

DCCC

INDEXABLE END MILL
FOR DEEP SHOULDER MILLING AND SLOTTING

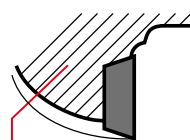


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DESIGN FEATURES OF DCCC TYPE END MILL



**HIGH RIGIDITY
FOR HIGH PERFORMANCE AND RELIABILITY**

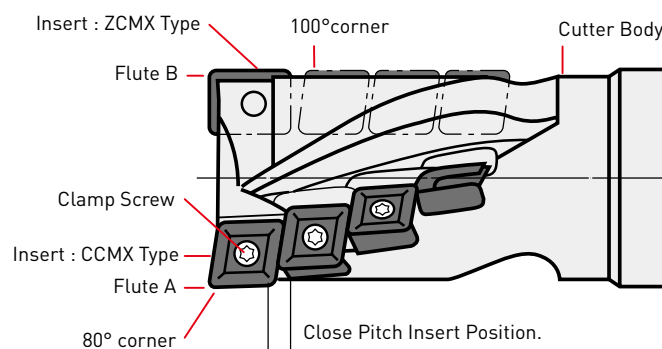


Additional body clearance reduces probability of chip jamming.

BENEFITS

- Different helical flute angles prevents chattering
- High rigidity tool for performance and reliability
- High-productivity for deep 2D profile milling

**ALL 4 CUTTING EDGES OF CCMX INSERT ARE UTILIZED,
80° CORNERS IN FLUTE "A" AND 100° CORNERS ON FLUTE "B".**



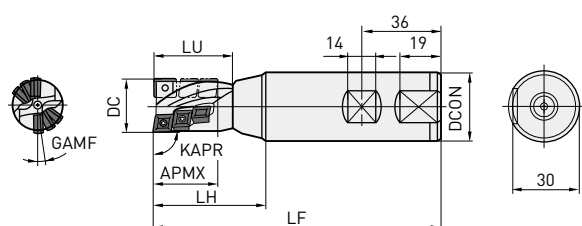
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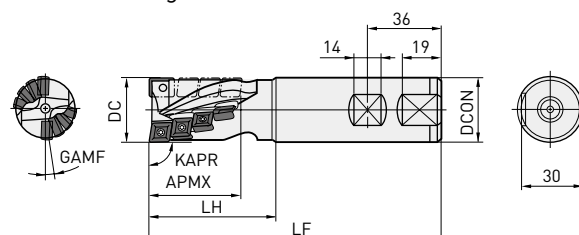
INDEXABLE END MILL FOR DEEP SHOULDER MILLING AND SLOTTING

P **M** **K**

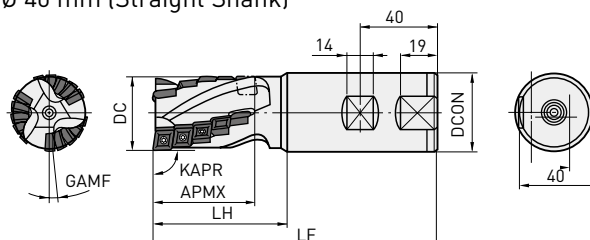
Ø 25 mm (Straight Shank)



Ø 32 mm (Straight Shank)



Ø 40 mm (Straight Shank)



Right hand tool holder only.

Order Number	Stock	APMX	DC	DCON	LF	LH	LU	ZNF	ZNP	ZEFF	GAMF	Peripheral and Bottom Inserts		Bottom Insert (One pocket only)	
												CCMX08 3508EN-A	CCMX09 T308EN-	ZCMX08 3508ER-A	ZCMX09 T308ER-
DCCCR2506S32	●	27	25	32	130	50	36	2	6	2	8°	5	-	1	-
DCCCR2510S32	●	44	25	32	150	70	56	2	10	2	8°	9	-	1	-
DCCCR3208S32	●	43	32	32	140	60	-	2	8	2	8°36'	-	7	-	1
DCCCR3212S32	●	63	32	32	160	80	-	2	12	2	8°36'	-	11	-	1
DCCCR4015S40	●	53	40	40	150	70	-	3	15	3	5°31'	-	14	-	1
DCCCR4015S42	★	53	40	42	150	70	-	3	15	3	5°31'	-	14	-	1
DCCCR4024S40	●	83	40	40	180	100	-	3	24	3	5°31'	-	23	-	1
DCCCR4024S42	★	83	40	42	180	100	-	3	24	3	5°31'	-	23	-	1



