

mitsubishi

MITSUBISHI CARBIDE

TOOLS NEWS

B009G

Ball Nose, 2 flute, Taper Neck

VC-XB

**Great for
deep slotting
of mold.**

Size up

**Neck taper of 1° type (half angle)
has been added as a new size.**

●The neck is tapered for rigidity. These endmills are best for deep slotting of molds and for other machining that needs long overhang.

VC-XB

MIRACLE END MILLS

VC-XB

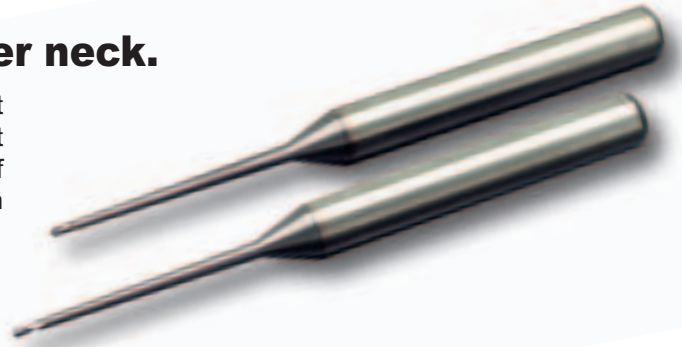


Ball Nose, 2 flute, Taper Neck

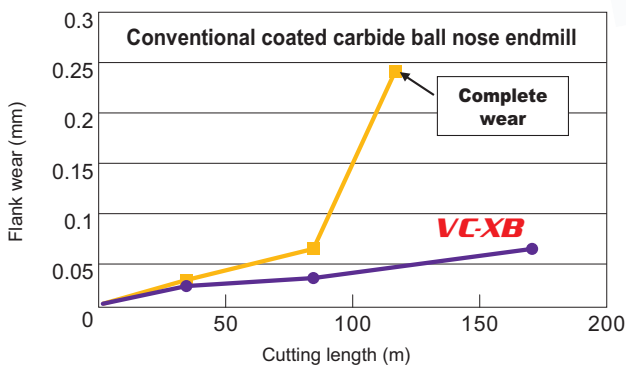
Easy deep slotting: optimal for direct milling

It is Ball nose endmill with taper neck.

The neck is tapered for rigidity. These endmills are best for deep slotting of molds and other machining that needs long overhang. The excellent wear resistance of the miracle coating ensures excellent performance in high hardness material machining.

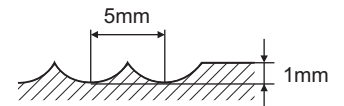


Long tool life



CUTTING CONDITION

End mill	VC-XB (2 flute) R5
Work material	SKD61 (53HRC)
Revolution	5,000min ⁻¹ (157m/min)
Feed rate	1,000mm/min(0.1mm/tooth)
Overhang	70mm
Cutting method	Climb cut, Air blow



Stable processing

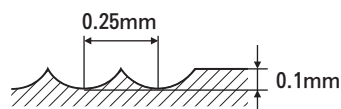
	VC-XB	Competitor
Proper milling level (Effect of Revolution and Feed per tooth)		
Finishing surface (Revolution 5,000min ⁻¹ Feed per tooth 0.02mm/tooth)		

Coding

-good
- ×.....generation of chatter

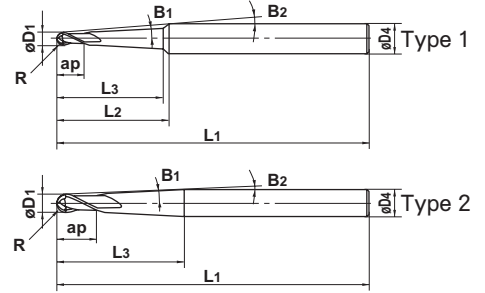
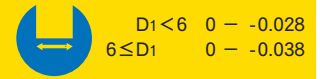
<Cutting condition>

End mill : R0.5×3°
 (Neck length 42mm)
 Work material : SKD61 (52HRC)



MIRACLE END MILLS

VC-XB Size up
Ball Nose, 2 flute, Taper Neck



● It is a ball nose end mill whose neck part is tapered.

