
DCCC

INDEXABLE END MILL

FOR DEEP SHOULDER MILLING AND SLOTTING



HIGH RIGIDITY
FOR HIGH
PERFORMANCE
AND RELIABILITY

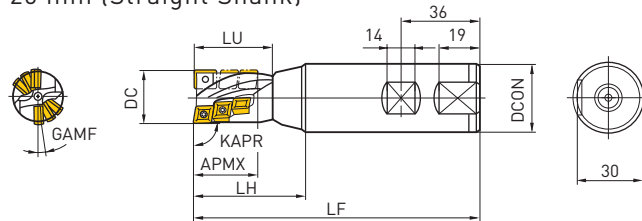
DCCC

INDEXABLE END MILL

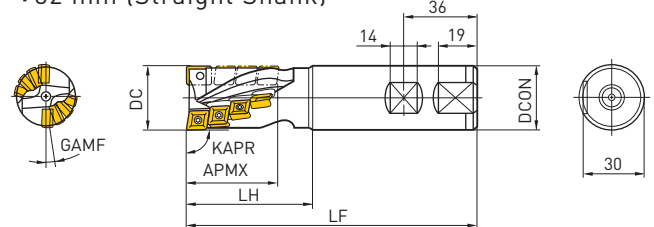
FOR DEEP SHOULDER MILLING AND SLOTTING



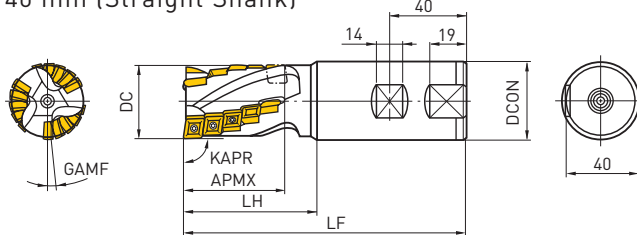
φ 25 mm (Straight Shank)



φ32 mm (Straight Shank)



φ 40 mm (Straight Shank)

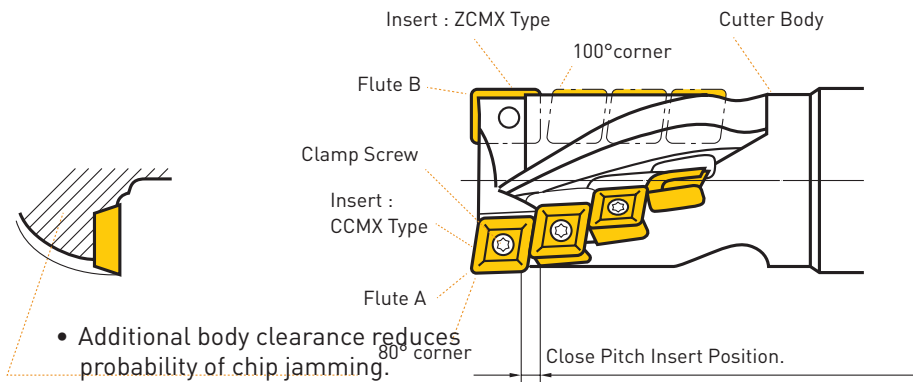


KAPR:90°

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

Right hand tool holder only.

DESIGN FEATURES OF DCCC TYPE END MILL

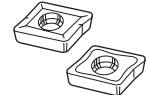


- All 4 cutting edges of CCMX insert are utilized, 80° corners in flute "A" and 100° corners on flute "B".

