

2 flute Mstar taper neck ball nose end mill

MSTARXB

**“*MSTAR* taper neck ball end mill”
Newly added to
MSTAR end mill series.**

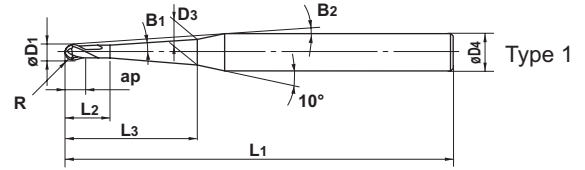
Great for deep slotting up to L/D40.



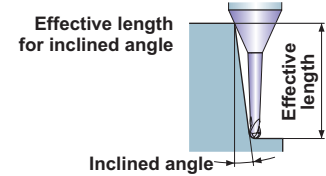
MSTAR END MILLS

MS2XB

Ball nose slot drill, 2 flute, Taper neck



● 2 flute taper neck ball nose end mill.



Unit : mm

Order Number	Radius of ball nose R	Dia. D1	Taper Angle One Side B1	Length of Cut ap	Neck Length L3	L2	Cutting Edge to Shank Angle B2	D3	Overall Length L1	Shank Dia. D4	No. of Flute N	Stock	Type	Effective length for inclined angle			
														30°	1°	2°	3°
MS2XBR0010T0030L015	0.1	0.2	30°	0.2	1.5	0.6	8.8°	0.19	50	4	2	○	1	1.7	1.8	2.0	2.3
R0010T0030L020	0.1	0.2	30°	0.2	2	0.6	8.5°	0.20	50	4	2	○	1	2.2	2.4	2.6	3.0
R0010T0100L015	0.1	0.2	1°	0.2	1.5	0.6	8.8°	0.21	50	4	2	○	1	—	1.8	2.0	2.2
R0010T0100L020	0.1	0.2	1°	0.2	2	0.6	8.5°	0.22	50	4	2	○	1	—	2.3	2.5	2.9
R0010T0130L015	0.1	0.2	1° 30'	0.2	1.5	0.6	8.9°	0.22	50	4	2	○	1	—	—	1.9	2.2
R0010T0130L020	0.1	0.2	1° 30'	0.2	2	0.6	8.6°	0.25	50	4	2	○	1	—	—	2.4	2.8
R0010T0200L015	0.1	0.2	2°	0.2	1.5	0.6	8.9°	0.24	50	4	2	○	1	—	—	1.8	2.1
R0010T0200L020	0.1	0.2	2°	0.2	2	0.6	8.6°	0.27	50	4	2	○	1	—	—	2.3	2.6
R0010T0300L015	0.1	0.2	3°	0.2	1.5	0.6	9.0°	0.27	50	4	2	○	1	—	—	—	1.9
R0010T0300L020	0.1	0.2	3°	0.2	2	0.6	8.7°	0.32	50	4	2	○	1	—	—	—	2.4
R0010T0500L020	0.1	0.2	5°	0.2	2	0.6	9.0°	0.42	50	4	2	○	1	—	—	—	—
R0015T0030L030	0.15	0.3	30°	0.3	3	0.7	7.9°	0.32	50	4	2	○	1	3.2	3.4	3.8	4.3
R0015T0100L030	0.15	0.3	1°	0.3	3	0.7	7.9°	0.36	50	4	2	○	1	—	3.3	3.7	4.2
R0015T0130L030	0.15	0.3	1° 30'	0.3	3	0.7	8.0°	0.40	50	4	2	○	1	—	—	3.5	4.0
R0015T0200L030	0.15	0.3	2°	0.3	3	0.7	8.1°	0.44	50	4	2	○	1	—	—	3.3	3.8
R0015T0300L030	0.15	0.3	3°	0.3	3	0.7	8.2°	0.52	50	4	2	○	1	—	—	—	3.4
R0015T0500L030	0.15	0.3	5°	0.3	3	0.7	8.6°	0.68	50	4	2	○	1	—	—	—	—