Unit : mm

Order Number	Radius of ball nose R	Dia. D ₁	Taper Angle on Side B ₁	Length of Cut ap	Neck Length L ₃	Under Shank Length L ₂	Cutting edge to shank Angle B ₂	Overall Length L ₁	Shank Dia. D ₄	No. of Flute N	Stock	Type
Size up VCXBR0050T0100L016	0.5	1	1°	2	16	22.3	6.5°	50	6	2	●	1
Size up VCXBR0050T0100L021	0.5	1	1°	2	21	27.0	5.4°	60	6	2	●	1
Size up VCXBR0050T0100L026	0.5	1	1°	2	26	31.8	4.6°	70	6	2	●	1
VCXBR0050T0130	0.5	1	1° 30'	2	23	28.5	5.1°	60	6	2	●	1
VCXBR0050T0300	0.5	1	3°	2	42	43.3	3.3°	80	6	2	●	1
VCXBR0050T0500	0.5	1	5°	2	23	25.2	5.8°	60	6	2	●	1
Size up VCXBR0100T0100L021	1	2	1°	4	21	25.8	4.6°	50	6	2	●	1
Size up VCXBR0100T0100L031	1	2	1°	4	31	35.3	3.3°	60	6	2	●	1
Size up VCXBR0100T0100L041	1	2	1°	4	41	44.8	2.6°	70	6	2	●	1
VCXBR0100T0130	1	2	1° 30'	4	23	27.3	4.3°	60	6	2	●	1
VCXBR0100T0300	1	2	3°	4	41	20.5	5.8°	80	6	2	●	1
VCXBR0100T0500	1	2	5°	4	23	24.4	4.9°	60	6	2	●	1
Size up VCXBR0150T0100L031	1.5	3	1°	6	31	34.0	2.6°	60	6	2	●	1
Size up VCXBR0150T0100L041	1.5	3	1°	6	41	43.5	2.0°	70	6	2	●	1
Size up VCXBR0150T0100L051	1.5	3	1°	6	51	53.1	1.7°	80	6	2	●	1
VCXBR0150T0130	1.5	3	1° 30'	6	52	38.1	2.3°	90	6	2	●	1
VCXBR0150T0300	1.5	3	3°	6	32	19.3	4.8°	70	6	2	●	1
Size up VCXBR0200T0100L036	2	4	1°	8	36	37.5	1.6°	70	6	2	●	1
Size up VCXBR0200T0100L046	2	4	1°	8	46	47.0	1.3°	80	6	2	●	1
Size up VCXBR0200T0100L060	2	4	1°	8	60	60.3	1.0°	90	6	2	●	1
VCXBR0200T0130	2	4	1° 30'	8	49	—	1.2°	90	6	2	●	2
VCXBR0200T0300	2	4	3°	8	28	—	2.2°	70	6	2	●	2
Size up VCXBR0250T0100L036	2.5	5	1°	10	36	36.3	0.8°	80	6	2	●	1
Size up VCXBR0250T0100L065	2.5	5	1°	10	65	66.6	1.3°	110	8	2	●	1
VCXBR0250T0130	2.5	5	1° 30'	10	61	38.1	2.4°	110	8	2	●	1
VCXBR0250T0300	2.5	5	3°	10	41	—	2.2°	90	8	2	●	2
Size up VCXBR0300T0100L051	3	6	1°	12	51	52.0	1.2°	90	8	2	●	1
Size up VCXBR0300T0100L065	3	6	1°	12	65	65.3	0.9°	110	8	2	●	1
Size up VCXBR0300T0100L092	3	6	1°	12	92	93.9	1.3°	140	10	2	●	1
VCXBR0300T0130	3	6	1° 30'	12	53	—	1.1°	110	8	2	●	2
VCXBR0300T0300	3	6	3°	12	34	—	1.9°	90	8	2	●	2
Size up VCXBR0400T0100L068	4	8	1°	14	68	68.3	0.9°	110	10	2	●	1
Size up VCXBR0400T0100L092	4	8	1°	14	92	93.9	1.3°	140	12	2	●	1
Size up VCXBR0400T0130	4	8	1° 30'	14	55	—	1.1°	120	10	2	●	2
VCXBR0400T0300	4	8	3°	14	36	—	1.8°	100	10	2	●	2
Size up VCXBR0500T0100L070	5	10	1°	18	70	70.4	0.9°	130	12	2	●	1
Size up VCXBR0500T0100L100	5	10	1°	18	100	104.5	1.7°	160	16	2	●	1
VCXBR0500T0130	5	10	1° 30'	18	59	—	1.1°	130	12	2	●	2
VCXBR0500T0300	5	10	3°	18	40	—	1.7°	110	12	2	●	2
Size up VCXBR0600T0100L070	6	12	1°	22	70	73.3	1.7°	140	16	2	●	1
Size up VCXBR0600T0100L100	6	12	1°	22	100	101.9	1.2°	160	16	2	●	1
VCXBR0600T0130	6	12	1° 30'	22	83	84.3	1.5°	160	16	2	●	1
VCXBR0600T0300	6	12	3°	22	63	—	2.0°	140	16	2	●	2

