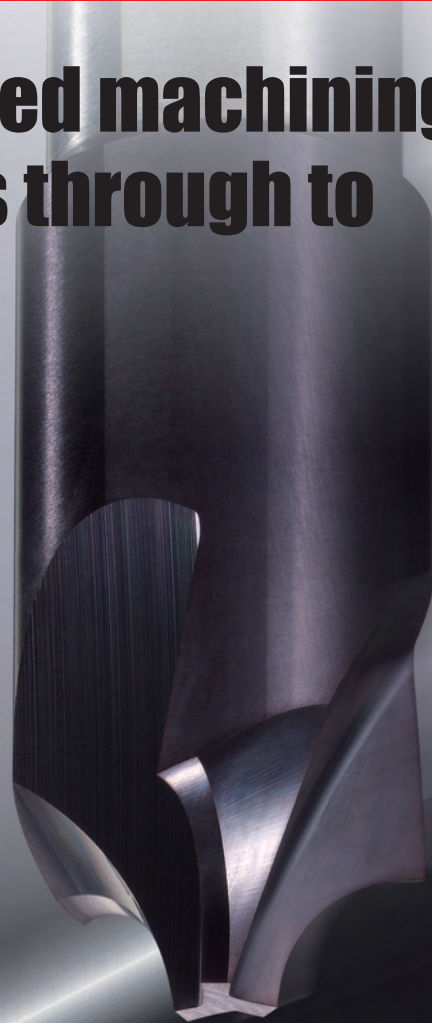


MIRACLE CORNER ROUNDING CUTTER

VC-RC

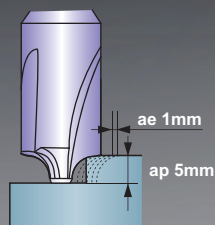
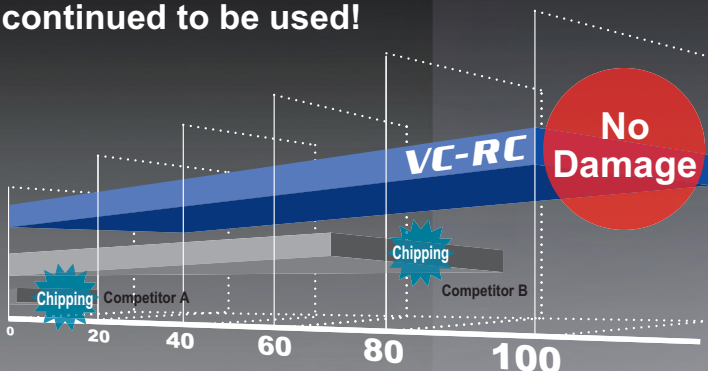
**3 flute for high feed machining!
For carbon steels through to
hardened steels!**

New carbide corner rounding
end mill.



Machining hardened steel (W.Nr. 1.2344(H13):52HRC)

After 100m of cutting, the VCRC can
continued to be used!

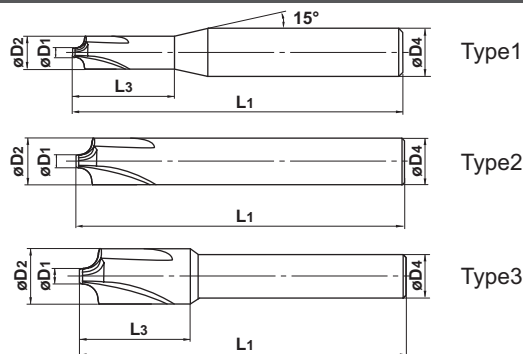
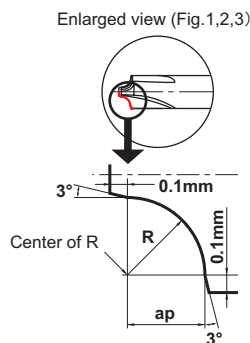


End mill	VC-RC R5
Work material	SKD61 (52HRC)
Revolution	3,000min ⁻¹ (Max.132m/min)
Feed rate	Cutting length ≤ 50m : 150mm/min (0.017mm/t) Cutting length > 50m : 300mm/min (0.033mm/t)
Cutting method	Climb cut, air blow

CORNER RADIUS END MILLS

VC-RC

Corner rounding cutter, 3 flute



Unit : mm

● Corner rounding cutter for high efficiency, high feed machining.

Order Number	Corner Radius R	Dia. D2	Overall Length L1	Tip Dia. D1	Length of Cut ap	Neck Length L3	Shank Dia. D4	No. of Flutes N	Stock	Type
VCRCR0050	0.5	4	50	2.8	0.5	12	6	3	●	1
R0100	1	5	50	2.8	1	15	6	3	●	1
R0150	1.5	6	50	2.8	1.5	—	6	3	●	2
R0200	2	8	60	3.8	2	—	8	3	●	2
R0250	2.5	9	70	3.8	2.5	27	10	3	●	1
R0300	3	10	70	3.8	3	—	10	3	●	2
R0400	4	12	75	3.8	4	—	12	3	●	2
R0500	5	14	75	3.8	5	26	12	3	●	3

● : Inventory maintained.

Work material	Structural steel, Carbon steel, Cast iron (-30HRC) AISI 1049, AISI 35		Alloy steel, Tool steel, Pre-hardened steel (30-45HRC) SCM, AISI H13, AISI D2		Austenitic stainless steel AISI 304, AISI 316		Hardened steel (45-55HRC) AISI H13	
	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	8,000	300	5,600	200	4,800	150	4,800	120
R1	6,400	300	4,500	200	3,800	150	3,800	120
R1.5	5,300	300	3,700	200	3,200	150	3,200	120
R2	4,000	300	2,800	200	2,400	150	2,400	120
R2.5	3,600	300	2,500	200	2,100	150	2,100	120
R3	3,200	300	2,300	200	1,900	150	1,900	120
R4	2,700	300	1,900	200	1,600	150	1,600	120
R5	2,300	300	1,600	200	1,400	150	1,400	120

Depth of cut	≤0.5R	≤0.3R	≤0.2R

1) When roughing, the material should be removed in several passes.

When finishing, a suitable minimum allowance should be removed to obtain the necessary finish.

- 2) If the rigidity of the machine or the workpiece set up is very low, or chattering and noise occur, reduce the feed rate accordingly.
3) Coolant is recommended.



JQA-2522
JQA-EM0941

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