SPARE PARTS

Tool Holder Number

*



Clamp Screw

Wrench

Insert

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


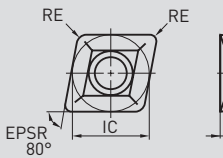
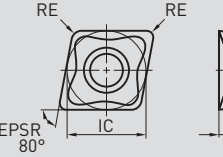

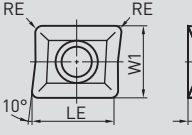
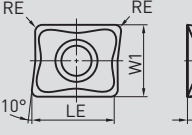
DCCR40

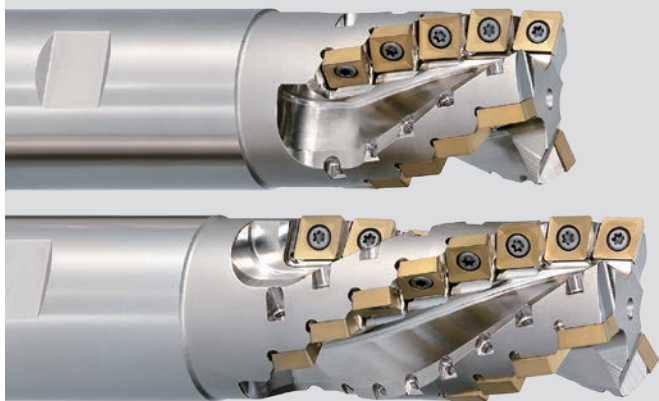
* Clamp Torque (N • m) : CS300890T=1.0, CS350990T=2.5

BENEFITS

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

INSERTS

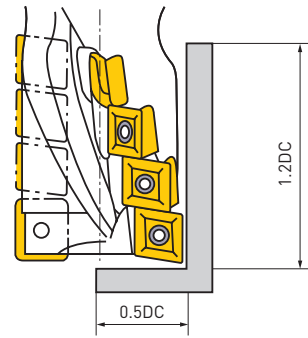
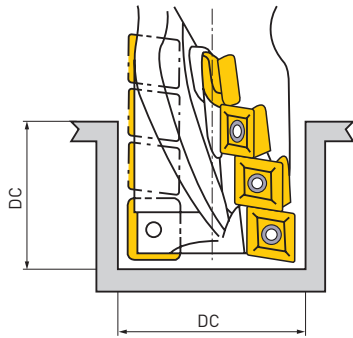
Material	P	Steel	●	●	●	●	Cutting Conditions:						
	M	Stainless Steel	●	●	●	●	●	●	●	●	●	●	●
	K	Cast Iron	+	+	+	+	+	+	+	+	+	+	+
Honing: E = Round													
Shape	Order Number	Class	Honing	F7030	VP15TF	UP20M	UT120T	LE	W1	IC	S	RE	Geometry
	CCMX083508EN-A	M	E	●	★	★	-	-	7.94	3.5	0.8		
	CCMX09T308EN-A	M	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		



RECOMMENDED CUTTING CONDITIONS

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

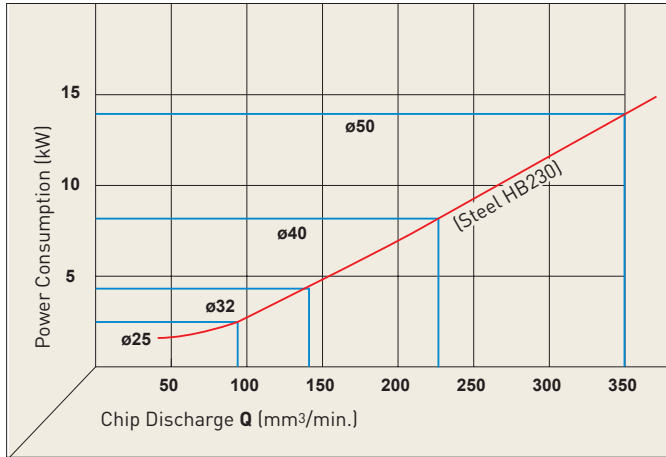
Cutting Mode B : Shoulder Milling (Standard Cutting Length Type)