R0020T0030L020	0.2	0.4	30°	0.4	2	1.2	8.4°	0.38	50	4	2	○	1	2.3	2.4	2.7	3.0
R0020T0030L030	0.2	0.4	30°	0.4	3	1.2	7.8°	0.40	50	4	2	○	1	3.3	3.5	3.9	4.4
R0020T0030L040	0.2	0.4	30°	0.4	4	1.2	7.3°	0.41	50	4	2	○	1	4.3	4.5	5.1	5.7
R0020T0030L050	0.2	0.4	30°	0.4	5	1.2	6.8°	0.43	50	4	2	○	1	5.3	5.6	6.2	7.1
R0020T0100L020	0.2	0.4	1°	0.4	2	1.2	8.4°	0.39	50	4	2	○	1	—	2.3	2.6	3.0
R0020T0100L030	0.2	0.4	1°	0.4	3	1.2	7.9°	0.43	50	4	2	○	1	—	3.3	3.7	4.2
R0020T0100L040	0.2	0.4	1°	0.4	4	1.2	7.4°	0.46	50	4	2	○	1	—	4.3	4.9	5.5
R0020T0100L050	0.2	0.4	1°	0.4	5	1.2	6.9°	0.50	50	4	2	○	1	—	5.3	6.0	6.8
R0020T0130L020	0.2	0.4	1° 30'	0.4	2	1.2	8.5°	0.41	50	4	2	○	1	—	—	2.5	2.9
R0020T0130L030	0.2	0.4	1° 30'	0.4	3	1.2	7.9°	0.46	50	4	2	○	1	—	—	3.6	4.1
R0020T0130L040	0.2	0.4	1° 30'	0.4	4	1.2	7.5°	0.51	50	4	2	○	1	—	—	4.7	5.3
R0020T0130L050	0.2	0.4	1° 30'	0.4	5	1.2	7.0°	0.56	50	4	2	○	1	—	—	5.7	6.5
R0020T0200L020	0.2	0.4	2°	0.4	2	1.2	8.5°	0.42	50	4	2	○	1	—	—	2.5	2.8
R0020T0200L030	0.2	0.4	2°	0.4	3	1.2	8.0°	0.49	50	4	2	○	1	—	—	3.5	4.0
R0020T0200L040	0.2	0.4	2°	0.4	4	1.2	7.5°	0.56	50	4	2	○	1	—	—	4.5	5.1
R0020T0200L050	0.2	0.4	2°	0.4	5	1.2	7.1°	0.63	50	4	2	○	1	—	—	5.5	6.2
R0025T0030L030	0.25	0.5	30°	0.5	3	1.5	7.8°	0.49	50	4	2	○	1	3.3	3.5	3.9	4.4
R0025T0030L050	0.25	0.5	30°	0.5	5	1.5	6.8°	0.53	50	4	2	○	1	5.3	5.6	6.2	7.1
R0025T0100L030	0.25	0.5	1°	0.5	3	1.5	7.8°	0.52	50	4	2	○	1	—	3.4	3.8	4.3
R0025T0100L050	0.25	0.5	1°	0.5	5	1.5	6.9°	0.59	50	4	2	○	1	—	5.4	6.0	6.8
R0025T0130L030	0.25	0.5	1° 30'	0.5	3	1.5	7.9°	0.54	50	4	2	○	1	—	—	3.7	4.1
R0025T0130L050	0.25	0.5	1° 30'	0.5	5	1.5	7.0°	0.65	50	4	2	○	1	—	—	5.8	6.6
R0025T0200L030	0.25	0.5	2°	0.5	3	1.5	7.9°	0.57	50	4	2	○	1	—	—	3.5	4.0
R0025T0200L050	0.25	0.5	2°	0.5	5	1.5	7.1°	0.71	50	4	2	○	1	—	—	5.5	6.3
R0030T0030L050	0.3	0.6	30°	0.6	5	1.6	6.8°	0.62	50	4	2	○	1	5.3	5.6	6.2	7.1

● : Inventory maintained. ○ : To be on sale.

