.5	●
LSDD0250A150	2.5	75.8	150.8	150	0.8	2.5	●
LSDD0260A100	2.6	50.8	100.8	100	0.8	2.6	●
LSDD0260A150	2.6	75.8	150.8	150	0.8	2.6	●
LSDD0270A100	2.7	50.8	100.8	100	0.8	2.7	●
LSDD0270A150	2.7	75.8	150.8	150	0.8	2.7	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
LSDD0280A100	2.8	50.8	100.8	100	0.8	2.8	●
LSDD0280A150	2.8	75.8	150.8	150	0.8	2.8	●
LSDD0290A100	2.9	50.9	100.9	100	0.9	2.9	●
LSDD0290A150	2.9	75.9	150.9	150	0.9	2.9	●
LSDD0300A100	3.0	50.9	100.9	100	0.9	3.0	●
LSDD0300A125	3.0	65.9	125.9	125	0.9	3.0	●
LSDD0300A150	3.0	75.9	150.9	150	0.9	3.0	●
LSDD0300A200	3.0	100.9	200.9	200	0.9	3.0	●
LSDD0310A150	3.1	75.9	150.9	150	0.9	3.1	●
LSDD0310A200	3.1	100.9	200.9	200	0.9	3.1	●
LSDD0320A125	3.2	66.0	126.0	125	1.0	3.2	●
LSDD0320A150	3.2	76.0	151.0	150	1.0	3.2	●
LSDD0320A200	3.2	101.0	201.0	200	1.0	3.2	●
LSDD0320A250	3.2	131.0	251.0	250	1.0	3.2	●
LSDD0330A150	3.3	76.0	151.0	150	1.0	3.3	●
LSDD0330A200	3.3	101.0	201.0	200	1.0	3.3	●
LSDD0340A150	3.4	76.0	151.0	150	1.0	3.4	●
LSDD0340A200	3.4	101.0	201.0	200	1.0	3.4	●
LSDD0350A125	3.5	66.1	126.1	125	1.1	3.5	●
LSDD0350A150	3.5	76.1	151.1	150	1.1	3.5	●
LSDD0350A200	3.5	101.1	201.1	200	1.1	3.5	●
LSDD0350A250	3.5	131.1	251.1	250	1.1	3.5	●
LSDD0360A150	3.6	76.1	151.1	150	1.1	3.6	●
LSDD0360A200	3.6	101.1	201.1	200	1.1	3.6	●
LSDD0370A150	3.7	76.1	151.1	150	1.1	3.7	●
LSDD0370A200	3.7	101.1	201.1	200	1.1	3.7	●
LSDD0380A150	3.8	76.1	151.1	150	1.1	3.8	●
LSDD0380A200	3.8	101.1	201.1	200	1.1	3.8	●
LSDD0390A150	3.9	76.2	151.2	150	1.2	3.9	●
LSDD0390A200	3.9	101.2	201.2	200	1.2	3.9	●
LSDD0400A125	4.0	71.2	126.2	125	1.2	4.0	●
LSDD0400A150	4.0	76.2	151.2	150	1.2	4.0	●
LSDD0400A200	4.0	101.2	201.2	200	1.2	4.0	●
LSDD0400A250	4.0	131.2	251.2	250	1.2	4.0	●
LSDD0410A150	4.1	76.2	151.2	150	1.2	4.1	●
LSDD0410A200	4.1	101.2	201.2	200	1.2	4.1	●
LSDD0420A150	4.2	76.3	151.3	150	1.3	4.2	●
LSDD0420A200	4.2	101.3	201.3	200	1.3	4.2	●

● : Inventory maintained in Japan.

CUTTING CONDITIONS ➤ P191
TECHNICAL DATA ➤ R001

LSD

Extra long

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
LSDD0430A150	4.3	76.3	151.3	150	1.3	4.3	●
LSDD0430A200	4.3	101.3	201.3	200	1.3	4.3	●
LSDD0440A150	4.4	76.3	151.3	150	1.3	4.4	●
LSDD0440A200	4.4	101.3	201.3	200	1.3	4.4	●
LSDD0450A125	4.5	71.4	126.4	125	1.4	4.5	●
LSDD0450A150	4.5	76.4	151.4	150	1.4	4.5	●
LSDD0450A200	4.5	101.4	201.4	200	1.4	4.5	●
LSDD0450A250	4.5	131.4	251.4	250	1.4	4.5	●
LSDD0460A150	4.6	91.4	151.4	150	1.4	4.6	●
LSDD0460A200	4.6	101.4	201.4	200	1.4	4.6	●
LSDD0470A150	4.7	91.4	151.4	150	1.4	4.7	●
LSDD0470A200	4.7	101.4	201.4	200	1.4	4.7	●
LSDD0480A150	4.8	91.4	151.4	150	1.4	4.8	●
LSDD0480A200	4.8	101.4	201.4	200	1.4	4.8	●
LSDD0490A150	4.9	91.5	151.5	150	1.5	4.9	●
LSDD0490A200	4.9	101.5	201.5	200	1.5	4.9	●
LSDD0500A150	5.0	91.5	151.5	150	1.5	5.0	●
LSDD0500A200	5.0	101.5	201.5	200	1.5	5.0	●
LSDD0500A250	5.0	131.5	251.5	250	1.5	5.0	●
LSDD0500A300	5.0	151.5	301.5	300	1.5	5.0	●
LSDD0510A200	5.1	101.5	201.5	200	1.5	5.1	●
LSDD0510A250	5.1	131.5	251.5	250	1.5	5.1	●
LSDD0520A200	5.2	101.6	201.6	200	1.6	5.2	●
LSDD0520A250	5.2	131.6	251.6	250	1.6	5.2	●
LSDD0530A200	5.3	101.6	201.6	200	1.6	5.3	●
LSDD0530A250	5.3	131.6	251.6	250	1.6	5.3	●
LSDD0540A200	5.4	101.6	201.6	200	1.6	5.4	●
LSDD0540A250	5.4	131.6	251.6	250	1.6	5.4	●
LSDD0550A150	5.5	91.7	151.7	150	1.7	5.5	●
LSDD0550A200	5.5	101.7	201.7	200	1.7	5.5	●
LSDD0550A250	5.5	131.7	251.7	250	1.7	5.5	●
LSDD0550A300	5.5	151.7	301.7	300	1.7	5.5	●
LSDD0560A200	5.6	101.7	201.7	200	1.7	5.6	●
LSDD0560A250	5.6	131.7	251.7	250	1.7	5.6	●
LSDD0570A200	5.7	101.7	201.7	200	1.7	5.7	●
LSDD0570A250	5.7	131.7	251.7	250	1.7	5.7	●
LSDD0580A200	5.8	101.7	201.7	200	1.7	5.8	●
LSDD0580A250	5.8	131.7	251.7	250	1.7	5.8	●
LSDD0590A200	5.9	101.8	201.8	200	1.8	5.9	●
LSDD0590A250	5.9	131.8	251.8	250	1.8	5.9	●
LSDD0600A150	6.0	91.8	151.8	150	1.8	6.0	●
LSDD0600A200	6.0	101.8	201.8	200	1.8	6.0	●
LSDD0600A250	6.0	131.8	251.8	250	1.8	6.0	●
LSDD0600A300	6.0	151.8	301.8	300	1.8	6.0	●
LSDD0640A200	6.4	121.9	201.9	200	1.9	6.4	●
LSDD0650A150	6.5	92.0	152.0	150	2.0	6.5	●
LSDD0650A200	6.5	122.0	202.0	200	2.0	6.5	●
LSDD0650A250	6.5	132.0	252.0	250	2.0	6.5	●
LSDD0650A300	6.5	152.0	302.0	300	2.0	6.5	●
LSDD0700A150	7.0	92.1	152.1	150	2.1	7.0	●
LSDD0700A200	7.0	122.1	202.1	200	2.1	7.0	●
LSDD0700A250	7.0	132.1	252.1	250	2.1	7.0	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
LSDD0700A300	7.0	152.1	302.1	300	2.1	7.0	●
LSDD0750A150	7.5	92.3	152.3	150	2.3	7.5	●
LSDD0750A200	7.5	122.3	202.3	200	2.3	7.5	●
LSDD0750A250	7.5	132.3	252.3	250	2.3	7.5	●
LSDD0750A300	7.5	152.3	302.3	300	2.3	7.5	●
LSDD0800A150	8.0	92.4	152.4	150	2.4	8.0	●
LSDD0800A200	8.0	122.4	202.4	200	2.4	8.0	●
LSDD0800A250	8.0	132.4	252.4	250	2.4	8.0	●
LSDD0800A300	8.0	152.4	302.4	300	2.4	8.0	●
LSDD0850A200	8.5	122.6	202.6	200	2.6	8.5	●
LSDD0850A250	8.5	132.6	252.6	250	2.6	8.5	●
LSDD0850A300	8.5	182.6	302.6	300	2.6	8.5	●
LSDD0850A350	8.5	202.6	352.6	350	2.6	8.5	●
LSDD0900A200	9.0	122.7	202.7	200	2.7	9.0	●
LSDD0900A250	9.0	132.7	252.7	250	2.7	9.0	●
LSDD0900A300	9.0	182.7	302.7	300	2.7	9.0	●
LSDD0900A350	9.0	202.7	352.7	350	2.7	9.0	●
LSDD0950A200	9.5	122.9	202.9	200	2.9	9.5	●
LSDD0950A250	9.5	132.9	252.9	250	2.9	9.5	●
LSDD0950A300	9.5	182.9	302.9	300	2.9	9.5	●
LSDD0950A350	9.5	202.9	352.9	350	2.9	9.5	●
LSDD1000A200	10.0	123.0	203.0	200	3.0	10.0	●
LSDD1000A250	10.0	133.0	253.0	250	3.0	10.0	●
LSDD1000A300	10.0	183.0	303.0	300	3.0	10.0	●
LSDD1000A350	10.0	203.0	353.0	350	3.0	10.0	●
LSDD1050A200	10.5	123.2	203.2	200	3.2	10.5	●
LSDD1050A250	10.5	133.2	253.2	250	3.2	10.5	●
LSDD1050A300	10.5	183.2	303.2	300	3.2	10.5	●
LSDD1050A350	10.5	203.2	353.2	350	3.2	10.5	●
LSDD1100A200	11.0	123.3	203.3	200	3.3	11.0	●
LSDD1100A250	11.0	133.3	253.3	250	3.3	11.0	●
LSDD1100A300	11.0	183.3	303.3	300	3.3	11.0	●
LSDD1100A350	11.0	203.3	353.3	350	3.3	11.0	●
LSDD1150A200	11.5	123.5	203.5	200	3.5	11.5	●
LSDD1150A250	11.5	133.5	253.5	250	3.5	11.5	●
LSDD1150A300	11.5	183.5	303.5	300	3.5	11.5	●
LSDD1150A350	11.5	203.5	353.5	350	3.5	11.5	●
LSDD1200A200	12.0	123.6	203.6	200	3.6	12.0	●
LSDD1200A250	12.0	133.6	253.6	250	3.6	12.0	●
LSDD1200A300	12.0	183.6	303.6	300	3.6	12.0	●
LSDD1200A350	12.0	203.6	353.6	350	3.6	12.0	●
LSDD1250A200	12.5	123.8	203.8	200	3.8	12.5	●
LSDD1250A250	12.5	133.8	253.8	250	3.8	12.5	●
LSDD1250A300	12.5	183.8	303.8	300	3.8	12.5	●
LSDD1250A350	12.5	203.8	353.8	350	3.8	12.5	●
LSDD1300A200	13.0	123.9	203.9	200	3.9	13.0	●
LSDD1300A250	13.0	133.9	253.9	250	3.9	13.0	●
LSDD1300A300	13.0	183.9	303.9	300	3.9	13.0	●
LSDD1300A350	13.0	203.9	353.9	350	3.9	13.0	●

● : Inventory maintained in Japan.

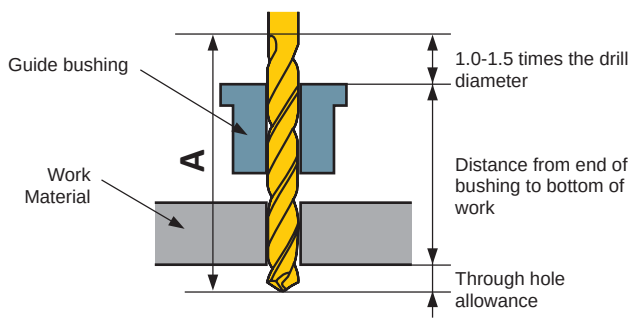
RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel SS Carbon Steel S-C (−25HRC)		Alloy Steel SCM Tool Steel SK (−35HRC)		Alloy Steel SCM Die Steel SKD (−40HRC)		Cast Iron FC	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
1.0	5000	0.02	4000	0.01	2800	0.008	5000	0.02
2.0	3000	0.05	2500	0.03	1800	0.02	3000	0.05
3.0	2100	0.10	1800	0.08	1200	0.05	2300	0.10
6.0	1100	0.18	900	0.15	600	0.13	1100	0.18
8.0	800	0.20	670	0.18	450	0.15	900	0.20
10.0	650	0.22	540	0.20	350	0.18	700	0.22
12.0	520	0.24	450	0.22	300	0.20	600	0.24
13.0	480	0.26	410	0.23	280	0.21	540	0.26

Work Material	Stainless Steel				Copper Alloy, Brass		Aluminium Alloy	
	Martensitic Ferritic AISI 430		Austenitic AISI 304 Precipitation Hardening ASTM 630					
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
1.0	4000	0.02	3000	0.02	5000	0.02	7000	0.04
2.0	2200	0.05	1500	0.04	3000	0.05	5000	0.08
3.0	1600	0.10	1000	0.07	2100	0.10	4200	0.13
6.0	800	0.18	530	0.10	1100	0.18	2100	0.23
8.0	600	0.20	400	0.13	800	0.20	1600	0.28
10.0	480	0.22	310	0.15	650	0.22	1200	0.33
12.0	400	0.24	250	0.17	520	0.24	1000	0.38
13.0	370	0.25	200	0.18	480	0.25	970	0.40

Note 1) Please reduce the cutting conditions when drilling a deep hole.
Note 2) This table only shows standard cutting conditions with water-soluble cutting fluids. Please make corrections or adjustments depending on the application.
Note 3) High-speed drills have lower rigidity than long carbide drills, and to prevent problems due to drill deflection and bending, please use guide bushes and guide holes (about 1 to 2 DC).
Note 4) When using guide bushes, please select a drill so that the groove length > A dimension (shown below).

Guide bushing



Drilling a pilot hole

①Use a drill with a larger (flatter) point angle than the super long type. VAPDS is recommended.

②Ensure a high precision hole is drilled for the guide.

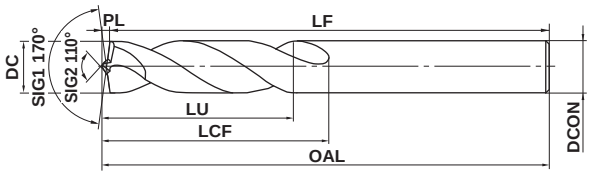
③Drill depth : Approx DC×1—2.

HSS

EPSS

Plate pal

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU : Max 1×DC

2≤DC≤3	3<DC≤6	6<DC≤10	10<DC≤13
0 −0.014	0 −0.018	0 −0.022	0 −0.027

●Special cutting edge geometry to prevent through hole burrs.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
EPSSD0200	2.0	17	48.3	48	0.3	2.0	●
EPSSD0210	2.1	17	48.3	48	0.3	2.1	●
EPSSD0220	2.2	17	48.3	48	0.3	2.2	●
EPSSD0230	2.3	17	48.3	48	0.3	2.3	●
EPSSD0240	2.4	17	48.3	48	0.3	2.4	●
EPSSD0250	2.5	17	48.4	48	0.4	2.5	●
EPSSD0260	2.6	17	48.4	48	0.4	2.6	●
EPSSD0270	2.7	17	48.4	48	0.4	2.7	●
EPSSD0280	2.8	17	48.4	48	0.4	2.8	●
EPSSD0290	2.9	17	48.4	48	0.4	2.9	●
EPSSD0300	3.0	17	48.5	48	0.5	3.0	●
EPSSD0310	3.1	17	48.5	48	0.5	3.1	●
EPSSD0320	3.2	17	48.5	48	0.5	3.2	●
EPSSD0330	3.3	17	48.5	48	0.5	3.3	●
EPSSD0340	3.4	19	51.5	51	0.5	3.4	●
EPSSD0350	3.5	19	51.6	51	0.6	3.5	●
EPSSD0360	3.6	19	51.6	51	0.6	3.6	●
EPSSD0370	3.7	19	51.6	51	0.6	3.7	●
EPSSD0380	3.8	21	54.6	54	0.6	3.8	●
EPSSD0390	3.9	21	54.6	54	0.6	3.9	●
EPSSD0400	4.0	21	54.6	54	0.6	4.0	●
EPSSD0410	4.1	21	54.6	54	0.6	4.1	●
EPSSD0420	4.2	21	54.6	54	0.6	4.2	●
EPSSD0430	4.3	23	57.6	57	0.6	4.3	●
EPSSD0440	4.4	23	57.6	57	0.6	4.4	●
EPSSD0450	4.5	23	57.7	57	0.7	4.5	●
EPSSD0460	4.6	23	57.7	57	0.7	4.6	●
EPSSD0470	4.7	23	57.7	57	0.7	4.7	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
EPSSD0480	4.8	24	60.7	60	0.7	4.8	●
EPSSD0490	4.9	24	60.7	60	0.7	4.9	●
EPSSD0500	5.0	24	60.8	60	0.8	5.0	●
EPSSD0510	5.1	24	60.8	60	0.8	5.1	●
EPSSD0520	5.2	24	60.8	60	0.8	5.2	●
EPSSD0530	5.3	24	60.8	60	0.8	5.3	●
EPSSD0540	5.4	26	64.8	64	0.8	5.4	●
EPSSD0550	5.5	26	64.9	64	0.9	5.5	●
EPSSD0600	6.0	26	65.0	64	1.0	6.0	●
EPSSD0650	6.5	29	69.0	68	1.0	6.5	●
EPSSD0680	6.8	32	73.1	72	1.1	6.8	●
EPSSD0700	7.0	32	73.1	72	1.1	7.0	●
EPSSD0750	7.5	32	73.2	72	1.2	7.5	●
EPSSD0800	8.0	34	77.3	76	1.3	8.0	●
EPSSD0820	8.2	34	77.3	76	1.3	8.2	●
EPSSD0850	8.5	34	77.4	76	1.4	8.5	●
EPSSD0900	9.0	37	82.5	81	1.5	9.0	●
EPSSD0950	9.5	37	82.6	81	1.6	9.5	●
EPSSD1000	10.0	40	87.6	86	1.6	10.0	●
EPSSD1020	10.2	40	87.6	86	1.6	10.2	●
EPSSD1030	10.3	40	87.6	86	1.6	10.3	●
EPSSD1050	10.5	40	87.7	86	1.7	10.5	●
EPSSD1100	11.0	43	92.8	91	1.8	11.0	●
EPSSD1150	11.5	43	92.9	91	1.9	11.5	●
EPSSD1200	12.0	47	100.0	98	2.0	12.0	●
EPSSD1250	12.5	47	100.0	98	2.0	12.5	●
EPSSD1300	13.0	47	100.2	98	2.2	13.0	●

P

DRILLING

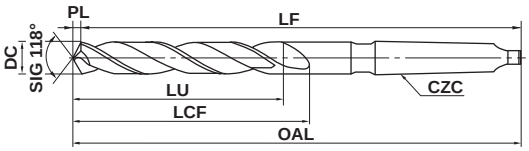
● : Inventory maintained in Japan.

TECHNICAL DATA ➢ R001

GTD

TiN

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

DC=6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤40
0 / −0.018	0 / −0.022	0 / −0.027	0 / −0.033	0 / −0.039

● Original manufacturing and coating technology for improved performance.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GTDD0600M1	6.0	56.8	149.8	148	1.8	MT.1	●
GTDD0650M1	6.5	63.0	154.0	152	2.0	MT.1	●
GTDD0660M1	6.6	63.0	157.0	155	2.0	MT.1	●
GTDD0680M1	6.8	69.0	157.0	155	2.0	MT.1	●
GTDD0700M1	7.0	69.1	157.1	155	2.1	MT.1	●
GTDD0720M1	7.2	69.2	160.2	158	2.2	MT.1	●
GTDD0750M1	7.5	69.3	160.3	158	2.3	MT.1	●
GTDD0770M1	7.7	74.3	164.3	162	2.3	MT.1	●
GTDD0780M1	7.8	74.3	164.3	162	2.3	MT.1	●
GTDD0800M1	8.0	74.4	164.4	162	2.4	MT.1	●
GTDD0820M1	8.2	74.5	170.5	168	2.5	MT.1	●
GTDD0850M1	8.5	74.6	170.6	168	2.6	MT.1	●
GTDD0880M1	8.8	80.6	174.6	172	2.6	MT.1	●
GTDD0900M1	9.0	80.7	174.7	172	2.7	MT.1	●
GTDD0950M1	9.5	80.9	177.9	175	2.9	MT.1	●
GTDD0970M1	9.7	86.9	180.9	178	2.9	MT.1	●
GTDD0980M1	9.8	86.9	180.9	178	2.9	MT.1	●
GTDD1000M1	10.0	87.0	181.0	178	3.0	MT.1	●
GTDD1030M1	10.3	87.1	185.1	182	3.1	MT.1	●
GTDD1050M1	10.5	87.2	185.2	182	3.2	MT.1	●
GTDD1080M1	10.8	93.2	188.2	185	3.2	MT.1	●
GTDD1100M1	11.0	93.3	188.3	185	3.3	MT.1	●
GTDD1150M1	11.5	93.5	191.5	188	3.5	MT.1	●
GTDD1200M1	12.0	100.6	195.6	192	3.6	MT.1	●
GTDD1250M1	12.5	100.8	198.8	195	3.8	MT.1	●
GTDD1300M1	13.0	100.9	201.9	198	3.9	MT.1	●
GTDD1350M1	13.5	107.1	206.1	202	4.1	MT.1	●
GTDD1400M1	14.0	107.2	209.2	205	4.2	MT.1	●
GTDD1450M2	14.5	113.4	226.4	222	4.4	MT.2	●
GTDD1500M2	15.0	113.5	229.5	225	4.5	MT.2	●
GTDD1550M2	15.5	119.7	232.7	228	4.7	MT.2	●
GTDD1600M2	16.0	119.8	234.8	230	4.8	MT.2	●
GTDD1650M2	16.5	124.0	237.0	232	5.0	MT.2	●
GTDD1700M2	17.0	124.1	240.1	235	5.1	MT.2	●
GTDD1750M2	17.5	129.3	245.3	240	5.3	MT.2	●
GTDD1800M2	18.0	129.4	245.4	240	5.4	MT.2	●
GTDD1850M2	18.5	134.6	250.6	245	5.6	MT.2	●
GTDD1900M2	19.0	134.7	250.7	245	5.7	MT.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GTDD1950M2	19.5	138.9	255.9	250	5.9	MT.2	●
GTDD2000M2	20.0	139.0	256.0	250	6.0	MT.2	●
GTDD2050M2	20.5	144.2	261.2	255	6.2	MT.2	●
GTDD2100M2	21.0	144.3	261.3	255	6.3	MT.2	●
GTDD2150M2	21.5	149.5	266.5	260	6.5	MT.2	●
GTDD2150M3	21.5	149.5	286.5	280	6.5	MT.3	●
GTDD2200M2	22.0	149.6	266.6	260	6.6	MT.2	●
GTDD2200M3	22.0	149.6	286.6	280	6.6	MT.3	●
GTDD2250M2	22.5	153.8	271.8	265	6.8	MT.2	●
GTDD2250M3	22.5	153.8	291.8	285	6.8	MT.3	●
GTDD2300M2	23.0	153.9	271.9	265	6.9	MT.2	●
GTDD2300M3	23.0	153.9	291.9	285	6.9	MT.3	●
GTDD2350M3	23.5	154.1	292.1	285	7.1	MT.3	●
GTDD2400M3	24.0	159.2	292.2	285	7.2	MT.3	●
GTDD2450M3	24.5	159.4	292.4	285	7.4	MT.3	●
GTDD2500M3	25.0	159.5	292.5	285	7.5	MT.3	●
GTDD2550M3	25.5	163.7	292.7	285	7.7	MT.3	●
GTDD2600M3	26.0	163.8	292.8	285	7.8	MT.3	●
GTDD2650M3	26.5	164.0	298.0	290	8.0	MT.3	●
GTDD2700M3	27.0	169.1	298.1	290	8.1	MT.3	●
GTDD2750M3	27.5	169.3	303.3	295	8.3	MT.3	●
GTDD2800M3	28.0	169.4	303.4	295	8.4	MT.3	●
GTDD2850M3	28.5	173.6	308.6	300	8.6	MT.3	●
GTDD2900M3	29.0	173.7	308.7	300	8.7	MT.3	●
GTDD2950M3	29.5	173.9	313.9	305	8.9	MT.3	●
GTDD3000M3	30.0	174.0	314.0	305	9.0	MT.3	●
GTDD3050M3	30.5	179.2	319.2	310	9.2	MT.3	●
GTDD3100M3	31.0	179.3	319.3	310	9.3	MT.3	●
GTDD3150M3	31.5	179.5	324.5	315	9.5	MT.3	●
GTDD3200M3	32.0	183.6	324.6	315	9.6	MT.3	●
GTDD3300M4	33.0	183.9	354.9	345	9.9	MT.4	●
GTDD3400M4	34.0	189.2	360.2	350	10.2	MT.4	●
GTDD3500M4	35.0	189.5	360.5	350	10.5	MT.4	●
GTDD3600M4	36.0	193.8	365.8	355	10.8	MT.4	●
GTDD3700M4	37.0	194.1	366.1	355	11.1	MT.4	●
GTDD3800M4	38.0	198.4	371.4	360	11.4	MT.4	●
GTDD3900M4	39.0	198.7	371.7	360	11.7	MT.4	●
GTDD4000M4	40.0	199.0	377.0	365	12.0	MT.4	●

CUTTING CONDITIONS ➤ P208
TECHNICAL DATA ➤ R001

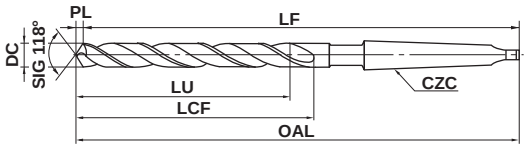
HSS

TD

Taper shank

HSS 118° DC>40

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

DC=3	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤50	50<DC≤75
0 −0.014	0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039	0 −0.046

●For general drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD0300M1	3.0	38.9	115.9	115	0.9	MT.1	●
TDD0310M1	3.1	45.9	122.9	122	0.9	MT.1	●
TDD0320M1	3.2	46.0	123.0	122	1.0	MT.1	●
TDD0330M1	3.3	46.0	123.0	122	1.0	MT.1	●
TDD0340M1	3.4	46.0	123.0	122	1.0	MT.1	●
TDD0350M1	3.5	46.1	123.1	122	1.1	MT.1	●
TDD0360M1	3.6	51.1	129.1	128	1.1	MT.1	●
TDD0370M1	3.7	51.1	129.1	128	1.1	MT.1	●
TDD0380M1	3.8	51.1	129.1	128	1.1	MT.1	●
TDD0390M1	3.9	51.2	129.2	128	1.2	MT.1	●
TDD0400M1	4.0	51.2	129.2	128	1.2	MT.1	●
TDD0410M1	4.1	56.2	136.2	135	1.2	MT.1	●
TDD0420M1	4.2	56.3	136.3	135	1.3	MT.1	●
TDD0430M1	4.3	56.3	136.3	135	1.3	MT.1	●
TDD0440M1	4.4	56.3	136.3	135	1.3	MT.1	●
TDD0450M1	4.5	56.4	136.4	135	1.4	MT.1	●
TDD0460M1	4.6	61.4	141.4	140	1.4	MT.1	●
TDD0470M1	4.7	61.4	141.4	140	1.4	MT.1	●
TDD0480M1	4.8	61.4	141.4	140	1.4	MT.1	●
TDD0490M1	4.9	61.5	141.5	140	1.5	MT.1	●
TDD0500M1	5.0	61.5	141.5	140	1.5	MT.1	●
TDD0510M1	5.1	66.5	146.5	145	1.5	MT.1	●
TDD0520M1	5.2	66.6	146.6	145	1.6	MT.1	●
TDD0530M1	5.3	66.6	146.6	145	1.6	MT.1	●
TDD0540M1	5.4	66.6	146.6	145	1.6	MT.1	●
TDD0550M1	5.5	66.7	146.7	145	1.7	MT.1	●
TDD0560M1	5.6	69.7	149.7	148	1.7	MT.1	●
TDD0570M1	5.7	69.7	149.7	148	1.7	MT.1	●
TDD0580M1	5.8	69.7	149.7	148	1.7	MT.1	●
TDD0590M1	5.9	69.8	149.8	148	1.8	MT.1	●
TDD0600M1	6.0	69.8	149.8	148	1.8	MT.1	●
TDD0610M1	6.1	73.8	153.8	152	1.8	MT.1	●
TDD0620M1	6.2	73.9	153.9	152	1.9	MT.1	●
TDD0630M1	6.3	73.9	153.9	152	1.9	MT.1	●
TDD0640M1	6.4	73.9	153.9	152	1.9	MT.1	●
TDD0650M1	6.5	74.0	154.0	152	2.0	MT.1	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD0660M1	6.6	77.0	157.0	155	2.0	MT.1	●
TDD0670M1	6.7	77.0	157.0	155	2.0	MT.1	●
TDD0680M1	6.8	77.0	157.0	155	2.0	MT.1	●
TDD0690M1	6.9	77.1	157.1	155	2.1	MT.1	●
TDD0700M1	7.0	77.1	157.1	155	2.1	MT.1	●
TDD0710M1	7.1	80.1	160.1	158	2.1	MT.1	●
TDD0720M1	7.2	80.2	160.2	158	2.2	MT.1	●
TDD0730M1	7.3	80.2	160.2	158	2.2	MT.1	●
TDD0740M1	7.4	80.2	160.2	158	2.2	MT.1	●
TDD0750M1	7.5	80.3	160.3	158	2.3	MT.1	●
TDD0760M1	7.6	84.3	164.3	162	2.3	MT.1	●
TDD0770M1	7.7	84.3	164.3	162	2.3	MT.1	●
TDD0780M1	7.8	84.3	164.3	162	2.3	MT.1	●
TDD0790M1	7.9	84.4	164.4	162	2.4	MT.1	●
TDD0800M1	8.0	84.4	164.4	162	2.4	MT.1	●
TDD0810M1	8.1	87.4	170.4	168	2.4	MT.1	●
TDD0820M1	8.2	87.5	170.5	168	2.5	MT.1	●
TDD0830M1	8.3	87.5	170.5	168	2.5	MT.1	●
TDD0840M1	8.4	87.5	170.5	168	2.5	MT.1	●
TDD0850M1	8.5	87.6	170.6	168	2.6	MT.1	●
TDD0860M1	8.6	90.6	174.6	172	2.6	MT.1	●
TDD0870M1	8.7	90.6	174.6	172	2.6	MT.1	●
TDD0880M1	8.8	90.6	174.6	172	2.6	MT.1	●
TDD0890M1	8.9	90.7	174.7	172	2.7	MT.1	●
TDD0900M1	9.0	90.7	174.7	172	2.7	MT.1	●
TDD0910M1	9.1	94.7	177.7	175	2.7	MT.1	●
TDD0920M1	9.2	94.8	177.8	175	2.8	MT.1	●
TDD0930M1	9.3	94.8	177.8	175	2.8	MT.1	●
TDD0940M1	9.4	94.8	177.8	175	2.8	MT.1	●
TDD0950M1	9.5	94.9	177.9	175	2.9	MT.1	●
TDD0960M1	9.6	97.9	180.9	178	2.9	MT.1	●
TDD0970M1	9.7	97.9	180.9	178	2.9	MT.1	●
TDD0980M1	9.8	97.9	180.9	178	2.9	MT.1	●
TDD0990M1	9.9	98.0	181.0	178	3.0	MT.1	●
TDD1000M1	10.0	98.0	181.0	178	3.0	MT.1	●
TDD1010M1	10.1	101.0	185.0	182	3.0	MT.1	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD1020M1	10.2	101.1	185.1	182	3.1	MT.1	●
TDD1030M1	10.3	101.1	185.1	182	3.1	MT.1	●
TDD1040M1	10.4	101.1	185.1	182	3.1	MT.1	●
TDD1050M1	10.5	101.2	185.2	182	3.2	MT.1	●
TDD1060M1	10.6	105.2	188.2	185	3.2	MT.1	●
TDD1070M1	10.7	105.2	188.2	185	3.2	MT.1	●
TDD1080M1	10.8	105.2	188.2	185	3.2	MT.1	●
TDD1090M1	10.9	105.3	188.3	185	3.3	MT.1	●
TDD1100M1	11.0	105.3	188.3	185	3.3	MT.1	●
TDD1110M1	11.1	108.3	191.3	188	3.3	MT.1	●
TDD1120M1	11.2	108.4	191.4	188	3.4	MT.1	●
TDD1130M1	11.3	108.4	191.4	188	3.4	MT.1	●
TDD1140M1	11.4	108.4	191.4	188	3.4	MT.1	●
TDD1150M1	11.5	108.5	191.5	188	3.5	MT.1	●
TDD1160M1	11.6	111.5	195.5	192	3.5	MT.1	●
TDD1170M1	11.7	111.5	195.5	192	3.5	MT.1	●
TDD1180M1	11.8	111.5	195.5	192	3.5	MT.1	●
TDD1190M1	11.9	111.6	195.6	192	3.6	MT.1	●
TDD1200M1	12.0	111.6	195.6	192	3.6	MT.1	●
TDD1210M1	12.1	115.6	198.6	195	3.6	MT.1	●
TDD1220M1	12.2	115.7	198.7	195	3.7	MT.1	●
TDD1230M1	12.3	115.7	198.7	195	3.7	MT.1	●
TDD1240M1	12.4	115.7	198.7	195	3.7	MT.1	●
TDD1250M1	12.5	115.8	198.8	195	3.8	MT.1	●
TDD1260M1	12.6	118.8	201.8	198	3.8	MT.1	●
TDD1270M1	12.7	118.8	201.8	198	3.8	MT.1	●
TDD1280M1	12.8	118.8	201.8	198	3.8	MT.1	●
TDD1290M1	12.9	118.9	201.9	198	3.9	MT.1	●
TDD1300M1	13.0	118.9	201.9	198	3.9	MT.1	●
TDD1310M1	13.1	121.9	205.9	202	3.9	MT.1	●
TDD1320M1	13.2	122.0	206.0	202	4.0	MT.1	●
TDD1330M1	13.3	122.0	206.0	202	4.0	MT.1	●
TDD1340M1	13.4	122.0	206.0	202	4.0	MT.1	●
TDD1350M1	13.5	122.1	206.1	202	4.1	MT.1	●
TDD1360M1	13.6	126.1	209.1	205	4.1	MT.1	●
TDD1370M1	13.7	126.1	209.1	205	4.1	MT.1	●
TDD1380M1	13.8	126.1	209.1	205	4.1	MT.1	●
TDD1390M1	13.9	126.2	209.2	205	4.2	MT.1	●
TDD1400M1	14.0	126.2	209.2	205	4.2	MT.1	●
TDD1410M2	14.1	126.2	226.2	222	4.2	MT.2	●
TDD1420M2	14.2	126.3	226.3	222	4.3	MT.2	●
TDD1430M2	14.3	126.3	226.3	222	4.3	MT.2	●
TDD1440M2	14.4	126.3	226.3	222	4.3	MT.2	●
TDD1450M2	14.5	126.4	226.4	222	4.4	MT.2	●
TDD1460M2	14.6	129.4	229.4	225	4.4	MT.2	●
TDD1470M2	14.7	129.4	229.4	225	4.4	MT.2	●
TDD1480M2	14.8	129.4	229.4	225	4.4	MT.2	●
TDD1490M2	14.9	129.5	229.5	225	4.5	MT.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD1500M2	15.0	129.5	229.5	225	4.5	MT.2	●
TDD1510M2	15.1	132.5	232.5	228	4.5	MT.2	●
TDD1520M2	15.2	132.6	232.6	228	4.6	MT.2	●
TDD1530M2	15.3	132.6	232.6	228	4.6	MT.2	●
TDD1540M2	15.4	132.6	232.6	228	4.6	MT.2	●
TDD1550M2	15.5	132.7	232.7	228	4.7	MT.2	●
TDD1560M2	15.6	134.7	234.7	230	4.7	MT.2	●
TDD1570M2	15.7	134.7	234.7	230	4.7	MT.2	●
TDD1580M2	15.8	134.7	234.7	230	4.7	MT.2	●
TDD1590M2	15.9	134.8	234.8	230	4.8	MT.2	●
TDD1600M2	16.0	134.8	234.8	230	4.8	MT.2	●
TDD1610M2	16.1	136.8	236.8	232	4.8	MT.2	●
TDD1620M2	16.2	136.9	236.9	232	4.9	MT.2	●
TDD1630M2	16.3	136.9	236.9	232	4.9	MT.2	●
TDD1640M2	16.4	136.9	236.9	232	4.9	MT.2	●
TDD1650M2	16.5	137.0	237.0	232	5.0	MT.2	●
TDD1660M2	16.6	140.0	240.0	235	5.0	MT.2	●
TDD1670M2	16.7	140.0	240.0	235	5.0	MT.2	●
TDD1680M2	16.8	140.0	240.0	235	5.0	MT.2	●
TDD1690M2	16.9	140.1	240.1	235	5.1	MT.2	●
TDD1700M2	17.0	140.1	240.1	235	5.1	MT.2	●
TDD1710M2	17.1	145.1	245.1	240	5.1	MT.2	●
TDD1720M2	17.2	145.2	245.2	240	5.2	MT.2	●
TDD1730M2	17.3	145.2	245.2	240	5.2	MT.2	●
TDD1740M2	17.4	145.2	245.2	240	5.2	MT.2	●
TDD1750M2	17.5	145.3	245.3	240	5.3	MT.2	●
TDD1760M2	17.6	145.3	245.3	240	5.3	MT.2	●
TDD1770M2	17.7	145.3	245.3	240	5.3	MT.2	●
TDD1780M2	17.8	145.3	245.3	240	5.3	MT.2	●
TDD1790M2	17.9	145.4	245.4	240	5.4	MT.2	●
TDD1800M2	18.0	145.4	245.4	240	5.4	MT.2	●
TDD1810M2	18.1	150.4	250.4	245	5.4	MT.2	●
TDD1820M2	18.2	150.5	250.5	245	5.5	MT.2	●
TDD1830M2	18.3	150.5	250.5	245	5.5	MT.2	●
TDD1840M2	18.4	150.5	250.5	245	5.5	MT.2	●
TDD1850M2	18.5	150.6	250.6	245	5.6	MT.2	●
TDD1860M2	18.6	150.6	250.6	245	5.6	MT.2	●
TDD1870M2	18.7	150.6	250.6	245	5.6	MT.2	●
TDD1880M2	18.8	150.6	250.6	245	5.6	MT.2	●
TDD1890M2	18.9	150.7	250.7	245	5.7	MT.2	●
TDD1900M2	19.0	150.7	250.7	245	5.7	MT.2	●
TDD1910M2	19.1	155.7	255.7	250	5.7	MT.2	●
TDD1920M2	19.2	155.8	255.8	250	5.8	MT.2	●
TDD1930M2	19.3	155.8	255.8	250	5.8	MT.2	●
TDD1940M2	19.4	155.8	255.8	250	5.8	MT.2	●
TDD1950M2	19.5	155.9	255.9	250	5.9	MT.2	●
TDD1960M2	19.6	155.9	255.9	250	5.9	MT.2	●
TDD1970M2	19.7	155.9	255.9	250	5.9	MT.2	●

CUTTING CONDITIONS ➤ P209
TECHNICAL DATA ➤ R001

TD

Taper shank

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD1980M2	19.8	155.9	255.9	250	5.9	MT.2	●
TDD1990M2	19.9	156.0	256.0	250	6.0	MT.2	●
TDD2000M2	20.0	156.0	256.0	250	6.0	MT.2	●
TDD2010M2	20.1	161.0	261.0	255	6.0	MT.2	●
TDD2020M2	20.2	161.1	261.1	255	6.1	MT.2	●
TDD2030M2	20.3	161.1	261.1	255	6.1	MT.2	●
TDD2040M2	20.4	161.1	261.1	255	6.1	MT.2	●
TDD2050M2	20.5	161.2	261.2	255	6.2	MT.2	●
TDD2060M2	20.6	161.2	261.2	255	6.2	MT.2	●
TDD2070M2	20.7	161.2	261.2	255	6.2	MT.2	●
TDD2080M2	20.8	161.2	261.2	255	6.2	MT.2	●
TDD2090M2	20.9	161.3	261.3	255	6.3	MT.2	●
TDD2100M2	21.0	161.3	261.3	255	6.3	MT.2	●
TDD2110M2	21.1	166.3	266.3	260	6.3	MT.2	●
TDD2120M2	21.2	166.4	266.4	260	6.4	MT.2	●
TDD2130M2	21.3	166.4	266.4	260	6.4	MT.2	●
TDD2140M2	21.4	166.4	266.4	260	6.4	MT.2	●
TDD2150M2	21.5	166.5	266.5	260	6.5	MT.2	●
TDD2160M2	21.6	166.5	266.5	260	6.5	MT.2	●
TDD2170M2	21.7	166.5	266.5	260	6.5	MT.2	●
TDD2180M2	21.8	166.5	266.5	260	6.5	MT.2	●
TDD2190M2	21.9	166.6	266.6	260	6.6	MT.2	●
TDD2200M2	22.0	166.6	266.6	260	6.6	MT.2	●
TDD2210M2	22.1	171.6	271.6	265	6.6	MT.2	●
TDD2220M2	22.2	171.7	271.7	265	6.7	MT.2	●
TDD2230M2	22.3	171.7	271.7	265	6.7	MT.2	●
TDD2240M2	22.4	171.7	271.7	265	6.7	MT.2	●
TDD2250M2	22.5	171.8	271.8	265	6.8	MT.2	●
TDD2260M2	22.6	171.8	271.8	265	6.8	MT.2	●
TDD2270M2	22.7	171.8	271.8	265	6.8	MT.2	●
TDD2280M2	22.8	171.8	271.8	265	6.8	MT.2	●
TDD2290M2	22.9	171.9	271.9	265	6.9	MT.2	●
TDD2300M2	23.0	171.9	271.9	265	6.9	MT.2	●
TDD2350M3	23.5	172.1	292.1	285	7.1	MT.3	●
TDD2400M3	24.0	172.2	292.2	285	7.2	MT.3	●
TDD2450M3	24.5	172.4	292.4	285	7.4	MT.3	●
TDD2500M3	25.0	172.5	292.5	285	7.5	MT.3	●
TDD2550M3	25.5	172.7	292.7	285	7.7	MT.3	●
TDD2600M3	26.0	172.8	292.8	285	7.8	MT.3	●
TDD2650M3	26.5	178.0	298.0	290	8.0	MT.3	●
TDD2700M3	27.0	178.1	298.1	290	8.1	MT.3	●
TDD2750M3	27.5	183.3	303.3	295	8.3	MT.3	●
TDD2800M3	28.0	183.4	303.4	295	8.4	MT.3	●
TDD2850M3	28.5	188.6	308.6	300	8.6	MT.3	●
TDD2900M3	29.0	188.7	308.7	300	8.7	MT.3	●
TDD2950M3	29.5	193.9	313.9	305	8.9	MT.3	●
TDD3000M3	30.0	194.0	314.0	305	9.0	MT.3	●
TDD3050M3	30.5	199.2	319.2	310	9.2	MT.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD3100M3	31.0	199.3	319.3	310	9.3	MT.3	●
TDD3150M3	31.5	204.5	324.5	315	9.5	MT.3	●
TDD3200M3	32.0	204.6	324.6	315	9.6	MT.3	●
TDD3250M4	32.5	209.8	354.8	345	9.8	MT.4	●
TDD3300M4	33.0	209.9	354.9	345	9.9	MT.4	●
TDD3350M4	33.5	215.1	360.1	350	10.1	MT.4	●
TDD3400M4	34.0	215.2	360.2	350	10.2	MT.4	●
TDD3450M4	34.5	215.4	360.4	350	10.4	MT.4	●
TDD3500M4	35.0	215.5	360.5	350	10.5	MT.4	●
TDD3550M4	35.5	220.7	365.7	355	10.7	MT.4	●
TDD3600M4	36.0	220.8	365.8	355	10.8	MT.4	●
TDD3650M4	36.5	221.0	366.0	355	11.0	MT.4	●
TDD3700M4	37.0	221.1	366.1	355	11.1	MT.4	●
TDD3750M4	37.5	226.3	371.3	360	11.3	MT.4	●
TDD3800M4	38.0	226.4	371.4	360	11.4	MT.4	●
TDD3850M4	38.5	226.6	371.6	360	11.6	MT.4	●
TDD3900M4	39.0	226.7	371.7	360	11.7	MT.4	●
TDD3950M4	39.5	231.9	376.9	365	11.9	MT.4	●
TDD4000M4	40.0	232.0	377.0	365	12.0	MT.4	●
TDD4050M4	40.5	232.2	377.2	365	12.2	MT.4	●
TDD4100M4	41.0	232.3	377.3	365	12.3	MT.4	●
TDD4150M4	41.5	237.5	382.5	370	12.5	MT.4	●
TDD4200M4	42.0	237.6	382.6	370	12.6	MT.4	●
TDD4250M4	42.5	237.8	382.8	370	12.8	MT.4	●
TDD4300M4	43.0	237.9	382.9	370	12.9	MT.4	●
TDD4350M4	43.5	243.1	388.1	375	13.1	MT.4	●
TDD4400M4	44.0	243.2	388.2	375	13.2	MT.4	●
TDD4450M4	44.5	243.4	388.4	375	13.4	MT.4	●
TDD4500M4	45.0	243.5	388.5	375	13.5	MT.4	●
TDD4550M4	45.5	248.7	393.7	380	13.7	MT.4	●
TDD4600M4	46.0	248.8	393.8	380	13.8	MT.4	●
TDD4650M4	46.5	249.0	394.0	380	14.0	MT.4	●
TDD4700M4	47.0	249.1	394.1	380	14.1	MT.4	●
TDD4750M4	47.5	254.3	399.3	385	14.3	MT.4	●
TDD4800M4	48.0	254.4	399.4	385	14.4	MT.4	●
TDD4850M4	48.5	254.6	399.6	385	14.6	MT.4	●
TDD4900M4	49.0	254.7	399.7	385	14.7	MT.4	●
TDD4950M4	49.5	259.9	404.9	390	14.9	MT.4	●
TDD5000M4	50.0	260.0	405.0	390	15.0	MT.4	●
TDD5100M5	51.0	260.3	440.3	425	15.3	MT.5	●
TDD5200M5	52.0	265.6	445.6	430	15.6	MT.5	●
TDD5300M5	53.0	265.9	445.9	430	15.9	MT.5	●
TDD5400M5	54.0	271.2	451.2	435	16.2	MT.5	●
TDD5500M5	55.0	271.5	451.5	435	16.5	MT.5	●
TDD5600M5	56.0	276.8	456.8	440	16.8	MT.5	●
TDD5700M5	57.0	277.1	457.1	440	17.1	MT.5	●
TDD5800M5	58.0	282.4	462.4	445	17.4	MT.5	●
TDD5900M5	59.0	282.7	462.7	445	17.7	MT.5	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD6000M5	60.0	288.0	468.0	450	18.0	MT.5	●
TDD6100M5	61.0	288.3	468.3	450	18.3	MT.5	●
TDD6200M5	62.0	293.6	473.6	455	18.6	MT.5	●
TDD6300M5	63.0	293.9	473.9	455	18.9	MT.5	●
TDD6400M5	64.0	299.2	479.2	460	19.2	MT.5	●
TDD6500M5	65.0	299.5	479.5	460	19.5	MT.5	●
TDD6600M5	66.0	304.8	484.8	465	19.8	MT.5	●
TDD6700M5	67.0	305.1	485.1	465	20.1	MT.5	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TDD6800M5	68.0	310.4	490.4	470	20.4	MT.5	●
TDD6900M5	69.0	310.7	490.7	470	20.7	MT.5	●
TDD7000M5	70.0	316.0	496.0	475	21.0	MT.5	●
TDD7100M5	71.0	316.3	496.3	475	21.3	MT.5	●
TDD7200M5	72.0	321.6	501.6	480	21.6	MT.5	●
TDD7300M5	73.0	321.9	501.9	480	21.9	MT.5	●
TDD7400M5	74.0	327.2	507.2	485	22.2	MT.5	●
TDD7500M5	75.0	327.5	507.5	485	22.5	MT.5	●

CUTTING CONDITIONS ➢ P209
TECHNICAL DATA ➢ R001

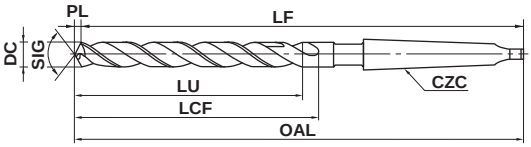
KTD

Cobalt HSS

CO HSS | 118° | 128° | C | S

DC<10,DC>35 | 10≤DC≤35 | 16<DC≤35 | DC>35

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

5≤DC≤6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤50
0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

●Suitable for drilling of difficult-to-cut materials.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
KTDD0500M1	5.0	61.5	141.5	140	1.5	MT.1	●
KTDD0550M1	5.5	66.7	146.7	145	1.7	MT.1	●
KTDD0600M1	6.0	69.8	149.8	148	1.8	MT.1	●
KTDD0650M1	6.5	74.0	154.0	152	2.0	MT.1	●
KTDD0700M1	7.0	77.1	157.1	155	2.1	MT.1	●
KTDD0750M1	7.5	80.3	160.3	158	2.3	MT.1	●
KTDD0800M1	8.0	84.4	164.4	162	2.4	MT.1	●
KTDD0850M1	8.5	87.6	170.6	168	2.6	MT.1	●
KTDD0900M1	9.0	90.7	174.7	172	2.7	MT.1	●
KTDD0950M1	9.5	94.9	177.9	175	2.9	MT.1	●
KTDD1000M1	10.0	97.4	180.4	178	2.4	MT.1	●
KTDD1010M1	10.1	100.5	184.5	182	2.5	MT.1	●
KTDD1020M1	10.2	100.5	184.5	182	2.5	MT.1	●
KTDD1030M1	10.3	100.5	184.5	182	2.5	MT.1	●
KTDD1040M1	10.4	100.5	184.5	182	2.5	MT.1	●
KTDD1050M1	10.5	100.6	184.6	182	2.6	MT.1	●
KTDD1060M1	10.6	104.6	187.6	185	2.6	MT.1	●
KTDD1070M1	10.7	104.6	187.6	185	2.6	MT.1	●
KTDD1080M1	10.8	104.6	187.6	185	2.6	MT.1	●
KTDD1090M1	10.9	104.7	187.7	185	2.7	MT.1	●
KTDD1100M1	11.0	104.7	187.7	185	2.7	MT.1	●
KTDD1150M1	11.5	107.8	190.8	188	2.8	MT.1	●
KTDD1200M1	12.0	110.9	194.9	192	2.9	MT.1	●
KTDD1210M2	12.1	115.0	215.0	212	3.0	MT.2	●
KTDD1220M2	12.2	115.0	215.0	212	3.0	MT.2	●
KTDD1250M2	12.5	115.0	215.0	212	3.0	MT.2	●
KTDD1300M2	13.0	118.2	218.2	215	3.2	MT.2	●
KTDD1310M2	13.1	121.2	221.2	218	3.2	MT.2	●
KTDD1320M2	13.2	121.2	221.2	218	3.2	MT.2	●
KTDD1350M2	13.5	121.3	221.3	218	3.3	MT.2	●
KTDD1370M2	13.7	125.3	225.3	222	3.3	MT.2	●
KTDD1380M2	13.8	125.4	225.4	222	3.4	MT.2	●
KTDD1390M2	13.9	125.4	225.4	222	3.4	MT.2	●
KTDD1400M2	14.0	125.4	225.4	222	3.4	MT.2	●
KTDD1410M2	14.1	125.4	225.4	222	3.4	MT.2	●
KTDD1420M2	14.2	125.5	225.5	222	3.5	MT.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
KTDD1430M2	14.3	125.5	225.5	222	3.5	MT.2	●
KTDD1440M2	14.4	125.5	225.5	222	3.5	MT.2	●
KTDD1450M2	14.5	125.5	225.5	222	3.5	MT.2	●
KTDD1470M2	14.7	128.6	228.6	225	3.6	MT.2	●
KTDD1500M2	15.0	128.7	228.7	225	3.7	MT.2	●
KTDD1550M2	15.5	131.8	231.8	228	3.8	MT.2	●
KTDD1600M2	16.0	133.9	233.9	230	3.9	MT.2	●
KTDD1620M2	16.2	136.0	236.0	232	4.0	MT.2	●
KTDD1650M2	16.5	136.0	236.0	232	4.0	MT.2	●
KTDD1670M2	16.7	139.1	239.1	235	4.1	MT.2	●
KTDD1700M2	17.0	139.1	239.1	235	4.1	MT.2	●
KTDD1750M2	17.5	144.3	244.3	240	4.3	MT.2	●
KTDD1770M2	17.7	144.3	244.3	240	4.3	MT.2	●
KTDD1800M2	18.0	144.4	244.4	240	4.4	MT.2	●
KTDD1850M2	18.5	149.5	249.5	245	4.5	MT.2	●
KTDD1900M2	19.0	149.6	249.6	245	4.6	MT.2	●
KTDD1950M2	19.5	154.8	254.8	250	4.8	MT.2	●
KTDD2000M2	20.0	154.9	254.9	250	4.9	MT.2	●
KTDD2050M3	20.5	160.0	280.0	275	5.0	MT.3	●
KTDD2100M3	21.0	160.1	280.1	275	5.1	MT.3	●
KTDD2150M3	21.5	165.2	285.2	280	5.2	MT.3	●
KTDD2200M3	22.0	165.4	285.4	280	5.4	MT.3	●
KTDD2250M3	22.5	170.5	290.5	285	5.5	MT.3	●
KTDD2300M3	23.0	170.6	290.6	285	5.6	MT.3	●
KTDD2350M3	23.5	170.7	290.7	285	5.7	MT.3	●
KTDD2400M3	24.0	170.9	290.9	285	5.9	MT.3	●
KTDD2450M3	24.5	171.0	291.0	285	6.0	MT.3	●
KTDD2500M3	25.0	171.1	291.1	285	6.1	MT.3	●
KTDD2550M3	25.5	171.2	291.2	285	6.2	MT.3	●
KTDD2600M3	26.0	171.3	291.3	285	6.3	MT.3	●
KTDD2650M3	26.5	176.5	296.5	290	6.5	MT.3	●
KTDD2700M3	27.0	176.6	296.6	290	6.6	MT.3	●
KTDD2750M4	27.5	181.7	326.7	320	6.7	MT.4	●
KTDD2800M4	28.0	181.8	326.8	320	6.8	MT.4	●
KTDD2850M4	28.5	187.0	332.0	325	7.0	MT.4	●
KTDD2900M4	29.0	187.1	332.1	325	7.1	MT.4	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
KTDD2950M4	29.5	192.2	337.2	330	7.2	MT.4	●
KTDD3000M4	30.0	192.3	337.3	330	7.3	MT.4	●
KTDD3050M4	30.5	197.4	342.4	335	7.4	MT.4	●
KTDD3100M4	31.0	197.6	342.6	335	7.6	MT.4	●
KTDD3150M4	31.5	202.7	347.7	340	7.7	MT.4	●
KTDD3200M4	32.0	202.8	347.8	340	7.8	MT.4	●
KTDD3300M4	33.0	208.0	353.0	345	8.0	MT.4	●
KTDD3400M4	34.0	213.3	358.3	350	8.3	MT.4	●
KTDD3500M4	35.0	213.5	358.5	350	8.5	MT.4	●
KTDD3600M4	36.0	220.8	365.8	355	10.8	MT.4	●
KTDD3700M4	37.0	221.1	366.1	355	11.1	MT.4	●
KTDD3800M4	38.0	226.4	371.4	360	11.4	MT.4	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
KTDD3900M4	39.0	226.7	371.7	360	11.7	MT.4	●
KTDD4000M4	40.0	232.0	377.0	365	12.0	MT.4	●
KTDD4100M4	41.0	232.3	377.3	365	12.3	MT.4	●
KTDD4200M4	42.0	237.6	382.6	370	12.6	MT.4	●
KTDD4300M4	43.0	237.9	382.9	370	12.9	MT.4	●
KTDD4400M4	44.0	243.2	388.2	375	13.2	MT.4	●
KTDD4500M4	45.0	243.5	388.5	375	13.5	MT.4	●
KTDD4600M4	46.0	248.8	393.8	380	13.8	MT.4	●
KTDD4700M4	47.0	249.1	394.1	380	14.1	MT.4	●
KTDD4800M4	48.0	254.4	399.4	385	14.4	MT.4	●
KTDD4900M4	49.0	254.7	399.7	385	14.7	MT.4	●
KTDD5000M4	50.0	260.0	405.0	390	15.0	MT.4	●

CUTTING CONDITIONS ➢ P209
TECHNICAL DATA ➢ R001

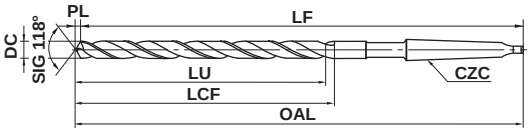
HSS

LTD

Extra long

HSS 118° S DC>6

P Steel | M | K Cast Iron | N Non-ferrous Metal | S | H



*LU = LCF-2DC

DC=6	6<DC≤10	10<DC≤18	18<DC≤30	30<DC≤40
0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

●For deep hole drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD0600A200M1	6.0	101.8	201.8	200	1.8	MT.1	●
LTDD0600A250M1	6.0	151.8	251.8	250	1.8	MT.1	●
LTDD0600A300M1	6.0	201.8	301.8	300	1.8	MT.1	●
LTDD0600A350M1	6.0	226.8	351.8	350	1.8	MT.1	●
LTDD0650A250M1	6.5	152.0	252.0	250	2.0	MT.1	●
LTDD0650A300M1	6.5	202.0	302.0	300	2.0	MT.1	●
LTDD0650A350M1	6.5	227.0	352.0	350	2.0	MT.1	●
LTDD0700A250M1	7.0	152.1	252.1	250	2.1	MT.1	●
LTDD0700A300M1	7.0	202.1	302.1	300	2.1	MT.1	●
LTDD0700A350M1	7.0	227.1	352.1	350	2.1	MT.1	●
LTDD0750A250M1	7.5	152.3	252.3	250	2.3	MT.1	●
LTDD0750A300M1	7.5	202.3	302.3	300	2.3	MT.1	●
LTDD0750A350M1	7.5	227.3	352.3	350	2.3	MT.1	●
LTDD0800A250M1	8.0	152.4	252.4	250	2.4	MT.1	●
LTDD0800A300M1	8.0	202.4	302.4	300	2.4	MT.1	●
LTDD0800A350M1	8.0	227.4	352.4	350	2.4	MT.1	●
LTDD0850A250M1	8.5	152.6	252.6	250	2.6	MT.1	●
LTDD0850A300M1	8.5	202.6	302.6	300	2.6	MT.1	●
LTDD0850A350M1	8.5	227.6	352.6	350	2.6	MT.1	●
LTDD0900A250M1	9.0	152.7	252.7	250	2.7	MT.1	●
LTDD0900A300M1	9.0	202.7	302.7	300	2.7	MT.1	●
LTDD0900A350M1	9.0	227.7	352.7	350	2.7	MT.1	●
LTDD0950A250M1	9.5	152.9	252.9	250	2.9	MT.1	●
LTDD0950A300M1	9.5	202.9	302.9	300	2.9	MT.1	●
LTDD0950A350M1	9.5	227.9	352.9	350	2.9	MT.1	●
LTDD0950A400M1	9.5	252.9	402.9	400	2.9	MT.1	●
LTDD1000A250M1	10.0	153.0	253.0	250	3.0	MT.1	●
LTDD1000A300M1	10.0	203.0	303.0	300	3.0	MT.1	●
LTDD1000A350M1	10.0	228.0	353.0	350	3.0	MT.1	●
LTDD1000A400M1	10.0	253.0	403.0	400	3.0	MT.1	●
LTDD1050A250M1	10.5	153.2	253.2	250	3.2	MT.1	●
LTDD1050A300M1	10.5	203.2	303.2	300	3.2	MT.1	●
LTDD1050A350M1	10.5	228.2	353.2	350	3.2	MT.1	●
LTDD1050A400M1	10.5	253.2	403.2	400	3.2	MT.1	●
LTDD1100A250M1	11.0	153.3	253.3	250	3.3	MT.1	●
LTDD1100A300M1	11.0	203.3	303.3	300	3.3	MT.1	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD1100A350M1	11.0	228.3	353.3	350	3.3	MT.1	●
LTDD1100A400M1	11.0	253.3	403.3	400	3.3	MT.1	●
LTDD1150A250M1	11.5	153.5	253.5	250	3.5	MT.1	●
LTDD1150A300M1	11.5	203.5	303.5	300	3.5	MT.1	●
LTDD1150A350M1	11.5	228.5	353.5	350	3.5	MT.1	●
LTDD1150A400M1	11.5	253.5	403.5	400	3.5	MT.1	●
LTDD1200A250M1	12.0	153.6	253.6	250	3.6	MT.1	●
LTDD1200A300M1	12.0	203.6	303.6	300	3.6	MT.1	●
LTDD1200A350M1	12.0	228.6	353.6	350	3.6	MT.1	●
LTDD1200A400M1	12.0	253.6	403.6	400	3.6	MT.1	●
LTDD1250A250M1	12.5	153.8	253.8	250	3.8	MT.1	●
LTDD1250A300M1	12.5	203.8	303.8	300	3.8	MT.1	●
LTDD1250A350M1	12.5	228.8	353.8	350	3.8	MT.1	●
LTDD1250A400M1	12.5	253.8	403.8	400	3.8	MT.1	●
LTDD1300A250M1	13.0	153.9	253.9	250	3.9	MT.1	●
LTDD1300A300M1	13.0	203.9	303.9	300	3.9	MT.1	●
LTDD1300A350M1	13.0	228.9	353.9	350	3.9	MT.1	●
LTDD1300A400M1	13.0	253.9	403.9	400	3.9	MT.1	●
LTDD1350A300M1	13.5	204.1	304.1	300	4.1	MT.1	●
LTDD1350A350M1	13.5	229.1	354.1	350	4.1	MT.1	●
LTDD1350A400M1	13.5	254.1	404.1	400	4.1	MT.1	●
LTDD1350A450M1	13.5	304.1	454.1	450	4.1	MT.1	●
LTDD1350A500M1	13.5	354.1	504.1	500	4.1	MT.1	●
LTDD1350A600M1	13.5	404.1	604.1	600	4.1	MT.1	●
LTDD1400A300M1	14.0	204.2	304.2	300	4.2	MT.1	●
LTDD1400A350M1	14.0	229.2	354.2	350	4.2	MT.1	●
LTDD1400A400M1	14.0	254.2	404.2	400	4.2	MT.1	●
LTDD1400A450M1	14.0	304.2	454.2	450	4.2	MT.1	●
LTDD1400A500M1	14.0	354.2	504.2	500	4.2	MT.1	●
LTDD1400A600M1	14.0	404.2	604.2	600	4.2	MT.1	●
LTDD1450A300M2	14.5	179.4	304.4	300	4.4	MT.2	●
LTDD1450A350M2	14.5	229.4	354.4	350	4.4	MT.2	●
LTDD1450A400M2	14.5	254.4	404.4	400	4.4	MT.2	●
LTDD1450A450M2	14.5	304.4	454.4	450	4.4	MT.2	●
LTDD1450A500M2	14.5	354.4	504.4	500	4.4	MT.2	●
LTDD1450A600M2	14.5	404.4	604.4	600	4.4	MT.2	●

● : Inventory maintained in Japan.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD1500A300M2	15.0	179.5	304.5	300	4.5	MT.2	●
LTDD1500A350M2	15.0	229.5	354.5	350	4.5	MT.2	●
LTDD1500A400M2	15.0	254.5	404.5	400	4.5	MT.2	●
LTDD1500A450M2	15.0	304.5	454.5	450	4.5	MT.2	●
LTDD1500A500M2	15.0	354.5	504.5	500	4.5	MT.2	●
LTDD1500A600M2	15.0	404.5	604.5	600	4.5	MT.2	●
LTDD1550A300M2	15.5	179.7	304.7	300	4.7	MT.2	●
LTDD1550A350M2	15.5	229.7	354.7	350	4.7	MT.2	●
LTDD1550A400M2	15.5	254.7	404.7	400	4.7	MT.2	●
LTDD1550A450M2	15.5	304.7	454.7	450	4.7	MT.2	●
LTDD1550A500M2	15.5	354.7	504.7	500	4.7	MT.2	●
LTDD1550A600M2	15.5	404.7	604.7	600	4.7	MT.2	●
LTDD1600A300M2	16.0	179.8	304.8	300	4.8	MT.2	●
LTDD1600A350M2	16.0	229.8	354.8	350	4.8	MT.2	●
LTDD1600A400M2	16.0	254.8	404.8	400	4.8	MT.2	●
LTDD1600A450M2	16.0	304.8	454.8	450	4.8	MT.2	●
LTDD1600A500M2	16.0	354.8	504.8	500	4.8	MT.2	●
LTDD1600A600M2	16.0	404.8	604.8	600	4.8	MT.2	●
LTDD1650A300M2	16.5	180.0	305.0	300	5.0	MT.2	●
LTDD1650A350M2	16.5	230.0	355.0	350	5.0	MT.2	●
LTDD1650A400M2	16.5	255.0	405.0	400	5.0	MT.2	●
LTDD1650A450M2	16.5	305.0	455.0	450	5.0	MT.2	●
LTDD1650A500M2	16.5	355.0	505.0	500	5.0	MT.2	●
LTDD1650A600M2	16.5	405.0	605.0	600	5.0	MT.2	●
LTDD1700A300M2	17.0	180.1	305.1	300	5.1	MT.2	●
LTDD1700A350M2	17.0	230.1	355.1	350	5.1	MT.2	●
LTDD1700A400M2	17.0	255.1	405.1	400	5.1	MT.2	●
LTDD1700A450M2	17.0	305.1	455.1	450	5.1	MT.2	●
LTDD1700A500M2	17.0	355.1	505.1	500	5.1	MT.2	●
LTDD1700A600M2	17.0	405.1	605.1	600	5.1	MT.2	●
LTDD1750A300M2	17.5	180.3	305.3	300	5.3	MT.2	●
LTDD1750A350M2	17.5	230.3	355.3	350	5.3	MT.2	●
LTDD1750A400M2	17.5	255.3	405.3	400	5.3	MT.2	●
LTDD1750A450M2	17.5	305.3	455.3	450	5.3	MT.2	●
LTDD1750A500M2	17.5	355.3	505.3	500	5.3	MT.2	●
LTDD1750A600M2	17.5	405.3	605.3	600	5.3	MT.2	●
LTDD1800A300M2	18.0	180.4	305.4	300	5.4	MT.2	●
LTDD1800A350M2	18.0	230.4	355.4	350	5.4	MT.2	●
LTDD1800A400M2	18.0	255.4	405.4	400	5.4	MT.2	●
LTDD1800A450M2	18.0	305.4	455.4	450	5.4	MT.2	●
LTDD1800A500M2	18.0	355.4	505.4	500	5.4	MT.2	●
LTDD1800A600M2	18.0	405.4	605.4	600	5.4	MT.2	●
LTDD1900A300M2	19.0	180.7	305.7	300	5.7	MT.2	●
LTDD1900A350M2	19.0	230.7	355.7	350	5.7	MT.2	●
LTDD1900A400M2	19.0	255.7	405.7	400	5.7	MT.2	●
LTDD1900A450M2	19.0	305.7	455.7	450	5.7	MT.2	●
LTDD1900A500M2	19.0	355.7	505.7	500	5.7	MT.2	●
LTDD1900A600M2	19.0	405.7	605.7	600	5.7	MT.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD2000A300M2	20.0	181.0	306.0	300	6.0	MT.2	●
LTDD2000A350M2	20.0	231.0	356.0	350	6.0	MT.2	●
LTDD2000A400M2	20.0	256.0	406.0	400	6.0	MT.2	●
LTDD2000A450M2	20.0	306.0	456.0	450	6.0	MT.2	●
LTDD2000A500M2	20.0	356.0	506.0	500	6.0	MT.2	●
LTDD2000A600M2	20.0	406.0	606.0	600	6.0	MT.2	●
LTDD2100A350M2	21.0	231.3	356.3	350	6.3	MT.2	●
LTDD2100A400M2	21.0	256.3	406.3	400	6.3	MT.2	●
LTDD2100A450M2	21.0	306.3	456.3	450	6.3	MT.2	●
LTDD2100A500M2	21.0	356.3	506.3	500	6.3	MT.2	●
LTDD2100A600M2	21.0	406.3	606.3	600	6.3	MT.2	●
LTDD2200A350M2	22.0	231.6	356.6	350	6.6	MT.2	●
LTDD2200A400M2	22.0	256.6	406.6	400	6.6	MT.2	●
LTDD2200A450M2	22.0	306.6	456.6	450	6.6	MT.2	●
LTDD2200A500M2	22.0	356.6	506.6	500	6.6	MT.2	●
LTDD2200A600M2	22.0	406.6	606.6	600	6.6	MT.2	●
LTDD2300A350M2	23.0	231.9	356.9	350	6.9	MT.2	●
LTDD2300A400M2	23.0	256.9	406.9	400	6.9	MT.2	●
LTDD2300A450M2	23.0	306.9	456.9	450	6.9	MT.2	●
LTDD2300A500M2	23.0	356.9	506.9	500	6.9	MT.2	●
LTDD2300A600M2	23.0	406.9	606.9	600	6.9	MT.2	●
LTDD2400A350M3	24.0	207.2	357.2	350	7.2	MT.3	●
LTDD2400A400M3	24.0	257.2	407.2	400	7.2	MT.3	●
LTDD2400A450M3	24.0	307.2	457.2	450	7.2	MT.3	●
LTDD2400A500M3	24.0	357.2	507.2	500	7.2	MT.3	●
LTDD2400A600M3	24.0	407.2	607.2	600	7.2	MT.3	●
LTDD2500A350M3	25.0	207.5	357.5	350	7.5	MT.3	●
LTDD2500A400M3	25.0	257.5	407.5	400	7.5	MT.3	●
LTDD2500A450M3	25.0	307.5	457.5	450	7.5	MT.3	●
LTDD2500A500M3	25.0	357.5	507.5	500	7.5	MT.3	●
LTDD2500A600M3	25.0	407.5	607.5	600	7.5	MT.3	●
LTDD2600A400M3	26.0	257.8	407.8	400	7.8	MT.3	●
LTDD2600A450M3	26.0	307.8	457.8	450	7.8	MT.3	●
LTDD2600A500M3	26.0	357.8	507.8	500	7.8	MT.3	●
LTDD2600A600M3	26.0	407.8	607.8	600	7.8	MT.3	●
LTDD2700A400M3	27.0	258.1	408.1	400	8.1	MT.3	●
LTDD2700A450M3	27.0	308.1	458.1	450	8.1	MT.3	●
LTDD2700A500M3	27.0	358.1	508.1	500	8.1	MT.3	●
LTDD2700A600M3	27.0	408.1	608.1	600	8.1	MT.3	●
LTDD2800A400M3	28.0	258.4	408.4	400	8.4	MT.3	●
LTDD2800A450M3	28.0	308.4	458.4	450	8.4	MT.3	●
LTDD2800A500M3	28.0	358.4	508.4	500	8.4	MT.3	●
LTDD2800A600M3	28.0	408.4	608.4	600	8.4	MT.3	●
LTDD2900A400M3	29.0	258.7	408.7	400	8.7	MT.3	●
LTDD2900A450M3	29.0	308.7	458.7	450	8.7	MT.3	●
LTDD2900A500M3	29.0	358.7	508.7	500	8.7	MT.3	●
LTDD2900A600M3	29.0	408.7	608.7	600	8.7	MT.3	●
LTDD3000A400M3	30.0	259.0	409.0	400	9.0	MT.3	●

CUTTING CONDITIONS ➢ P203
TECHNICAL DATA ➢ R001

LTD

Extra long

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD3000A450M3	30.0	309.0	459.0	450	9.0	MT.3	●
LTDD3000A500M3	30.0	359.0	509.0	500	9.0	MT.3	●
LTDD3000A600M3	30.0	409.0	609.0	600	9.0	MT.3	●
LTDD3100A450M3	31.0	309.3	459.3	450	9.3	MT.3	●
LTDD3100A500M3	31.0	359.3	509.3	500	9.3	MT.3	●
LTDD3100A600M3	31.0	409.3	609.3	600	9.3	MT.3	●
LTDD3200A450M3	32.0	309.6	459.6	450	9.6	MT.3	●
LTDD3200A500M3	32.0	359.6	509.6	500	9.6	MT.3	●
LTDD3200A600M3	32.0	409.6	609.6	600	9.6	MT.3	●
LTDD3300A500M4	33.0	359.9	509.9	500	9.9	MT.4	●
LTDD3300A600M4	33.0	409.9	609.9	600	9.9	MT.4	●
LTDD3400A500M4	34.0	360.2	510.2	500	10.2	MT.4	●
LTDD3400A600M4	34.0	410.2	610.2	600	10.2	MT.4	●
LTDD3500A500M4	35.0	360.5	510.5	500	10.5	MT.4	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
LTDD3500A600M4	35.0	410.5	610.5	600	10.5	MT.4	●
LTDD3600A500M4	36.0	360.8	510.8	500	10.8	MT.4	●
LTDD3600A600M4	36.0	410.8	610.8	600	10.8	MT.4	●
LTDD3700A500M4	37.0	361.1	511.1	500	11.1	MT.4	●
LTDD3700A600M4	37.0	411.1	611.1	600	11.1	MT.4	●
LTDD3800A500M4	38.0	361.4	511.4	500	11.4	MT.4	●
LTDD3800A600M4	38.0	411.4	611.4	600	11.4	MT.4	●
LTDD3900A500M4	39.0	361.7	511.7	500	11.7	MT.4	●
LTDD3900A600M4	39.0	411.7	611.7	600	11.7	MT.4	●
LTDD4000A500M4	40.0	362.0	512.0	500	12.0	MT.4	●
LTDD4000A600M4	40.0	412.0	612.0	600	12.0	MT.4	●

● : Inventory maintained in Japan.

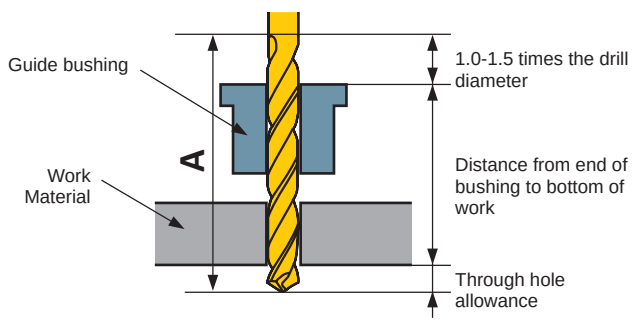
RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel SS Carbon Steel S-C (−25HRC)		Alloy Steel SCM Tool Steel SK (−35HRC)		Alloy Steel SCM Die Steel SKD (−40HRC)		Cast Iron FC	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
6.0	1100	0.18	900	0.15	600	0.13	1100	0.18
8.0	800	0.20	670	0.18	450	0.15	900	0.20
10.0	650	0.22	540	0.20	350	0.18	700	0.22
12.0	520	0.24	450	0.22	300	0.20	600	0.24
15.0	420	0.28	360	0.24	240	0.22	470	0.28
20.0	320	0.33	270	0.26	180	0.24	350	0.33
25.0	250	0.36	210	0.28	145	0.26	280	0.36
30.0	210	0.40	180	0.30	120	0.28	230	0.40
40.0	160	0.42	130	0.32	90	0.30	180	0.42

Work Material	Stainless Steel				Copper Alloy, Brass		Aluminium Alloy	
	Martensitic Ferritic AISI 430		Austenitic AISI 304 Precipitation Hardening ASTM 630					
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
6.0	800	0.18	530	0.10	1100	0.18	2100	0.23
8.0	600	0.20	400	0.13	800	0.20	1600	0.28
10.0	480	0.22	310	0.15	650	0.22	1200	0.33
12.0	400	0.24	250	0.17	520	0.24	1000	0.38
15.0	320	0.26	170	0.20	420	0.26	850	0.42
20.0	240	0.28	130	0.23	320	0.28	630	0.45
25.0	190	0.32	100	0.24	250	0.32	500	0.48
30.0	160	0.35	85	0.25	210	0.35	400	0.50
40.0	120	0.38	65	0.28	160	0.38	300	0.52

Note 1) Please reduce the cutting conditions when drilling a deep hole.
Note 2) This table only shows standard cutting conditions with water-soluble cutting fluids. Please make corrections or adjustments depending on the application.
Note 3) High-speed drills have lower rigidity than long carbide drills, and to prevent problems due to drill deflection and bending, please use guide bushes and guide holes (about 1 to 2 DC).
Note 4) When using guide bushes, please select a drill so that the groove length > A dimension (shown below).

Guide bushing



Drilling a pilot hole

①Use a drill with a larger (flatter) point angle than the super long type. VAPDS is recommended.

②Ensure a high precision hole is drilled for the guide.

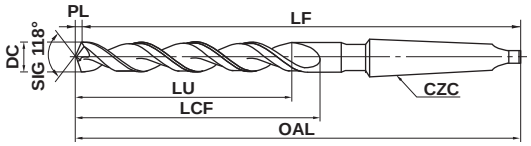
③Drill depth : Approx DC×1–2.