SOLID ENDMILL
MIRACLE END MILLS

● : Inventory maintained.

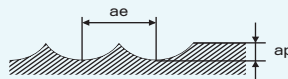
STANDARD CUTTING CONDITIONS OF MIRACLE END MILL

VC-XB

Ball Nose, 2 flute, Taper Neck

Work material				Alloy steel, Tool steel, Pre-hardened steel (-45HRC) AISI H13, AISI D2, NAK		Hardened steel (45-55HRC) AISI H13		
R (mm)	Neck taper half angle	Neck length (mm)	Depth of cut		Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
			ap (mm)	ae (mm)				
R0.5	1°	16	0.02		22,000	530	12,000	230
	1°	21	0.01					
	1°	26	0.01					
	1° 30'	23	0.02					
	3°	42	0.05					
	5°	23	0.05					
R1	1°	21	0.05		18,000	570	10,000	260
	1°	31	0.04					
	1°	41	0.03					
	1° 30'	23	0.1					
	3°	41	0.1					
	5°	23	0.1					
R2	1°	36	0.2		14,000	670	6,000	200
	1°	46	0.15					
	1°	60	0.1					
	1° 30'	49	0.2					
	3°	28	0.2					
R3	1°	51	0.3		10,000	840	5,000	220
	1°	65	0.2					
	1°	92	0.1					
	1° 30'	53	0.3					
	3°	34	0.3					
R4	1° 30'	55	0.4		8,000	840	4,000	270
	3°	36	0.4					
R5	1°	70	0.4		6,000	840	3,000	310
	1°	100	0.3					
	1° 30'	59	0.5					
	3°	40	0.5					
R6	1°	70	0.6		5,000	900	2,500	340
	1°	100	0.4					
	1° 30'	83	0.6					
	3°	63	0.6					

Depth of cut



- 1) Please reduce the cutting depth (especially ap) if chattering and noise are generated.
- 2) When high machining accuracy is especially needed, we recommend reduce feed rate.
- 3) If the cutting depth is shallow, the revolution and feed rate can be increased.

MITSUBISHI MATERIALS KOBE TOOLS



JQA-2522
JQA-EM0941

Overseas Operations Center : Cutting Tools

KFC bldg., 7F, 1-6-1, Yokoami, Sumida-ku, Tokyo 130-0015, Japan
TEL 81-3-5819-8771 FAX 81-3-5819-8774

MMC HARTMETALL GmbH

Comeniusstr.2, 40670, Meerbusch GERMANY
TEL 49-2159-9189-0 FAX 49-2159-50462

MITSUBISHI MATERIALS U.S.A. CORPORATION Headquarters

17401, Eastman Street, Irvine, California, 92614, USA
TEL 1-949-862-5100 FAX 1-949-862-5180

MMC METAL SINGAPORE PTE LTD.

10, Arumugam Road, #04-00 Lion Industrial Bldg., 409957, SINGAPORE
TEL 65-743-9370 FAX 65-749-1469

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