Order Number	Radius of ball nose R	Dia. D1	Taper Angle One Side B1	Length of Cut ap	Neck Length L3	L2	Cutting Edge to Shank Angle B2	D3	Overall Length L1	Shank Dia. D4	No. of Flute N	Stock	Type	Effective length for inclined angle			
														30°	1°	2°	3°
MS2XBR0030T0030L080	0.3	0.6	30°	0.6	8	1.6	5.7°	0.68	50	4	2	○	1	8.3	8.7	9.8	11.1
R0030T0100L050	0.3	0.6	1°	0.6	5	1.6	6.8°	0.68	50	4	2	○	1	—	5.4	6.0	6.8
R0030T0100L080	0.3	0.6	1°	0.6	8	1.6	5.8°	0.79	50	4	2	○	1	—	8.4	9.4	10.7
R0030T0100L100	0.3	0.6	1°	0.6	10	1.6	5.2°	0.86	50	4	2	○	1	—	10.4	11.6	13.2
R0030T0100L120	0.3	0.6	1°	0.6	12	1.6	4.8°	0.93	50	4	2	○	1	—	12.4	13.9	15.8
R0030T0100L150	0.3	0.6	1°	0.6	15	1.6	4.2°	1.03	50	4	2	○	1	—	15.4	17.2	19.6
R0030T0130L050	0.3	0.6	1° 30'	0.6	5	1.6	6.9°	0.74	50	4	2	○	1	—	—	5.8	6.6
R0030T0130L080	0.3	0.6	1° 30'	0.6	8	1.6	5.9°	0.90	50	4	2	○	1	—	—	9.0	10.2
R0030T0200L060	0.3	0.6	2°	0.6	6	1.6	6.6°	0.87	50	4	2	○	1	—	—	6.6	7.4
R0030T0200L080	0.3	0.6	2°	0.6	8	1.6	6.0°	1.01	50	4	2	○	1	—	—	8.6	9.7
R0040T0030L080	0.4	0.8	30°	0.8	8	1.8	5.5°	0.87	50	4	2	○	1	8.3	8.7	9.8	11.1
R0040T0030L120	0.4	0.8	30°	0.8	12	1.8	4.5°	0.94	60	4	2	○	1	12.3	13.0	14.5	16.5
R0040T0100L080	0.4	0.8	1°	0.8	8	1.8	5.6°	0.98	50	4	2	○	1	—	8.4	9.4	10.7
R0040T0100L120	0.4	0.8	1°	0.8	12	1.8	4.6°	1.12	60	4	2	○	1	—	12.4	13.9	15.8
R0040T0130L080	0.4	0.8	1° 30'	0.8	8	1.8	5.8°	1.09	50	4	2	○	1	—	—	9.0	10.2
R0040T0130L120	0.4	0.8	1° 30'	0.8	12	1.8	4.8°	1.30	60	4	2	○	1	—	—	13.2	15.0
R0040T0200L080	0.4	0.8	2°	0.8	8	1.8	5.9°	1.20	60	4	2	○	1	—	—	8.6	9.7
R0040T0300L120	0.4	0.8	3°	0.8	12	1.8	5.2°	1.83	60	4	2	○	1	—	—	—	12.8
R0050T0030L100	0.5	1	30°	1	10	2.5	6.1°	1.08	60	6	2	●	1	10.4	10.9	12.2	13.9
R0050T0030L150	0.5	1	30°	1	15	2.5	5.1°	1.16	60	6	2	●	1	15.4	16.2	18.2	20.7
R0050T0030L200	0.5	1	30°	1	20	2.5	4.4°	1.25	70	6	2	●	1	20.4	21.5	24.1	27.4
R0050T0030L250	0.5	1	30°	1	25	2.5	3.8°	1.34	70	6	2	●	1	25.4	26.8	30.0	34.2
R0050T0030L300	0.5	1	30°	1	30	2.5	3.4°	1.42	70	6	2	●	1	30.4	32.0	35.9	41.0
R0050T0100L100	0.5	1	1°	1	10	2.5	6.2°	1.21	60	6	2	●	1	—	10.5	11.8	13.4
R0050T0100L150	0.5	1	1°	1	15	2.5	5.2°	1.38	60	6	2	●	1	—	15.5	17.4	19.8