HSS

GWTS

TiN, For deep hole, Convolute flute

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

DC=6	6<DC≦10	10<DC≦18	18<DC≦30	30<DC≦32
0 −0.018	0 −0.022	0 −0.027	0 −0.033	0 −0.039

●Suitable for general and deep hole drilling.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GWTSD0600M1	6.0	69.8	149.8	148	1.8	MT.1	●
GWTSD0620M1	6.2	73.9	153.9	152	1.9	MT.1	●
GWTSD0650M1	6.5	74.0	154.0	152	2.0	MT.1	●
GWTSD0680M1	6.8	77.0	157.0	155	2.0	MT.1	●
GWTSD0690M1	6.9	77.1	157.1	155	2.1	MT.1	●
GWTSD0700M1	7.0	77.1	157.1	155	2.1	MT.1	●
GWTSD0720M1	7.2	80.2	160.2	158	2.2	MT.1	●
GWTSD0750M1	7.5	80.3	160.3	158	2.3	MT.1	●
GWTSD0780M1	7.8	84.3	164.3	162	2.3	MT.1	●
GWTSD0800M1	8.0	84.4	164.4	162	2.4	MT.1	●
GWTSD0820M1	8.2	87.5	170.5	168	2.5	MT.1	●
GWTSD0850M1	8.5	87.6	170.6	168	2.6	MT.1	●
GWTSD0880M1	8.8	90.6	174.6	172	2.6	MT.1	●
GWTSD0900M1	9.0	90.7	174.7	172	2.7	MT.1	●
GWTSD0920M1	9.2	94.8	177.8	175	2.8	MT.1	●
GWTSD0950M1	9.5	94.9	177.9	175	2.9	MT.1	●
GWTSD0980M1	9.8	97.9	180.9	178	2.9	MT.1	●
GWTSD1000M1	10.0	98.0	181.0	178	3.0	MT.1	●
GWTSD1020M1	10.2	101.1	185.1	182	3.1	MT.1	●
GWTSD1030M1	10.3	101.1	185.1	182	3.1	MT.1	●
GWTSD1050M1	10.5	101.2	185.2	182	3.2	MT.1	●
GWTSD1100M1	11.0	105.3	188.3	185	3.3	MT.1	●
GWTSD1150M1	11.5	108.5	191.5	188	3.5	MT.1	●
GWTSD1200M1	12.0	111.6	195.6	192	3.6	MT.1	●
GWTSD1220M2	12.2	115.7	215.7	212	3.7	MT.2	●
GWTSD1230M2	12.3	115.7	215.7	212	3.7	MT.2	●
GWTSD1250M2	12.5	115.8	215.8	212	3.8	MT.2	●
GWTSD1300M2	13.0	118.9	218.9	215	3.9	MT.2	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GWTSD1350M2	13.5	122.1	222.1	218	4.1	MT.2	●
GWTSD1400M2	14.0	126.2	226.2	222	4.2	MT.2	●
GWTSD1410M2	14.1	126.2	226.2	222	4.2	MT.2	●
GWTSD1420M2	14.2	126.3	226.3	222	4.3	MT.2	●
GWTSD1450M2	14.5	126.4	226.4	222	4.4	MT.2	●
GWTSD1500M2	15.0	129.5	229.5	225	4.5	MT.2	●
GWTSD1550M2	15.5	132.7	232.7	228	4.7	MT.2	●
GWTSD1600M2	16.0	134.8	234.8	230	4.8	MT.2	●
GWTSD1650M2	16.5	137.0	237.0	232	5.0	MT.2	●
GWTSD1700M2	17.0	140.1	240.1	235	5.1	MT.2	●
GWTSD1750M2	17.5	145.3	245.3	240	5.3	MT.2	●
GWTSD1800M2	18.0	145.4	245.4	240	5.4	MT.2	●
GWTSD1850M2	18.5	150.6	250.6	245	5.6	MT.2	●
GWTSD1900M2	19.0	150.7	250.7	245	5.7	MT.2	●
GWTSD1950M2	19.5	155.9	255.9	250	5.9	MT.2	●
GWTSD2000M2	20.0	156.0	256.0	250	6.0	MT.2	●
GWTSD2100M3	21.0	161.3	281.3	275	6.3	MT.3	●
GWTSD2200M3	22.0	166.6	286.6	280	6.6	MT.3	●
GWTSD2300M3	23.0	171.9	291.9	285	6.9	MT.3	●
GWTSD2400M3	24.0	172.2	292.2	285	7.2	MT.3	●
GWTSD2500M3	25.0	172.5	292.5	285	7.5	MT.3	●
GWTSD2600M3	26.0	172.8	292.8	285	7.8	MT.3	●
GWTSD2700M3	27.0	178.1	298.1	290	8.1	MT.3	●
GWTSD2800M4	28.0	183.4	328.4	320	8.4	MT.4	●
GWTSD2900M4	29.0	188.7	333.7	325	8.7	MT.4	●
GWTSD3000M4	30.0	194.0	339.0	330	9.0	MT.4	●
GWTSD3100M4	31.0	199.3	344.3	335	9.3	MT.4	●
GWTSD3200M4	32.0	204.6	349.6	340	9.6	MT.4	●

P

DRILLING

● : Inventory maintained in Japan.

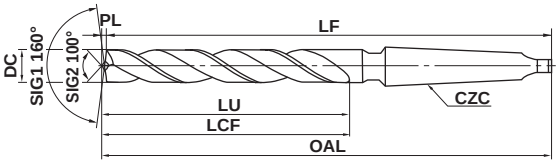
CUTTING CONDITIONS ➤ P208

GTTD

TiN, For steel frame

P M K N S H

Steel



*LU = LCF-2DC

17≤DC≤18	18<DC≤30	30<DC≤32
0 −0.027	0 −0.033	0 −0.039

●Special point geometry for minimal through hole burrs.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GTTDD1700M3	17.0	135	257.9	255	2.9	MT.3	●
GTTDD1750M3	17.5	140	263.0	260	3.0	MT.3	●
GTTDD1800M3	18.0	140	263.0	260	3.0	MT.3	●
GTTDD1900M3	19.0	145	268.2	265	3.2	MT.3	●
GTTDD2000M3	20.0	150	273.3	270	3.3	MT.3	●
GTTDD2150M3	21.5	160	283.6	280	3.6	MT.3	●
GTTDD2200M3	22.0	160	283.7	280	3.7	MT.3	●
GTTDD2250M3	22.5	165	288.8	285	3.8	MT.3	●
GTTDD2300M3	23.0	165	288.8	285	3.8	MT.3	●
GTTDD2350M3	23.5	165	289.0	285	4.0	MT.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
GTTDD2400M3	24.0	165	289.0	285	4.0	MT.3	●
GTTDD2450M3	24.5	165	289.1	285	4.1	MT.3	●
GTTDD2500M3	25.0	165	289.1	285	4.1	MT.3	●
GTTDD2600M3	26.0	165	289.3	285	4.3	MT.3	●
GTTDD2650M3	26.5	170	294.4	290	4.4	MT.3	●
GTTDD2800M4	28.0	175	324.5	320	4.5	MT.4	●
GTTDD3200M4	32.0	195	345.0	340	5.0	MT.4	●

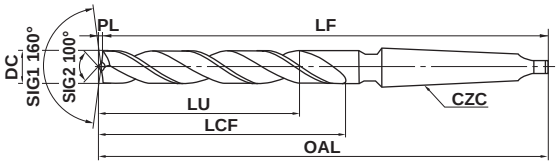
CUTTING CONDITIONS ➢ P208
TECHNICAL DATA ➢ R001

TTD

For steel frame

P M K N S H

Steel



*LU = LCF-2DC

17≤DC≤18	18<DC≤30	30<DC≤32
0 −0.027	0 −0.033	0 −0.039

●Special point geometry for minimal through hole burrs.

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TTDD1700M3	17.0	135	257.9	255	2.9	MT.3	●
TTDD1750M3	17.5	140	263.0	260	3.0	MT.3	●
TTDD1800M3	18.0	140	263.0	260	3.0	MT.3	●
TTDD1900M3	19.0	145	268.2	265	3.2	MT.3	●
TTDD2000M3	20.0	150	273.3	270	3.3	MT.3	●
TTDD2150M3	21.5	160	283.6	280	3.6	MT.3	●
TTDD2200M3	22.0	160	283.7	280	3.7	MT.3	●
TTDD2250M3	22.5	165	288.8	285	3.8	MT.3	●
TTDD2300M3	23.0	165	288.8	285	3.8	MT.3	●
TTDD2350M3	23.5	165	289.0	285	4.0	MT.3	●

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	CZC	
TTDD2400M3	24.0	165	289.0	285	4.0	MT.3	●
TTDD2450M3	24.5	165	289.1	285	4.1	MT.3	●
TTDD2500M3	25.0	165	289.1	285	4.1	MT.3	●
TTDD2600M3	26.0	165	289.3	285	4.3	MT.3	●
TTDD2650M3	26.5	170	294.4	290	4.4	MT.3	●
TTDD2800M4	28.0	175	324.5	320	4.5	MT.4	●
TTDD3200M4	32.0	195	345.0	340	5.0	MT.4	●

● : Inventory maintained in Japan.

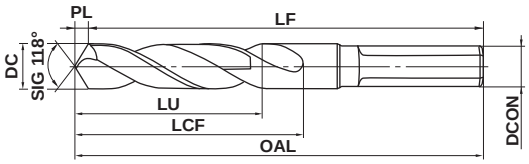
CUTTING CONDITIONS ➢ P209
TECHNICAL DATA ➢ R001

3KD

Triangular shank (Type 6.5)(Type 10)(Type 13)

HSS

P	M	K	N	S	H
Steel		Cast Iron	Non-ferrous Metal		



*LU = LCF-2DC

7≤DC≤10	10<DC≤18	18<DC≤26
0 −0.022	0 −0.027	0 −0.033

●3 shank types for portable power tools.

Type 6.5

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
3KD6D0700	7.0	37.1	77.1	75	2.1	6.5	●
3KD6D0750	7.5	37.3	77.3	75	2.3	6.5	●
3KD6D0800	8.0	37.4	77.4	75	2.4	6.5	●
3KD6D0850	8.5	37.6	77.6	75	2.6	6.5	●
3KD6D0900	9.0	37.7	77.7	75	2.7	6.5	●
3KD6D0950	9.5	37.9	77.9	75	2.9	6.5	●
3KD6D1000	10.0	53.0	93.0	90	3.0	6.5	●
3KD6D1050	10.5	53.2	93.2	90	3.2	6.5	●
3KD6D1100	11.0	53.3	93.3	90	3.3	6.5	●
3KD6D1150	11.5	53.5	93.5	90	3.5	6.5	●
3KD6D1200	12.0	53.6	93.6	90	3.6	6.5	●
3KD6D1250	12.5	53.8	93.8	90	3.8	6.5	●
3KD6D1300	13.0	53.9	93.9	90	3.9	6.5	●

Type 10

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
3KD10D1000	10.0	53.0	93.0	90	3.0	10	●
3KD10D1050	10.5	53.2	93.2	90	3.2	10	●
3KD10D1100	11.0	53.3	93.3	90	3.3	10	●
3KD10D1150	11.5	53.5	93.5	90	3.5	10	●
3KD10D1200	12.0	53.6	93.6	90	3.6	10	●
3KD10D1250	12.5	53.8	93.8	90	3.8	10	●
3KD10D1300	13.0	53.9	93.9	90	3.9	10	●
3KD10D1350	13.5	89.1	144.1	140	4.1	10	●
3KD10D1400	14.0	89.2	144.2	140	4.2	10	●
3KD10D1450	14.5	89.4	144.4	140	4.4	10	●
3KD10D1500	15.0	89.5	144.5	140	4.5	10	●
3KD10D1550	15.5	89.7	144.7	140	4.7	10	●
3KD10D1600	16.0	89.8	144.8	140	4.8	10	●

Type 13

Order Number	Dimensions (mm)						Stock
	DC	LCF	OAL	LF	PL	DCON	
3KD13D1350	13.5	89.1	144.1	140	4.1	13	●
3KD13D1400	14.0	89.2	144.2	140	4.2	13	●
3KD13D1450	14.5	89.4	144.4	140	4.4	13	●
3KD13D1500	15.0	89.5	144.5	140	4.5	13	●
3KD13D1550	15.5	89.7	144.7	140	4.7	13	●
3KD13D1600	16.0	89.8	144.8	140	4.8	13	●
3KD13D1650	16.5	90.0	145.0	140	5.0	13	●
3KD13D1700	17.0	90.1	145.1	140	5.1	13	●
3KD13D1750	17.5	90.3	145.3	140	5.3	13	●
3KD13D1800	18.0	90.4	145.4	140	5.4	13	●
3KD13D1850	18.5	90.6	145.6	140	5.6	13	●
3KD13D1900	19.0	90.7	145.7	140	5.7	13	●
3KD13D1950	19.5	90.9	145.9	140	5.9	13	●
3KD13D2000	20.0	91.0	146.0	140	6.0	13	●
3KD13D2050	20.5	91.2	146.2	140	6.2	13	●
3KD13D2100	21.0	91.3	146.3	140	6.3	13	●
3KD13D2150	21.5	91.5	146.5	140	6.5	13	●
3KD13D2200	22.0	91.6	146.6	140	6.6	13	●
3KD13D2250	22.5	91.8	146.8	140	6.8	13	●
3KD13D2300	23.0	91.9	146.9	140	6.9	13	●
3KD13D2350	23.5	92.1	147.1	140	7.1	13	●
3KD13D2400	24.0	92.2	147.2	140	7.2	13	●
3KD13D2450	24.5	92.4	147.4	140	7.4	13	●
3KD13D2500	25.0	92.5	147.5	140	7.5	13	●
3KD13D2550	25.5	92.7	147.7	140	7.7	13	●
3KD13D2600	26.0	92.8	147.8	140	7.8	13	●

GSD GWSS GTD GWTS GTTD

TiN coated drills

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel SS Carbon Steel S-C (−25HRC)		Alloy Steel SCM Tool Steel SK (−35HRC)		Alloy Steel SCM Die Steel SKD (−40HRC)		Cast Iron FC	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	8000	0.01	7000	0.008	6000	0.005	8000	0.01
1.0	6000	0.02	5500	0.01	4500	0.008	6000	0.02
2.0	4700	0.05	3600	0.03	2400	0.02	4700	0.05
3.0	3200	0.10	2400	0.08	1800	0.05	3500	0.10
6.0	1600	0.18	1200	0.15	900	0.13	1750	0.18
8.0	1200	0.20	900	0.18	680	0.15	1300	0.20
10.0	960	0.22	720	0.20	550	0.18	1100	0.22
12.0	800	0.24	600	0.22	450	0.20	880	0.24
15.0	630	0.28	480	0.24	350	0.22	700	0.28
20.0	470	0.33	360	0.26	260	0.24	530	0.33
25.0	380	0.36	290	0.28	210	0.26	420	0.36
30.0	310	0.40	240	0.30	180	0.28	330	0.40

Work Material	Stainless Steel				Copper Alloy, Brass		Aluminium Alloy	
	Martensitic Ferritic AISI 430		Austenitic AISI 304 Precipitation Hardening ASTM 630					
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	8000	0.01	6000	0.01	8000	0.01	10000	0.02
1.0	5000	0.02	4000	0.02	6000	0.02	7000	0.04
2.0	2500	0.05	2300	0.04	4700	0.05	6000	0.08
3.0	1900	0.10	1500	0.07	3200	0.10	5500	0.13
6.0	950	0.18	750	0.10	1600	0.18	3100	0.23
8.0	700	0.20	530	0.13	1200	0.20	2300	0.28
10.0	560	0.22	420	0.15	960	0.22	1900	0.33
12.0	460	0.24	340	0.17	800	0.24	1600	0.38
15.0	360	0.26	270	0.20	630	0.26	1300	0.42
20.0	270	0.28	200	0.23	470	0.28	950	0.45
25.0	210	0.32	160	0.24	380	0.32	750	0.48
30.0	180	0.35	135	0.25	310	0.35	630	0.50

Note 1) Please reduce the cutting conditions when drilling a deep hole.
Note 2) This table only shows standard cutting conditions with water-soluble cutting fluids. Please make corrections or adjustments depending on the application.

Reduction rate of cutting conditions for hole drilling

Drilling Depth	Reduction Rate of Cutting Speed	Reduction Rate of Feed
4DC	10%	10%
5DC	10%	15%
6DC	20%	20%
7DC	20%	20%

Drilling Depth	Reduction Rate of Cutting Speed	Reduction Rate of Feed
8DC	30%	20%
10DC	30%	25%
15DC	40%	30%
20DC	40%	45%

DC : Drill dia.

SD KSD TD KTD TTD

Standard drills

RECOMMENDED CUTTING CONDITIONS

Work Material	Structural Steel SS Carbon Steel S-C (−25HRC)		Alloy Steel SCM Tool Steel SK (−35HRC)		Alloy Steel SCM Die Steel SKD (−40HRC)		Cast Iron FC	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	6000	0.01	5000	0.008	4000	0.005	6000	0.01
1.0	5000	0.02	4000	0.01	2800	0.008	5000	0.02
2.0	3000	0.05	2500	0.03	1800	0.02	3000	0.05
3.0	2100	0.10	1800	0.08	1200	0.05	2300	0.10
6.0	1100	0.18	900	0.15	600	0.13	1100	0.18
8.0	800	0.20	670	0.18	450	0.15	900	0.20
10.0	650	0.22	540	0.20	350	0.18	700	0.22
12.0	520	0.24	450	0.22	300	0.20	600	0.24
15.0	420	0.28	360	0.24	240	0.22	470	0.28
20.0	320	0.33	270	0.26	180	0.24	350	0.33
25.0	250	0.36	210	0.28	145	0.26	280	0.36
30.0	210	0.40	180	0.30	120	0.28	230	0.40
40.0	160	0.42	130	0.32	90	0.30	180	0.42

Work Material	Stainless Steel				Copper Alloy, Brass		Aluminium Alloy	
	Martensitic Ferritic AISI 430		Austenitic AISI 304 Precipitation Hardening ASTM 630					
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)	Revolution (min^{-1})	Feed rate (mm/rev)
0.5	5000	0.01	4000	0.01	6000	0.01	10000	0.02
1.0	4000	0.02	3000	0.02	5000	0.02	7000	0.04
2.0	2200	0.05	1500	0.04	3000	0.05	5000	0.08
3.0	1600	0.10	1000	0.07	2100	0.10	4200	0.13
6.0	800	0.18	530	0.10	1100	0.18	2100	0.23
8.0	600	0.20	400	0.13	800	0.20	1600	0.28
10.0	480	0.22	310	0.15	650	0.22	1200	0.33
12.0	400	0.24	250	0.17	520	0.24	1000	0.38
15.0	320	0.26	170	0.20	420	0.26	850	0.42
20.0	240	0.28	130	0.23	320	0.28	630	0.45
25.0	190	0.32	100	0.24	250	0.32	500	0.48
30.0	160	0.35	85	0.25	210	0.35	400	0.50
40.0	120	0.38	65	0.28	160	0.38	300	0.52

Note 1) Please reduce the cutting conditions when drilling a deep hole.
Note 2) This table only shows standard cutting conditions with water-soluble cutting fluids. Please make corrections or adjustments depending on the application.

Reduction rate of cutting conditions for hole drilling

Drilling Depth	Reduction Rate of Cutting Speed	Reduction Rate of Feed
4DC	10%	10%
5DC	10%	15%
6DC	20%	20%
7DC	20%	20%

Drilling Depth	Reduction Rate of Cutting Speed	Reduction Rate of Feed
8DC	30%	20%
10DC	30%	25%
15DC	40%	30%
20DC	40%	45%

DC : Drill dia.

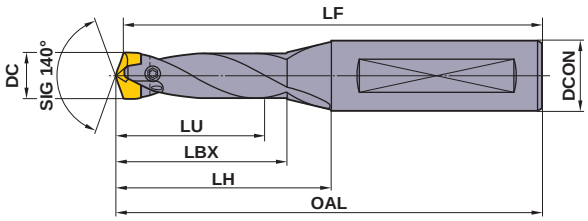
STAW

Small Diameter Indexable Drill

- Wavy cutting edge design for good chip control.
- Highly rigid clamping system offers stability and reliability for small hole drilling.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			



HOLDERS

DC (mm)	Hole Depth (L/D)	Holder Order Number	Stock	LU	LBX	LH	OAL	LF	DCON	F Wrench	Insert DC (mm)	Insert Order Number	VP15TF	VP10H	DP5010
10.0 – 10.4	1.5	STAWSS1000S16	●	16.8	23.8	33.8	81.8	80	16	TIP06F	10.0	* STAWN1000TH	●	□	
												STAWK1000TG			●
	3	STAWSN1000S16	●	31.8	38.8	48.8	96.8	95	16	TIP06F	10.1	STAWN1010TH	●	□	
												STAWK1010TG			●
	5	STAWMN1000S16	●	51.8	58.8	68.8	116.8	115	16	TIP06F	10.2	STAWN1020TH	●	□	
												STAWK1020TG			●
	8	STAWLN1000S16	●	81.8	88.8	98.8	146.8	145	16	TIP06F	10.3	STAWN1030TH	●	□	
												STAWK1030TG			●
											10.4	STAWN1040TH	●	□	
												STAWK1040TG			●
10.5 – 10.9	1.5	STAWSS1050S16	●	17.7	23.9	33.9	81.9	80	16	TIP06F	10.5	* STAWN1050TH	●	□	
												STAWK1050TG			●
	3	STAWSN1050S16	●	33.4	38.9	48.9	96.9	95	16	TIP06F	10.6	STAWN1060TH	●	□	
												STAWK1060TG			●
	5	STAWMN1050S16	●	54.4	58.9	68.9	116.9	115	16	TIP06F	10.7	STAWN1070TH	●	□	
												STAWK1070TG			●
											10.8	STAWN1080TH	●	□	
												STAWK1080TG			●
	8	STAWLN1050S16	●	85.9	88.9	98.9	146.9	145	16	TIP06F	10.9	STAWN1090TH	●	□	
												STAWK1090TG			●
11.0 – 11.4	1.5	STAWSS1100S16	●	18.5	27.0	38.0	86.0	84	16	TIP06F	11.0	* STAWN1100TH	●	□	
												STAWK1100TG			●
	3	STAWSN1100S16	●	35.0	43.0	54.0	102.0	100	16	TIP06F	11.1	STAWN1110TH	●	□	
												STAWK1110TG			●
	5	STAWMN1100S16	●	57.0	68.0	79.0	127.0	125	16	TIP06F	11.2	STAWN1120TH	●	□	
												STAWK1120TG			●
											11.3	STAWN1130TH	●	□	
												STAWK1130TG			●
	8	STAWLN1100S16	●	90.0	98.0	109.0	157.0	155	16	TIP06F	11.4	STAWN1140TH	●	□	
												STAWK1140TG			●
11.5 – 11.9	1.5	STAWSS1150S16	●	19.4	27.1	38.1	86.1	84	16	TIP06F	11.5	* STAWN1150TH	●	□	
												STAWK1150TG			●
	3	STAWSN1150S16	●	36.6	43.1	54.1	102.1	100	16	TIP06F	11.6	STAWN1160TH	●	□	
												STAWK1160TG			●
	5	STAWMN1150S16	●	59.6	68.1	79.1	127.1	125	16	TIP06F	11.7	STAWN1170TH	●	□	
												STAWK1170TG			●
											11.8	STAWN1180TH	●	□	
												STAWK1180TG			●
	8	STAWLN1150S16	●	94.1	98.1	109.1	157.1	155	16	TIP06F	11.9	STAWN1190TH	●	□	
												STAWK1190TG			●
12.0 – 12.4	1.5	STAWSS1200S16	●	20.2	29.2	41.2	89.2	87	16	TIP06F	12.0	* STAWN1200TH	●	□	
												STAWK1200TG			●
	3	STAWSN1200S16	●	38.2	47.2	59.2	107.2	105	16	TIP06F	12.1	STAWN1210TH	●	□	
												STAWK1210TG			●
	5	STAWMN1200S16	●	62.2	72.2	84.2	132.2	130	16	TIP06F	12.2	STAWN1220TH	●	□	
												STAWK1220TG			●
											12.3	STAWN1230TH	●	□	
												STAWK1230TG			●
	8	STAWLN1200S16	●	98.2	107.2	119.2	167.2	165	16	TIP06F	12.4	STAWN1240TH	●	□	
												STAWK1240TG			●

Note 1) The above dimensions (*) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	Holder Order Number	Stock	LU	LBX	LH	OAL	LF	DCON	Wrench (F / W)	DC (mm)	Insert Order Number	VP15TF	VP10H	DP5010
12.5 – 12.9	1.5	STAWSS1250S16	●	21.1	29.3	41.3	89.3	87	16	TIP06F	12.5	* STAWN1250TH	●	□	
												STAWK1250TG			●
	3	STAWSN1250S16	●	39.8	47.3	59.3	107.3	105	16	TIP06F	12.6	STAWN1260TH	●	□	
												STAWK1260TG			●
	5	STAWMN1250S16	●	64.8	72.3	84.3	132.3	130	16	TIP06F	12.7	STAWN1270TH	●	□	
												STAWK1270TG			●
	8	STAWLN1250S16	●	102.3	107.3	119.3	167.3	165	16	TIP06F	12.8	STAWN1280TH	●	□	
												STAWK1280TG			●
											12.9	STAWN1290TH	●	□	
												STAWK1290TG			●
13.0 – 13.4	1.5	STAWSS1300S16	●	21.9	32.4	45.4	93.4	91	16	TIP08W	13.0	* STAWN1300TH	●	□	
												STAWK1300TG			●
	3	STAWSN1300S16	●	41.4	51.4	64.4	112.4	110	16	TIP08W	13.1	STAWN1310TH	●	□	
												STAWK1310TG			●
	5	STAWMN1300S16	●	67.4	76.4	89.4	137.4	135	16	TIP08W	13.2	STAWN1320TH	●	□	
												STAWK1320TG			●
											13.3	STAWN1330TH	●	□	
												STAWK1330TG			●
	8	STAWLN1300S16	●	106.4	116.4	129.4	177.4	175	16	TIP08W	13.4	STAWN1340TH	●	□	
												STAWK1340TG			●
13.5 – 13.9	1.5	STAWSS1350S16	●	22.8	32.5	45.5	93.5	91	16	TIP08W	13.5	* STAWN1350TH	●	□	
												STAWK1350TG			●
	3	STAWSN1350S16	●	43.0	51.5	64.5	112.5	110	16	TIP08W	13.6	STAWN1360TH	●	□	
												STAWK1360TG			●
	5	STAWMN1350S16	●	70.0	76.5	89.5	137.5	135	16	TIP08W	13.7	STAWN1370TH	●	□	
												STAWK1370TG			●
											13.8	STAWN1380TH	●	□	
												STAWK1380TG			●
	8	STAWLN1350S16	●	110.5	116.5	129.5	177.5	175	16	TIP08W	13.9	STAWN1390TH	●	□	
												STAWK1390TG			●
14.0 – 14.4	1.5	STAWSS1400S16	●	23.5	33.5	47.5	95.5	93	16	TIP08W	14.0	* STAWN1400TH	●		
												STAWK1400TG			●
	3	STAWSN1400S16	●	44.5	55.5	69.5	117.5	115	16	TIP08W	14.1	STAWN1410TH	●		
												STAWK1410TG			●
	5	STAWMN1400S16	●	72.5	85.5	99.5	147.5	145	16	TIP08W	14.2	STAWN1420TH	●		
												STAWK1420TG			●
											14.3	STAWN1430TH	●		
												STAWK1430TG			●
	8	STAWLN1400S16	●	114.5	124.5	139.5	187.5	185	16	TIP08W	14.4	STAWN1440TH	●		
												STAWK1440TG			●
14.5 – 14.9	1.5	STAWSS1450S16	●	24.4	33.6	47.6	95.6	93	16	TIP08W	14.5	* STAWN1450TH	●		
												STAWK1450TG			●
	3	STAWSN1450S16	●	46.1	55.6	69.6	117.6	115	16	TIP08W	14.6	STAWN1460TH	●		
												STAWK1460TG			●
	5	STAWMN1450S16	●	75.1	85.6	99.6	147.6	145	16	TIP08W	14.7	STAWN1470TH	●		
												STAWK1470TG			●
											14.8	STAWN1480TH	●		
												STAWK1480TG			●
	8	STAWLN1450S16	●	118.6	124.6	139.6	187.6	185	16	TIP08W	14.9	STAWN1490TH	●		
												STAWK1490TG			●
15.0 – 15.4	1.5	STAWSS1500S20	●	25.2	35.7	50.7	100.7	98	20	TIP08W	15.0	* STAWN1500TH	●		
												STAWK1500TG			●
	3	STAWSN1500S20	●	47.7	62.7	77.7	127.7	125	20	TIP08W	15.1	STAWN1510TH	●		
												STAWK1510TG			●
	5	STAWMN1500S20	●	77.7	92.7	107.7	157.7	155	20	TIP08W	15.2	STAWN1520TH	●		
												STAWK1520TG			●
											15.3	STAWN1530TH	●		
												STAWK1530TG			●
	8	STAWLN1500S20	●	122.7	132.7	150.7	200.7	198	20	TIP08W	15.4	STAWN1540TH	●		
												STAWK1540TG			●

INSERT DESCRIPTION ➤ P213
CUTTING CONDITIONS ➤ P217
USAGE NOTE ➤ P218
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

STAW

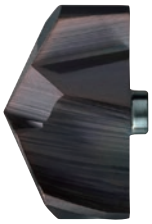
Small Diameter Indexable Drill

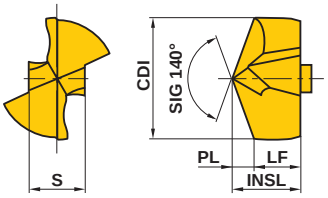
DC (mm)	Hole Depth (L/D)	Holder Order Number	Holder Stock	LU	LBX	LH	OAL	LF	DCON	W Wrench	Insert DC (mm)	Insert Order Number	Stock VP15TF	Stock VP10H	Stock DP5010
15.5 – 16.4	1.5	STAWSS1600S20	●	26.1	36.8	52.8	102.8	100	20	TIP10W	15.5	* STAWN1550T	●		
												STAWK1550TG			●
											15.6	STAWN1560T	●		
												STAWK1560TG			●
											15.7	STAWN1570T	●		
												STAWK1570TG			●
	3	STAWSN1600S20	●	49.3	62.8	82.8	132.8	130	20	TIP10W	15.8	STAWN1580T	●		
												STAWK1580TG			●
											15.9	STAWN1590T	●		
												STAWK1590TG			●
	5	STAWMN1600S20	●	80.3	92.8	117.8	167.8	165	20	TIP10W	16.0	STAWN1600T	●		
												STAWK1600TG			●
											16.1	STAWN1610T	●		
												STAWK1610TG			●
											16.2	STAWN1620T	●		
												STAWK1620TG			●
	8	STAWLN1600S20	●	126.8	140.8	160.8	210.8	208	20	TIP10W	16.3	STAWN1630T	●		
												STAWK1630TG			●
											16.4	STAWN1640T	●		
												STAWK1640TG			●
16.5 – 17.4	1.5	STAWSS1700S20	●	27.8	39.0	56.0	106.0	103	20	TIP10W	16.5	* STAWN1650T	●		
												STAWK1650TG			●
											16.6	STAWN1660T	●		
												STAWK1660TG			●
											16.7	STAWN1670T	●		
												STAWK1670TG			●
	3	STAWSN1700S20	●	52.5	64.0	88.0	138.0	135	20	TIP10W	16.8	STAWN1680T	●		
												STAWK1680TG			●
											16.9	STAWN1690T	●		
												STAWK1690TG			●
	5	STAWMN1700S20	●	85.5	98.0	123.0	173.0	170	20	TIP10W	17.0	STAWN1700T	●		
												STAWK1700TG			●
											17.1	STAWN1710T	●		
												STAWK1710TG			●
											17.2	STAWN1720T	●		
												STAWK1720TG			●
	8	STAWLN1700S20	●	135.0	149.0	169.0	219.0	216	20	TIP10W	17.3	STAWN1730T	●		
												STAWK1730TG			●
											17.4	STAWN1740T	●		
												STAWK1740TG			●
17.5 – 18.4	1.5	STAWSS1800S20	●	29.5	40.2	58.2	108.2	105	20	TIP10W	17.5	* STAWN1750T	●		
												STAWK1750TG			●
											17.6	STAWN1760T	●		
												STAWK1760TG			●
											17.7	STAWN1770T	●		
												STAWK1770TG			●
	3	STAWSN1800S20	●	55.7	67.2	93.2	143.2	140	20	TIP10W	17.8	STAWN1780T	●		
												STAWK1780TG			●
											17.9	STAWN1790T	●		
												STAWK1790TG			●
	5	STAWMN1800S20	●	90.7	103.2	128.2	178.2	175	20	TIP10W	18.0	STAWN1800T	●		
												STAWK1800TG			●
											18.1	STAWN1810T	●		
												STAWK1810TG			●
											18.2	STAWN1820T	●		
												STAWK1820TG			●
	8	STAWLN1800S20	●	143.2	157.2	177.2	227.2	224	20	TIP10W	18.3	STAWN1830T	●		
												STAWK1830TG			●
											18.4	STAWN1840T	●		
												STAWK1840TG			●

Note 1) The above dimensions (*) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

INSERTS





Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
STAWN1000TH	●	□	10.0	5.6	3.8	1.8	4.6	STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16
STAWN1010TH	●	□	10.1	5.6	3.8	1.8	4.6	
STAWN1020TH	●	□	10.2	5.7	3.8	1.9	4.6	
STAWN1030TH	●	□	10.3	5.7	3.8	1.9	4.6	
STAWN1040TH	●	□	10.4	5.7	3.8	1.9	4.6	
STAWN1050TH	●	□	10.5	5.9	4.0	1.9	4.8	STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16
STAWN1060TH	●	□	10.6	5.9	4.0	1.9	4.8	
STAWN1070TH	●	□	10.7	5.9	4.0	1.9	4.8	
STAWN1080TH	●	□	10.8	6.0	4.0	2.0	4.8	
STAWN1090TH	●	□	10.9	6.0	4.0	2.0	4.8	
STAWN1100TH	●	□	11.0	6.2	4.2	2.0	5.1	STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16
STAWN1110TH	●	□	11.1	6.2	4.2	2.0	5.1	
STAWN1120TH	●	□	11.2	6.2	4.2	2.0	5.1	
STAWN1130TH	●	□	11.3	6.3	4.2	2.1	5.1	
STAWN1140TH	●	□	11.4	6.3	4.2	2.1	5.1	
STAWN1150TH	●	□	11.5	6.5	4.4	2.1	5.3	STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16
STAWN1160TH	●	□	11.6	6.5	4.4	2.1	5.3	
STAWN1170TH	●	□	11.7	6.5	4.4	2.1	5.3	
STAWN1180TH	●	□	11.8	6.5	4.4	2.1	5.3	
STAWN1190TH	●	□	11.9	6.6	4.4	2.2	5.3	
STAWN1200TH	●	□	12.0	6.8	4.6	2.2	5.5	STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16
STAWN1210TH	●	□	12.1	6.8	4.6	2.2	5.5	
STAWN1220TH	●	□	12.2	6.8	4.6	2.2	5.5	
STAWN1230TH	●	□	12.3	6.8	4.6	2.2	5.5	
STAWN1240TH	●	□	12.4	6.9	4.6	2.3	5.5	
STAWN1250TH	●	□	12.5	7.1	4.8	2.3	5.8	STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16
STAWN1260TH	●	□	12.6	7.1	4.8	2.3	5.8	
STAWN1270TH	●	□	12.7	7.1	4.8	2.3	5.8	
STAWN1280TH	●	□	12.8	7.1	4.8	2.3	5.8	
STAWN1290TH	●	□	12.9	7.1	4.8	2.3	5.8	
STAWN1300TH	●	□	13.0	7.3	4.9	2.4	6.0	STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16
STAWN1310TH	●	□	13.1	7.3	4.9	2.4	6.0	
STAWN1320TH	●	□	13.2	7.3	4.9	2.4	6.0	
STAWN1330TH	●	□	13.3	7.3	4.9	2.4	6.0	
STAWN1340TH	●	□	13.4	7.3	4.9	2.4	6.0	
STAWN1350TH	●	□	13.5	7.6	5.1	2.5	6.2	STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16
STAWN1360TH	●	□	13.6	7.6	5.1	2.5	6.2	
STAWN1370TH	●	□	13.7	7.6	5.1	2.5	6.2	
STAWN1380TH	●	□	13.8	7.6	5.1	2.5	6.2	
STAWN1390TH	●	□	13.9	7.6	5.1	2.5	6.2	
STAWN1400TH	●		14.0	7.8	5.3	2.5	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
STAWN1410TH	●		14.1	7.9	5.3	2.6	6.4	
STAWN1420TH	●		14.2	7.9	5.3	2.6	6.4	
STAWN1430TH	●		14.3	7.9	5.3	2.6	6.4	
STAWN1440TH	●		14.4	7.9	5.3	2.6	6.4	

CUTTING CONDITIONS ➤ P217
USAGE NOTE ➤ P218
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

STAW

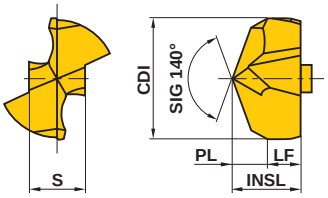
Small Diameter Indexable Drill

Order Number	Coated		Dimensions (mm)					Applicable Holder
	VP15TF	VP10H	CDI	INSL	LF	PL	S	
STAWN1450TH	●		14.5	8.1	5.5	2.6	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
STAWN1460TH	●		14.6	8.2	5.5	2.7	6.7	
STAWN1470TH	●		14.7	8.2	5.5	2.7	6.7	
STAWN1480TH	●		14.8	8.2	5.5	2.7	6.7	
STAWN1490TH	●		14.9	8.2	5.5	2.7	6.7	
STAWN1500TH	●		15.0	8.4	5.7	2.7	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
STAWN1510TH	●		15.1	8.4	5.7	2.7	6.9	
STAWN1520TH	●		15.2	8.5	5.7	2.8	6.9	
STAWN1530TH	●		15.3	8.5	5.7	2.8	6.9	
STAWN1540TH	●		15.4	8.5	5.7	2.8	6.9	
STAWN1550T	●		15.5	8.7	5.9	2.8	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
STAWN1560T	●		15.6	8.7	5.9	2.8	7.1	
STAWN1570T	●		15.7	8.8	5.9	2.9	7.1	
STAWN1580T	●		15.8	8.8	5.9	2.9	7.1	
STAWN1590T	●		15.9	8.8	5.9	2.9	7.1	
STAWN1600T	●		16.0	8.8	5.9	2.9	7.1	
STAWN1610T	●		16.1	8.8	5.9	2.9	7.1	
STAWN1620T	●		16.2	8.8	5.9	2.9	7.1	
STAWN1630T	●		16.3	8.9	5.9	3.0	7.1	
STAWN1640T	●		16.4	8.9	5.9	3.0	7.1	
STAWN1650T	●		16.5	9.3	6.3	3.0	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
STAWN1660T	●		16.6	9.3	6.3	3.0	7.6	
STAWN1670T	●		16.7	9.3	6.3	3.0	7.6	
STAWN1680T	●		16.8	9.4	6.3	3.1	7.6	
STAWN1690T	●		16.9	9.4	6.3	3.1	7.6	
STAWN1700T	●		17.0	9.4	6.3	3.1	7.6	
STAWN1710T	●		17.1	9.4	6.3	3.1	7.6	
STAWN1720T	●		17.2	9.4	6.3	3.1	7.6	
STAWN1730T	●		17.3	9.4	6.3	3.1	7.6	
STAWN1740T	●		17.4	9.5	6.3	3.2	7.6	
STAWN1750T	●		17.5	9.9	6.7	3.2	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
STAWN1760T	●		17.6	9.9	6.7	3.2	8.1	
STAWN1770T	●		17.7	9.9	6.7	3.2	8.1	
STAWN1780T	●		17.8	9.9	6.7	3.2	8.1	
STAWN1790T	●		17.9	10.0	6.7	3.3	8.1	
STAWN1800T	●		18.0	10.0	6.7	3.3	8.1	
STAWN1810T	●		18.1	10.0	6.7	3.3	8.1	
STAWN1820T	●		18.2	10.0	6.7	3.3	8.1	
STAWN1830T	●		18.3	10.0	6.7	3.3	8.1	
STAWN1840T	●		18.4	10.0	6.7	3.3	8.1	

● : Inventory maintained in Japan.
(1 insert in one case)

INSERTS

(Cast Iron)



Order Number	Coated DP5010		Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
STAWK1000TG	●		10.0	5.6	3.3	2.3	4.6	STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16
STAWK1010TG	●		10.1	5.6	3.3	2.3	4.6	
STAWK1020TG	●		10.2	5.6	3.3	2.3	4.6	
STAWK1030TG	●		10.3	5.7	3.3	2.4	4.6	
STAWK1040TG	●		10.4	5.7	3.3	2.4	4.6	
STAWK1050TG	●		10.5	5.9	3.5	2.4	4.8	STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16
STAWK1060TG	●		10.6	5.9	3.5	2.4	4.8	
STAWK1070TG	●		10.7	5.9	3.5	2.4	4.8	
STAWK1080TG	●		10.8	5.9	3.5	2.4	4.8	
STAWK1090TG	●		10.9	6.0	3.5	2.5	4.8	
STAWK1100TG	●		11.0	6.2	3.7	2.5	5.1	STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16
STAWK1110TG	●		11.1	6.2	3.7	2.5	5.1	
STAWK1120TG	●		11.2	6.2	3.7	2.5	5.1	
STAWK1130TG	●		11.3	6.2	3.7	2.5	5.1	
STAWK1140TG	●		11.4	6.3	3.7	2.6	5.1	
STAWK1150TG	●		11.5	6.5	3.9	2.6	5.3	STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16
STAWK1160TG	●		11.6	6.5	3.9	2.6	5.3	
STAWK1170TG	●		11.7	6.5	3.9	2.6	5.3	
STAWK1180TG	●		11.8	6.5	3.9	2.6	5.3	
STAWK1190TG	●		11.9	6.5	3.9	2.6	5.3	
STAWK1200TG	●		12.0	6.8	4.1	2.7	5.5	STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16
STAWK1210TG	●		12.1	6.8	4.1	2.7	5.5	
STAWK1220TG	●		12.2	6.8	4.1	2.7	5.5	
STAWK1230TG	●		12.3	6.8	4.1	2.7	5.5	
STAWK1240TG	●		12.4	6.8	4.1	2.7	5.5	
STAWK1250TG	●		12.5	7.0	4.2	2.8	5.8	STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16
STAWK1260TG	●		12.6	7.0	4.2	2.8	5.8	
STAWK1270TG	●		12.7	7.0	4.2	2.8	5.8	
STAWK1280TG	●		12.8	7.0	4.2	2.8	5.8	
STAWK1290TG	●		12.9	7.0	4.2	2.8	5.8	
STAWK1300TG	●		13.0	7.2	4.4	2.8	6.0	STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16
STAWK1310TG	●		13.1	7.3	4.4	2.9	6.0	
STAWK1320TG	●		13.2	7.3	4.4	2.9	6.0	
STAWK1330TG	●		13.3	7.3	4.4	2.9	6.0	
STAWK1340TG	●		13.4	7.3	4.4	2.9	6.0	
STAWK1350TG	●		13.5	7.5	4.6	2.9	6.2	STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16
STAWK1360TG	●		13.6	7.6	4.6	3.0	6.2	
STAWK1370TG	●		13.7	7.6	4.6	3.0	6.2	
STAWK1380TG	●		13.8	7.6	4.6	3.0	6.2	
STAWK1390TG	●		13.9	7.6	4.6	3.0	6.2	

CUTTING CONDITIONS ➢ P217
USAGE NOTE ➢ P218
SPARE PARTS ➢ Q001
TECHNICAL DATA ➢ R001

STAW

Small Diameter Indexable Drill

Order Number	Coated		Dimensions (mm)					Applicable Holder
	DP5010		CDI	INSL	LF	PL	S	
STAWK1400TG	●		14.0	7.8	4.8	3.0	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
STAWK1410TG	●		14.1	7.8	4.8	3.0	6.4	
STAWK1420TG	●		14.2	7.9	4.8	3.1	6.4	
STAWK1430TG	●		14.3	7.9	4.8	3.1	6.4	
STAWK1440TG	●		14.4	7.9	4.8	3.1	6.4	
STAWK1450TG	●		14.5	8.1	5.0	3.1	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
STAWK1460TG	●		14.6	8.1	5.0	3.1	6.7	
STAWK1470TG	●		14.7	8.2	5.0	3.2	6.7	
STAWK1480TG	●		14.8	8.2	5.0	3.2	6.7	
STAWK1490TG	●		14.9	8.2	5.0	3.2	6.7	
STAWK1500TG	●		15.0	8.4	5.2	3.2	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
STAWK1510TG	●		15.1	8.4	5.2	3.2	6.9	
STAWK1520TG	●		15.2	8.4	5.2	3.2	6.9	
STAWK1530TG	●		15.3	8.5	5.2	3.3	6.9	
STAWK1540TG	●		15.4	8.5	5.2	3.3	6.9	
STAWK1550TG	●		15.5	8.7	5.3	3.4	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
STAWK1560TG	●		15.6	8.7	5.3	3.4	7.1	
STAWK1570TG	●		15.7	8.7	5.3	3.4	7.1	
STAWK1580TG	●		15.8	8.8	5.3	3.5	7.1	
STAWK1590TG	●		15.9	8.8	5.3	3.5	7.1	
STAWK1600TG	●		16.0	8.8	5.3	3.5	7.1	
STAWK1610TG	●		16.1	8.8	5.3	3.5	7.1	
STAWK1620TG	●		16.2	8.8	5.3	3.5	7.1	
STAWK1630TG	●		16.3	8.8	5.3	3.5	7.1	
STAWK1640TG	●		16.4	8.9	5.3	3.6	7.1	
STAWK1650TG	●		16.5	9.3	5.7	3.6	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
STAWK1660TG	●		16.6	9.3	5.7	3.6	7.6	
STAWK1670TG	●		16.7	9.3	5.7	3.6	7.6	
STAWK1680TG	●		16.8	9.3	5.7	3.6	7.6	
STAWK1690TG	●		16.9	9.4	5.7	3.7	7.6	
STAWK1700TG	●		17.0	9.4	5.7	3.7	7.6	
STAWK1710TG	●		17.1	9.4	5.7	3.7	7.6	
STAWK1720TG	●		17.2	9.4	5.7	3.7	7.6	
STAWK1730TG	●		17.3	9.4	5.7	3.7	7.6	
STAWK1740TG	●		17.4	9.4	5.7	3.7	7.6	
STAWK1750TG	●		17.5	9.8	6.0	3.8	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
STAWK1760TG	●		17.6	9.8	6.0	3.8	8.1	
STAWK1770TG	●		17.7	9.8	6.0	3.8	8.1	
STAWK1780TG	●		17.8	9.8	6.0	3.8	8.1	
STAWK1790TG	●		17.9	9.8	6.0	3.8	8.1	
STAWK1800TG	●		18.0	9.9	6.0	3.9	8.1	
STAWK1810TG	●		18.1	9.9	6.0	3.9	8.1	
STAWK1820TG	●		18.2	9.9	6.0	3.9	8.1	
STAWK1830TG	●		18.3	9.9	6.0	3.9	8.1	
STAWK1840TG	●		18.4	9.9	6.0	3.9	8.1	

● : Inventory maintained in Japan.
(1 insert in one case)

■ HONE WIDTH

If an insert with honing other than standard is needed, please order using the symbols below.

(Insert Order Number)

S T A W N 1 0 0 0 T ◌

- S T A W: STAW Product Name
- N: N : General Use / K : For Cast Iron
- 1 0 0 0: Insert Diameter
- T: Honing Symbol
- ◌: Honing Type

(Honing Standard)

Honing Type	Hone Width (mm)
F	0
G	0.02—0.05
H	0.05—0.10
-	0.10—0.15
K	0.15—0.20
S	0.20—0.25
M	0.25—0.30

RECOMMENDED CUTTING CONDITIONS

Work Material		Drill Diameter	ϕ10.0—ϕ12.9		ϕ13.0—ϕ13.9		ϕ14.0—ϕ15.4		ϕ15.5—ϕ18.4	
		Conditions / Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P	Mild Steel	≤180HB	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.35 (0.25—0.40)
	Carbon Steel Alloy Steel	180—280HB	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.35 (0.25—0.40)
		280—350HB	70 (60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)	90 (70—110)	0.30 (0.20—0.35)
M	Stainless Steel	≤200HB	40 (30—50)	0.13 (0.10—0.16)	50 (40—60)	0.15 (0.12—0.18)	60 (50—70)	0.17 (0.14—0.20)	60 (50—70)	0.17 (0.14—0.20)
K	Gray Cast Iron	Tensile Strength ≤350MPa	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	120 (80—140)	0.45 (0.35—0.55)
	Ductile Cast Iron	Tensile Strength ≤450MPa	70 (60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.30 (0.25—0.35)	100 (80—120)	0.35 (0.25—0.40)

Note 1) When using a drill for DC×1.5 depth of hole, it is possible to increase the feed rate by approx. 20%.
Note 2) When using the DC×8 type holder, reduce the cutting speed by approx. 20%.
Note 3) When using the DC×8 type holder, it is recommended to drill a pilot guide hole.
Note 4) For stainless steel, please use internal coolant. (Mist & MQL are not recommended).

STAW

Small Diameter Indexable Drill

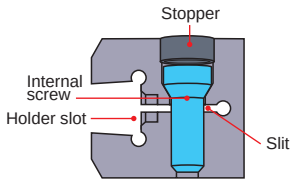
NOTES ON USE

■INSERT INSTALLATION

1. Before inserting the insert into the holder, ensure that there are no foreign objects or dirt in the holder slot or slit. If there are any foreign objects or dirt, use compressed air to remove them.

2. Use the provided wrench to loosen the inner screw to open the tip of the holder, then put the insert into the holder slot as shown in figure 1.
   *Ensure that the wrench is firmly in contact with the base of the inner screw head when tightening.

3. After the insert has been set in the holder slot, tighten the inner screw while holding the insert lightly as shown in figure 2 to securely clamp and locate the insert.
   *Ensure that the wrench is firmly in contact with the base of the inner screw head when tightening.



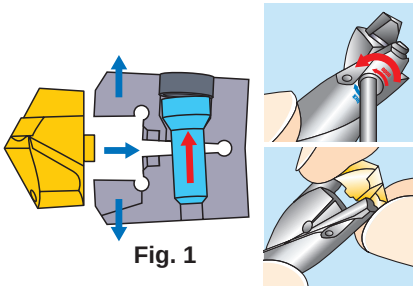


Fig. 1

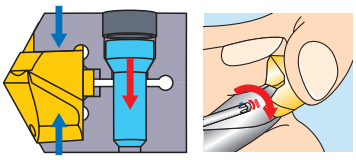
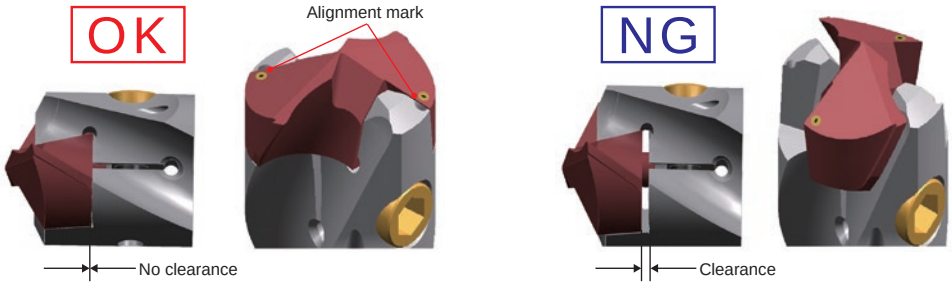


Fig. 2

Tighten the clamp screw according to the torque below.

Drill Diameter (mm)	Clamp Torque N · m
10 －12.9	1
13 －15.4	2
15.5－18.4	2.5

4. Check there is no gap between the bottom of the insert and holder slot.



Note 1) Poor or incorrect clamping of inserts can cause poor drilling performance and/or drill breakage.
Therefore ensure that the alignment marks on both the body and insert are aligned when setting.
When machining, use safety guards and goggles.

SPARE PARTS

Applicable Holder	Pack Order Number (Internal Screw & Stopper)	Internal Screw	Stopper
STAWSS/SN/MN/LN1000S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1050S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1100S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1150S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1200S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1250S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1300S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1350S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1400S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1450S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1500S20	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1600S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1700S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1800S20	WS304912TPS-55LH	WS304912TPS	WS55LH

Note 1) The parts are packaged internal screw, stopper and operation manual. Please replace the parts in accordance with the operation manual.

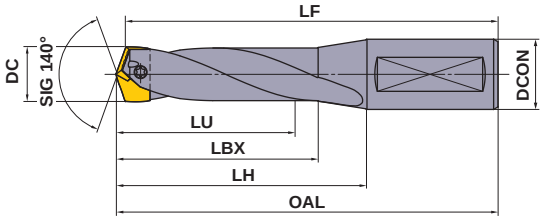
TAW

- Wavy cutting edge design for good chip control.
- Serration geometry for accurate insert location.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			

(General Use)



HOLDERS

DC (mm)	Hole Depth (L/D)	Holder: Order Number	Holder: Stock	Dimensions (mm): LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant
18.5 – 19.4	3	TAWSN1900S25	●	58.9	71.4	102.4	158.4	155.0	25	WS304517T	TKY10T	WPT4405	MK1KS
	5	TAWMN1900S25	●	95.9	110.4	137.4	193.4	190.0	25	WS304517T	TKY10T	WPT4405	MK1KS
	8	TAWLN1900S25	●	151.4	165.4	188.4	244.4	241.0	25	WS304517T	TKY10T	WPT4405	MK1KS
19.5 – 20.4	3	TAWSN2000S25	●	62.0	75.5	102.5	158.5	155.0	25	WS304518T	TKY10T	WPT4405	MK1KS
	5	TAWMN2000S25	●	101.0	116.5	142.5	198.5	195.0	25	WS304518T	TKY10T	WPT4405	MK1KS
	8	TAWLN2000S25	●	159.5	173.5	196.5	252.5	249.0	25	WS304518T	TKY10T	WPT4405	MK1KS

Insert: DC (mm)	Order Number	Stock: VP15TF	DP5010	VP10H
18.5	⋆TAWNH1850T	●		□
	TAWKH1850TG		●	
18.6	TAWNH1860T	●		□
	TAWKH1860TG		●	
18.7	TAWNH1870T	●		□
	TAWKH1870TG		●	
18.8	TAWNH1880T	●		□
	TAWKH1880TG		●	
18.9	TAWNH1890T	●		□
	TAWKH1890TG		●	
19.0	TAWNH1900T	●		□
	TAWKH1900TG		●	
19.1	TAWNH1910T	●		□
	TAWKH1910TG		●	
19.2	TAWNH1920T	●		□
	TAWKH1920TG		●	
19.3	TAWNH1930T	●		□
	TAWKH1930TG		●	
19.4	TAWNH1940T	●		□
	TAWKH1940TG		●	
19.5	⋆TAWNH1950T	●		□
	TAWKH1950TG		●	
19.6	TAWNH1960T	●		□
	TAWKH1960TG		●	
19.7	TAWNH1970T	●		□
	TAWKH1970TG		●	
19.8	TAWNH1980T	●		□
	TAWKH1980TG		●	
19.9	TAWNH1990T	●		□
	TAWKH1990TG		●	
20.0	TAWNH2000T	●		□
	TAWKH2000TG		●	
20.1	TAWNH2010T	□		□
	TAWKH2010TG		□	
20.2	TAWNH2020T	□		□
	TAWKH2020TG		□	
20.3	TAWNH2030T	□		□
	TAWKH2030TG		□	
20.4	TAWNH2040T	□		□
	TAWKH2040TG		□	

Note 1) The above dimensions (⋆) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.
□ : Non stock, produced to order only.

INSERT DESCRIPTION	➤ P224
CUTTING CONDITIONS	➤ P228
USAGE NOTE	➤ P228
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

TAW

DC (mm)	Hole Depth (L/D)	Holder Order Number	Holder Stock	LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert DC (mm)	Insert Order Number	Stock VP15TF	Stock DP5010	Stock VP10H
20.5 – 21.4	3	TAWSN2100S25	●	65.2	78.7	102.7	158.7	155.0	25	WS304518T	TKY10T	WPT4405	MK1KS	20.5	*TAWNH2050T	●		□
															TAWKH2050TG		●	
														20.6	TAWNH2060T	□		□
															TAWKH2060TG		□	
														20.7	TAWNH2070T	□		□
															TAWKH2070TG		□	
														20.8	TAWNH2080T	□		□
															TAWKH2080TG		□	
	5	TAWMN2100S25	●	106.2	121.7	142.7	198.7	195.0	25	WS304518T	TKY10T	WPT4405	MK1KS	20.9	TAWNH2090T	□		□
															TAWKH2090TG		□	
														21.0	TAWNH2100T	●		□
															TAWKH2100TG		●	
														21.1	TAWNH2110T	□		□
															TAWKH2110TG		□	
	8	TAWLN2100S25	●	167.7	181.7	205.7	261.7	258.0	25	WS304518T	TKY10T	WPT4405	MK1KS	21.2	TAWNH2120T	□		□
															TAWKH2120TG		□	
														21.3	TAWNH2130T	□		□
															TAWKH2130TG		□	
														21.4	TAWNH2140T	□		□
															TAWKH2140TG		□	
21.5 – 22.4	3	TAWSN2200S25	●	68.4	83.2	108.2	164.2	160.3	25	WS355520T	TKY15T	WPT4405	MK1KS	21.5	*TAWNH2150T	●		□
															TAWKH2150TG		●	
														21.6	TAWNH2160T	□		□
															TAWKH2160TG		□	
														21.7	TAWNH2170T	□		□
															TAWKH2170TG		□	
														21.8	TAWNH2180T	□		□
															TAWKH2180TG		□	
	5	TAWMN2200S25	●	111.4	128.2	148.2	204.2	200.3	25	WS355520T	TKY15T	WPT4405	MK1KS	21.9	TAWNH2190T	□		□
															TAWKH2190TG		□	
														22.0	TAWNH2200T	●		□
															TAWKH2200TG		●	
														22.1	TAWNH2210T	□		□
															TAWKH2210TG		□	
	8	TAWLN2200S25	●	175.9	189.9	213.9	269.9	266.0	25	WS355520T	TKY15T	WPT4405	MK1KS	22.2	TAWNH2220T	□		□
															TAWKH2220TG		□	
														22.3	TAWNH2230T	□		□
															TAWKH2230TG		□	
														22.4	TAWNH2240T	□		□
															TAWKH2240TG		□	
22.5 – 23.4	3	TAWSN2300S25	●	71.6	86.4	108.4	164.4	160.3	25	WS355521T	TKY15T	WPT4405	MK1KS	22.5	*TAWNH2250T	●		□
															TAWKH2250TG		●	
														22.6	TAWNH2260T	□		□
															TAWKH2260TG		□	
														22.7	TAWNH2270T	□		□
															TAWKH2270TG		□	
														22.8	TAWNH2280T	□		□
															TAWKH2280TG		□	
	5	TAWMN2300S25	●	116.6	133.4	158.4	214.4	210.3	25	WS355521T	TKY15T	WPT4405	MK1KS	22.9	TAWNH2290T	□		□
															TAWKH2290TG		□	
														23.0	TAWNH2300T	●		□
															TAWKH2300TG		●	
														23.1	TAWNH2310T	□		□
															TAWKH2310TG		□	
	8	TAWLN2300S25	●	184.1	198.1	227.1	283.1	279.0	25	WS355521T	TKY15T	WPT4405	MK1KS	23.2	TAWNH2320T	□		□
															TAWKH2320TG		□	
														23.3	TAWNH2330T	□		□
															TAWKH2330TG		□	
														23.4	TAWNH2340T	□		□
															TAWKH2340TG		□	

Note 1) The above dimensions (*) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.
□ : Non stock, produced to order only.

DC (mm)	Hole Depth (L/D)	Holder: Order Number	Holder: Stock	Dimensions (mm): LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert: DC (mm)	Insert: Order Number	Stock: VP15TF	DP5010	VP10H
23.5 – 24.4	3	TAWSN2400S32	●	74.8	90.6	114.6	174.6	170.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.5	*TAWNH2350T	●		□
															TAWKH2350TG		●	
														23.6	TAWNH2360T	□		□
															TAWKH2360TG		□	
														23.7	TAWNH2370T	□		□
															TAWKH2370TG		□	
														23.8	TAWNH2380T	□		□
															TAWKH2380TG		□	
	5	TAWMN2400S32	●	121.8	139.6	164.6	224.6	220.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.9	TAWNH2390T	□		□
															TAWKH2390TG		□	
														24.0	TAWNH2400T	●		□
															TAWKH2400TG		●	
														24.1	TAWNH2410T	□		□
															TAWKH2410TG		□	
	8	TAWLN2400S32	●	192.3	206.6	236.6	296.6	292.3	32	WS355521T	TKY15T	WPT4405	MK1KS	24.2	TAWNH2420T	□		□
															TAWKH2420TG		□	
														24.3	TAWNH2430T	□		□
															TAWKH2430TG		□	
														24.4	TAWNH2440T	□		□
															TAWKH2440TG		□	
24.5 – 25.4	3	TAWSN2500S32	●	78.0	93.1	115.1	175.1	170.6	32	WS406023T	TKY25T	WPT4405	MK1KS	24.5	*TAWNH2450T	●		□
															TAWKH2450TG		●	
														24.6	TAWNH2460T	□		□
															TAWKH2460TG		□	
														24.7	TAWNH2470T	□		□
															TAWKH2470TG		□	
														24.8	TAWNH2480T	□		□
															TAWKH2480TG		□	
	5	TAWMN2500S32	●	127.0	145.1	170.1	230.1	225.6	32	WS406023T	TKY25T	WPT4405	MK1KS	24.9	TAWNH2490T	□		□
															TAWKH2490TG		□	
														25.0	TAWNH2500T	●		□
															TAWKH2500TG		●	
														25.1	TAWNH2510T	□		□
															TAWKH2510TG		□	
	8	TAWLN2500S32	●	200.5	215.1	245.1	305.1	300.6	32	WS406023T	TKY25T	WPT4405	MK1KS	25.2	TAWNH2520T	□		□
															TAWKH2520TG		□	
														25.3	TAWNH2530T	□		□
															TAWKH2530TG		□	
														25.4	TAWNH2540T	□		□
															TAWKH2540TG		□	
25.5 – 26.4	3	TAWSN2600S32	●	81.1	97.2	120.2	180.2	175.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.5	*TAWNH2550T	●		□
															TAWKH2550TG		●	
														25.6	TAWNH2560T	□		□
															TAWKH2560TG		□	
														25.7	TAWNH2570T	□		□
															TAWKH2570TG		□	
														25.8	TAWNH2580T	□		□
															TAWKH2580TG		□	
	5	TAWMN2600S32	●	132.1	151.2	175.2	235.2	230.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.9	TAWNH2590T	□		□
															TAWKH2590TG		□	
														26.0	TAWNH2600T	●		□
															TAWKH2600TG		●	
														26.1	TAWNH2610T	□		□
															TAWKH2610TG		□	
	8	TAWLN2600S32	●	208.6	223.2	253.2	313.2	308.6	32	WS406024T	TKY25T	WPT4405	MK1KS	26.2	TAWNH2620T	□		□
															TAWKH2620TG		□	
														26.3	TAWNH2630T	□		□
															TAWKH2630TG		□	
														26.4	TAWNH2640T	□		□
															TAWKH2640TG		□	

INSERT DESCRIPTION	➢ P224
CUTTING CONDITIONS	➢ P228
USAGE NOTE	➢ P228
SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

TAW

DC (mm)	Hole Depth (L/D)	Holder Order Number	Holder Stock	LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert DC (mm)	Insert Order Number	Stock VP15TF	Stock DP5010	Stock VP10H
26.5 – 27.4	3	TAWSN2700S32	●	84.3	99.4	120.4	180.4	175.6	32	WS406024T	TKY25T	WPT4405	MK1KS	26.5	*TAWNH2650T	●		□
															TAWKH2650TG		●	
														26.6	TAWNH2660T	□		□
															TAWKH2660TG		□	
														26.7	TAWNH2670T	□		□
															TAWKH2670TG		□	
														26.8	TAWNH2680T	□		□
															TAWKH2680TG		□	
	5	TAWMN2700S32	●	137.3	156.4	180.4	240.4	235.6	32	WS406024T	TKY25T	WPT4405	MK1KS	26.9	TAWNH2690T	□		□
															TAWKH2690TG		□	
														27.0	TAWNH2700T	●		□
															TAWKH2700TG		●	
														27.1	TAWNH2710T	□		□
															TAWKH2710TG		□	
	8	TAWLN2700S32	●	216.8	231.4	261.4	321.4	316.6	32	WS406024T	TKY25T	WPT4405	MK1KS	27.2	TAWNH2720T	□		□
															TAWKH2720TG		□	
														27.3	TAWNH2730T	□		□
															TAWKH2730TG		□	
														27.4	TAWNH2740T	□		□
															TAWKH2740TG		□	
27.5 – 28.4	3	TAWSN2800S32	●	87.5	102.2	125.2	185.2	180.2	32	WS508026T	TKY27T	WPT4405	MK1KS	27.5	*TAWNH2750T	●		□
															TAWKH2750TG		●	
														27.6	TAWNH2760T	□		□
															TAWKH2760TG		□	
														27.7	TAWNH2770T	□		□
															TAWKH2770TG		□	
														27.8	TAWNH2780T	□		□
															TAWKH2780TG		□	
	5	TAWMN2800S32	●	142.5	162.2	185.2	245.2	240.2	32	WS508026T	TKY27T	WPT4405	MK1KS	27.9	TAWNH2790T	□		□
															TAWKH2790TG		□	
														28.0	TAWNH2800T	●		□
															TAWKH2800TG		●	
														28.1	TAWNH2810T	□		□
															TAWKH2810TG		□	
														28.2	TAWNH2820T	□		□
															TAWKH2820TG		□	
	8	TAWLN2800S32	●	225.0	239.2	269.2	329.2	324.2	32	WS508026T	TKY27T	WPT4405	MK1KS	28.3	TAWNH2830T	□		□
															TAWKH2830TG		□	
														28.4	TAWNH2840T	□		□
															TAWKH2840TG		□	
28.5 – 29.4	3	TAWSN2900S32	●	90.7	105.4	130.4	190.4	185.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.5	*TAWNH2850T	●		□
															TAWKH2850TG		●	
														28.6	TAWNH2860T	□		□
															TAWKH2860TG		□	
														28.7	TAWNH2870T	□		□
															TAWKH2870TG		□	
														28.8	TAWNH2880T	□		□
															TAWKH2880TG		□	
	5	TAWMN2900S32	●	147.7	167.4	190.4	250.4	245.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.9	TAWNH2890T	□		□
															TAWKH2890TG		□	
														29.0	TAWNH2900T	●		□
															TAWKH2900TG		●	
														29.1	TAWNH2910T	□		□
															TAWKH2910TG		□	
														29.2	TAWNH2920T	□		□
															TAWKH2920TG		□	
	8	TAWLN2900S32	●	233.2	247.4	277.4	337.4	332.2	32	WS508027T	TKY27T	WPT4405	MK1KS	29.3	TAWNH2930T	□		□
															TAWKH2930TG		□	
														29.4	TAWNH2940T	□		□
															TAWKH2940TG		□	

Note 1) The above dimensions (*) are for when installing the inserts.
Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.
□ : Non stock, produced to order only.

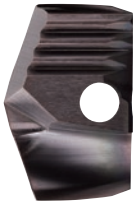
DC (mm)	Hole Depth (L/D)	Holder: Order Number	Holder: Stock	LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert: DC (mm)	Insert: Order Number	Stock: VP15TF	Stock: DP5010	Stock: VP10H
29.5 – 30.4	3	TAWSN3000S32	●	93.9	109.6	130.6	190.6	185.2	32	WS508027T	TKY27T	WPT4405	MK1KS	29.5	*TAWNH2950T	●		□
															TAWKH2950TG		●	
														29.6	TAWNH2960T	□		□
															TAWKH2960TG		□	
														29.7	TAWNH2970T	□		□
															TAWKH2970TG		□	
														29.8	TAWNH2980T	□		□
															TAWKH2980TG		□	
														29.9	TAWNH2990T	□		□
															TAWKH2990TG		□	
	5	TAWMN3000S32	●	152.9	172.6	200.6	260.6	255.2	32	WS508027T	TKY27T	WPT4405	MK1KS	30.0	TAWNH3000T	●		□
															TAWKH3000TG		●	
														30.1	TAWNH3010T	□		□
															TAWKH3010TG		□	
														30.2	TAWNH3020T	□		□
															TAWKH3020TG		□	
	8	TAWLN3000S32	●	241.4	255.6	290.6	350.6	345.2	32	WS508027T	TKY27T	WPT4405	MK1KS	30.3	TAWNH3030T	□		□
															TAWKH3030TG		□	
														30.4	TAWNH3040T	□		□
															TAWKH3040TG		□	

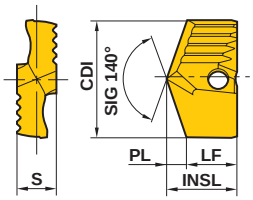
INSERT DESCRIPTION	➢ P224
CUTTING CONDITIONS	➢ P228
USAGE NOTE	➢ P228
SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

TAW

INSERTS

H Type





Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWNH1850T	●	□	18.5	12.7	9.3	3.4	7.0	TAWSN 1900S25 / TAWMN 1900S25 / TAWLN 1900S25
TAWNH1860T	●	□	18.6	12.7	9.3	3.4	7.0	
TAWNH1870T	●	□	18.7	12.7	9.3	3.4	7.0	
TAWNH1880T	●	□	18.8	12.7	9.3	3.4	7.0	
TAWNH1890T	●	□	18.9	12.7	9.3	3.4	7.0	
TAWNH1900T	●	□	19.0	12.7	9.2	3.5	7.0	
TAWNH1910T	●	□	19.1	12.7	9.2	3.5	7.0	
TAWNH1920T	●	□	19.2	12.7	9.2	3.5	7.0	
TAWNH1930T	●	□	19.3	12.7	9.2	3.5	7.0	
TAWNH1940T	●	□	19.4	12.7	9.2	3.5	7.0	
TAWNH1950T	●	□	19.5	12.6	9.1	3.5	7.0	TAWSN 2000S25 / TAWMN 2000S25 / TAWLN 2000S25
TAWNH1960T	●	□	19.6	12.7	9.1	3.6	7.0	
TAWNH1970T	●	□	19.7	12.7	9.1	3.6	7.0	
TAWNH1980T	●	□	19.8	12.7	9.1	3.6	7.0	
TAWNH1990T	●	□	19.9	12.7	9.1	3.6	7.0	
TAWNH2000T	●	□	20.0	12.6	9.0	3.6	7.0	
TAWNH2010T	□	□	20.1	12.7	9.0	3.7	7.0	
TAWNH2020T	□	□	20.2	12.7	9.0	3.7	7.0	
TAWNH2030T	□	□	20.3	12.7	9.0	3.7	7.0	
TAWNH2040T	□	□	20.4	12.7	9.0	3.7	7.0	
TAWNH2050T	●	□	20.5	12.6	8.9	3.7	7.0	TAWSN 2100S25 / TAWMN 2100S25 / TAWLN 2100S25
TAWNH2060T	□	□	20.6	12.6	8.9	3.7	7.0	
TAWNH2070T	□	□	20.7	12.7	8.9	3.8	7.0	
TAWNH2080T	□	□	20.8	12.7	8.9	3.8	7.0	
TAWNH2090T	□	□	20.9	12.7	8.9	3.8	7.0	
TAWNH2100T	●	□	21.0	12.6	8.8	3.8	7.0	
TAWNH2110T	□	□	21.1	12.6	8.8	3.8	7.0	
TAWNH2120T	□	□	21.2	12.7	8.8	3.9	7.0	
TAWNH2130T	□	□	21.3	12.7	8.8	3.9	7.0	
TAWNH2140T	□	□	21.4	12.7	8.8	3.9	7.0	
TAWNH2150T	●	□	21.5	14.5	10.6	3.9	8.0	TAWSN 2200S25 / TAWMN 2200S25 / TAWLN 2200S25
TAWNH2160T	□	□	21.6	14.5	10.6	3.9	8.0	
TAWNH2170T	□	□	21.7	14.5	10.6	3.9	8.0	
TAWNH2180T	□	□	21.8	14.6	10.6	4.0	8.0	
TAWNH2190T	□	□	21.9	14.6	10.6	4.0	8.0	
TAWNH2200T	●	□	22.0	14.5	10.5	4.0	8.0	
TAWNH2210T	□	□	22.1	14.5	10.5	4.0	8.0	
TAWNH2220T	□	□	22.2	14.5	10.5	4.0	8.0	
TAWNH2230T	□	□	22.3	14.6	10.5	4.1	8.0	
TAWNH2240T	□	□	22.4	14.6	10.5	4.1	8.0	
TAWNH2250T	●	□	22.5	14.5	10.4	4.1	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWNH2260T	□	□	22.6	14.5	10.4	4.1	8.0	
TAWNH2270T	□	□	22.7	14.5	10.4	4.1	8.0	
TAWNH2280T	□	□	22.8	14.5	10.4	4.1	8.0	
TAWNH2290T	□	□	22.9	14.6	10.4	4.2	8.0	

Order Number	Coated VP15TF	Coated VP10H	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWNH2300T	●	□	23.0	14.5	10.3	4.2	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWNH2310T	□	□	23.1	14.5	10.3	4.2	8.0	
TAWNH2320T	□	□	23.2	14.5	10.3	4.2	8.0	
TAWNH2330T	□	□	23.3	14.5	10.3	4.2	8.0	
TAWNH2340T	□	□	23.4	14.6	10.3	4.3	8.0	
TAWNH2350T	●	□	23.5	14.5	10.2	4.3	8.0	TAWSN 2400S32 / TAWMN 2400S32 / TAWLN 2400S32
TAWNH2360T	□	□	23.6	14.5	10.2	4.3	8.0	
TAWNH2370T	□	□	23.7	14.5	10.2	4.3	8.0	
TAWNH2380T	□	□	23.8	14.5	10.2	4.3	8.0	
TAWNH2390T	□	□	23.9	14.5	10.2	4.3	8.0	
TAWNH2400T	●	□	24.0	14.5	10.1	4.4	8.0	
TAWNH2410T	□	□	24.1	14.5	10.1	4.4	8.0	
TAWNH2420T	□	□	24.2	14.5	10.1	4.4	8.0	
TAWNH2430T	□	□	24.3	14.5	10.1	4.4	8.0	
TAWNH2440T	□	□	24.4	14.5	10.1	4.4	8.0	
TAWNH2450T	●	□	24.5	16.2	11.7	4.5	9.0	TAWSN 2500S32 / TAWMN 2500S32 / TAWLN 2500S32
TAWNH2460T	□	□	24.6	16.2	11.7	4.5	9.0	
TAWNH2470T	□	□	24.7	16.2	11.7	4.5	9.0	
TAWNH2480T	□	□	24.8	16.2	11.7	4.5	9.0	
TAWNH2490T	□	□	24.9	16.2	11.7	4.5	9.0	
TAWNH2500T	●	□	25.0	16.1	11.6	4.5	9.0	
TAWNH2510T	□	□	25.1	16.2	11.6	4.6	9.0	
TAWNH2520T	□	□	25.2	16.2	11.6	4.6	9.0	
TAWNH2530T	□	□	25.3	16.2	11.6	4.6	9.0	
TAWNH2540T	□	□	25.4	16.2	11.6	4.6	9.0	
TAWNH2550T	●	□	25.5	16.1	11.5	4.6	9.0	TAWSN 2600S32 / TAWMN 2600S32 / TAWLN 2600S32
TAWNH2560T	□	□	25.6	16.2	11.5	4.7	9.0	
TAWNH2570T	□	□	25.7	16.2	11.5	4.7	9.0	
TAWNH2580T	□	□	25.8	16.2	11.5	4.7	9.0	
TAWNH2590T	□	□	25.9	16.2	11.5	4.7	9.0	
TAWNH2600T	●	□	26.0	16.1	11.4	4.7	9.0	
TAWNH2610T	□	□	26.1	16.1	11.4	4.7	9.0	
TAWNH2620T	□	□	26.2	16.2	11.4	4.8	9.0	
TAWNH2630T	□	□	26.3	16.2	11.4	4.8	9.0	
TAWNH2640T	□	□	26.4	16.2	11.4	4.8	9.0	
TAWNH2650T	●	□	26.5	16.1	11.3	4.8	9.0	TAWSN 2700S32 / TAWMN 2700S32 / TAWLN 2700S32
TAWNH2660T	□	□	26.6	16.1	11.3	4.8	9.0	
TAWNH2670T	□	□	26.7	16.2	11.3	4.9	9.0	
TAWNH2680T	□	□	26.8	16.2	11.3	4.9	9.0	
TAWNH2690T	□	□	26.9	16.2	11.3	4.9	9.0	
TAWNH2700T	●	□	27.0	16.1	11.2	4.9	9.0	
TAWNH2710T	□	□	27.1	16.1	11.2	4.9	9.0	
TAWNH2720T	□	□	27.2	16.1	11.2	4.9	9.0	
TAWNH2730T	□	□	27.3	16.2	11.2	5.0	9.0	
TAWNH2740T	□	□	27.4	16.2	11.2	5.0	9.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

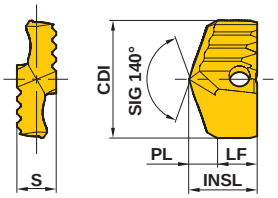
Order Number	Coated		Dimensions (mm)					Applicable Holder
	VP15TF	VP10H	CDI	INSL	LF	PL	S	
TAWNH2750T	●	□	27.5	17.3	12.3	5.0	10.0	TAWSN 2800S32 TAWMN 2800S32 TAWLN 2800S32
TAWNH2760T	□	□	27.6	17.3	12.3	5.0	10.0	
TAWNH2770T	□	□	27.7	17.3	12.3	5.0	10.0	
TAWNH2780T	□	□	27.8	17.4	12.3	5.1	10.0	
TAWNH2790T	□	□	27.9	17.4	12.3	5.1	10.0	
TAWNH2800T	●	□	28.0	17.3	12.2	5.1	10.0	
TAWNH2810T	□	□	28.1	17.3	12.2	5.1	10.0	
TAWNH2820T	□	□	28.2	17.3	12.2	5.1	10.0	
TAWNH2830T	□	□	28.3	17.4	12.2	5.2	10.0	
TAWNH2840T	□	□	28.4	17.4	12.2	5.2	10.0	
TAWNH2850T	●	□	28.5	17.3	12.1	5.2	10.0	TAWSN 2900S32 TAWMN 2900S32 TAWLN 2900S32
TAWNH2860T	□	□	28.6	17.3	12.1	5.2	10.0	
TAWNH2870T	□	□	28.7	17.3	12.1	5.2	10.0	
TAWNH2880T	□	□	28.8	17.3	12.1	5.2	10.0	
TAWNH2890T	□	□	28.9	17.4	12.1	5.3	10.0	
TAWNH2900T	●	□	29.0	17.3	12.0	5.3	10.0	
TAWNH2910T	□	□	29.1	17.3	12.0	5.3	10.0	
TAWNH2920T	□	□	29.2	17.3	12.0	5.3	10.0	
TAWNH2930T	□	□	29.3	17.3	12.0	5.3	10.0	
TAWNH2940T	□	□	29.4	17.4	12.0	5.4	10.0	

Order Number	Coated		Dimensions (mm)					Applicable Holder
	VP15TF	VP10H	CDI	INSL	LF	PL	S	
TAWNH2950T	●	□	29.5	17.3	11.9	5.4	10.0	TAWSN 3000S32 TAWMN 3000S32 TAWLN 3000S32
TAWNH2960T	□	□	29.6	17.3	11.9	5.4	10.0	
TAWNH2970T	□	□	29.7	17.3	11.9	5.4	10.0	
TAWNH2980T	□	□	29.8	17.3	11.9	5.4	10.0	
TAWNH2990T	□	□	29.9	17.3	11.9	5.4	10.0	
TAWNH3000T	●	□	30.0	17.3	11.8	5.5	10.0	
TAWNH3010T	□	□	30.1	17.3	11.8	5.5	10.0	
TAWNH3020T	□	□	30.2	17.3	11.8	5.5	10.0	
TAWNH3030T	□	□	30.3	17.3	11.8	5.5	10.0	
TAWNH3040T	□	□	30.4	17.3	11.8	5.5	10.0	

TAW

INSERTS

H Type
(Cast Iron)



Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH1850TG	●	18.5	12.7	8.6	4.1	7.0	TAWSN 1900S25 / TAWMN 1900S25 / TAWLN 1900S25
TAWKH1860TG	●	18.6	12.7	8.6	4.1	7.0	
TAWKH1870TG	●	18.7	12.7	8.6	4.1	7.0	
TAWKH1880TG	●	18.8	12.7	8.6	4.1	7.0	
TAWKH1890TG	●	18.9	12.7	8.6	4.1	7.0	
TAWKH1900TG	●	19.0	12.6	8.5	4.1	7.0	
TAWKH1910TG	●	19.1	12.7	8.5	4.2	7.0	
TAWKH1920TG	●	19.2	12.7	8.5	4.2	7.0	
TAWKH1930TG	●	19.3	12.7	8.5	4.2	7.0	
TAWKH1940TG	●	19.4	12.7	8.5	4.2	7.0	
TAWKH1950TG	●	19.5	12.6	8.4	4.2	7.0	TAWSN 2000S25 / TAWMN 2000S25 / TAWLN 2000S25
TAWKH1960TG	●	19.6	12.7	8.4	4.3	7.0	
TAWKH1970TG	●	19.7	12.7	8.4	4.3	7.0	
TAWKH1980TG	●	19.8	12.7	8.4	4.3	7.0	
TAWKH1990TG	●	19.9	12.7	8.4	4.3	7.0	
TAWKH2000TG	●	20.0	12.6	8.3	4.3	7.0	
TAWKH2010TG	□	20.1	12.6	8.3	4.3	7.0	
TAWKH2020TG	□	20.2	12.7	8.3	4.4	7.0	
TAWKH2030TG	□	20.3	12.7	8.3	4.4	7.0	
TAWKH2040TG	□	20.4	12.7	8.3	4.4	7.0	
TAWKH2050TG	●	20.5	12.6	8.2	4.4	7.0	TAWSN 2100S25 / TAWMN 2100S25 / TAWLN 2100S25
TAWKH2060TG	□	20.6	12.6	8.2	4.4	7.0	
TAWKH2070TG	□	20.7	12.7	8.2	4.5	7.0	
TAWKH2080TG	□	20.8	12.7	8.2	4.5	7.0	
TAWKH2090TG	□	20.9	12.7	8.2	4.5	7.0	
TAWKH2100TG	●	21.0	12.6	8.1	4.5	7.0	
TAWKH2110TG	□	21.1	12.6	8.1	4.5	7.0	
TAWKH2120TG	□	21.2	12.6	8.1	4.5	7.0	
TAWKH2130TG	□	21.3	12.7	8.1	4.6	7.0	
TAWKH2140TG	□	21.4	12.7	8.1	4.6	7.0	
TAWKH2150TG	●	21.5	14.5	9.8	4.7	8.0	TAWSN 2200S25 / TAWMN 2200S25 / TAWLN 2200S25
TAWKH2160TG	□	21.6	14.5	9.8	4.7	8.0	
TAWKH2170TG	□	21.7	14.5	9.8	4.7	8.0	
TAWKH2180TG	□	21.8	14.6	9.8	4.8	8.0	
TAWKH2190TG	□	21.9	14.6	9.8	4.8	8.0	
TAWKH2200TG	●	22.0	14.5	9.7	4.8	8.0	
TAWKH2210TG	□	22.1	14.5	9.7	4.8	8.0	
TAWKH2220TG	□	22.2	14.5	9.7	4.8	8.0	
TAWKH2230TG	□	22.3	14.5	9.7	4.8	8.0	
TAWKH2240TG	□	22.4	14.6	9.7	4.9	8.0	
TAWKH2250TG	●	22.5	14.5	9.6	4.9	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWKH2260TG	□	22.6	14.5	9.6	4.9	8.0	
TAWKH2270TG	□	22.7	14.5	9.6	4.9	8.0	
TAWKH2280TG	□	22.8	14.5	9.6	4.9	8.0	
TAWKH2290TG	□	22.9	14.6	9.6	5.0	8.0	

Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2300TG	●	23.0	14.5	9.5	5.0	8.0	TAWSN 2300S25 / TAWMN 2300S25 / TAWLN 2300S25
TAWKH2310TG	□	23.1	14.5	9.5	5.0	8.0	
TAWKH2320TG	□	23.2	14.5	9.5	5.0	8.0	
TAWKH2330TG	□	23.3	14.5	9.5	5.0	8.0	
TAWKH2340TG	□	23.4	14.5	9.5	5.0	8.0	
TAWKH2350TG	●	23.5	14.5	9.4	5.1	8.0	TAWSN 2400S32 / TAWMN 2400S32 / TAWLN 2400S32
TAWKH2360TG	□	23.6	14.5	9.4	5.1	8.0	
TAWKH2370TG	□	23.7	14.5	9.4	5.1	8.0	
TAWKH2380TG	□	23.8	14.5	9.4	5.1	8.0	
TAWKH2390TG	□	23.9	14.5	9.4	5.1	8.0	
TAWKH2400TG	●	24.0	14.5	9.3	5.2	8.0	
TAWKH2410TG	□	24.1	14.5	9.3	5.2	8.0	
TAWKH2420TG	□	24.2	14.5	9.3	5.2	8.0	
TAWKH2430TG	□	24.3	14.5	9.3	5.2	8.0	
TAWKH2440TG	□	24.4	14.5	9.3	5.2	8.0	
TAWKH2450TG	●	24.5	16.0	10.7	5.3	9.0	TAWSN 2500S32 / TAWMN 2500S32 / TAWLN 2500S32
TAWKH2460TG	□	24.6	16.1	10.7	5.4	9.0	
TAWKH2470TG	□	24.7	16.1	10.7	5.4	9.0	
TAWKH2480TG	□	24.8	16.1	10.7	5.4	9.0	
TAWKH2490TG	□	24.9	16.1	10.7	5.4	9.0	
TAWKH2500TG	●	25.0	16.1	10.7	5.4	9.0	
TAWKH2510TG	□	25.1	16.2	10.7	5.5	9.0	
TAWKH2520TG	□	25.2	16.2	10.7	5.5	9.0	
TAWKH2530TG	□	25.3	16.2	10.7	5.5	9.0	
TAWKH2540TG	□	25.4	16.2	10.7	5.5	9.0	
TAWKH2550TG	●	25.5	16.1	10.6	5.5	9.0	TAWSN 2600S32 / TAWMN 2600S32 / TAWLN 2600S32
TAWKH2560TG	□	25.6	16.1	10.6	5.5	9.0	
TAWKH2570TG	□	25.7	16.2	10.6	5.6	9.0	
TAWKH2580TG	□	25.8	16.2	10.6	5.6	9.0	
TAWKH2590TG	□	25.9	16.2	10.6	5.6	9.0	
TAWKH2600TG	●	26.0	16.1	10.5	5.6	9.0	
TAWKH2610TG	□	26.1	16.1	10.5	5.6	9.0	
TAWKH2620TG	□	26.2	16.2	10.5	5.7	9.0	
TAWKH2630TG	□	26.3	16.2	10.5	5.7	9.0	
TAWKH2640TG	□	26.4	16.2	10.5	5.7	9.0	
TAWKH2650TG	●	26.5	16.1	10.4	5.7	9.0	TAWSN 2700S32 / TAWMN 2700S32 / TAWLN 2700S32
TAWKH2660TG	□	26.6	16.1	10.4	5.7	9.0	
TAWKH2670TG	□	26.7	16.1	10.4	5.7	9.0	
TAWKH2680TG	□	26.8	16.2	10.4	5.8	9.0	
TAWKH2690TG	□	26.9	16.2	10.4	5.8	9.0	
TAWKH2700TG	●	27.0	16.1	10.3	5.8	9.0	
TAWKH2710TG	□	27.1	16.1	10.3	5.8	9.0	
TAWKH2720TG	□	27.2	16.1	10.3	5.8	9.0	
TAWKH2730TG	□	27.3	16.2	10.3	5.9	9.0	
TAWKH2740TG	□	27.4	16.2	10.3	5.9	9.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2750TG	●	27.5	17.2	11.2	6.0	10.0	TAWSN 2800S32 TAWMN 2800S32 TAWLN 2800S32
TAWKH2760TG	□	27.6	17.2	11.2	6.0	10.0	
TAWKH2770TG	□	27.7	17.2	11.2	6.0	10.0	
TAWKH2780TG	□	27.8	17.3	11.2	6.1	10.0	
TAWKH2790TG	□	27.9	17.3	11.2	6.1	10.0	
TAWKH2800TG	●	28.0	17.3	11.2	6.1	10.0	
TAWKH2810TG	□	28.1	17.3	11.2	6.1	10.0	
TAWKH2820TG	□	28.2	17.3	11.2	6.1	10.0	
TAWKH2830TG	□	28.3	17.3	11.2	6.1	10.0	
TAWKH2840TG	□	28.4	17.4	11.2	6.2	10.0	
TAWKH2850TG	●	28.5	17.3	11.1	6.2	10.0	TAWSN 2900S32 TAWMN 2900S32 TAWLN 2900S32
TAWKH2860TG	□	28.6	17.3	11.1	6.2	10.0	
TAWKH2870TG	□	28.7	17.3	11.1	6.2	10.0	
TAWKH2880TG	□	28.8	17.3	11.1	6.2	10.0	
TAWKH2890TG	□	28.9	17.4	11.1	6.3	10.0	
TAWKH2900TG	●	29.0	17.3	11.0	6.3	10.0	
TAWKH2910TG	□	29.1	17.3	11.0	6.3	10.0	
TAWKH2920TG	□	29.2	17.3	11.0	6.3	10.0	
TAWKH2930TG	□	29.3	17.3	11.0	6.3	10.0	
TAWKH2940TG	□	29.4	17.3	11.0	6.3	10.0	

Order Number	Coated DP5010	Dimensions (mm) CDI	INSL	LF	PL	S	Applicable Holder
TAWKH2950TG	●	29.5	17.3	10.9	6.4	10.0	TAWSN 3000S32 TAWMN 3000S32 TAWLN 3000S32
TAWKH2960TG	□	29.6	17.3	10.9	6.4	10.0	
TAWKH2970TG	□	29.7	17.3	10.9	6.4	10.0	
TAWKH2980TG	□	29.8	17.3	10.9	6.4	10.0	
TAWKH2990TG	□	29.9	17.3	10.9	6.4	10.0	
TAWKH3000TG	●	30.0	17.3	10.8	6.5	10.0	
TAWKH3010TG	□	30.1	17.3	10.8	6.5	10.0	
TAWKH3020TG	□	30.2	17.3	10.8	6.5	10.0	
TAWKH3030TG	□	30.3	17.3	10.8	6.5	10.0	
TAWKH3040TG	□	30.4	17.3	10.8	6.5	10.0	

TAW

RECOMMENDED CUTTING CONDITIONS

Work Material		Drill Diameter	ϕ18.5−ϕ21.4		ϕ21.5−ϕ24.4	
		Conditions / Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P	Mild Steel	≤180HB	90 (70−110)	0.25 (0.20−0.30)	100 (80−120)	0.30 (0.25−0.35)
	Carbon Steel Alloy Steel	180−280HB	80 (60−100)	0.25 (0.20−0.30)	90 (70−110)	0.30 (0.25−0.35)
		280−350HB	70 (50−90)	0.20 (0.15−0.25)	80 (60−100)	0.25 (0.20−0.30)
M	Stainless Steel	≤200HB	60 (50−70)	0.20 (0.15−0.22)	60 (50−70)	0.20 (0.15−0.22)
K	Gray Cast Iron	Tensile Strength ≤350MPa	120 (60−140)	0.25 (0.20−0.30)	130 (80−150)	0.35 (0.25−0.40)
	Ductile Cast Iron	Tensile Strength ≤450MPa	80 (60−90)	0.25 (0.20−0.30)	90 (60−100)	0.30 (0.25−0.35)

Work Material		Drill Diameter	ϕ24.5−ϕ27.4		ϕ27.5−ϕ30.4	
		Conditions / Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P	Mild Steel	≤180HB	110 (80−120)	0.30 (0.25−0.35)	110 (80−120)	0.30 (0.25−0.35)
	Carbon Steel Alloy Steel	180−280HB	100 (80−120)	0.30 (0.25−0.35)	100 (80−120)	0.30 (0.25−0.35)
		280−350HB	90 (70−110)	0.25 (0.20−0.30)	90 (70−110)	0.25 (0.20−0.30)
M	Stainless Steel	≤200HB	70 (60−80)	0.25 (0.20−0.28)	70 (60−80)	0.25 (0.20−0.28)
K	Gray Cast Iron	Tensile Strength ≤350MPa	140 (90−160)	0.35 (0.25−0.40)	140 (90−160)	0.40 (0.30−0.45)
	Ductile Cast Iron	Tensile Strength ≤450MPa	100 (80−110)	0.30 (0.25−0.35)	100 (80−110)	0.30 (0.25−0.35)

Note 1) When using the DC×8 type holder, reduce the cutting speed by approx. 20%.
Note 2) When using the DC×8 type holder, it is recommended to drill a pilot guide hole.
Note 3) H type honing is recommended when machining mild steel and stainless steel.

■HONE WIDTH

If an insert with honing other than standard is needed, please order using the symbols below.

(Insert Order Number)

T A W N H 1 4 0 0 T ○

- TAW — TAW Product Name
- N — N : General Use / K : For Cast Iron / B : For Bridges
- H — H : H Type
- 1400 — Insert Diameter
- T — Honing Symbol
- ○ — Honing Type

(Honing Standard)

Honing Type	Hone Width (mm)
F	0
G	0.02−0.05
H	0.05−0.10
-(Standard)	0.10−0.15
K	0.15−0.20
S	0.20−0.25
M	0.25−0.30

NOTES ON USE

■INSERT INSTALLATION

- ●Loosen the clamp screw to install the insert.
- ●Correctly mesh the insert and the holder serrations, then slide the insert to the bottom of the slot.
- ●Fasten the clamp screw using the torque wrench provided while holding the insert lightly as shown. (Figure 1)
- ●Check there is no gap between the bottom of the insert and holder. (Figure 2)

Tighten the clamp screw according to the torque below.

Drill Diameter (mm)	Clamp Torque (N · m)
14−15	2.0
16−18	2.0
19−21	3.5
22−24	5.5
25−27	8.5
28−30	12.0

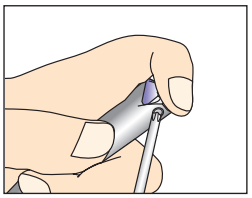


Fig. 1

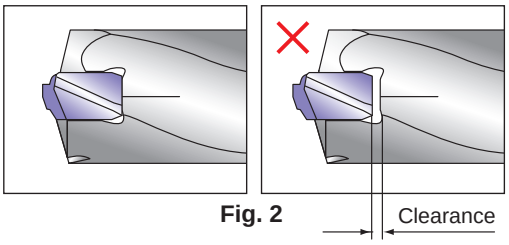


Fig. 2

INSERT REPLACEMENT

●Thouroughly clean the serrations of the holder before installing a new insert.
Remove heavy dirt in the holder serrations by using the cleaning plate provided.

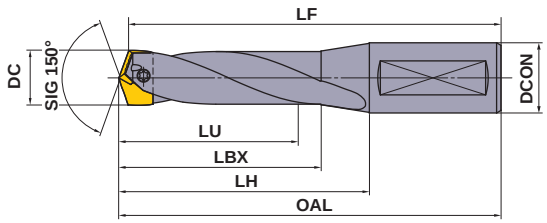
TAW

TOOL NEWS

P M K N S H

Steel

(For Bridge Construction)

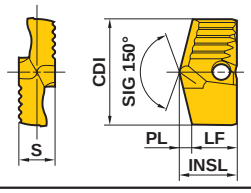


■HOLDERS

DC (mm)	Hole Depth (L/D)	Holder: Order Number	Holder: Stock	Dimensions (mm): LU	LBX	LH	OAL	LF	DCON	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert: DC (mm)	Insert: Order Number	Insert: Stock VP15TF
24.5	3	TAWSB2500S32	●	76.8	91.3	113.3	173.3	170.0	32	WS406023T	TKY25T	WPT4405	MK1KS	24.5	⋆TAWBH2450T	●
24.6	5	TAWMB2500S32	□	125.8	143.3	168.3	228.3	225.0	32	WS406023T	TKY25T	WPT4405	MK1KS	24.6	TAWBH2460T	□
24.7														24.7	TAWBH2470T	●
26.5	3	TAWSB2700S32	●	83.1	97.6	118.6	178.6	175.0	32	WS406024T	TKY25T	WPT4405	MK1KS	26.5	⋆TAWBH2650T	□
26.7	5	TAWMB2700S32	□	136.1	154.6	178.6	238.6	235.0	32	WS406024T	TKY25T	WPT4405	MK1KS	26.7	TAWBH2670T	●

Note 1) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

INSERTS

Shape	Order Number	Stock VP15TF	Dimensions (mm): CDI	INSL	LF	PL	S	Applicable Holder	Hone Width (mm)	Geometry
H Type	TAWBH2450T	●	24.5	15.0	11.7	3.3	9.0	TAWSB2500S32 TAWMB2500S32	0.20—0.25	
	TAWBH2460T	□	24.6	15.0	11.7	3.3	9.0			
	TAWBH2470T	●	24.7	15.0	11.7	3.3	9.0			
	TAWBH2650T	□	26.5	14.9	11.3	3.6	9.0	TAWSB2700S32 TAWMB2700S32		
	TAWBH2670T	●	26.7	14.9	11.3	3.6	9.0			

RECOMMENDED CUTTING CONDITIONS

Work Material			Drill Diameter / Conditions / Hardness	ϕ24.5, ϕ24.6, ϕ24.7: Cutting Speed (m/min)	Feed (mm/rev)	ϕ26.5, ϕ26.7: Cutting Speed (m/min)	Feed (mm/rev)
P	Structural Steel	JIS SS400	Tensile Strength ≦400—500MPa	70 (60—80)	0.30 (0.25—0.35)	70 (60—80)	0.30 (0.25—0.35)
		JIS SM490	Tensile Strength ≦490—610MPa	65 (55—75)	0.30 (0.25—0.35)	65 (55—75)	0.30 (0.25—0.35)
		JIS SM570	Tensile Strength ≦570—720MPa	60 (50—70)	0.30 (0.25—0.35)	60 (50—70)	0.30 (0.25—0.35)

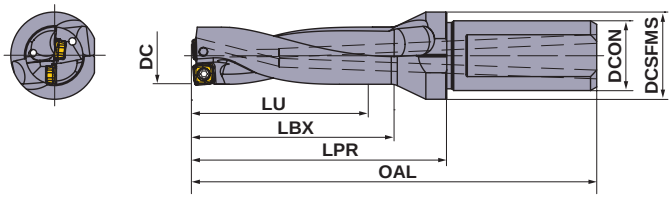
● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(1 insert in one case)

MVX

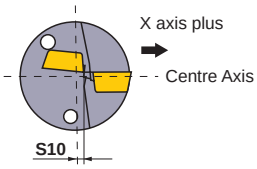
- Ideal combination of outer CVD insert and inner PVD insert.
- High rigidity body that enabled L/D=6 deep hole machining.

TOOL NEWS

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-ferrous Metal		Hardened Steel



Maximum offset for turning



L/D	Machining Tolerance(Guide)(mm) ø14.0—ø33.0	ø33.5—ø47.0	ø48.0—ø63.0
2D, 3D	0 / + 0.25	0 / + 0.3	0 / + 0.3
4D, 5D	0 / + 0.35	0 / + 0.4	0 / + 0.45
6D	0 / + 0.45	0 / + 0.6	

	DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	F Wrench
NEW	14.0	2	MVX1400X2F20	●	2	28	35	50	93	20	25	0.6	SO○X05	TPS20-1	TIP06F
NEW	14.0	3	MVX1400X3F20	●	2	42	49	64	107	20	25	0.6	SO○X05	TPS20-1	TIP06F
NEW	14.0	4	MVX1400X4F20	●	2	56	63	78	121	20	25	0.6	SO○X05	TPS20-1	TIP06F
NEW	14.0	5	MVX1400X5F20	●	2	70	77	92	135	20	25	0.6	SO○X05	TPS20-1	TIP06F
NEW	14.5	2	MVX1450X2F20	●	2	29	36	51	94	20	25	0.5	SO○X05	TPS20-1	TIP06F
NEW	14.5	3	MVX1450X3F20	●	2	43.5	50.5	65.5	108.5	20	25	0.5	SO○X05	TPS20-1	TIP06F
NEW	14.5	4	MVX1450X4F20	●	2	58	65	80	123	20	25	0.5	SO○X05	TPS20-1	TIP06F
NEW	14.5	5	MVX1450X5F20	●	2	72.5	79.5	94.5	137.5	20	25	0.5	SO○X05	TPS20-1	TIP06F
NEW	15.0	2	MVX1500X2F20	●	2	30	37	52	95	20	25	0.35	SO○X05	TPS20-1	TIP06F
NEW	15.0	3	MVX1500X3F20	●	2	45	52	67	110	20	25	0.35	SO○X05	TPS20-1	TIP06F
NEW	15.0	4	MVX1500X4F20	●	2	60	67	82	125	20	25	0.35	SO○X05	TPS20-1	TIP06F
NEW	15.0	5	MVX1500X5F20	●	2	75	82	97	140	20	25	0.35	SO○X05	TPS20-1	TIP06F
NEW	15.5	2	MVX1550X2F20	●	2	31	38	53	96	20	25	0.3	SO○X05	TPS20-1	TIP06F
NEW	15.5	3	MVX1550X3F20	●	2	46.5	53.5	68.5	111.5	20	25	0.3	SO○X05	TPS20-1	TIP06F
NEW	15.5	4	MVX1550X4F20	●	2	62	69	84	127	20	25	0.3	SO○X05	TPS20-1	TIP06F
NEW	15.5	5	MVX1550X5F20	●	2	77.5	84.5	99.5	142.5	20	25	0.3	SO○X05	TPS20-1	TIP06F
NEW	16.0	2	MVX1600X2F20	●	2	32	39	54	97	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.0	3	MVX1600X3F20	●	2	48	55	70	113	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.0	4	MVX1600X4F20	●	2	64	71	86	129	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.0	5	MVX1600X5F20	●	2	80	87	102	145	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.5	2	MVX1650X2F20	●	2	33	40	55	98	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.5	3	MVX1650X3F20	●	2	49.5	56.5	71.5	114.5	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.5	4	MVX1650X4F20	●	2	66	73	88	131	20	25	0.25	SO○X05	TPS20-1	TIP06F
NEW	16.5	5	MVX1650X5F20	●	2	82.5	89.5	104.5	147.5	20	25	0.25	SO○X05	TPS20-1	TIP06F
	17.0	2	MVX1700X2F20	●	2	34	41	56	99	20	25	0.5	SO○X06	TPS25	TIP07F
	17.0	3	MVX1700X3F20	●	2	51	58	73	116	20	25	0.5	SO○X06	TPS25	TIP07F
	17.0	4	MVX1700X4F20	●	2	68	75	90	133	20	25	0.5	SO○X06	TPS25	TIP07F
	17.0	5	MVX1700X5F20	●	2	85	92	107	150	20	25	0.5	SO○X06	TPS25	TIP07F
	17.0	6	MVX1700X6F20	●	2	102	109	124	167	20	25	0.5	SO○X06	TPS25	TIP07F
	17.5	2	MVX1750X2F25	●	2	35	42	62	112	25	32	0.45	SO○X06	TPS25	TIP07F
	17.5	3	MVX1750X3F25	●	2	52.5	59.5	79.5	129.5	25	32	0.45	SO○X06	TPS25	TIP07F
	17.5	4	MVX1750X4F25	●	2	70	77	97	147	25	32	0.45	SO○X06	TPS25	TIP07F

* Clamp Torque (N • m) : TPS20-1=0.6, TPS25=1.0

● : Inventory maintained in Japan.

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	F W Wrench
17.5	5	MVX1750X5F25	●	2	87.5	94.5	114.5	164.5	25	32	0.45	SO○X06	TPS25	TIP07F
17.5	6	MVX1750X6F25	●	2	105	112	132	182	25	32	0.45	SO○X06	TPS25	TIP07F
18.0	2	MVX1800X2F25	●	2	36	43	63	113	25	32	0.4	SO○X06	TPS25	TIP07F
18.0	3	MVX1800X3F25	●	2	54	61	81	131	25	32	0.4	SO○X06	TPS25	TIP07F
18.0	4	MVX1800X4F25	●	2	72	79	99	149	25	32	0.4	SO○X06	TPS25	TIP07F
18.0	5	MVX1800X5F25	●	2	90	97	117	167	25	32	0.4	SO○X06	TPS25	TIP07F
18.0	6	MVX1800X6F25	●	2	108	115	135	185	25	32	0.4	SO○X06	TPS25	TIP07F
18.5	2	MVX1850X2F25	●	2	37	44	64	114	25	32	0.35	SO○X06	TPS25	TIP07F
18.5	3	MVX1850X3F25	●	2	55.5	62.5	82.5	132.5	25	32	0.35	SO○X06	TPS25	TIP07F
18.5	4	MVX1850X4F25	●	2	74	81	101	151	25	32	0.35	SO○X06	TPS25	TIP07F
18.5	5	MVX1850X5F25	●	2	92.5	99.5	119.5	169.5	25	32	0.35	SO○X06	TPS25	TIP07F
18.5	6	MVX1850X6F25	●	2	111	118	138	188	25	32	0.35	SO○X06	TPS25	TIP07F
19.0	2	MVX1900X2F25	●	2	38	45	65	115	25	32	0.3	SO○X06	TPS25	TIP07F
19.0	3	MVX1900X3F25	●	2	57	64	84	134	25	32	0.3	SO○X06	TPS25	TIP07F
19.0	4	MVX1900X4F25	●	2	76	83	103	153	25	32	0.3	SO○X06	TPS25	TIP07F
19.0	5	MVX1900X5F25	●	2	95	102	122	172	25	32	0.3	SO○X06	TPS25	TIP07F
19.0	6	MVX1900X6F25	●	2	114	121	141	191	25	32	0.3	SO○X06	TPS25	TIP07F
19.5	2	MVX1950X2F25	●	2	39	46	66	116	25	32	0.25	SO○X06	TPS25	TIP07F
19.5	3	MVX1950X3F25	●	2	58.5	65.5	85.5	135.5	25	32	0.25	SO○X06	TPS25	TIP07F
19.5	4	MVX1950X4F25	●	2	78	85	105	155	25	32	0.25	SO○X06	TPS25	TIP07F
19.5	5	MVX1950X5F25	●	2	97.5	104.5	124.5	174.5	25	32	0.25	SO○X06	TPS25	TIP07F
19.5	6	MVX1950X6F25	●	2	117	124	144	194	25	32	0.25	SO○X06	TPS25	TIP07F
20.0	2	MVX2000X2F25	●	2	40	47	67	117	25	32	0.6	SO○X07	TPS3	TIP10F
20.0	3	MVX2000X3F25	●	2	60	67	87	137	25	32	0.6	SO○X07	TPS3	TIP10F
20.0	4	MVX2000X4F25	●	2	80	87	107	157	25	32	0.6	SO○X07	TPS3	TIP10F
20.0	5	MVX2000X5F25	●	2	100	107	127	177	25	32	0.6	SO○X07	TPS3	TIP10F
20.0	6	MVX2000X6F25	●	2	120	127	147	197	25	32	0.6	SO○X07	TPS3	TIP10F
20.5	2	MVX2050X2F25	●	2	41	48	68	118	25	32	0.55	SO○X07	TPS3	TIP10F
20.5	3	MVX2050X3F25	●	2	61.5	68.5	88.5	138.5	25	32	0.55	SO○X07	TPS3	TIP10F
21.0	2	MVX2100X2F25	●	2	42	49	69	119	25	32	0.5	SO○X07	TPS3	TIP10F
21.0	3	MVX2100X3F25	●	2	63	70	90	140	25	32	0.5	SO○X07	TPS3	TIP10F
21.0	4	MVX2100X4F25	●	2	84	91	111	161	25	32	0.5	SO○X07	TPS3	TIP10F
21.0	5	MVX2100X5F25	●	2	105	112	132	182	25	32	0.5	SO○X07	TPS3	TIP10F
21.0	6	MVX2100X6F25	●	2	126	133	153	203	25	32	0.5	SO○X07	TPS3	TIP10F
21.5	2	MVX2150X2F25	●	2	43	50	70	120	25	32	0.45	SO○X07	TPS3	TIP10F
21.5	3	MVX2150X3F25	●	2	64.5	71.5	91.5	141.5	25	32	0.45	SO○X07	TPS3	TIP10F
22.0	2	MVX2200X2F25	●	2	44	51	71	121	25	32	0.4	SO○X07	TPS3	TIP10F
22.0	3	MVX2200X3F25	●	2	66	73	93	143	25	32	0.4	SO○X07	TPS3	TIP10F
22.0	4	MVX2200X4F25	●	2	88	95	115	165	25	32	0.4	SO○X07	TPS3	TIP10F
22.0	5	MVX2200X5F25	●	2	110	117	137	187	25	32	0.4	SO○X07	TPS3	TIP10F
22.0	6	MVX2200X6F25	●	2	132	139	159	209	25	32	0.4	SO○X07	TPS3	TIP10F
22.5	2	MVX2250X2F25	●	2	45	52	72	122	25	32	0.35	SO○X07	TPS3	TIP10F
22.5	3	MVX2250X3F25	●	2	67.5	74.5	94.5	144.5	25	32	0.35	SO○X07	TPS3	TIP10F
23.0	2	MVX2300X2F25	●	2	46	53	73	123	25	32	0.8	SO○X08	TPS351	TIP10W
23.0	3	MVX2300X3F25	●	2	69	76	96	146	25	32	0.8	SO○X08	TPS351	TIP10W
23.0	4	MVX2300X4F25	●	2	92	99	119	169	25	32	0.8	SO○X08	TPS351	TIP10W
23.0	5	MVX2300X5F25	●	2	115	122	142	192	25	32	0.8	SO○X08	TPS351	TIP10W
23.0	6	MVX2300X6F25	●	2	138	145	165	215	25	32	0.8	SO○X08	TPS351	TIP10W
23.5	2	MVX2350X2F25	●	2	47	54	74	124	25	32	0.75	SO○X08	TPS351	TIP10W
23.5	3	MVX2350X3F25	●	2	70.5	77.5	97.5	147.5	25	32	0.75	SO○X08	TPS351	TIP10W

* Clamp Torque (N • m) : TPS25=1.0, TPS3=2.0, TPS351=2.5

INSERT DESCRIPTION	➤ P237
CUTTING CONDITIONS	➤ P238
USAGE NOTE	➤ P248

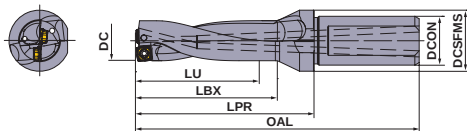
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

MVX

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	W Wrench
24.0	2	**MVX2400X2F25**	●	2	48	55	75	125	25	32	0.7	**SO○X08**	TPS351	TIP10W
24.0	3	**MVX2400X3F25**	●	2	72	79	99	149	25	32	0.7	**SO○X08**	TPS351	TIP10W
24.0	4	**MVX2400X4F25**	●	2	96	103	123	173	25	32	0.7	**SO○X08**	TPS351	TIP10W
24.0	5	**MVX2400X5F25**	●	2	120	127	147	197	25	32	0.7	**SO○X08**	TPS351	TIP10W
24.0	6	**MVX2400X6F25**	●	2	144	151	171	221	25	32	0.7	**SO○X08**	TPS351	TIP10W
24.5	2	**MVX2450X2F25**	●	2	49	56	76	126	25	32	0.65	**SO○X08**	TPS351	TIP10W
24.5	3	**MVX2450X3F25**	●	2	73.5	80.5	100.5	150.5	25	32	0.65	**SO○X08**	TPS351	TIP10W
25.0	2	**MVX2500X2F25**	●	2	50	57	77	127	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.0	3	**MVX2500X3F25**	●	2	75	82	102	152	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.0	4	**MVX2500X4F25**	●	2	100	107	127	177	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.0	5	**MVX2500X5F25**	●	2	125	132	152	202	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.0	6	**MVX2500X6F25**	●	2	150	157	177	227	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.5	2	**MVX2550X2F25**	●	2	51	58	78	128	25	32	0.6	**SO○X08**	TPS351	TIP10W
25.5	3	**MVX2550X3F25**	●	2	76.5	83.5	103.5	153.5	25	32	0.6	**SO○X08**	TPS351	TIP10W
26.0	2	**MVX2600X2F32**	●	2	52	59	79	134	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.0	3	**MVX2600X3F32**	●	2	78	85	105	160	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.0	4	**MVX2600X4F32**	●	2	104	111	131	186	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.0	5	**MVX2600X5F32**	●	2	130	137	157	212	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.0	6	**MVX2600X6F32**	●	2	156	163	183	238	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.5	2	**MVX2650X2F32**	●	2	53	60	80	135	32	42	0.5	**SO○X08**	TPS351	TIP10W
26.5	3	**MVX2650X3F32**	●	2	79.5	86.5	106.5	161.5	32	42	0.5	**SO○X08**	TPS351	TIP10W
27.0	2	**MVX2700X2F32**	●	2	54	61	81	136	32	42	0.45	**SO○X08**	TPS351	TIP10W
27.0	3	**MVX2700X3F32**	●	2	81	88	108	163	32	42	0.45	**SO○X08**	TPS351	TIP10W
27.0	4	**MVX2700X4F32**	●	2	108	115	135	190	32	42	0.45	**SO○X08**	TPS351	TIP10W
27.0	5	**MVX2700X5F32**	●	2	135	142	162	217	32	42	0.45	**SO○X08**	TPS351	TIP10W
27.0	6	**MVX2700X6F32**	●	2	162	169	189	244	32	42	0.45	**SO○X08**	TPS351	TIP10W
27.5	2	**MVX2750X2F32**	●	2	55	62	82	137	32	42	0.4	**SO○X08**	TPS351	TIP10W
27.5	3	**MVX2750X3F32**	●	2	82.5	89.5	109.5	164.5	32	42	0.4	**SO○X08**	TPS351	TIP10W
28.0	2	**MVX2800X2F32**	●	2	56	63	83	138	32	42	0.85	**SO○X09**	TPS4	TIP15W
28.0	3	**MVX2800X3F32**	●	2	84	91	111	166	32	42	0.85	**SO○X09**	TPS4	TIP15W
28.0	4	**MVX2800X4F32**	●	2	112	119	139	194	32	42	0.85	**SO○X09**	TPS4	TIP15W
28.0	5	**MVX2800X5F32**	●	2	140	147	167	222	32	42	0.85	**SO○X09**	TPS4	TIP15W
28.0	6	**MVX2800X6F32**	●	2	168	175	195	250	32	42	0.85	**SO○X09**	TPS4	TIP15W
28.5	2	**MVX2850X2F32**	●	2	57	64	84	139	32	42	0.8	**SO○X09**	TPS4	TIP15W
28.5	3	**MVX2850X3F32**	●	2	85.5	92.5	112.5	167.5	32	42	0.8	**SO○X09**	TPS4	TIP15W
29.0	2	**MVX2900X2F32**	●	2	58	65	85	140	32	42	0.75	**SO○X09**	TPS4	TIP15W
29.0	3	**MVX2900X3F32**	●	2	87	94	114	169	32	42	0.75	**SO○X09**	TPS4	TIP15W
29.0	4	**MVX2900X4F32**	●	2	116	123	143	198	32	42	0.75	**SO○X09**	TPS4	TIP15W
29.0	5	**MVX2900X5F32**	●	2	145	152	172	227	32	42	0.75	**SO○X09**	TPS4	TIP15W
29.0	6	**MVX2900X6F32**	●	2	174	181	201	256	32	42	0.75	**SO○X09**	TPS4	TIP15W
29.5	2	**MVX2950X2F32**	●	2	59	66	86	141	32	42	0.7	**SO○X09**	TPS4	TIP15W
29.5	3	**MVX2950X3F32**	●	2	88.5	95.5	115.5	170.5	32	42	0.7	**SO○X09**	TPS4	TIP15W
30.0	2	**MVX3000X2F32**	●	2	60	67	87	142	32	42	0.65	**SO○X09**	TPS4	TIP15W
30.0	3	**MVX3000X3F32**	●	2	90	97	117	172	32	42	0.65	**SO○X09**	TPS4	TIP15W
30.0	4	**MVX3000X4F32**	●	2	120	127	147	202	32	42	0.65	**SO○X09**	TPS4	TIP15W
30.0	5	**MVX3000X5F32**	●	2	150	157	177	232	32	42	0.65	**SO○X09**	TPS4	TIP15W
30.0	6	**MVX3000X6F32**	●	2	180	187	207	262	32	42	0.65	**SO○X09**	TPS4	TIP15W
30.5	3	**MVX3050X3F32**	●	2	91.5	98.5	118.5	173.5	32	42	0.6	**SO○X09**	TPS4	TIP15W
31.0	2	**MVX3100X2F40**	●	2	62	69	89	154	40	50	0.55	**SO○X09**	TPS4	TIP15W
31.0	3	**MVX3100X3F40**	●	2	93	100	120	185	40	50	0.55	**SO○X09**	TPS4	TIP15W

⋆ Clamp Torque (N • m) : TPS351=2.5, TPS4=3.5

● : Inventory maintained in Japan.



DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	W Wrench
31.0	4	MVX3100X4F40	●	2	124	131	151	216	40	50	0.55	SO○X09	TPS4	TIP15W
31.0	5	MVX3100X5F40	●	2	155	162	182	247	40	50	0.55	SO○X09	TPS4	TIP15W
31.0	6	MVX3100X6F40	●	2	186	193	213	278	40	50	0.55	SO○X09	TPS4	TIP15W
31.5	3	MVX3150X3F40	●	2	94.5	101.5	121.5	186.5	40	50	0.55	SO○X09	TPS4	TIP15W
32.0	2	MVX3200X2F40	●	2	64	71	91	156	40	50	0.45	SO○X09	TPS4	TIP15W
32.0	3	MVX3200X3F40	●	2	96	103	123	188	40	50	0.45	SO○X09	TPS4	TIP15W
32.0	4	MVX3200X4F40	●	2	128	135	155	220	40	50	0.45	SO○X09	TPS4	TIP15W
32.0	5	MVX3200X5F40	●	2	160	167	187	252	40	50	0.45	SO○X09	TPS4	TIP15W
32.0	6	MVX3200X6F40	●	2	192	199	219	284	40	50	0.45	SO○X09	TPS4	TIP15W
32.5	3	MVX3250X3F40	●	2	97.5	104.5	124.5	189.5	40	50	0.45	SO○X09	TPS4	TIP15W
33.0	2	MVX3300X2F40	●	2	66	73	93	158	40	50	0.4	SO○X09	TPS4	TIP15W
33.0	3	MVX3300X3F40	●	2	99	106	126	191	40	50	0.4	SO○X09	TPS4	TIP15W
33.0	4	MVX3300X4F40	●	2	132	139	159	224	40	50	0.4	SO○X09	TPS4	TIP15W
33.0	5	MVX3300X5F40	●	2	165	172	192	257	40	50	0.4	SO○X09	TPS4	TIP15W
33.0	6	MVX3300X6F40	●	2	198	205	225	290	40	50	0.4	SO○X09	TPS4	TIP15W
33.5	3	MVX3350X3F40	●	2	100.5	107.5	127.5	192.5	40	50	1.15	SO○X11	TPS43	TIP15W
34.0	2	MVX3400X2F40	●	2	68	75	105	170	40	50	1.11	SO○X11	TPS43	TIP15W
34.0	3	MVX3400X3F40	●	2	102	109	139	204	40	50	1.11	SO○X11	TPS43	TIP15W
34.0	4	MVX3400X4F40	●	2	136	143	173	238	40	50	1.11	SO○X11	TPS43	TIP15W
34.0	5	MVX3400X5F40	●	2	170	177	207	272	40	50	1.11	SO○X11	TPS43	TIP15W
34.0	6	MVX3400X6F40	●	2	204	211	241	306	40	50	1.1	SO○X11	TPS43	TIP15W
34.5	3	MVX3450X3F40	●	2	103.5	110.5	140.5	205.5	40	50	1.08	SO○X11	TPS43	TIP15W
35.0	2	MVX3500X2F40	●	2	70	77	107	172	40	50	1.03	SO○X11	TPS43	TIP15W
35.0	3	MVX3500X3F40	●	2	105	112	142	207	40	50	1.03	SO○X11	TPS43	TIP15W
35.0	4	MVX3500X4F40	●	2	140	147	177	242	40	50	1.03	SO○X11	TPS43	TIP15W
35.0	5	MVX3500X5F40	●	2	175	182	212	277	40	50	1.03	SO○X11	TPS43	TIP15W
35.0	6	MVX3500X6F40	●	2	210	217	247	312	40	50	1.02	SO○X11	TPS43	TIP15W
35.5	3	MVX3550X3F40	●	2	106.5	113.5	143.5	208.5	40	50	0.99	SO○X11	TPS43	TIP15W
36.0	2	MVX3600X2F40	●	2	72	79	109	174	40	50	0.95	SO○X11	TPS43	TIP15W
36.0	3	MVX3600X3F40	●	2	108	115	145	210	40	50	0.95	SO○X11	TPS43	TIP15W
36.0	4	MVX3600X4F40	●	2	144	151	181	246	40	50	0.95	SO○X11	TPS43	TIP15W
36.0	5	MVX3600X5F40	●	2	180	187	217	282	40	50	0.95	SO○X11	TPS43	TIP15W
36.0	6	MVX3600X6F40	●	2	216	223	253	318	40	50	0.94	SO○X11	TPS43	TIP15W
37.0	2	MVX3700X2F40	●	2	74	81	111	176	40	50	0.87	SO○X11	TPS43	TIP15W
37.0	3	MVX3700X3F40	●	2	111	118	148	213	40	50	0.87	SO○X11	TPS43	TIP15W
37.0	4	MVX3700X4F40	●	2	148	155	185	250	40	50	0.87	SO○X11	TPS43	TIP15W
37.0	5	MVX3700X5F40	●	2	185	192	222	287	40	50	0.87	SO○X11	TPS43	TIP15W
37.0	6	MVX3700X6F40	●	2	222	229	259	324	40	50	0.86	SO○X11	TPS43	TIP15W
38.0	2	MVX3800X2F40	●	2	76	83	113	178	40	50	0.79	SO○X11	TPS43	TIP15W
38.0	3	MVX3800X3F40	●	2	114	121	151	216	40	50	0.79	SO○X11	TPS43	TIP15W
38.0	4	MVX3800X4F40	●	2	152	159	189	254	40	50	0.79	SO○X11	TPS43	TIP15W
38.0	5	MVX3800X5F40	●	2	190	197	227	292	40	50	0.79	SO○X11	TPS43	TIP15W
38.0	6	MVX3800X6F40	●	2	228	235	265	330	40	50	0.78	SO○X11	TPS43	TIP15W
39.0	2	MVX3900X2F40	●	2	78	85	115	180	40	50	0.71	SO○X11	TPS43	TIP15W
39.0	3	MVX3900X3F40	●	2	117	124	154	219	40	50	0.71	SO○X11	TPS43	TIP15W
39.0	4	MVX3900X4F40	●	2	156	163	193	258	40	50	0.71	SO○X11	TPS43	TIP15W
39.0	5	MVX3900X5F40	●	2	195	202	232	297	40	50	0.71	SO○X11	TPS43	TIP15W
39.0	6	MVX3900X6F40	●	2	234	241	271	336	40	50	0.7	SO○X11	TPS43	TIP15W
40.0	2	MVX4000X2F40	●	2	80	87	117	182	40	50	1.46	SO○X13	TPS43	TIP15W
40.0	3	MVX4000X3F40	●	2	120	127	157	222	40	50	1.46	SO○X13	TPS43	TIP15W

⋆ Clamp Torque (N • m) : TPS4=3.5, TPS43=3.5

INSERT DESCRIPTION	➢ P237
CUTTING CONDITIONS	➢ P238
USAGE NOTE	➢ P248

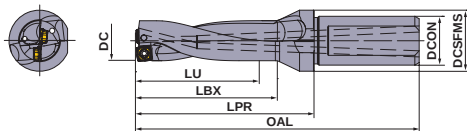
SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

MVX

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	Wrench
40.0	4	MVX4000X4F40	●	2	160	167	197	262	40	50	1.46	SO○X13	TPS43	TIP15W
40.0	5	MVX4000X5F40	●	2	200	207	237	302	40	50	1.46	SO○X13	TPS43	TIP15W
40.0	6	MVX4000X6F40	●	2	240	247	277	342	40	50	1.45	SO○X13	TPS43	TIP15W
41.0	2	MVX4100X2F40	●	2	82	89	119	184	40	50	1.36	SO○X13	TPS43	TIP15W
41.0	3	MVX4100X3F40	●	2	123	130	160	225	40	50	1.36	SO○X13	TPS43	TIP15W
41.0	4	MVX4100X4F40	●	2	164	171	201	266	40	50	1.36	SO○X13	TPS43	TIP15W
41.0	5	MVX4100X5F40	●	2	205	212	242	307	40	50	1.36	SO○X13	TPS43	TIP15W
41.0	6	MVX4100X6F40	●	2	246	253	283	348	40	50	1.35	SO○X13	TPS43	TIP15W
42.0	2	MVX4200X2F40	●	2	84	91	121	186	40	50	1.27	SO○X13	TPS43	TIP15W
42.0	3	MVX4200X3F40	●	2	126	133	163	228	40	50	1.27	SO○X13	TPS43	TIP15W
42.0	4	MVX4200X4F40	●	2	168	175	205	270	40	63	1.27	SO○X13	TPS43	TIP15W
42.0	4	MVX4200X4F50	●	2	168	175	205	280	50	63	1.27	SO○X13	TPS43	TIP15W
42.0	5	MVX4200X5F40	●	2	210	217	247	312	40	63	1.27	SO○X13	TPS43	TIP15W
42.0	5	MVX4200X5F50	●	2	210	217	247	322	50	63	1.27	SO○X13	TPS43	TIP15W
42.0	6	MVX4200X6F40	●	2	252	259	289	354	40	63	1.27	SO○X13	TPS43	TIP15W
42.0	6	MVX4200X6F50	●	2	252	259	289	364	50	63	1.26	SO○X13	TPS43	TIP15W
43.0	2	MVX4300X2F40	●	2	86	93	123	188	40	50	1.18	SO○X13	TPS43	TIP15W
43.0	3	MVX4300X3F40	●	2	129	136	166	231	40	50	1.18	SO○X13	TPS43	TIP15W
43.0	4	MVX4300X4F40	●	2	172	179	209	274	40	63	1.18	SO○X13	TPS43	TIP15W
43.0	4	MVX4300X4F50	●	2	172	179	209	284	50	63	1.18	SO○X13	TPS43	TIP15W
43.0	5	MVX4300X5F40	●	2	215	222	252	317	40	63	1.18	SO○X13	TPS43	TIP15W
43.0	5	MVX4300X5F50	●	2	215	222	252	327	50	63	1.18	SO○X13	TPS43	TIP15W
43.0	6	MVX4300X6F40	●	2	258	265	295	360	40	63	1.17	SO○X13	TPS43	TIP15W
43.0	6	MVX4300X6F50	●	2	258	265	295	370	50	63	1.17	SO○X13	TPS43	TIP15W
44.0	2	MVX4400X2F40	●	2	88	95	125	190	40	50	1.08	SO○X13	TPS43	TIP15W
44.0	3	MVX4400X3F40	●	2	132	139	169	234	40	50	1.08	SO○X13	TPS43	TIP15W
44.0	4	MVX4400X4F40	●	2	176	183	213	278	40	63	1.08	SO○X13	TPS43	TIP15W
44.0	4	MVX4400X4F50	●	2	176	183	213	288	50	63	1.08	SO○X13	TPS43	TIP15W
44.0	5	MVX4400X5F40	●	2	220	227	257	322	40	63	1.08	SO○X13	TPS43	TIP15W
44.0	5	MVX4400X5F50	●	2	220	227	257	332	50	63	1.08	SO○X13	TPS43	TIP15W
45.0	2	MVX4500X2F40	●	2	90	97	127	192	40	50	0.99	SO○X13	TPS43	TIP15W
45.0	3	MVX4500X3F40	●	2	135	142	172	237	40	50	0.99	SO○X13	TPS43	TIP15W
45.0	4	MVX4500X4F40	●	2	180	187	217	282	40	63	0.99	SO○X13	TPS43	TIP15W
45.0	4	MVX4500X4F50	●	2	180	187	217	292	50	63	0.99	SO○X13	TPS43	TIP15W
45.0	5	MVX4500X5F40	●	2	225	232	262	327	40	63	0.99	SO○X13	TPS43	TIP15W
45.0	5	MVX4500X5F50	●	2	225	232	262	337	50	63	0.99	SO○X13	TPS43	TIP15W
46.0	2	MVX4600X2F40	●	2	92	99	129	194	40	50	0.89	SO○X13	TPS43	TIP15W
46.0	3	MVX4600X3F40	●	2	138	145	175	240	40	50	0.89	SO○X13	TPS43	TIP15W
46.0	4	MVX4600X4F40	●	2	184	191	221	286	40	63	0.89	SO○X13	TPS43	TIP15W
46.0	4	MVX4600X4F50	●	2	184	191	221	296	50	63	0.89	SO○X13	TPS43	TIP15W
46.0	5	MVX4600X5F40	●	2	230	237	267	332	40	63	0.89	SO○X13	TPS43	TIP15W
46.0	5	MVX4600X5F50	●	2	230	237	267	342	50	63	0.89	SO○X13	TPS43	TIP15W
47.0	2	MVX4700X2F40	●	2	94	101	141	206	40	63	1.9	SO○X16	TPS54	TIP25D
47.0	3	MVX4700X3F40	●	2	141	148	188	253	40	63	1.9	SO○X16	TPS54	TIP25D
47.0	4	MVX4700X4F40	●	2	188	195	235	300	40	63	1.9	SO○X16	TPS54	TIP25D
47.0	4	MVX4700X4F50	●	2	188	195	235	310	50	63	1.9	SO○X16	TPS54	TIP25D
47.0	5	MVX4700X5F40	●	2	235	242	282	347	40	63	1.9	SO○X16	TPS54	TIP25D
47.0	5	MVX4700X5F50	●	2	235	242	282	357	50	63	1.9	SO○X16	TPS54	TIP25D
48.0	2	MVX4800X2F40	●	2	96	103	143	208	40	63	1.8	SO○X16	TPS54	TIP25D
48.0	3	MVX4800X3F40	●	2	144	151	191	256	40	63	1.8	SO○X16	TPS54	TIP25D

⋆ Clamp Torque (N • m) : TPS43=3.5, TPS54=7.5

● : **Inventory maintained in Japan.**



DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	D Wrench
48.0	4	MVX4800X4F40	●	2	192	199	239	304	40	63	1.8	SO○X16	TPS54	TIP25D
48.0	4	MVX4800X4F50	●	2	192	199	239	314	50	63	1.8	SO○X16	TPS54	TIP25D
48.0	5	MVX4800X5F40	●	2	240	247	287	352	40	63	1.8	SO○X16	TPS54	TIP25D
48.0	5	MVX4800X5F50	●	2	240	247	287	362	50	63	1.8	SO○X16	TPS54	TIP25D
49.0	2	MVX4900X2F40	●	2	98	105	145	210	40	63	1.7	SO○X16	TPS54	TIP25D
49.0	3	MVX4900X3F40	●	2	147	154	194	259	40	63	1.7	SO○X16	TPS54	TIP25D
49.0	4	MVX4900X4F40	●	2	196	203	243	308	40	63	1.7	SO○X16	TPS54	TIP25D
49.0	4	MVX4900X4F50	●	2	196	203	243	318	50	63	1.7	SO○X16	TPS54	TIP25D
49.0	5	MVX4900X5F40	●	2	245	252	292	357	40	63	1.7	SO○X16	TPS54	TIP25D
49.0	5	MVX4900X5F50	●	2	245	252	292	367	50	63	1.7	SO○X16	TPS54	TIP25D
50.0	2	MVX5000X2F40	●	2	100	107	147	212	40	63	1.6	SO○X16	TPS54	TIP25D
50.0	3	MVX5000X3F40	●	2	150	157	197	262	40	63	1.6	SO○X16	TPS54	TIP25D
50.0	4	MVX5000X4F40	●	2	200	207	247	312	40	63	1.6	SO○X16	TPS54	TIP25D
50.0	4	MVX5000X4F50	●	2	200	207	247	322	50	63	1.6	SO○X16	TPS54	TIP25D
50.0	5	MVX5000X5F40	●	2	250	257	297	362	40	63	1.6	SO○X16	TPS54	TIP25D
50.0	5	MVX5000X5F50	●	2	250	257	297	372	50	63	1.6	SO○X16	TPS54	TIP25D
51.0	2	MVX5100X2F40	●	2	102	109	149	214	40	63	1.5	SO○X16	TPS54	TIP25D
51.0	3	MVX5100X3F40	●	2	153	160	200	265	40	63	1.5	SO○X16	TPS54	TIP25D
51.0	4	MVX5100X4F40	●	2	204	211	251	316	40	63	1.5	SO○X16	TPS54	TIP25D
51.0	4	MVX5100X4F50	●	2	204	211	251	326	50	63	1.5	SO○X16	TPS54	TIP25D
51.0	5	MVX5100X5F40	●	2	255	262	302	367	40	63	1.5	SO○X16	TPS54	TIP25D
51.0	5	MVX5100X5F50	●	2	255	262	302	377	50	63	1.5	SO○X16	TPS54	TIP25D
52.0	2	MVX5200X2F40	●	2	104	111	151	216	40	63	1.39	SO○X16	TPS54	TIP25D
52.0	3	MVX5200X3F40	●	2	156	163	203	268	40	63	1.39	SO○X16	TPS54	TIP25D
52.0	4	MVX5200X4F40	●	2	208	215	255	320	40	63	1.39	SO○X16	TPS54	TIP25D
52.0	4	MVX5200X4F50	●	2	208	215	255	330	50	63	1.39	SO○X16	TPS54	TIP25D
52.0	5	MVX5200X5F40	●	2	260	267	307	372	40	63	1.39	SO○X16	TPS54	TIP25D
52.0	5	MVX5200X5F50	●	2	260	267	307	382	50	63	1.39	SO○X16	TPS54	TIP25D
53.0	2	MVX5300X2F40	●	2	106	113	153	218	40	63	1.29	SO○X16	TPS54	TIP25D
53.0	3	MVX5300X3F40	●	2	159	166	206	271	40	63	1.29	SO○X16	TPS54	TIP25D
53.0	4	MVX5300X4F40	●	2	212	219	259	324	40	63	1.29	SO○X16	TPS54	TIP25D
53.0	4	MVX5300X4F50	●	2	212	219	259	334	50	63	1.29	SO○X16	TPS54	TIP25D
53.0	5	MVX5300X5F40	●	2	265	272	312	377	40	63	1.29	SO○X16	TPS54	TIP25D
53.0	5	MVX5300X5F50	●	2	265	272	312	387	50	63	1.29	SO○X16	TPS54	TIP25D
54.0	2	MVX5400X2F40	●	2	108	115	155	220	40	63	1.19	SO○X16	TPS54	TIP25D
54.0	3	MVX5400X3F40	●	2	162	169	209	274	40	63	1.19	SO○X16	TPS54	TIP25D
54.0	4	MVX5400X4F40	●	2	216	223	263	328	40	63	1.19	SO○X16	TPS54	TIP25D
54.0	4	MVX5400X4F50	●	2	216	223	263	338	50	63	1.19	SO○X16	TPS54	TIP25D
54.0	5	MVX5400X5F40	●	2	270	277	317	382	40	63	1.19	SO○X16	TPS54	TIP25D
54.0	5	MVX5400X5F50	●	2	270	277	317	392	50	63	1.19	SO○X16	TPS54	TIP25D
55.0	2	MVX5500X2F40	●	2	110	117	157	222	40	63	1.08	SO○X16	TPS54	TIP25D
55.0	3	MVX5500X3F40	●	2	165	172	212	277	40	63	1.08	SO○X16	TPS54	TIP25D
55.0	4	MVX5500X4F40	●	2	220	227	267	332	40	63	1.08	SO○X16	TPS54	TIP25D
55.0	4	MVX5500X4F50	●	2	220	227	267	342	50	63	1.08	SO○X16	TPS54	TIP25D
55.0	5	MVX5500X5F40	●	2	275	282	322	387	40	63	1.08	SO○X16	TPS54	TIP25D
55.0	5	MVX5500X5F50	●	2	275	282	322	397	50	63	1.08	SO○X16	TPS54	TIP25D
56.0	2	MVX5600X2F40	●	2	112	119	159	224	40	63	0.98	SO○X16	TPS54	TIP25D
56.0	3	MVX5600X3F40	●	2	168	175	215	280	40	63	0.98	SO○X16	TPS54	TIP25D
56.0	4	MVX5600X4F40	●	2	224	231	271	336	40	63	0.98	SO○X16	TPS54	TIP25D
56.0	4	MVX5600X4F50	●	2	224	231	271	346	50	63	0.98	SO○X16	TPS54	TIP25D

* Clamp Torque (N • m) : TPS54=7.5

INSERT DESCRIPTION	➢ P237
CUTTING CONDITIONS	➢ P238
USAGE NOTE	➢ P248

SPARE PARTS	➢ Q001
TECHNICAL DATA	➢ R001

MVX

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	S10 (mm)	Insert Number	Clamp Screw	D Wrench
56.0	5	**MVX5600X5F40**	●	2	280	287	327	392	40	63	0.98	**SO○X16**	TPS54	TIP25D
56.0	5	**MVX5600X5F50**	●	2	280	287	327	402	50	63	0.98	**SO○X16**	TPS54	TIP25D
57.0	2	**MVX5700X2F40**	●	2	114	121	161	226	40	68	1.47	**SO○X18**	TPS54	TIP25D
57.0	3	**MVX5700X3F40**	●	2	171	178	218	283	40	68	1.47	**SO○X18**	TPS54	TIP25D
57.0	4	**MVX5700X4F40**	●	2	228	235	275	340	40	68	1.47	**SO○X18**	TPS54	TIP25D
57.0	4	**MVX5700X4F50**	●	2	228	235	275	350	50	68	1.47	**SO○X18**	TPS54	TIP25D
57.0	5	**MVX5700X5F40**	●	2	285	292	332	397	40	68	1.47	**SO○X18**	TPS54	TIP25D
57.0	5	**MVX5700X5F50**	●	2	285	292	332	407	50	68	1.47	**SO○X18**	TPS54	TIP25D
58.0	2	**MVX5800X2F40**	●	2	116	123	163	228	40	68	1.37	**SO○X18**	TPS54	TIP25D
58.0	3	**MVX5800X3F40**	●	2	174	181	221	286	40	68	1.37	**SO○X18**	TPS54	TIP25D
58.0	4	**MVX5800X4F40**	●	2	232	239	279	344	40	68	1.37	**SO○X18**	TPS54	TIP25D
58.0	4	**MVX5800X4F50**	●	2	232	239	279	354	50	68	1.37	**SO○X18**	TPS54	TIP25D
58.0	5	**MVX5800X5F40**	●	2	290	297	337	402	40	68	1.37	**SO○X18**	TPS54	TIP25D
58.0	5	**MVX5800X5F50**	●	2	290	297	337	412	50	68	1.37	**SO○X18**	TPS54	TIP25D
59.0	2	**MVX5900X2F40**	●	2	118	125	165	230	40	68	1.26	**SO○X18**	TPS54	TIP25D
59.0	3	**MVX5900X3F40**	●	2	177	184	224	289	40	68	1.26	**SO○X18**	TPS54	TIP25D
59.0	4	**MVX5900X4F40**	●	2	236	243	283	348	40	68	1.26	**SO○X18**	TPS54	TIP25D
59.0	4	**MVX5900X4F50**	●	2	236	243	283	358	50	68	1.26	**SO○X18**	TPS54	TIP25D
59.0	5	**MVX5900X5F40**	●	2	295	302	342	407	40	68	1.26	**SO○X18**	TPS54	TIP25D
59.0	5	**MVX5900X5F50**	●	2	295	302	342	417	50	68	1.26	**SO○X18**	TPS54	TIP25D
60.0	2	**MVX6000X2F40**	●	2	120	127	167	232	40	68	1.16	**SO○X18**	TPS54	TIP25D
60.0	3	**MVX6000X3F40**	●	2	180	187	227	292	40	68	1.16	**SO○X18**	TPS54	TIP25D
60.0	4	**MVX6000X4F40**	●	2	240	247	287	352	40	68	1.16	**SO○X18**	TPS54	TIP25D
60.0	4	**MVX6000X4F50**	●	2	240	247	287	362	50	68	1.16	**SO○X18**	TPS54	TIP25D
60.0	5	**MVX6000X5F40**	●	2	300	307	347	412	40	68	1.16	**SO○X18**	TPS54	TIP25D
60.0	5	**MVX6000X5F50**	●	2	300	307	347	422	50	68	1.16	**SO○X18**	TPS54	TIP25D
61.0	2	**MVX6100X2F40**	●	2	122	129	169	234	40	68	1.05	**SO○X18**	TPS54	TIP25D
61.0	3	**MVX6100X3F40**	●	2	183	190	230	295	40	68	1.05	**SO○X18**	TPS54	TIP25D
61.0	4	**MVX6100X4F40**	●	2	244	251	291	356	40	68	1.05	**SO○X18**	TPS54	TIP25D
61.0	4	**MVX6100X4F50**	●	2	244	251	291	366	50	68	1.05	**SO○X18**	TPS54	TIP25D
61.0	5	**MVX6100X5F40**	●	2	305	312	352	417	40	68	1.05	**SO○X18**	TPS54	TIP25D
61.0	5	**MVX6100X5F50**	●	2	305	312	352	427	50	68	1.05	**SO○X18**	TPS54	TIP25D
62.0	2	**MVX6200X2F40**	●	2	124	131	171	236	40	68	0.95	**SO○X18**	TPS54	TIP25D
62.0	3	**MVX6200X3F40**	●	2	186	193	233	298	40	68	0.95	**SO○X18**	TPS54	TIP25D
62.0	4	**MVX6200X4F40**	●	2	248	255	295	360	40	68	0.95	**SO○X18**	TPS54	TIP25D
62.0	4	**MVX6200X4F50**	●	2	248	255	295	370	50	68	0.95	**SO○X18**	TPS54	TIP25D
62.0	5	**MVX6200X5F40**	●	2	310	317	357	422	40	68	0.95	**SO○X18**	TPS54	TIP25D
62.0	5	**MVX6200X5F50**	●	2	310	317	357	432	50	68	0.95	**SO○X18**	TPS54	TIP25D
63.0	2	**MVX6300X2F40**	●	2	126	133	173	238	40	68	0.85	**SO○X18**	TPS54	TIP25D
63.0	3	**MVX6300X3F40**	●	2	189	196	236	301	40	68	0.85	**SO○X18**	TPS54	TIP25D
63.0	4	**MVX6300X4F40**	●	2	252	259	299	364	40	68	0.85	**SO○X18**	TPS54	TIP25D
63.0	4	**MVX6300X4F50**	●	2	252	259	299	374	50	68	0.85	**SO○X18**	TPS54	TIP25D
63.0	5	**MVX6300X5F40**	●	2	315	322	362	427	40	68	0.85	**SO○X18**	TPS54	TIP25D
63.0	5	**MVX6300X5F50**	●	2	315	322	362	437	50	68	0.85	**SO○X18**	TPS54	TIP25D

⋆ Clamp Torque (N • m) : TPS54=7.5

INSERTS

Shape	Drill Dia.	Insert Number	IC	S	RE	Coated MC5020	Coated MC1020	Coated VP15TF	Coated DP8020	Coated TF15	Geometry
UM	ø14.0—ø16.5	NEW **SOMX052704-UM**	5.0	2.7	0.4	●	●	●			ø.14.0—ø16.5
	ø17.0—ø19.5	**SOMX063005-UM**	6.0	3.0	0.5	●	●	●			
	ø20.0—ø22.5	**SOMX073505-UM**	7.0	3.5	0.5	●	●	●			
	ø23.0—ø27.5	**SOMX084005-UM**	8.3	4.0	0.5	●	●	●			
	ø28.0—ø33.0	**SOMX094506-UM**	9.7	4.5	0.6	●	●	●			
	ø33.5—ø39.0	**SOMX115506-UM**	11.6	5.5	0.6	●	●	●			ø17.0—ø63.0
	ø40.0—ø46.0	**SOMX136008-UM**	13.8	6.0	0.8	●	●	●			
	ø47.0—ø56.0	**SOMX166508-UM**	16.5	6.5	0.8	●	●	●			
General purpose and inner or outer Edge	ø57.0—ø63.0	**SOMX187008-UM**	18.2	7.0	0.8	●	●	●			
US	ø17.0—ø19.5	**SOMX063005-US**	6.0	3.0	0.5			●			
	ø20.0—ø22.5	**SOMX073505-US**	7.0	3.5	0.5			●			
	ø23.0—ø27.5	**SOMX084005-US**	8.3	4.0	0.5			●			
	ø28.0—ø33.0	**SOMX094506-US**	9.7	4.5	0.6			●			
	ø33.5—ø39.0	**SOMX115506-US**	11.6	5.5	0.6			●			
	ø40.0—ø46.0	**SOMX136008-US**	13.8	6.0	0.8			●			
	ø47.0—ø56.0	**SOMX166508-US**	16.5	6.5	0.8			●			
For Stainless Steel and Inner Edge	ø57.0—ø63.0	**SOMX187008-US**	18.2	7.0	0.8			●			
UH	ø17.0—ø19.5	**SOMX062905-UH**	6.0	2.9	0.5				●		
	ø20.0—ø22.5	**SOMX073405-UH**	7.0	3.4	0.5				●		
	ø23.0—ø27.5	**SOMX083905-UH**	8.3	3.9	0.5				●		
	ø28.0—ø33.0	**SOMX094406-UH**	9.7	4.4	0.6				●		
	ø33.5—ø39.0	**SOMX115406-UH**	11.6	5.4	0.6				●		
	ø40.0—ø46.0	**SOMX135908-UH**	13.8	5.9	0.8				●		
	ø47.0—ø56.0	**SOMX166408-UH**	16.5	6.4	0.8				●		
Strong Cutting Edge Type and Inner Edge	ø57.0—ø63.0	**SOMX186908-UH**	18.2	6.9	0.8				●		
UN	ø17.0—ø19.5	**SOGX063005-UN**	6.0	3.0	0.5					●	
	ø20.0—ø22.5	**SOGX073505-UN**	7.0	3.5	0.5					●	
	ø23.0—ø27.5	**SOGX084005-UN**	8.3	4.0	0.5					●	
	ø28.0—ø33.0	**SOGX094506-UN**	9.7	4.5	0.6					●	
	ø33.5—ø39.0	**SOGX115506-UN**	11.6	5.5	0.6					●	
	ø40.0—ø46.0	**SOGX136008-UN**	13.8	6.0	0.8					●	
	ø47.0—ø56.0	**SOGX166508-UN**	16.5	6.5	0.8					●	
Aluminium Alloy and Inner or Outer Edge	ø57.0—ø63.0	**SOGX187008-UN**	18.2	7.0	0.8					●	

Note 1) MC1020 and MC5020 are made exclusively for use as an outer insert. DP8020 are made exclusively for use as an inner insert.

INSERT RECOMMENDATION

		1st Recommendation		When outer insert fractures	
		Outer Insert	Inner Insert	Outer Insert	Inner Insert
P	Mild Steel, Alloy Steel	MC1020	VP15TF	VP15TF	VP15TF
		UM Breaker	**UM Breaker**	**UM Breaker**	**UM Breaker**
M	Stainless Steel	MC1020	VP15TF	VP15TF	VP15TF
		UM Breaker	**US Breaker**	**UM Breaker**	**US Breaker**
K	Cast Iron	MC5020	VP15TF	VP15TF	VP15TF
		UM Breaker	**UM Breaker**	**UM Breaker**	**UM Breaker**

		1st Recommendation		When outer insert fractures	
		Outer Insert	Inner Insert	Outer Insert	Inner Insert
H	Hardened Steel	MC1020	DP8020	VP15TF	DP8020
		UM Breaker	**UH Breaker**	**UM Breaker**	**UH Breaker**
N	Aluminium Alloy	TF15	TF15		
		UN Breaker	**UN Breaker**		

SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

MVX

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Speed (m/min)	Inner Breaker	ϕ14—ϕ16.5mm Feed Rate (mm/rev) L/D=2, 3	4	5
P	Mild Steel (ASTM A36, AISI 1010 etc.)	≤180HB	200 (180—235)	UM	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
				UH	—	—	—
	Carbon Steel, Alloy Steel (AISI 1045, AISI 4140 etc.)	180—280HB	140 (115—180)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
	Carbon Steel, Alloy Steel (AISI 4340 etc.)	280—350HB	100 (75—140)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
	Alloy Tool Steel (SKD, SKT etc.)	≤350HB	135 (100—170)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
M	Austenitic Stainless Steel (AISI 304, AISI 316 etc.)	≤200HB	130 (80—180)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Austenitic Stainless Steel (AISI 304LN, AISI 316LN etc.)	>200HB	130 (80—180)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430 etc.)	≤200HB	120 (80—165)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Ferritic and Martensitic Stainless Steel (AISI 431, AISI 420J2 etc.)	>200HB	120 (80—165)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
K	Gray Cast Iron (FC300 etc.)	Tensile Strength ≤350MPa	160 (130—195)	UM	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)
	Ductile Cast Iron (FCD450 etc.)	Tensile Strength ≤450MPa	100 (80—135)	UM	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)
	Ductile Cast Iron (FCD700 etc.)	Tensile Strength ≤800MPa	100 (70—125)	UM	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)
N	Aluminium Alloy (A6061, A7075)	Si<5%	200 (100—350)	UN	—	—	—
	Aluminium Alloy (AC4B)	5%≤Si≤10%	150 (100—200)	UN	—	—	—
	Aluminium Alloy (ADC12, A390)	Si>10%	150 (100—200)	UN	—	—	—
H	Hardened Steel (AISI H13, JIS SKT4)	38—45HRC	50 (30—80)	UH	—	—	—

Note 1) Reduce the cutting speed by 30% when VP15TF is used as an outer insert.
Note 2) L/D=3 is the recommended maximum depth when only external coolant is used.
Note 3) Internal through coolant is highly necessary when drilling stainless steel.

	ϕ17—ϕ19.5mm				ϕ20—ϕ23.5mm				ϕ24—ϕ29.5mm			
	Feed Rate (mm/rev)				Feed Rate (mm/rev)				Feed Rate (mm/rev)			
	L/D=2, 3	4	5	6	L/D=2, 3	4	5	6	L/D=2, 3	4	5	6
	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	0.06 (0.04—0.08)	0.06 (0.04—0.07)	0.06 (0.04—0.07)	0.04 (0.04—0.05)	0.07 (0.04—0.08)	0.06 (0.04—0.07)	0.06 (0.04—0.07)	0.05 (0.04—0.06)
	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.08)	0.12 (0.08—0.18)	0.10 (0.08—0.12)	0.10 (0.08—0.12)	0.09 (0.08—0.10)
	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.08)	0.12 (0.08—0.18)	0.10 (0.08—0.12)	0.10 (0.08—0.12)	0.09 (0.08—0.10)
	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.08)	0.12 (0.08—0.18)	0.10 (0.08—0.12)	0.10 (0.08—0.12)	0.09 (0.08—0.10)
	0.08 (0.06—0.12)	0.06 (0.04—0.08)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.10 (0.06—0.14)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.09 (0.06—0.12)	0.07 (0.06—0.09)	0.07 (0.06—0.09)	0.06 (0.06—0.08)
	0.08 (0.06—0.12)	0.06 (0.04—0.08)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.10 (0.06—0.14)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.09 (0.06—0.12)	0.07 (0.06—0.09)	0.07 (0.06—0.09)	0.06 (0.06—0.08)
	0.08 (0.06—0.12)	0.06 (0.04—0.08)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.10 (0.06—0.14)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.09 (0.06—0.12)	0.07 (0.06—0.09)	0.07 (0.06—0.09)	0.06 (0.06—0.08)
	0.08 (0.06—0.12)	0.06 (0.04—0.08)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.10 (0.06—0.14)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)	0.09 (0.06—0.12)	0.07 (0.06—0.09)	0.07 (0.06—0.09)	0.06 (0.06—0.08)
	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	0.14 (0.10—0.18)	0.10 (0.10—0.12)	0.10 (0.10—0.12)	0.07 (0.06—0.08)	0.15 (0.10—0.20)	0.11 (0.10—0.13)	0.11 (0.10—0.13)	0.09 (0.08—0.10)
	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	0.13 (0.10—0.16)	0.10 (0.10—0.11)	0.10 (0.10—0.11)	0.07 (0.06—0.08)	0.14 (0.10—0.18)	0.11 (0.10—0.12)	0.11 (0.10—0.12)	0.09 (0.08—0.10)
	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	0.13 (0.10—0.16)	0.10 (0.10—0.11)	0.10 (0.10—0.11)	0.07 (0.06—0.08)	0.14 (0.10—0.18)	0.11 (0.10—0.12)	0.11 (0.10—0.12)	0.09 (0.08—0.10)
	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
	0.08 (0.04—0.12)	0.06 (0.04—0.09)	—	—	0.09 (0.06—0.14)	0.07 (0.06—0.09)	—	—	0.09 (0.06—0.14)	0.07 (0.06—0.09)	—	—

MVX

RECOMMENDED CUTTING CONDITIONS

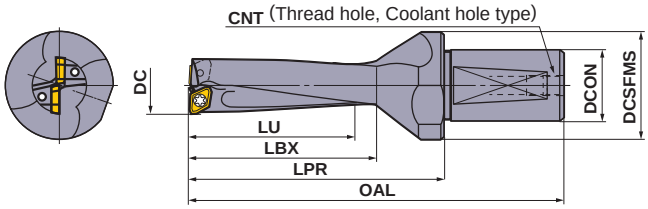
	Work Material	Hardness	Cutting Speed (m/min)	Inner Breaker	ϕ30—ϕ63mm Feed Rate (mm/rev) L/D=2, 3	4	5	6
P	Mild Steel (ASTM A36, AISI 1010 etc.)	≤180HB	200 (180—235)	UM	0.08 (0.06—0.10)	0.07 (0.06—0.08)	0.07 (0.06—0.08)	0.06 (0.06—0.07)
				UH				
	Carbon Steel, Alloy Steel (AISI 1045, AISI 4140 etc.)	180—280HB	140 (115—180)	UM	0.14 (0.08—0.20)	0.12 (0.08—0.16)	0.12 (0.08—0.16)	0.11 (0.10—0.12)
				UH				
	Carbon Steel, Alloy Steel (AISI 4340 etc.)	280—350HB	100 (75—140)	UM	0.14 (0.08—0.20)	0.12 (0.08—0.16)	0.12 (0.08—0.16)	0.11 (0.10—0.12)
				UH				
	Alloy Tool Steel (SKD, SKT etc.)	≤350HB	135 (100—170)	UM	0.14 (0.08—0.20)	0.12 (0.08—0.16)	0.12 (0.08—0.16)	0.10 (0.08—0.12)
				UH				
M	Austenitic Stainless Steel (AISI 304, AISI 316 etc.)	≤200HB	130 (80—180)	US	0.10 (0.06—0.14)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.10)
				UM	0.09 (0.06—0.12)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	Austenitic Stainless Steel (AISI 304LN, AISI 316LN etc.)	>200HB	130 (80—180)	US	0.10 (0.06—0.14)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.10)
				UM	0.09 (0.06—0.12)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	Ferritic and Martensitic Stainless Steel (AISI 410, AISI 430 etc.)	≤200HB	120 (80—165)	US	0.10 (0.06—0.14)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.10)
				UM	0.09 (0.06—0.12)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
	Ferritic and Martensitic Stainless Steel (AISI 431, AISI 420J2 etc.)	>200HB	120 (80—165)	US	0.10 (0.06—0.14)	0.09 (0.06—0.12)	0.09 (0.06—0.12)	0.07 (0.06—0.10)
				UM	0.09 (0.06—0.12)	0.08 (0.06—0.10)	0.08 (0.06—0.10)	0.07 (0.06—0.08)
K	Gray Cast Iron (FC300 etc.)	Tensile Strength ≤350MPa	160 (130—195)	UM	0.15 (0.10—0.20)	0.12 (0.10—0.13)	0.12 (0.10—0.13)	0.11 (0.10—0.12)
	Ductile Cast Iron (FCD450 etc.)	Tensile Strength ≤450MPa	100 (80—135)	UM	0.15 (0.10—0.20)	0.12 (0.10—0.13)	0.12 (0.10—0.13)	0.11 (0.10—0.12)
	Ductile Cast Iron (FCD700 etc.)	Tensile Strength ≤800MPa	100 (70—125)	UM	0.15 (0.10—0.20)	0.12 (0.10—0.13)	0.12 (0.10—0.13)	0.11 (0.10—0.12)
N	Aluminium Alloy (A6061, A7075)	Si<5%	200 (100—350)	UN	0.12 (0.05—0.20)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
	Aluminium Alloy (AC4B)	5%≤Si≤10%	150 (100—200)	UN	0.12 (0.05—0.20)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
	Aluminium Alloy (ADC12, A390)	Si>10%	150 (100—200)	UN	0.12 (0.05—0.20)	0.12 (0.05—0.18)	0.12 (0.05—0.18)	0.08 (0.05—0.12)
H	Hardened Steel (AISI H13, JIS SKT4)	38—45HRC	50 (30—80)	UH	0.11 (0.06—0.16)	0.09 (0.06—0.012)	—	—

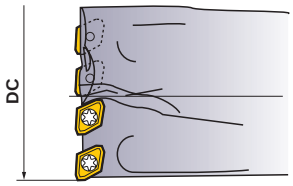
Note 1) Reduce the cutting speed by 30% when VP15TF is used as an outer insert.
Note 2) L/D=3 is the recommended maximum depth when only external coolant is used.
Note 3) Internal through coolant is highly necessary when drilling stainless steel.

TAFS/TAFM/TAFL

- High rigidity holder.
- 4 corner use insert.
- Various grades and chip breakers.

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron			





Number of Teeth = 4 (ϕDC ≥ 49)

✱A screw hole on the flange section is not a coolant hole.

