

2 flute IMPACT MIRACLE short ball endmill (S)



VF-255B

**Short overall length
gives high rigidity.**

Realized optimum tool overhang.



NEW

VF-255B

IMPACT

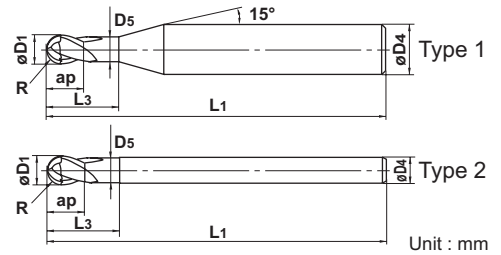
IMPACT MIRACLE END MILL

VF-255B Expand

2 flute IMPACT MIRACLE short ball endmill (S)



● Suitable for shrink fit chucks.



Unit : mm

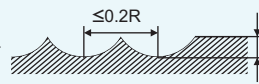
Order Number	Radius of Ball Nose R	Dia. D1	Length of Cut ap	Neck Length L3	Neck Dia. D5	Overall Length L1	Shank Dia. D4	No. of Flutes N	Stock	Type
* VF2SSBR0050S04	0.5	1	1	2	0.94	40	4	2	●	1
R0050	0.5	1	1	2	0.94	40	6	2	●	1
* R0075S04	0.75	1.5	1.5	3	1.44	40	4	2	●	1
R0075	0.75	1.5	1.5	3	1.44	40	6	2	●	1
R0100	1	2	2	4	1.9	45	6	2	●	1
R0150	1.5	3	3	6	2.9	45	6	2	●	1
R0200	2	4	4	8	3.9	45	6	2	●	1
R0250	2.5	5	5	10	4.9	50	6	2	●	1
R0300	3	6	6	12	5.85	50	6	2	●	2
R0400	4	8	8	14	7.85	60	8	2	●	2
R0500	5	10	10	18	9.7	70	10	2	●	2
R0600	6	12	12	22	11.7	75	12	2	●	2

* Expand

Cutting conditions

Work material	Hardened steel (-55HRC) NAK, AISI H13					Hardened steel (55-62HRC) AISI D2, SUS420					Hardened steel (62-70HRC) SKS, SKH				
	α ≤ 15°		α > 15°		Depth of cut (mm)	α ≤ 15°		α > 15°		Depth of cut (mm)	α ≤ 15°		α > 15°		Depth of cut (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	40,000	8,000	40,000	3,200	0.06	40,000	5,600	40,000	2,400	0.05	40,000	3,600	32,000	1,300	0.04
R 0.75	40,000	9,600	40,000	4,000	0.09	40,000	7,200	32,000	2,500	0.075	32,000	4,500	21,000	1,200	0.05
R 1	40,000	9,600	39,000	4,700	0.11	40,000	8,000	24,000	2,400	0.1	24,000	3,800	16,000	1,000	0.07
R 1.5	40,000	12,000	27,000	4,300	0.13	32,000	7,700	16,000	2,200	0.12	16,000	3,200	11,000	880	0.09
R 2	32,000	10,880	20,000	3,600	0.15	24,000	6,200	12,000	1,900	0.13	12,000	2,400	8,000	800	0.1
R 2.5	25,000	9,000	16,000	2,900	0.2	19,000	5,300	9,600	1,700	0.15	9,600	2,100	6,000	600	0.1
R 3	21,000	8,400	13,000	2,600	0.25	16,000	4,800	8,000	1,600	0.2	8,000	1,700	5,000	600	0.11
R 4	16,000	6,400	10,000	2,000	0.3	12,000	3,600	6,000	1,200	0.2	6,000	1,400	4,000	480	0.11
R 5	13,000	5,200	8,000	1,700	0.5	10,000	3,200	4,800	960	0.2	4,800	1,100	3,000	420	0.12
R 6	9,000	3,600	6,000	1,300	0.5	7,000	2,200	3,600	720	0.3	3,600	860	2,200	310	0.12

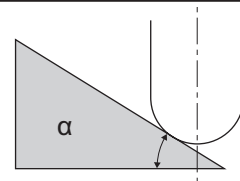
Depth of cut Pick feed rates should be chosen according to the surface finish required. The table above should be used as a reference start point.



≤ Please refer to the list above for depth of cut.

R: Radius

- 1) If the rigidity of the machine or the workpiece installation is very low, or chattering and noise are generated, please reduce the revolution and the feed rate proportionately.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased. If accuracy is important, please reduce the feed rate.
- 3) α is the inclination angle of the machined surface.



JQA-2522
JQA-EM0941

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MITSUBISHI MATERIALS CORPORATION MARKETING DEPT.

KFC bldg., 8F, 1-6-1, Yokoami, Sumida-ku, Tokyo 130-0015, Japan
TEL 81-3-5819-8772 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 65-6743-9370 FAX 65-6749-1469