R0050T0100L200	0.5	1	1°	1	20	2.5	4.5°	1.56	70	6	2	●	1	—	20.5	23.0	26.2
R0050T0100L250	0.5	1	1°	1	25	2.5	3.9°	1.73	70	6	2	●	1	—	25.5	28.6	32.6
R0050T0100L300	0.5	1	1°	1	30	2.5	3.5°	1.91	70	6	2	●	1	—	30.5	34.2	39.0
R0050T0100L350	0.5	1	1°	1	35	2.5	3.2°	2.08	80	6	2	●	1	—	35.5	39.8	45.4
R0050T0130L100	0.5	1	1° 30'	1	10	2.5	6.3°	1.34	60	6	2	●	1	—	—	11.3	12.8
R0050T0130L150	0.5	1	1° 30'	1	15	2.5	5.3°	1.60	60	6	2	●	1	—	—	16.6	18.9
R0050T0130L200	0.5	1	1° 30'	1	20	2.5	4.6°	1.86	70	6	2	●	1	—	—	21.9	24.9
R0050T0200L150	0.5	1	2°	1	15	2.5	5.4°	1.82	60	6	2	●	1	—	—	15.8	18.0
R0050T0200L200	0.5	1	2°	1	20	2.5	4.7°	2.17	70	6	2	●	1	—	—	20.8	23.7
R0050T0300L200	0.5	1	3°	1	20	2.5	5.0°	2.78	70	6	2	●	1	—	—	—	21.2
R0050T0300L400	0.5	1	3°	1	40	2.5	3.4°	4.88	80	6	2	●	1	—	—	—	41.2
R0050T0500L200	0.5	1	5°	1	20	2.5	5.7°	4.01	70	6	2	●	1	—	—	—	—
R0060T0030L120	0.6	1.2	30°	1.2	12	2.7	5.6°	1.31	60	6	2	●	1	12.4	13.1	14.6	16.6
R0060T0030L240	0.6	1.2	30°	1.2	24	2.7	3.8°	1.52	70	6	2	●	1	24.4	25.7	28.8	32.8
R0060T0100L120	0.6	1.2	1°	1.2	12	2.7	5.7°	1.47	60	6	2	●	1	—	12.5	14.0	15.9
R0060T0100L240	0.6	1.2	1°	1.2	24	2.7	3.9°	1.89	70	6	2	●	1	—	24.5	27.5	31.3
R0060T0130L120	0.6	1.2	1° 30'	1.2	12	2.7	5.8°	1.63	60	6	2	●	1	—	—	13.4	15.2
R0060T0130L240	0.6	1.2	1° 30'	1.2	24	2.7	4.1°	2.26	70	6	2	●	1	—	—	26.2	29.8
R0060T0200L120	0.6	1.2	2°	1.2	12	2.7	5.9°	1.79	60	6	2	●	1	—	—	12.8	14.6
R0060T0200L240	0.6	1.2	2°	1.2	24	2.7	4.2°	2.63	70	6	2	●	1	—	—	24.8	28.3
R0075T0030L100	0.75	1.5	30°	1.5	10	3	5.9°	1.57	60	6	2	●	1	10.4	10.9	12.2	13.8
R0075T0030L150	0.75	1.5	30°	1.5	15	3	4.9°	1.65	60	6	2	●	1	15.4	16.2	18.1	20.6
R0075T0030L300	0.75	1.5	30°	1.5	30	3	3.2°	1.92	70	6	2	●	1	30.4	32.0	35.9	40.9
R0075T0100L100	0.75	1.5	1°	1.5	10	3	6.0°	1.69	60	6	2	●	1	—	10.5	11.8	13.3
R0075T0100L150	0.75	1.5	1°	1.5	15	3	5.0°	1.86	60	6	2	●	1	—	15.5	17.4	19.7
R0075T0100L200	0.75	1.5	1°	1.5	20	3	4.2°	2.04	70	6	2	●	1	—	20.5	23.0	26.1
R0075T0100L300	0.75	1.5	1°	1.5	30	3	3.3°	2.39	70	6	2	●	1	—	30.5	34.2	39.0
R0075T0130L100	0.75	1.5	1° 30'	1.5	10	3	6.1°	1.81	60	6	2	●	1	—	—	11.3	12.8
R0075T0130L150	0.75	1.5	1° 30'	1.5	15	3	5.1°	2.07	60	6	2	●	1	—	—	16.6	18.9