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	CNT	Insert Number	Clamp Screw	F Wrench
12.0	2	TAFS1200F20	●	2	24	29	39	82	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
12.0	3	TAFM1200F20	●	2	36	41	51	94	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
12.5	2	TAFS1250F20	●	2	25	29	39	82	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
12.5	3	TAFM1250F20	●	2	37.5	41	51	94	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
13.0	2	TAFS1300F20	●	2	26	31	41	84	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
13.0	3	TAFM1300F20	●	2	39	44	54	97	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
13.5	2	TAFS1350F20	●	2	27	31	41	84	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
13.5	3	TAFM1350F20	●	2	40.5	44	54	97	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
14.0	2	TAFS1400F20	●	2	28	33	43	86	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
14.0	3	TAFM1400F20	●	2	42	47	57	100	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
14.5	2	TAFS1450F20	●	2	29	33	43	86	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
14.5	3	TAFM1450F20	●	2	43.5	47	57	100	20	25	PT1/8	GCMT040204-U◌	TS2	TKY06F
15.0	2	TAFS1500F20	●	2	30	35	45	88	20	25	PT1/8	GPMT060204-U◌	TS2	TKY06F
15.0	3	TAFM1500F20	●	2	45	50	60	103	20	25	PT1/8	GPMT060204-U◌	TS2	TKY06F
15.5	2	TAFS1550F20	●	2	31	35	45	88	20	25	PT1/8	GPMT060204-U◌	TS2	TKY06F
15.5	3	TAFM1550F20	●	2	46.5	50	60	103	20	25	PT1/8	GPMT060204-U◌	TS2	TKY06F
16.0	2	TAFS1600F25	●	2	32	38	57	107	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
16.0	3	TAFM1600F25	●	2	48	54	73	123	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
16.0	4	TAFL1600F25	●	2	64	70	89	139	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
16.5	2	TAFS1650F25	●	2	33	38	57	107	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
16.5	3	TAFM1650F25	●	2	49.5	54	73	123	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
17.0	2	TAFS1700F25	●	2	34	41	59	109	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
17.0	3	TAFM1700F25	●	2	51	58	76	126	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
17.0	4	TAFL1700F25	●	2	68	75	93	143	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
17.5	2	TAFS1750F25	●	2	35	41	59	109	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
17.5	3	TAFM1750F25	●	2	52.5	58	76	126	25	35	PT1/8	GPMT060204-U◌	TS2	TKY06F
18.0	2	TAFS1800F25	●	2	36	43	61	111	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
18.0	3	TAFM1800F25	●	2	54	61	79	129	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
18.0	4	TAFL1800F25	●	2	72	79	97	147	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
18.5	2	TAFS1850F25	●	2	37	43	61	111	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F

✱ Clamp Torque (N • m) : TS2=0.5, TS25=1.0

● : Inventory maintained in Japan.

INSERT DESCRIPTION	➤ P245
CUTTING CONDITIONS	➤ P246
USAGE NOTE	➤ P249
SPARE PARTS	➤ Q001
TECHNICAL DATA	➤ R001

TAFS/TAFM/TAFL

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	CNT	Insert Number	Clamp Screw	F D Wrench
18.5	3	TAFM1850F25	●	2	55.5	61	79	129	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
19.0	2	TAFS1900F25	●	2	38	46	63	113	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
19.0	3	TAFM1900F25	●	2	57	65	82	132	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
19.0	4	TAFL1900F25	●	2	76	84	101	151	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
19.5	2	TAFS1950F25	●	2	39	46	63	113	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
19.5	3	TAFM1950F25	●	2	58.5	65	82	132	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
20.0	2	TAFS2000F25	●	2	40	48	65	115	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
20.0	3	TAFM2000F25	●	2	60	68	85	135	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
20.0	4	TAFL2000F25	●	2	80	88	105	155	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
20.5	2	TAFS2050F25	●	2	41	48	65	115	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
20.5	3	TAFM2050F25	●	2	61.5	68	85	135	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
21.0	2	TAFS2100F25	●	2	42	50	67	117	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
21.0	3	TAFM2100F25	●	2	63	71	88	138	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
21.0	4	TAFL2100F25	●	2	84	92	109	159	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
21.5	2	TAFS2150F25	●	2	43	50	67	117	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
21.5	3	TAFM2150F25	●	2	64.5	71	88	138	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
22.0	2	TAFS2200F25	●	2	44	53	69	119	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
22.0	3	TAFM2200F25	●	2	66	75	91	141	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
22.0	4	TAFL2200F25	●	2	88	97	113	163	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
22.5	2	TAFS2250F25	●	2	45	53	69	119	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
22.5	3	TAFM2250F25	●	2	67.5	75	91	141	25	35	PT1/8	GPMT070204-U◌	TS25	TKY08F
23.0	2	TAFS2300F25	●	2	46	55	71	121	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
23.0	3	TAFM2300F25	●	2	69	78	94	144	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
23.0	4	TAFL2300F25	●	2	92	101	117	167	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
23.5	2	TAFS2350F25	●	2	47	55	71	121	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
23.5	3	TAFM2350F25	●	2	70.5	78	94	144	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
24.0	2	TAFS2400F25	●	2	48	58	73	123	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
24.0	3	TAFM2400F25	●	2	72	82	97	147	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
24.0	4	TAFL2400F25	●	2	96	106	121	171	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
24.5	2	TAFS2450F25	●	2	49	58	73	123	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
24.5	3	TAFM2450F25	●	2	73.5	82	97	147	25	35	PT1/8	GPMT090304-U◌	TS3	TKY08F
25.0	2	TAFS2500F32	●	2	50	60	75	130	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
25.0	3	TAFM2500F32	●	2	75	85	100	155	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
25.0	4	TAFL2500F32	●	2	100	110	125	180	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
25.5	2	TAFS2550F32	●	2	51	60	75	130	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
25.5	3	TAFM2550F32	●	2	76.5	85	100	155	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
26.0	2	TAFS2600F32	●	2	52	62	77	132	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
26.0	3	TAFM2600F32	●	2	78	88	103	158	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
26.0	4	TAFL2600F32	●	2	104	114	129	184	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
26.5	2	TAFS2650F32	●	2	53	62	77	132	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
26.5	3	TAFM2650F32	●	2	79.5	88	103	158	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
27.0	2	TAFS2700F32	●	2	54	65	79	134	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
27.0	3	TAFM2700F32	●	2	81	92	106	161	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
27.0	4	TAFL2700F32	●	2	108	119	133	188	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
27.5	2	TAFS2750F32	●	2	55	65	79	134	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
27.5	3	TAFM2750F32	●	2	82.5	92	106	161	32	42	PT1/8	GPMT090304-U◌	TS3	TKY08F
28.0	2	TAFS2800F32	●	2	56	67	81	136	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
28.0	3	TAFM2800F32	●	2	84	95	109	164	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D

⋆ Clamp Torque (N • m) : TS25=1.0, TS3=1.0

● : **Inventory maintained in Japan.**

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	CNT	Insert Number	Clamp Screw	D Wrench
28.0	4	TAFL2800F32	●	2	112	123	137	192	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
28.5	2	TAFS2850F32	●	2	57	67	81	136	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
28.5	3	TAFM2850F32	●	2	85.5	95	109	164	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
29.0	2	TAFS2900F32	●	2	58	70	83	138	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
29.0	3	TAFM2900F32	●	2	87	99	112	167	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
29.0	4	TAFL2900F32	●	2	116	128	141	196	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
29.5	2	TAFS2950F32	●	2	59	70	83	138	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
29.5	3	TAFM2950F32	●	2	88.5	99	112	167	32	42	PT1/8	GPMT11T308-U◌	TS4	TKY15D
30.0	2	TAFS3000F40	●	2	60	72	90	155	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
30.0	3	TAFM3000F40	●	2	90	102	120	185	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
30.0	4	TAFL3000F40	●	2	120	132	150	215	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
31.0	2	TAFS3100F40	●	2	62	74	92	157	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
31.0	3	TAFM3100F40	●	2	93	105	123	188	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
31.0	4	TAFL3100F40	●	2	124	136	154	219	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
32.0	2	TAFS3200F40	●	2	64	77	94	159	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
32.0	3	TAFM3200F40	●	2	96	109	126	191	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
32.0	4	TAFL3200F40	●	2	128	141	158	223	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
33.0	2	TAFS3300F40	●	2	66	79	96	161	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
33.0	3	TAFM3300F40	●	2	99	112	129	194	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
33.0	4	TAFL3300F40	●	2	132	145	162	227	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
34.0	2	TAFS3400F40	●	2	68	82	98	163	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
34.0	3	TAFM3400F40	●	2	102	116	132	197	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
34.0	4	TAFL3400F40	●	2	136	150	166	231	40	50	PT1/4	GPMT11T308-U◌	TS4	TKY15D
35.0	2	TAFS3500F40	●	2	70	84	100	165	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
35.0	3	TAFM3500F40	●	2	105	119	135	200	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
36.0	2	TAFS3600F40	●	2	72	86	102	167	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
36.0	3	TAFM3600F40	●	2	108	122	138	203	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
37.0	2	TAFS3700F40	●	2	74	89	104	169	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
37.0	3	TAFM3700F40	●	2	111	126	141	206	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
38.0	2	TAFS3800F40	●	2	76	91	106	171	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
38.0	3	TAFM3800F40	●	2	114	129	144	209	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
39.0	2	TAFS3900F40	●	2	78	94	108	173	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
39.0	3	TAFM3900F40	●	2	117	133	147	212	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
40.0	2	TAFS4000F40	●	2	80	96	110	175	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
40.0	3	TAFM4000F40	●	2	120	136	150	215	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
41.0	2	TAFS4100F40	●	2	82	98	112	177	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
41.0	3	TAFM4100F40	●	2	123	139	153	218	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
42.0	2	TAFS4200F40	●	2	84	101	114	179	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
42.0	3	TAFM4200F40	●	2	126	143	156	221	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
43.0	2	TAFS4300F40	●	2	86	103	116	181	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
43.0	3	TAFM4300F40	●	2	129	146	159	224	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
44.0	2	TAFS4400F40	●	2	88	106	118	183	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
44.0	3	TAFM4400F40	●	2	132	150	162	227	40	50	PT1/4	GPMT140408-U◌	TS55	TKY25D
45.0	2	TAFS4500F40	●	2	90	108	120	185	40	54	PT1/4	GPMT140408-U◌	TS55	TKY25D
45.0	3	TAFM4500F40	●	2	135	153	165	230	40	54	PT1/4	GPMT140408-U◌	TS55	TKY25D
46.0	2	TAFS4600F40	●	2	92	110	122	187	40	54	PT1/4	GPMT140408-U◌	TS55	TKY25D
46.0	3	TAFM4600F40	●	2	138	156	168	233	40	54	PT1/4	GPMT140408-U◌	TS55	TKY25D
47.0	2	TAFS4700F40	●	2	94	113	124	189	40	54	PT1/4	GPMT140408-U◌	TS55	TKY25D

★ Clamp Torque (N • m) : TS4=3.5, TS55=7.5

INSERT DESCRIPTION ➤ P245
CUTTING CONDITIONS ➤ P246
USAGE NOTE ➤ P249
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

TAFS/TAFM/TAFL

DC (mm)	Hole Depth (L/D)	Order Number	Stock	Number of Teeth	Dimensions (mm) LU	LBX	LPR	OAL	DCON	DCSFMS	CNT	Insert Number	Clamp Screw	Wrench (F / D)
47.0	3	**TAFM4700F40**	●	2	141	160	171	236	40	54	PT1/4	**GPMT140408-U◌**	TS55	TKY25D
48.0	2	**TAFS4800F40**	●	2	96	115	126	191	40	54	PT1/4	**GPMT140408-U◌**	TS55	TKY25D
48.0	3	**TAFM4800F40**	●	2	144	163	174	239	40	54	PT1/4	**GPMT140408-U◌**	TS55	TKY25D
49.0	2	**TAFS4900F40**	●	4	98	118	133	198	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
49.0	3	**TAFM4900F40**	●	4	147	167	182	247	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
50.0	2	**TAFS5000F40**	●	4	100	120	135	200	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
50.0	3	**TAFM5000F40**	●	4	150	170	185	250	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
51.0	2	**TAFS5100F40**	●	4	102	122	137	202	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
51.0	3	**TAFM5100F40**	●	4	153	173	188	253	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
52.0	2	**TAFS5200F40**	●	4	104	125	139	204	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
52.0	3	**TAFM5200F40**	●	4	156	177	191	256	40	58	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
53.0	2	**TAFS5300F40**	●	4	106	127	141	206	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
53.0	3	**TAFM5300F40**	●	4	159	180	194	259	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
54.0	2	**TAFS5400F40**	●	4	108	128	143	208	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
54.0	3	**TAFM5400F40**	●	4	162	182	197	262	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
55.0	2	**TAFS5500F40**	●	4	110	130	145	210	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
55.0	3	**TAFM5500F40**	●	4	165	185	200	265	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
56.0	2	**TAFS5600F40**	●	4	112	132	147	212	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F
56.0	3	**TAFM5600F40**	●	4	168	188	203	268	40	63	PT1/4	**GPMT090304-U◌**	TS3	TKY08F

⋆ Clamp Torque (N • m) : TS3=1.0, TS55=7.5

● : Inventory maintained in Japan. (1 insert in one case)

INSERTS

Geometry	Drill Dia.	Insert Number	Dimensions (mm) IC	L	S	RE	Coated VP15TF	UP20M	GP20M	UE6020	US735
U1 Breaker GCMT	ø12.0－ø14.5	**GCMT040204-U1**	–	5.0	2.38	0.4		●			
	ø15.0－ø17.5	**GPMT060204-U1**	5.56	–	2.38	0.4		●		●	
	ø18.0－ø22.5	**GPMT070204-U1**	6.35	–	2.38	0.4		●		●	
	ø23.0－ø27.5 ø49.0－ø56.0	**GPMT090304-U1**	7.94	–	3.18	0.4		●		●	
GPMT	ø28.0－ø34.0	**GPMT11T308-U1**	9.525	–	3.97	0.8		●		●	
	ø35.0－ø48.0	**GPMT140408-U1**	12.70	–	4.76	0.8		●		●	
U2 Breaker GCMT	ø12.0－ø14.5	**GCMT040204-U2**	–	5.0	2.38	0.4	●		●		
	ø15.0－ø17.5	**GPMT060204-U2**	5.56	–	2.38	0.4	●	●		●	●
	ø18.0－ø22.5	**GPMT070204-U2**	6.35	–	2.38	0.4	●	●		●	●
	ø23.0－ø27.5 ø49.0－ø56.0	**GPMT090304-U2**	7.94	–	3.18	0.4	●	●		●	●
GPMT	ø28.0－ø34.0	**GPMT11T308-U2**	9.525	–	3.97	0.8	●	●		●	●
	ø35.0－ø48.0	**GPMT140408-U2**	12.70		4.76	0.8	●	●		●	●
U3 Breaker GPMT	ø15.0－ø17.5	**GPMT060204-U3**	5.56	–	2.38	0.4		●		●	●
	ø18.0－ø22.5	**GPMT070204-U3**	6.35	–	2.38	0.4		●		●	●
	ø23.0－ø27.5 ø49.0－ø56.0	**GPMT090304-U3**	7.94	–	3.18	0.4		●		●	●
	ø28.0－ø34.0	**GPMT11T308-U3**	9.525	–	3.97	0.8		●		●	●
	ø35.0－ø48.0	**GPMT140408-U3**	12.70	–	4.76	0.8		●		●	●

INSERT RECOMMENDATION

■CHIP BREAKER RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material / Breaker	P Mild Steel GCMT	P Mild Steel GPMT	P Carbon Steel GCMT	P Carbon Steel GPMT	P Alloy Steel GCMT	P Alloy Steel GPMT	M Stainless Steel GCMT	M Stainless Steel GPMT	K Gray Cast Iron GCMT	K Gray Cast Iron GPMT	K Ductile Cast Iron GCMT	K Ductile Cast Iron GPMT
U1	◎	◎	○	○	○	○	○	○	○	○	○	○
U2	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
U3		○		○		○		○		○		○

■INSERT GRADE RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material / Grade	P Mild Steel GCMT	P Mild Steel GPMT	P Carbon Steel GCMT	P Carbon Steel GPMT	P Alloy Steel GCMT	P Alloy Steel GPMT	M Stainless Steel GCMT	M Stainless Steel GPMT	K Gray Cast Iron GCMT	K Gray Cast Iron GPMT	K Ductile Cast Iron GCMT	K Ductile Cast Iron GPMT
VP15TF		○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
UP20M	◎	◎	○	○	○	○	○	○	○	○	○	○
GP20M	○		○		○		○		○		○	
UE6020		○		○		○		○		○		○
US735		○		○		○		○		○		○

CUTTING CONDITIONS ➤ P246
USAGE NOTE ➤ P249
SPARE PARTS ➤ Q001
TECHNICAL DATA ➤ R001

TAFS/TAFM/TAFL

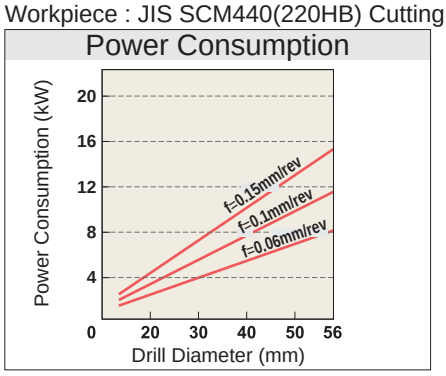
RECOMMENDED CUTTING CONDITIONS

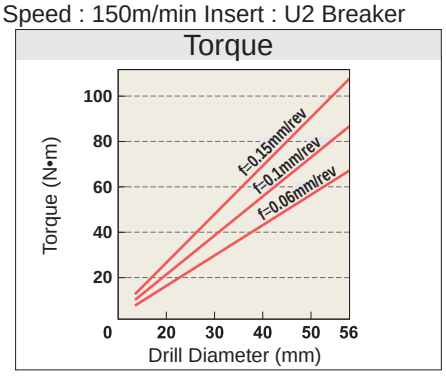
	Work Material	Hardness	Cutting Speed (m/min) For L/D=2,3 (ϕ12–ϕ14.5)	Cutting Speed (m/min) For L/D=2,3 (ϕ15–)	Cutting Speed (m/min) For L/D=4 (ϕ16–)	Breaker	Feed (mm/rev) Drill Diameter (mm) ϕ12–ϕ14.5	ϕ15–ϕ22.5	ϕ23–ϕ34	ϕ35–ϕ48	ϕ49–ϕ56
P	Mild Steel	≤180HB	150 (100–200)	200 (150–300)	140 (100–200)	U1	0.06 (0.04–0.10)	0.07 (0.04–0.10)	0.08 (0.04–0.10)	0.10 (0.04–0.12)	0.08 (0.04–0.10)
						U2	0.06 (0.04–0.10)	0.08 (0.04–0.12)	0.10 (0.04–0.12)	0.12 (0.04–0.14)	0.10 (0.04–0.12)
						U3	–	0.08 (0.04–0.12)	0.10 (0.04–0.12)	0.12 (0.04–0.14)	0.10 (0.04–0.12)
	Carbon Steel	180–280HB	120 (80–160)	150 (120–180)	100 (80–120)	U1	0.06 (0.04–0.10)	0.09 (0.06–0.12)	0.12 (0.08–0.14)	0.15 (0.08–0.18)	0.12 (0.08–0.14)
						U2	0.06 (0.04–0.10)	0.12 (0.06–0.14)	0.14 (0.08–0.18)	0.17 (0.08–0.20)	0.14 (0.08–0.18)
						U3	–	0.12 (0.06–0.14)	0.14 (0.08–0.18)	0.17 (0.08–0.20)	0.14 (0.08–0.18)
	Alloy Steel	180–280HB	120 (80–160)	150 (120–180)	100 (80–120)	U1	0.06 (0.04–0.10)	0.08 (0.06–0.10)	0.09 (0.06–0.12)	0.11 (0.06–0.14)	0.09 (0.06–0.12)
						U2	0.06 (0.04–0.10)	0.10 (0.06–0.12)	0.12 (0.08–0.16)	0.14 (0.08–0.18)	0.12 (0.08–0.16)
						U3	–	0.10 (0.06–0.12)	0.12 (0.08–0.16)	0.14 (0.08–0.18)	0.12 (0.08–0.16)
M	Stainless Steel	≤200HB	100 (80–120)	150 (120–200)	110 (80–140)	U1	0.07 (0.04–0.10)	0.07 (0.04–0.10)	0.08 (0.04–0.10)	0.10 (0.04–0.12)	0.08 (0.04–0.10)
						U2	0.07 (0.04–0.10)	0.08 (0.04–0.12)	0.10 (0.04–0.14)	0.12 (0.04–0.16)	0.10 (0.04–0.14)
						U3	–	0.08 (0.04–0.12)	0.10 (0.04–0.14)	0.12 (0.04–0.16)	0.10 (0.04–0.14)
K	Gray Cast Iron	Tensile Strength ≤350MPa	120 (80–160)	150 (120–180)	140 (110–160)	U1	0.07 (0.06–0.10)	0.07 (0.06–0.10)	0.10 (0.04–0.14)	0.10 (0.06–0.14)	0.10 (0.06–0.14)
						U2	0.07 (0.06–0.10)	0.15 (0.10–0.18)	0.20 (0.10–0.25)	0.20 (0.10–0.25)	0.20 (0.10–0.25)
						U3	–	0.15 (0.10–0.18)	0.20 (0.10–0.25)	0.20 (0.10–0.25)	0.20 (0.10–0.25)
	Ductile Cast Iron	Tensile Strength ≤450MPa	120 (80–150)	150 (120–180)	100 (80–120)	U1	0.06 (0.04–0.10)	0.07 (0.06–0.10)	0.10 (0.06–0.14)	0.10 (0.06–0.14)	0.10 (0.06–0.14)
						U2	0.06 (0.04–0.10)	0.12 (0.08–0.14)	0.15 (0.08–0.20)	0.18 (0.08–0.20)	0.15 (0.08–0.20)
						U3	–	0.12 (0.08–0.14)	0.15 (0.08–0.20)	0.18 (0.08–0.20)	0.15 (0.08–0.20)

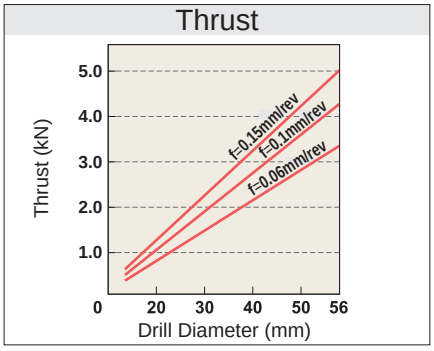
Note 1) When using drills for L/D= 4, the feed should be reduced to 80% of the above recommendations.

■CUTTING RESISTANCE

Workpiece : JIS SCM440(220HB) Cutting Speed : 150m/min Insert : U2 Breaker

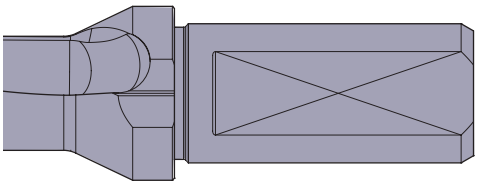


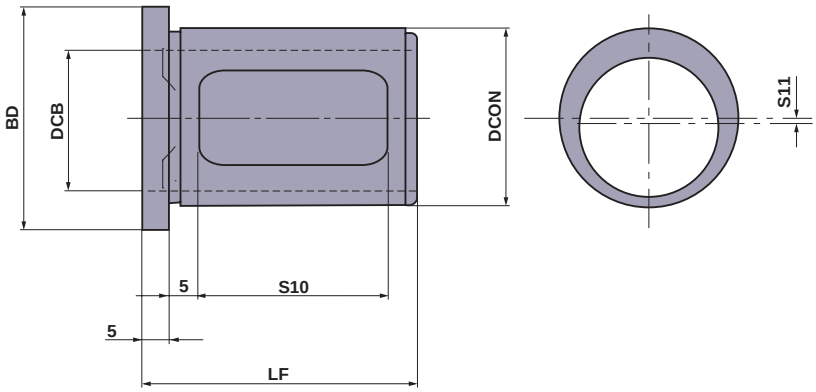




JUST FIT SLEEVE [JFS]

● When intstalling on the drill shank the rotation axis of the drill is slightly decentered. It enables slight enlargement of the machined hole. (enlargement range: 0.1-0.5mm)





Order Number	Stock	Set Order Number	Dimensions (mm)					⋆Increase (S11×2)	MVX Order Number The Last Three Letters
			DCB	DCON	BD	LF	S10		
JFS2520-10	●	**JFS-1**	20	25	33	43	30	0.1	F20
JFS2520-20	●	**JFS-1**	20	25	33	43	30	0.2	F20
JFS2520-30	●	**JFS-1**	20	25	33	43	30	0.3	F20
JFS2520-40	●	**JFS-1**	20	25	33	43	30	0.4	F20
JFS2520-50	●	**JFS-1**	20	25	33	43	30	0.5	F20
JFS3225-10	●	**JFS-2**	25	32	40	50	34	0.1	F25
JFS3225-20	●	**JFS-2**	25	32	40	50	34	0.2	F25
JFS3225-30	●	**JFS-2**	25	32	40	50	34	0.3	F25
JFS3225-40	●	**JFS-2**	25	32	40	50	34	0.4	F25
JFS3225-50	●	**JFS-2**	25	32	40	50	34	0.5	F25
JFS4032-10	●	**JFS-3**	32	40	48	55	40	0.1	F32
JFS4032-20	●	**JFS-3**	32	40	48	55	40	0.2	F32
JFS4032-30	●	**JFS-3**	32	40	48	55	40	0.3	F32
JFS4032-40	●	**JFS-3**	32	40	48	55	40	0.4	F32
JFS4032-50	●	**JFS-3**	32	40	48	55	40	0.5	F32
JFS5040-10	●	–	40	50	68	65	50	0.1	F40
JFS5040-20	●	–	40	50	68	65	50	0.2	F40
JFS5040-30	●	–	40	50	68	65	50	0.3	F40
JFS5040-40	●	–	40	50	68	65	50	0.4	F40
JFS5040-50	●	–	40	50	68	65	50	0.5	F40

It does not correspond to the shank diameter ø50mm.

⋆Increase : Size of the increase in the cutting diameter.

■ Guideline for Selecting a JUST FIT SLEEVE

Desired = (Drillø+ Increase of JFS) + 0.1mm

(E.g.) Desired diameter is ø20.3mm (oversize is taken as 0.1mm).

ø20.3=(MVX2000 X ◌F25+JFS3225-20)+0.1

ø20mm Drill — Using JFS an Increase of 0.2mm. — Oversize

<Tool Selected>
MVX : **MVX2000 X ◌F25**
JUST FIT SLEEVE [JFS]
: **JFS3225-20**

Note 1) Oversize can vary due to the cutting conditions used, please use the above as a guideline.

■ Ordering the JUST FIT SLEEVE

● **Purchasing Method 1**
Oversize can vary due to the cutting conditions used. Therefore it is recommended to purchase as a set. (5 sleeves/set) When placing an order, please use the set order number.

● **Purchasing Method 2**
It is possible to order individually. When placing an order, please use the order number.

● **: Inventory maintained in Japan.**

USAGE NOTE ➤ **P249**
TECHNICAL DATA ➤ **R001**

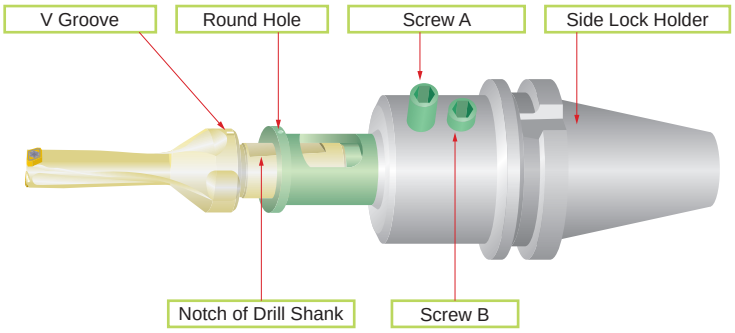
JUST FIT SLEEVE [JFS]

APPLICATION OF JUST FIT SLEEVE

1 When inserting the drill into the side lock holder, aligin the V groove on the outer peripheral edge of the drill flange, as well as the round holes of the outer peripheral edge of the sleeve flange and the screws of the side lock holder for fixing the drill. (If the drill does not have a V groove, align the notch of the drill shank with the round holes of the sleeve.)

2 Insert screws A of the side lock holder directly to the open window of the sleeve and fix the drill. Tighten screw B to a degree so as not to damage the sleeve.

<Note>
- Fine adjustments cannot be made for the diameter
- Cannot be used with collect chuck type holders.

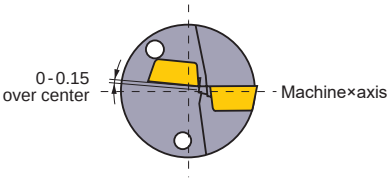


APPLICATION OF MVX TYPE DRILL

●Use on a Lathe

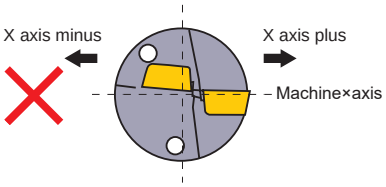
(1)The outer insert and machine X axis must be set parallel. The drill is designed so that when the drill center and the machine spindle center are aligned then the inner insert height is 0-0.15mm lower.

*The inner insert may fracture if the center height of the inner insert is higher than the machine X axis.

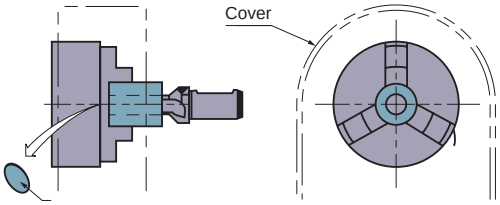


(2)By off setting it is possible to adjust the hole diameter. To do this adjust in the positive X axis direction (hole oversize direction). For the amount of possible adjustment please refer to the dimensions list.

*It is not recommended to adjust in the negative X axis direction as this may lead to drill interference with the hole.



(3)When through hole drilling on a lathe the disc produced by the drill exiting the workpiece may be expelled at high velocity.
To reduce the danger of injury or damage a cover guard is highly recommended.

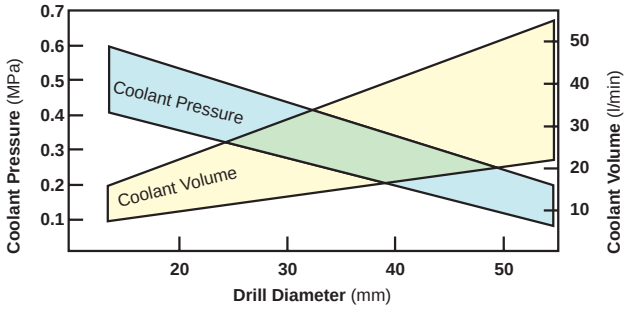


APPLICATION OF TAF TYPE DRILL

●Please ensure the highest rigidity possible exists in both machine set up and workholding.

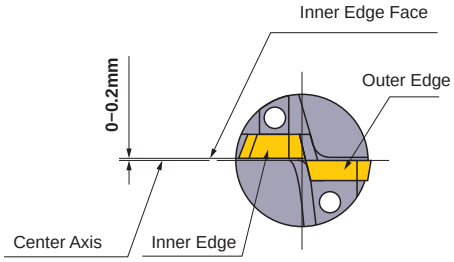
●Refer to the following graph on the right for coolant pressure and volume. Coolant is an important factor in the efficient use of these drills.

●Cannot be used for stack drilling.
In common with many indexable insert drills, these drills produce a round disc on exit which unless evacuated may cause the drill to fracture.

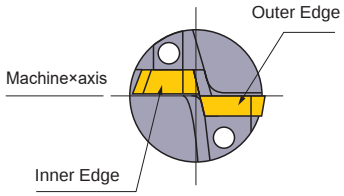


●Use on a Lathe

(1)The inner cutting edge must be positioned between 0—0.2mm over center.

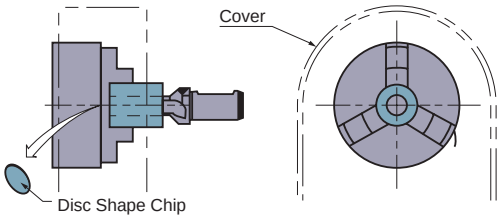


(2)To adjust the hole diameter by off-setting the drill, the outer cutting edge and machine axis must be set parallel.



(3)When producing an oversize hole.
The drill offset should be no more than 2% of the diameter.
It is not possible to produce an undersized hole.

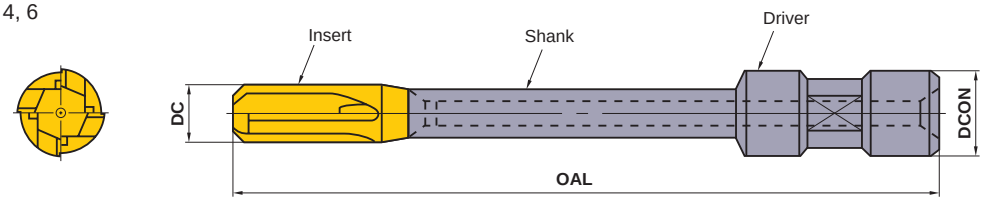
(4)When through hole drilling on a lathe the disc produced by the drill exiting the workpiece may be expelled at high velocity.
To reduce the danger of injury or damage a cover guard is highly recommended.



GUN REAMER

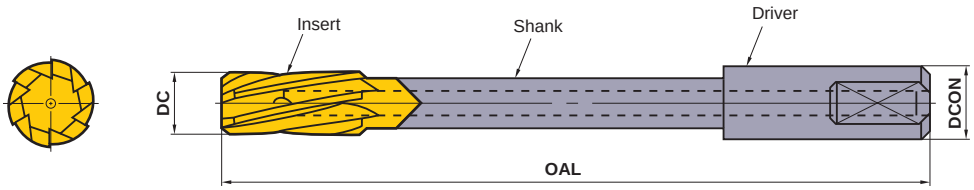
●Straight Reamer Type

●Reamer Diameter : ϕ6.0—ϕ30.0
●Number of teeth : 1, 2, 3, 4, 6



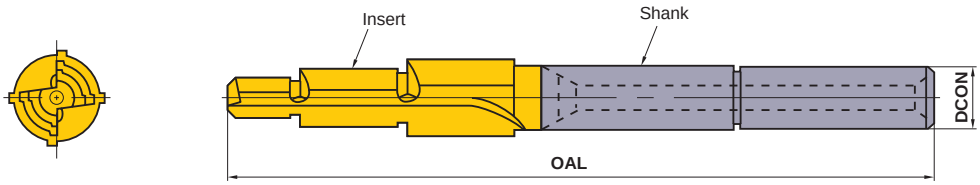
●Spiral Reamer Type

●Reamer Diameter : ϕ6.0—ϕ30.0
●Number of teeth : 4, 6



●Line Reamer Type

●Reamer Diameter : ϕ6.0—ϕ30.0
●Number of teeth : 1, 2, 4

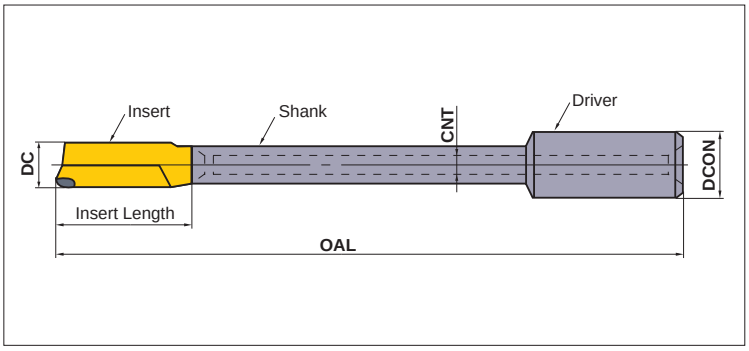


■ORDERING METHOD

Please specify the following when ordering.
①Reamer Name ②Diameter of Reamer (DC) ③Length of Reamer (OAL) ④Outside Diameter of Driver (DCON) and Type
⑤Number of Teeth ⑥Workpiece Material, Drilling Accuracy, Drilling Depth and Drilling Mode (Through Hole, Blind Hole)
e.g.) General Gun Reamer ϕ12 x 450 x ϕ19.5 A type Driver, 4-Teeth, FC250 (180HB) x $\phi 12^{\pm 0.020}$ x 100 x Through Hole

WITH DIAMOND COMPOUND

GUN REAMER



STANDARD

Reamer Diameter	Insert Length	Overall Length OAL	Number of Teeth	Shape of Teeth
ø6−ø30.3	*	*	*	Straight

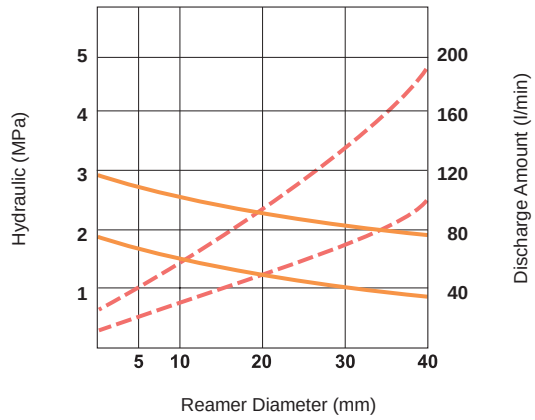
*Please contact us for any geometry (different diameter of reamer, insert length, tool length, number of teeth) that is not in this list.

Reamer Diameter DC	Driver Hole Diameter CNT	External Diameter of Driver DCON
6.0≦DC≦7.0	3.5	12.70
7.0<DC≦13.3	4.8	19.05
13.3<DC≦20.8	6.4	25.40
20.8<DC≦25.3	8.0	31.75
25.3<DC≦30.3	8.0	38.10

RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Speed (m/min)	Feed (mm/rev)		
		ø5 − ø10	ø10 − ø20	ø25 − ø30
Aluminium Alloy	150 (100−200)	0.08 (0.05−0.10)	0.10 (0.05−0.15)	0.10 (0.05−0.15)
Alloy Steel	130 (80−180)	0.03 (0.02−0.04)	0.05 (0.03−0.06)	0.06 (0.04−0.07)

■COOLANT



■ORDERING METHOD

Please specify the following when ordering.

①Reamer Name ②Diameter of Reamer (DC) ③Length of Reamer (OAL) ④Number of Teeth ⑤Outside Diameter of Driver (DCON) and Type ⑥Workpiece Material, Drilling Accuracy, Drilling Depth and Drilling Mode (Through Hole, Blind Hole)

e.g.) Gun Reamer with Diamond Compound ϕ10 x 300 1-Tooth x ϕ19.05 A Type Driver, AC4B x $\phi 10^{+0.01}_{0}$ x 200 x Through Hole

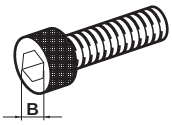
Memo

SPARE PARTS

IDENTIFICATION Q002
SPARE PARTS
- CLAMP SCREW Q003
- SET BOLT Q009
- SHIM Q010
- SHIM PIN AND CLAMP LEVER Q013
- LOCK PIN Q014
- CLAMP BRIDGE Q014
- BREAKER PIECE Q016
- ANTI SEIZE LUBRICANT Q017
- REPLACEMENT PARTS FOR OLD TYPE TOOLS
  - TURNING HOLDERS Q018
  - GROOVING/CUTTING OFF Q023
  - BORING BARS Q024
  - BORING UNITS Q027
  - FACE MILLS Q028
  - INDEXABLE TYPE END MILLS Q034
  - BALL NOSE END MILLS Q039
  - INDEXABLE TYPE DRILLS Q041

IDENTIFICATION

■ IDENTIFICATION OF CLAMP SCREW (Metric Coarse Right Screw Thread)



H SC 060 05

Length

Example	
Symbol	L
05	5
10	10
20	20
30	30

Screw Diameter

Example	
Symbol	d
050	M5
060	M6

● **Hexagonal Hole Dimensions**

Diameter	Pitch	B Dimensions			
		HBH	HFC	HSC	HS◌
M2	0.4	—	—	1.5	0.9
M2.5	0.45	—	—	2	1.3
M3	0.5	2	2	2.5	1.5
M4	0.7	2.5	2.5	3	2
M5	0.8	3	3	4	2.5
M6	1	4	4	5	3
M8	1.25	5	5	6	4
M10	1.5	6	6	8	5

Screw Head

Symbol	Shape
H	⬡
S	⊖
C	✚

Hexagonal Hole Dimensions — H
With Slot — S
With Cross Hole — C

Symbol	Manufacturer	Shape
BH	CHUUBURASHI CO.	Button Head
BHA	UNBRAKO CO.	
FC	CHUUBURASHI CO.	Flat Head
SC	JIS Standard	Socket Head
PM	JIS Standard	Pan Head
FM	JIS Standard	Flat Head
SD	JIS Standard	Set Screw (Cut Point)
SP	JIS Standard	Set Screw (Cone Point)
SR	JIS Standard	Set Screw (Dog Point)
SS	JIS Standard	Set Screw (Flat Point)

■ IDENTIFICATION OF WRENCH

HKY 15 R

Symbol	Wrench
HKY	Hexagonal Wrench
TKY	Torx Wrench
TIP	Torx plus Wrench

Hexagonal Wrench

Symbol	B
15	1.5
20	2
25	2.5
30	3
35	3.5
40	4
50	5
60	6

Torx Wrench

Symbol	B	Size
06	1.7	T6
08	2.3	T8
10	2.7	T10
15	3.3	T15
20	3.8	T20
25	4.4	T25
27	5.0	T27
30	5.5	T30

Torx plus® Wrench

Symbol	Size
06	6IP
07	7IP
08	8IP
15	15IP

R	Standard L Wrench
L	Long L Wrench
T	T Wrench
F FS	Flag Wrench
W	Flag Wrench
D DS	Driver

IMX 10 - WR

Symbol	Wrench
IMX	Wrench for IMX Series

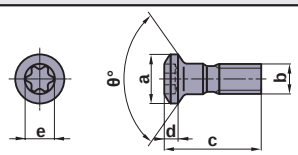
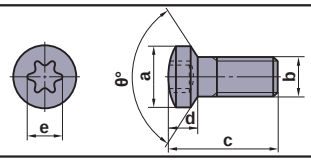
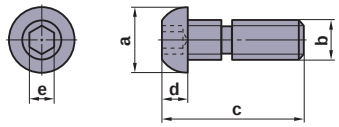
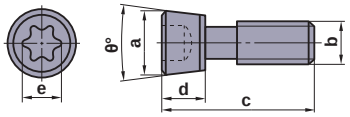
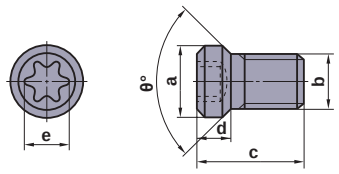
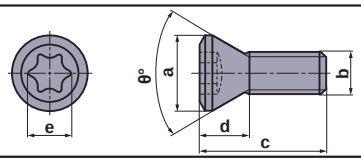
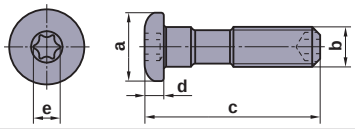
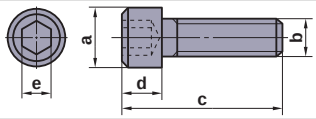
Hexagonal Wrench

Symbol	B
10	10
12	12
16	16
20	20
25	25

WR

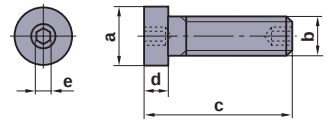
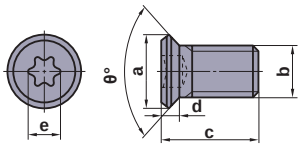
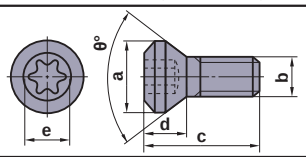
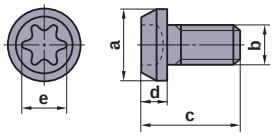
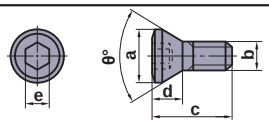
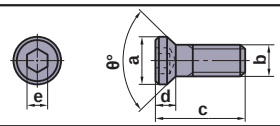
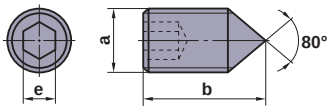
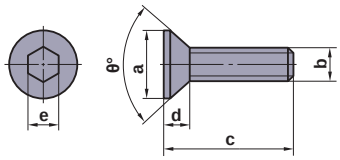
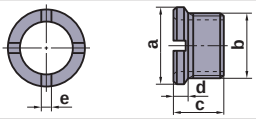
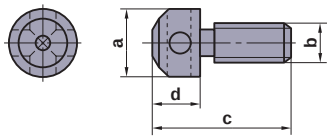
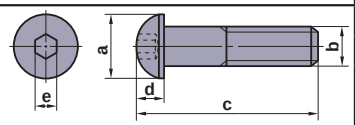
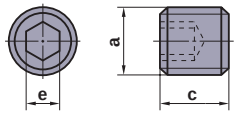
SPARE PARTS

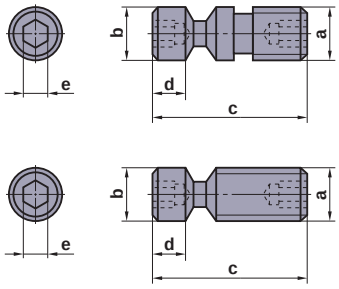
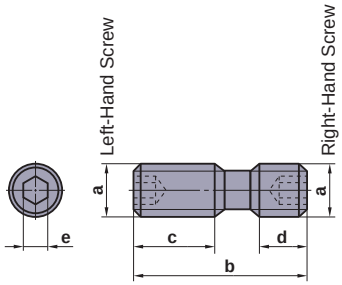
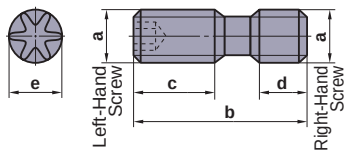
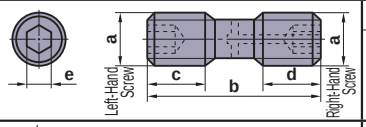
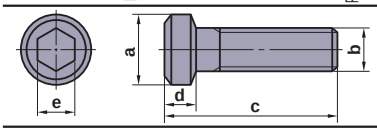
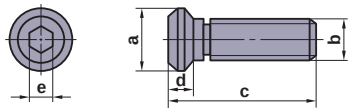
CLAMP SCREW

Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	**AJS3010T10**	5	M3×0.5	10	1.5	2.8	120	T10	2.5	Profile Holder (➲C030) **AJX** (➲M162) **PMC** (➲M254)
	AJS4012T15	7	M4×0.7	12	2.2	3.4	120	T15	3.5	**AJX** (➲M162) **PMC** (➲M254)
	AJS5014T25	8	M5×0.8	14	2.7	4.5	120	T25	7.5	
	**BRS103**	5	M3×0.5	9.9	2.9	3.4	120	T15	3.5	
	BRS105	8	M5×0.8	13.8	3.8	4.5	120	T25	7.5	
	**CS3**(For Use with C3)	7	M4×0.7	14.6	2.6	2.5	—	—	2.2	**F** Type Boring Bar (➲E026)
	CS4(For Use with C4)	9	M5×0.8	15.4	3.4	3	—	—	3.3	
	CS5(For Use with C5)	10.5	M6×1	22	4	4	—	—	7.0	This clamp screw is included with the clamp as a set.
	**CAS51T**	7.9	M5×0.8	19	5	4.5	10	T25	8.5	
	**CS200T**	3.2	M2×0.4	5	1.6	1.8	90	T6	0.6	**F** Type Boring Bar (➲E025)
	CS250T	3.7	M2.5×0.45	6	1.8	2.4	90	T8	1.0	**Milling Tools** Series (➲M001)
	⁎ **CS250560T**	3.9	M2.5×0.45	5.2	2.5	2.4	60	T8	1.0	**BRP** (➲M196)
	CS300590T	4.1	M3×0.5	5.5	2.1	2.4	90	T8	1.0	
	CS300790TS	4.7	M3×0.5	7	2.3	2.8	90	T10	2.0	
	CS300890T	4.1	M3×0.5	8	2.1	2.4	90	T8	1.0	**Boring Unit** (➲N012) **DCCC** (➲M212)
	⁎ **CS350760T**	5.5	M3.5×0.6	7	4	3.4	60	T15	3.5	
	CS350790T	4.8	M3.5×0.6	7	2.4	2.8	90	T10	2.5	**V10000** (➲M070)
	⁎ **CS350860T**	5.5	M3.5×0.6	8.4	4	3.4	60	T15	3.5	**MMTI** Type Boring Bar (➲G028)**BRP** (➲M196)
	CS350990T	4.8	M3.5×0.6	9	2.4	2.8	90	T10	2.5	**OCTACUT** (➲M180) **DCCC** (➲M212)
	CS400990T	6.0	M4×0.7	9	2.8	3.4	90	T15	3.5	
	CS401160T	5.7	M4×0.7	11	4.5	3.4	60	T15	3.5	
	CS401990T	6.0	M4×0.7	19	3.0	3.9	90	T20	3.5	**AL** Holder (➲C032)
	CS451190T	6.3	M4.5×0.75	11	2.9	3.9	90	T20	5.0	
	⁎ **CS501160T**	7.0	M5×0.8	11	3.6	3.9	60	T20	5.0	
	CS501290T	7.0	M5×0.8	11	3.5	4.5	90	T25	7.5	**OCTACUT** (➲M180)
	⁎ **CS5015060T**	7.2	M5×0.8	15	2.4	3.9	60	T20	5.0	**AHX640S** (➲M046)
	CS502190T	8.5	M5×0.8	21	4.0	5.1	90	T27	7.5	
	CS6016060T	8.5	M6×1.0	16	4.5	4.5	60	T25	7.5	
	**CSF401260T**	7.2	M4×0.5	12	5.2	3.9	60	T20	5.0	**PMR** (➲M258)
	**DC0520T**	8.5	M5×0.8	22.5	2.5	3.4	—	T15	3.5	**DOUBLE CLAMP** Holder (➲C008)
	DC0621T	10.5	M6×1.0	25	4	3.9	—	T20	5.0	**DOUBLE CLAMP DIMPLE BAR** (➲E013) **HSK** Tool Holder (➲H001)
	**DKS4**	5.6	M4×0.7	18	3.5	3	—	—	3.3	
	DKS5	7.6	M5×0.8	19	4.5	4	—	—	7.0	

SPARE PARTS

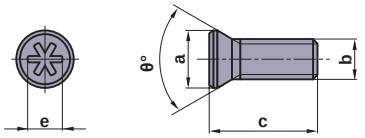
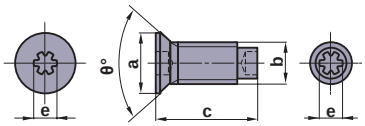
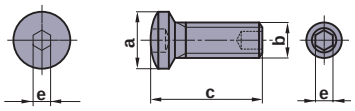
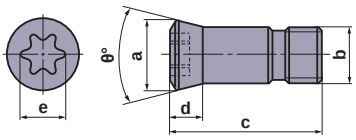
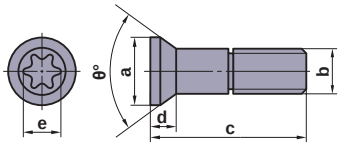
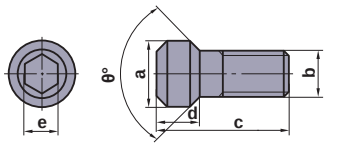
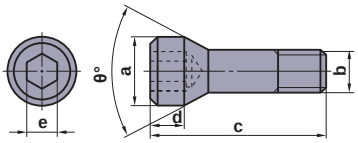
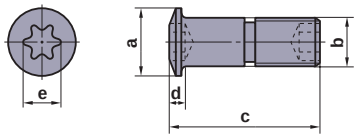
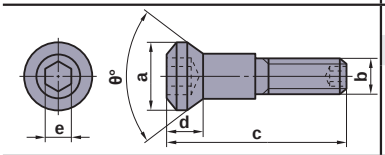
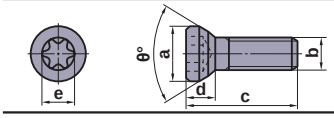
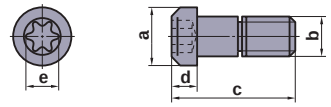
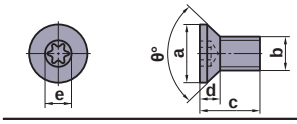
CLAMP SCREW

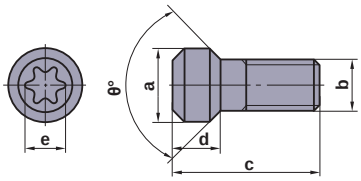
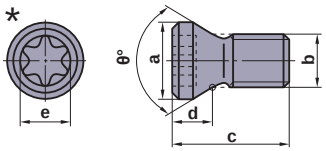
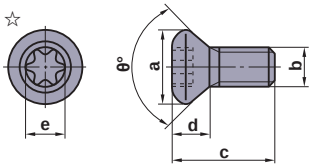
Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	**EGS06019**	9	M6×1	22.5	3.5	3	—	—	3.3	
	EGS08024	11	M8×1.25	28.5	4.5	4	—	—	7.0	
	**FC400890T**	5.6	M4×0.7	7.5	1.3	2.8	90	T10	2.5	**AL** Type Holder (➲C033) **AL** Type Boring Bar (➲E043) **SMG** Type Holder (➲F118,G026)
	**GY05016S**	8.7	M5×0.8	16	3.5	3.9	90	T20	5.0	**GY** Series (➲F004)
	**GY06013M**	12	M6×1.0	18	5	5.6	—	T30	6.0	**GY** Series (➲F004)
	**HFF06015**	10	M6×1	15	6	5	80	—	8.2	
	**HS4L**	5.4	M4×0.7	14	2.3	2.5	80	—	3.8	
	HS5S	6.8	M5×0.8	9	2.8	3	80	—	3.3	
	HS5L	6.8	M5×0.8	15	2.8	3	80	—	6.6	
	**HSP05008C**	M5×0.8	8	—	—	2.5	—	—	2.5	**D** Type Boring Head (➲E042) **MP** Type Holder (➲C018)
	**HY-A1**	4.4	M3×0.5	7	2.1	2	82	—	1.5	**Boring Unit** (➲N012)
	HY-V1	5.5	M3×0.5	7	2.5	2	82	—	1.5	
	HY2	5.5	M3×0.5	10	2.5	2	82	—	1.5	
	HY3	7	M3.5×0.6	12	2.9	2	82	—	1.5	
	HY4	9.3	M5×0.8	16	3.6	3	82	—	3.3	
	**JSS6**	6.9	M6×0.75	4.5	1.5	0.8	—	—	—	
	JSS7	8	M7×0.75	4.4	1.5	1	—	—	—	
	**KS1**	7	M4×0.7	14	5	—	—	—	—	**BC** Type Cartridge (➲N008) **LL** Type Cartridge (➲N006) **MI** Type Boring Bar (➲N015) **SS** Type Cartridge (➲N010) **V10000** (➲M070)
	KS2	10	M6×1	18	7	—	—	—	—	
	KS3	8	M4×0.7	14	6.5	—	—	—	—	
	KS1S	7	M4×0.7	14	5	—	—	—	—	
	KS2S	10	M6×1	18	7	—	—	—	—	
	**KS11**	8	M5×0.8	19	3	3	—	—	3.3	
	KS12	10	M6×1	26	4	4	—	—	7.0	
	KS13	10	M6×1	30	4	4	—	—	7.0	
	KS14	13	M8×1.25	45	5	5	—	—	9.0	
	**LLR1**	M5×0.8	—	3.5	—	2.5	—	—	—	**LL** Type Cartridge (➲N006)
	LLR2	M6×1	—	5	—	3	—	—	—	

Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	☆**LLCS103**	M3×0.5	4	11	4.6	2	—	—	1.5	**LL** Type Holder (➲C008)
	⁎ **LLCS105**	M5×0.8	M5×0.8	10	1.5	2	—	—	1.5	**P** Type Boring Bar (➲E035)
	LLCS106	M6×1	6	16.5	3.5	2.5	—	—	2.2	**D** Type Boring Head (➲E040)
	⁎ **LLCS106S**	M6×1	6	13.4	0.7	2.5	—	—	2.2	**HSK** Tool Holder (➲H001)
	LLCS108	M8×1.25	8	21	6.5	3	—	—	3.3	**KSMG** (➲M252)
	⁎ **LLCS108S**	M8×1.25	8	16.5	2	3	—	—	3.3	**Boring Unit** (➲N012)
	LLCS110	M10×1.5	10	29	8	4	—	—	7.0	**LL** Type Cartridge (➲N006)
	LLCS112	M12×1	11.9	36.2	9	5	—	—	8.0	
	LLCS125	M5×0.8	M5×0.8	12	2	2	—	—	1.5	
	LLCS205	M5×0.8	M5×0.8	16	4	2	—	—	1.5	
	LLCS206	M6×1	6	26	13	2.5	—	—	2.2	
	LLCS208	M8×1.25	8	24	6.5	3	—	—	3.3	
LLCS103, LLCS105 **LLCS112, LLCS125** **LLCS205** The products with "⁎" do not have a hexagonal hole at the end marked **b**. The products with "☆" do not have a hexagonal hole at the end marked **a**.	**LLCS306**	M6×1	6	21	4	2.5	—	—	2.2	
	LLCS308	M8×1.25	8	42	27.5	3	—	—	3.3	
	LLCS310	M10×1	10	29	8	4	—	—	7.0	
	LLCS410	M10×1	10	30	6.6	4	—	—	7.0	
	LLCS508	M8×1	8	24	6.5	3	—	—	3.3	
	⁎ **LLCS508S**	M8×1	8	20.5	3	3	—	—	3.3	
	**LS1**	M6×1	22	8	8	3	—	—	5.0	
	LS2	M8×1	29	13	10	4	—	—	8.2	
	LS3	M8×1	32	13	13	4	—	—	8.2	
	⁎ **LS4**	M6×1	15	8	4	3	—	—	5.0	**Milling Tools** Series (➲M001)
	⁎ **LS5**	M6×1	18	8	5	3	—	—	5.0	
	⁎ **LS6**	M8×1	24	13	5	4	—	—	8.2	
	⁎ **LS7**	M8×1	27	13	8	4	—	—	8.2	
	⁎ **LS8**	M6×0.75	18	7	7	3	—	—	5.0	
	⁎ **LS9**	M6×0.75	22	8	8	3	—	—	5.0	
	⁎ **LS10**	M7×0.75	16	6	6	4	—	—	7.8	**FE404** (➲M266)
	⁎ **LS11**	M8×1	16	6	6	4	—	—	7.8	
	⁎ **LS12**	M8×1	24	7	7	4	—	—	7.8	
	⁎ **LS13**	M8×1	34	12	12	4	—	—	7.8	
	⁎ **LS14**	M7×0.75	24	10	10	4	—	—	7.8	**FP490** (➲M262) **FP590** (➲M264)
The products with "⁎" do not have a hexagonal hole at the end of Right-Hand Screw side.	⁎ **LS15**	M7×0.75	18	6	8	4	—	—	7.8	
	⁎ **LS16**	M7×0.75	23	11	8	4	—	—	7.8	
	⁎ **LS17**	M8×1	42	17	11	4	—	—	7.8	
	⁎ **LS18**	M7×0.75	14	6	4	4	—	—	7.8	
	⁎ **LS20**	M10×1.5	26	9	9	5	—	—	9.0	
	⁎ **LS21**	M10×1.5	32	12	12	5	—	—	9.0	
	LS24	M8×1.25	24	8.5	8.5	4	—	—	7.8	**DOUBLE CLAMP** Holder (➲C014) (For Heavy Cutting)
	LS25	M8×1.0	28.5	12.0	10.5	4	—	—	7.8	
	**LS10T**	M7×0.75	14	6	5	4.5	—	T25	8.0	**NF10000** (➲M072)
	LS14T	M7×0.75	24	10	10	4.5	—	T25	8.0	
	LS15T	M7×0.75	18	7	7	4.5	—	T25	8.0	**AOX445** (➲M060) **SE515** (➲M062) **SG20** (➲M064)
	LS19T	M6×0.75	11	4	4	3.4	—	T15	5.0	
	LS10TS	M7×0.75	13	6	4	4.5	—	T25	8.5	
	LS0622T	M6×0.75	22	8	8	3.4	—	T15	6.0	**AHX640W** (➲M054)
	**LS24H**	M8×1.25	24	8.5	8.5	4	—	—	8.2	
	**MGS6**	10	M6×1	26	4	5	—	—	9.0	
	**MHT1**	11	M8×1	18.5	3.5	4	—	—	8.7	

SPARE PARTS

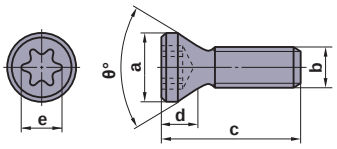
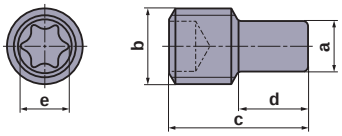
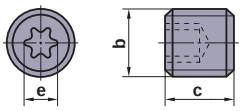
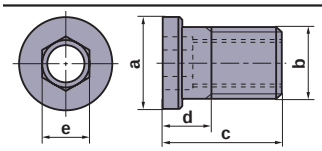
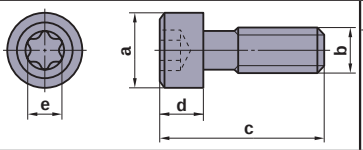
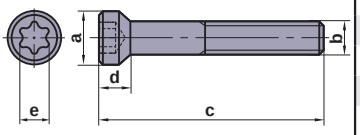
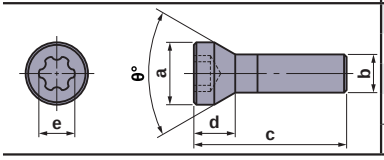
CLAMP SCREW

Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	**NS251**	3.6	M2.5×0.45	7	—	2.2	60	—	0.7	**SMALL TOOLS** (➲D001)
	NS401	5.8	M4×0.7	6	—	3.6	60	—	3.5	
	**NS402W**	5.85	M4×0.7	10	—	2.2	60	—	0.7	**SMALL TOOLS** (➲D001)
	NS403W	5.85	M4×0.7	12	—	2.2	60	—	0.7	
	NS404W	5.8	M4×0.7	10	—	2.2	90	—	0.7	
	**NS501W**	8	M5×0.8	16	—	2.5	120	—	2.2	**SMALL TOOLS** (➲D001)
	NS502W	8	M5×0.8	20	—	2.5	120	—	2.2	
	**RN-S4S**	5.8	M4×0.5	8.4	2.5	3.4	61	T15	3.5	
	RN-S4M	5.8	M4×0.5	10	2.2	3.4	61	T15	3.5	
	RN-S4	5.8	M4×0.5	12.5	2.2	3.4	61	T15	3.5	
	RN-S5	8.1	M5×0.5	15.4	3.6	3.9	61	T20	5.0	
	RN-S6	9.5	M6×0.75	20.3	4.6	3.9	61	T20	5.0	
	RN-S7	11	M7×0.75	24.7	5.2	4.5	61	T25	7.5	
	**RS3008T**	4.3	M3×0.35	8.6	2	2.4	61	T8	1.5	**SRF** Series (➲M228) **SUF** Series (➲M232)
	RS3510T	5	M3.5×0.35	10	2.3	2.8	61	T10	2.5	
	RS4015T	6	M4×0.5	14	2.7	3.4	61	T15	3.3	
	RS5020T	8.1	M5×0.5	16.4	3.6	3.9	61	T20	5.0	
	RS6025T	9.5	M6×0.75	21.5	4.2	4.5	61	T25	7.5	
	RS8030T	12	M8×0.75	25	5	5.6	61	T30	10.0	
	**S1**	3.5	M2×0.4	5.5	2.2	1.5	92	—	1.0	**Boring Unit** (➲N012)
	S3	4.5	M3×0.5	7.7	2.4	2	92	—	1.5	
	S4	5.3	M4×0.7	8	1.8	2.5	62	—	2.2	
	S5	6.8	M5×0.8	9	2.4	3	62	—	3.3	
	**SD32**	12	M8×1.25	28	7.2	6	50	—	9.5	**D** Type Head Arbor (➲E042)
	SD40	12	M8×1.25	36	7.2	6	50	—	9.5	
	SD50	16	M10×1.5	46	8.2	8	50	—	1.0	
	SD63	16	M10×1.5	61	8.2	8	50	—	1.0	
	**SETS51**	6.8	M5×0.8	14.8	1.5	3.4	—	T15	3.5	**HSK** Tool Holder (➲H016)
	SETS61	8	M6×1	20	1.8	3.9	—	T20	5.0	**MMTE** Type Holder (➲G019)
										MMTI Type Boring Bar (➲G028)
	**SLCS105**	10	M5×0.8	25	6.3	4	90	—	7.0	**WP** Type Holder (➲C017)
	SLCS106	12	M6×1	32	6.2	4	90	—	7.0	
	**SPS1**	8.5	M5×0.8	16	4	4.5	70	T25	5.0	
	**SRS5**	6.7	M5×0.8	16	3.5	3.9	—	T20	5.0	
	**STS1**	6.8	M3×0.5	7	2.2	2.8	90	T10	2.5	

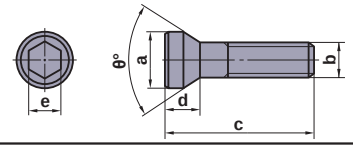
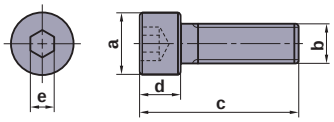
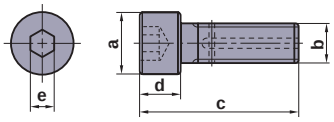
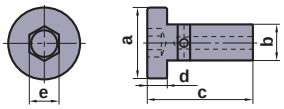
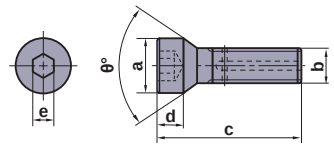
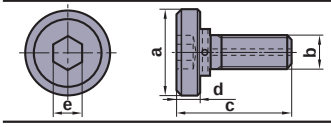
Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	★ **TS16**	2.5	M1.6×0.35	3.2	1.6	1.8	60	T6	0.6	**MICRO-DEX** (➲E016)
	TS2	2.7	M2×0.4	4.6	1.4	1.8	60	T6	0.6	**Boring Unit** (➲N012) **TAF** Drill (➲P241)
	★ **TS2A**	2.7	M2×0.4	4.5	1.2	1.8	60	T6	0.6	**AQX** (➲M154)
	TS2C	2.7	M2×0.4	3.8	1.4	1.8	60	T6	0.6	
	☆ **TS2D**	3.8	M2×0.4	5.3	1.9	1.8	82	T6	0.6	**DIMPLE BAR** (➲E006)
	TS21	2.7	M2×0.4	3.4	1.4	1.8	60	T6	0.6	**F** Type Boring Bar (➲E027)
	★ **TS22**	3.0	M2.2×0.45	5	1.2	1.8	60	T6	0.6	**S** Type Boring Bar (➲E028)
	★ **TS25**	3.3	M2.5×0.45	5.5	1.7	2.4	60	T8	1.0	**AQX** (➲M154) **AJX** (➲M162) **TAF** Drill (➲P241)
	☆ **TS25D**	4.4	M2.5×0.45	6.2	2.2	2.4	82	T8	1.0	**DIMPLE BAR** (➲E006)
	★ **TS25H**	3.6	M2.5×0.45	5.5	2	2.4	60	T8	1.0	**SRM2** (➲M236)
	TS202	2.7	M2×0.4	5.5	1.8	1.8	60	T6	0.6	
	TS253	3.3	M2.5×0.45	4.5	1.7	2.4	60	T8	1.0	**Milling Tools** Series (➲M001)
	TS254	3.3	M2.5×0.45	7	1.7	2.4	60	T8	1.0	**SMALL TOOLS** (➲D001) **PMF** (➲M256)
	★ **TS255**	3.5	M2.5×0.45	7.5	1.6	2.4	60	T8	1.0	**Profile Holder** (➲C030)
	TS3	3.9	M3×0.5	6	2	2.4	60	T8	1.0	**TSMP** (➲M248) **CBJP** (➲M250) **TAF** Drill (➲P241)
	TS3D	5.0	M3×0.5	6	2.3	2.8	82	T10	2.5	**DIMPLE BAR** (➲E006)
	★ **TS3SB**	4.4	M3×0.5	8	2	2.4	80	T8	1.5	**AXD4000** (➲M134)
	TS3SBS	4.4	M3×0.5	6.5	2.0	2.4	80	T8	1.5	**AXD4000** (➲M134)
	☆ **TS31D**	4.8	M3×0.5	7.2	2.2	2.8	82	T10	2.5	**DIMPLE BAR** (➲E007)
	★ **TS32**	3.9	M3×0.5	7.5	2	2.4	60	T8	2.0	**SRM2** (➲M236)
	★ **TS33**	3.9	M3×0.5	6.7	2	2.4	60	T8	1.5	**AQX** (➲M154) **AJX** (➲M162) **PMC** (➲M254)
	TS35	4.8	M3.5×0.6	6.5	2.4	2.8	60	T10	2.5	
	★ **TS35D**	5.3	M3.5×0.6	12	2.8	3.4	60	T15	3.5	**HSK** Tool Holder (➲H013)
★ 	**TS35R**	5.7	M3.5×0.6	10	2.1	3.4	—	T15	3.5	**AHX440S** (➲M038) **AHX475S** (➲M043)
	TS351	4.8	M3.5×0.6	7.2	2.4	2.8	60	T10	2.5	**AJX** (➲M162) **SRM2** (➲M236) **PMC** (➲M254)
	TS352	4.8	M3.5×0.6	10	3	2.8	60	T10	2.5	**VFX5** (➲M220)
	TS4S	5.4	M4×0.7	7	2.4	3.4	80	T15	3.5	
	★ **TS4SL**	5.4	M4×0.7	8	2.4	3.4	80	T15	4.0	**BXD4000** (➲M150)
	★ **TS4SB**	5.8	M4×0.7	9	2.7	3.4	80	T15	3.5	**AXD7000** (➲M142)
	★ **TS4SBL**	5.8	M4×0.7	10.5	2.7	3.4	80	T15	3.5	**GY** SERIES (➲F001) **AXD7000** (➲M142)
☆ 	**TS4**	5.4	M4×0.7	8	2.6	3.4	60	T15	3.5	**SS** Type Cartridge (➲N010) **CE/CF/CGSP** (➲M246) **TSMP** (➲M248)
	TS4D	5.6	M4×0.7	7.7	2.5	3.4	82	T15	3.5	**DIMPLE BAR** (➲E006)
	TS42	5.4	M4×0.7	6	2.6	3.4	60	T15	3.5	
	TS43	5.4	M4×0.7	10	2.6	3.4	60	T15	3.5	**AJX** (➲M162) **BRP** (➲M196) **PMC** (➲M254) **SRM2** (➲M236)
	TS44	5.4	M4×0.7	12	2.6	3.4	60	T15	3.5	
	TS406	5.4	M4×0.7	15.5	2.6	3.4	60	T15	3.5	
	TS407	5.4	M4×0.7	9	2.6	3.4	60	T15	3.5	**AQX** (➲M154) **AJX** (➲M162)
	TS450	5.9	M4.5×0.75	13	3.6	3.9	60	T20	5.0	**VFX6** (➲M224)
	TS5S	6.8	M5×0.8	9	2.9	4.5	80	T25	7.5	
	★ **TS5SL**	6.8	M5×0.8	12	2.9	4.5	80	T25	7.5	
	TS5	6.8	M5×0.8	9	3.2	4.5	60	T25	7.5	**SP** Holder (➲C022) **CE/CF/CGSP** (➲M246) **TSMP** (➲M248)
	TS5L	6.8	M5×0.8	15	2.9	4.5	80	T25	7.5	
	TS5R	6.9	M5×0.8	12	3.5	3.9	60	T20	5.0	**WJX** (➲M172)
	TS52	6.8	M5×0.8	8	3.2	4.5	60	T25	7.5	**CESP/CFSP/CGSP** (➲M246)
	TS53	6.8	M5×0.8	16	3.2	4.5	60	T25	7.5	
	TS54	6.8	M5×0.8	12	3.2	4.5	60	T25	7.5	**AJX** (➲M162)
	TS55	6.8	M5×0.8	10.5	3.2	4.5	60	T25	7.5	**GY** SERIES (➲F001) **AQX** (➲M154) **SPX** (➲M215) **SRM2** (➲M236)
	★ **TS6S**	8.5	M6×1.0	13	4.4	5.6	60	T30	10.0	**AQX** (➲M154) **SRM2** (➲M244)
	★ **TS6**	8.5	M6×1.0	16	4.4	5.6	60	T30	10.0	**SRM2** (➲M244)

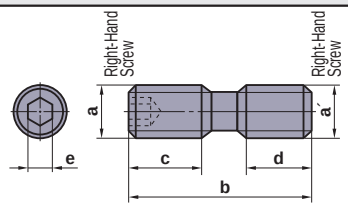
SPARE PARTS

CLAMP SCREW

Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	**TPS20**	2.7	M2×0.4	3.5	1.3	1.8	60	6IP	0.5	**ARX** (➲M192)
	TPS22	3.0	M2.2×0.45	4.7	1.6	2.1	60	7IP	0.5	**ARX** (➲M192)
	TPS22S	3.0	M2.2×0.45	4.2	1.6	2.1	60	7IP	0.5	**ARX** (➲M192)
	TPS25	3.3	M2.5×0.45	5.5	1.7	2.1	60	7IP	1.0	**APX3000** (➲M096) **MVS** (➲P022)
	TPS25-1	3.3	M2.5×0.45	6.5	1.7	2.1	60	7IP	1.0	**APX3000** (➲M096)
	TPS27F1	3.7	M2.7×0.35	6.5	1.8	2.1	60	7IP	1.0	**VPX200** (➲M110)
	TPS27F2	3.7	M2.7×0.35	8.0	1.8	2.1	60	7IP	1.0	**VPX200** (➲M110)
	TPS3	3.9	M3×0.5	6.7	1.4	2.82	60	10IP	1.0	**MVX** (➲P231)
	TPS35	5.3	M3.5×0.6	11.5	2.8	3.4	60	15IP	3.5	**ASX445** (➲M030) **ASX400** (➲M080) **PMR** (➲M258)
	TPS351	4.8	M3.5×0.6	7.2	1.4	2.82	60	10IP	2.5	**MVX** (➲P231)
	TPS351B	5.1	M3.5×0.6	7.2	1.4	2.82	60	10IP	2.5	**ARP** (➲M186)
	TPS4	5.3	M4×0.7	8	2.6	3.4	60	15IP	3.5	**APX4000** (➲M102) **ARP** (➲M186) **MVX** (➲P232)
	TPS40F1	5.3	M4×0.5	10.5	2.8	3.4	60	15IP	3.0	**VPX300** (➲M122)
	TPS43	5.3	M4×0.7	10	2.6	3.4	60	15IP	4.0	**APX4000** (➲M102) **MVX** (➲P233)
	TPS4R	6.4	M4×0.7	10.6	2.9	3.4	60	15IP	3.5	**WSX445** (➲M018)
	TPS54	6.8	M5×0.8	12	3.2	4.5	60	25IP	7.5	**MVX** (➲P234)
	**TSR05008S**	3.5	M5×0.8	8	—	2.8	—	T10	—	
	TSR06011S	4	M6×1.0	11	—	3.9	—	T20	—	
	**TSS04005**	—	M4×0.7	5	—	2.4	—	T8	—	**PMF** (➲M256)
	TSS04505S	—	M4.5×0.7	5	—	3.5	—	T10	3.5	**FMAX** (➲M066)
	TSS05006	—	M5×0.8	6	—	2.8	—	T10	—	**BC** Type Cartridge (➲N008)
	TSS06010	—	M6×1	10	—	3.9	—	T20	—	**SS** Type Cartridge (➲N010)
	**WCS503507H**	6.3	M5×0.5	7	3.3	3.5	—	—	5.0	**ASX445** (➲M030) **ASX400** (➲M080) **PMR** (➲M258)
	WCS604010H	7.8	M6×0.75	10	4.1	4.0	—	—	7.0	**PMR** (➲M258)
	**WS1**	8.5	M5×0.8	19	5	4.5	—	T25	7.5	
	**WS254012T**	4	M2.5×0.45	11.5	2.2	2.4	80	T8	2.0	**TAW** Drill (➲P219)
	WS254013T	4	M2.5×0.45	12.5	2.2	2.4	80	T8	2.0	
	WS254014T	4	M2.5×0.45	13.5	2.2	2.4	80	T8	2.0	
	WS254015T	4	M2.5×0.45	14.5	2.2	2.4	80	T8	2.0	
	WS254016T	4	M2.5×0.45	15.5	2.2	2.4	80	T8	2.0	
	WS304517T	4.5	M3×0.5	16.5	3.4	2.8	60	T10	3.5	
	WS304518T	4.5	M3×0.5	17.5	3.4	2.8	60	T10	3.5	
	WS355520T	5.5	M3.5×0.6	19.5	3.9	3.4	60	T15	5.5	
	WS355521T	5.5	M3.5×0.6	20.5	3.9	3.4	60	T15	5.5	
	WS406023T	6	M4×0.7	22.0	4.4	4.5	60	T25	8.5	
	WS406024T	6	M4×0.7	23.0	4.4	4.5	60	T25	8.5	
	WS508026T	8	M5×0.8	25.0	5.2	5.1	60	T27	12.0	
	WS508027T	8	M5×0.8	26.0	5.2	5.1	60	T27	12.0	
	**WS203107TPS**	3.1	M2×0.25	7.3	1.7	1.8	60	6IP	1.0	**STAW** Drill (➲P218)
	WS203108TPS	3.1	M2×0.25	8.3	1.9	1.8	60	6IP	1.0	
	WS253909TPS	3.9	M2.5×0.35	9.5	2.4	2.4	60	8IP	2.0	
	WS304912TPS	4.9	M3×0.35	12	3.25	2.82	60	10IP	2.5	

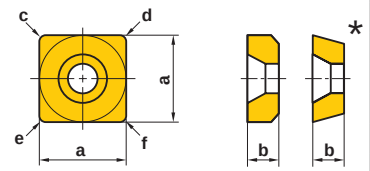
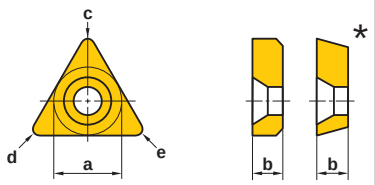
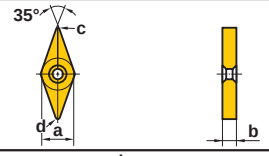
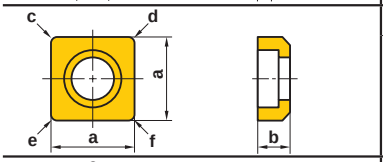
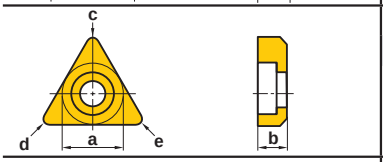
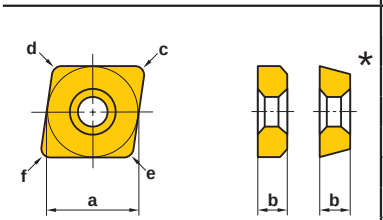
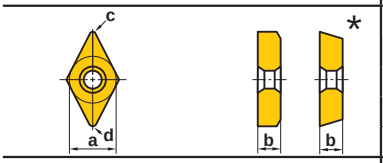
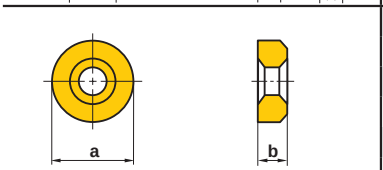
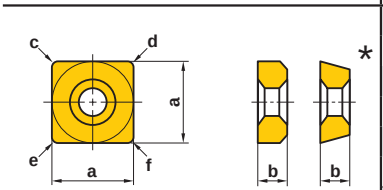
SET BOLT