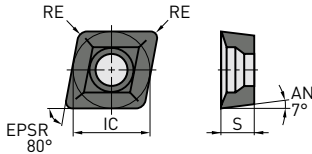
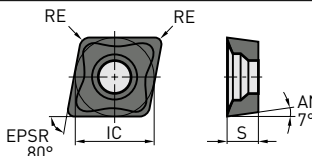
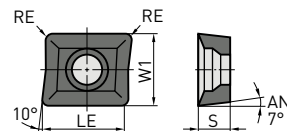
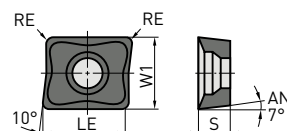
SPARE PARTS

Tool Holder Number	*			
	Clamp Screw	Wrench	Peripheral and Bottom Insert	Bottom Insert (One Pocket Only)
DCCR25	CS300890T	TKY08DS	CCMX083508EN-A	ZCMX083508ER-A
DCCR32	CS350990T	TKY10DS	CCMX09T308EN-A / B	ZCMX09T308ER-A / B
DCCR40				

* Clamp Torque (N • m) : CS300890T=1.0, CS350990T=2.5

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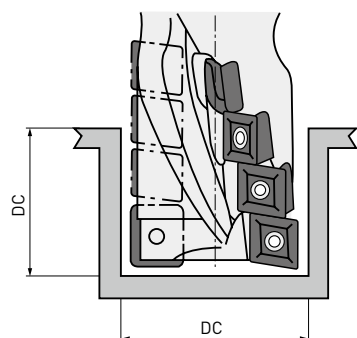
INSERTS

Material	P	Steel	●	●	●	●	Cutting Conditions:						
	M	Stainless Steel	●	●	●	●	● : Stable Cutting ● : General Cutting						
	K	Cast Iron	✖			✖	✖ : Unstable Cutting Honing: E = Round						
Shape	Order Number	Class	Honing	F7030	VP15TF	UP20M	UTi20T	LE	W1	IC	S	RE	Geometry
	CCMX083508EN-A	M	E	●		★	★	-	-	7.94	3.5	0.8	
	CCMX09T308EN-A	M	E	●	●	★		-	-	9.525	3.97	0.8	
 Strong Cutting Edge	CCMX09T308EN-B	M	E	●			★	-	-	9.525	3.97	0.8	
	ZCMX083508ER-A	M	E	●			★	10.4	7.94	-	3.5	0.8	
	ZCMX09T308ER-A	M	E	●	●	●	★	12	9.525	-	3.97	0.8	
 Strong Cutting Edge	ZCMX09T308ER-B	M	E	●		★	★	12	9.525	-	3.97	0.8	

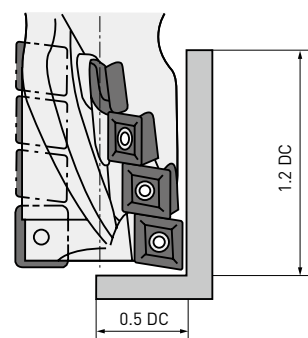
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RECOMMENDED CUTTING CONDITIONS

Cutting Mode A : Slot Milling (Standard Cutting Length Type)



Cutting Mode B : Shoulder Milling (Standard Cutting Length Type)