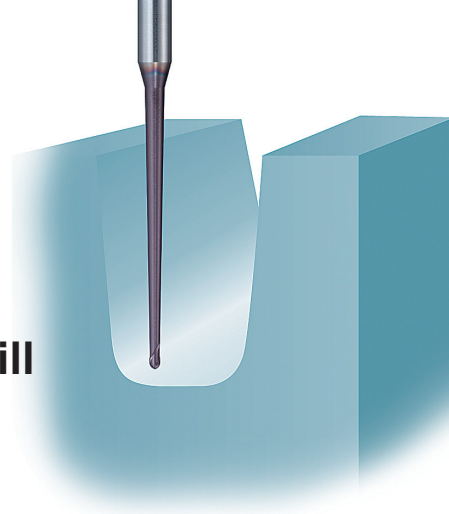
Unit : mm

Order Number	Radius of ball nose R	Dia. D1	Taper Angle One Side B1	Length of Cut ap	Neck Length L3	L2	Cutting Edge to Shank Angle B2	D3	Overall Length L1	Shank Dia. D4	No. of Flute N	Stock	Type	Effective length for inclined angle			
														30'	1°	2°	3°
MS2XBR0075T0130L300	0.75	1.5	1° 30'	1.5	30	3	3.4°	2.86	70	6	2	●	1	—	—	32.5	37.0
R0075T0200L100	0.75	1.5	2°	1.5	10	3	6.2°	1.93	60	6	2	●	1	—	—	10.9	12.3
R0075T0200L150	0.75	1.5	2°	1.5	15	3	5.2°	2.28	60	6	2	●	1	—	—	15.9	18.0
R0075T0200L300	0.75	1.5	2°	1.5	30	3	3.5°	3.33	70	6	2	●	1	—	—	30.9	35.1
R0100T0030L200	1	2	30'	2	20	4	3.9°	2.18	60	6	2	●	1	20.7	21.7	24.3	27.6
R0100T0030L300	1	2	30'	2	30	4	2.9°	2.36	70	6	2	●	1	30.7	32.3	36.2	No interference
R0100T0030L400	1	2	30'	2	40	4	2.4°	2.53	80	6	2	●	1	40.7	42.8	48.0	No interference
R0100T0100L200	1	2	1°	2	20	4	4.0°	2.46	60	6	2	●	1	—	20.8	23.3	26.4
R0100T0100L250	1	2	1°	2	25	4	3.4°	2.64	60	6	2	●	1	—	25.8	28.9	32.9
R0100T0100L300	1	2	1°	2	30	4	3.0°	2.81	70	6	2	●	1	—	30.8	34.5	39.3
R0100T0100L350	1	2	1°	2	35	4	2.7°	2.99	80	6	2	●	1	—	35.8	40.1	No interference
R0100T0100L400	1	2	1°	2	40	4	2.5°	3.16	80	6	2	●	1	—	40.8	45.8	No interference
R0100T0100L500	1	2	1°	2	50	4	2.1°	3.51	90	6	2	●	1	—	50.8	57.0	No interference
R0100T0130L200	1	2	1° 30'	2	20	4	4.1°	2.74	60	6	2	●	1	—	—	22.3	25.3
R0100T0130L300	1	2	1° 30'	2	30	4	3.1°	3.27	70	6	2	●	1	—	—	32.9	37.4
R0100T0130L400	1	2	1° 30'	2	40	4	2.6°	3.79	80	6	2	●	1	—	—	43.5	No interference
R0100T0200L300	1	2	2°	2	30	4	3.3°	3.72	70	6	2	●	1	—	—	31.3	35.5