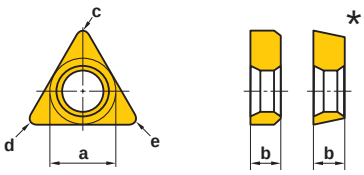
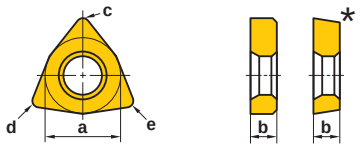
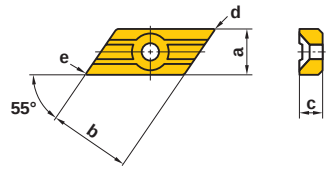
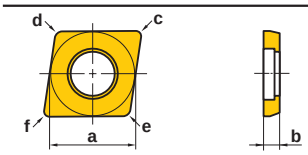
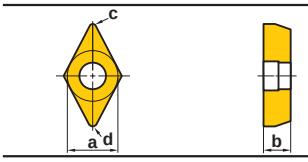
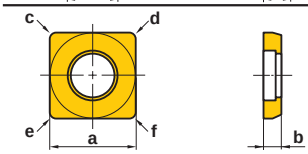
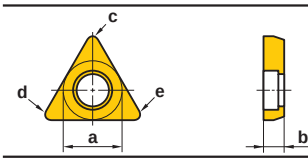
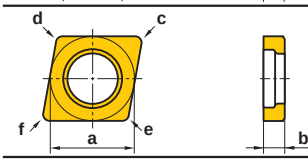
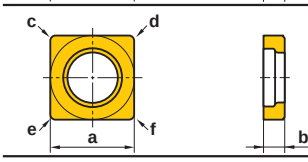
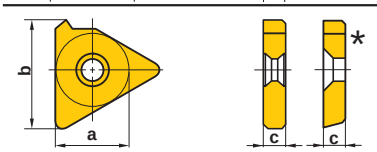
Geometry	Order Number	Dimensions (mm) a	b	c	d	e	Angle θ°	Drive Size	Torque (N•m)	Tool Holder
	**BOES101**	15	M10×1.5	45	10	8	60	—	10.0	**OCTACUT** (➲M180)
	∗**HSC08030H**	13	M8×1.25	38	8	5	—	—	24	**APX3000/4000** (➲M096, M102)
	HSC08040	13	M8×1.25	48	8	6	—	—	24	**WSX445** (➲M018)
	HSC08050	13	M8×1.25	58	8	6	—	—	24	**AXD4000** (➲M134) **AXD7000** (➲M142)
	∗**HSC10030H**	16	M10×1.5	40	10	6	—	—	40	**APX** (➲M102) **AJX** (➲M162) **WSX445** (➲M018)
	HSC10035	16	M10×1.5	45	10	8	—	—	44	**BXD** (➲M150)
	HSC10045	16	M10×1.5	55	10	8	—	—	44	**VFX5/6** (➲M220)
	HSC10055	16	M10×1.5	65	10	8	—	—	44	**AHX475S** (➲M043) **AHX640S** (➲M046)
	HSC12035	18	M12×1.75	47	12	10	—	—	80	**WSX445** (➲M018)
	∗**HSC12035H**	18	M12×1.75	47	12	10	—	—	80	**APX3000/4000** (➲M096, M102) **AJX** (➲M162)
	HSC12045	18	M12×1.75	57	12	10	—	—	80	**WSX445** (➲M018)
	**HSC12070**	18	M12×1.75	82	12	10	—	—	80	
	HSC16040	24	M16×2	56	16	14	—	—	150	
	∗**HSC16040H**	24	M16×2	56	16	14	—	—	150	**APX3000/4000** (➲M096, M102) **AJX** (➲M162)
	HSC16080	24	M16×2	96	16	14	—	—	150	
∗ With coolant hole.	**HSC20040**	30	M20×2.5	60	20	17	—	—	320	
	HSC20090	30	M20×2.5	110	20	17	—	—	320	
	**HSCX12030H**	24	M12×1.75	37	7	8	—	—	40	**FMAX** (➲M067)
	HSCX16035H	30	M16×2	44	9	12	—	—	100	
	HSCX16045H	30	M16×2	54	9	12	—	—	100	
	HSCX20035H	36	M20×2.5	46	11	14	—	—	180	
	**HFF08043H**	11	M8×1.25	43	5	5	90	—	8.2	**AXD4000** (➲M134) **BXD** (➲M150)
	**MBA16033H**	40	M16×2	43	10	14	—	—	150	**AHX640** (For ϕ100) (➲M046)
	MBA20040H	50	M20×2.5	54	14	17	—	—	320	**WSX445** (➲M018) **APX4000** (➲M102) **AHX475S** (➲M043) **AHX640S** (➲M046)
	MBA24045H	65	M24×3	59	14	17	—	—	520	**AXD4000** (➲M134) **AXD7000** (➲M142) **AJX** (➲M162) **BXD** (➲M150)

Geometry	Order Number	Dimensions (mm) a	a′	b	c	d	e	Torque (N•m)	Tool Holder
	**HDS08030**	M8×0.75	M8×1.25	30	13.5	11.5	4	8.2	**BRP** (➲M196)
	HDS10031	M10×1.0	M10×1.5	31	14	12	5	9.0	**OCTACUT** (➲M180) **PMF** (➲M256)

SPARE PARTS

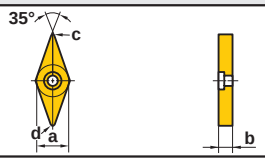
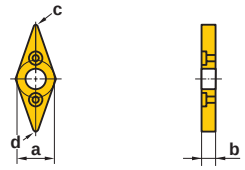
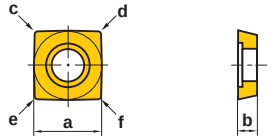
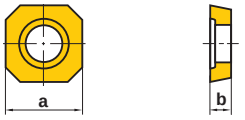
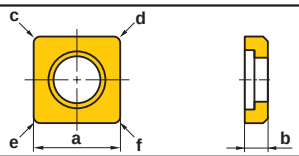
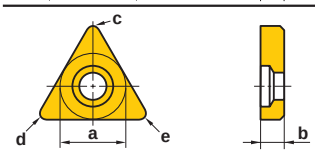
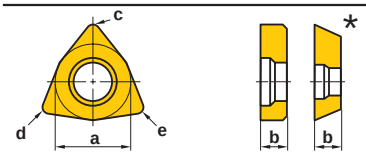
SHIM

Geometry	Order Number	Dimensions (mm) a	b	c	d	e	f	Tool Holder
	**CS32**	9.52	3.18	0.8	0.8	1.2	1.2	
	CS42	12.70	3.18	0.8	0.8	1.2	1.6	
	CS43	12.70	4.76	0.8	0.8	1.2	1.6	
	CS62	19.05	3.18	1.2	1.2	1.6	1.6	
	⁎ **PS31**	8.28	2.38	0.2	0.2	0.6	0.6	
	⁎ **PS42**	11.46	3.18	0.2	0.2	0.6	1.0	**BC** Type Cartridge (➲N008)
	⁎ **PS62**	17.20	3.18	0.3	0.3	0.7	0.7	
	**CT22**	6.35	3.18	0.4	0.8	1.2	—	
	CT32	9.52	3.18	0.4	0.8	1.2	—	
	CT33	9.52	4.76	0.4	0.8	1.2	—	
	CT42	12.70	3.18	0.4	0.8	1.2	—	
	⁎ **PT21**	5.11	2.38	0.2	0.2	0.6	—	
	⁎ **PT32**	8.28	3.18	0.2	0.2	0.6	—	**F** Type Boring Bar (➲E026)
	⁎ **PT42**	10.85	3.18	0.3	0.3	0.7	—	
	BPT322	7.8	3.18	—	—	—	—	
	**DCSVN32**	9.52	3.18	0.8	1.2	—	—	**DOUBLE CLAMP** Holder (➲C018) **DOUBLE CLAMP DIMPLE BAR** (➲E015)
	**ESS42**	12.70	3.18	0.8	0.8	1.2	1.6	
	**EST32**	9.52	3.18	0.4	0.8	1.2	—	
	EST43	12.70	4.76	0.4	0.8	1.2	—	
	**LLSCN3T3**	9.52	3.97	0.4	0.4	0.8	0.8	**DOUBLE CLAMP** Holder (➲C008) **DOUBLE CLAMP DIMPLE BAR** (➲E013) **D** Type Boring Head (➲E040) **HSK** Tool Holder (➲H001) **LL** Type Holder (➲C008) **LL** Type Cartridge (➲N006) **P** Type Boring Bar (➲E035)
	LLSCN33	9.52	4.76	0.4	0.4	0.8	0.8	
	LLSCN42	12.70	3.18	0.8	0.8	1.2	1.2	
	LLSCN53	15.87	4.76	1.2	1.2	1.6	1.6	
	LLSCN63	19.05	4.76	1.2	1.2	1.6	1.6	
	⁎ **LLSCP42**	12.70	3.18	0.8	0.8	1.2	1.2	**DOUBLE CLAMP DIMPLE BAR** (➲E013)
	⁎ **LLSCP63**	19.05	4.76	1.2	1.2	1.6	1.6	**HSK** Tool Holder (➲H001) **P** Type Boring Bar (➲E035)
	**LLSDN32**	9.52	3.18	0.8	1.2	—	—	**DOUBLE CLAMP** Holder (➲C008) **DOUBLE CLAMP DIMPLE BAR** (➲E013) **D** Type Boring Head (➲E040) **HSK** Tool Holder (➲H001) **LL** Type Holder (➲C008) **P** Type Boring Bar (➲E035)
	LLSDN42	12.70	3.18	0.8	1.2	—	—	
	LLSDN43	12.70	4.76	0.8	1.2	—	—	
	LLSDN53	15.87	4.76	1.2	1.6	—	—	
	⁎ **LLSDP42**	12.70	3.18	0.8	1.2	—	—	**DOUBLE CLAMP DIMPLE BAR** (➲E013)
	**LLSRN103**	8.3	3.18	—	—	—	—	**HSK** Tool Holder (➲H001) **LL** Type Holder (➲C024)
	LLSRN123	9.8	3.18	—	—	—	—	
	LLSRN164	13.6	4.76	—	—	—	—	
	LLSRN204	17.3	4.76	—	—	—	—	
	LLSRN256	22.0	6.35	—	—	—	—	
	LLSRN326	28.0	6.35	—	—	—	—	
	**LLSSN32**	9.52	3.18	0.8	0.8	1.2	1.2	**LL** Type Holder (➲C012) **LL** Type Cartridge (➲N006) **P** Type Boring Bar (➲E035)
	LLSSN33	9.52	4.76	0.8	0.8	1.2	1.2	
	LLSSN42	12.70	3.18	0.8	0.8	1.2	1.6	
	LLSSN53	15.87	4.76	1.2	1.2	1.6	1.6	
	LLSSN63	19.05	4.76	1.2	1.2	1.6	2.0	
	LLSSN84	25.40	6.35	1.6	1.6	2.4	2.4	
	⁎ **LLSSP42**	12.70	3.18	0.8	0.8	1.2	1.6	

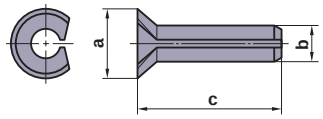
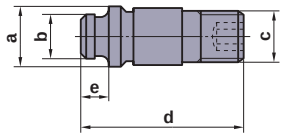
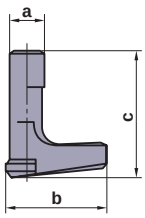
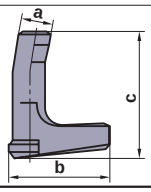
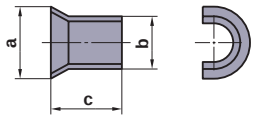
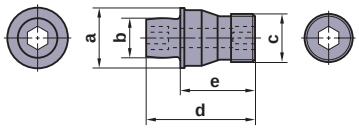
Geometry	Order Number	Dimensions (mm)						Tool Holder
		a	b	c	d	e	f	
	**LLSTE32**	7.6	3.18	0.4	0.4	0.4	—	**DOUBLE CLAMP** Holder (➲C016)
	LLSTN32	9.52	3.18	0.4	0.8	1.2	—	**DOUBLE CLAMP DIMPLE BAR** (➲E014)
	LLSTN33	9.52	4.76	0.4	0.8	1.2	—	**Boring Unit** (➲N012)
	LLSTN42	12.70	3.18	0.4	0.8	1.2	—	**D** Type Boring Head (➲E040)
	LLSTN53	15.87	4.76	0.8	1.2	1.6	—	**LL** Type Holder (➲C008)
	⁎**LLSTP32**	9.52	3.18	0.4	0.8	1.2	—	**LL** Type Cartridge (➲N006)
	⁎**LLSTP42**	12.70	3.18	0.4	0.8	1.2	—	**P** Type Boring Bar (➲E035)
	**LLSWN32**	9.52	3.18	0.4	0.8	1.2	—	**DOUBLE CLAMP** Holder (➲C021)
	LLSWN3T3	9.52	3.97	0.4	0.8	1.2	—	**DOUBLE CLAMP DIMPLE BAR** (➲E015)
	LLSWN42	12.70	3.18	0.4	0.8	1.2	—	**LL** Type Holder (➲C008)
	⁎**LLSWP32**	9.52	3.18	0.4	0.8	1.2	—	
	⁎**LLSWP42**	12.70	3.18	0.4	0.8	1.2	—	
	**MHS532R/L**	9.4	15.7	4.5	0.8	0.8	—	
	MHS533R/L	9.4	15.7	4.5	1.2	1.2	—	
	MHS534R/L	9.4	15.7	4.5	1.6	1.6	—	
	MHS542R/L	9.4	15.7	6.5	0.8	0.8	—	
	MHS543R/L	9.4	15.7	6.5	1.2	1.2	—	
	MHS544R/L	9.4	15.7	6.5	1.6	1.6	—	
	**MLCP42**	12.58	3.18	1.2	1.2	1.2	1.2	**P** Type Boring Bar (➲E036)
	**MLDP42**	12.56	3.18	1.2	1.2	—	—	**P** Type Boring Bar (➲E036)
	**MLSP42**	12.63	3.18	1.2	1.2	1.2	1.2	**P** Type Boring Bar (➲E035)
	**MLTP32**	9.50	3.18	1.2	1.2	1.2	—	**P** Type Boring Bar (➲E035)
	**MSCN63**	18.8	4.76	1.6	1.6	1.6	1.6	**DOUBLE CLAMP** Holder (For Heavy Cutting) (➲C014)
	**MSSN63**	18.8	4.76	1.6	1.6	1.6	1.6	**DOUBLE CLAMP** Holder (For Heavy Cutting) (➲C014)
	**CT32T1**	9.525	15.03	3.18	—	—	—	
	⁎**PT32T1R**	8.28	13.34	3.18	—	—	—	
	⁎**PT32T2R**	8.28	13.19	3.18	—	—	—	
	⁎**PT42TR**	10.85	17.20	3.18	—	—	—	

SPARE PARTS

SHIM

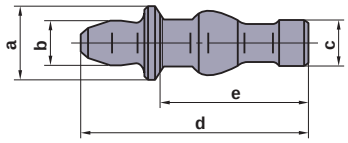
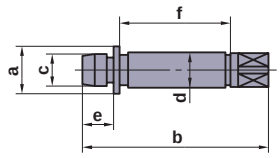
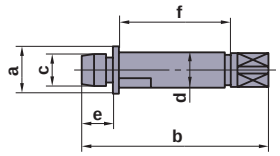
Geometry	Order Number	Dimensions (mm)						Tool Holder
		a	b	c	d	e	f	
	**PV321**	9.52	3.18	0.4	0.4	—	—	**MP** Type Holder (➲C019)
	PV322	9.52	3.18	0.8	0.8	—	—	
	PV323	9.52	3.18	1.2	1.2	—	—	
	**SPSVN32**	8.06	3.18	0.3	0.3	—	—	**HSK** Tool Holder (➲H001) **SP** Type Holder (➲C028)
	**STASX400N**	11.00	3.00	0.4	0.4	0.4	0.4	**ASX400** (➲M080)
	**STASX445N**	10.76	3.00	—	—	—	—	**ASX445** (➲M030)
	**STBS500N**	12.7	3.18	0.8	0.8	0.8	0.8	
	**WPSTN33**	9.3	4.76	0.8	0.4	1.2	—	**WP** Type Holder (➲C017)
	WPSTN43	12.50	4.76	0.8	0.4	1.2	—	
	＊**WPSWC43**	12.50	4.76	0.4	0.8	1.2	—	
	WPSWN43	12.50	4.76	0.4	0.8	1.2	—	

SHIM PIN AND CLAMP LEVER

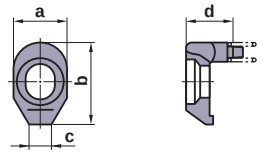
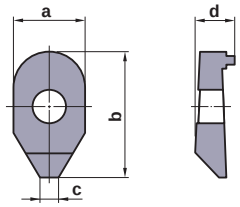
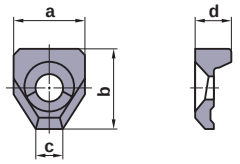
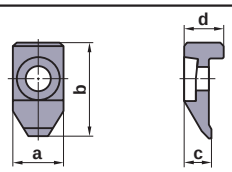
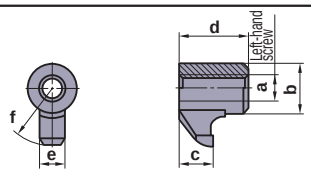
Geometry	Order Number	Dimensions (mm)					Tool Holder
		a	b	c	d	e	
	**BCP141**	3.0	1.4	5.6	—	—	**SP** Type Holder (➲C028)
	BCP201	4.3	2	7.4	—	—	**F** Type Boring Bar (➲E026)
	BCP202	4.3	2	6.4	—	—	**HSK** Tool Holder (➲H013)
	BCP251	4.8	2.5	7.4	—	—	**BC** Type Cartridge (➲N008)
	BCP252	4.8	2.5	6.4	—	—	
	BCP301	5.3	3	7.4	—	—	
	BCP401	6.3	4	7.4	—	—	
	**CCP33**	6.5	3.66	M5×0.8	18.5	3	**WP** Holder (➲C017)
	CCP34	7.5	5.0	M6×1.0	18.5	3	
	CCP44	7.5	5.0	M5×0.8	14.2	3	
	**LLCL12S**	2.1	9.3	5.6	—	—	**LL** Type Holder (➲C008)
	LLCL13	3.6	10	12.5	—	—	**LL** Type Cartridge (➲N006)
	LLCL13S	3.6	10	7.8	—	—	**D** Type Boring Head (➲E040)
	LLCL14	4.7	13.4	13.2	—	—	**HSK** Tool Holder (➲H001)
	LLCL14S	4.7	13.6	12.2	—	—	**KSMG** (➲M252)
	LLCL15	6.0	19	17	—	—	**Boring Unit** (➲N012)
	LLCL16	7.5	20.8	21	—	—	**P** Type Boring Bar (➲E035)
	LLCL18	8.6	25.4	25.2	—	—	
	LLCL23	3.6	12.0	11.5	—	—	
	LLCL23S	3.6	11.6	9.5	—	—	
	LLCL24	4.7	16.2	14.8	—	—	
	LLCL25	6.0	17.1	17	—	—	
	**LLCL110**	3.0	10.7	11.6	—	—	
	LLCL112	3.5	13	13.5	—	—	
	LLCL116	4.5	18.5	18	—	—	
	LLCL120	5.6	20.3	19	—	—	
	LLCL125	6	24	24	—	—	
	LLCL132	8	30	27	—	—	
	**LLP13**	5.55	4.85	5.3	—	—	**LL** Type Holder (➲C008)
	LLP14	7.25	6.55	5.8	—	—	**DOUBLE CLAMP** Holder (➲C008)
	LLP15	8.8	8.05	8.6	—	—	**DOUBLE CLAMP DIMPLE BAR** (➲E013)
	LLP16	10.85	9.85	11.1	—	—	**P** Type Boring Bar (➲E035)
	LLP18	15.35	13.05	12.0	—	—	**D** Type Boring Head (➲E040)
	LLP23	5.55	4.85	6.8	—	—	**HSK** Tool Holder (➲H001)
	LLP24	7.25	6.55	9.1	—	—	**KSMG** (➲M252)
							Boring Unit (➲N006)
							LL Type Cartridge (➲N006)
	**MP6**	11.9	7.8	M10×1	22.1	15	**DOUBLE CLAMP** Holder (For Heavy Cutting) (➲C014)

SPARE PARTS

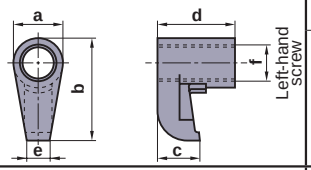
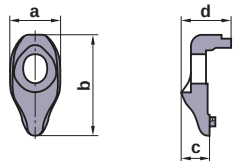
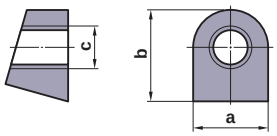
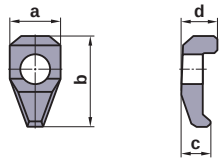
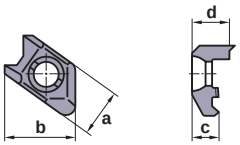
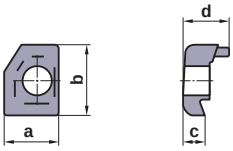
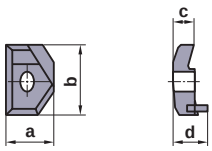
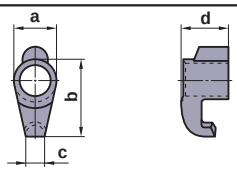
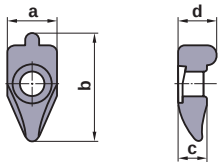
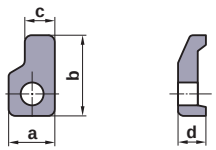
LOCK PIN

Geometry	Order Number	Dimensions (mm)						Tool Holder
		a	b	c	d	e	f	
	**P11S**	6	3.7	4	17	11.1	—	**D** Type Boring Head (➲E042) **MP** Type Holder (➲C018)
	P21S	7.5	4.9	4.5	17.2	11.5	—	
	**P221US**	4	18	2.11	3.5	3.3	7.7	
	P321US	5.5	18	3.64	5.0	3.3	7.5	
	P322US	5.5	21	3.64	5.0	3.3	10.5	
	P323US	5.5	24	3.64	5.0	3.3	13.5	
	P332US	5.5	21	3.64	5.0	4.9	8.9	
	**P323WS**	5.75	24	3.64	5.0	3.3	12.9	
	P333WS	5.75	24	3.64	5.0	4.9	11.3	
	P334WS	5.75	30	3.64	5.0	4.9	17.3	
	P433W	7.75	24	5.03	7.0	4.9	10.8	
	P434W	7.75	30	5.03	7.0	4.9	16.8	

CLAMP BRIDGE

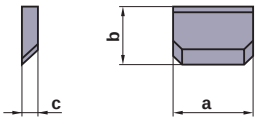
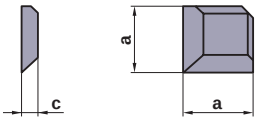
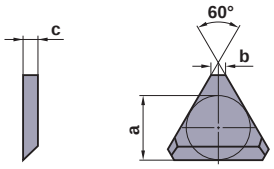
Geometry	Order Number	Dimensions (mm)						Tool Holder
		a	b	c	d	e	f	
	**AMS3**	7	12	3	3.3	—	—	**Profile** Holder (➲C030) **AJX** (➲M162)
	AMS4	9	13.5	3	3.8	—	—	
	AMS5	10	15	3.5	5	—	—	
	**CA142**	8	15	4	7	—	—	
	CA150	9	16	4.5	7	—	—	
	CA151	10	17	5	7	—	—	
	CA152	10	19	5	7	—	—	
	CA153	10	24	5	7	—	—	
	CA161	13	20	6	8	—	—	
	CA162	13	24	6	8	—	—	
	CA163	13	27	6	8	—	—	
	CA181	16	30	8	10	—	—	
	CA183	16	37	8	10	—	—	
	**CCK13**	15	18.5	6	9	—	—	**WP** Type Holder (➲C017)
	CCK14	19	22	8	9.5	—	—	
	**CCTC1**	13	25	7	10.2	—	—	
	**CK231**	M6×1	8	4	7.5	4.5	9.5	
	CK232	M6×1	8	4.5	8	4.5	11.5	
	CK341	M8×1	11	5.5	13.5	6	13.5	
	CK342	M8×1	11	6	14	6	16.5	

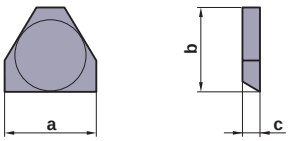
CLAMP BRIDGE

Geometry	Order Number	Dimensions (mm)						Tool Holder
		a	b	c	d	e	f	
	**CKW6**	10.9	22.5	9.2	16.8	5	M8×1	**DOUBLE CLAMP** Holder (For Heavy Cutting) (➲C014)
	**DCK2211**	11	22	6.57	11.1	—	—	**DOUBLE CLAMP** Holder (➲C008) **DOUBLE CLAMP DIMPLE BAR** (➲E013) **HSK** Tool Holder (➲H001)
	DCK2613	13	26.5	7.35	12.9	—	—	
	DCK3113	13	31	9	14.5	—	—	
	**KGC1**	12.0	15.0	M7×0.75	—	—	—	**UG** Type Holder (➲F114)
	**LK1**	8	14.3	4.5	5.9	—	—	
	**MHK5NR/L**	15.5	23.5	8.1	12.1	—	—	
	**MTK1R/L**	13	17.5	5	12	—	—	**HSK** Tool Holder (➲H001) **MG** Type Holder (➲F116) **MT** Type Holder (➲G024) **MT1** Type Holder (➲G024)
	**MTK2R/L**	18	28	7	14	—	—	
	**SETK51**	6.8	14.5	2.9	8	—	—	**MMTE** Type Holder (➲G019) **MMTI** Type Holder (➲G029) **HSK** Tool Holder (➲H001)
	SETK61	8.9	18.1	4.1	8.6	—	—	
	**SRK1R**	9.4	21	5.5	7.5	—	—	
	**UCR**	12	24	8	7	—	—	

SPARE PARTS

BREAKER PIECE

Geometry	Order Number	Dimensions (mm)					Tool Holder
		a	b	c	Inscribed Circle	Breaker Width	
	**CBS3**	9.4	8.0	1.5	9.525	1.5	
	CBS4	12.6	9.2	2.5	12.70	3.5	
	CBS4N	12.6	10.2	2.5	12.70	2.5	
	CBS4F	12.6	11.2	2.5	12.70	1.5	
	CBS6	18.9	14.6	2.5	19.05	4.5	
	CBS6N	18.9	16.6	2.5	19.05	2.5	
	CBS6F	18.9	17.6	2.5	19.05	1.5	
	**CBS3D**	8.0	—	1.5	9.525	1.5	
	CBS4D	10.2	—	2.5	12.70	2.5	
	CBS6D	15.6	—	2.5	19.05	3.5	
	**CBT2**	5.33	1.4	1.5	6.35	1.5	**F** Type Boring Bar (➲E026) *For positive inserts, the breaker width is 0.5mm larger than the figures in the list.
	CBT2N	5.67	1.4	1.5	6.35	1.0	
	CBT3	7.20	1.4	2.5	9.525	3.5	
	CBT3N	7.87	1.4	2.5	9.525	2.5	
	CBT3F	8.53	1.4	2.5	9.525	1.5	
	CBT4	9.73	1.4	2.5	12.70	4.5	
	CBT4N	11.07	1.4	2.5	12.70	2.5	
	CBT4F	11.73	1.4	2.5	12.70	1.5	

Geometry	Order Number	Dimensions (mm)			Thread Pitch (mm)	Tool Holder
		a	b	c		
	**CBT3106**	11.5	10.6	2.0	2.5—3.0	
	CBT3113	11.5	11.3	2.0	1.5—2.0	
	CBT3120	11.5	12	2.0	0.75—1.25	
	CBT4108	13.3	10.8	2.0	3.5—4.0	
	CBT4128	13.3	12.8	2.0	4.5—5.0	

ANTI SEIZE LUBRICANT

ANTI SEIZE LUBRICANT

Shape	Order Number	Stock	Volume (g)
	MK1K	●	20
	MK1KS	●	3

● : **Inventory maintained in Japan.**

REPLACEMENT PARTS FOR OLD TYPE TOOLS (TURNING HOLDERS)

EG TYPE HOLDER

Old Type Tool Number			
Type	Size	Clamp Screw	Wrench
EGHR	**2020K03**	EGS06019	HKY30R
	2525M3	EGS06019	HKY30R
	2525M4	EGS08024	HKY40R
	2525M5	EGS08024	HKY40R
	2525M7	EGS08024	HKY40R
	2525M8	EGS08024	HKY40R

ET TYPE HOLDER

Old Type Tool Number							
Type	Size	Clamp Bridge	Clamp Screw	Shim Screw	Shim	Breaker Piece	Wrench
ETHR	**2525M16**	CK341	LS2	CFM02008	PT32T1R PT32T2R	CBT3106 CBT3113 CBT3120	HKY40R

LL TYPE HOLDER

Old Type Tool Number						
Type	Size	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
PCFNR/L PCLNR/L PCBNR/L	**1616H09**	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
	2020K09	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
	2525M09	LLSCN3T3	LLP13	LLCL13	LLCS106	HKY25R
	2020K12	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
	2525M12	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R
	2525M16	LLSCN53	LLP15	LLCL25	LLCS508	HKY30R
	3225P16	LLSCN53	LLP15	LLCL25	LLCS508	HKY30R
	4040R19	LLSCN63	LLP16	LLCL16	LLCS310	HKY40R
PTANR/L PTBNR/L PTTNR/L PTGNR/L PTFNR/L	**1010E11**	–	–	LLCL12S	LLCS105	HKY20F
	1212F11	–	–	LLCL12S	LLCS105	HKY20F
	1616H16	LLSTN32	LLP13	LLCL13	LLCS106	HKY25R
	2020K16	LLSTN32	LLP13	LLCL13	LLCS106	HKY25R
	2525M16	LLSTN32	LLP13	LLCL13	LLCS206	HKY25R
	2525M22	LLSTN42	LLP14	LLCL14	LLCS108	HKY30R
	3225P22	LLSTN42	LLP14	LLCL14	LLCS108	HKY30R
	3232P22	LLSTN42	LLP14	LLCL14	LLCS108	HKY30R
	4040R27	LLSTN53	LLP15	LLCL25	LLCS508	HKY30R
PSBNR/L PSSNR/L PSKNR/L	**3225P12**	LLSSN42	LLP14	LLCL14	LLCS108	HKY30R
	2525M15	LLSSN53	LLP15	LLCL25	LLCS508	HKY30R
	3232P15	LLSSN53	LLP15	LLCL25	LLCS508	HKY30R
	3232P19	LLSSN63	LLP16	LLCL16	LLCS310	HKY40R
	4040R19	LLSSN63	LLP16	LLCL16	LLCS310	HKY40R
	5050T25	LLSSN84	LLP18	LLCL18	LLCS112	HKY50R
PRGCR/L PRDCN	**2020K10**	LLSRN103	LLP13	LLCL110	LLCS205	HKY20R
	2020K12	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R
	3225P12	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R
	3225P16	LLSRN164	LLP24	LLCL116	LLCS306	HKY25R
	4040R25	LLSRN256	LLP16	LLCL125	LLCS410	HKY40R
	5050T32	LLSRN326	LLP18	LLCL132	LLCS112	HKY50R

MC TYPE HOLDER

Old Type Tool Number								
Type	Size	Shim	Shim Pin	Clamp Bridge	Clamp Screw	Breaker Piece	Wrench	Spring
CTANR/L CTGNR/L	**1616**	CT22	BCP201	CK231	LS1	CBT2◌	HKY30R	–
	2020	CT32	BCP301	CK341	LS2	CBT3◌	HKY40R	–
	2525	CT32	BCP301	CK341	LS3	CBT3◌	HKY40R	–
CSTNR/L CSSNR/L	**1616**	CS32	BCP251	CK232	LS1	CBS3◌	HKY30R	–
	2020	CS42	BCP301	CK341	LS2	CBS4◌	HKY40R	–
	2525M43	CS42	BCP301	CK341	LS3	CBS4◌	HKY40R	–
CTAPR/L	**2020**	PT32	BCP201	CK341	LS2	CBT3◌	HKY40R	–
CSBPR/L CSSPR/L CSKPR/L	**1616**	PS31	BCP201	CK232	LS1	CBS3◌	HKY30R	–
	2020	PS42	BCP251	CK342	LS2	CBS4◌	HKY40R	–
CTCPR/L	**2020K16**	BPT322	BCP201	CCTC1	HSC06020	CBT3◌	HKY50R	MES3
	2525M16	BPT322	BCP201	CCTC1	HSC06020	CBT3◌	HKY50R	MES3

MG TYPE HOLDER

Old Type Tool Number					
Type	Size	Clamp Bridge	Clamp Screw	Spring	Wrench
MGHR/L	**2020K3333**	MTK1L/R	HBH06020	MES3	HKY40R
	2020K4447	MTK1L/R	HBH06020	MES3	HKY40R
	3232P5660	MTK2L/R	MGS6	MES3	HKY50R
	3232P5670	MTK2L/R	MGS6	MES3	HKY50R
	3232P5680	MTK2L/R	MGS6	MES3	HKY50R

MG2 TYPE HOLDER

Old Type Tool Number					
Type	Size	Clamp Bridge	Clamp Screw	Spring	Wrench
MG2R/L	**2525M4315**	MTK1R/L	HBH06020	MES3	HKY40R
	2525M4323	MTK1R/L	HBH06020	MES3	HKY40R
	2525M4333	MTK1R/L	HBH06020	MES3	HKY40R

REPLACEMENT PARTS FOR OLD TYPE TOOLS (TURNING HOLDERS)

MH TYPE HOLDER

Old Type Tool Number							
Type	Size	Shim	Shim Pin	Clamp Bridge	Clamp Screw	Stop Ring	Wrench
KKCR/L	**445**	MHS532R/L MHS533R/L MHS534R/L	SFC03010	MHK5NR/L	MHT1	CE8	HKY40R

ML TYPE HOLDER

Old Type Tool Number					
Type	Size	Lock Pin	Shim	Stop Ring	Spanner
ETANR/L **ETENN** **ETFNR/L** **ETGNR/L** **ETXNR/L**	**1212**	P221US	–	ER2	KY25
	1616H32	P322US	–	ER3	KY40
	1616H33	P332US	–	ER3	KY40
	2020K32W	P323WS	EST32	ER3	KY40
	2020K33W	P333WS	EST32	ER3	KY40
	2525M33W	P334WS	EST32	ER3	KY40
	2525M43W	P434W	EST43	ER4	KY40
ESBNR/L **ESENR/L** **ESDNR/L** **ESKNR/L** **ESSNR/L**	**1212**	P321US	–	ER3	KY40
	1616H32	P322US	–	ER3	KY40
	2020W	P433W	ESS42	ER4	KY40
	2525W	P434W	ESS42	ER4	KY40

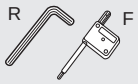
MP TYPE HOLDER

Old Type Tool Number						
Type	Size	Shim	Lock Pin	Lock Screw	Stop Ring	Wrench
PVVNN **PVPNR/L**	**3225P16**	PV32◌	P11S	HSP05008C	E03	HKY25R

MT2 TYPE HOLDER

Old Type Tool Number					
Type	Size	Clamp Bridge	Clamp Screw	Spring	Wrench
MT2R/L	**2525M4**	MTK1L/R	HBH06020	MES3	HKY40R

SET TYPE HOLDER

Old Type Tool Number							
Type	Size	Clamp Bridge	Clamp Screw	Stop Ring	Shim Pin	Shim	Wrench
SETHR	**1616H16**	SETK51	SETS51	CR4	HFC03008	CT32T1	TKY15F HKY20R
	2020K16	SETK51	SETS51	CR4	HFC03008	CT32T1	TKY15F HKY20R
	2525M16	SETK51	SETS51	CR4	HFC03008	CT32T1	TKY15F HKY20R

SL TYPE HOLDER

Old Type Tool Number							
Type	Size	Shim	Lock Pin	Nut	Clamp Wedge	Clamp Screw	Wrench
ETJNR/L **ETQNR/L**	**33K16S**	SLSTN33	SLP13	SLN13	SLCW13	SLCS105	HKY25R HKY40R
	44M16S	SLSTN33	SLP13	SLN13	SLCW13	SLCS105	HKY25R HKY40R
	44M22S	SLSTN43	SLP14	SLN14	SLCW14	SLCS106	HKY30R HKY40R
	54P22S	SLSTN43	SLP14	SLN14	SLCW14	SLCS106	HKY30R HKY40R
ETNNR/L	**64M22S**	SLSTN43	SLP14	SLN14	SLCW14	SLCS106	HKY30R HKY40R
	85M22S	SLSTN43	SLP14	SLN14	SLCW14	SLCS106	HKY30R HKY40R

SP TYPE HOLDER

Old Type Tool Number					
Type	Size	Clamp Screw	Wrench	Shim	Shim Pin
SDJCR/L **SDFCR/L** **SDXCR/L**	**0808D07**	TS25	TKY08F	–	–
	1010E07	TS25	TKY08F	–	–
	1212F07	TS25	TKY08F	–	–
	1616H11	TS43	TKY15F	–	–
SVJCR/L **SVVCN** **SVPCR/L**	**0808D11**	TS25	TKY08F	–	–
	1010E11	TS25	TKY08F	–	–
	1212F16	TS43	TKY15F	–	–
	3225P16	TS44	TKY15R	SPSVN32	BCP141
SSBCR/L	**1616H09**	TS43	TKY15F	–	–
SRGCR/L **SRXCR/L** **SRDCN**	**0808D06**	TS25	TKY08F	–	–
	1010E06	TS25	TKY08F	–	–
	1212F06	TS25	TKY08F	–	–
	1010E08	TS3	TKY08F	–	–
	1212F08	TS3	TKY08F	–	–

SR TYPE HOLDER

Old Type Tool Number			
Type	Size	Clamp Screw	Wrench
SRSGR/L **SRSGN**	**2525M20**	TS5	TKY25F
	3225P20	TS5	TKY25F

REPLACEMENT PARTS FOR OLD TYPE TOOLS (TURNING HOLDERS)

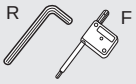
WP TYPE HOLDER (OLD TYPE PRODUCTS)

Old Type Tool Number									
Type	Size	Shim	Shim Pin	Clamp Bridge	Clamp Screw	Side Lock Plate	Lock Screw	Spring	Wrench
MTJNR/L MTENN MTQNR/L	**2020K16**	SLSTN33	CCP13	CCK13	SLCS105	CPT13	WPS1	MES2	HKY30R HKY40R
	2525M16	SLSTN33	CCP13	CCK13	SLCS105	CPT13	WPS1	MES2	HKY30R HKY40R
	2525M22	SLSTN43	CCP14	CCK14	SLCS106	CPT14	WPS1	MES3	HKY30R HKY40R
MTNNR/L	**5032M22**	SLSTN43	CCP14	CCK14	SLCS106	CPT14	WPS1	MES3	HKY30R HKY40R
MWLNR/L	**2020K08**	WPSWN43	CCP34	CCK13	SLCS105	CPT24	–	MES2	HKY30R HKY40R
	2525M08								
	3225P08								

WP TYPE HOLDER

Old Type Tool Number							–		
Type	Size	Shim	Shim Pin	Clamp Bridge	Clamp Screw	Side Lock Plate	Lock Screw	Spring	Wrench
MTENN MTQNR/L	**2020K16N**	WPSTN33	CCP33	CCK13	SLCS105	CPT13	–	MES2	HKY25R HKY40R
	2525M16N	WPSTN33	CCP33	CCK13	SLCS105	CPT13	–	MES2	HKY25R HKY40R
	2525M22N	WPSTN43	CCP34	CCK14	SLCS106	CPT14	–	MES3	HKY30R HKY40R
MTNNR/L	**5032M22N**	WPSTN43	CCP34	CCK14	SLCS106	CPT14	–	MES3	HKY30TL HKY40R

AL TYPE HOLDER

Old Type Tool Number						
Type	Size	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
PTGER/L PTFER/L	**2020K16**	LLSTE32	LLP13	LLCL131	LLCS106	HKY25R
	2525M16	LLSTE32	LLP13	LLCL131	LLCS106	HKY25R
SVVDN SVPDR/L	**1616H16**	–	–	–	FC400890T	TKY10F
	2020K16	–	–	–	FC400890T	TKY10F
	2525M16	–	–	–	FC400890T	TKY10F

REPLACEMENT PARTS FOR OLD TYPE TOOLS (GROOVING/CUTTING OFF)

DG TYPE HOLDER

Old Type Tool Number	Clamp Bridge	Locator Screw	Wrench	Clamp Screw	Spring
DGHR/L 1616K2G	DGK2R/L	–	HKY40R	DGS51	MES2
DGHR/L 1616K3	DGK3R/L	–	HKY40R	DGS51	MES2
DGHR/L 1616K3G	DGK3R/L	–	HKY40R	DGS51	MES2
DGHR/L 1616KF3	DGK3R/L	–	HKY40R	DGS51	MES2
DGHR/L 2020K	–	HSC04014	HKY30R HKY40R	DGS51	MES2
DGHR/L 2020KFS	–	HSC04014	HKY30R HKY40R	DGS51	MES2
DGHR/L 2020KL	–	HSC04014	HKY30R HKY40R	DGS51	MES2
DGHR/L 2020KLS	–	HSC04014	HKY30R HKY40R	DGS51	MES2
DGHR/L 2020KS	–	HSC04014	HKY30R HKY40R	DGS51	MES2
DGHR/L 2525M	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525MC	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525MCS	–	HSC05010	HKY40R	DGS51	MES2
DGHR/L 2525MF	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525MFS	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525ML	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525MLS	–	HSC05012	HKY40R	DGS51	MES2
DGHR/L 2525MS	–	HSC05012	HKY40R	DGS51	MES2

HSK-T TOOLS (DG)

Old Type Tool Number	Locator Screw	Clamp Screw	Spring	Wrench
H63TH-DGHR/LS	HSC05012	DGS51	MES2	HKY40R
H63TH-DGHR/L	HSC05012	DGS51	MES2	HKY40R
H63TH-DGHN-H4	HSC05010	DGS51	MES2	HKY40R
H63TH-DGHN-H5	HSC05012	DGS51	MES2	HKY40R
H63TH-DGHN-H6	HSC05012	DGS51	MES2	HKY40R
H63TH-DGHN-L4	HSC05010	DGS51	MES2	HKY40R
H63TH-DGHN-L5	HSC05012	DGS51	MES2	HKY40R
H63TH-DGHN-L6	HSC05012	DGS51	MES2	HKY40R

UG TYPE HOLDER

Old Type Tool Number	Wrench
DGHN262	UGS1
DGHN263	UGS1
DGHN264	UGS1
DGHN265	UGS1
DGHN322	UGS1
DGHN323	UGS1
DGHN324	UGS1
DGHN325	UGS1

TOOL BLOCK FOR UG HOLDER

Old Type Tool Number	Block			Shank	
	Clamp Bridge	Clamp Screw	Wrench	Set Bolt	Wrench
KGBN26-20	KGC1	LST15T	TKY25R	HSC08016	HKY60R
KGBN26-25	KGC1	LST15T	TKY25R	HSC08016	HKY60R
KGBN32-20	KGC1	LST15T	TKY25R	HSC08016	HKY60R
KGBN32-25	KGC1	LST15T	TKY25R	HSC08016	HKY60R

REPLACEMENT PARTS FOR OLD TYPE TOOLS (BORING BARS)

COBRA (STEEL SHANK)

Old Type Tool Number	Clamp Screw	Wrench
S08HSTFPR09	TS253	TKY08F
S10KSTFPR09	TS25	TKY08F
S○○○STFPR11	TS3	TKY08F
S○○○STFPR16	TS4	TKY15F
S○○○SCLPR/L08	TS3	TKY08F
S○○○SCLPR/L09	TS4	TKY15F
S○○○SWLPR/L04	TS25	TKY08F
S○○○SWLPR/L06	TS4	TKY15F

COBRA (CARBIDE SHANK)

Old Type Tool Number	Clamp Screw	Wrench
E08KSTFPR09	TS253	TKY08F
E10MSTFPR09	TS25	TKY08F
E○○○STFPR11	TS3	TKY08F
E○○○SCLPR08	TS3	TKY08F
E○○○SCLPR09	TS4	TKY15F

D TYPE (FOR BORING)

Old Type Tool Number									
Type	Size	Shim	Shim Pin	Clamp Lever	Clamp Screw	Clamp Set	Breaker Piece	Stop Ring	Wrench
DPSK	**132R/L**	LLSSN42	LLP14	LLCL14	LLCS108	–	–	–	HKY30R
	140R/L	LLSSN42	LLP14	LLCL14	LLCS108	–	–	–	HKY30R
	150R/L	LLSSN63	LLP16	LLCL16	LLCS110	–	–	–	HKY40R
	163R/L	LLSSN63	LLP16	LLCL16	LLCS110	–	–	–	HKY40R
DPTF	**150R/L**	LLSTN42	LLP14	LLCL14	LLCS108	–	–	–	HKY30R
	163R/L	LLSTN42	LLP14	LLCL14	LLCS108	–	–	–	HKY30R
DPDU DPDH DPDZ	**132R/L**	LLSDN42	LLP14	LLCL24	LLCS108	–	–	–	HKY30R
	140R/L	LLSDN42	LLP14	LLCL24	LLCS108	–	–	–	HKY30R
	* **150R/L**	LLSDN53	LLP15	LLCL15	LLCS208	–	–	–	HKY30R
DPCL	**150R/L**	LLSCN63	LLP16	LLCL16	LLCS110	–	–	–	HKY40R
	163R/L	LLSCN63	LLP16	LLCL16	LLCS110	–	–	–	HKY40R
DPVP	**150R/L**	PV322	P11S	–	HSP05008C	–	–	E03	HKY25R
DCTU	**132R/L**	PT32	BCP201	–	–	C4	CBT3N	–	HKY30R
	140R/L	PT42	BCP251	–	–	C5	CBT4F	–	HKY40R
	150R/L	PT42	BCP251	–	–	C5	CBT4F	–	HKY40R

*DPDH150R/L can be compatible with 140R/L.

D TYPE (FOR GROOVING AND THREADING)

Old Type Tool Number					
Type	Size	Lock Pin	Lock Screw	Stop Ring	Wrench
DPT2	**132R**	P21S	HSP08014	E01	HKY40R
	140R	P21S	HSP08014	E01	HKY40R
DPT4	**132R**	P21S	HSP08014	E01	HKY40R
	140R	P21S	HSP08014	E01	HKY40R

F TYPE

Old Type Tool Number						
Type	Size	Shim	Shim Pin	Clamp Set	Breaker Piece	Wrench
FCSK	**116R/L**	–	–	C3	CBS3	HKY25R
	120R/L	–	–	C3	CBS3	HKY25R
	125R/L	PS42	BCP252	C4	CBS4F	HKY30R
	132R/L	PS42	BCP251	C4	CBS4F	HKY30R
FCSK	**216R/L**	–	–	C3	CBS3	HKY25R
	220R/L	–	–	C3	CBS3	HKY25R
	225R/L	PS42	BCP252	C4	CBS4F	HKY30R
FCTU	**232R/L**	PT32	BCP201	C4	CBT3F	HKY30R

F TYPE (FOR GROOVING AND THREADING)

Old Type Tool Number								
Type	Size	Clamp Bridge	Clamp Set	Clamp Screw	Shim	Shim Pin	Stop Ring	Wrench
FCL5	**116R/L**	LK1	–	HBH04012	–	–	–	HKY25R
	120R/L	LK1	–	HBH04012	–	–	–	HKY25R
	125R/L	LK1	–	HBH04012	–	–	–	HKY25R
	132R/L	LK1	–	HBH04012	–	–	–	HKY25R
	216R/L	LK1	–	HBH04012	–	–	–	HKY25R
	220R/L	LK1	–	HBH04012	–	–	–	HKY25R
	225R/L	LK1	–	HBH04012	–	–	–	HKY25R
NTF	**M16R**	–	C3	–	–	–	–	HKY25R
	Q20R	–	C4	–	–	–	–	HKY30R
	R25R	–	C4	–	–	–	–	HKY30R
	R216R	–	C3	–	–	–	–	HKY25R
	S220R	–	C4	–	–	–	–	HKY30R
	T225R	–	C4	–	–	–	–	HKY30R
SNTF	**K16R11**	–	–	TS25	–	–	–	TKY08F
	M16R	–	–	CS350860T	–	–	–	TKY15F
	P20R	SETK51	–	SETS51	CT32T1	HFC03008	CR4	TKY15F HKY20R
	R25R	SETK51	–	SETS51	CT32T1	HFC03008	CR4	TKY15F HKY20R
	M210R11	–	–	TS25	–	–	–	TKY08F
	Q212R11	–	–	TS25	–	–	–	TKY08F
	R216R	–	–	CS350860T	–	–	–	TKY15F
	S220R	SETK51	–	SETS51	CT32T1	HFC03008	CR4	TKY15F
	T225R	SETK51	–	SETS51	CT32T1	HFC03008	CR4	TKY15F
FCDG4	**120R/L3M**	–	BC5	–	–	–	–	TKY20R
	125R/L3M	–	BC5	–	–	–	–	TKY20R
	132R/L3M	–	BC5	–	–	–	–	TKY20R
	120R/L4M	–	BC5	–	–	–	–	TKY20R
	125R/L4M	–	BC5	–	–	–	–	TKY20R
	132R/L4M	–	BC5	–	–	–	–	TKY20R
	125R/L5M	–	BC5	–	–	–	–	TKY20R
	132R/L5M	–	BC5	–	–	–	–	TKY20R
FCDG4	**120R/L4J**	–	BC5	–	–	–	–	TKY20R
	125R/L4J	–	BC5	–	–	–	–	TKY20R
	132R/L4J	–	BC5	–	–	–	–	TKY20R
	125R/L5J	–	BC5	–	–	–	–	TKY20R
	132R/L5J	–	BC5	–	–	–	–	TKY20R

REPLACEMENT PARTS FOR OLD TYPE TOOLS (BORING BARS)

M TYPE

Old Type Tool Number	Shim	Shim Pin	Clamp Bridge	Side Lock Plate	Spring	Clamp Screw	Wrench	Plug
A25RMWLNR/L08	–	–	CCK13	CPT24	MES2	SLCS105	HKY25R HKY40R	HGM-PT1/4
A32SMWLNR/L08	WPSWC43	CCP44	CCK13	CPT24	MES2	SLCS105	HKY25R HKY40R	HGM-PT3/8
A40TMWLNR/L08	WPSWC43	CCP44	CCK13	CPT24	MES2	SLCS105	HKY25R HKY40R	HGM-PT3/8

P TYPE

Old Type Tool Number	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	Plug
A50UPSKNR/L19	LLSSP63	LLP16	LLCL16	LLCS310	HKY40R	HGM-PT3/8
A40TPCLNR/L16	LLSCN53	LLP15	LLCL25	LLCS508	HKY30R	HGM-PT3/8
A50UPCLNR/L19	LLSCP63	LLP16	LLCL16	LLCS310	HKY40R	HGM-PT3/8

S TYPE (CARBIDE SHANK)

Old Type Tool Number	Clamp Screw	Wrench
C○○○SSKCR/L09	TS4	TKY15F
C○○○SDUCR/L15	TS5	TKY25F
C○○○SVUCR/L11	TS25	TKY08F
C○○○SVUCR/L16	TS4	TKY15F
C○○○SCLCR/L12	TS5	TKY25F
C○○○SCZCR/L06	TS25	TKY08F
C○○○SCZCR/L09	TS4	TKY15F
C○○○SCZCR/L12	TS5	TKY25F
C○○○SDZCR11	TS4	TKY15F

S TYPE (STEEL SHANK)

Old Type Tool Number	Clamp Screw	Wrench
S○○○SSKCR/L12	TS5	TKY25F
S○○○SDQCR/L15	TS5	TKY25F
S○○○SCZCR/L06	TS25	TKY08F
S○○○SCZCR/L09	TS4	TKY15F
S○○○SCZCR/L12	TS5	TKY25F
S○○○SDZCR11	TS4	TKY15F

REPLACEMENT PARTS FOR OLD TYPE TOOLS (BORING UNITS)

UNIT

Old Type Tool Number	Washer Screw	Bush Screw	Wrench	Bush	Washer	Leaf Spring
NA1	HFC03008	HY-A1	HKY20R	The parts above are not sold separately as accuracy can only be guaranteed by having the complete set. Please contact us for questions about parts replacement.		
NV1	HFC03008	HY-V1	HKY20R			
NA2	HSC03010	HY2	HKY20R HKY25R			
NV2	HSC03010	HY2	HS-N2 HKY25R			
NA3	HSC04010	HY3	HKY20R HKY30R			
NV3	HSC04010	HY3	HKY20R HKY30R			
NA4	HSC05012	HY4	HKY30R HKY40R			
NV4	HSC05012	HY4	HKY30R HKY40R			

CARTRIDGE

Old Type Tool Number	Clamp Lever	Clamp Screw	Shim	Shim Pin	Spanner	Wrench
NASP11	–	CS250T	–	–	HR12	TKY08F
NVSP11	–	CS250T	–	–	HR12	TKY08F
NASP21	–	CS300890T	–	–	HR12	TKY08F
NVSP21	–	CS300890T	–	–	HR12	TKY08F
NAPN21	LLCL12S	LLCS103	–	–	HR12	HKY20F
NVPN21	LLCL12S	LLCS103	–	–	HR12	HKY20F
NASP31	–	CS300890T	–	–	HR34	TKY08F
NVSP31	–	CS300890T	–	–	HR34	TKY08F
NAPN31	LLCL12S	LLCS103	–	–	HR34	HKY20F
NVPN31	LLCL12S	LLCS103	–	–	HR34	HKY20F
NAPN41	LLCL13	LLCS106	LLSTN32	LLP13	HR34	HKY25F
NVPN41	LLCL13	LLCS106	LLSTN32	LLP13	HR34	HKY25F

REPLACEMENT PARTS FOR OLD TYPE TOOLS (FACE MILLS)

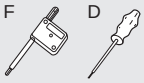
AF5000 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Adjust Screw	Wrench	Wrench	Recommended Cutter
AF5000 Type	CWAF5R/L	LS10T	KS1S	TKY25T	HKY15R	**NF10000** (➲M072)

BAP300 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Cutter
BAP300 Type	TS25	TKY08F	**APX3000** (➲M096)

BAP400 TYPE

Old Type Tool Number	Clamp Screw	 Wrench	Recommended Cutter
BAP400-040A04R	TS43	TKY15F	**APX4000** (➲M102)
BAP400-050A05R	TS43	TKY15F	
BAP400-063A06R	TS43	TKY15F	
BAP400R0307C	TS43	TKY15F	
BAP400R0408D	TS43	TKY15F	
BAP400R0509E	TS43	TKY15D	
BAP400R0610E	TS43	TKY15D	

BF407 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Setting Screw	Wrench	Recommended Cutter
BF407R0812K	CWSF407TR2	LS15T	CAS51T	TKY25T	–
BF407R1016K	CWSF407TR2	LS15T	CAS51T	TKY25T	
BF407R1218P	CWSF407TR2	LS15T	CAS51T	TKY25T	

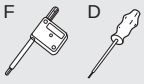
BN425 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Wrench	Recommended Cutter
BN425 Type	CWS43SNN	LS14T	TKY25T	–

BOE TYPE

Old Type Tool Number	Set Bolt	Set Bolt	Clamp Screw	Wrench (Insert)	Wrench (Set Bolt)	Recommended Cutter
BOER0202B	LS21	–	CS501290T	TKY25T	HKY50R	**OCTACUT** (➲M180)
BOE-050A02R	LS20	–	CS501290T	TKY25T	HKY50R	
BOER2H03B	–	BOES101	CS501290T	TKY25T	HKY80R	
BOE-063A03R	–	BOES101	CS501290T	TKY25T	HKY80R	
BOER0304C	–	–	CS501290T	TKY25T	–	
BOER0405D	–	HSC16035	CS501290T	TKY25T	–	

BSX400 TYPE

Old Type Tool Number	Clamp Screw	 Wrench	Recommended Cutter
BSX400R05004A	TS43	TKY15F	**ASX400** (➲M080)
BSX400R06305A	TS43	TKY15F	
BSX400R08006C	TS43	TKY15F	
BSX400R10008D	TS43	TKY15F	
BSX400R12510E	TS43	TKY15D	
BSX400R16012E	TS43	TKY15D	

BSX500 TYPE

Old Type Tool Number	Clamp Screw	Shim Screw	Shim	Wrench	Recommended Cutter
BSX500 Type	CSF401260T	WCS604010H	STBS500N	TKY20D	**ASX400** (➲M080)

BXD7000 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Cutter
BXD7000 Type	TS5SL	TKY25D	**AXD7000** (➲M142)

BZC400 TYPE

Old Type Tool Number	Clamp Screw	Set Bolt	Wrench (Wedge)	Wrench (Set Bolt)	Recommended Cutter
BZC400-032A03R	CS350990T	LS24	TKY10F	HKY40R	**APX4000** (➲M102)
BZC400-040A04R	CS350990T	–	TKY10F	–	
BZC400R0408D	CS350990T	–	TKY10F	–	

E404 TYPE

Old Type Tool Number	Locator	Locator Screw	Shim	Shim Screw	Wedge	Clamp Screw (Wedge)	Wrench	Wrench	Recommended Cutter
E404 Type	SSE41R	SPS1	SCD43	STS1	CWS3R/L	WS1	TKY10R	TKY25T	–

FBP415 TYPE

Old Type Tool Number	Shim	Wedge-T	Clamp Screw	Shim Screw	Wrench (Wedge)	Wrench (Shim)	Recommended Cutter
FBP415R0308C	STSP415R	CWSP415TR	LS10T	TS32	TKY25T	TKY08F	**AHX640W** (➲M054)
FBP415R0410D							
FBP415R0514E							
FBP415R0618F							
FBP415R0822K							
FBP415R1028K							
FBP415R1234P							

REPLACEMENT PARTS FOR OLD TYPE TOOLS (FACE MILLS)

FN548 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Wrench	Wrench	Hexagonal Head	Recommended Cutter
FN548 Type	CWS4	LS14	HKY40T	120QSPK x 80 (KANNON-SEIKI CO.)	6.35□ x 4 (KYOKUTO MFG CO.)	–

LSE445 TYPE

Old Type Tool Number	Shim	Shim Screw	Wedge	Clamp Screw	Wrench (Wedge)	Wrench	Recommended Cutter
LSE445 Type	STBE445NF	CS300890T	CWSE445TR	LS15T	TKY25T	TKY08F	**ASX445** (➲M030)

MG300, 400 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Cutter
MG300 Type	CS350990T	TKY10F	–
MG400 Type	CS451190T	TKY20F	**ASX400** (➲M080)

MG345, 445 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Cutter
MG345 Type	CS350990T	TKY10F	**ASX445** (➲M030)
MG445 Type	CS451190T	TKY20F	

MGP445 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Cutter
MGP445 Type	CS401160T	TKY15D	**ASX445** (➲M030)

MSD445 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Wrench	Recommended Cutter
MSD445 Type	CWMSE445R2	LS15T	TKY25T	**ASX445** (➲M030)

MSE445 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Wrench	Recommended Cutter
MSE445 Type	CWMSE445R2	LS15T	TKY25T	**ASX445** (➲M030)

NR10000 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Adjusting Wedge	Adjusting Screw	Clamp Screw	Wrench	Recommended Cutter
NR10000 Type	CWAF10R2	LS10T	CWAF10N	LS15T	CSAF10	TKY25T	–

NSE300 TYPE

Old Type Tool Number	Locator	Wedge-T	Clamp Screw	Locator Screw	Wrench (Wedge)	Wrench (Locator)	Set Bolt	Recommended Cutter
NSE300-050A04R **NSE300-063A05R**	SPTSE300R	CWTSE300TR	LS19T	TS32	TKY15T	TKY08F	–	**ASX400** (➲M080)
NSE300R0408D							HSC16035	
NSE300R0306C **NSE300R0510E** **NSE300R0612F**		CWNSE300TR	LS10T		TKY25T		–	
NSE300R504S32 **NSE300R635S32**		CWTSE300TR	LS19T		TKY15T			

⁎ Clamp Torque (N • m) : LS10T=8.5, LS19T=5.0, TS32=1.0

NSE400 TYPE

Old Type Tool Number	Locator	Wedge-T	Clamp Screw	Locator Screw	Wrench (Wedge)	Wrench (Locator)	Set Bolt	Recommended Cutter
NSE400R0306C	SPTSE400R	CWSE300TR	LS10TS	TS32	TKY25T	TKY08F	–	**ASX400** (➲M080)
NSE400R0407D							HSC16035	
NSE400R0508E **NSE400R0610F** **NSE400R503S32** **NSE400R634S32**							–	

P425, P525 TYPE

Old Type Tool Number	Locator	Locator Screw	Shim	Shim Screw	Wedge	Clamp Screw (Wedge)	Wrench	Wrench	Recommended Cutter
P425 Type	SSP41R	SPS1	SCP431R/L	STS1	CWS1R/L	WS1	TKY10R	TKY25T	**ASX445** (➲M030)
P525 Type	SSP51R	SPS1	SCP521R/L	STS1	CWS1R/L	WS1	TKY10R	TKY25T	**SE515** (➲M062)

QBF407 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Setting Screw	Guide Plate	Stop Screw	Wrench	Recommended Cutter
QBF407R0304Q	CWSF407TR1	LS15T	CAS51T	QPAR1	TFC04010	TKY20R TKY25T	–
QBF407R0406Q	CWSF407TR1	LS15T	CAS51T	QPAR1	TFC04010	TKY20R TKY25T	
QBF407R0508Q	CWSF407TR2	LS15T	CAS51T	QPAR1	TFC04010	TKY20R TKY25T	

QBP415 TYPE

Old Type Tool Number	Shim	Shim Pin	Wedge-T	Clamp Screw	Wrench	Recommended Cutter
QBP415 Type	STSP415R	TS32	QWGR1	LS10T	TKY25T	–

QF10000 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Guide Plate	Stop Screw	Adjusting Wedge	Adjusting Screw	Stop Screw	Wrench	Recommended Cutter
QF10000 Type	CWAF10R3	LS15T	QPCR1	TFC04010	CWAF10N	LS10T	CSAF10	TKY20T TKY25T	–

REPLACEMENT PARTS FOR OLD TYPE TOOLS (FACE MILLS)

QSE415 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Setting Screw	Guide Plate	Stop Screw	Wrench	Recommended Cutter
QSE415 Type	CWSF407TR3	LS15T	CAS51T	QPAR1	TFC04010	TKY20R TKY25T	–

SE300 TYPE

Old Type Tool Number	Locator	Locator (Wiper)	Wedge-T	Wedge-S	Wedge-S (Wiper)	Clamp Screw	Wrench	Recommended Cutter
SE300 Type	SPSE300R	SPSEW300R	CWNSE300TR	CWSE300SN	CWSEW300SN	LS10T	TKY25T	–

SE400 TYPE

Old Type Tool Number	Locator	Locator (Wiper)	Wedge-T	Wedge-S	Clamp Screw	Wrench	Recommended Cutter
SE400 Type	SPSE400R	SPSEW400R	CWSE400TN	CWSE400SN	LS15T (SE400R0304C:LS10T)	TKY25T	–

SE415 TYPE

Old Type Tool Number	Locator	Shim	Wedge-T	Wedge-S	Clamp Screw	Wrench	Set Bolt	Recommended Cutter
SE415R0304C **SE415R0306C**	SPSE415R	STSE415R	CWSE445TR	CWSE445SN	LS15T	TKY25T	HSC12035	**SE515** (➲M062)
SE415R0405D **SE415R0407D**							HSC16035	
SE415R0506E – **SE415R0611F**							–	

SE445 TYPE

Old Type Tool Number	Locator	Shim	Wedge-T	Wedge-S	Clamp Screw	Wrench	Set Bolt	Recommended Cutter
SE445R/L03□□C	SPSE445R/L	STSE445R/L	CWSE445TR/L	CWSE445SN	LS15T	TKY25T	HSC12035	**ASX445** (➲M030)
SE445R/L04□□D							HSC16035	
SE445R/L0506E – **SE445R/L1214P**							–	

SE545 TYPE

Old Type Tool Number	Locator	Shim	Wedge-T	Wedge-S	Clamp Screw	Wrench	Set Bolt	Recommended Cutter
SE545R0405D	SPSE545R	STSE545R	CWSE545TR	CWSE545SN	LS15T	TKY25T	HSC16035	**ASX445** (➲M030)
SE545R0506E – **SE545R1012K**							–	

SHP400 TYPE

Old Type Tool Number						Recommended Cutter
	Wedge-T	Clamp Screw	Locator Screw	Wrench (Wedge)	Wrench (Locator)	
SHP400 Type	CWSE300TR/L	LS10T	TS32	TKY25T	TKY08F	**ASX400** (➲M080)

VIP400 TYPE

Old Type Tool Number			Recommended Cutter
	Clamp Screw	Wrench	
VIP400 Type	CS501160T	TKY20F	**ASX400** (➲M080)

VIP445 TYPE

Old Type Tool Number			Recommended Cutter
	Clamp Screw	Wrench	
VIP445 Type	CS501160T	TKY20F	**ASX445** (➲M030)

REPLACEMENT PARTS FOR OLD TYPE TOOLS (END MILLS)

BAE TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
BAE500R161S16	TS42	TKY15F	**APX4000** (➲M102)
BAE500R201S20	TS42	TKY15F	
BAE500R252S25	TS42	TKY15F	
BAE500R323S32	TS4	TKY15F	
BAE500R403S32	TS4	TKY15F	
BAE500R504S32	TS4	TKY15F	
BAE600 Type	TS52	TKY25F	

BAP300 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
BAP300 (Under-cut Type)	TS25	TKY08F	–

BAP400 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
BAP400R252S25	TS4	TKY15F	**APX4000** (➲M102)
BAP400R323S32	TS43	TKY15F	
BAP400R404S32	TS43	TKY15F	
BAP400R505S32	TS43	TKY15F	
BAP400R636S32	TS43	TKY15F	

BAP400 (Long Cutting Edge Type) TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
BAP400 (Long Cutting Edge Type)	TS43	TKY15F	**APX4000** (➲M102)

BAP3500 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
BAP3500R161SA16○○	TS3	TKY08F	**APX3000** (➲M096)
BAP3500R161SN16○○	TS3	TKY08F	
BAP3500R202SA20○○	TS32	TKY08F	
BAP3500R202SN20○○	TS32	TKY08F	
BAP3500R253SA25○○	TS32	TKY08F	
BAP3500R253SN25○○	TS32	TKY08F	
BAP3500R324SA32○○	TS32	TKY08F	
BAP3500R324SN32○○	TS32	TKY08F	
BAP3500R405SA32○○	TS32	TKY08F	
BAP3500R405SN32○○	TS32	TKY08F	

BOE TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BOE Type	CS501290T	TKY25T	**OCTACUT** (➲M180)

BRE TYPE

Old Type Tool Number						Recommended End Mill
	Clamp Screw	Clamp Bridge	Clamp Screw (Bridge)	Spring	Wrench	
BRE Type	TS5S	AMS5	BRS105	ASS3	TKY25R	**BRP** (➲M196)

BSP TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BSPR Type	CS451190T	TKY20F	**APX3000** (➲M096)

BSX300 TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BSX300 Type	TS32	TKY08F	**APX3000** (➲M096)

BSX400 TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BSX400 Type	TS43	TKY15F	**ASX400** (➲M080)

BSX500 TYPE

Old Type Tool Number					Recommended End Mill
	Clamp Screw	Shim Screw	Shim	Wrench	
BSX500 Type	CSF401260T	WCS604010H	STBS500N	TKY20D	**ASX400** (➲M080)

BXD7000 TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BXD7000R251SA25SA/B	TS5S	TKY25D	**AXD7000** (➲M142)
BXD7000R321SA32SA/B	TS5S	TKY25D	
BXD7000R402SA42SA/B	TS5SL	TKY25D	

BZC400 TYPE

Old Type Tool Number			Recommended End Mill
	Clamp Screw	Wrench	
BZC400 Type	CS350990T	TKY10F	**APX4000** (➲M102)

REPLACEMENT PARTS FOR OLD TYPE TOOLS (END MILLS)

CV TYPE

Old Type Tool Number	Clamp Screw	Clamp Bridge	Clamp Screw (Bridge)	Spring	Wrench	Recommended End Mill
CV10R253S32	TS4	AMS3	BRS103	ASS2	TKY15R	**BRP** (➲M196)
CV12R323S32	TS4	AMS3	BRS103	ASS2	TKY15R	
CV16R403S32	TS5	AMS5	BRS105	ASS3	TKY25R	

CV20 TYPE

Old Type Tool Number	Clamp Screw	Wedge	Wrench	Recommended End Mill
CV20R403S32	LS14T	CWCV20	TKY25T	–

DCSD, DCSN TYPE

Old Type Tool Number	Shim Screw	Clamp Screw	Shim Screw	Clamp Screw	Wrench	Wrench	Recommended End Mill
DCSDR2063SN	–	TS5S	–	DKS5	HKY40R	TKY25T	**SPX** (➲M215)
DCSDR2063LN	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSDR2080SN	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSDR2100SN	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSNR2063SN	JSS7	TS5L	JSS7	DKS5	HKY40R	TKY25T	
DCSNR2063LN	JSS7	TS5L	JSS7	DKS5	HKY40R	TKY25T	
DCSDR2063SB	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSDR2063LN	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSNR2063SB	JSS7	TS5L	JSS7	DKS5	HKY40R	TKY25T	
DCSDR2080SA	–	TS5S	–	DKS5	HKY40R	TKY25T	
DCSNR2080SA	JSS7	TS5L	JSS7	DKS5	HKY40R	TKY25T	

ECMP TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
ECMP252S25	TS4	TKY15R	–
ECMP322S32	TS5	TKY25R	
ECMP402S42	TS5	TKY25R	

FF3000 TYPE

Old Type Tool Number	Shim	Lock Pin	Wrench	Recommended End Mill
FF3000 Type	FFSS	FFP	HKY25L	–

FSTE TYPE

Old Type Tool Number	Locator	Wedge	Clamp Screw	Locator Screw	Wrench	Recommended End Mill
FSTE Type	TS441R	CWFSTE	LS10T	CPM03008	TKY25T	**ASX400** (➲M080)

MG200, 300 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
MG200 Type	CS300890T	TKY08F	–
MG300 Type	CS350990T	TKY10F	**ASX400** (➲M080)

MG245, 345 TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
MG245 Type	CS300890T	TKY08F	**ASX445** (➲M030)
MG345 Type	CS350990T	TKY10F	

MSE445 TYPE

Old Type Tool Number	Wedge	Clamp Screw	Wrench	Recommended End Mill
MSE445 Type	CWMSE445R1	LS15T	TKY25T	**ASX445** (➲M030)

NSE300 TYPE

Old Type Tool Number	Locator	Wedge-T	Clamp Screw	Locator Screw	Wrench (Wedge)	Wrench (Locator)	Recommended End Mill
NSE300R504S32 **NSE300R635S32**	SPTSE300R	CWTSE300TR	LS19T	TS32	TKY15T	TKY08F	**ASX400** (➲M080)

NSE400 TYPE

Old Type Tool Number	Locator	Wedge-T	Clamp Screw	Locator Screw	Wrench (Wedge)	Wrench (Locator)	Recommended End Mill
NSE400R503S32 **NSE400R634S32**	SPTSE400R	CWSE300TR	LS10TS	TS32	TKY25T	TKY08F	**ASX400** (➲M080)

SE300 TYPE

Old Type Tool Number	Locator	Wedge-T	Wedge-S	Clamp Screw	Wrench	Recommended End Mill
SE300 Type	SPSE300R	CWNSE300TR	CWSE300SN	LS10T	TKY25T	–

SHP400 TYPE

Old Type Tool Number	Locator	Wedge-T	Clamp Screw	Locator Screw	Wrench (Insert)	Wrench (Locator)	Recommended End Mill
SHP400 Type	SPSHP400R	CWSE300TR	LS10T	TS32	TKY25T	TKY08F	**ASX400** (➲M080)

REPLACEMENT PARTS FOR OLD TYPE TOOLS (END MILLS)

SRE TYPE

Old Type Tool Number	Clamp Screw	Clamp Bridge	Stop Ring	Wrench	Recommended End Mill
SRER100SS16	TS253	–	–	TKY08F	–
SRER120SS16	TS3	–	–	TKY08F	
SRER140SS16	TS3	–	–	TKY08F	
SRER160SS16	TS35	–	–	TKY10F	
SRER180SS20	TS35	–	–	TKY10F	
SRER200SS20	SRS5	SRK1R	CR4	TKY20F	
SRER200SL20	SRS5	SRK1R	CR4	TKY20F	
SRER250SS25	SRS5	SRK1R	CR4	TKY20F	
SRER250SL25	SRS5	SRK1R	CR4	TKY20F	
SRER300SS32	SRS5	SRK1R	CR4	TKY20F	
SRER300SL32	SRS5	SRK1R	CR4	TKY20F	

STLG TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
STLGR22S32	CS300890T	TKY08F	**KSMG** (➲M252)
STLGR38S32	CS350990T	TKY10F	

VIPER TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
VIPER Type	CS400990T	TKY15D	**SPX** (➲M215)

ZR TYPE

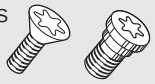
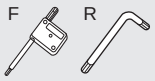
Old Type Tool Number	TS CS Clamp Screw	Wrench	Recommended End Mill
ZR202C/T	TS25	TKY08F	–
ZR252C/T	CS300890T	TKY08F	
ZR322C/T	CS300990T	TKY10F	
ZR402C/T	CS451190T	TKY20F	
ZR502C/T	CS451190T	TKY20F	

REPLACEMENT PARTS FOR OLD TYPE TOOLS (BALL NOSE END MILLS)

FBE2 TYPE

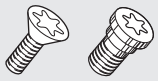
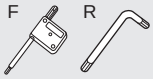
Old Type Tool Number	Clamp Screw	Wrench	Recommended End Mill
FBE2200SM	CS300590T	TKY08R	**SRF** (➲M228)
FBE2250SM	CS350790T	TKY10R	
FBE2300SM	CS400990T	TKY15R	
FBE2200SF	CS300590T	TKY08R	
FBE2250SF	CS350790T	TKY10R	
FBE2300SF	CS400990T	TKY15R	

TBE1/TBE2 TYPE

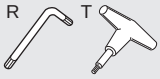
Old Type Tool Number	 Clamp Screw		 Wrench				Recommended End Mill
	TS R	CS Peripheral	F R		R Peripheral		
TBE1100SS	TS3	–	TKY08F	–	–	–	–
TBE1100SM	TS3	–	TKY08F	–	–	–	
TBE1100S	TS3	–	TKY08F	–	–	–	
TBE1150S	CS300790TS	–	–	TKY10R	–	–	**SRM2** (➲M236)
TBE1200S	CS400990T	–	–	TKY15R	–	–	
TBE1250S	CS400990T	–	–	TKY15R	–	–	
TBE1300S	CS501290T	–	–	TKY25R	–	–	
TBE2150S	TS254	–	TKY08F	–	–	–	
TBE2150SM	TS254	–	–	–	–	–	
TBE2160S	TS254	–	–	–	–	–	
TBE2160SM	TS254	–	–	–	–	–	
TBE2200S	CS350790T	–	–	TKY10R	–	–	
TBE2200SM	CS350790T	–	–	TKY10R	–	–	
TBE2250S	CS400990T	–	–	TKY15R	–	–	
TBE2250SM	CS400990T	–	–	TKY15R	–	–	
TBE2300S	CS501290T	–	–	TKY25R	–	–	
TBE2300SM	CS501290T	–	–	TKY25R	–	–	
TBE1150SU	CS300790TS	–	–	TKY10R	–	–	
TBE1200SU	CS400990T	–	–	TKY15R	–	–	
TBE1250SU	CS400990T	–	–	TKY15R	–	–	
TBE1300SU	CS501290T	–	–	TKY25R	–	–	
TBE2150SU	TS254	–	TKY08F	–	–	–	
TBE2160SU	TS254	–	TKY08F	–	–	–	
TBE2200SU	CS350790T	–	–	TKY10R	–	–	
TBE2250SU	CS400990T	–	–	TKY15R	–	–	
TBE2300SU	CS501290T	–	–	TKY25R	–	–	
TBE1200SL	CS400990T	TS3	–	TKY15R	TKY08F	–	
TBE1250SL	CS400990T	TS3	–	TKY15R	TKY08F	–	
TBE1300SL	CS501290T	TS4	–	TKY25R	–	TKY15R	
TBE2200SL	CS350790T	CS350790T	–	TKY10R	–	TKY10R	
TBE2250SL	CS400990T	CS400990T	–	TKY15R	–	TKY15R	
TBE2300SL	CS501290T	CS400990T	–	TKY25R	–	TKY15R	

REPLACEMENT PARTS FOR OLD TYPE TOOLS (BALL NOSE END MILLS)

TRM2 TYPE

Old Type Tool Number	 Clamp Screw		 Wrench		Recommended End Mill
	Inner, Outer	Peripheral	Inner, Outer	Peripheral	
TRM2200SM	CS300790TS	–	TKY10R	–	**SRM2** (➲M236)
TRM2250SM	CS400990T	–	TKY15R	–	
TRM2300SM	CS501290T	–	TKY25R	–	
TRM2200SL	CS300790TS	TS3	TKY10R	TKY08F	
TRM2250SL	CS400990T	TS3	TKY15R	TKY08F	
TRM2300SL	CS501290T	TS4	TKY25R	TKY15R	
TRM2200SF	CS300790TS	TS3	TKY10R	TKY08F	
TRM2250SF	CS400990T	TS3	TKY15R	TKY08F	
TRM2300SF	CS501290T	TS4	TKY25R	TKY15R	

TRM4 TYPE

Old Type Tool Number	Clamp Screw	 Wrench	Recommended End Mill
TRM4400SL	CS451190T	TKY20R	**SRM2-40/50** (➲M244)
TRM4500SL	CS501290T	TKY25T	
TRM4400SF	CS451190T	TKY20R	
TRM4500SF	CS501290T	TKY25T	

REPLACEMENT PARTS FOR OLD TYPE TOOLS (DRILLS)

TASS TYPE (STANDARD)

Old Type Tool Number	Clamp Screw	Wrench	Recommended Drill
TASS1600S32	TS202	TKY06F	**TAF Drill** (➲P241)
TASS1700S32	TS202	TKY06F	
TASS1800S32	TS202	TKY06F	
TASS1900S32	TS202	TKY06F	
TASS2000S32	TS25	TKY08F	
TASS2100S32	TS25	TKY08F	
TASS2200S32	TS25	TKY08F	
TASS2300S32	TS25	TKY08F	
TASS2400S32	TS25	TKY08F	
TASS2500S32	TS32	TKY08F	
TASS2600S32	TS32	TKY08F	
TASS2700S32	TS32	TKY08F	
TASS2800S32	TS32	TKY08F	
TASS2900S32	TS32	TKY08F	
TASS3000S32	TS43	TKY15F	
TASS3100S32	TS43	TKY15F	
TASS3200S32	TS43	TKY15F	
TASS3300S40	TS43	TKY15F	
TASS3400S40	TS43	TKY15F	
TASS3500S40	TS43	TKY15F	
TASS3600S40	TS43	TKY15F	

TASS TYPE (FLANGE)