Material	Hardness	Grade	Cutting Mode	Cutting Speed (m/min)	Table Feed (mm/min)		
					φ 25 mm	φ 32 mm	φ 40 mm
P Mild Steel	≤ 180HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	120 (100-140)
			B	180 (100-250)	200 (180-220)	200 (180-220)	230 (200-250)
Carbon Steel Alloy Steel	180-280HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	140 (120-150)
			B	180 (100-250)	150 (120-180)	150 (120-180)	180 (150-200)
	280-350HB	VP15TF	A	180 (100-250)	100 (80-120)	100 (80-120)	130 (100-150)
			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)
			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)
			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)
			B	160 (100-220)	230 (200-250)	230 (200-250)	260 (240-280)

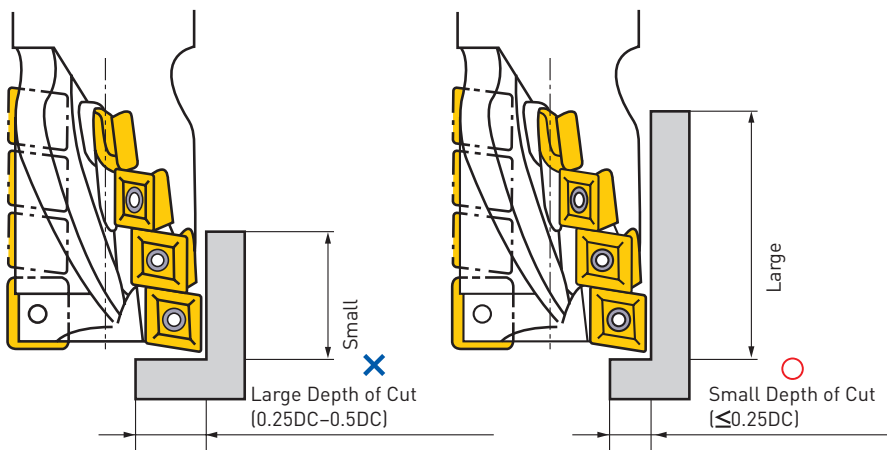
POWER CONSUMPTION

- Please use the chart below for reference, please select the conditions that suits the machines power.
- Chip Discharge Q (mm³/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.)



NOTES

A series of horizontal dashed lines for writing notes.

GERMANY

MMC HARTMETALL GMBH
Comeniusstraße 2. 40670 Meerbusch
Tel +49 2159 91890 Fax +49 2159 918966
E-Mail admin@mmchg.de

U.K.

MMC HARDMETAL U.K. LTD
Mitsubishi House, Galena Close. B77 4AS Tamworth
Tel +44 1827 312312 Fax +44 1827 312314
E-Mail sales@mitsubishicarbide.co.uk

SPAIN

MITSUBISHI MATERIALS ESPAÑA, S.A.
Calle Emperador. 46136 Museros/Valencia
Tel +34 96 144 1711 Fax +34 96 144 3786
E-Mail mme@mmevalencia.com

FRANCE

MMC METAL FRANCE S.A.R.L.
6, Rue Jacques Monod 91400 Orsay
Tel +33 169 355353. Fax +33 169 355350
E-Mail mmfsales@mmc-metal-france.fr

ITALY

MMC ITALIA S.R.L.
Via Montefeltro 6/A, 20156 Milano
Tel +39 02 93 77031 Fax +39 02 93 589093
E-Mail info@mmc-italia.it

RUSSIA

MITSUBISHI HARDMETAL 000 LTD.
Electrozavodskaya St. 24, build.3, 107023 Moscow
Tel +7 495 7255885 Fax +7 495 9813973
E-Mail info@mmc-carbide.ru

POLAND

MMC HARDMETAL POLAND SP. Z O.O
Al. Armii Krajowej 61, 50-541 Wrocław
Tel +48 71335 1620 Fax +48 71335 1621
E-Mail sales@mitsubishicarbide.com.pl

TURKEY

MMC HARTMETALL GMBH ALMANYA - İZMİR MERKEZ ŞUBESİ
Adalet Mahallesi Anadolu Caddesi No: 41-1 / 15001 35580 Bayraklı / İzmir
Tel. +90 232 5015000 Fax +90 232 5015007
E-Mail info@mmchg.com.tr

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