R0100T0200L400	1	2	2°	2	40	4	2.7°	4.42	80	6	2	●	1	—	—	41.3	No interference
R0100T0300L300	1	2	3°	2	30	4	3.5°	4.63	70	6	2	●	1	—	—	—	31.8
R0100T0300L400	1	2	3°	2	40	4	2.9°	5.68	80	6	2	●	1	—	—	—	No interference
R0100T0500L200	1	2	5°	2	20	4	5.1°	4.70	60	6	2	●	1	—	—	—	—
R0100T0500L380	1	2	5°	2	38	4	4.6°	7.85	80	8	2	●	1	—	—	—	—
R0150T0030L300	1.5	3	30'	3	30	6	2.4°	3.32	70	6	2	●	1	30.7	32.3	36.2	No interference
R0150T0030L400	1.5	3	30'	3	40	6	1.9°	3.50	80	6	2	●	1	40.7	42.9	No interference	No interference
R0150T0030L500	1.5	3	30'	3	50	6	1.6°	3.67	90	6	2	●	1	50.7	53.4	No interference	No interference
R0150T0100L300	1.5	3	1°	3	30	6	2.5°	3.74	70	6	2	●	1	—	31.0	34.7	No interference
R0150T0100L400	1.5	3	1°	3	40	6	2.0°	4.09	80	6	2	●	1	—	41.0	45.9	No interference
R0150T0100L500	1.5	3	1°	3	50	6	1.7°	4.44	90	6	2	●	1	—	51.0	—	No interference
R0150T0130L300	1.5	3	1° 30'	3	30	6	2.6°	4.16	70	6	2	●	1	—	—	33.1	No interference
R0150T0130L400	1.5	3	1° 30'	3	40	6	2.1°	4.69	80	6	2	●	1	—	—	43.8	No interference
R0150T0130L500	1.5	3	1° 30'	3	50	6	1.7°	5.21	90	6	2	●	1	—	—	—	No interference
R0150T0200L300	1.5	3	2°	3	30	6	2.7°	4.58	70	6	2	●	1	—	—	31.6	No interference
R0150T0200L480	1.5	3	2°	3	48	6	1.9°	5.84	90	6	2	●	1	—	—	—	No interference
R0150T0300L300	1.5	3	3°	3	30	6	2.9°	5.42	70	6	2	●	1	—	—	—	No interference
R0150T0300L500	1.5	3	3°	3	50	6	2.9°	7.52	90	8	2	●	1	—	—	—	No interference
R0200T0030L600	2	4	30'	4	60	7	1.0°	4.83	110	6	2	○	1	60.8	64.0	No interference	No interference
R0200T0100L600	2	4	1°	4	60	7	1.0°	5.76	110	6	2	○	1	—	61.1	No interference	No interference