Old Type Tool Number	Clamp Screw	Wrench	Recommended Drill
TASS1600C20	TS202	TKY06F	**TAF Drill** (➲P241)
TASS1650C20	TS202	TKY06F	
TASS1700C20	TS202	TKY06F	
TASS1750C20	TS202	TKY06F	
TASS1800C20	TS202	TKY06F	
TASS1850C20	TS202	TKY06F	
TASS1900C20	TS202	TKY06F	
TASS1950C20	TS202	TKY06F	
TASS2000C20	TS25	TKY08F	
TASS2100C25	TS25	TKY08F	
TASS2200C25	TS25	TKY08F	
TASS2300C25	TS25	TKY08F	
TASS2400C25	TS25	TKY08F	
TASS2500C25	TS32	TKY08F	
TASS2600C25	TS32	TKY08F	
TASS2700C25	TS32	TKY08F	
TASS2800C25	TS32	TKY08F	
TASS2900C25	TS32	TKY08F	
TASS3000C25	TS43	TKY15F	
TASS3100C32	TS43	TKY15F	
TASS3200C32	TS43	TKY15F	
TASS3300C32	TS43	TKY15F	
TASS3400C32	TS43	TKY15F	
TASS3500C32	TS43	TKY15F	
TASS3600C32	TS43	TKY15F	
TASS3700C32	TS43	TKY15F	
TASS3800C32	TS43	TKY15F	
TASS3900C32	TS43	TKY15F	
TASS4000C32	TS5	TKY25F	
TASS4100C32	TS5	TKY25F	
TASS4200C40	TS5	TKY25F	
TASS4300C40	TS5	TKY25F	
TASS4400C40	TS5	TKY25F	
TASS4500C40	TS5	TKY25F	
TASS4600C40	TS5	TKY25F	
TASS4700C40	TS5	TKY25F	
TASS4800C40	TS5	TKY25F	
TASS4900C40	TS5	TKY25F	
TASS5000C40	TS32	TKY08F	

REPLACEMENT PARTS FOR OLD TYPE TOOLS (DRILLS)

TAGS TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Drill
TAGS1600F25	TS2	TKY06F	**TAF Drill** (➲P241)
TAGS1700F25	TS2	TKY06F	
TAGS1800F25	TS2	TKY06F	
TAGS1900F25	TS2	TKY06F	
TAGS2000F25	TS25	TKY08F	
TAGS2100F25	TS25	TKY08F	
TAGS2200F25	TS25	TKY08F	
TAGS2300F25	TS25	TKY08F	
TAGS2400F25	TS25	TKY08F	
TAGS2500F32	TS3	TKY08F	
TAGS2600F32	TS3	TKY08F	
TAGS2700F32	TS3	TKY08F	
TAGS2800F32	TS3	TKY08F	
TAGS2900F32	TS3	TKY08F	
TAGS3000F40	TS4	TKY15F	
TAGS3100F40	TS4	TKY15F	
TAGS3200F40	TS4	TKY15F	
TAGS3300F40	TS4	TKY15F	
TAGS3400F40	TS4	TKY15F	
TAGS3500F40	TS4	TKY15F	
TAGS3600F40	TS4	TKY15F	
TAGS3700F40	TS4	TKY15F	
TAGS3800F40	TS4	TKY15F	
TAGS3900F40	TS4	TKY15F	
TAGS4000F40	TS5	TKY25F	
TAGS4100F40	TS5	TKY25F	
TAGS4200F40	TS5	TKY25F	
TAGS4300F40	TS5	TKY25F	
TAGS4400F40	TS5	TKY25F	
TAGS4500F40	TS5	TKY25F	
TAGS4600F40	TS5	TKY25F	
TAGS4700F40	TS5	TKY25F	
TAGS4800F40	TS5	TKY25F	
TAGS4900F40	TS5	TKY25F	
TAGS5000F40	TS3	TKY08F	
TAGS5100F40	TS3	TKY08F	
TAGS5200F40	TS3	TKY08F	
TAGS5300F40	TS3	TKY08F	
TAGS5400F40	TS3	TKY08F	
TAGS5500F40	TS4	TKY15F	
TAGS5600F40	TS4	TKY15F	
TAGS5700F40	TS4	TKY15F	
TAGS5800F40	TS4	TKY15F	
TAGS5900F40	TS4	TKY15F	

TAGM TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Drill
TAGM1600F25	TS2	TKY06F	**TAF Drill** (➲P241)
TAGM1700F25	TS2	TKY06F	
TAGM1800F25	TS2	TKY06F	
TAGM1900F25	TS2	TKY06F	
TAGM2000F25	TS25	TKY08F	
TAGM2100F25	TS25	TKY08F	
TAGM2200F25	TS25	TKY08F	
TAGM2300F25	TS25	TKY08F	
TAGM2400F25	TS25	TKY08F	
TAGM2500F32	TS3	TKY08F	
TAGM2600F32	TS3	TKY08F	
TAGM2700F32	TS3	TKY08F	
TAGM2800F32	TS3	TKY08F	
TAGM2900F32	TS3	TKY08F	
TAGM3000F40	TS4	TKY15F	
TAGM3100F40	TS4	TKY15F	
TAGM3200F40	TS4	TKY15F	
TAGM3300F40	TS4	TKY15F	
TAGM3400F40	TS4	TKY15F	
TAGM3500F40	TS4	TKY15F	
TAGM3600F40	TS4	TKY15F	
TAGM3700F40	TS4	TKY15F	
TAGM3800F40	TS4	TKY15F	
TAGM3900F40	TS4	TKY15F	
TAGM4000F40	TS5	TKY25F	
TAGM4100F40	TS5	TKY25F	
TAGM4200F40	TS5	TKY25F	
TAGM4300F40	TS5	TKY25F	
TAGM4400F40	TS5	TKY25F	
TAGM4500F40	TS5	TKY25F	
TAGM4600F40	TS5	TKY25F	
TAGM4700F40	TS5	TKY25F	
TAGM4800F40	TS5	TKY25F	
TAGM4900F40	TS5	TKY25F	
TAGM5000F40	TS3	TKY08F	
TAGM5100F40	TS3	TKY08F	
TAGM5200F40	TS3	TKY08F	
TAGM5300F40	TS3	TKY08F	
TAGM5400F40	TS3	TKY08F	
TAGM5500F40	TS4	TKY15F	
TAGM5600F40	TS4	TKY15F	
TAGM5700F40	TS4	TKY15F	
TAGM5800F40	TS4	TKY15F	
TAGM5900F40	TS4	TKY15F	

TAB TYPE

Old Type Tool Number	Clamp Screw	Plug	Wrench	Recommended Drill
TAB1700S32	TS3	PT1/4	TKY08D	**TAF Drill** (➲P241)
TAB1800S32	TS3	PT1/4	TKY08D	
TAB1900S32	TS3	PT1/4	TKY08D	
TAB2000S32	TS32	PT1/4	TKY08D	
TAB2100S32	TS32	PT1/4	TKY08D	
TAB2200S32	TS32	PT1/4	TKY08D	
TAB2300S32	TS32	PT1/4	TKY08D	
TAB2400S32	TS32	PT1/4	TKY08D	
TAB2500S32	TS32	PT1/4	TKY08D	
TAB2600S32	TS4	PT1/4	TKY15D	
TAB2700S32	TS4	PT1/4	TKY15D	
TAB2800S32	TS4	PT1/4	TKY15D	
TAB2900S32	TS4	PT1/4	TKY15D	
TAB3000S32	TS4	PT1/4	TKY15D	
TAB3100S32	TS4	PT1/4	TKY15D	
TAB3200S32	TS4	PT1/4	TKY15D	
TAB3300S40	TS5	PT1/4	TKY25D	
TAB3400S40	TS5	PT1/4	TKY25D	
TAB3500S40	TS5	PT1/4	TKY25D	
TAB3600S40	TS5	PT1/4	TKY25D	
TAB3700S40	TS5	PT1/4	TKY25D	
TAB3800S40	TS5	PT1/4	TKY25D	
TAB3900S40	TS5	PT1/4	TKY25D	
TAB4000S40	TS5	PT1/4	TKY25D	
TAB4100S40	TS5	PT1/4	TKY25D	
TAB4200S40	TS5	PT1/4	TKY25D	
TAB4300S40	TS5	PT1/4	TKY25D	
TAB4400S40	TS5	PT1/4	TKY25D	
TAB4500S40	TS5	PT1/4	TKY25D	

NPX TYPE

Old Type Tool Number	Clamp Screw	Wrench	Recommended Drill
NPXM2000S25	TS3	TKY08F	**TAW Drill** (➲P219)
NPXM2100S25	TS3	TKY08F	
NPXM2200S25	TS3	TKY08F	
NPXM2300S25	TS35	TKY10F	
NPXM2400S32	TS35	TKY10F	
NPXM2500S32	TS35	TKY10F	
NPXM2600S32	TS35	TKY10F	
NPXM2700S32	TS4	TKY15F	
NPXM2800S32	TS4	TKY15F	
NPXM2900S32	TS4	TKY15F	
NPXM3000S32	TS4	TKY15F	

REPLACEMENT PARTS FOR OLD TYPE TOOLS (DRILLS)

WSTAR INSERT TYPE DRILL (TAW TYPE)

Old Type Tool Number	Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Recommended Cutter
TAWSNH1400S16	WS254012T	TKY08W	WPT4405	MK1KS	**STAW**(➲P210)
TAWMNH1400S16	WS254012T	TKY08W	WPT4405	MK1KS	
TAWLNH1400S16	WS254012T	TKY08W	WPT4405	MK1KS	
TAWSNH1500S20	WS254013T	TKY08W	WPT4405	MK1KS	
TAWMNH1500S20	WS254013T	TKY08W	WPT4405	MK1KS	
TAWLNH1500S20	WS254013T	TKY08W	WPT4405	MK1KS	
TAWSN1600S20	WS254014T	TKY08W	WPT4405	MK1KS	
TAWMN1600S20	WS254014T	TKY08W	WPT4405	MK1KS	
TAWLN1600S20	WS254014T	TKY08W	WPT4405	MK1KS	
TAWSN1700S20	WS254015T	TKY08W	WPT4405	MK1KS	
TAWMN1700S20	WS254015T	TKY08W	WPT4405	MK1KS	
TAWLN1700S20	WS254015T	TKY08W	WPT4405	MK1KS	
TAWSN1800S20	WS254016T	TKY08W	WPT4405	MK1KS	
TAWMN1800S20	WS254016T	TKY08W	WPT4405	MK1KS	
TAWLN1800S20	WS254016T	TKY08W	WPT4405	MK1KS	

TECHNICAL DATA

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LIST OF PROPERTY SYMBOLS COMPLYING WITH ISO13399

Alphabetical

Source: ISO13399 standard
URL : https://www.iso.org/search/x/query/13399

ISO13399 Property Symbols	Content
ADJLX	Adjustment limit maximum
ADJRG	Adjustment range
ALF	Clearance angle radial
ALP	Clearance angle axial
AN	Clearance angle major
ANN	Clearance angle minor
APMX	Depth of cut maximum
AS	Clearance angle wiper edge
ASP	Adjusting screw protrusion
AZ	Plunge depth maximum
B	Shank width
BBD	Balanced by design
BCH	Corner chamfer length
BD	Body diameter
BDX	Body diameter maximum
BHCC	Bolt hole circle count
BHTA	Body half taper angle
BMC	Body material code
BS	Wiper edge length
BSR	Wiper edge radius
CASC	Cartridge size code
CB	Chip breaker face count
CBDP	Connection bore depth
CBMD	Chip breaker manufacturers designation
CBP	Chip breaker property
CCMS	Connection code machine side
CCWS	Connection code workpiece side
CCP	Chamfer corner property
CDI	Insert cutting diameter
CDX	Cutting depth maximum
CEATC	Tool cutting edge angle type code
CECC	Cutting edge condition code
CEDC	Cutting edge count
CF	Spot chamfer
CHW	Corner chamfer width
CICT	Cutting item count
CNC	Corner count
CND	Coolant entry diameter
CNSC	Coolant entry style code
CNT	Coolant entry thread size
CP	Coolant pressure
CRE	Spot radius
CRKS	Connection retention knob thread size
CSP	Coolant supply property
CTP	Coating property
CTX	Cutting point translation X-direction
CTY	Cutting point translation Y-direction
CUTDIA	Work piece parting diameter maximum
CUB	Connection unit basis
CW	Cutting width
CWX	Cutting width maximum
CXD	Coolant exit diameter

ISO13399 Property Symbols	Content
CXSC	Coolant exit style code
CZC	Connection size code
D1	Fixing hole diameter
DAH	Diameter access hole
DAXN	Axial groove outside diameter minimum
DAXX	Axial groove outside diameter maximum
DBC	Diameter bolt circle
DC	Cutting diameter
DCB	Connection bore diameter
DCBN	Connection bore diameter minimum
DCBX	Connection bore diameter maximum
DCC	Design configuration style code
DCCB	Counterbore diameter connection bore
DCIN	Cutting diameter internal
DCINN	Cutting diameter internal minimum
DCINX	Cutting diameter internal maximum
DCN	Cutting diameter minimum
DCON	Connection diameter
DCONMS	Connection diameter machine side
DCONWS	Connection diameter workpiece side
DCSC	Cutting diameter size code
DCSFMS	Contact surface diameter machine side
DCX	Cutting diameter maximum
DF	Flange diameter
DHUB	Hub diameter
DMIN	Minimum bore diameter
DMM	Shank diameter
DN	Neck diameter
DRVA	Drive angle
EPSR	Insert included angle
FHA	Flute helix angle
FHCSA	Fixing hole countersunk angle
FHCSD	Fixing hole countersunk diameter
FLGT	Flange thickness
FMT	Form type
FXHLP	Fixing hole property
GAMF	Rake angle radial
GAMN	Rake angle normal
GAMO	Rake angle orthogonal
GAMP	Rake angle axial
GAN	Insert rake angle
H	Shank height
HA	Thread height theoretical
HAND	Hand
HBH	Head bottom offset height
HBKL	Head back offset length
HBKW	Head back offset width
HBL	Head bottom offset length
HC	Thread height actual
HF	Functional height
HHUB	Hub height
HTB	Body height
IC	Inscribed circle diameter
IFS	Insert mounting style code
IIC	Insert interface code
INSL	Insert length
KAPR	Tool cutting edge angle
KCH	Corner chamfer angle

LIST OF PROPERTY SYMBOLS COMPLYING WITH ISO13399

ISO13399 Property Symbols	Content
KRINS	Cutting edge angle major
KWL	Keyway length
KWW	Keyway width
KYP	Keyway property
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LBB	Chip breaker width
LBX	Body length maximum
LCCB	Counterbore depth connection bore
LCF	Length chip flute
LDRED	Reduced body diameter length
LE	Cutting edge effective length
LF	Functional length
LFA	A dimension on lf
LH	Head length
LPR	Protruding length
LS	Shank length
LSC	Clamping length
LSCN	Clamping length minimum
LSCX	Clamping length maximum
LTA	LTA length (length from MCS to CRP)
LU	Usable length
LUX	Usable length maximum
M	M-dimension
M2	Distance between the nominal inscribed circle and the corner of an insert that has the secondary included angle
MHA	Mounting hole angle
MHD	Mounting hole distance
MHH	Mounting hole height
MIID	Master insert identification
MTP	Clamping type code
NCE	Cutting end count
NOF	Flute count
NOI	Insert index count
NT	Tooth count
OAH	Overall height
OAL	Overall length
OAW	Overall width
PDPT	Profile depth insert
PDX	Profile distance ex
PDY	Profile distance ey
PFS	Profile style code
PL	Point length
PNA	Profile included angle
PSIR	Tool lead angle
PSIRL	Cutting edge angle major left hand
PSIRR	Cutting edge angle major right hand
RAL	Relief angle left hand
RAR	Relief angle right hand
RCP	Rounded corner property
RE	Corner radius
REL	Corner radius left hand
RER	Corner radius right hand
RMPX	Ramping angle maximum
RPMX	Rotational speed maximum
S	Insert thickness
S1	Insert thickness total

ISO13399 Property Symbols	Content
SC	Insert shape code
SDL	Step diameter length
SIG	Point angle
SSC	Insert seat size code
SX	Shank cross section shape code
TC	Tolerance class insert
TCE	Tipped cutting edge code
TCTR	Thread tolerance class
TD	Thread diameter
THFT	Thread form type
THL	Threading length
THLGTH	Thread length
THSC	Tool holder shape code
THUB	Hub thickness
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch minimum
TPIX	Threads per inch maximum
TPN	Thread pitch minimum
TPT	Thread profile type
TPX	Thread pitch maximum
TQ	Torque
TSYC	Tool style code
TTP	Thread type
ULDR	Usable length diameter ratio
UST	Unit system
W1	Insert width
WEP	Wiper edge property
WF	Functional width
WF2	Distance between the cutting reference point and the front seating surface of a turning tool
WFS	Functional width secondary
WT	Weight of item
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count
ZNC	Cutting edge center count
ZNF	Face mounted insert count
ZNP	Peripheral mounted insert count

LIST OF REFERENCE SYMBOLS COMPLYING WITH ISO13399

ISO13399 Reference Symbols	Content
CIP	Coordinate system in process
CRP	Cutting reference point
CSW	Coordinate system workpiece side
MCS	Mounting coordinate system
PCS	Primary coordinate system

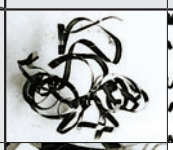
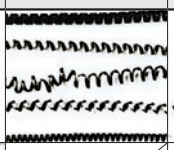
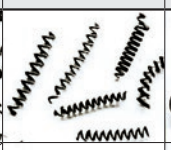
TROUBLE SHOOTING FOR TURNING

Trouble		Solution / Factors	Insert Grade Selection				Cutting Conditions					Style and Design of the Tool							Machine, Installation of Tool		
			Select a harder grade	Select a tougher grade	Select a grade with better thermal shock resistance	Select a grade with better adhesion resistance	Cutting speed (Up ↗ / Down ↘)	Feed (Up ↗ / Down ↘)	Depth of cut (Up ↗ / Down ↘)	Coolant: Do not use water-soluble cutting fluid	Coolant: Determine dry or wet cutting	Select chip breaker	Rake (Up ↗ / Down ↘)	Corner radius (Up ↗ / Down ↘)	Lead angle (Up ↗ / Down ↘)	Honing strengthens the cutting edge (Up ↗ / Down ↘)	Class of insert	Improve tool holder rigidity	Increase clamping rigidity of the tool and workpiece	Decrease holder overhang	Decrease power and machine backlash
Deterioration of Tool Life	Insert wear quickly generated	Improper tool grade	●																		
		Improper cutting edge geometry										●	↗●	↗●	↗●	●↘					
		Improper cutting speed					●↘	↗●			● Wet										
	Chipping or fracturing of cutting edge	Improper tool grade		●																	
		Improper cutting conditions						●↘	●↘												
		Lack of cutting edge strength.										●		↗●		↗●					
		Thermal crack occurs			●		●↘	●↘	●↘	●	● Dry										
		Build-up edge occurs				●	↗●	↗●		●	● Wet										
		Lack of rigidity																●	●	●	●
Out of Tolerance	Dimensions are not constant	Poor insert accuracy															●				
		Large cutting resistance and cutting edge flank										●	●	●↘	●↘	●↘		●	●	●	●
	Necessary to adjust often because of over-size	Improper tool grade	●																		
		Improper cutting conditions					●↘	↗●													
Deterioration of Surface Finish	Poor finished surface	Welding occurs					↗●			●	● Wet										
		Improper cutting edge geometry										●		↗●							
		Chattering					●↘	●↘	●↘									●	●	●	●
Generation of Heat	Workpiece over heating can cause poor accuracy and short life of insert	Improper cutting conditions					●↘	●↘	●↘												
		Improper cutting edge geometry										●	↗●			●↘					

Trouble		Solution / Factors	Insert Grade Selection				Cutting Conditions					Style and Design of the Tool							Machine, Installation of Tool		
			Select a harder grade	Select a tougher grade	Select a grade with better thermal shock resistance	Select a grade with better adhesion resistance	Cutting speed (Up ↗ / Down ↘)	Feed (Up ↗ / Down ↘)	Depth of cut (Up ↗ / Down ↘)	Coolant: Do not use water-soluble cutting fluid	Coolant: Determine dry or wet cutting	Select chip breaker	Rake (Up ↗ / Down ↘)	Corner radius (Up ↗ / Down ↘)	Lead angle (Up ↗ / Down ↘)	Honing strengthens the cutting edge (Up ↗ / Down ↘)	Class of insert	Improve tool holder rigidity	Increase clamping rigidity of the tool and workpiece	Decrease holder overhang	Decrease power and machine backlash
Burrs, Chipping etc.	Burrs (Steel, Aluminium)	Notch wear	●																		
		Improper cutting conditions					● ↘	↗ ●			● Wet										
		Improper cutting edge geometry										●	↗ ●	● ↘	● ↘	● ↘					
	Workpiece chipping (Cast iron)	Improper cutting conditions						● ↘	● ↘												
		Improper cutting edge geometry										●	↗ ●	↗ ●	↗ ●	● ↘					
		Vibration occurs																●	●	●	●
	Burrs (Mild steel)	Improper tool grade				●															
		Improper cutting conditions					↗ ●			●	● Wet										
		Improper cutting edge geometry										●	↗ ●			● ↘					
		Vibration occurs																●	●	●	●
Poor Chip Dispersal	Long chips	Improper cutting conditions					● ↘	↗ ●	↗ ●		● Wet										
		Large chip control range										●									
		Improper cutting edge geometry												● ↘	● ↘						
	Chips are short and scattered	Improper cutting conditions						● ↘	● ↘		● Dry										
		Small chip control range										●									
		Improper cutting edge geometry												↗ ●	↗ ●						

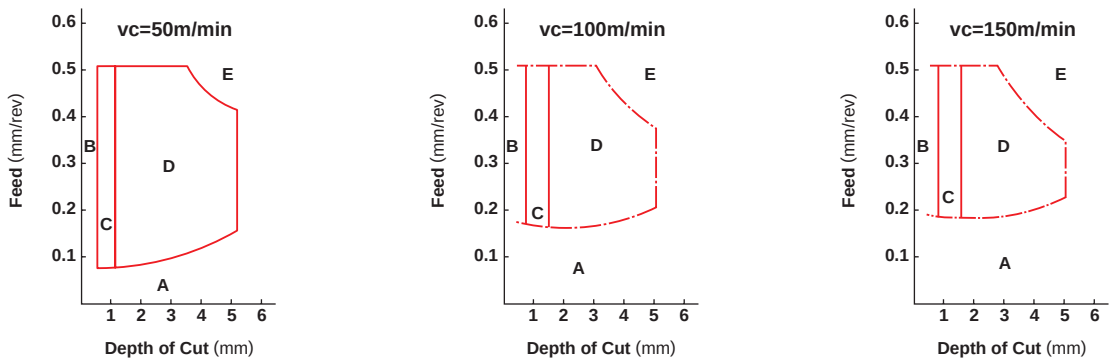
CHIP CONTROL FOR TURNING

■CHIP BREAKING CONDITIONS IN STEEL TURNING

Type	A Type	B Type	C Type	D Type	E Type
Small Depth of Cut d < 7mm					
Small Depth of Cut d=7−15mm					
Curl Length l	Curless	l ≥ 50mm	l ≤ 50mm 1−5 Curl	≒ 1 Curl	Less Than 1 Curl Half a Curl
Note	●Irregular continuous shape ●Tangle around tool and workpiece	●Regular continuous shape ●Long chips	Good	Good	●Chip scattering ●Chattering ●Poor finished surface ●Maximum

●Cutting speed and chip control range of chip breaker

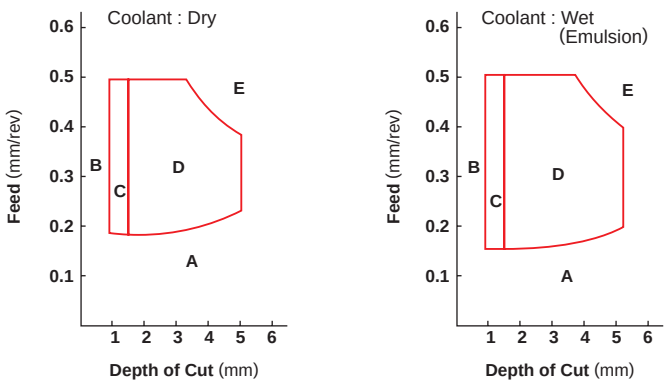
In general, when cutting speed increases, the chip control range tends to become narrower.



Workpiece : **S45C(180HB)**
Insert : **TNMG160408**
Grade : **P10**Cemented Carbide
Tool : **MTJNR2525M16N**
Dry Cutting

●Effects of coolant on the chip control range of a chip breaker

If the cutting speed is the same, the range of chip control differs according to whether coolant is used or not.



Workpiece : **S45C**
Cutting Conditions : **vc=100m/min**

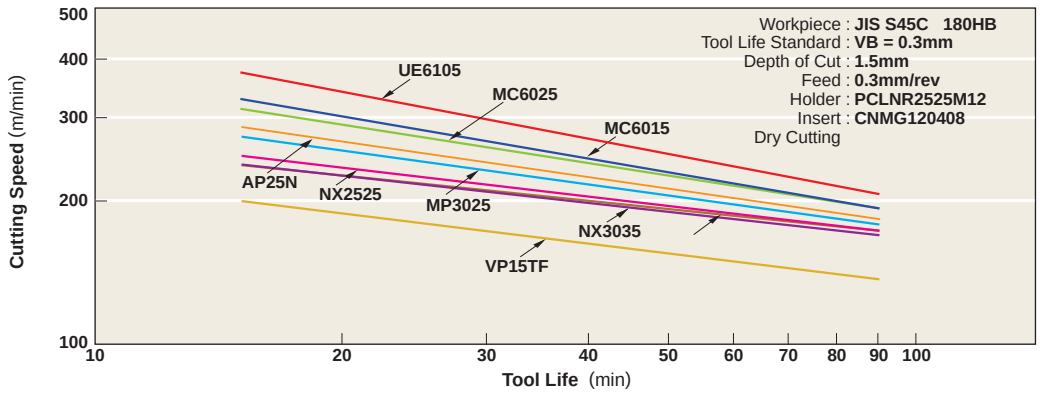
EFFECTS OF CUTTING CONDITIONS FOR TURNING

■EFFECTS OF CUTTING CONDITIONS

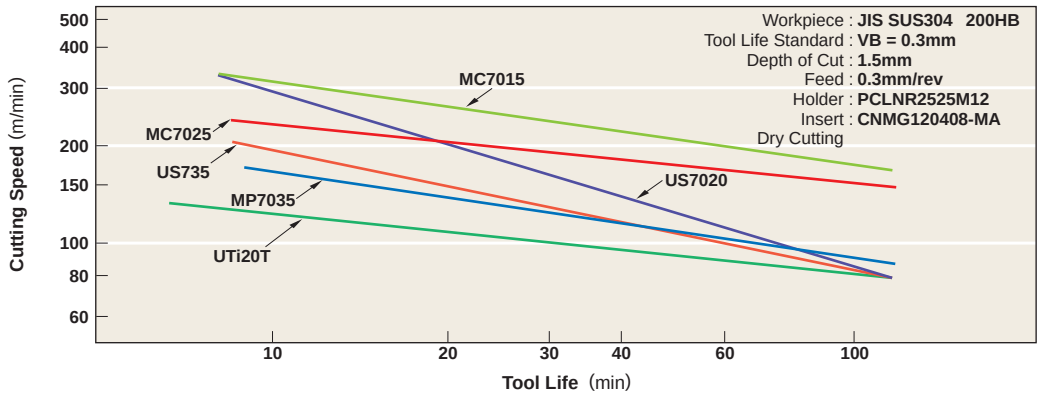
Ideal conditions for cutting are short cutting time, long tool life, and high cutting accuracy. In order to obtain these conditions, selection of efficient cutting conditions and tools, based on work material, hardness, shape and machine capability is necessary.

■CUTTING SPEED

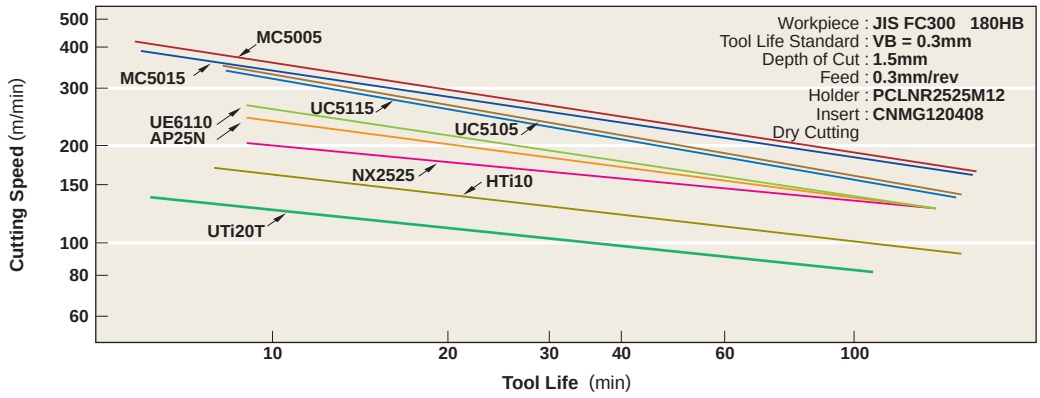
Cutting speed effects tool life greatly. Increasing cutting speed increases cutting temperature and results in shortening tool life. Cutting speed varies depending on the type and hardness of the work material. Selecting a tool grade suitable for the cutting speed is necessary.



P Class Grade Tool Life



M Class Grade Tool Life



K Class Grade Tool Life

●Effects of Cutting Speed

1. Increasing cutting speed by 20% decreases tool life by 50%. Increasing cutting speed by 50% decreases tool life by 80%.
2. Cutting at low cutting speed (20−40m/min) tends to cause chattering. Thus, tool life is shortened.

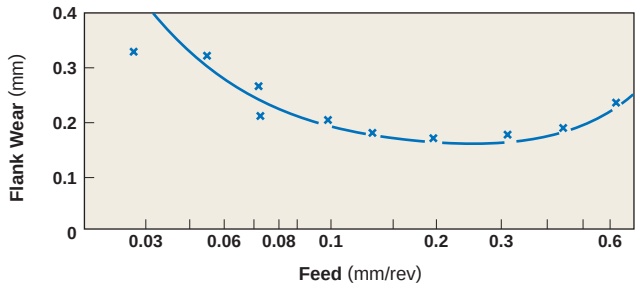
EFFECTS OF CUTTING CONDITIONS FOR TURNING

■FEED

When cutting with a general type holder, feed is the distance a holder moves per workpiece revolution. When milling, feed is the distance a machine table moves per cutter revolution divided by the number of inserts. Thus, it is indicated as feed per tooth. Feed rate relates to finished surface roughness.

●Effects of Feed

1. Decreasing feed rate results in flank wear and shortens tool life.
2. Increasing feed rate increases cutting temperature and flank wear. However, effects on the tool life is minimal compared to cutting speed.
3. Increasing feed rate improves machining efficiency.



Cutting Conditions Workpiece : **JIS SNCM431** Grade : **STi10T**
Insert : **0-0-5-5-35-35-0.3mm**
Depth of Cut **ap=1.0mm** Cutting Speed **vc=200m/min**
Cutting Time **Tc=10min**

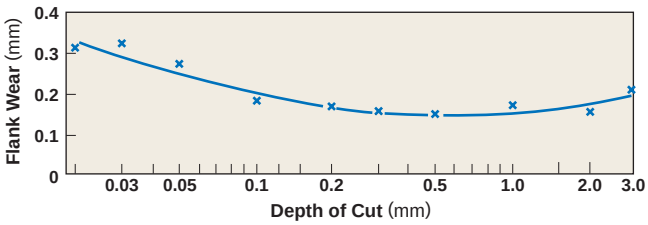
Feed and Flank Wear Relationship in Steel Turning

■DEPTH OF CUT

Depth of cut is determined according to the required stock removal, shape of workpiece, power and rigidity of the machine and tool rigidity.

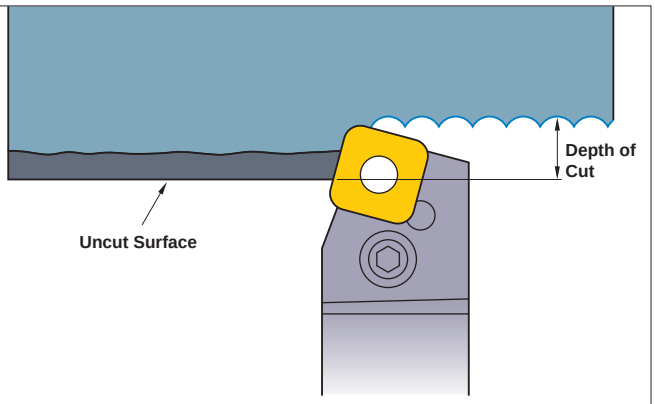
●Effects of Depth of Cut

1. Changing depth of cut doesn't effect tool life greatly.
2. Small depths of cut result in friction when cutting the hardened layer of a workpiece. Thus tool life is shortened.
3. When cutting uncut surfaces or cast iron surfaces, the depth of cut needs to be increased as much as the machine power allows in order to avoid cutting impure hard layers with the tip of cutting edge to prevent chipping and abnormal wear.



Cutting Conditions Workpiece : **JIS SNCM431** Grade : **STi10T**
Insert : **0-0-5-5-35-35-0.3mm**
Feed **f=0.20mm/rev** Cutting Speed **vc=200m/min**
Cutting Time **Tc=10min**

Depth of Cut and Flank Wear Relationship in Steel Turning

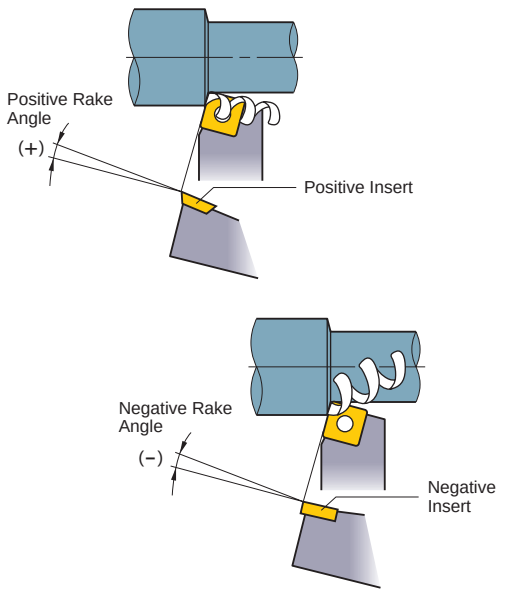


Roughing of Surface Layer that Includes Uncut Surface

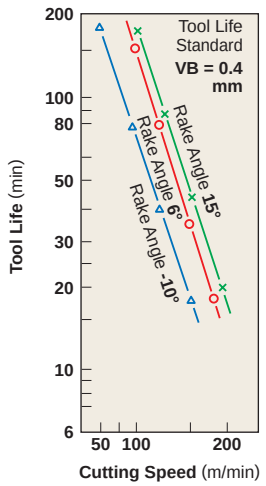
FUNCTION OF TOOL FEATURES FOR TURNING

■RAKE ANGLE

Rake angle is cutting edge angle that has a large effect on cutting resistance, chip disposal, cutting temperature and tool life.

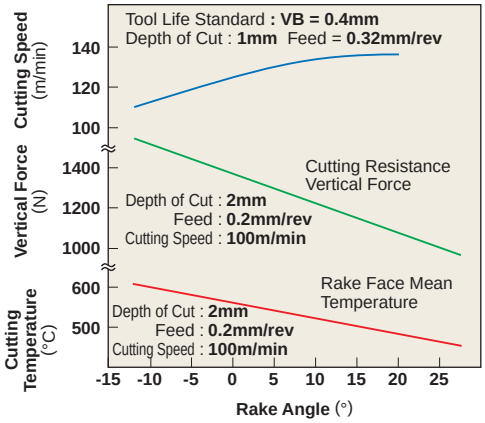


Chip Disposal and Rake Angle



Cutting Conditions
Grade : **STi10**
Depth of Cut : **1mm** Feed : **0.32mm/rev**
Workpiece : **JIS SK5**

Rake Angle and Tool Life



Cutting Conditions
Workpiece : **JIS SK5** Grade : **STi10T**
Insert : **0-Var-5-5-20-20-0.5mm**
Dry Cutting

Effects of Rake Angle on Cutting Speed, Vertical Force, and Cutting Temperature

●Effects of Rake Angle

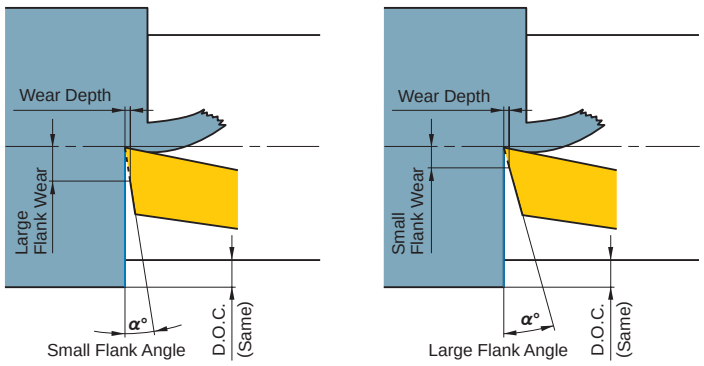
1. Increasing rake angle in the positive (+) direction improves sharpness.
2. Increasing rake angle by 1° in the positive (+) direction decreases cutting power by about 1%.
3. Increasing rake angle in the positive (+) direction lowers cutting edge strength and in the negative (-) direction increases cutting resistance.

When to Increase Rake Angle in the Negative (-) Direction
○ Hard workpieces.
○ When the cutting edge strength is required such as for uncut surfaces and interrupted cutting.

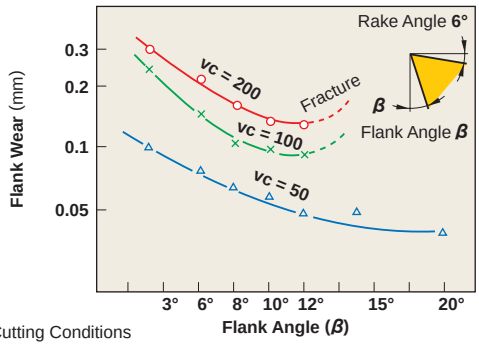
When to Increase Rake Angle in the Positive (+) Direction
○ Soft workpieces.
○ Workpiece is easily machined.
○ When the workpiece or the machine have poor rigidity.

■FLANK ANGLE

Flank angle prevents friction between flank face and workpiece resulting in smooth feed.



Flank angle creates a space between tool and workpiece. Flank angle relates to flank wear.



Cutting Conditions
Workpiece : **JIS SNCM431 (200HB)**
Grade : **STi20** Insert : **0-6-β-β-20-20-0.5mm**
Depth of Cut : **1mm** Feed : **0.32mm/rev** Cutting Time : **20min**

Flank Angle and Flank Wear Relationship

●Effects of Rake Angle

1. Increasing flank angle decreases flank wear occurrence.
2. Increasing flank angle lowers cutting edge strength.

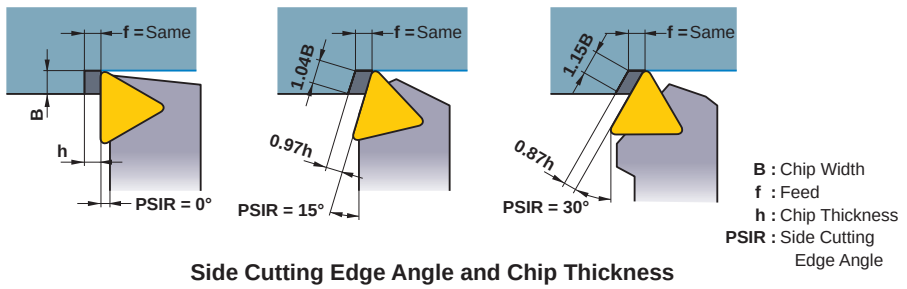
When to Decrease Flank Angle
○ Hard workpieces.
○ When cutting edge strength is required.

When to Increase Flank Angle
○ Soft workpieces.
○ Workpieces suffer from work hardening easily.

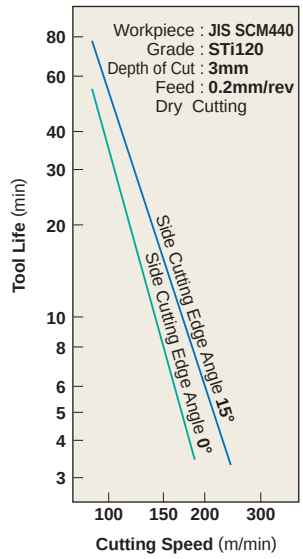
FUNCTION OF TOOL FEATURES FOR TURNING

■SIDE CUTTING EDGE ANGLE (LEAD ANGLE)

The side cutting edge angle reduces impact load and effects the amount of feed force, back force and chip thickness.



Side Cutting Edge Angle and Chip Thickness

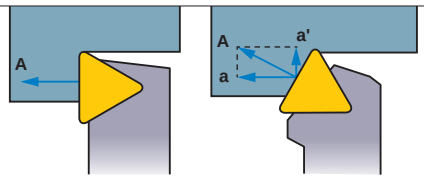


Side Cutting Edge and Tool Life

●Effects of Side Cutting Edge Angle (Lead Angle)

1. At the same feed rate, increasing the side cutting edge angle increases the chip contact length and decreases chip thickness. As a result, the cutting force is dispersed on a longer cutting edge and tool life is prolonged. (Refer to the chart.)
2. Increasing the side cutting edge angle increases force a'. Thus, thin, long workpieces suffer from bending in some cases.
3. Increasing the side cutting edge angle decreases chip control.
4. Increasing the side cutting edge angle decreases the chip thickness and increases chip width. Thus, breaking chips is difficult.

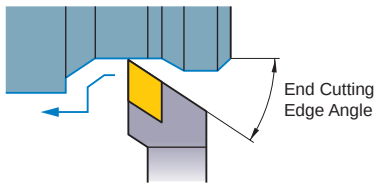
When to Decrease Lead Angle	When to Increase Lead Angle
○ Finishing with small depth of cut. ○ Thin, long workpieces. ○ When the machine has poor rigidity.	○ Hard workpieces which produce high cutting temperature. ○ When roughing a workpiece with large diameter. ○ When the machine has high rigidity.



Receive force A. **Force A is divided into a and a'.**

■END CUTTING EDGE ANGLE

The end cutting edge angle avoids interference between the machined surface and the tool (end cutting edge). Usually 5°–15°.

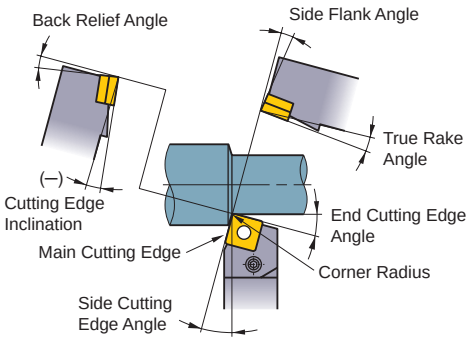


●Effects of End Cutting Edge Angle

1. Decreasing the end cutting edge angle increases cutting edge strength, but it also increases cutting edge temperature.
2. Decreasing the end cutting edge angle increases the back force and can result in chattering and vibration while machining.
3. Small end cutting edge angle for roughing and large angle for finishing are recommended.

■CUTTING EDGE INCLINATION

Cutting edge inclination indicates inclination of the rake face. During heavy cutting, the cutting edge receives an extremely large shock at the beginning of each cut. Cutting edge inclination keeps the cutting edge from receiving this shock and prevents fracturing. 3°–5° in turning and 10°–15° in milling are recommended.

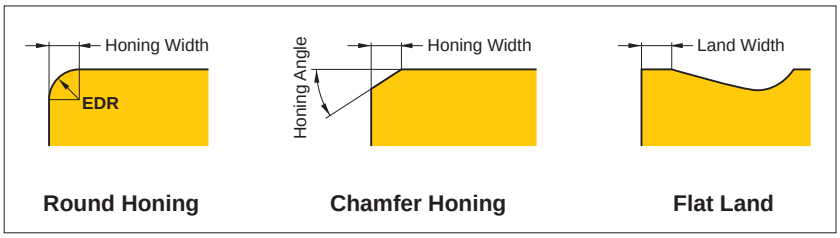


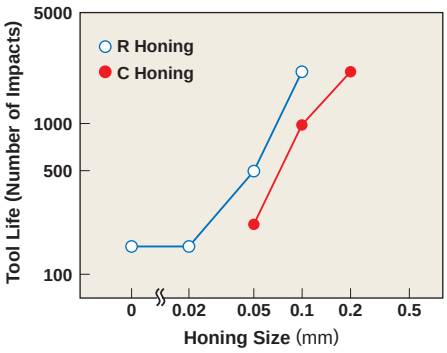
●Effects of Cutting Edge Inclination

1. Negative (–) cutting edge inclination disposes chips in the workpiece direction, and positive (+) disposes chips in the opposite direction.
2. Negative (–) cutting edge inclination increases cutting edge strength, but it also increases the back force of cutting resistance. Thus, chattering can easily occur.

■HONING AND LAND

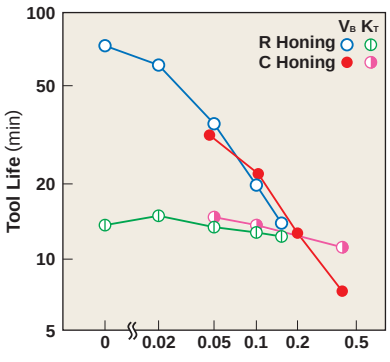
Honing and land are cutting edge shapes that maintain cutting edge strength.
Honing can be round or chamfer type. The optimal honing width is approximately 1/2 of the feed.
Land is the narrow flat area on the rake or flank face.





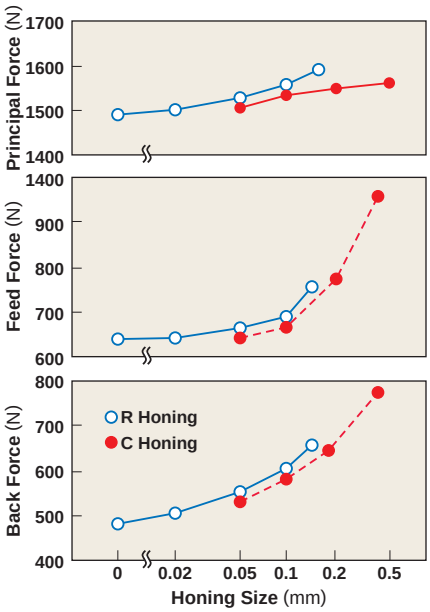
Workpiece : **JIS SNCM439 (280HB)**
Grade : **P10**
Cutting Conditions : **vc=200m/min ap=1.5mm f=0.335mm/rev**

Honing Size and Tool Life Due to Fracturing



Workpiece : **JIS SNCM439 (220HB)**
Grade : **P10**
Cutting Conditions : **vc=160m/min ap=1.5mm f=0.45mm/rev**

Honing Size and Tool Life Due to Wear



Workpiece : **JIS SNCM439 (220HB)**
Grade : **P10**
Cutting Conditions : **vc=100m/min ap=1.5mm f=0.425mm/rev**

Honing Size and Cutting Resistance

●Effects of Honing

1. Enlarging the honing increases cutting edge strength, tool life and reduces fracturing.
2. Enlarging the honing increases flank wear occurrence and shortens tool life. Honing size doesn't affect rake wear.
3. Enlarging the honing increases cutting resistance and chattering.

When to Decrease Honing Size
○ When finishing with small depth of cut and small feed. ○ Soft workpieces. ○ When the workpiece or the machine have poor rigidity.

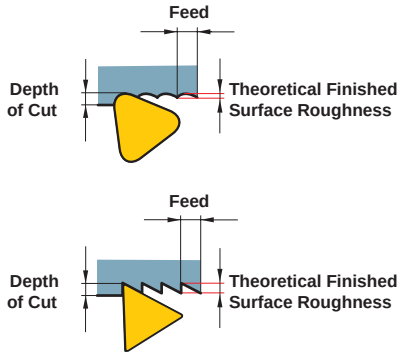
When to Increase Honing Size
○ Hard workpieces. ○ When the cutting edge strength is required such as for uncut surfaces and interrupted cutting. ○ When the machine has high rigidity.

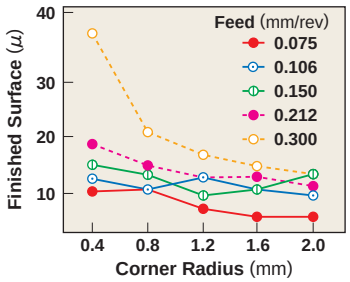
Note 1) Cemented carbide, coated diamond, and indexable cermet inserts have round honing as standard.

FUNCTION OF TOOL FEATURES FOR TURNING

■RADIUS

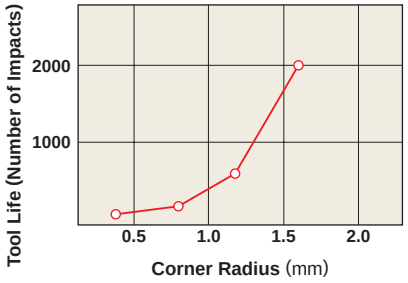
Radius effects the cutting edge strength and finished surface. In general, a corner radius 2–3 times the feed is recommended.





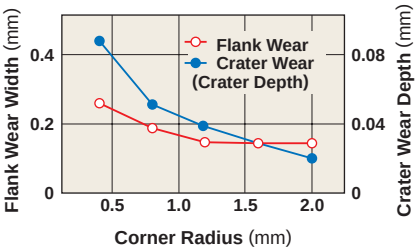
Workpiece : **JIS SNCM439 (200HB)**
Grade : **P20**
Cutting Conditions : **vc=120m/min ap=0.5mm**

Corner Radius and Finished Surface



Workpiece : **JIS SNCM440 (280HB)**
Grade : **P10**
Cutting Conditions : **vc=100m/min ap=2mm f=0.335mm/rev**

Corner Radius Size and Tool Life Due to Fracturing



Workpiece : **JIS SNCM439 (200HB)**
Grade : **P10**
Cutting Conditions : **vc=140m/min ap=2mm f=0.212mm/rev Tc=10min**

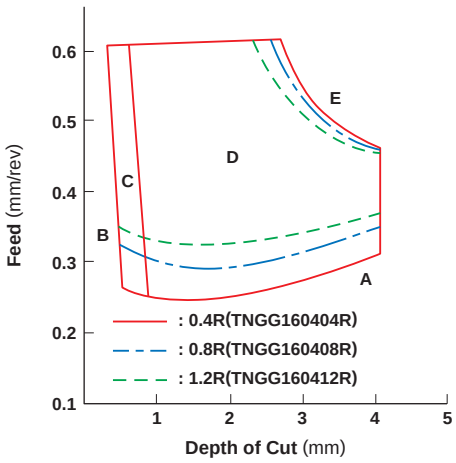
Corner Radius Size and Tool Wear

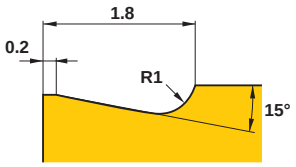
●Effects of Corner Radius

1. Increasing the corner radius improves the surface finish.
2. Increasing the corner radius improves cutting edge strength.
3. Increasing the corner radius too much increases the cutting resistance and causes chattering.
4. Increasing the corner radius decreases flank and rake wear.
5. Increasing the corner radius too much results in poor chip control.

When to Decrease Corner Radius	When to Increase Corner Radius
○Finishing with small depth of cut. ○Thin, long workpieces. ○When the machine has poor rigidity.	○When the cutting edge strength is required such as in intrrupted cutting and uncut surface cutting. ○When roughing a workpiece with large diameter. ○When the machine has high rigidity.

●Corner Radius and Chip Control Range





Workpiece : **JIS S45C (180HB)**
Insert : **TNGG160404R TNGG160408R TNGG160412R (STi10T)**
Holder : **ETJNR33K16 (Side Cutting Edge angle 3°)**
Cutting Speed : **vc=100m/min**
Dry Cutting

FORMULAE FOR CUTTING POWER

■CUTTING POWER (Pc)

$$Pc = \frac{ap \cdot f \cdot vc \cdot Kc}{60 \times 10^3 \times \eta} \text{ (kW)}$$

Pc (kW) : Actual Cutting Power
f (mm/rev) : Feed per Revolution
Kc (MPa) : Specific Cutting Force
ap (mm) : Depth of Cut
vc (m/min) : Cutting Speed
η : (Machine Coefficient)

(Problem) What is the cutting power required for machining mild steel at cutting speed 120m/min with depth of cut 3mm and feed 0.2mm/rev (Machine coefficient 80%) ?

(Answer) Substitute the specific cutting force Kc=3100MPa into the formula.

$$Pc = \frac{3 \times 0.2 \times 120 \times 3100}{60 \times 10^3 \times 0.8} = 4.65 \text{(kW)}$$

● **Kc**

Work Material	Tensile Strength(MPa) and Hardness	Specific Cutting Force Kc (MPa)				
		0.1 (mm/rev)	0.2 (mm/rev)	0.3 (mm/rev)	0.4 (mm/rev)	0.6 (mm/rev)
Mild Steel	**520**	3610	3100	2720	2500	2280
Medium Steel	**620**	3080	2700	2570	2450	2300
Hard Steel	**720**	4050	3600	3250	2950	2640
Tool Steel	**670**	3040	2800	2630	2500	2400
Tool Steel	**770**	3150	2850	2620	2450	2340
Chrome Manganese Steel	**770**	3830	3250	2900	2650	2400
Chrome Manganese Steel	**630**	4510	3900	3240	2900	2630
Chrome Molybdenum Steel	**730**	4500	3900	3400	3150	2850
Chrome Molybdenum Steel	**600**	3610	3200	2880	2700	2500
Nickel Chrome Molybdenum Steel	**900**	3070	2650	2350	2200	1980
Nickel Chrome Molybdenum Steel	**352HB**	3310	2900	2580	2400	2200
Hard Cast Iron	**46HRC**	3190	2800	2600	2450	2270
Meehanite Cast Iron	**360**	2300	1930	1730	1600	1450
Grey Cast Iron	**200HB**	2110	1800	1600	1400	1330

■CUTTING SPEED (vc)

$$vc = \frac{\pi \cdot Dm \cdot n}{1000} \text{ (m/min)}$$

vc (m/min) : Cutting Speed
Dm (mm) : Workpiece Diameter
π (3.14) : Pi
n (min^{-1}) : Main Axis Spindle Speed

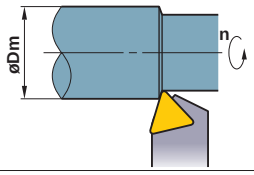
*Divide by 1000 to change to m from mm.

(Problem) What is the cutting speed when main axis spindle speed is 700min^{-1} and external diameter is ϕ50 ?

(Answer) Substitute π=3.14, Dm=50, n=700 into the formula.

$$vc = \frac{\pi \cdot Dm \cdot n}{1000} = \frac{3.14 \times 50 \times 700}{1000} = 110 \text{m/min}$$

Cutting speed is 110m/min.



■FEED (f)

$$f = \frac{l}{n} \text{ (mm/rev)}$$

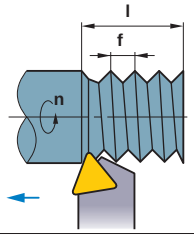
f (mm/rev) : Feed per Revolution
l (mm/min) : Cutting Length per Min.
n (min^{-1}) : Main Axis Spindle Speed

(Problem) What is the feed per revolution when main axis spindle speed is 500min^{-1} and cutting length per minute is 120mm/min ?

(Answer) Substitute n=500, l=120 into the formula.

$$f = \frac{l}{n} = \frac{120}{500} = 0.24 \text{mm/rev}$$

The answer is 0.24mm/rev.



■CUTTING TIME (Tc)

$$Tc = \frac{lm}{l} \text{ (min)}$$

Tc (min) : Cutting Time
lm (mm) : Workpiece Length
l (mm/min) : Cutting Length per Min.

(Problem) What is the cutting time when 100mm workpiece is machined at 1000min^{-1} with feed = 0.2mm/rev ?

(Answer) First, calculate the cutting length per min. from the feed and spindle speed.

$$l = f \times n = 0.2 \times 1000 = 200 \text{mm/min}$$

Substitute the answer above into the formula.

$$Tc = \frac{lm}{l} = \frac{100}{200} = 0.5 \text{min}$$

0.5 x 60=30 (sec.) The answer is 30 sec.

■THEORETICAL FINISHED SURFACE ROUGHNESS (h)

$$h = \frac{f^2}{8RE} \times 1000 (\mu m)$$

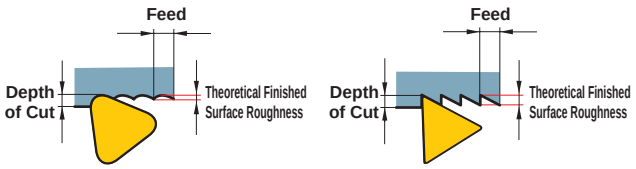
h (μm) : Finished Surface Roughness
f (mm/rev) : Feed per Revolution
RE(mm) : Insert Corner Radius

(Problem) What is the theoretical finished surface roughness when the insert corner radius is 0.8mm and feed is 0.2mm/rev ?

(Answer) Substitute f=0.2mm/rev, RE=0.8 into the formula.

$$h = \frac{0.2^2}{8 \times 0.8} \times 1000 = 6.25 \mu m$$

The theoretical finished surface roughness is 6μm.



TROUBLE SHOOTING FOR THREADING

Problems	Observation	Causes	Solutions
Low thread precision.	Threads do not mesh with each other.	Incorrect tool installation.	Set the insert center height at 0mm.
			Check holder inclination (Lateral).
	Shallow thread.	Incorrect depth of cut.	Modify the depth of cut.
		Lack of insert wear or plastic deformation resistance.	Refer to "Quickly generated flank wear." and "Large plastic deformation." below.
Poor surface finish.	Surface damage.	Chips wrap around or clog the work pieces.	Change to flank infeed and control the chip discharge direction.
			Change to an M-class insert with a 3-D chip breaker.
		The side of the insert cutting edge interferes with the workpiece.	Check the lead angle and select an appropriate shim.
	Surface tears.	Built-up edge (Welding).	Increase cutting speed.
			Increase coolant pressure and volume.
		Cutting resistance too high.	Decrease depth of cut per pass.
	Surface vibrations.	Cutting speed too high.	Decrease the cutting speed.
		Insufficient work piece or tool clamping.	Re-check work piece and tool clamping. (Chuck pressure, clamping allowance)
		Incorrect tool installation.	Set the insert center height at 0mm.
Short tool life.	Flank wear quickly generated.	Cutting speed too high.	Decrease the cutting speed.
		Too many passes causes abrasive wear.	Reduce the number of passes.
		Small depth of cut for the finishing pass.	Do not re-cut at 0mm depth of cut, larger than 0.05mm depth of cut is recommended.
	Non-uniform wear of the right and left sides of the cutting edge.	The work piece lead angle and the tool lead angle do not match.	Check the work piece lead angle and select an appropriate shim.
	Chipping and fracture.	Cutting speed too low.	Increase cutting speed.
		Cutting resistance too high.	Increase the number of passes and decrease the cutting resistance per pass.
		Unstable clamping.	Check work piece deflection.
			Shorten tool overhang.
			Recheck work piece and tool clamping. (Chuck pressure, clamping allowance)
		Chip packing.	Increase coolant pressure to blow away chips.
			Change the tool pass to control chips. (Lengthen each pass to allow the coolant to clear the chips.
			Change from standard internal cutting to back turning to prevent chip jamming.
		Non-chamfered work pieces causes high resistance at the start of each pass.	Chamfer the workpiece entry and exit faces.
	Large plastic deformation.	High cutting speed and large heat generation.	Decrease the cutting speed.
		Lack of coolant supply.	Check coolant is supply is sufficient.
			Increase coolant pressure and volume.
		Cutting resistance too high.	Increase the number of passes and decrease the cutting resistance per pass.

DRILL DIAMETERS FOR PREPARED HOLES

●Metric Coarse Screw Thread

Nominal	Drill Diameter	
	HSS	Carbide
M1 ×0.25	0.75	0.75
M1.1×0.25	0.85	0.85
M1.2×0.25	0.95	0.95
M1.4×0.3	1.10	1.10
M1.6×0.35	1.25	1.30
M1.7×0.35	1.35	1.40
M1.8×0.35	1.45	1.50
M2 ×0.4	1.60	1.65
M2.2×0.45	1.75	1.80
M2.3×0.4	1.90	1.95
M2.5×0.45	2.10	2.15
M2.6×0.45	2.15	2.20
M3 ×0.5	2.50	2.55
M3.5×0.6	2.90	2.95
M4 ×0.7	3.3	3.4
M4.5×0.75	3.8	3.9
M5 ×0.8	4.2	4.3
M6 ×1.0	5.0	5.1
M7 ×1.0	6.0	6.1
M8 ×1.25	6.8	6.9
M9 ×1.25	7.8	7.9
M10 ×1.5	8.5	8.6
M11 ×1.5	9.5	9.7
M12 ×1.75	10.3	10.5
M14 ×2.0	12.0	12.2
M16 ×2.0	14.0	14.2
M18 ×2.5	15.5	15.7
M20 ×2.5	17.5	17.7
M22 ×2.5	19.5	19.7
M24 ×3.0	21.0	—
M27 ×3.0	24.0	—
M30 ×3.5	26.5	—
M33 ×3.5	29.5	—
M36 ×4.0	32.0	—
M39 ×4.0	35.0	—
M42 ×4.5	37.5	—
M45 ×4.5	40.5	—
M48 ×5.0	43.0	—

●Metric Fine Screw Thread

Nominal	Drill Diameter	
	HSS	Carbide
M1 ×0.2	0.80	0.80
M1.1×0.2	0.90	0.90
M1.2×0.2	1.00	1.00
M1.4×0.2	1.20	1.20
M1.6×0.2	1.40	1.40
M1.8×0.2	1.60	1.60
M2 ×0.25	1.75	1.75
M2.2×0.25	1.95	2.00
M2.5×0.35	2.20	2.20
M3 ×0.35	2.70	2.70
M3.5×0.35	3.20	3.20
M4 ×0.5	3.50	3.55
M4.5×0.5	4.00	4.05
M5 ×0.5	4.50	4.55
M5.5×0.5	5.00	5.05
M6 ×0.75	5.30	5.35
M7 ×0.75	6.30	6.35
M8 ×1.0	7.00	7.10
M8 ×0.75	7.30	7.35
M9 ×1.0	8.00	8.10
M9 ×0.75	8.30	8.35
M10 ×1.25	8.80	8.90
M10 ×1.0	9.00	9.10
M10 ×0.75	9.30	9.35
M11 ×1.0	10.0	10.1
M11 ×0.75	10.3	10.3
M12 ×1.5	10.5	10.7
M12 ×1.25	10.8	10.9
M12 ×1.0	11.0	11.1
M14 ×1.5	12.5	12.7
M14 ×1.0	13.0	13.1
M15 ×1.5	13.5	13.7
M15 ×1.0	14.0	14.1
M16 ×1.5	14.5	14.7
M16 ×1.0	15.0	15.1
M17 ×1.5	15.5	15.7
M17 ×1.0	16.0	16.1
M18 ×2.0	16.0	16.3
M18 ×1.5	16.5	16.7
M18 ×1.0	17.0	17.1

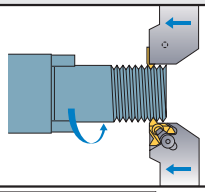
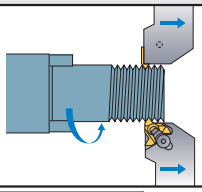
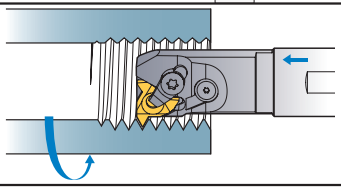
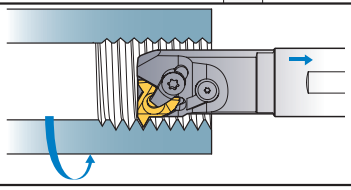
Nominal	Drill Diameter	
	HSS	Carbide
M20 ×2.0	18.0	18.3
M20 ×1.5	18.5	18.7
M20 ×1.0	19.0	19.1
M22 ×2.0	20.0	—
M22 ×1.5	20.5	—
M22 ×1.0	21.0	—
M24 ×2.0	22.0	—
M24 ×1.5	22.5	—
M24 ×1.0	23.0	—
M25 ×2.0	23.0	—
M25 ×1.5	23.5	—
M25 ×1.0	24.0	—
M26 ×1.5	24.5	—
M27 ×2.0	25.0	—
M27 ×1.5	25.5	—
M27 ×1.0	26.0	—
M28 ×2.0	26.0	—
M28 ×1.5	26.5	—
M28 ×1.0	27.0	—
M30 ×3.0	27.0	—
M30 ×2.0	28.0	—
M30 ×1.5	28.5	—
M30 ×1.0	29.0	—
M32 ×2.0	30.0	—
M32 ×1.5	30.5	—
M33 ×3.0	30.0	—
M33 ×2.0	31.0	—
M33 ×1.5	31.5	—
M35 ×1.5	33.5	—
M36 ×3.0	33.0	—
M36 ×2.0	34.0	—
M36 ×1.5	34.5	—
M38 ×1.5	36.5	—
M39 ×3.0	36.0	—
M39 ×2.0	37.0	—
M39 ×1.5	37.5	—
M40 ×3.0	37.0	—
M40 ×2.0	38.0	—
M40 ×1.5	38.5	—
M42 ×4.0	38.0	—

Nominal	Drill Diameter	
	HSS	Carbide
M42 ×3.0	39.0	—
M42 ×2.0	40.0	—
M42 ×1.5	40.5	—
M45 ×4.0	41.0	—
M45 ×3.0	42.0	—
M45 ×2.0	43.0	—
M45 ×1.5	43.5	—
M48 ×4.0	44.0	—
M48 ×3.0	45.0	—
M48 ×2.0	46.0	—
M48 ×1.5	46.5	—
M50 ×3.0	47.0	—
M50 ×2.0	48.0	—
M50 ×1.5	48.5	—

Note 1) When using the drill diameters shown in this table, that the processed hole should be measured since the size accuracy of a drill hole may change due to the drilling condition, and that if found to be inappropriate for a prepared hole, the drill diameter must be corrected accordingly.

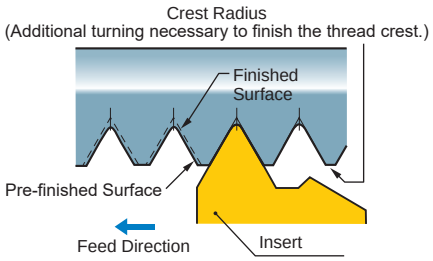
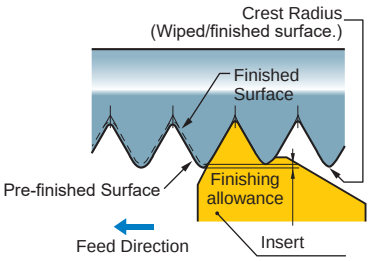
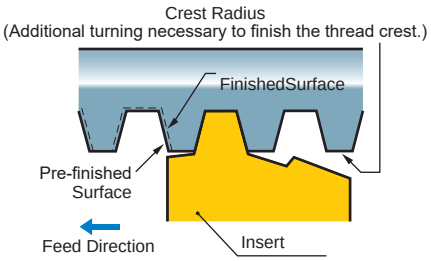
THREADING METHODS

THREADING METHODS

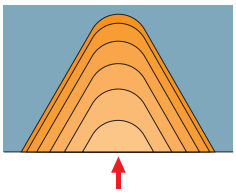
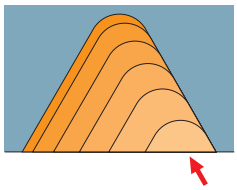
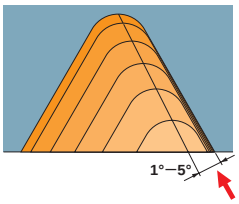
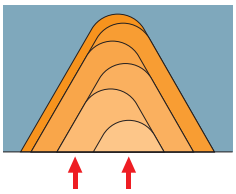
	Right Hand Thread	Left Hand Thread
EXTERNAL	 Holder Reversed	 Holder Reversed
INTERNAL		

- Usually, threads are cut with the feed towards the chuck.
- When machining left hand threads, note that clamping rigidity is lowered due the application of back turning.
- When machining left hand threads, the lead angle is negative. Ensure an appropriate lead angle by changing the shim.

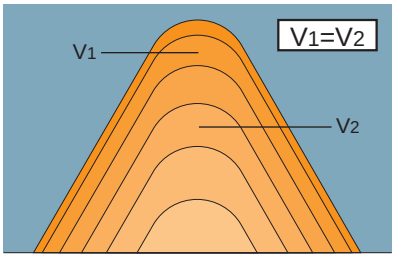
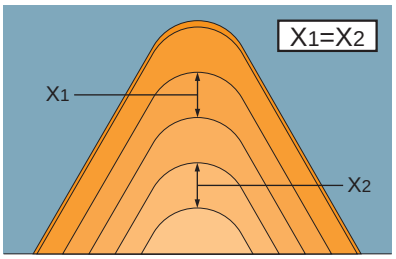
INSERT TYPES

Partial form	Full form	Semi-full form (Trapezoidal threads only)
● The same insert can be used for a range of pitches. ● Shorter tool life because the corner radius of the insert is smaller than that of the full form insert. ● Finishing with another operation is necessary.	● No deburring needed after threading. ● Requires different threading inserts.	● No deburring needed after threading. ● Requires different threading inserts. ● Finishing with another operation is necessary.
		

INFEED METHODS

		Radial Infeed	Flank Infeed	Modified Flank Infeed	Incremental Infeed
					
Features	Advantages	● Easiest to use. (Standard programme for threading) ● Wide application. (Cutting conditions easy to change.) ● Uniform wear of the right and left sides of the cutting edge.	● Relatively easy to use. (Semi-standard program for threading.) ● Reduced cutting force. ● Suitable for large pitch threads or materials that peel easily. ● Good chip discharge.	● Preventing flank wear on the right side of the cutting edge. ● Reduced cutting force. ● Suitable for large pitch threads or materials that peel easily. ● Good chip discharge.	● Uniform flank wear of the right and left sides of the cutting edge. ● Reduced cutting force. ● Suitable for large pitch threads or materials that peel easily.
	Disadvantages	● Difficult chip control. ● Subject to vibration in the later in stages of cutting. ● Ineffective for large pitch threading. ● Heavy load on the corner radius.	● Large flank wear on the right side of the cutting edge. ● Relatively difficult to change cutting depth. (Re-programming necessary)	● Complex machining programming. ● Difficult to change cutting depth. (Re-programming necessary)	● Complex machining programming. ● Difficult to change cutting depth. (Re-programming necessary) ● Difficult chip control.

THREADING DEPTH

	Features	
	Advantages	Disadvantages
 Fixed cut area	● Easy to use. (Standard programme for threading.) ● Superior resistance to vibration. (Constant cutting force.)	● Long chips generated during the final pass. ● Complex calculation of cutting depth when changing the number of passes.
 Fixed cutting depth	● Reduced load on corner radius during the first half of the passes. ● Easy chip control. (Optional setting of chip thickness) ● Easy to calculate cutting depth when changing the number of passes. ● Good chip control.	● Subject to vibration in the later stages of cutting. (Increased cutting force) ● In some cases, changing the NC programme is necessary.

* It is recommended to set the depth of cut of the final pass to 0.05mm−0.025mm.
Large cutting depths can cause vibration, leading to a poor surface finish.

■ FORMULAE

● Formulae to calculate infeed for each pass in a reduced series.

$$\triangle ap_n = \frac{ap}{\sqrt{n_{ap}-1}} \times \sqrt{b}$$

$\triangle ap_n$: Depth of cut
n : Actual pass
ap : Total depth of cut
n_{ap} : Number of passes
b : 1st pass 0.3
2nd pass 2−1 = 1
3rd pass 3−1 = 2
•
•
nth pass n−1

(Example)
External threading (ISO Metric)
Pitch : 1.0mm
ap : 0.6mm
n_{ap} : 5 passes

1st Pass $\triangle ap_1 = \frac{0.60}{\sqrt{5-1}} \times \sqrt{0.3} = 0.16 \rightarrow$ **0.16** ($\triangle ap_1$)

2st Pass $\triangle ap_2 = \frac{0.60}{\sqrt{5-1}} \times \sqrt{2-1} = 0.3 \rightarrow$ **0.14** ($\triangle ap_2 - \triangle ap_1$)

3st Pass $\triangle ap_3 = \frac{0.60}{\sqrt{5-1}} \times \sqrt{3-1} = 0.42 \rightarrow$ **0.12** ($\triangle ap_3 - \triangle ap_2$)

4st Pass $\triangle ap_4 = \frac{0.60}{\sqrt{5-1}} \times \sqrt{4-1} = 0.52 \rightarrow$ **0.1** ($\triangle ap_4 - \triangle ap_3$)

5st Pass $\triangle ap_5 = \frac{0.60}{\sqrt{5-1}} \times \sqrt{5-1} = 0.6 \rightarrow$ **0.08** ($\triangle ap_5 - \triangle ap_4$)

■ NC PROGRAMME FOR MODIFIED FLANK INFEED

● Example) M12×1.0 5 passes modified 5°

External Threading	Internal Threading
G00 Z = 5.0 X = 14.0 G92 U−4.34 Z−13.0 F1.0 G00 W−0.07 G92 U−4.64 Z−13.0 F1.0 G00 W−0.06 G92 U−4.88 Z−13.0 F1.0 G00 W−0.05 G92 U−5.08 Z−13.0 F1.0 G00 W−0.03 G92 U−5.20 Z−13.0 F1.0 G00	G00 Z = 5.0 X = 10.0 G92 U4.34 Z−13.0 F1.0 G00 W−0.07 G92 U4.64 Z−13.0 F1.0 G00 W−0.05 G92 U4.84 Z−13.0 F1.0 G00 W−0.04 G92 U5.02 Z−13.0 F1.0 G00 W−0.03 G92 U5.14 Z−13.0 F1.0 G00

THREADING METHODS

SELECTING CUTTING CONDITIONS

		Priority					
		Tool Life	Cutting Force	Surface Finish	Precision of Thread	Chip Discharge	Efficiency (Reduced Passes)
Threading Methods	Radial	○		○	○		○
	Flank	(△ : Modified)	○	(△ : Modified)		○	
Cutting Depth	Fixed Cutting Depth					○	
	Fixed Cut Area	○	○	○	○		○

Note 1) Tool life and surface finish accuracy can be increased by changing the threading method from flank infeed to modified flank infeed.
Chip control can be improved by increasing the cutting depth in the later half of passes.

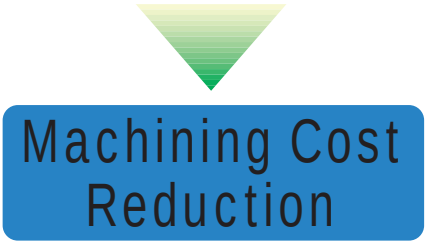
CUTTING DEPTH AND THE NUMBER OF PASSES

● Selection of the appropriate cutting depth and the right number of passes is vital for threading.

- For most threading, use a "threading cycle program," which has originally been installed on machines, and specify "total cutting depth" and "cutting depth in the first or final pass."
- Cutting depth and the number of passes are easy to change for the radial infeed method, thus making it easy to determine the appropriate cutting conditions.

FEATURES AND BENEFITS OF MITSUBISHI PRODUCTS

- Insert grades with high wear and plastic deformation resistance, specially produced for threading tools, ensure highly efficient cutting by enabling high-speed machining and a reduced number of passes.



ADVICE ON IMPROVED THREADING

● Increasing tool life

- To prevent damage to the corner radius - Recommended method - Modified flank infeed
- To have uniform flank wear on both sides of a cutting edge - Recommended method - Radial infeed
- To prevent crater wear - Recommended method - Flank infeed

● Preventing chip problems

- Change to flank or modified infeed.
- During radial infeed cutting, use an inverted holder and change the coolant supply to a downward direction.
- When using the radial infeed method, set the minimum cutting depth at around 0.2mm to make the chips thicker.

● To achieve highly efficient machining

- Increase cutting speed. (Dependant on the maximum revolution and rigidity of the machine.)
- Reduce the number of passes. (Reduce by 30-40%.)
- A reduced number of passes can improve chip discharge because of the thicker chips generated.

● Preventing vibration

- Change to flank or modified infeed.
- When using radial infeed, reduce cutting depth in the later half of passes and lower the cutting speed.

● Increased surface finish accuracy

- A final wiping pass should be performed at the same depth of cut as the last regular pass.
- When using the flank infeed method, change to radial infeed only during the final pass.

TROUBLE SHOOTING FOR FACE MILLING

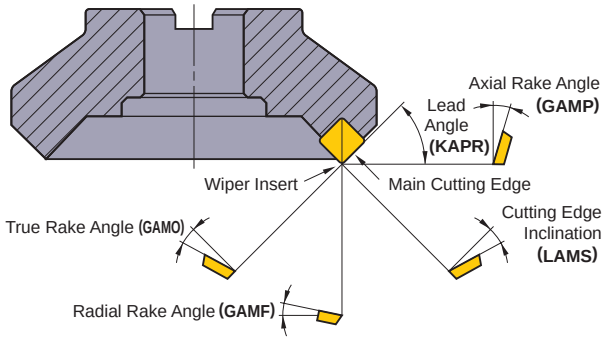
Trouble		Factors \ Solution	Insert Grade Selection				Cutting Conditions						Style and Design of the Tool									Machine, Installation of Tool		
			Select a harder grade	Select a tougher grade	Select a grade with better thermal shock resistance	Select a grade with better adhesion resistance	Cutting speed	Feed	Depth of cut	Engage angle	Coolant: Do not use water-soluble cutting fluid	Coolant: Determine dry or wet cutting	Rake	Corner angle	Honing strengthens the cutting edge	Cutter diameter	Number of teeth	Wider chip pocket	Use of a wiper insert	Improve run-out accuracy	Cutter rigidity	Increase clamping rigidity of the tool and workpiece	Decrease overhang	Decrease power and machine backlash
							Up ↗ / Down ↘			↗ Up			Up ↗ / Down ↘				Larger ↗ / Smaller ↘							
Deterioration of Tool Life	Insert wear quickly generated	Improper tool grade	●																					
		Improper cutting edge geometry											↗●	↗●	●↘					●				
		Improper cutting speed					●↘					●Wet												
	Chipping or fracturing of cutting edge	Improper tool grade		●																				
		Improper cutting conditions						●↘	●↘															
		Lack of cutting edge strength.													↗●									
		Thermal crack occurs			●		●↘	●↘	●↘		●	●Dry												
		Build-up edge occurs				●	↗●	↗●			●	●Wet												
		Lack of rigidity																			●	●	●	●
Deterioration of Surface Finish	Poor finished surface	Improper cutting conditions	●				●↘	●↘	●↘															
		Welding occurs				●	↗●				●	●Wet	↗●		●↘									
		Poor run-out accuracy																	●	●				
		Chattering					●↘	●↘	●↘	↗●			↗●		●↘		●↘				●	●	●	●
	Not parallel or irregular surface	Workpiece bending						●↘	●↘				↗●	●↘	●↘		●↘					●		
		Tool clearance																			●	●	●	●
		Large back force											↗●	●↘	●↘		●↘							
Burr, Workpiece Chipping	Burrs, chipping	Chip thickness is too large					↗●	●↘	●↘															
		Cutter diameter is too large								↗●						●↘								
		Low sharpness											↗●		●↘									
		A large corner angle												●↘										
	Workpiece edge chipping	Improper cutting conditions						●↘	●↘															
		Low sharpness											↗●		●↘									
		A small corner angle												↗●										
		Chattering					●↘	●↘	●↘	↗●			↗●		●↘		●↘				●	●	●	●
Chip Control	Poor chip dispersal, chip jamming and chip packing	Welding occurs					↗●																	
		Chip thickness is too thin					↗●	↗●																
		Cutter diameter is too small														●↘								
		Poor chip disposal									●	●Wet					●↘	●						

TECHNICAL DATA

R

FUNCTION OF TOOL FEATURES FOR FACE MILLING

■FUNCTION OF EACH CUTTING EDGE ANGLE IN FACE MILLING

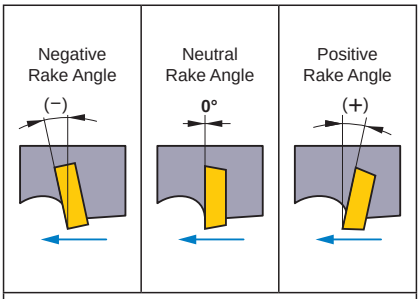


Each Cutting Edge Angle in Face Milling

Type of Angle	Symbol	Function	Effect
Axial Rake Angle	GAMP	Determines chip disposal direction.	**Positive** : Excellent machinability.
Radial Rake Angle	GAMF	Determines sharpness.	**Negative** : Excellent chip disposal.
Lead Angle	KAPR	Determines chip thickness.	**Small** : Thin chips and small cutting impact. Large back force.
True Rake Angle	GAMO	Determines actual sharpness.	**Positive (large)** : Excellent machinability. Minimal welding. **Negative (large)** : Poor machinability. Strong cutting edge.
Cutting Edge Inclination	LAMS	Determines chip disposal direction.	**Positive (large)** : Excellent chip disposal. Low cutting edge strength.