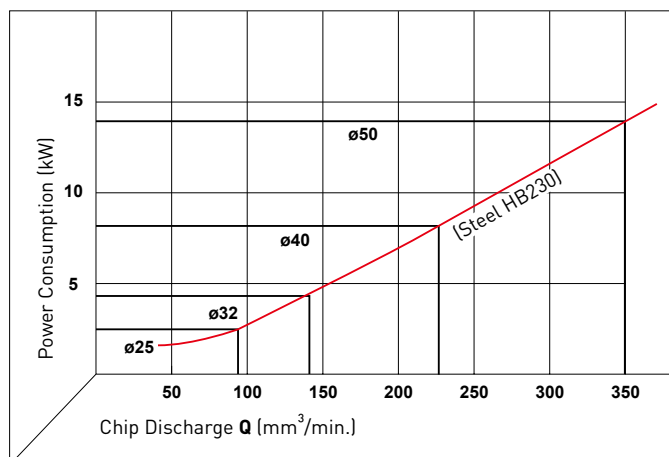


Material	Hardness	Grade	Cutting Mode	Vc	Vf		
					Ø 25 mm	Ø 32 mm	Ø 40 mm
P	Mild Steel	≤ 180HB	VP15TF A	180 (100–250)	120 (100–140)	120 (100–140)	120 (100–140)
			VP15TF B	180 (100–250)	200 (180–220)	200 (180–220)	230 (200–250)
	Carbon Steel	180–280HB	VP15TF A	180 (100–250)	120 (100–140)	120 (100–140)	140 (120–150)
			VP15TF B	180 (100–250)	150 (120–180)	150 (120–180)	180 (150–200)
	Alloy Steel	280–350HB	VP15TF A	180 (100–250)	100 (80–120)	100 (80–120)	130 (100–150)
			VP15TF B	180 (100–250)	120 (100–140)	120 (100–140)	150 (120–180)
	High Alloy Steel	200–280HB	VP15TF A	140 (100–180)	100 (80–120)	100 (80–120)	130 (100–150)
			VP15TF B	140 (100–180)	120 (100–140)	120 (100–140)	150 (120–180)
M	Stainless Steel	≤200HB	VP15TF A	150 (100–200)	70 (50–90)	70 (50–90)	70 (50–90)
			VP15TF B	150 (100–200)	100 (80–120)	100 (80–120)	120 (100–140)
K	Cast Iron	Tensile Strength ≤450MPa	VP15TF A	160 (100–220)	200 (180–220)	200 (180–220)	230 (200–250)
			VP15TF B	160 (100–220)	230 (200–250)	230 (200–250)	260 (240–280)

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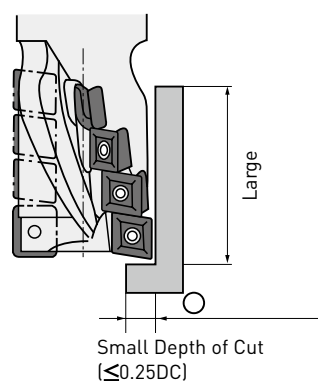
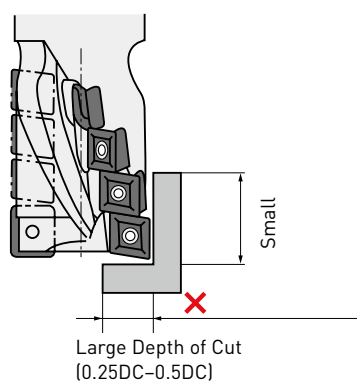
POWER CONSUMPTION

- Please use the chart below for reference, please select the conditions that suits the machines power.
- Chip Discharge Q ($\text{mm}^3/\text{min.}$) = Table Feed x Depth of Cut x Cutting Width / 1000



FOR USE OF LONG CUTTING LENGTH TYPE

- Since the overhang from the milling chuck is long, a large width of cut will cause chattering and tool breakage.
- Keep the width of cut small and the depth of cut in axial direction large. [See the following illustration.]



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