

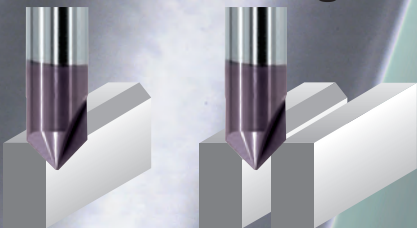
MIRACLE Chamfering Cutter

VC-2C

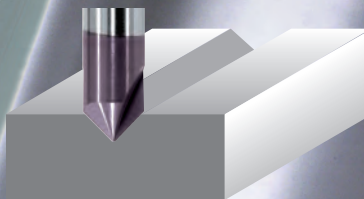
VC-2C is a multi purpose chamfering cutter which can be used not only for chamfering, but also chamfering of hole, V slotting and center drilling.

- Widely used for milling from raw materials to hardened steels and difficult-to-cut materials.
- VC-2C adopts MIRACLE coating (Al,Ti)N. It is possible to cut high speed and high efficient machining.
- Due to end cutting edge, it is possible to cut V slotting and center drilling.

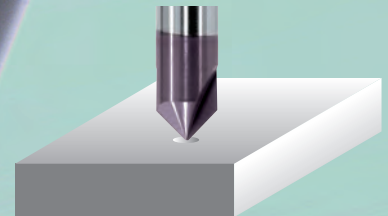
Chamfering



V slotting



Center drilling



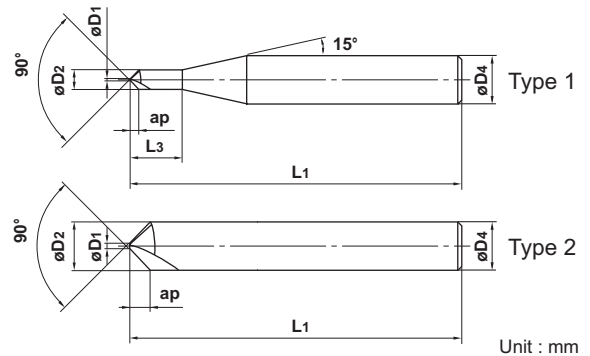
*With end cutting edge.

VC-2C

2 flute Chamfering Cutter



● It is possible to cut hardened steel & difficult-to-cut material.



Unit : mm

Order Number	Dia. D2	Small mill Dia. D1	Length of Cut ap	Neck Length L3	Overall Length L1	Shank Dia. D4	No. of Flute N	Stock	Type
VC2CD0200	2	0.3	0.85	6	50	6	2	●	1
D0400	4	0.3	1.85	12	50	6	2	●	1
D0600	6	0.3	2.85	—	50	6	2	●	2
D0800	8	0.4	3.8	—	60	8	2	●	2
D1000	10	0.5	4.75	—	70	10	2	●	2
D1200	12	0.5	5.75	—	75	12	2	●	2

● : Inventory maintained.

Work material	Carbon steel, Alloy steel (-30HRC) AISI 1049, SCM Cast iron FC250		Alloy steel, Tool steel Pre-hardened steel (30-45HRC) AISI H13 NAK		Austenitic stainless steel AISI 304, AISI 316		Hardened steel (45-55HRC) AISI H13	
	Dia. (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)
2	16,000	960	11,000	590	9,500	460	8,000	320
4	8,000	480	5,600	300	4,800	230	4,000	160
6	5,300	320	3,700	200	3,200	150	2,700	110
8	4,000	240	2,800	150	2,400	120	2,000	80
10	3,200	190	2,200	120	1,900	90	1,600	60
12	2,700	160	1,900	100	1,600	80	1,300	50

Depth of cut	Camfering		Chamfering milling of hole	
	D: Dia.			

1) The above table shows cutting condition for chamfering milling.

For V slotting, please reduce the feed rate at 1/3 or below of the above value. For center drilling, please reduce the feed rate at 1/5 or below of the above value.

2) If the rigidity of the machine or the material installation is very low, or chattering is generated, please reduce the revolution and the feed rate of the above table proportionately.

3) In cutting austenitic stainless steels or hardened steels, cutting oil is recommended.



JQA-2522
JQA-EM0941

MITSUBISHI MATERIALS KOBE TOOLS

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