■STANDARD INSERTS

● Positive and Negative Rake Angle

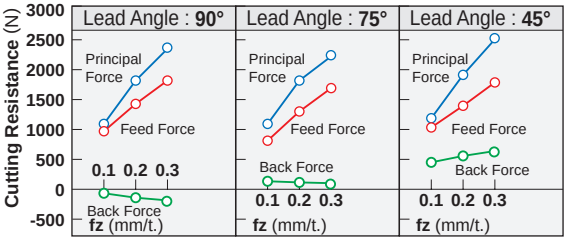


· Insert shape whose cutting edge precedes is a positive rake angle.
· Insert shape whose cutting edge follows is a negative rake angle.

● Standard Cutting Edge Shape

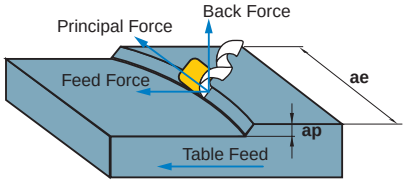
Standard Cutting Edge Combinations		(+) Axial Rake Angle / Radial Rake Angle (+) Double Positive (DP Edge Type)	(−) Axial Rake Angle / Radial Rake Angle (−) Double Negative (DN Edge Type)	(+) Axial Rake Angle / Radial Rake Angle (−) Negative/Positive (NP Edge Type)
Axial Rake Angle (GAMP)		Positive (+)	Negative (−)	Positive (+)
Radial Rake Angle (GAMF)		Positive (+)	Negative (−)	Negative (−)
Insert Used		Positive Insert (One Sided Use)	Negative Insert (Double Sided Use)	Positive Insert (One Sided Use)
Work Material	Steel	●	–	●
	Cast Iron	–	●	●
	Aluminium Alloy	●	–	–
	Difficult-to-Cut Material	●	–	●

■LEAD ANGLE (KAPR) AND CUTTING CHARACTERISTICS



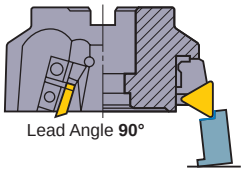
Workpiece : **JIS SCM440 (281HB)**
Tool : **ø125mm** Single Insert
Cutting Conditions : **vc=125.6m/min ap=4mm ae=110mm**

Cutting Resistance Comparison between Different Insert Shapes

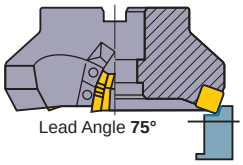


Three Cutting Resistance Forces in Milling

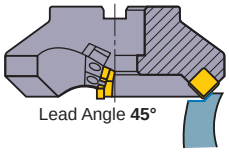
Lead Angle 0°
Back force is in the minus direction. Lifts the workpiece when workpiece clamp rigidity is low.



Lead Angle 15°
Lead angle 75° is recommended for face milling of workpieces with low rigidity such as thin workpieces.



Lead Angle 45°
The largest back force.
Bends thin workpieces and lowers cutting accuracy.
★Prevents workpiece edge chipping when cast iron cutting.

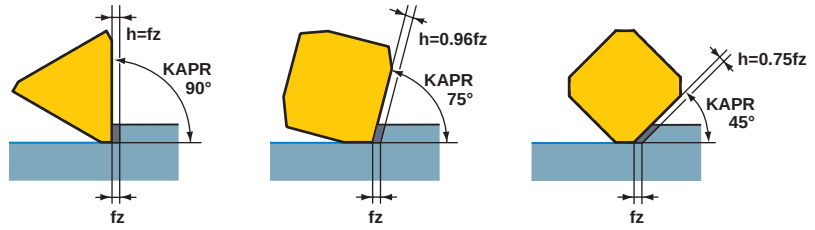


★ Principal force : Force is in the opposite direction of face milling rotation.
★ Back force : Force that pushes in the axial direction.
★ Feed force : Force is in the feed direction and is caused by table feed.

■APPROACH ANGLE AND THE TOOL LIFE

● Approach Angle and Chip Thickness

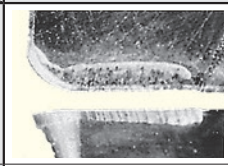
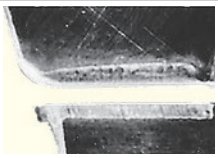
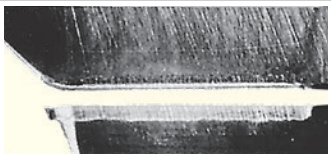
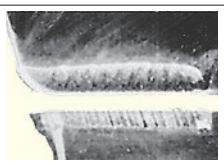
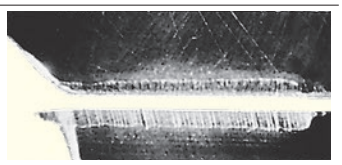
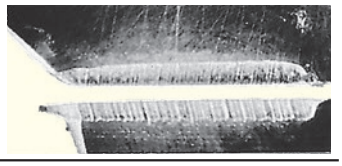
When the depth of cut and feed per tooth, fz, are fixed, the smaller the lead angle (KAPR) is, then the thinner the chip thickness (h) becomes (for a 45° KAPR, it is approx. 75% that of a 90° KAPR). This can be seen in below. Therefore as the KAPR increases, the cutting resistance decreases resulting in longer tool life. Note however, if the chip thickness is too large then the cutting resistance can increase leading to vibrations and shortened tool life.



Effects on chip thickness due to the variation of lead angles

● Approach Angle and Face Wear

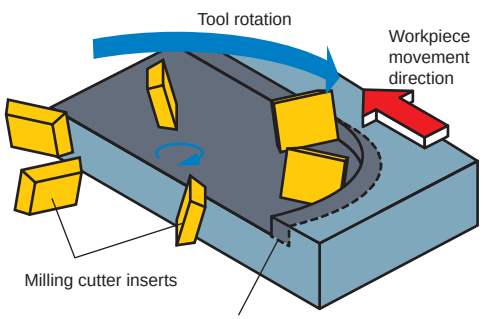
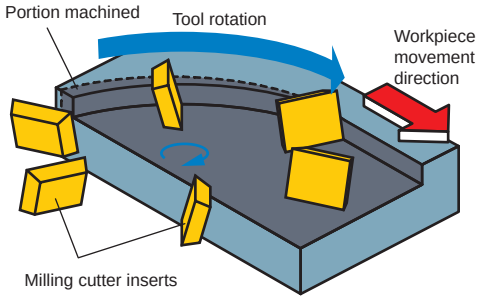
Below shows wear patterns for different lead angles. When comparing crater wear for 90° and 45° lead angles, it can be clearly seen that the ctater wear for 90° lead angle is larger.

	Lead Angle **90°**	Lead Angle **75°**	Lead Angle **45°**
vc=100m/min Tc=69min			
vc=125m/min Tc=55min			
vc=160m/min Tc=31min			

Workpiece : **SNCM439 287HB**
Tools : **DC=125mm**
Insert : **M20**Cemented Carbide
Cutting Conditions : **ap=3.0mm**
ae=110mm
fz=0.2mm/t.
Dry Cutting

■UP AND DOWN CUT (CLIMB) MILLING

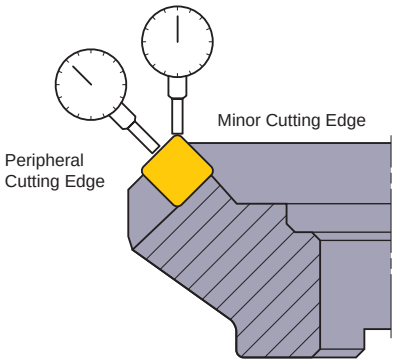
When choosing a method to machine, up cutting or down cut milling (climb milling) is decided by the conditions of the machine tool, the milling cutter and the application. However, it is said that in terms of tool life, down cut (climb) milling is more advantageous.

Up Cut	Down Cut
	

FUNCTION OF TOOL FEATURES FOR FACE MILLING

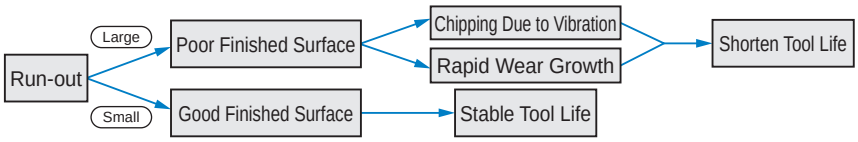
■FINISHED SURFACE

● Cutting Edge Run-out Accuracy

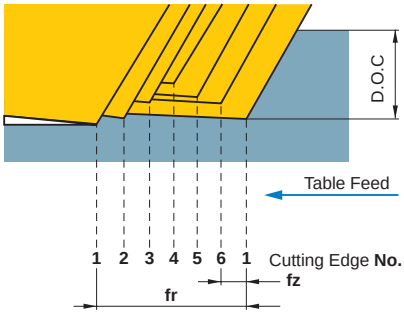


Cutting Edge Run-out and Accuracy in Face Milling

Cutting edge run-out accuracy of indexable inserts on the cutter body greatly affects the surface finish and tool life.



● Improve Finished Surface Roughness



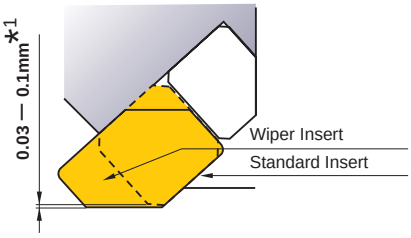
fz : Feed per Tooth
fr : Feed per Revolution

Sub Cutting Edge Run-out and Finished Surface

Since Mitsubishi Materials' normal sub cutting edge width is 1.4mm, and the sub cutting edges are set parallel to the face of a milling cutter, theoretically the finished surface accuracy should be maintained even if run-out accuracy is low.

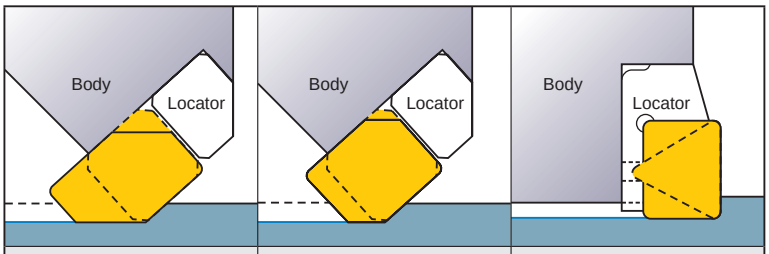
Actual Problems	Countermeasure
· Cutting edge run-out. · Sub cutting edge inclination. · Milling cutter body accuracy. · Spare parts accuracy. · Welding, vibration, chattering.	Wiper Insert

∗ Machine a surface that has already been per-machined in order to produce smooth finished surface.



· Replace one or two normal inserts with wiper inserts.
· Wiper inserts be set to protrude by 0.03−0.1mm from the standard inserts.
∗1.Value depends on the cutting edge and insert combination.

● How to Set a Wiper Insert



(a) **One Corner Type**	(b) **Two Corner Type**	(c) **Two Corner Type**
Replace normal insert.	Replace normal insert.	Use locator for wiper insert.

· Sub cutting edge length has to be longer than the feed per revolution.
∗ Too long sub cutting edge causes chattering.
· When the cutter diameter is large and feed per revolution is longer than the sub cutting edge of the wiper insert, use two or three wiper inserts.
· When using more than 1 wiper inserts, eliminate run-out of wiper inserts.
· Use a high hardness grade (high wear resistance) for wiper inserts.

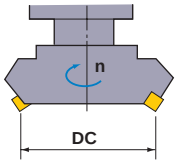
FORMULAE FOR FACE MILLING

■CUTTING SPEED (vc)

$$vc = \frac{\pi \cdot DC \cdot n}{1000} \text{ (m/min)}$$

vc (m/min) : Cutting Speed
π (3.14) : Pi
DC(mm) : Cutter Diameter
n (min^{-1}) : Main Axis Spindle Speed

*Divide by 1000 to change to m from mm.



(Problem) What is the cutting speed when main axis spindle speed is 350min^{-1} and the cutter diameter is ϕ125 ?

(Answer) Substitute π=3.14, DC=125, n=350 into the formula.

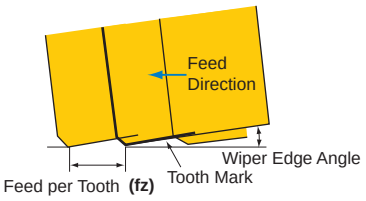
$$vc = \frac{\pi \cdot DC \cdot n}{1000} = \frac{3.14 \times 125 \times 350}{1000} = 137.4\text{m/min}$$

The cutting speed is 137.4m/min.

■FEED PER TOOTH (fz)

$$fz = \frac{vf}{z \cdot n} \text{ (mm/t.)}$$

fz (mm/t.) : Feed per Tooth
vf (mm/min) : Table Feed per Min.
n (min^{-1}) : Main Axis Spindle Speed (Feed per Revolution **fr = z** x **fz**)
z : Insert Number



(Problem) What is the feed per tooth when the main axis spindle speed is 500min^{-1}, number of insert is 10, and table feed is 500mm/min ?

(Answer) Substitute the above figures into the formula.

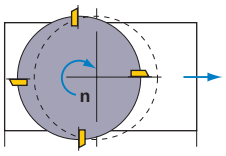
$$fz = \frac{vf}{z \times n} = \frac{500}{10 \times 500} = 0.1\text{mm/t.}$$

The answer is 0.1mm/t.

■TABLE FEED (vf)

$$vf = fz \cdot z \cdot n \text{ (mm/min)}$$

vf (mm/min) : Table Feed per Min.
fz (mm/t.) : Feed per Tooth
n (min^{-1}) : Main Axis Spindle Speed
z : Insert Number



(Problem) What is the table feed when feed per tooth is 0.1mm/t., number of insert is 10, and main axis spindle speed is 500min^{-1}?

(Answer) Substitute the above figures into the formula.

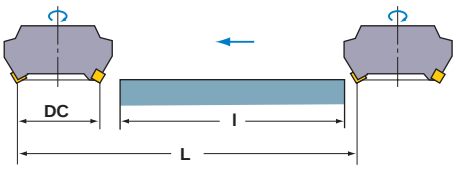
vf = fz×z×n = 0.1×10×500 = 500mm/min

The table feed is 500mm/min.

■CUTTING TIME (Tc)

$$Tc = \frac{L}{vf} \text{ (min)}$$

Tc (min) : Cutting Time
vf (mm/min) : Table Feed per Min.
L (mm) : Total Table Feed Length (Workpiece Length: (**l**)+Cutter Diameter : (**DC**))



(Problem) What is the cutting time required for finishing 100mm width and 300mm length surface of a cast iron (JIS FC200) block when the cutter diameter is ϕ200mm, the number of inserts is 16, the cutting speed is 125m/min, and feed per tooth is 0.25mm. (spindle speed is 200min^{-1})

(Answer) Calculate table feed per min vf=0.25×16×200=800mm/min
Calculate total table feed length. L=300+200=500mm
Substitute the above answers into the formula.

$$Tc = \frac{500}{800} = 0.625 \text{ (min)}$$

0.625×60=37.5 (sec). The answer is 37.5 sec.

FORMULAE FOR FACE MILLING

■CUTTING POWER (Pc)

$$Pc = \frac{ap \cdot ae \cdot vf \cdot Kc}{60 \times 10^6 \times \eta}$$

Pc (kW)	: Actual Cutting Power	**ap (mm)**	: Depth of Cut
ae (mm)	: Cutting Width	**vf (mm/min)**	: Table Feed per Min.
Kc (MPa)	: Specific Cutting Force	**η**	: (Machine Coefficient)

(Problem) What is the cutting power required for milling tool steel at a cutting speed of 80m/min. With depth of cut 2mm, cutting width 80mm, and table feed 280mm/min by ϕ250 cutter with 12 inserts. Machine coefficient 80%.

(Answer) First, calculate the spindle speed in order to obtain feed per tooth.

$$n = \frac{1000vc}{\pi DC} = \frac{1000 \times 80}{3.14 \times 250} = 101.91 min^{-1}$$

Feed per Tooth $fz = \frac{vf}{z \times n} = \frac{280}{12 \times 101.9} = 0.228 mm/t.$

Substitute the specific cutting force into the formula.

$$Pc = \frac{2 \times 80 \times 280 \times 1800}{60 \times 10^6 \times 0.8} = 1.68 \text{ kW}$$

●Kc

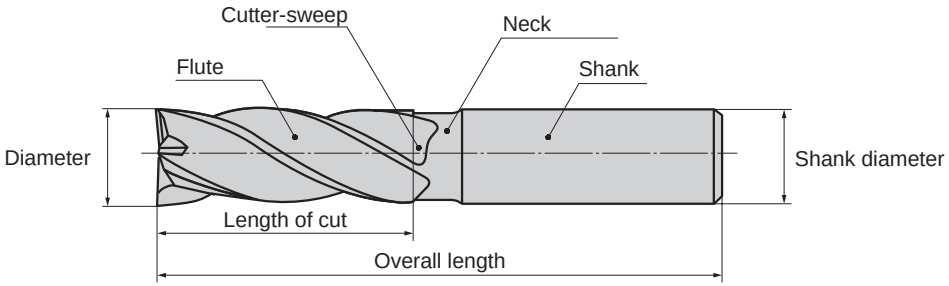
Work Material	Tensile Strength (MPa) and Hardness	Specific Cutting Force Kc (MPa)				
		0.1mm/t.	0.2mm/t.	0.3mm/t.	0.4mm/t.	0.6mm/t.
Mild Steel	**520**	2200	1950	1820	1700	1580
Medium Steel	**620**	1980	1800	1730	1600	1570
Hard Steel	**720**	2520	2200	2040	1850	1740
Tool Steel	**670**	1980	1800	1730	1700	1600
Tool Steel	**770**	2030	1800	1750	1700	1580
Chrome Manganese Steel	**770**	2300	2000	1880	1750	1660
Chrome Manganese Steel	**630**	2750	2300	2060	1800	1780
Chrome Molybdenum Steel	**730**	2540	2250	2140	2000	1800
Chrome Molybdenum Steel	**600**	2180	2000	1860	1800	1670
Nickel Chrome Molybdenum Steel	**940**	2000	1800	1680	1600	1500
Nickel Chrome Molybdenum Steel	**352HB**	2100	1900	1760	1700	1530
Austenitic Stainless Steel	**155HB**	2030	1970	1900	1770	1710
Cast Iron	**520**	2800	2500	2320	2200	2040
Hard Cast Iron	**46HRC**	3000	2700	2500	2400	2200
Meehanite Cast Iron	**360**	2180	2000	1750	1600	1470
Grey Cast Iron	**200HB**	1750	1400	1240	1050	970
Brass	**500**	1150	950	800	700	630
Light Alloy (Al-Mg)	**160**	580	480	400	350	320
Light Alloy (Al-Si)	**200**	700	600	490	450	390
Light Alloy (Al-Zn-Mg-Cu)	**570**	880	840	840	810	720

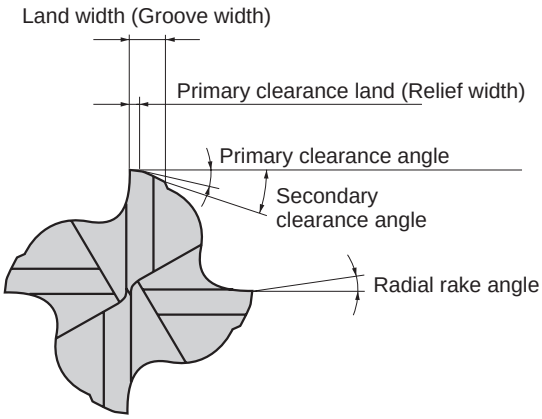
TROUBLE SHOOTING FOR END MILLING

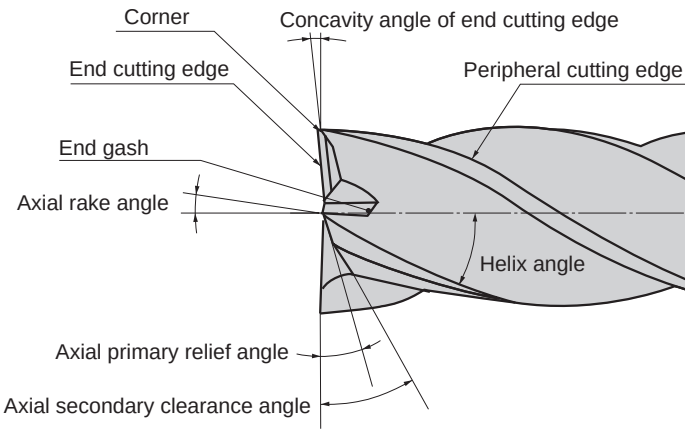
Trouble		Factors \ Solution	Insert Grade Selection	Cutting Conditions									Style and Design of the Tool						Machine, Installation of Tool					
			Coated tool	Cutting speed (Up ↗ / Down ↘)	Feed (Up ↗ / Down ↘)	Depth of cut (Up ↗ / Down ↘)	Pick feed (↘ Down)	Down cut	Use air blow	Coolant: Increase coolant quantity	Coolant: Do not use water-soluble cutting fluid	Coolant: Determine dry or wet cutting	Helix angle (Up ↗ / Down ↘)	Insert number (Larger / Smaller)	Concavity angle of end cutting edge (Larger / Smaller)	Tool diameter (Larger / Smaller)	Cutter rigidity	Wider chip pocket	Shorten tool overhang	Increase tool installation accuracy	Increase spindle collet run-out accuracy	Collet inspection and exchange	Increase chuck clamping power	Increase work clamping rigidity
Deterioration of Tool Life	Large peripheral cutting edge wear	Non-coated end mill is used	●																					
		A small number of cutting edges												↗ ●										
		Improper cutting conditions		● ↘							●													
		Up cut milling is used						Down Cut																
	Severe chipping	Improper cutting conditions																						
		Fragile cutting edge															●							
		Insufficient clamping force																				●	●	
		Low clamping rigidity																	●	●	●	●	●	●
	Breakage during cutting	Improper cutting conditions				● ↘																		
		Low end mill rigidity														↗ ●	●							
		Overhang longer than necessary				● ↘													●					
		Chip jamming								●								●						
Deterioration of Surface Finish	Vibration during cutting	Improper cutting conditions		● ↘	● ↘																			
		Low end mill rigidity											↗ ●	↗ ●		↗ ●	●							
		Low clamping rigidity																	●	●	●	●	●	●
	Poor surface finish on walls	Large cutting edge wear	●																					
		Improper cutting conditions		● ↘		● ↘																		
		Chip packing.							●	●		● Wet												
	Poor surface finish on faces	The end cutting edge does not have a concave angle			● ↘	● ↘									↗ ●									
		Large pick feed					● ↘																	
	Out of vertical	Large cutting edge wear	●																					
		Improper cutting conditions			● ↘	● ↘																		
		Lack of end mill rigidty											↗ ●	↗ ●		↗ ●	●							
	Poor dimensional accuracy	Improper cutting conditions		● ↘	● ↘	● ↘																		
		Low clamping rigidity																	●	●	●	●	●	●
Burrs, Chipping, etc.	Burr or chipping occurs	Improper cutting conditions			● ↘	● ↘																		
		Large helix angle											● ↘											
	Quick bur formation	Notch wear	●																					
		Improper cutting conditions		● ↘	↗ ●																			
Poor Chip Dispersal	Chip packing	Metal removal too large			● ↘	● ↘																		
		Lack of chip pocket												● ↘				●						

END MILL TERMINOLOGY

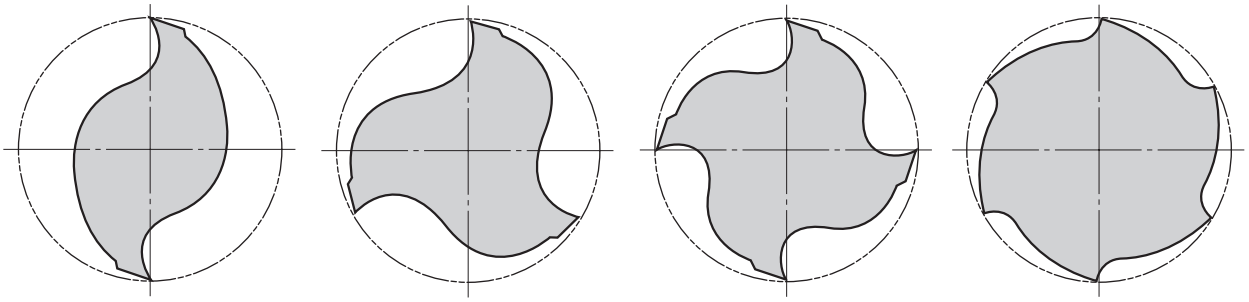
■END MILL TERMINOLOGY







■COMPARISON OF SECTIONAL SHAPE AREA OF CHIP POCKET



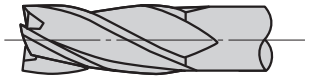
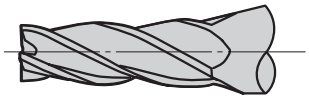
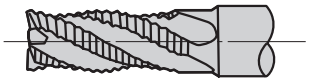
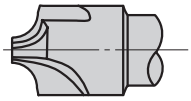
2-flutes 50% | 3-flutes 45% | 4-flutes 40% | 6-flutes 20%

■CHARACTERISTICS AND APPLICATIONS OF DIFFERENT-NUMBER-OF-FLUTE END MILLS

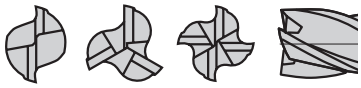
		2-flutes	3-flutes	4-flutes	6-flutes
Feature	Advantage	Chip disposability is excellent. Suitable for sinking. Low cutting resistance.	Chip disposability is excellent. Suitable for sinking.	High rigidity	High rigidity. Superior cutting edge durability.
	Fault	Low rigidity	Diameter is not easily measured.	Chip disposability is poor.	Chip disposability is poor.
Usage		Slotting, side milling, sinking etc. Wide range of use.	Slotting, side milling Heavy cutting, finishing	Shallow slotting, side milling Finishing	High Hardness Material Shallow slotting, side milling

TYPES AND SHAPES OF END MILL

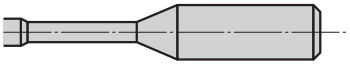
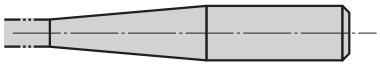
■Peripheral Cutting Edge

Kind	Shape	Feature
Ordinary Flute		Ordinary flute type is most generally used for the slotting, side milling, and the shoulder milling, etc. Can be used for roughing, semi-finishing, and the finishing.
Tapered Flute		A tapered fute is used for milling mould drafts and angled faces.
Roughing Flute		Because a roughing tooth has a wave-like form and produces small chips. Cutting resistance is low, and is suitable for roughing. Not suitable for finishing. The tooth face is re-grindable.
Formed Flute		A corner radius cutter is shown. An infinite range of form cutters can be produced.

■End Cutting Edge

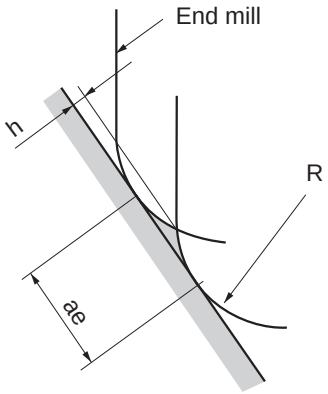
Kind	Shape	Feature
Square End (Centre With Hole)		This is generally used for slotting, side milling, and shoulder milling. Sinking is not possible. Grinding is center supported, making re-grinding accurate.
Square End (Centre Cut)		It is generally used for slotting, side milling, and shoulder milling. Vertical cutting can be performed. Re-grinding is possible.
Ball End		Suitable for profile machining and pick feed milling.
End Radius		For corner radius milling and contouring. Efficient small corner radius milling due to large diameter and small corner radius.

■Shank and Neck Parts

Kind	Shape	Feature
Standard (Straight Shank)		For general use.
Long Shank		For deep slotting and has a long shank, so that adjustment of the overhang is possible.
Long Neck		For deep slotting and small diameter end mills, also suitable for boring.
Taper Neck		For best performance in deep slotting and on mould drafts.

PITCH SELECTION OF PICK FEED

■PICK FEED MILLING (CONTOURING) WITH BALL NOSE END MILLS AND END MILLS WITH CORNER RADIUS



$$h = R \cdot \left[1 - \cos \left\{ \sin^{-1}\left(\frac{ae}{2R} \right) \right\} \right]$$

R : Radius of Ball Nose(RE), Corner Radius(RE)

ae : Pick Feed

h : Cusp Height

■CORNER R OF END MILLS AND CUSP HEIGHT BY PICK FEED

Unit : mm

R \ ae	Pick Feed									
	0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0
0.5	0.003	0.010	0.023	0.042	0.067	0.100	–	–	–	–
1	0.001	0.005	0.011	0.020	0.032	0.046	0.063	0.083	0.107	–
1.5	0.001	0.003	0.008	0.013	0.021	0.030	0.041	0.054	0.069	0.086
2	0.001	0.003	0.006	0.010	0.016	0.023	0.031	0.040	0.051	0.064
2.5	0.001	0.002	0.005	0.008	0.013	0.018	0.025	0.032	0.041	0.051
3		0.002	0.004	0.007	0.010	0.015	0.020	0.027	0.034	0.042
4		0.001	0.003	0.005	0.008	0.011	0.015	0.020	0.025	0.031
5		0.001	0.002	0.004	0.006	0.009	0.012	0.016	0.020	0.025
6		0.001	0.002	0.003	0.005	0.008	0.010	0.013	0.017	0.021
8			0.001	0.003	0.004	0.006	0.008	0.010	0.013	0.016
10			0.001	0.002	0.003	0.005	0.006	0.008	0.010	0.013
12.5			0.001	0.002	0.003	0.004	0.005	0.006	0.008	0.010

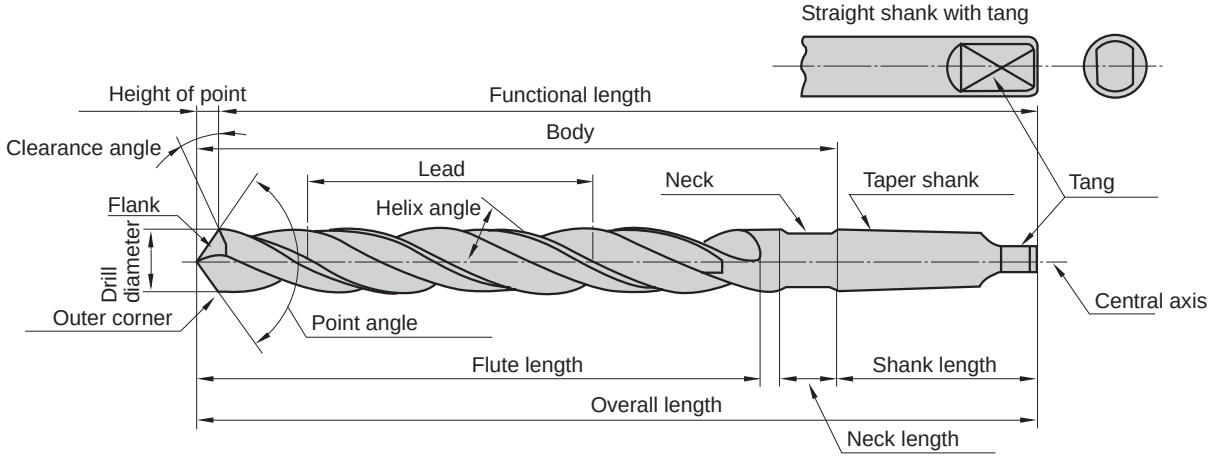
R \ ae	Pick Feed									
	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2.0
0.5	–	–	–	–	–	–	–	–	–	–
1	–	–	–	–	–	–	–	–	–	–
1.5	0.104	–	–	–	–	–	–	–	–	–
2	0.077	0.092	0.109	–	–	–	–	–	–	–
2.5	0.061	0.073	0.086	0.100	–	–	–	–	–	–
3	0.051	0.061	0.071	0.083	0.095	0.109	–	–	–	–
4	0.038	0.045	0.053	0.062	0.071	0.081	0.091	0.103	–	–
5	0.030	0.036	0.042	0.049	0.057	0.064	0.073	0.082	0.091	0.101
6	0.025	0.030	0.035	0.041	0.047	0.054	0.061	0.068	0.076	0.084
8	0.019	0.023	0.026	0.031	0.035	0.040	0.045	0.051	0.057	0.063
10	0.015	0.018	0.021	0.025	0.028	0.032	0.036	0.041	0.045	0.050
12.5	0.012	0.014	0.017	0.020	0.023	0.026	0.029	0.032	0.036	0.040

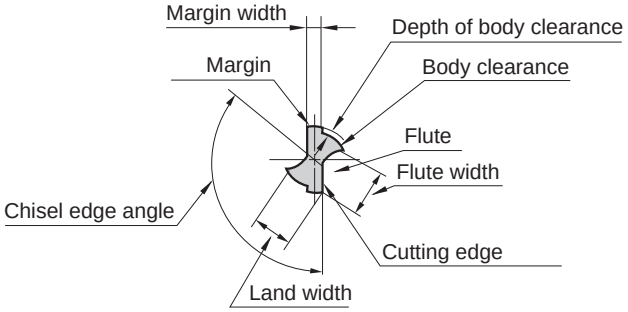
TROUBLE SHOOTING FOR DRILLING

Trouble		Factors \ Solution	Cutting Conditions: Cutting speed (Up ↗ / Down ↘)	Cutting Conditions: Feed (Up ↗ / Down ↘)	Cutting Conditions: Lower feed at initial cutting	Cutting Conditions: Lower feed when breaking through	Cutting Conditions: Step feed	Cutting Conditions: Increase accuracy of prep-hole and depth	Cutting Conditions: Coolant: Increase oil ratio	Cutting Conditions: Coolant: Increase volume	Cutting Conditions: Coolant: Increase coolant pressure	Style and Design of the Tool: Chisel width (Up ↗ / Down ↘)	Style and Design of the Tool: Honing width (Up ↗ / Down ↘)	Style and Design of the Tool: Core thickness (Up ↗ / Down ↘)	Style and Design of the Tool: Shorten flute length	Style and Design of the Tool: Decrease lip height	Style and Design of the Tool: Use internal coolant type drill	Style and Design of the Tool: Change to a drill with X type thinning	Machine, Installation of Tool: Increase tool installation accuracy	Machine, Installation of Tool: Shorten tool overhang	Machine, Installation of Tool: Flat workpiece face	Machine, Installation of Tool: Increase work clamping rigidity	Machine, Installation of Tool: Reduce machine backlash and increase rigidity
Deterioration of Tool Life	Drill breakage	Lack of drill rigidity												● ↗	●								
		Improper cutting conditions		● ↘																			
		Large deflection of the tool holder																●					●
		Workpiece face is inclined																		●			
	Large wear at the peripheral cutting edge and along the land	Improper cutting conditions	● ↘																				
		An increase in temperature at the cutting point							●	●							●						
		Poor run-out accuracy																●					
	Chipping of the peripheral cutting edge	Improper cutting conditions		● ↘			●																
		Large deflection of the tool holder																●					●
		chattering, vibration											● ↘							●		●	●
	Chisel edge chipping	The chisel edge width is too wide										● ↘											
		Poor entry			●																		
		Chattering, vibration											● ↘							●		●	●
Deterioration of Hole Accuracy	Hole diameter increases	Lack of drill rigidity												● ↗	●								
		Improper drill geometry														●							
	Hole diameter becomes smaller	An increase in temperature at the cutting point							●	●							●						
		Improper cutting conditions	● ↘																				
		Improper drill geometry														●							
	Poor straightness	Lack of drill rigidity												● ↗	●								
		Large deflection of the tool holder																●					●
		Poor guiding properties						●															
	Poor hole positioning accuracy, roundness and surface finish	Lack of drill rigidity												● ↗	●								
		Poor entry																●					
		Improper cutting conditions			●																		
		Large deflection of the tool holder																●					●
Burrs	Burrs at the hole exit	Improper drill geometry											● ↘										
		Improper cutting conditions				●																	
Poor Chip Dispersal	Long chips	Improper cutting conditions		● ↗				●															
		Poor chip disposal								●	●			● ↘			●						
	Chip jamming	Improper cutting conditions	● ↘	● ↘				●															
		Poor chip disposal								●	●			● ↘			●						

DRILL TERMINOLOGY AND CUTTING CHARACTERISTICS

■NAMES OF EACH PART OF A DRILL





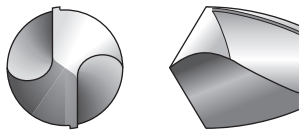
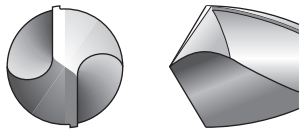
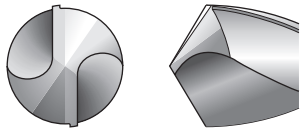
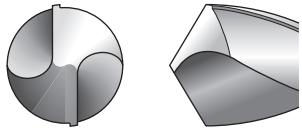
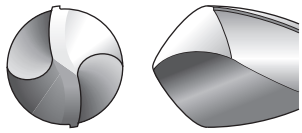
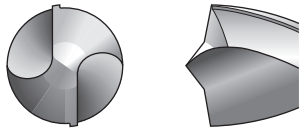
■SHAPE SPECIFICATION AND CUTTING CHARACTERISTICS

Helix Angle	Is the inclination of the flute with respect to the axial direction of a drill, which corresponds to the rake angle of a bit. The rake angle of a drill differs according to the position of the cutting edge, and it decreases greatly as the circumference approaches the centre.The chisel edge has a negative rake angle, crushing the work. **High-hardness material** Small ◀•• Rake angle ••▶ Large **Soft material** (Aluminium, etc.)
Flute Length	It is determined by depth of hole, bush length, and regrinding allowance. Since the influence on the tool life is great, it is necessary to minimize it as much as possible.
Point Angle	In general, the angle is 118° which is set differently to various applications. **Soft material with good machinability** Small ◀•• Point angle ••▶ Large **For hard material and high-efficiency machining**
Web Thickness	It is an important element that determines the rigidity and chip raking performance of a drill. The web thickness is set according to applications. Small cutting resistance Low rigidity Good chip raking performance Machinable material } Thin ◀•• Web thickness ••▶ Thick { Large cutting resistance High rigidity Poor chip raking performance High-hardness material, cross hole drilling, etc.
Margin	The tip determines the drill diameter and functions as a drill guide during drilling. The margin width is determined in consideration of friction during hole drilled. **Poor guiding performance** Small ◀•• Margin width ••▶ Large **Good guiding performance**
Diameter Back Taper	To reduce friction with the inside of the drilled hole, the portion from the tip to the shank is tapered slightly. The degree is usually represented by the quantity of reduction in the diameter with respect to the flute length, which is approx. 0.04−0.1mm. It is set at a larger value for high-efficiency drills and the work material that allows drilled holes.

■CUTTING EDGE GEOMETRY AND ITS INFLUENCE

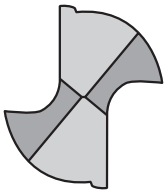
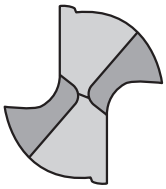
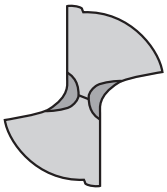
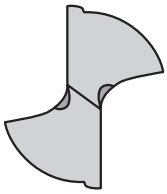
As shown in the table below, it is possible to select the most suitable cutting edge geometry for different applications. If the most suitable cutting edge geometry is selected then higher machining efficiency and higher hole accuracy can be obtained.

●Cutting Edge Shapes

Grinding Name	Shape	Features and Effect	Application
Conical		• The flank is conical and the clearance angle increases toward the centre of the drill.	• General Use
Flat		• The flank is flat. • Easy grinding.	• Mainly for small diameter drills.
Three Flank Angles		• As there is no chisel edge, the results are high centripetal force and small hole oversize. • Requires a special grinding machine. • Surface grinding of three sides.	• For drilling operations that require high hole accuracy and positioning accuracy.
Spiral Point		• To increase the clearance angle near the centre of the drill, conical grinding combined with irregular helix. • S type chisel edge with high centripetal force and machining accuracy.	• For drilling that requires high accuracy.
Radial Lip		• The cutting edge is ground radial with the aim of dispersing load. • High machining accuracy and finished surface roughness. • For through holes, small burrs on the base. • Requires a special grinding machine.	• Cast Iron, Aluminium Alloy • For cast iron plates. • Steel
Centre Point Drill		• This geometry has two-stage point angle for better concentricity and a reduction in shock when exiting the workpiece.	• For thin sheet drilling.

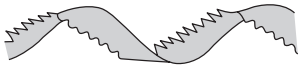
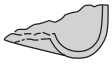
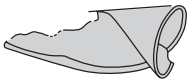
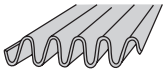
■WEB THINNING

The rake angle of the cutting edge of a drill reduces toward the centre, and it changes into a negative angle at the chisel edge. During drilling, the centre of a drill crushes the work, generating 50–70% of the cutting resistance. Web thinning is very effective for reduction in the cutting resistance of a drill, early removal of cut chips at the chisel edge, and better initial bite.

Shape	 **X type**	 **XR type**	 **S type**	 **N type**
Features	The thrust load substantially reduces, and the bite performance improves. This is effective when the web is thick.	The initial performance is slightly inferior to that of the X type, but the cutting edge is hard and the applicable range of work is wide.	Popular design, easy cutting type.	Effective when the web is comparatively thick.
Major Applications	General drilling and deep hole drilling.	Long life. General drilling and stainless steel drilling.	General drilling for steel, cast iron, and non-ferrous metal.	Deep hole drilling.

DRILL TERMINOLOGY AND CUTTING CHARACTERISTICS

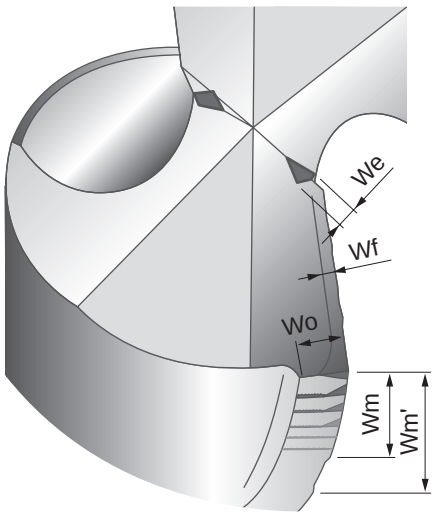
DRILLING CHIPS

Types of Chips	Shape	Features and Ease of Raking
Conical Spiral		Fan-shaped chips cut by the cutting edge are curved by the flute. Chips of this type are produced when the feeding rate of ductile material is small. If the chip breaks after several turns, the chip raking performance is satisfactory.
Long Pitch		The generated chip comes out without coiling. It will easily coil around the drill.
Fan		This is a chip broken by the restraint caused by the drill flute and the wall of a drilled hole. It is generated when the feed rate is high.
Segment		A conical spiral chip that is broken before the chip grows into the long-pitch shape by the restraint caused by the wall of the drilled hole due to the insufficiency of ductility. Excellent chip disposal and chip discharge.
Zigzag		A chip that is buckled and folded because of the shape of flute and the characteristics of the material. It easily causes chip packing at the flute.
Needle		Chips broken by vibration or broken when brittle material is curled with a small radius. The raking performance is satisfactory, but these chips can pack closely creating.

DRILL WEAR AND CUTTING EDGE DAMAGE

■DRILL WEAR CONDITION

The table below shows a simple drawing depicting the wear of a drill's cutting edge. The generation and the amount of wear differ according to the workpiece materials and cutting conditions used. But generally, the peripheral wear is largest and determines a drill tool life. When regrinding, the flank wear at the point needs to be ground away completely. Therefore, if there is large wear more material needs to be ground away to renew the cutting edge.



We : **Chisel edge wear width**

Wf : **Flank Wear (The middle of the cutting edge)**

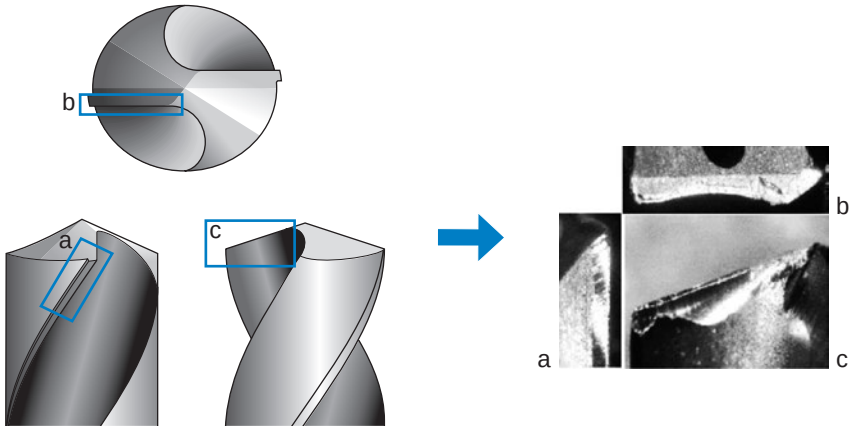
Wo : **Outer corner wear width**

Wm : **Margin wear width**

Wm' : **Margin wear width (Leading edge)**

■CUTTING EDGE DAMAGE

When drilling, the cutting edge of the drill can suffer from chipping, fracture and abnormal damage. In such cases, it is important to take a closer look at the damage, investigate the cause and take countermeasures.



Cutting edge damage

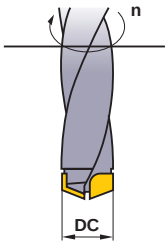
FORMULAE FOR DRILLING

■CUTTING SPEED (vc)

$$vc = \frac{\pi \cdot DC \cdot n}{1000} \text{ (m/min)}$$

vc (m/min) : Cutting Speed
π (3.14) : Pi
DC (mm) : Drill Diameter
n (min^{-1}) : Main Axis Spindle Speed

*Divide by 1,000 to change to m from mm.



(Problem) What is the cutting speed when main axis spindle speed is 1350min^{-1} and drill diameter is 12mm ?

(Answer) Substitute π=3.14, DC=12, n=1350 into the formula

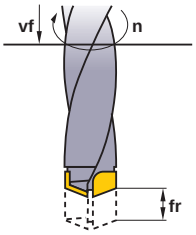
$$vc = \frac{\pi \cdot DC \cdot n}{1000} = \frac{3.14 \times 12 \times 1350}{1000} = 50.9\text{m/min}$$

The cutting speed is 50.9m/min.

■FEED OF THE MAIN SPINDLE (vf)

$$vf = fr \cdot n \text{ (mm/min)}$$

vf (mm/min) : Feed Speed of the Main Spindle (Z axis)
fr (mm/rev) : Feed per Revolution
n (min^{-1}) : Main Axis Spindle Speed



(Problem) What is the spindle feed (vf) when the feed per revolution is 0.2mm/rev and main axis spindle speed is 1350min^{-1} ?

(Answer) Substitute fr=0.2, n=1350 into the formula

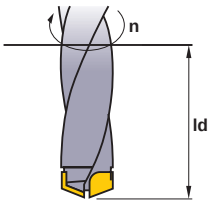
$$vf = fr \times n = 0.2 \times 1350 = 270\text{mm/min}$$

The spindle feed is 270mm/min.

■DRILLING TIME (Tc)

$$Tc = \frac{ld \cdot i}{n \cdot fr}$$

Tc (min) : Drilling Time
n (min^{-1}) : Spindle Speed
ld (mm) : Hole Depth
fr (mm/rev) : Feed per Revolution
i : Number of Holes



(Problem) What is the drilling time required for drilling a 30mm length hole in alloy steel (JIS SCM440) at a cutting speed of 50m/min and a feed 0.15mm/rev ?

(Answer) Spindle Speed $n = \frac{50 \times 1000}{15 \times 3.14} = 1061.57\text{min}^{-1}$

$$Tc = \frac{30 \times 1}{1061.57 \times 0.15} = 0.188$$

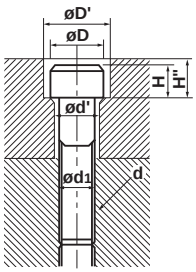
$$= 0.188 \times 60 \fallingdotseq 11.3 \text{ sec}$$

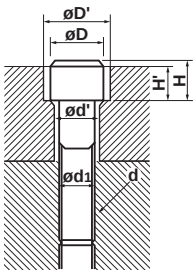
HEXAGON SOCKET HEAD BOLT HOLE SIZE

■DIMENSIONS OF COUNTERBORING FOR HEXAGON SOCKET HEAD CAP SCREW AND BOLT HOLE

Unit : mm

Nominal dimensions of thread d	M3	M4	M5	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30
d1	3	4	5	6	8	10	12	14	16	18	20	22	24	27	30
d'	3.4	4.5	5.5	6.6	9	11	14	16	18	20	22	24	26	30	33
D	5.5	7	8.5	10	13	16	18	21	24	27	30	33	36	40	45
D'	6.5	8	9.5	11	14	17.5	20	23	26	29	32	35	39	43	48
H	3	4	5	6	8	10	12	14	16	18	20	22	24	27	30
H'	2.7	3.6	4.6	5.5	7.4	9.2	11	12.8	14.5	16.5	18.5	20.5	22.5	25	28
H"	3.3	4.4	5.4	6.5	8.6	10.8	13	15.2	17.5	19.5	21.5	23.5	25.5	29	32





INTERNATIONAL SYSTEM OF UNITS

■UNIT CONVERSION TABLE for EASIER CHANGE into SI UNITS (Bold type Indicates SI unit)

●Pressure

Pa	**kPa**	**MPa**	bar	kgf/cm^2	atm	mmH$_2$O	mmHg or Torr
1	1×10^{-3}	1×10^{-6}	1×10^{-5}	1.01972×10^{-5}	9.86923×10^{-6}	1.01972×10^{-1}	7.50062×10^{-3}
1×10^{3}	1	1×10^{-3}	1×10^{-2}	1.01972×10^{-2}	9.86923×10^{-3}	1.01972×10^{2}	7.50062
1×10^{6}	1×10^{3}	1	1×10	1.01972×10	9.86923	1.01972×10^{5}	7.50062×10^{3}
1×10^{5}	1×10^{2}	1×10^{-1}	1	1.01972	9.86923×10^{-1}	1.01972×10^{4}	7.50062×10^{2}
9.80665×10^{4}	9.80665×10	9.80665×10^{-2}	9.80665×10^{-1}	1	9.67841×10^{-1}	1×10^{4}	7.35559×10^{2}
1.01325×10^{5}	1.01325×10^{2}	1.01325×10^{-1}	1.01325	1.03323	1	1.03323×10^{4}	7.60000×10^{2}
9.80665	9.80665×10^{-3}	9.80665×10^{-6}	9.80665×10^{-5}	1×10^{-4}	9.67841×10^{-5}	1	7.35559×10^{-2}
1.33322×10^{2}	1.33322×10^{-1}	1.33322×10^{-4}	1.33322×10^{-3}	1.35951×10^{-3}	1.31579×10^{-3}	1.35951×10	1

Note 1) 1Pa=1N/m^2

●Force

N	dyn	kgf
1	1×10^{5}	1.01972×10^{-1}
1×10^{-5}	1	1.01972×10^{-6}
9.80665	9.80665×10^{5}	1

●Stress

Pa	**MPa** or **N/mm^2**	kgf/mm^2	kgf/cm^2
1	1×10^{-6}	1.01972×10^{-7}	1.01972×10^{-5}
1×10^{6}	1	1.01972×10^{-1}	1.01972×10
9.80665×10^{6}	9.80665	1	1×10^{2}
9.80665×10^{4}	9.80665×10^{-2}	1×10^{-2}	1

Note 1) 1Pa=1N/m^2

●Work / Energy / Quantity of Heat

J	kW•h	kgf•m	kcal
1	2.77778×10^{-7}	1.01972×10^{-1}	2.38889×10^{-4}
$3.600\ \times10^{6}$	1	3.67098×10^{5}	$8.6000\ \times10^{2}$
9.80665	2.72407×10^{-6}	1	2.34270×10^{-3}
4.18605×10^{3}	1.16279×10^{-3}	4.26858×10^{2}	1

Note 1) 1J=1W•s, 1J=1N•m
1cal=4.18605J
(By the law of weights and measures)

●Power (Rate of Production / Motive Power) /Heat Flow Rate

W	kgf•m/s	PS	kcal/h
1	1.01972×10^{-1}	1.35962×10^{-3}	$8.6000\ \times10^{-1}$
9.80665	1	1.33333×10^{-2}	8.43371
$7.355\ \times10^{2}$	$7.5\ \times10$	1	6.32529×10^{2}
1.16279	1.18572×10^{-1}	1.58095×10^{-3}	1

Note 1) 1W=1J/s, PS:French horse power
1PS=0.7355kW
(By the enforcement act for the law of weights and measures)
1cal=4.18605J

METALLIC MATERIALS CROSS REFERENCE LIST

CARBON STEEL

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
STKM 12A STKM 12C	1.0038	RSt.37-2	4360 40 C	–	E 24-2 Ne	–	–	1311	A570.36	15
–	1.0401	C15	080M15	–	CC12	C15, C16	F.111	1350	1015	15
–	1.0402	C22	050A20	2C	CC20	C20, C21	F.112	1450	1020	20
SUM22	1.0715	9SMn28	230M07	1A	S250	CF9SMn28	F.2111 11SMn28	1912	1213	Y15
SUM22L	1.0718	9SMnPb28	–	–	S250Pb	CF9SMnPb28	11SMnPb28	1914	12L13	–
–	1.0722	10SPb20	–	–	10PbF2	CF10Pb20	10SPb20	–	–	–
–	1.0736	9SMn36	240M07	1B	S300	CF9SMn36	12SMn35	–	1215	Y13
–	1.0737	9SMnPb36	–	–	S300Pb	CF9SMnPb36	12SMnP35	1926	12L14	–
S15C	1.1141	Ck15	080M15	32C	XC12	C16	C15K	1370	1015	15
S25C	1.1158	Ck25	–	–	–	–	–	–	1025	25
–	1.8900	StE380	4360 55 E	–	–	FeE390KG	–	2145	A572-60	–
–	1.0501	C35	060A35	–	CC35	C35	F.113	1550	1035	35
–	1.0503	C45	080M46	–	CC45	C45	F.114	1650	1045	45
–	1.0726	35S20	212M36	8M	35MF4	–	F210G	1957	1140	–
–	1.1157	40Mn4	150M36	15	35M5	–	–	–	1039	40Mn
SMn438(H)	1.1167	36Mn5	–	–	40M5	–	36Mn5	2120	1335	35Mn2
SCMn1	1.1170	28Mn6	150M28	14A	20M5	C28Mn	–	–	1330	30Mn
S35C	1.1183	Cf35	060A35	–	XC38TS	C36	–	1572	1035	35Mn
S45C	1.1191	Ck45	080M46	–	XC42	C45	C45K	1672	1045	Ck45
S50C	1.1213	Cf53	060A52	–	XC48TS	C53	–	1674	1050	50
–	1.0535	C55	070M55	9	–	C55	–	1655	1055	55
–	1.0601	C60	080A62	43D	CC55	C60	–	–	1060	60
S55C	1.1203	Ck55	070M55	–	XC55	C50	C55K	–	1055	55
S58C	1.1221	Ck60	080A62	43D	XC60	C60	–	1678	1060	60Mn
–	1.1274	Ck101	060A96	–	XC100	–	F.5117	1870	1095	–
SK3	1.1545	C105W1	BW1A	–	Y105	C36KU	F.5118	1880	W1	–
SUP4	1.1545	C105W1	BW2	–	Y120	C120KU	F.515	2900	W210	–

ALLOY STEEL

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SM400A, SM400B SM400C	1.0144	St.44.2	4360 43 C	–	E28-3	–	–	1412	A573-81	–
SM490A, SM490B SM490C	1.0570	St52-3	4360 50 B	–	E36-3	Fe52BFN Fe52CFN	–	2132	–	–
–	1.0841	St52-3	150M19	–	20MC5	Fe52	F.431	2172	5120	–
–	1.0904	55Si7	250A53	45	55S7	55Si8	56Si7	2085	9255	55Si2Mn
–	1.0961	60SiCr7	–	–	60SC7	60SiCr8	60SiCr8	–	9262	–
SUJ2	1.3505	100Cr6	534A99	31	100C6	100Cr6	F.131	2258	ASTM 52100	GCr15
–	1.5415	15Mo3	1501-240	–	15D3	16Mo3KW	16Mo3	2912	ASTM A204Gr.A	–
–	1.5423	16Mo5	1503-245-420	–	–	16Mo5	16Mo5	–	4520	–
–	1.5622	14Ni6	–	–	16N6	14Ni6	15Ni6	–	ASTM A350LF5	–
–	1.5662	X8Ni9	1501-509-510	–	–	X10Ni9	XBNi09	–	ASTM A353	–
SNC236	1.5710	36NiCr6	640A35	111A	35NC6	–	–	–	3135	–
SNC415(H)	1.5732	14NiCr10	–	–	14NC11	16NiCr11	15NiCr11	–	3415	–
SNC815(H)	1.5752	14NiCr14	655M13	36A	12NC15	–	–	–	3415, 3310	–
SNCM220(H)	1.6523	21NiCrMo2	805M20	362	20NCD2	20NiCrMo2	20NiCrMo2	2506	8620	–
SNCM240	1.6546	40NiCrMo22	311-Type 7	–	–	40NiCrMo2(KB)	40NiCrMo2	–	8740	–
–	1.6587	17CrNiMo6	820A16	–	18NCD6	–	14NiCrMo13	–	–	–
SCr415(H)	1.7015	15Cr3	523M15	–	12C3	–	–	–	5015	15Cr

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SCr440	1.7045	42Cr4	–	–	–	–	42Cr4	2245	5140	40Cr
SUP9(A)	1.7176	55Cr3	527A60	48	55C3	–	–	–	5155	20CrMn
SCM415(H)	1.7262	15CrMo5	–	–	12CD4	–	12CrMo4	2216	–	–
–	1.7335	13CrMo4 4	1501-620Gr27	–	15CD3.5 15CD4.5	14CrMo45	14CrMo45	–	ASTM A182 F11, F12	–
–	1.7380	10CrMo910	1501-622 Gr31, 45	–	12CD9 12CD10	12CrMo9 12CrMo10	TU.H	2218	ASTM A182 F.22	–
–	1.7715	14MoV63	1503-660-440	–	–	–	13MoCrV6	–	–	–
–	1.8523	39CrMoV13 9	897M39	40C	–	36CrMoV12	–	–	–	–
–	1.6511	36CrNiMo4	816M40	110	40NCD3	38NiCrMo4(KB)	35NiCrMo4	–	9840	–
–	1.6582	34CrNiMo6	817M40	24	35NCD6	35NiCrMo6(KB)	–	2541	4340	40CrNiMoA
SCr430(H)	1.7033	34Cr4	530A32	18B	32C4	34Cr4(KB)	35Cr4	–	5132	35Cr
SCr440(H)	1.7035	41Cr4	530M40	18	42C4	41Cr4	42Cr4	–	5140	40Cr
–	1.7131	16MnCr5	(527M20)	–	16MC5	16MnCr5	16MnCr5	2511	5115	18CrMn
SCM420 SCM430	1.7218	25CrMo4	1717CDS110 708M20	–	25CD4	25CrMo4(KB)	55Cr3	2225	4130	30CrMn
SCM432 SCCRM3	1.7220	34CrMo4	708A37	19B	35CD4	35CrMo4	34CrMo4	2234	4137 4135	35CrMo
SCM 440	1.7223	41CrMo4	708M40	19A	42CD4TS	41CrMo4	42CrMo4	2244	4140 4142	40CrMoA
SCM440(H)	1.7225	42CrMo4	708M40	19A	42CD4	42CrMo4	42CrMo4	2244	4140	42CrMo 42CrMnMo
–	1.7361	32CrMo12	722M24	40B	30CD12	32CrMo12	F.124.A	2240	–	–
SUP10	1.8159	50CrV4	735A50	47	50CV4	50CrV4	51CrV4	2230	6150	50CrVA
–	1.8509	41CrAlMo7	905M39	41B	40CAD6 40CAD2	41CrAlMo7	41CrAlMo7	2940	–	–
–	1.2067	100Cr6	BL3	–	Y100C6	–	100Cr6	–	L3	CrV, 9SiCr
SKS31 SKS2, SKS3	1.2419	105WCr6	–	–	105WC13	100WCr6 107WCr5KU	105WCr5	2140	–	CrWMo
SKT4	1.2713	55NiCrMoV6	BH224/5	–	55NCDV7	–	F.520.S	–	L6	5CrNiMo
–	1.5662	X8Ni9	1501-509	–	–	X10Ni9	XBNi09	–	ASTM A353	–
–	1.5680	12Ni19	–	–	Z18N5	–	–	–	2515	–
–	1.6657	14NiCrMo134	832M13	36C	–	15NiCrMo13	14NiCrMo131	–	–	–
SKD1	1.2080	X210Cr12	BD3	–	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	–	D3 ASTM D3	Cr12
SKD11	1.2601	X153CrMoV12	BD2	–	–	X160CrMoV12	–	–	D2	Cr12MoV
SKD12	1.2363	X100CrMoV5	BA2	–	Z100CDV5	X100CrMoV5	F.5227	2260	A2	Cr5Mo1V
SKD61	1.2344	X40CrMoV51 X40CrMoV51	BH13	–	Z40CDV5	X35CrMoV05KU X40CrMoV51KU	X40CrMoV5	2242	H13 ASTM H13	40CrMoV5
SKD2	1.2436	X210CrW12	–	–	–	X215CrW121KU	X210CrW12	2312	–	–
–	1.2542	45WCrV7	BS1	–	–	45WCrV8KU	45WCrSi8	2710	S1	–
SKD5	1.2581	X30WCrV93	BH21	–	Z30WCV9	X28W09KU	X30WCrV9	–	H21	30WCrV9
–	1.2601	X165CrMoV12	–	–	–	X165CrMoW12KU	X160CrMoV12	2310	–	–
SKS43	1.2833	100V1	BW2	–	Y1105V	–	–	–	W210	V
SKH3	1.3255	S 18-1-2-5	BT4	–	Z80WKCV	X78WCo1805KU	HS18-1-1-5	–	T4	W18Cr4VCo5
SKH2	1.3355	S 18-0-1	BT1	–	Z80WCV	X75W18KU	HS18-0-1	–	T1	–
SCMnH/1	1.3401	G-X120Mn12	Z120M12	–	Z120M12	XG120Mn12	X120MN12	–	–	–
SUH1	1.4718	X45CrSi93	401S45	52	Z45CS9	X45CrSi8	F.322	–	HW3	X45CrSi93
SUH3	1.3343	S6-5-2	4959BA2	–	Z40CSD10	15NiCrMo13	–	2715	D3	–
SKH9, SKH51	1.3343	S6/5/2	BM2	–	Z85WDCV	HS6-5-2-2	F.5603	2722	M2	–
–	1.3348	S 2-9-2	–	–	–	HS2-9-2	HS2-9-2	2782	M7	–
SKH55	1.3243	S6/5/2/5	BM35	–	6-5-2-5	HS6-5-2-5	F.5613	2723	M35	–

METALLIC MATERIALS CROSS REFERENCE LIST

■STAINLESS STEEL (FERRITIC,MARTENSITIC)

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SUS403	1.4000	X7Cr13	403S17	–	Z6C13	X6Cr13	F.3110	2301	403	OCr13 1Cr12
–	1.4001	X7Cr14	–	–	–	–	F.8401	–	–	–
SUS416	1.4005	X12CrS13	416S21	–	Z11CF13	X12CrS13	F.3411	2380	416	–
SUS410	1.4006	X10Cr13	410S21	56A	Z10C14	X12Cr13	F.3401	2302	410	1Cr13
SUS430	1.4016	X8Cr17	430S15	60	Z8C17	X8Cr17	F.3113	2320	430	1Cr17
SCS2	1.4027	G-X20Cr14	420C29	56B	Z20C13M	–	–	–	–	–
SUS420J2	1.4034	X46Cr13	420S45	56D	Z40CM Z38C13M	X40Cr14	F.3405	2304	–	4Cr13
–	1.4003	–	405S17	–	Z8CA12	X6CrAl13	–	–	405	–
–	1.4021	–	420S37	–	Z8CA12	X20Cr13	–	2303	420	–
SUS431	1.4057	X22CrNi17	431S29	57	Z15CNi6.02	X16CrNi16	F.3427	2321	431	1Cr17Ni2
SUS430F	1.4104	X12CrMoS17	–	–	Z10CF17	X10CrS17	F.3117	2383	430F	Y1Cr17
SUS434	1.4113	X6CrMo17	434S17	–	Z8CD17.01	X8CrMo17	–	2325	434	1Cr17Mo
SCS5	1.4313	X5CrNi134	425C11	–	Z4CND13.4M	(G)X6CrNi304	–	2385	CA6-NM	–
SUS405	1.4724	X10CrA113	403S17	–	Z10C13	X10CrA112	F.311	–	405	OCr13Al
SUS430	1.4742	X10CrA118	430S15	60	Z10CAS18	X8Cr17	F.3113	–	430	Cr17
SUH4	1.4747	X80CrNiSi20	443S65	59	Z80CSN20.02	X80CrSiNi20	F.320B	–	HNV6	–
SUH446	1.4762	X10CrA124	–	–	Z10CAS24	X16Cr26	–	2322	446	2Cr25N
SUH35	1.4871	X53CrMnNiN219	349S54	–	Z52CMN21.09	X53CrMnNiN219	–	–	EV8	5Cr2Mn9Ni4N
–	1.4521	X1CrMoTi182	–	–	–	–	–	2326	S44400	–
–	1.4922	X20CrMoV12-1	–	–	–	X20CrMoNi1201	–	2317	–	–
–	1.4542	–	–	–	Z7CNU17-04	–	–	–	630	–

■STAINLESS STEEL (AUSTENITIC)

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SUS304L	1.4306	X2CrNi1911	304S11	–	Z2CN18.10	X2CrNi18.11	–	2352	304L	OCr19Ni10
SUS304	1.4350	X5CrNi189	304S11	58E	Z6CN18.09	X5CrNi1810	F.3551 F.3541 F.3504	2332	304	OCr18Ni9
SUS303	1.4305	X12CrNiS188	303S21	58M	Z10CNF18.09	X10CrNiS18.09	F.3508	2346	303	1Cr18Ni9MoZr
SUS304L	–	–	304C12	–	Z3CN19.10	–	–	2333	–	–
SCS19	1.4306	X2CrNi189	304S12	–	Z2CrNi1810	X2CrNi18.11	F.3503	2352	304L	–
SUS301	1.4310	X12CrNi177	–	–	Z12CN17.07	X12CrNi1707	F.3517	2331	301	Cr17Ni7
SUS304LN	1.4311	X2CrNiN1810	304S62	–	Z2CN18.10	–	–	2371	304LN	–
SUS316	1.4401	X5CrNiMo1810	316S16	58J	Z6CND17.11	X5CrNiMo1712	F.3543	2347	316	0Cr17Ni11Mo2
SCS13	1.4308	G-X6CrNi189	304C15	–	Z6CN18.10M	–	–	–	–	–
SCS14	1.4408	G-X6CrNiMo1810	316C16	–	–	–	F.8414	–	–	–
SCS22	1.4581	G-X5CrNiMoNb1810	318C17	–	Z4CNDNb1812M	XG8CrNiMo1811	–	–	–	–
SUS316LN	1.4429	X2CrNiMoN1813	–	–	Z2CND17.13	–	–	2375	316LN	OCr17Ni13Mo
–	1.4404	–	316S13	–	Z2CND17.12	X2CrNiMo1712	–	2348	316L	–
SCS16 SUS316L	1.4435	X2CrNiMo1812	316S13	–	Z2CND17.12	X2CrNiMo1712	–	2353	316L	OCr27Ni12Mo3
–	1.4436	–	316S13	–	Z6CND18-12-03	X8CrNiMo1713	–	2343, 2347	316	–
SUS317L	1.4438	X2CrNiMo1816	317S12	–	Z2CND19.15	X2CrNiMo1816	–	2367	317L	OOCr19Ni13Mo
–	1.4539	X1NiCrMo	–	–	Z6CNT18.10	–	–	2562	UNS V 0890A	–
SUS321	1.4541	X10CrNiTi189	321S12	58B	Z6CNT18.10	X6CrNiTi1811	F.3553 F.3523	2337	321	1Cr18NI9Ti
SUS347	1.4550	X10CrNiNb189	347S17	58F	Z6CNNb18.10	X6CrNiNb1811	F.3552 F.3524	2338	347	1Cr18Ni11Nb
–	1.4571	X10CrNiMoTi1810	320S17	58J	Z6CNDT17.12	X6CrNiMoTi1712	F.3535	2350	316Ti	Cr18Ni12Mo2T
–	1.4583	X10CrNiMoNb1812	–	–	Z6CNDNb1713B	X6CrNiMoNb1713	–	–	318	Cr17Ni12Mo3Mb

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SUH309	1.4828	X15CrNiSi2012	309S24	–	Z15CNS20.12	X6CrNi2520	–	–	309	1Cr23Ni13
SUH310	1.4845	X12CrNi2521	310S24	–	Z12CN2520	X6CrNi2520	F.331	2361	310S	OCr25Ni20
SCS17	1.4406	X10CrNi18.08	–	58C	Z1NCDU25.20	–	F.8414	2370	308	–
–	1.4418	X4CrNiMo165	–	–	Z6CND16-04-01	–	–	–	–	–
–	1.4568 1.4504	–	316S111	–	Z8CNA17-07	X2CrNiMo1712	–	–	17-7PH	–
–	1.4563	–	–	–	Z1NCDU31-27-03 Z1CNDU20-18-06AZ	–	–	2584 2378	NO8028 S31254	–
SUS321	1.4878	X12CrNiTi189	321S32	58B, 58C	Z6CNT18.12B	X6CrNiTi18 11	F.3523	–	321	1Cr18Ni9Ti

■HEAT RESISTANT STEELS

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
SUH330	1.4864	X12NiCrSi3616	–	–	Z12NCS35.16	–	–	–	330	–
SCH15	1.4865	G-X40NiCrSi3818	330C11	–	–	XG50NiCr3919	–	–	HT, HT 50	–

■GRAY CAST IRON

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
–	–	–	–	–	–	–	–	0100	–	–
FC100	–	GG 10	–	–	Ft 10 D	–	–	0110	No 20 B	–
FC150	0.6015	GG 15	Grade 150	–	Ft 15 D	G15	FG15	0115	No 25 B	HT150
FC200	0.6020	GG 20	Grade 220	–	Ft 20 D	G20	–	0120	No 30 B	HT200
FC250	0.6025	GG 25	Grade 260	–	Ft 25 D	G25	FG25	0125	No 35 B	HT250
–	–	–	–	–	–	–	–	–	No 40 B	–
FC300	0.6030	GG 30	Grade 300	–	Ft 30 D	G30	FG30	0130	No 45 B	HT300
FC350	0.6035	GG 35	Grade 350	–	Ft 35 D	G35	FG35	0135	No 50 B	HT350
–	0.6040	GG 40	Grade 400	–	Ft 40 D	–	–	0140	No 55 B	HT400
–	0.6660	GGL NiCr202	L-NiCuCr202	–	L-NC 202	–	–	0523	A436 Type 2	–

■DUCTILE CAST IRON

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
FCD400	0.7040	GGG 40	SNG 420/12	–	FCS 400-12	GS 370-17	FGE 38-17	07 17-02	60-40-18	QT400-18
–	–	GGG 40.3	SNG 370/17	–	FGS 370-17	–	–	07 17-12	–	–
–	0.7033	GGG 35.3	–	–	–	–	–	07 17-15	–	–
FCD500	0.7050	GGG 50	SNG 500/7	–	FGS 500-7	GS 500	FGE 50-7	07 27-02	80-55-06	QT500-7
–	0.7660	GGG NiCr202	Grade S6	–	S-NC202	–	–	07 76	A43D2	–
–	–	GGG NiMn137	L-NiMn 137	–	L-MN 137	–	–	07 72	–	–
FCD600	–	GGG 60	SNG 600/3	–	FGS 600-3	–	–	07 32-03	–	QT600-3
FCD700	0.7070	GGG 70	SNG 700/2	–	FGS 700-2	GS 700-2	FGS 70-2	07 37-01	100-70-03	QT700-18

■MALLEABLE CAST IRON

Japan	Germany		U.K.		France	Italy	Spain	Sweden	USA	China
JIS	W-nr.	DIN	BS	EN	AFNOR	UNI	UNE	SS	AISI/SAE	GB
FCMB310	–	–	8 290/6	–	MN 32-8	–	–	08 14	–	–
FCMW330	–	GTS-35	B 340/12	–	MN 35-10	–	–	08 15	32510	–
FCMW370	0.8145	GTS-45	P 440/7	–	Mn 450	GMN45	–	08 52	40010	–
FCMP490	0.8155	GTS-55	P 510/4	–	MP 50-5	GMN55	–	08 54	50005	–
FCMP540	–	GTS-65	P 570/3	–	MP 60-3	–	–	08 58	70003	–
FCMP590	0.8165	GTS-65-02	P 570/3	–	Mn 650-3	GMN 65	–	08 56	A220-70003	–
FCMP690	–	GTS-70-02	P 690/2	–	Mn 700-2	GMN 70	–	08 62	A220-80002	–

DIE STEELS

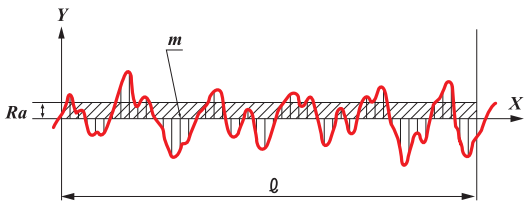
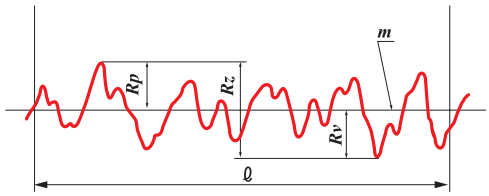
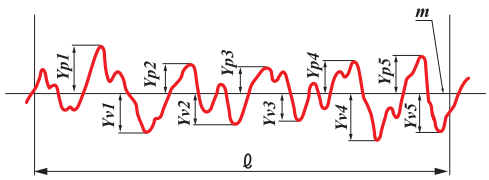
Classification	JIS (Others)	Aichi Steel Works	Uddeholm	Kobe Steel, Ltd.	Sumitomo Metal Industries, Ltd.	Daido Steel Co., Ltd.	Nippon Koshuha	Hitachi Metals, Ltd.	Mitsubishi Steel Manufacturing Co., Ltd.
Carbon Steel for Machine Structure	S50C	AUK1		KTSM2A	SD10	PDS1	KPM1		MT50C
	|			KTSM21	SD17	PXZ			
	S55C			KTSM22	SD21				
Alloy Steel for Machine Structure	SCM440	AUK11		KTSM3A	SD61	PDS3			
	|			KTSM31					
	SCM445		HOLDAX						
Carbon Tool Steel	SK3	SK3				YK3	K3	YC3	
Alloy Tool Steel (For Cold Working)	SKS3	SKS3				GOA	KS3	SGT	
	SKS31					GO31	K31		
	SKS93	SK301				YK30	K3M	YCS3	
	SKD1						KD1	CRD	
	SKD11	SKD11		KAD181		DC11	KD11	SLD	
	SKD11	AUD11				DC3	KD11V	SLD2	
	SKD11						KDQ		
	SKD12		RIGOR			DC12	KD12	SCD	
		SX4							
		SX44							
		SX105V					FH5		
		TCD							
						DC53	KD21	SLD8	
						PD613			
						GO4		ACD37	
						GO5		HMD5	
						GO40F		HPM2T	
								YSM	
								HPM31	
								HMD1	
							KDM5	HMD5	
							KD11S	ACD6	
								ACD8	
								ACD9	
Alloy Tool Steel (For Cold Working and Others)	(P20)		IMPAX	KTSM3M		PX5	KPM30	HPM2	MT24M
	(P20)							HPM7	
	(P21)			KTSM40EF		NAK55	KAP	HPM1	
				KTSM40E		NAK80	KAP2	HPM50	
						GLD2		CENA1	
Alloy Tool Steel (For Hot Working)	SKD4					DH4	KD4	YDC	
	SKD5					DH5	KD5	HDC	
	SKD6					DH6	KD6		
	SKD61	SKD61	Over M Suprem			DHA1	KDA	DAC	
	SKD61						MFA		
	SKD62	SKD62				DH62	KDB	DBC	
	SKT4					GFA	KTV	DM	
	SKD7					DH72	KDH1	YEM	
	(H10)					DH73			
	SKD8					DH41	KDF	MDC	
			QRO80M						
								YHD40	
						DH71			
						DH42			
						DH21			
							KDW		
							KDHM		
							AE31		
								YEM4	
								YHD50	
	SKT4	SKT4A						YHD26	
	6F4	MPH							
	SKT4								
						DH31	KDA1	DAC3	
							KDA5	DAC10	
								DAC40	
						GF78		DAC45	
						DH76		DAC55	
							TD3		
						DH2F	KDAS	FDAC	
								YHD3	
								MDC−K	
								YEM−K	

Classification	JIS (Others)	Aichi Steel Works	Uddeholm	Kobe Steel, Ltd.	Sumitomo Metal Industries, Ltd.	Daido Steel Co., Ltd.	Nippon Koshuha	Hitachi Metals, Ltd.	Mitsubishi Steel Manufacturing Co., Ltd.
High-speed Tool Steel	SKH51					MH51	H51	YXM1	
	SKH55					MH55	HM35	YXM4	
	SKH57					MH57	MV10	XVC5	
						MH8	NK4	YXM60	
						MH24			
						MH7V1			
						MH64			
						VH54	HV2	XVC11	
							HM3	YXM7	
						MH85	KDMV	YXR3	
						MH88	HM9TL	YXR4	
								YXR7	
								YXR35	
Powder High-speed Tool Steel			ASP23	KHA32		DEX20		HAP10	
			ASP30	KHA30		DEX40		HAP40	
				KHA3VN		DEX60		HAP50	
				KHA30N		DEX70		HAP63	
				KHA33N		DEX80		HAP72	
				KHA50					
				KHA77					
			ASP60	KHA60					
Stainless Steel	SUS403					GLD1			
	SUS420		STAVAX			S–STAR	KSP1	HPM38	
	SUS440C		ELMAX (Powder)	KAS440 (Powder)		SUS440C	KSP3		
	SUS420							SUS420	
	SUS630					NAK101	U630	PSL	
	(414)								
Maraging Steel						MAS1C	KMS18–20	YAG	DMG300
Heat Resistant Alloy								HRNC	

SURFACE ROUGHNESS

SURFACE ROUGHNESS

(From JIS B 0601-1994)

Type	Code	Determination	Determination Example (Figure)
Arithmetical Mean Roughness	Ra	Ra means the value obtained by the following formula and expressed in micrometer (μm) when sampling only the reference length from the roughness curve in the direction of the mean line, taking X-axis in the direction of mean line and Y-axis in the direction of longitudinal magnification of this sampled part and the roughness curve is expressed by y=f(x): $Ra=\frac{1}{l}\int_0^l \lvert f(x)\rvert dx$	
Maximum Height	Rz	Rz shall be that only when the reference length is sampled from the roughness curve in the direction of the mean line, the distance between the top profile peak line and the bottom profile valley line on this sampled portion is measured in the longitudinal magnification direction of roughness curve and the obtained value is expressed in micrometer (μm). Note) When finding Rz, a portion without an exceptionally high peak or low valley, which may be regarded as a flaw, is selected as the sampling length. $Rz=R_P+Rv$	
Ten-Point Mean Roughness	R_{ZJIS}	R_{ZJIS} shall be that only when the reference length is sampled from the roughness curve in the direction of its mean line, the sum of the average value of absolute values of the heights of five highest profile peaks (Yp) and the depths of five deepest profile valleys (Yv) measured in the vertical magnification direction from the mean line of this sampled portion and this sum is expressed in micrometer (μm). $R_{ZJIS}=\frac{(Y_{p1}+Y_{p2}+Y_{p3}+Y_{p4}+Y_{p5})+(Y_{v1}+Y_{v2}+Y_{v3}+Y_{v4}+Y_{v5})}{5}$	 $Y_{p1}, Y_{p2}, Y_{p3}, Y_{p4}, Y_{p5}$: altitudes of the five highest profile peaks of the sampled portion corresponding to the reference length l. $Y_{v1}, Y_{v2}, Y_{v3}, Y_{v4}, Y_{v5}$: altitudes of the five deepest profile valleys of the sampled portion corresponding to the reference length l.

