

MIRACLE END MILLS

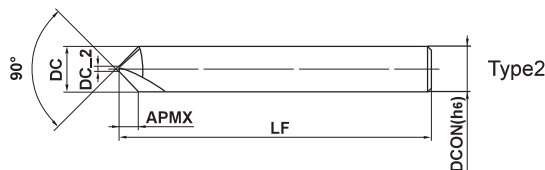
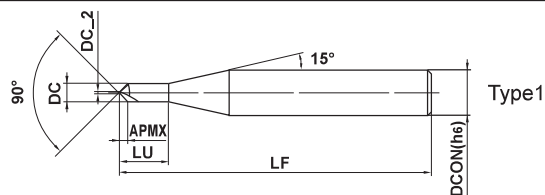
VC2C

Chamfer cutter, 2 flute



CARBIDE

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
○	○	○	○	○	○	○	○



±0.02				
DCON=6	8≤DCON≤10	DCON=12		
⁰ / _{-0.008}	⁰ / _{-0.009}	⁰ / _{-0.011}		

● Chamfering cutters for machining of hardened steel and difficult-to-cut materials.

Unit : mm

Order Number	DC	DC_2	APMX	LU	LF	DCON	No. of Flutes	Stock	Type
VC2CD0200	2	0.3	0.85	6	50	6	2	●	1
VC2CD0400	4	0.3	1.85	12	50	6	2	●	1
VC2CD0600	6	0.3	2.85	—	50	6	2	●	2
VC2CD0800	8	0.4	3.8	—	60	8	2	●	2
VC2CD1000	10	0.5	4.75	—	70	10	2	●	2
VC2CD1200	12	0.5	5.75	—	75	12	2	●	2

RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Cast iron, Alloy steel (—30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45—55HRC)	
	AISI 1050, AISI No 35 B, AISI P20		AISI H13, AISI W1-10, AISI P21		AISI 304, AISI 306, Ti-6Al-4V		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	Chamfering of hole

DC: Dia.

- 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 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.