Mstar End Mill

M52XB

2 flute Mstar taper neck ball nose end mill



Features 1

MSTAR end mill series which is great for deep slotting.

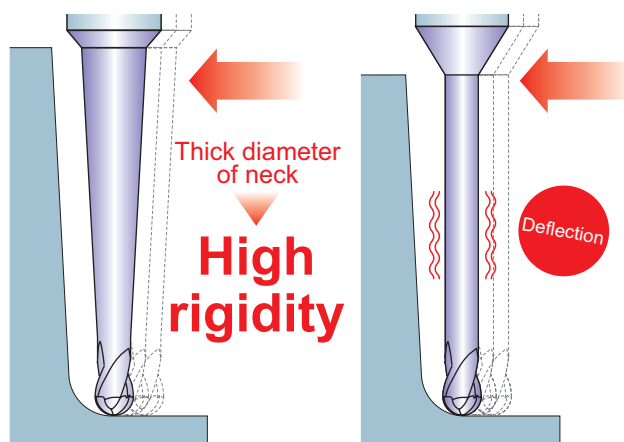
- Optimal for deep slotting on the wall side of mold draft.
- Realize stable deep slotting due to the high rigidity of neck and short flute.

Compare same diameter

M52XB

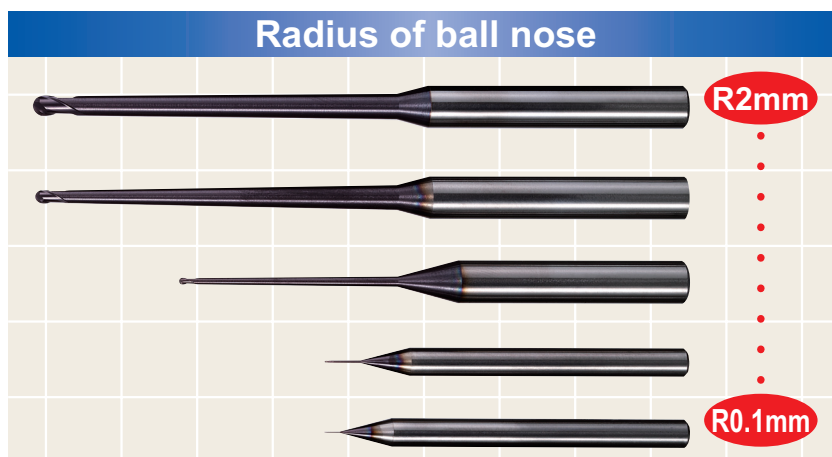
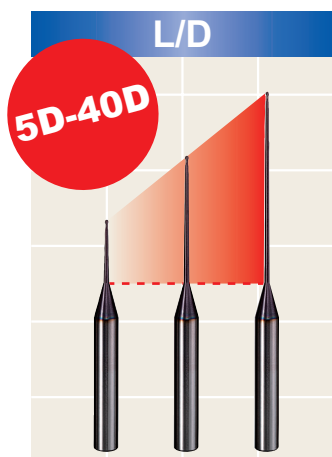
(Taper neck ball)

Long neck type



Features 2 Wide varieties of diameter, taper angle and neck length.

- Lineup of 133 sizes in total from R0.1mm to R2mm.
- Optimal sizes are available according to work materials and cutting condition.



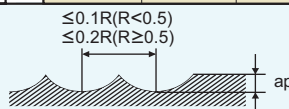
MS2XB

Ball nose slot drill, 2 flute, Taper neck

Work material				Alloy steel, Tool steel, Pre-hardened steel (-45HRC) AISI H13, AISI D2, NAK	
R (mm)	Taper angle one side	Neck length (mm)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
R0.1	30'	1.5	0.005	30,000	300
	30'	2	0.005		
	1°	1.5	0.005		
	1°	2	0.005		
	2°	1.5	0.01		
	2°	2	0.01		
	3°	1.5	0.01		
	3°	2	0.01		
	5°	2	0.01		
R0.15	30'	3	0.005	30,000	300
	1°	3	0.005		
	2°	3	0.01		
	3°	3	0.01		
R0.2	30'	2	0.02	30,000	300
	30'	5	0.01		
	1°	2	0.02		
	1°	5	0.01		
R0.25	30'	3	0.03	30,000	300
	30'	5	0.02		
	1°	3	0.03		
	1°	5	0.02		
	2°	3	0.03		
R0.3	30'	5	0.03	30,000	400
	30'	8	0.02		
	1°	5	0.03		
	1°	10	0.02		
	2°	6	0.03		
	2°	8	0.02		
R0.4	30'	8	0.05	30,000	500
	30'	12	0.04		
	1°	8	0.05		
	1°	12	0.04		
	2°	8	0.08		
	3°	12	0.06		

Work material				Alloy steel, Tool steel, Pre-hardened steel (-45HRC) AISI H13, AISI D2, NAK	
R (mm)	Taper angle one side	Neck length (mm)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
R0.5	30'	10	0.05	22,000	530
	30'	20	0.02		
	30'	30	0.005		
	1°	10	0.05		
	1°	20	0.02		
	1°	35	0.005		
	2°	20	0.03		
	3°	40	0.05		
	5°	20	0.05		
R0.6	30'	12	0.05	22,000	600
	30'	24	0.02		
	1°	12	0.05		
	1°	24	0.02		
R0.75	30'	10	0.1	20,000	700
	30'	30	0.02		
	1°	10	0.1		
R1	30'	30	0.05	18,000	1,000
	30'	30	0.03		
	30'	40	0.02		
	1°	20	0.05		
	1°	40	0.03		
	1°	50	0.02		
	2°	40	0.1		
	3°	40	0.1		
	5°	38.2	0.1		
R1.5	30'	30	0.1	16,000	1,300
	30'	50	0.03		
	1°	30	0.1		
	1°	50	0.03		
	2°	48.9	0.1		
R2	30'	50	0.1	14,000	1,100
	30'	60	0.1		
	1°	60	0.1		

Depth of cut



R:Radius

- 1) Please reduce the cutting depth (especially ap) if chattering and noise are generated, and reduce the feed rate proportionately.
- 2) When high machining accuracy is needed, we recommend reducing the feed rate.

MITSUBISHI MATERIALS KOBE TOOLS



JQA-2522
JQA-EM0941

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