■RELATIONSHIP BETWEEN ARITHMETICAL MEAN (Ra) AND CONVENTIONAL DESIGNATION (REFERENCE DATA)

Arithmetical Mean Roughness Ra		Max. Height Rz	Ten-Point Mean Roughness R_{ZJIS}	Sampling Length for Rz • R_{ZJIS} l (mm)	Conventional Finish Mark
Standard Series	Cutoff Value λc (mm)	Standard Series			
0.012 a	0.08	0.05s	0.05z	0.08	▽▽▽▽
0.025 a	0.25	0.1 s	0.1 z		
0.05 a		0.2 s	0.2 z	0.25	
0.1 a	0.8	0.4 s	0.4 z		
0.2 a		0.8 s	0.8 z	0.8	
0.4 a		1.6 s	1.6 z		▽▽▽
0.8 a		3.2 s	3.2 z		
1.6 a		6.3 s	6.3 z		
3.2 a	2.5	12.5 s	12.5 z	2.5	▽▽
6.3 a		25 s	25 z		
12.5 a	8	50 s	50 z		▽
25 a		100 s	100 z	8	
50 a		200 s	200 z		–
100 a	–	400 s	400 z	–	

*The correlation among the three is shown for convenience and is not exact.
*Ra: The evaluation length of Rz and R_{ZJIS} is the cutoff value and sampling length multiplied by 5, respectively.

HARDNESS COMPARISON TABLE

HARDNESS CONVERSION NUMBERS OF STEEL

Brinell Hardness (HB) 10mm Ball,Load: 3,000 kgf		Vickers Hardness	Rockwell Hardness				Shore Hardness	Tensile Strength (Approx.)
Standard Ball	Tungsten Carbide Ball	(HV)	A Scale, Load:60kgf, Diamond Point (HRA)	B Scale, Load:100kgf, 1/16" Ball (HRB)	C Scale, Load:150kgf, Diamond Point (HRC)	D Scale, Load:100kgf, Diamond Point (HRD)	(HS)	Mpa
—	—	940	85.6	—	68.0	76.9	97	—
—	—	920	85.3	—	67.5	76.5	96	—
—	—	900	85.0	—	67.0	76.1	95	—
—	(767)	880	84.7	—	66.4	75.7	93	—
—	(757)	860	84.4	—	65.9	75.3	92	—
—	(745)	840	84.1	—	65.3	74.8	91	—
—	(733)	820	83.8	—	64.7	74.3	90	—
—	(722)	800	83.4	—	64.0	73.8	88	—
—	(712)	—	—	—	—	—	—	—
—	(710)	780	83.0	—	63.3	73.3	87	—
—	(698)	760	82.6	—	62.5	72.6	86	—
—	(684)	740	82.2	—	61.8	72.1	—	—
—	(682)	737	82.2	—	61.7	72.0	84	—
—	(670)	720	81.8	—	61.0	71.5	83	—
—	(656)	700	81.3	—	60.1	70.8	—	—
—	(653)	697	81.2	—	60.0	70.7	81	—
—	(647)	690	81.1	—	59.7	70.5	—	—
—	(638)	680	80.8	—	59.2	70.1	80	—
—	630	670	80.6	—	58.8	69.8	—	—
—	627	667	80.5	—	58.7	69.7	79	—
—	—	677	80.7	—	59.1	70.0	—	—
—	601	640	79.8	—	57.3	68.7	77	—
—	—	640	79.8	—	57.3	68.7	—	—
—	578	615	79.1	—	56.0	67.7	75	—
—	—	607	78.8	—	55.6	67.4	—	—
—	555	591	78.4	—	54.7	66.7	73	2055
—	—	579	78.0	—	54.0	66.1	—	2015
—	534	569	77.8	—	53.5	65.8	71	1985
—	—	533	77.1	—	52.5	65.0	—	1915
—	514	547	76.9	—	52.1	64.7	70	1890
(495)	—	539	76.7	—	51.6	64.3	—	1855
—	—	530	76.4	—	51.1	63.9	—	1825
	495	528	76.3	—	51.0	63.8	68	1820
(477)	—	516	75.9	—	50.3	63.2	—	1780
—	—	508	75.6	—	49.6	62.7	—	1740
	477	508	75.6	—	49.6	62.7	66	1740
(461)	—	495	75.1	—	48.8	61.9	—	1680
—	—	491	74.9	—	48.5	61.7	—	1670
	461	491	74.9	—	48.5	61.7	65	1670
444	—	474	74.3	—	47.2	61.0	—	1595
—	—	472	74.2	—	47.1	60.8	—	1585
—	444	472	74.2	—	47.1	60.8	63	1585

Brinell Hardness (HB) 10mm Ball,Load: 3,000 kgf		Vickers Hardness	Rockwell Hardness				Shore Hardness	Tensile Strength (Approx.)
Standard Ball	Tungsten Carbide Ball	(HV)	A Scale, Load:60kgf, Diamond Point (HRA)	B Scale, Load:100kgf, 1/16" Ball (HRB)	C Scale, Load:150kgf, Diamond Point (HRC)	D Scale, Load:100kgf, Diamond Point (HRD)	(HS)	Mpa
429	429	455	73.4	—	45.7	59.7	61	1510
415	415	440	72.8	—	44.5	58.8	59	1460
401	401	425	72.0	—	43.1	57.8	58	1390
388	388	410	71.4	—	41.8	56.8	56	1330
375	375	396	70.6	—	40.4	55.7	54	1270
363	363	383	70.0	—	39.1	54.6	52	1220
352	352	372	69.3	(110.0)	37.9	53.8	51	1180
341	341	360	68.7	(109.0)	36.6	52.8	50	1130
331	331	350	68.1	(108.5)	35.5	51.9	48	1095
321	321	339	67.5	(108.0)	34.3	51.0	47	1060
311	311	328	66.9	(107.5)	33.1	50.0	46	1025
302	302	319	66.3	(107.0)	32.1	49.3	45	1005
293	293	309	65.7	(106.0)	30.9	48.3	43	970
285	285	301	65.3	(105.5)	29.9	47.6	—	950
277	277	292	64.6	(104.5)	28.8	46.7	41	925
269	269	284	64.1	(104.0)	27.6	45.9	40	895
262	262	276	63.6	(103.0)	26.6	45.0	39	875
255	255	269	63.0	(102.0)	25.4	44.2	38	850
248	248	261	62.5	(101.0)	24.2	43.2	37	825
241	241	253	61.8	100	22.8	42.0	36	800
235	235	247	61.4	99.0	21.7	41.4	35	785
229	229	241	60.8	98.2	20.5	40.5	34	765
223	223	234	—	97.3	(18.8)	—	—	—
217	217	228	—	96.4	(17.5)	—	33	725
212	212	222	—	95.5	(16.0)	—	—	705
207	207	218	—	94.6	(15.2)	—	32	690
201	201	212	—	93.8	(13.8)	—	31	675
197	197	207	—	92.8	(12.7)	—	30	655
192	192	202	—	91.9	(11.5)	—	29	640
187	187	196	—	90.7	(10.0)	—	—	620
183	183	192	—	90.0	(9.0)	—	28	615
179	179	188	—	89.0	(8.0)	—	27	600
174	174	182	—	87.8	(6.4)	—	—	585
170	170	178	—	86.8	(5.4)	—	26	570
167	167	175	—	86.0	(4.4)	—	—	560
163	163	171	—	85.0	(3.3)	—	25	545
156	156	163	—	82.9	(0.9)	—	—	525
149	149	156	—	80.8	—	—	23	505
143	143	150	—	78.7	—	—	22	490
137	137	143	—	76.4	—	—	21	460
131	131	137	—	74.0	—	—	—	450
126	126	132	—	72.0	—	—	20	435
121	121	127	—	69.8	—	—	19	415
116	116	122	—	67.6	—	—	18	400
111	111	117	—	65.7	—	—	15	385

Note 1) Above list is the same as that at AMS Metals Hand book with tensile strength in approximate metric value and Brinell hardness over a recommended range.
Note 2) 1MPa=1N/mm^2
Note 3) Figures in ( ) are rarely used and are included for reference. This list has been taken from JIS Handbook Steel I.

JIS FIT TOLERANCE TABLE (HOLE)

Classification of Standard Dimensions (mm)		Class of Geometrical Tolerance Zone of Holes															
>	≤	B10	C9	C10	D8	D9	D10	E7	E8	E9	F6	F7	F8	G6	G7	H6	H7
–	3	+180 +140	+85 +60	+100 +60	+34 +20	+45 +20	+60 +20	+24 +14	+28 +14	+39 +14	+12 +6	+16 +6	+20 +6	+8 +2	+12 +2	+6 0	+10 0
3	6	+188 +140	+100 +70	+118 +70	+48 +30	+60 +30	+78 +30	+32 +20	+38 +20	+50 +20	+18 +10	+22 +10	+28 +10	+12 +4	+16 +4	+8 0	+12 0
6	10	+208 +150	+116 +80	+138 +80	+62 +40	+76 +40	+98 +40	+40 +25	+47 +25	+61 +25	+22 +13	+28 +13	+35 +13	+14 +5	+20 +5	+9 0	+15 0
10	14	+220 +150	+138 +95	+165 +95	+77 +50	+93 +50	+120 +50	+50 +32	+59 +32	+75 +32	+27 +16	+34 +16	+43 +16	+17 +6	+24 +6	+11 0	+18 0
14	18																
18	24	+244 +160	+162 +110	+194 +110	+98 +65	+117 +65	+149 +65	+61 +40	+73 +40	+92 +40	+33 +20	+41 +20	+53 +20	+20 +7	+28 +7	+13 0	+21 0
24	30																
30	40	+270 +170	+182 +120	+220 +120	+119 +80	+142 +80	+180 +80	+75 +50	+89 +50	+112 +50	+41 +25	+50 +25	+64 +25	+25 +9	+34 +9	+16 0	+25 0
40	50	+280 +180	+192 +130	+230 +130													
50	65	+310 +190	+214 +140	+260 +140	+146 +100	+174 +100	+220 +100	+90 +60	+106 +60	+134 +60	+49 +30	+60 +30	+76 +30	+29 +10	+40 +10	+19 0	+30 0
65	80	+320 +200	+224 +150	+270 +150													
80	100	+360 +220	+257 +170	+310 +170	+174 +120	+207 +120	+260 +120	+107 +72	+126 +72	+159 +72	+58 +36	+71 +36	+90 +36	+34 +12	+47 +12	+22 0	+35 0
100	120	+380 +240	+267 +180	+320 +180													
120	140	+420 +260	+300 +200	+360 +200	+208 +145	+245 +145	+305 +145	+125 +85	+148 +85	+185 +85	+68 +43	+83 +43	+106 +43	+39 +14	+54 +14	+25 0	+40 0
140	160	+440 +280	+310 +210	+370 +210													
160	180	+470 +310	+330 +230	+390 +230													
180	200	+525 +340	+355 +240	+425 +240	+242 +170	+285 +170	+355 +170	+146 +100	+172 +100	+215 +100	+79 +50	+96 +50	+122 +50	+44 +15	+61 +15	+29 0	+46 0
200	225	+565 +380	+375 +260	+445 +260													
225	250	+605 +420	+395 +280	+465 +280													
250	280	+690 +480	+430 +300	+510 +300	+271 +190	+320 +190	+400 +190	+162 +110	+191 +110	+240 +110	+88 +56	+108 +56	+137 +56	+49 +17	+69 +17	+32 0	+52 0
280	315	+750 +540	+460 +330	+540 +330													
315	355	+830 +600	+500 +360	+590 +360	+299 +210	+350 +210	+440 +210	+182 +125	+214 +125	+265 +125	+98 +62	+119 +62	+151 +62	+54 +18	+75 +18	+36 0	+57 0
355	400	+910 +680	+540 +400	+630 +400													
400	450	+1010 +760	+595 +440	+690 +440	+327 +230	+385 +230	+480 +230	+198 +135	+232 +135	+290 +135	+108 +68	+131 +68	+165 +68	+60 +20	+83 +20	+40 0	+63 0
450	500	+1090 +840	+635 +480	+730 +480													

Note) Values shown in the upper portion of respective lines are upper dimensional tolerance, while values shown in the lower portion of respective lines are lower dimensional tolerance.

Units : μm

Class of Geometrical Tolerance Zone of Holes																	
H8	**H9**	**H10**	**JS6**	**JS7**	**K6**	**K7**	**M6**	**M7**	**N6**	**N7**	**P6**	**P7**	**R7**	**S7**	**T7**	**U7**	**X7**
+14 0	+25 0	+40 0	±3	±5	0 −6	0 −10	−2 −8	−2 −12	−4 −10	−4 −14	−6 −12	−6 −16	−10 −20	−14 −24	—	−18 −28	−20 −30
+18 0	+30 0	+48 0	±4	±6	+2 −6	+3 −9	−1 −9	0 −12	−5 −13	−4 −16	−9 −17	−8 −20	−11 −23	−15 −27	—	−19 −31	−24 −36
+22 0	+36 0	+58 0	±4.5	±7	+2 −7	+5 −10	−3 −12	0 −15	−7 −16	−4 −19	−12 −21	−9 −24	−13 −28	−17 −32	—	−22 −37	−28 −43
+27 0	+43 0	+70 0	±5.5	±9	+2 −9	+6 −12	−4 −15	0 −18	−9 −20	−5 −23	−15 −26	−11 −29	−16 −34	−21 −39	—	−26 −44	−33 −51 −38 −56
+33 0	+52 0	+84 0	±6.5	±10	+2 −11	+6 −15	−4 −17	0 −21	−11 −24	−7 −28	−18 −31	−14 −35	−20 −41	−27 −48	— −33 −54	−33 −54 −40 −61	−46 −67 −56 −77
+39 0	+62 0	+100 0	±8	±12	+3 −13	+7 −18	−4 −20	0 −25	−12 −28	−8 −33	−21 −37	−17 −42	−25 −50	−34 −59	−39 −64 −45 −70	−51 −76 −61 −86	—
+46 0	+74 0	+120 0	±9.5	±15	+4 −15	+9 −21	−5 −24	0 −30	−14 −33	−9 −39	−26 −45	−21 −51	−30 −60 −32 −62	−42 −72 −48 −78	−55 −85 −64 −94	−76 −106 −91 −121	—
+54 0	+87 0	+140 0	±11	±17	+4 −18	+10 −25	−6 −28	0 −35	−16 −38	−10 −45	−30 −52	−24 −59	−38 −73 −41 −76	−58 −93 −66 −101	−78 −113 −91 −126	−111 −146 −131 −166	—
+63 0	+100 0	+160 0	±12.5	±20	+4 −21	+12 −28	−8 −33	0 −40	−20 −45	−12 −52	−36 −61	−28 −68	−48 −88 −50 −90 −53 −93	−77 −117 −85 −125 −93 −133	−107 −147 −119 −159 −131 −171	—	—
+72 0	+115 0	+185 0	±14.5	±23	+5 −24	+13 −33	−8 −37	0 −46	−22 −51	−14 −60	−41 −70	−33 −79	−60 −106 −63 −109 −67 −113	−105 −151 −113 −159 −123 −169	—	—	—
+81 0	+130 0	+210 0	±16	±26	+5 −27	+16 −36	−9 −41	0 −52	−25 −57	−14 −66	−47 −79	−36 −88	−74 −126 −78 −130	—	—	—	—
+89 0	+140 0	+230 0	±18	±28	+7 −29	+17 −40	−10 −46	0 −57	−26 −62	−16 −73	−51 −87	−41 −98	−87 −144 −93 −150	—	—	—	—
+97 0	+155 0	+250 0	±20	±31	+8 −32	+18 −45	−10 −50	0 −63	−27 −67	−17 −80	−55 −95	−45 −108	−103 −166 −109 −172	—	—	—	—

JIS FIT TOLERANCE TABLE (SHAFTS)

Classification of Standard Dimensions (mm)		Class of Geometrical Tolerance Zone of Shafts														
>	≤	b9	c9	d8	d9	e7	e8	e9	f6	f7	f8	g5	g6	h5	h6	h7
–	3	−140 −165	−60 −85	−20 −34	−20 −45	−14 −24	−14 −28	−14 −39	−6 −12	−6 −16	−6 −20	−2 −6	−2 −8	0 −4	0 −6	0 −10
3	6	−140 −170	−70 −100	−30 −48	−30 −60	−20 −32	−20 −38	−20 −50	−10 −18	−10 −22	−10 −28	−4 −9	−4 −12	0 −5	0 −8	0 −12
6	10	−150 −186	−80 −116	−40 −62	−40 −76	−25 −40	−25 −47	−25 −61	−13 −22	−13 −28	−13 −35	−5 −11	−5 −14	0 −6	0 −9	0 −15
10	14	−150 −193	−95 −138	−50 −77	−50 −93	−32 −50	−32 −59	−32 −75	−16 −27	−16 −34	−16 −43	−6 −14	−6 −17	0 −8	0 −11	0 −18
14	18															
18	24	−160 −212	−110 −162	−65 −98	−65 −117	−40 −61	−40 −73	−40 −92	−20 −33	−20 −41	−20 −53	−7 −16	−7 −20	0 −9	0 −13	0 −21
24	30															
30	40	−170 −232	−120 −182	−80 −119	−80 −142	−50 −75	−50 −89	−50 −112	−25 −41	−25 −50	−25 −64	−9 −20	−9 −25	0 −11	0 −16	0 −25
40	50	−180 −242	−130 −192													
50	65	−190 −264	−140 −214	−100 −146	−100 −174	−60 −90	−60 −106	−60 −134	−30 −49	−30 −60	−30 −76	−10 −23	−10 −29	0 −13	0 −19	0 −30
65	80	−200 −274	−150 −224													
80	100	−220 −307	−170 −257	−120 −174	−120 −207	−72 −107	−72 −126	−72 −159	−36 −58	−36 −71	−36 −90	−12 −27	−12 −34	0 −15	0 −22	0 −35
100	120	−240 −327	−180 −267													
120	140	−260 −360	−200 −300	−145 −208	−145 −245	−85 −125	−85 −148	−85 −185	−43 −68	−43 −83	−43 −106	−14 −32	−14 −39	0 −18	0 −25	0 −40
140	160	−280 −380	−210 −310													
160	180	−310 −410	−230 −330													
180	200	−340 −455	−240 −355	−170 −242	−170 −285	−100 −146	−100 −172	−100 −215	−50 −79	−50 −96	−50 −122	−15 −35	−15 −44	0 −20	0 −29	0 −46
200	225	−380 −495	−260 −375													
225	250	−420 −535	−280 −395													
250	280	−480 −610	−300 −430	−190 −271	−190 −320	−110 −162	−110 −191	−110 −240	−56 −88	−56 −108	−56 −137	−17 −40	−17 −49	0 −23	0 −32	0 −52
280	315	−540 −670	−330 −460													
315	355	−600 −740	−360 −500	−210 −299	−210 −350	−125 −182	−125 −214	−125 −265	−62 −98	−62 −119	−62 −151	−18 −43	−18 −54	0 −25	0 −36	0 −57
355	400	−680 −820	−400 −540													
400	450	−760 −915	−440 −595	−230 −327	−230 −385	−135 −198	−135 −232	−135 −290	−68 −108	−68 −131	−68 −165	−20 −47	−20 −60	0 −27	0 −40	0 −63
450	500	−840 −995	−480 −635													

Note) Values shown in the upper portion of respective lines are upper dimensional tolerance, while values shown in the lower portion of respective lines are lower dimensional tolerance.

Units : μm

Class of Geometrical Tolerance Zone of Shafts															
h8	**h9**	**js5**	**js6**	**js7**	**k5**	**k6**	**m5**	**m6**	**n6**	**p6**	**r6**	**s6**	**t6**	**u6**	**x6**
0 −14	0 −25	±2	±3	±5	+4 0	+6 0	+6 +2	+8 +2	+10 +4	+12 +6	+16 +10	+20 +14	—	+24 +18	+26 +20
0 −18	0 −30	±2.5	±4	±6	+6 +1	+9 +1	+9 +4	+12 +4	+16 +8	+20 +12	+23 +15	+27 +19	—	+31 +23	+36 +28
0 −22	0 −36	±3	±4.5	±7	+7 +1	+10 +1	+12 +6	+15 +6	+19 +10	+24 +15	+28 +19	+32 +23	—	+37 +28	+43 +34
0 −27	0 −43	±4	±5.5	±9	+9 +1	+12 +1	+15 +7	+18 +7	+23 +12	+29 +18	+34 +23	+39 +28	—	+44 +33	+51 +40 +56 +45
0 −33	0 −52	±4.5	±6.5	±10	+11 +2	+15 +2	+17 +8	+21 +8	+28 +15	+35 +22	+41 +28	+48 +35	— +54 +41	+54 +41 +61 +48	+67 +54 +77 +64
0 −39	0 −62	±5.5	±8	±12	+13 +2	+18 +2	+20 +9	+25 +9	+33 +17	+42 +26	+50 +34	+59 +43	+64 +48 +70 +54	+76 +60 +86 +70	—
0 −46	0 −74	±6.5	±9.5	±15	+15 +2	+21 +2	+24 +11	+30 +11	+39 +20	+51 +32	+60 +41 +62 +43	+72 +53 +78 +59	+85 +66 +94 +75	+106 +87 +121 +102	—
0 −54	0 −87	±7.5	±11	±17	+18 +3	+25 +3	+28 +13	+35 +13	+45 +23	+59 +37	+73 +51 +76 +54	+93 +71 +101 +79	+113 +91 +126 +104	+146 +124 +166 +144	—
0 −63	0 −100	±9	±12.5	±20	+21 +3	+28 +3	+33 +15	+40 +15	+52 +27	+68 +43	+88 +63 +90 +65 +93 +68	+117 +92 +125 +100 +133 +108	+147 +122 +159 +134 +171 +146	—	—
0 −72	0 −115	±10	±14.5	±23	+24 +4	+33 +4	+37 +17	+46 +17	+60 +31	+79 +50	+106 +77 +109 +80 +113 +84	+151 +122 +159 +130 +169 +140	—	—	—
0 −81	0 −130	±11.5	±16	±26	+27 +4	+36 +4	+43 +20	+52 +20	+66 +34	+88 +56	+126 +94 +130 +98	—	—	—	—
0 −89	0 −140	±12.5	±18	±28	+29 +4	+40 +4	+46 +21	+57 +21	+73 +37	+98 +62	+144 +108 +150 +114	—	—	—	—
0 −97	0 −155	±13.5	±20	±31	+32 +5	+45 +5	+50 +23	+63 +23	+80 +40	+108 +68	+166 +126 +172 +132	—	—	—	—

TAPER STANDARD

Fig.1
Bolt Grip Taper

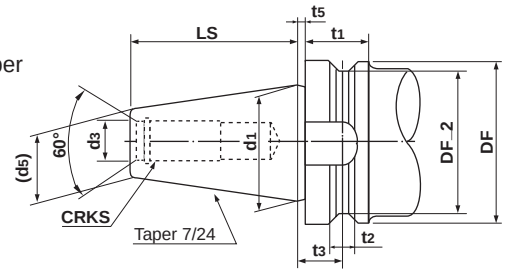
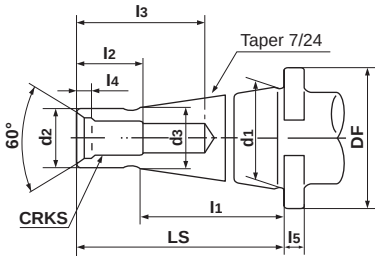


Fig.2
National Taper



●Table 1 Bolt Grip Taper (Fig.1)

Bearing Number	DF	DF_2	t_1	t_2	t_3	t_5	d_1	d_3	LS	CRKS	d_5
BT35	53	43	20	10	13.0	2	38.1	13	56.5	M12×1.75	21.62
BT40	63	53	25	10	16.6	2	44.45	17	65.4	M16×2	25.3
BT45	85	73	30	12	21.2	3	57.15	21	82.8	M20×25	33.1
BT50	100	85	35	15	23.2	3	69.85	25	101.8	M24×3	40.1
BT60	155	135	45	20	28.2	3	107.95	31	161.8	M30×3.5	60.7

●Table 2 National Taper (Fig.2)

Bearing Number	d_1	d_2	LS	l_1	CRKS		l_2	l_3	d_3	l_4	DF	l_5
					Metric Screw	Wit Screw						
NT30	31.75	17.4	70	50	M12	W 1/2	24	50	16.5	6	50	8
NT40	44.45	25.3	95	67	M16	W 5/8	30	70	24	7	63	10
NT50	69.85	39.6	130	105	M24	W 1	45	90	38	11	100	13
NT60	107.95	60.2	210	165	M30	W 1¹/4	56	110	58	12	170	15

Fig.3
Morse Taper
(Shank with Tongue)

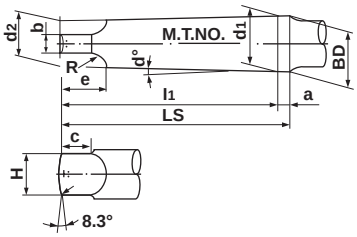
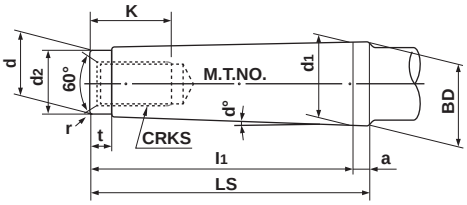


Fig.4
Morse Taper
(Shank with Screw)



●Table 3 Shank with Tongue (Fig.3)

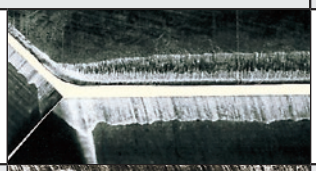
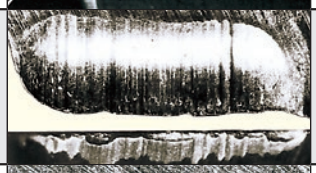
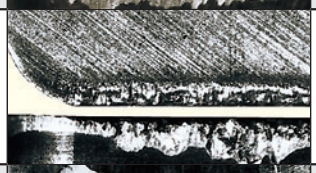
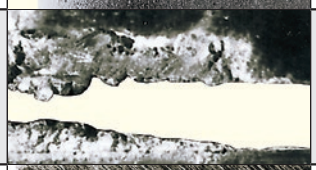
Morse Taper Number	d_1	a	BD	d_2	H	l_1	LS	d	c	e	R	r
0	9.045	3	9.201	6.104	6	56.5	59.5	3.9	6.5	10.5	4	1
1	12.065	3.5	12.240	8.972	8.7	62.0	65.5	5.2	8.5	13.5	5	1.2
2	17.780	5	18.030	14.034	13.5	75.0	80.0	6.3	10	16	6	1.6
3	23.825	5	24.076	19.107	18.5	94.0	99	7.9	13	20	7	2
4	31.267	6.5	31.605	25.164	24.5	117.5	124	11.9	16	24	8	2.5
5	44.399	6.5	44.741	36.531	35.7	149.5	156	15.9	19	29	10	3
6	63.348	8	63.765	52.399	51.0	210.0	218	19	27	40	13	4
7	83.058	10	83.578	68.185	66.8	286.0	296	28.6	35	54	19	5

●Table 4 Shank with Screw (Fig.4)

Morse Taper Number	d_1	a	BD	d	d_2	l_1	LS	t	r	CRKS	K
0	9.045	3	9.201	6.442	6	50	53	4	0.2	—	—
1	12.065	3.5	12.240	9.396	9	53.5	57	5	0.2	M6	16
2	17.780	5	18.030	14.583	14	64	69	5	0.2	M10	24
3	23.825	5	24.076	19.759	19	81	86	7	0.6	M12	28
4	31.267	6.5	31.605	25.943	25	102.5	109	9	1.0	M16	32
5	44.399	6.5	44.741	37.584	35.7	129.5	136	9	2.5	M20	40
6	63.348	8	63.765	53.859	51	182	190	12	4.0	M24	50
7	83.058	10	83.578	70.052	65	250	260	18.5	5.0	M33	80

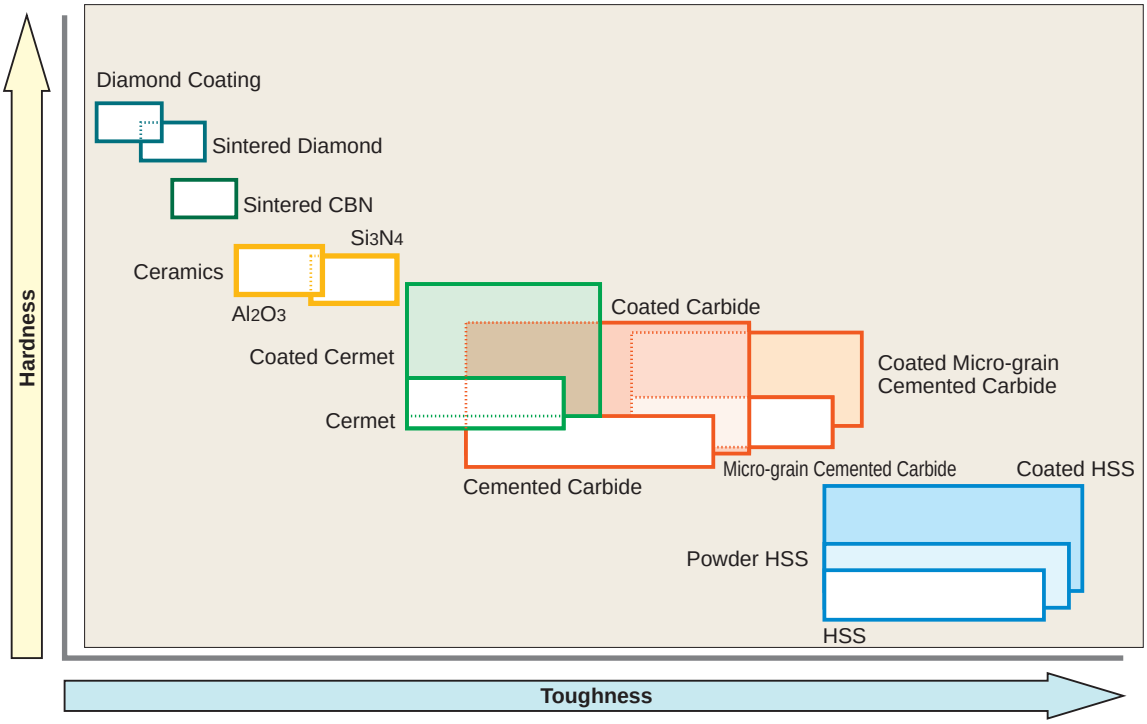
TOOL WEAR AND DAMAGE

CAUSES AND COUNTERMEASURES

Tool Damage Form		Cause	Countermeasure
Flank Wear		• Tool grade is too soft. • Cutting speed is too high. • Flank angle is too small. • Feed rate is extremely low.	• Tool grade with high wear resistance. • Lower cutting speed. • Increase flank angle. • Increase feed rate.
Crater Wear		• Tool grade is too soft. • Cutting speed is too high. • Feed rate is too high.	• Tool grade with high wear resistance. • Lower cutting speed. • Lower feed rate.
Chipping		• Tool grade is too hard. • Feed rate is too high. • Lack of cutting edge strength. • Lack of shank or holder rigidity.	• Tool grade with high toughness. • Lower feed rate. • Increase honing. (Round honing is to be changed to chamfer honing.) • Use large shank size.
Fracture		• Tool grade is too hard. • Feed rate is too high. • Lack of cutting edge strength. • Lack of shank or holder rigidity.	• Tool grade with high toughness. • Lower feed rate. • Increase honing. (Round honing is to be changed to chamfer honing.) • Use large shank size.
Plastic Deformation		• Tool grade is too soft. • Cutting speed is too high. • Depth of cut and feed rate are too large. • Cutting temperature is high.	• Tool grade with high wear resistance. • Lower cutting speed. • Decrease depth of cut and feed rate. • Tool grade with high thermal conductivity.
Welding		• Cutting speed is low. • Poor sharpness. • Unsuitable grade.	• Increase cutting speed. (For JIS S45C, cutting speed 80m/min.) • Increase rake angle. • Tool grade with low affinity. (Coated grade, cermet grade)
Thermal Cracks		• Expansion or shrinkage due to cutting heat. • Tool grade is too hard. *Especially in milling.	• Dry cutting. (For wet cutting, flood workpiece with cutting fluid) • Tool grade with high toughness.
Notching		• Hard surfaces such as uncut surfaces, chilled parts and machining hardened layer. • Friction caused by jagged shape chips. (Caused by small vibration)	• Tool grade with high wear resistance. • Increase rake angle to improve sharpness.
Flaking		• Cutting edge welding and adhesion. • Poor chip disposal.	• Increase rake angle to improve sharpness. • Enlarge chip pocket.
Flank Wear Fracture *Damage for polycrystallines		• Damage due to the lack of strength of a curved cutting edge.	• Increase honing. • Tool grade with high toughness.
Crater Wear Fracture *Damage for polycrystallines		• Tool grade is too soft. • Cutting resistance is too high and causes high cutting heat.	• Decrease honing. • Tool grade with high wear resistance.

CUTTING TOOL MATERIALS

The table below shows the relationship between various tool materials, in relation with hardness on a vertical axis and toughness on a horizontal axis. Today, cemented carbide, coated carbide and TiC-TiN-based cermet are key tool materials in the market. This is because they have the best balance of hardness and toughness.



GRADE CHARACTERISTICS

Hard Materials	Hardness (HV)	Energy Formation (kcal/g·atom)	Solubility in Iron (%.1250℃)	Thermal Conductivity (W/m·k)	Thermal Expansion (x 10^{-6}/k)*	Tool Material
Diamond	>9000	–	Highly Soluble	2100	3.1	Sintered Diamond
CBN	>4500	–	–	1300	4.7	Sintered CBN
Si_3N_4	1600	–	–	100	3.4	Ceramics
Al_2O_3	2100	-100	≒0	29	7.8	Ceramics Cemented Carbide
TiC	3200	-35	< 0.5	21	7.4	Cermet Coated Carbide
TiN	2500	-50	–	29	9.4	Cermet Coated Carbide
TaC	1800	-40	0.5	21	6.3	Cemented Carbide
WC	2100	-10	7	121	5.2	Cemented Carbide

*1W/m•K=2.39×10^{-3}cal/cm•sec•℃

GRADE CHAIN

For Cutting Tools

- **Cemented Carbide**
  - P Steel: UTi20T
  - M Stainless Steel General: UTi20T
  - K Cast Iron: HTi05T, HTi10, UTi20T
  - N Non-Ferrous: HTi10, TF15
  - S Heat Resistant Alloy Ti Alloy: RT9010, MT9005, MT9015, TF15
- **Coated Carbide**
  - P Steel: UE6105, UE6110, MC6015, MS6015 (PVD), UE6020, MP6120 (PVD), MC6025, MC6035, UH6400
    - FH7020, VP15TF (PVD), MP6130 (PVD), VP10RT (PVD), VP20RT (PVD), VP30RT (PVD), VP20MF (PVD), UP20M (PVD)
  - M Stainless Steel General: MC7015, US7020, MC7020, MC7025, F7030, VP15TF (PVD), VP20RT Add information., MP7030 Add information.
    - MP7130 (PVD), MP7035 (PVD), US735, MP7140 (PVD), VP10RT (PVD), VP30RT (PVD), VP20MF (PVD), UP20M (PVD)
  - K Cast Iron: UC5105, MC5005, UC5115, NEW MH515, MC5015, MY5015, MC5020, VP15TF (PVD), VP10RT (PVD), VP20RT (PVD)
  - N Non-Ferrous: LC15TF
  - S Heat Resistant Alloy Ti Alloy: US905, MP9005 (PVD), VP05RT (PVD), VP10RT (PVD), VP20RT (PVD), MP9015 (PVD), NEW MP9025 (PVD), VP15TF (PVD), MP9120 (PVD), MP9030 (PVD), MP9130 (PVD), NEW MP9140 (PVD)
  - H Hardened Materials: MP8010 (PVD), VP15TF (PVD)
- **Cermet**
  - P Steel: NX2525, NEW MX3020, MX3030, NX3035, NX4545
  - M Stainless Steel General: NX2525, NEW MX3020, MX3030, NX4545
  - K Cast Iron: NX2525, NEW MX3020, MX3030
- **Coated Cermet**
  - P Steel: AP25N (PVD), VP25N (PVD), MP3025 (PVD), VP45N (PVD)
  - M Stainless Steel General: AP25N (PVD), VP25N (PVD)
  - K Cast Iron: AP25N (PVD), VP25N (PVD)
- **Polycrystallines**
  - N Non-Ferrous Non-Metal (Sintered Diamond): MD205, MD220, MD230, MD2030
  - Sintered Alloy: MB4020, NEW MB4120, MB835
  - K Cast Iron (Sintered CBN): MB710, MB730, MBS140, BC5030, MB4020, NEW MB4120
  - H Hardened Materials (Sintered CBN): BC8105, NEW MB8110, MBC010, BC8110, MB8120, MBC020, NEW BC8120, BC8020, MB8025, MB825, NEW MB8130, BC8130, MB835
- **Micro-grain Cemented Carbide**
  - Steel Cast Iron: SF10, MF07, MF10, TF15, MF20, MF30

For Wear Resistance

- **Cemented Carbide**
  - General Wear Resistance: GTi05, GTi10, GTi15, GTi20, GTi30, GTi35, GTi40, GTi50
  - Corrosion Resistance: GC15, GC20, GC30
- **Micro-grain Cemented Carbide**
  - Special Wear Resistance: TF15, MF10, MF20S, GM30

For Construction Tools

- **Cemented Carbide**
  - General Use: MG10, MG20, MG25, MG30, MG40, MG50, MG60

GRADES COMPARISON TABLE

CEMENTED CARBIDE

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Iscar
Turning	P	P01										
		P10		ST10P	TX10S		SRT	WS10				IC70
		P20	UTi20T	ST20E	UX30		SRT DX30	EX35	SMA			IC70 IC50M
		P30	UTi20T	A30 A30N	UX30	PW30	SR30 DX30	EX35 EX40	SM30			IC50M IC54
		P40		ST40E			SR30	EX45				IC54
	M	M10		EH510 U10E			UMN	WA10B	H10A	KU10 K313 K68	890	IC07
		M20	UTi20T	EH520 U2	UX30		DX25 UMS	EX35	H13A	KU10 K313 K68	HX	IC07 IC08 IC20
		M30	UTi20T	A30 A30N	UX30		DX25 UMS	EX45	H10F SM30		883	IC08 IC20 IC28
		M40					UM40	EX45				IC28
	K	K01	HTi05T	H1 H2	TH03 KS05F		KG03	WH05		KU10 K313 K68		
		K10	HTi10	EH10 EH510	TH10	KW10 GW15	KG10 KT9	WH10	H10 HM	KU10 K313 K68	890	IC20
		K20	UTi20T	G10E EH20 EH520	KS15F KS20	GW25	CR1 KG20	WH20	H13A	KU10 K313 K68	HX	IC20
		K30	UTi20T	G10E			KG30				883	
	N	N01		H1 H2	KS05F	KW10			H10 H13A			
		N10	HTi10	EH10 EH510	TH10	KW10 GW15	KT9	WH10		KU10 K313 K68	H15	IC08 IC20
		N20		G10E EH20 EH520	KS15F		CR1	WH20		KU10 K313 K68	HX KX	IC08 IC20
		N30									H25	
	S	S01	MT9005			SW05	KG03					
		S10	MT9005 RT9010 MT9015	EH10 EH510	KS05F TH10	SW10	FZ05 KG10	WH13S	H10 H10A H10F H13A	K10 K313 K68	HX	IC07 IC08
		S20	RT9010 TF15	EH20 EH520	KS15F KS20	SW25	FZ15 KG20			K10 K313 K68	H25	IC07 IC08
		S30	TF15				KG30					
Milling	P	P10					SRT					
		P20	UTi20T	A30N	UX30		SRT DX30	EX35		K125M		IC50M IC28
		P30	UTi20T	A30N	UX30	PW30	SR30 DX30	EX35		GX		IC50M IC28
		P40				PW30	SR30	EX45				IC28
	M	M10					UMN					
		M20	UTi20T	A30N	UX30		DX25 UMS	EX35				IC08 IC20
		M30	UTi20T	A30N	UX30		DX25 UMS	EX45	SM30			IC08 IC28
		M40						EX45				IC28
	K	K01	HTi05T				KG03			K115M,K313		
		K10	HTi10	G10E	TH10	KW10 GW25	KG10	WH10		K115M K313		IC20
		K20	UTi20T	G10E	KS20	GW25	KT9 CR1 KG20	WH20	H13A		HX	IC20
		K30	UTi20T				KG30					

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

MICRO GRAIN

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools
Cutting Tools	Z	Z01	**SF10** **MF07** **MF10**	F0	F MD05F MD1508		FZ05 FB05 FB10	NM08	PN90 6UF,H3F 8UF,H6F		
		Z10	**HTi10** **MF20**	XF1 F1 AFU	MD10 MD0508 MD07F	FW30	FZ10 FZ15 FB15	NM10 NM12 NM15	H10F		890
		Z20	**TF15** **MF30**	AF0 SF2 AF1	EM10 MD20 G1F		FZ15 FB15 FB20	BRM20 EF20N	H15F		890 883
		Z30		A1 CC			FZ20 FB20	NM25 NM40			883

CERMET

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Iscar
Turning	P	P01	**AP25N*** **VP25N***	T110A T1000A	NS520 AT520* GT520* GT720*	TN30 TN610 PV710* PV30* TN6010 PV7010*	LN10 CX50					IC20N IC520N*
		P10	**NX2525** **AP25N*** **VP25N***	T1200A T2000Z* T1500A T1500Z*	NS520 NS730 GT730* NS9530 GT9530* AT9530*	TN60 TN610 PV710* PV60* TN6010 PV7010*	CX50 CX75 PX75*	CZ25*	CT5015 GC1525*	KT315 KT125	TP1020 TP1030* CM CMP*	IC20N IC520N* IC530N*
		P20	**NX2525** **AP25N*** **VP25N*** **NX3035** **MP3025***	T1200A T2500A T2000Z* T3000Z* T1500A T1500Z*	NS530 NS730 GT730* NS9530 GT9530* AT9530*	TN60 PV60* TN620 PV720* TN6020 PV7020* PV7025*	CX75 PX75* PX90*	CH550	GC1525*	KT325 KT1120 KT5020*	TP1020 TP1030*	IC20N IC520N* IC30N IC530N* IC75T
		P30	**MP3025*** **VP45N***	T3000Z*		PV7025* PV90*	PX90*					IC75T
	M	M10	**NX2525** **AP25N*** **VP25N***	T110A T1000A T2000Z* T1500Z*	NS520 AT530* GT530* GT720*	TN60 PV60* TN620 PV720* TN6020 PV7020*	LN10 CX50		GC1525*	KT125	TP1020 TP1030* CM CMP*	
		M20	**NX2525** **AP25N*** **VP25N***	T1200A T2000Z* T1500A T1500Z*	NS530 GT730* NS730	TN90 TN6020 TN620 PV720* PV90* PV7020* PV7025*	CX50 CX75	CH550				
		M30										
	K	K01	**NX2525** **AP25N***	T110A T1000A T2000Z* T1500Z*	NS710 NS520 AT520* GT520* GT720*	TN30 PV30* PV7005* TN610 PV710* TN6010 PV7010*	LN10					
		K10	**NX2525** **AP25N***	T1200A T2000Z* T1500A T1500Z*	NS520 GT730* NS730	TN60 PV60* TN6020 TN620 PV720* PV7020* PV7025*	LN10		CT5015	KT325 KT125		
		K20	**NX2525** **AP25N***	T3000Z*			CX75					
Milling	P	P10	**NX2525**			TN620M TN60	CX75	MZ1000*			C15M	IC30N
		P20	**MX3020** **NX2525**	T250A	NS530	TN100M TN620M TN60	CX75 CX90	CH550 CH7030 MZ1000* MZ2000*	CT530	KT530M HT7 KT605M	C15M MP1020	IC30N
		P30	**MX3030** **NX4545**	T250A T4500A	NS530 NS540 NS740		CX90 CX99	MZ3000* CH7035				IC30N
	M	M10	**NX2525**			TN60 TN620M						IC30N
		M20	**MX3020** **NX2525**		NS530	TN100M TN620M	CX75	CH550 CH7030 MZ1000* MZ2000*	CT530	KT530M HT7 KT605M	C15M	IC30N
		M30	**MX3030** **NX4545**	T250A	NS540 NS740		CX90 CX99	MZ3000* CH7035				
	K	K01										
		K10	**NX2525**		NS530	TN60						
		K20	**NX2525**				CX75			KT530M HT7		

*Coated Cermet

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

GRADES COMPARISON TABLE

CVD COATED GRADE

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Iscar
Turning	P	P01	UE6105	AC810P AC700G	T9105 T9005	CA510 CA5505	JC110V	HG8010	GC4305 GC4205	KCP05B KCP05 KC9105	TP0501 TP0500 TP1501 TP1500	IC9150 IC8150 IC428
		P10	UE6105 MC6015 UE6110 MY5015	AC810P AC700G AC820P AC2000 AC8015P	T9105 T9005 T9115 T9215	CA510 CA5505 CA515 CA5515	JC110V JC215V	HG8010 HG8025 GM8020	GC4315 GC4215 GC4325	KCP10B KCP10 KCP25 KC9110	TP1501 TP1500 TP2501 TP2500	IC9150 IC8150 IC8250
		P20	MC6015 UE6110 MC6025 UE6020 MY5015	AC820P AC2000 AC8025P AC830P	T9115 T9125 T9215 T9225	CA025P CA515 CA5515 CA525 CA5525 CR9025	JC110V JC215V	HG8025 GM8020 GM25	GC4315 GC4215 GC4325 GC4225	KCP25B KCP30B KCP25 KC9125	TP2501 TP2500	IC8250 IC9250 IC8350
		P30	MC6025 UE6020 MC6035 UE6035 UH6400	AC8035P AC830P AC630M	T9125 T9135 T9035 T9225	CA025P CA525 CA5525 CA530 CA5535 CR9025	JC215V JC325V	GM25 GM8035	GC4325 GC4335 GC4225 GC4025 GC4235	KCP30B KCP30	TP3501 TP3500 TP3000	IC8350 IC9250 IC9350
		P40	MC6035 UE6035 UH6400	AC8035P AC630M	T9135 T9035	CA530 CA5535	JC325V	GM8035 GX30	GC4235 GC4335	KCP40 KCP40B KC9140 KC9240	TP3501 TP3500 TP3000	IC9350
	M	M10	MC7015 US7020	AC610M AC6020M	T6120 T9215	CA6515	JX605X JC110V		GC2015 GC2220	KCM15B KCM15	TM2000	IC6015 IC8250
		M20	MC7015 US7020 MC7025	AC6020M AC610M AC6030M AC630M	T6120 T9215	CA6515 CA6525	JC110V	HG8025 GM25	GC2015 GC2220	KCM15 KCM25B KCP40B	TM2000	IC6015
		M30	MC7025 US735	AC6030M AC630M	T6130	CA6525	JX525X	GM8035 GX30	GC2025	KCM25 KCM35B KCP40	TM4000	IC6025
		M40	US735	AC6030M AC630M			JX525X	GX30	GC2025	KCM35B KCM35	TM4000	IC6025
	K	K01	MC5005 UC5105	AC405K AC410K AC4010K	T515 T5105	CA4505 CA4010 CA310	JC050W JC105V	HX3505	GC3205 GC3210	KCK05B KCK05	TK0501 TH1500	IC5005
		K10	MC5015 MH515 UC5115 MY5015	AC405K AC4010K AC410K AC4015K AC415K	T515 T5115	CA315 CA4515 CA4010 CA4115	JC108W JC050W JC105V JC110V	HX3515 HG8010	GC3205 GC3210	KCK15B KCK15 KCK20 KC9315 KCK20B	TK0501 TK1501	IC5005 IC5010 IC428
		K20	MC5015 MH515 UC5115 UE6110 MY5015	AC4015K AC415K AC420K AC8025P	T5115 T5125	CA320 CA4515 CA4115 CA4120	JC108W JC110V JC215V	HG8025 GM8020	GC3225	KCK20B KCK20 KCPK05	TK1501	IC5010 IC8150
		K30	UE6110	AC8025P	T5125		JC215	HG8025 GM8020	GC3225	KCPK05		
	S	S01	US905			CA6515 CA6525 CA6535		HS9105 HS9115	S05F			
Milling	P	P10					JC730U				MP1500	IC9080 IC4100 IC9015
		P20	F7030 MC7020	ACP100	T3130 T3225		JC730U	GX2140	GC4220		MP1500 MP2500	IC5500 IC5100 IC520M
		P30	F7030 MC7020	ACP100	T3130 T3225			GX2140 GX2160	GC4330 GC4230	KCPK30 KC930M	MP2500	IC5500 IC4050
		P40						GX2030 GX30 GX2160	GC4340 GC4240	KC935M KC530M		
	M	M10										IC9250
		M20	F7030 MC7020	ACP100 ACM200	T3130 T3225	CA6535	JC730U	AX2040 GX2140		KC925M	MP2500 MM4500	IC520M IC9350
		M30	F7030 FC7020 MC7020	ACP100	T3130 T3225	CA6535		AX2040 GX2140 GX2160 GX30	GC2040	KC930M	MP2500 MM4500	IC9350 IC4050
		M40						GX2030 GX2160 GX30		KC930M KC935M		IC635
	K	K01					JC600					
		K10	MC5020	ACK100	T1215 T1115 T1015	CA420M	JC600					
		K20	MC5020	ACK200	T1115 T1015		JC610		GC3220 GC3330 K20W	KC915M	MK1500 MK2000	IC5100 IC9150
		K30					JC610	GX30	GC3330 GC3040	KC920M KC925M KCPK30 KC930M KC935M	MK2000 MK3000	IC4100 IC4050 IC520M

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

PVD COATED GRADE

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Iscar
Turning	P	P01				PR1005						
		P10	**VP10MF MS6015**		AH710 SH725	PR1005 PR930 PR1025 PR1115 PR1225 PR1425			GC1125	KCU10 KC5010 KC5510 KU10T	CP200 TS2000	IC250 IC507 IC570 IC807 IC907 IC908
		P20	**VP10RT VP20RT VP15TF VP20MF MS6015**	AC520U	AH710 AH725 AH120 SH730 GH730 GH130 SH725	PR930 PR1025 PR1115 PR1225 PR1425 PR1535		IP2000	GC1125 GC15	KCU10 KC5025 KC5525 KU25T	TS2500	IC1007 IC250 IC308 IC507 IC807 IC808 IC907 IC908 IC1008 IC1028 IC3028
		P30	**VP10RT VP20RT VP15TF VP20MF**	AC1030U AC530U	AH725 AH120 SH730 GH730 GH130 AH740 J740 SH725	PR1025 PR1225 PR1425 PR1535 PR1625		IP3000	GC1125	KCU25 KC5525 KU25T	CP500	IC228 IC250 IC328 IC330 IC354 IC528 IC1008 IC1028 IC3028
		P40			AH740 J740	PR1535					CP500 CP600	IC228 IC328 IC528 IC928 IC1008 IC1028 IC3028
	M	M01										
		M10	**VP10MF MS6015**		AH710 SH725	PR1025 PR1225 PR1425	JC5003 JC8015	IP050S	GC1115 GC15 GC1105	KCU10 KC5010 KC5510	CP200 TS2000	IC354 IC507 IC520 IC807 IC907 IC1007 IC5080T
		M20	**VP10RT VP20RT VP15TF VP20MF**	AC520U AC5015S	AH710 AH725 AH120 SH730 GH730 GH130 GH330 AH630 SH725	PR1025 PR1125 PR1225 PR1425 PR915 PR930 PR1535	JC5003 JC5015 JC8015 JC5118	IP100S	GC1115 GC15 GC1125	KCU10 KC5010 KC5510	TS2500 CP500	IC354 IC808 IC908 IC1008 IC1028 IC3028 IC5080T
		M30	**VP10RT VP20RT VP15TF VP20MF MP7035**	AC520U AC530U AC1030U AC6040M AC5025S	GH330 AH725 AH120 SH730 GH730 GH130 J740 AH645 SH725	PR1125 PR1425 PR1535	JC5015 JC8015 JC5118		GC1125 GC2035	KCU25 KC5525	CP500 CP600 TTP2050	IC228 IC250 IC328 IC330 IC1008 IC1028 IC9080T
		M40	**MP7035**	AC530U AC6040M	J740	PR1535	JC5118		GC2035			IC328 IC928 IC1008 IC1028 IC3028 IC9080T
	K	K01										
		K10		AC510U	GH110 AH110 AH710				GC15	KCU10 KC5010 KC5510	CP200 TS2000	IC350 IC910 IC1008
		K20	**VP10RT VP20RT VP15TF**		GH110 AH110 AH710 AH725 AH120 GH730 GH130					KCU15 KCU25	CP200 TS2000 TS2500	IC228 IC350 IC808 IC830 IC908 IC1007 IC1008
		K30	**VP10RT VP20RT VP15TF**		AH725 AH120 GH730 GH130					KCU25 KC5525	CP500	IC228 IC350 IC808 IC830 IC908 IC928 IC1007 IC1008
	S	S01	**MP9005 VP05RT**		AH905 AH8005	PR005S PR1305	JC5003 JC8015	JP9105			TH1000	IC507 IC804 IC807 IC907 IC5080T
		S10	**MP9005 MP9015 VP10RT**	AC510U AC5015S	AH905 SH730 AH110 AH8005 AH120	PR005S PR015S PR1310	JC5003 JC5015 JC8015	JP9115	GC1105 GC15	KCU10 KC5010 KC5410 KC5510	CP200 CP250 TS2000 TS2050 TS2500 TH1000	IC507 IC806 IC807 IC903 IC5080T
		S20	**MP9015 MT9015**	AC510U AC520U AC5025S	AH120 AH725 AH8015	PR015S PR1125 PR1325	JC5015 JC8015 JC5118		GC1125	KCU10 KCU25 KC5025 KC5525	TS2500 CP500	IC228 IC300 IC328 IC808 IC908 IC928 IC3028 IC806 IC9080T
		S30	**MP9025 VP15TF VP20RT**	AC1030U	AH725	PR1125 PR1535	JC5118		GC1125	KC5525	CP600	IC928 IC830
Milling	P	P01					JC8003	ATH80D ATH08M TH308 PN208 JP4105 PN15M				IC903
		P10		ACP200		PR830 PR1225	JC8003 JC8015 JC5015 JC5118	PN15M PN215 PCA12M JP4115	GC1010 GC1130	KC505M KC715M KC510M KC515M		IC250 IC350 IC808 IC810 IC900 IC903 IC908 IC910 IC950
		P20	**MP6120 VP15TF**	ACP200	AH725 AH120 GH330 AH330	PR830 PR1225 PR1230 PR1525	JC5015 JC5040 JC6235 JC8015 JC5118 JC6235 JC7560P JC8118P	CY9020 JP4120 CY150	GC1010 GC1030 GC1130 GC2030	KC522M KC525M KC527M KC610M KC620M KC635M KC715M KC720M KC730M KTPK20	F25M MP3000	IC250 IC300 IC328 IC330 IC350 IC808 IC810 IC830 IC900 IC908 IC910 IC928 IC950 IC1008

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

GRADES COMPARISON TABLE

PVD COATED GRADE

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Iscar
Milling	P	P30	**MP6120 VP15TF MP6130 VP30RT**	ACP200 ACP300	AH725 AH120 AH130 AH140 GH130 AH730 AH3035	PR1230 PR1525	JC6235 JC7560 JC8050 JC7560P JC5015 JC8118 JC5040 JC8118P JC8015 JC5118	JS4045 CY250 CY250V CY25 HC844	GC1010 GC1030 GC2030 GC1130	KC735M KC725M KC530M KC537M KCPM40	F25M MP3000 F30M MP2050	IC250 IC300 IC328 IC330 IC350 IC830 IC845 IC900 IC928 IC950 IC1008
		P40	**VP30RT**	ACP300	AH140 AH3035	PR1525	JC6235 JC7560 JC8050 JC7560P JC5040 JC8118 JC5118 JC8118P JC5118	JS4060 PTH30E PTH40H JX1060 JS4060	GC2030 GC1030 GC1130	KC735M KC537M KCPM40	F40M T60M	IC300 IC328 IC330 IC830 IC928 IC1008
	M	M01						PN08M PN208				IC907
		M10		ACM100		PR1225		PN15M PN215	GC1025 GC1030 GC1010 GC1130	KC715M KC515M		IC903
		M20	**VP15TF MP7130 MP7030 VP20RT**	ACP200	AH725 AH120 GH330 AH330 GH110	PR1025 PR1225	JC5015 JC5118 JC8015	JP4120	GC1025 GC1030 GC1040 GC2030 S30T	KC610M KC635M KC730M KC720M KC522M KC525M KCPM40 KTPK20	F25M MP3000	IC250 IC300 IC808 IC830 IC900 IC908 IC928 IC1008
		M30	**VP15TF MP7130 MP7030 VP20RT MP7140 VP30RT**	ACP200 ACP300 ACM300	AH120 AH725 AH130 AH140 GH130 AH730 GH340 AH3135 AH4035	PR830 PR1225 PR1525 PR1535	JC5015 JC7560 JC8015 JC7560P JC8050 JC8118 JC5118 JC8118P	JS4045 CY250 HC844	S30T GC1040 GC2030	KC537M KC725M KC735M KCPM40 KC530M	F30M F40M MP3000 MP2050	IC250 IC300 IC328 IC330 IC380 IC830 IC882 IC928 IC1008
		M40	**MP7140 VP30RT**	ACP300 ACM300	AH140 AH3135 AH4035	PR1525 PR1535	JC5015 JC7560 JC5118 JC7560P JC8050 JC8118 JC8118P	PTH30E PTH40H JM4160			F40M MP2050	IC250 IC300 IC328 IC330 IC882 IC1008
	K	K01	**MP8010**		AH110 GH110 AH330		JC8003	ATH80D ATH08M TH308				
		K10	**MP8010**		AH110 GH110 AH725 AH120 GH130 AH330	PR1210 PR1510	JC8015	ATH10E TH315 CY100H	GC1010	KC514M KC515M KC527M KC635M	MK2050	IC350 IC810 IC830 IC900 IC910 IC928 IC950 IC380 IC1008
		K20	**VP15TF VP20RT**	ACK300	GH130	PR1210 PR1510	JC5015 JC8015 JC6235	CY150 JP4120 CY9020 PTH13S	GC1010 GC1020	KTPK20 KC514M KC610M KC520M KC620M KC524M	MK2000 MK2050	IC350 IC808 IC810 IC830 IC900 IC908 IC910 IC928 IC950 IC1008
		K30	**VP15TF VP20RT**	ACK300			JC6235 JC5015 JC8015 JC8118 JC8118P	CY250 JS4045	GC1020	KC522M KC725M KC524M KC735M KC537M	MK2050	IC350 IC808 IC830 IC908 IC928 IC950 IC1008
	S	S01				PR1210	JC8003 JC8015 JC5118	PN08M PN208				IC907 IC908 IC808 IC903
		S10	**MP9120 VP15TF**	EH520Z EH20Z ACM100		PR1210	JC8003 JC5015 JC8015 JC5118	JS1025 JP4120	GC1130 GC1010 GC1030 GC2030	KC510M	MS2050	IC903 IC907 IC908 IC840 IC910 IC808
		S20	**MP9120 VP15TF MP9130 MP9030**	EH520Z EH20Z ACK300 ACP300		PR1535	JC8015 JC5015 JC8050 JC5118	PTH30H	S30T GC2030 GC1030 GC1130	KC522M KC525M KCSM30 KCPM40	MS2050 MP2050	IC300 IC908 IC808 IC900 IC830 IC928 IC328 IC330 IC840 IC882 IC380
		S30		ACP300 ACM300	AH3135	PR1535	JC8050 JC7560 JC5118	JM4160	GC2030 GC1040	KC725M KCPM40	MS2050 F40M KCSM40	IC830 IC882 IC928
	H	H01	**MP8010 VP05HT**				JC8003 DH103 JC8008 DH102					IC903
		H10	**VP15TF VP10H**				JC8003 JC8008 JC8015 JC5118 JC8118P	JP4105 TH303 TH308 PTH08M ATH08M ATH80D	GC1130 GC1010 GC1030	KC505M KC510M	MH1000 F15M	IC900 IC808 IC907 IC905
		H20	**VP15TF**		AH3135		JC8015 JC5118 JC8118P	JP4115 TH315	GC1030 GC1130		F15M	IC900 IC808 IC908 IC380 IC1008
		H30			AH3135			JP4120			MP3000 F30M	IC380 IC900 IC1008

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

CBN

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Sandvik	Seco Tools
Turning	H	H01	BC8105 BC8110 MBC010 MB8110	BNC100 BNX10 BN1000	BXM10 BX310	KBN050M KBN10M KBN510			CBN060K
		H10	BC8110 MBC020 BC8120 MB8025 MB8110 MB8120	BNC160 BNX20 BN2000	BXM20 BX330	KBN25M KBN525	JBN300	CB7015	CBN010
		H20	MBC020 BC8120 MB8025 MB8120	BNC200 BNX25 BN250	BXM20 BX360	KBN30M	JBN245	CB7025 CB20	CBN150 CBN160C
		H30	BC8130 MB8130	BNC300 BN350	BXC50 BX380	KBN35M		CB7525	CBN150 CBN160C
	S	S01	MB730	BN700 BN7000	BX950				CBN170
		S10							
		S20							
		S30							
	K	K01	MB710 MB5015	BN500 BNC500	BX930 BX910				
		K10	MB730 MB4020 MB4120	BN700 BN7500 BN7000	BX850	KBN60M	JBN795	CB7525	
		K20	MB730 MB4020 MB4120	BN700 BN7000	BX950	KBN60M	JBN500		CBN200
		K30	BC5030 MBS140	BNS800	BX90S BXC90	KBN900		CB7925	CBN300 CBN400C CBN500
	Sintered Alloy		MB4020 MB835 MB4120	BN7500 BN7000	BX450 BX470 BX480	KBN65B KBN570 KBN65M KBN70M			CBN200

PCD

	ISO Classification	ISO Symbol	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Sandvik	Seco Tools
Turning	N	N01	MD205	DA90	DX180 DX160	KPD230	JDA30 JDA735	CD05	PCD05
		N10	MD220	DA150	DX140	KPD010		CD10	PCD10
		N20	MD220	DA2200	DX120		JDA715		PCD20
		N30	MD230 MD2030	DA1000	DX110	KPD001	JDA10		PCD30 PCD30M

Note 1) The above table is selected from a publication. We have not obtained approval from each company.

INSERT CHIP BREAKER COMPARISON TABLE

NEGATIVE INSERT TYPE

ISO Classification	Cutting Mode	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Walter	TaeguTec
P	Finish	PK* FH, FP FY, FS	FA, FB FL	01* TF, 11 ZF	DP* GP, PP, VF XP, XP-T, XF		FE	QF LC	FF	FF1, FF2	FP5	FA FX
	Light	LP C SA, SH	SU LU, FE SX, SE	NS, 27 TSF, AS, TQ	PQ HQ, CQ	PF UR, UA, UT	BE B, BH, CE	XF PF	LF, FN	MF2	MP3, FV5 NF3, NF4	FM FG
	Light (Mild Steel)	SY		17	XQ, XS							FC
	Light (With Wiper)	SW	LUW, SEW	FW, SW AFW, ASW	WF WP, WQ			WL, WF	FW	W-MF2	NF	WS
	Medium	MP MA MH	GU UG GE, UX	NM, ZM TM, AM DM, 33, 37, 38	PG, CJ, GS PS, HS PT	PG UB	CT, AB AH AY, AE	PM QM, XM	P MN	MF3 MF5, M3 M5	MP5, MV5	PC, MP, FT MT SM
	Medium (With Wiper)	MW	GUW		WE			WMX, WM	MW, RW	W-M6, W-M3 W-MF5	NM	WT
	Rough	RP GH Std.	MU, MX, ME UZ	TH, THS Std.	PH GT Std.	UD GG	RE Y	PR, HM XMR Std.	RN, RP	MR6, MR7 M5	RP5, RP7 PV5 NM6, NM9	RT Std.
	Heavy	HZ HL, HM, HX HV	MP HG, HP HU, HW, HF	TRS TU TUS	PX	UC	TE, UE, HX HE, H	QR, PR HR, MR	MR RM RH	R4, R5, R6 R57, RR6, R7 R8, RR9	NR6, NRF NRR	RX, RH HD, HY, HT HZ, EH
M	Finish Light	SH, LM	SU, EF	SS	MQ, GU		MP, AB, BH	MF	FP LF*	MF1	NF4, FM5	SF
	Medium	MS, GM MM, MA ES	EX, EG, UP GU HM	SA, SF SM S	MS, MU SU, HU, TK ST	SF, SZ SG	PV, DE, SE AH	MM QM, XM K	MP	MF4	MM5, RM5 NM4	ML EM, MM VF
	Heavy	GH, RM HL, HZ	EM, MU MP	TH, SH			AE	MR MR	UP, RP	M5, MR7 RR6	NR4, NR5	
K	Finish Light	LK, MA		CF	KQ		VA, AH	KF	FN	MF2, MF5 M3, M4	MK5	
	Medium	MK, GK Std.	UZ, GZ, UX	CM Std.	KG, Std., C	PG	V, AE	KM	RP,UN	M5	RK5, NM5	MC
	Rough	RK			KH, GC	GG	RE	KR, KRR			RK7	KT
	Heavy	Flat Top	Flat Top	CH, Flat Top	ZS, Flat Top	Flat Top	Flat Top		Flat Top	MR3, MR4, MR7 Flat Top	Flat Top	
S	Finish	FJ*	EF		MQ			SF	FS, LF*	MF1		
	Light	LS,MJ,MJ*	SU*	HRF				SGF*	MS	MF4, MF5	NF4, NFT MS3	EA
	Medium	MS	EG, EX, UP	HRM SA, HMM	SQ MS, MU, TK		VI	NGP*, SM	UP, P, NGP*	M1	NMS, NMT	
	Heavy	RS, GJ	MU		SG, SX			SR, SMR	RP	MR3 MR4	NRS, NRT	ET

*Peripheral ground type insert.

Note 1) Above charts are based on published data and not authorized by each manufacturer.

7°POSITIVE INSERT TYPE

ISO Classifi-cation	Cutting Mode	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Walter	TaeguTec
P	Finish	SMG*	FC*, SC*	JS*, 01*	CF*,CK* GQ*,GF* SK*			UM*	LF*			SA*
	Finish Light	FP, FV LP, SV	FP, LU SU	PF, PSF PS, PSS	GP, PP, VF XP		JQ	PF, UF, XF	UF, 11 LF, FP	FF1 F1	PF4, FP4	FA, FX FG
	Light (With Wiper)	SW	LUW, SDW		WP			WF	FW	W-F1	PF2*, PF PF5*	
	Medium	MV MP, Std.	MU	23 PM, 24	HQ, MF* XQ, GK	FT	JE	XM, PM UM PR, XR	MF, MP	F2, MF2, M5	FP6, PS5 PM5	PC MT
	Medium (With Wiper)	MW						WM	MW	W-F2 W-M3	PM	WT
M	Finish | Light	FM LM	FC*,SI* LU SU	PF, PSF PS, PSS	CF*,CK* GQ*,GF* MQ ,SK		MP	MF	LF, UF FP	F1, F2	FM4	
	Medium	MM Std.	MU	PM	HQ, GK			MM	MP		MM4, RM4	
K	Medium	MK, Std. Flat Top	MU, Flat Top*	Flat Top, CM	Flat Top*			KF, KM, KR	Flat Top	F1, M3, M5	FK6	
N	Medium	AZ*	AG*	AL*	AP* AH*	ASF*,ALU* ACB*		AL*	HP*	AL*	FM2*, PM2* MN2*	FL*
S	Finish Light	FS*, LS* FS-P*, LS-P* FJ* LS, MS	SI*	Std.	MQ				LF* HP*			

*Peripheral ground type insert.
Note 1) Above charts are based on published data and not authorized by each manufacturer.

11°POSITIVE INSERT TYPE

ISO Classifi-cation	Cutting Mode	Mitsubishi Materials	Sumitomo Electric	Tungaloy	Kyocera	Dijet	Mitsubishi Hitachi Tool	Sandvik	Kennametal	Seco Tools	Walter	TaeguTec
P	Finish Light	FV, SMG* SV	SI, FK. FB LU, LUW, LB SU,SF	01* PF, PSF PS, PSS	PP, GP* CF XP		JQ	PF	UF, FP FW, LF			FG PC
	Medium	MV	MU	PM 23 24	HQ XQ	BM	JE	PM, UM	MF MP, MW		MP4	
M	Finish | Light	SV	SU	SS* PF, PS	GP, CF*		MP	MF	HP* LF		MM4	
	Medium	MV	MU	PM	HQ			MM				

*Peripheral ground type insert.
Note 1) Above charts are based on published data and not authorized by each manufacturer.

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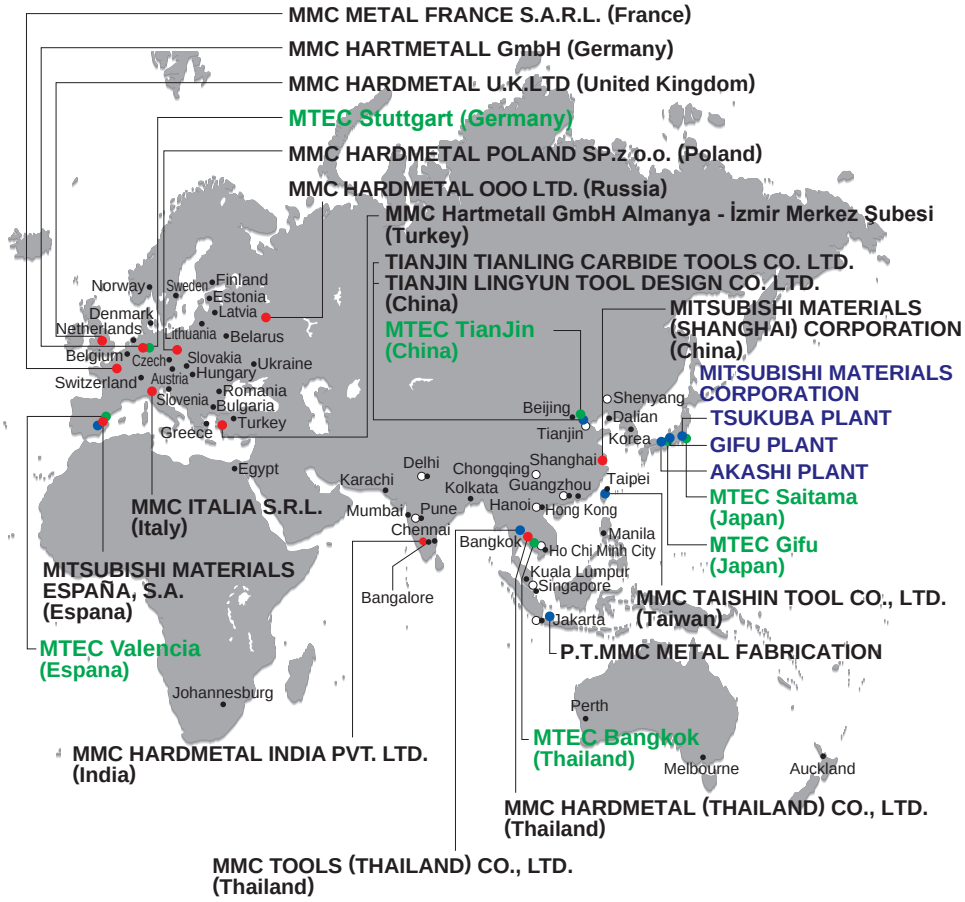

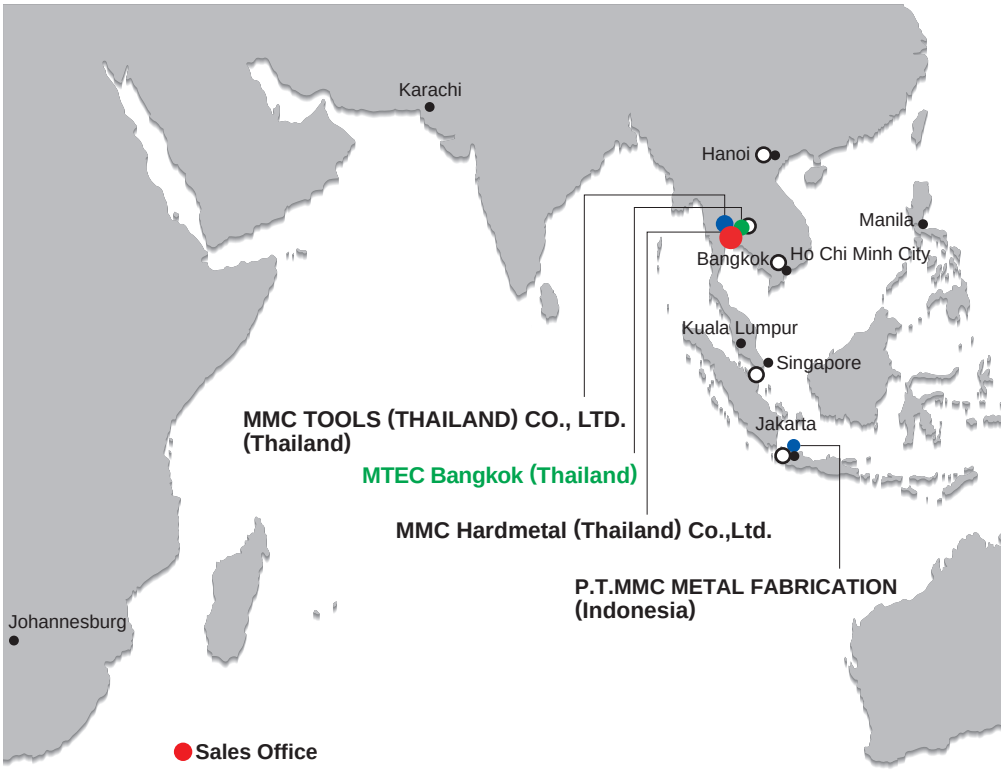

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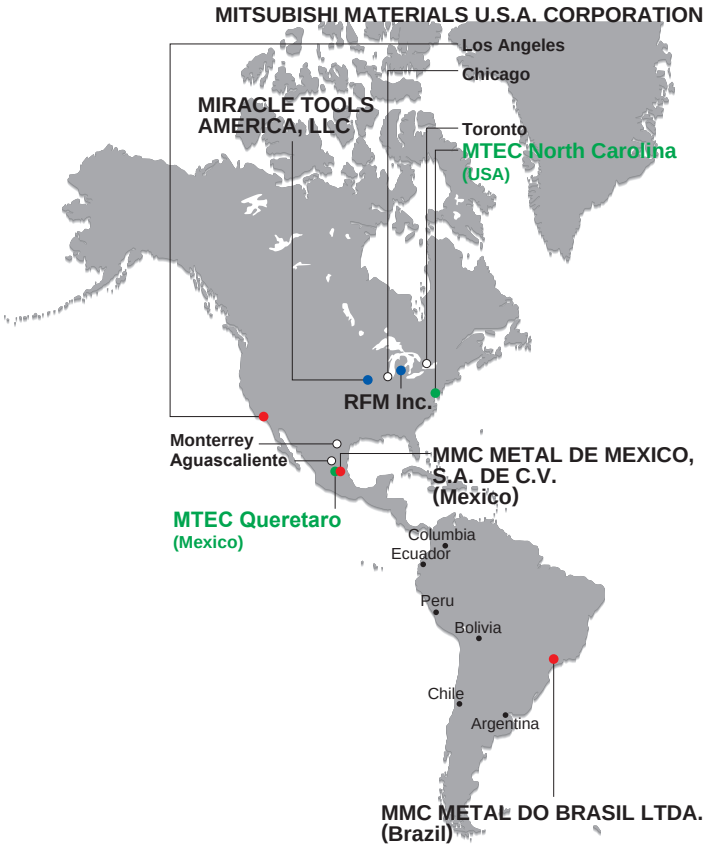

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Design, Development and Production of Cemented Carbide Tools and Carbide Blanks

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QMS、EMS
ISO 9001 , ISO 14001
(JSAQ094) (JSAE1545)
The Scope of the Registration:
Design, Development, and Production of Cutting Tools, Cemented Carbide Blanks, and Coated Products

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