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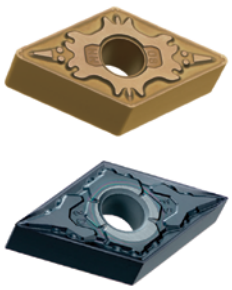

FREE CUTTER PROMO

SEE PAGES 2-4

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PROMOTION 2023-2024

DIAEDGE

MVX INDEXABLE DRILL PROMO

GET 1 DRILL BODY & 20 INSERTS

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SEE PAGE 8

PROMOTION ENDS MARCH 31, 2024

PROMO CODE: PROMOMVX-US

Drill Diameter	xD	PART#	Drill	Insert
0.687 (11/16")	2x	KIT-MVX0687X2C100-*	MVX0687X2C100	SOMX063005
	3x	KIT-MVX0687X3C100-*	MVX0687X3C100	
	4x	KIT-MVX0687X4C100-*	MVX0687X4C100	
	5x	KIT-MVX0687X5C100-*	MVX0687X5C100	
	6x	KIT-MVX0687X6C100-*	MVX0687X6C100	
0.750 (3/4")	2x	KIT-MVX0750X2C100-*	MVX0750X2C100	
	3x	KIT-MVX0750X3C100-*	MVX0750X3C100	
	4x	KIT-MVX0750X4C100-*	MVX0750X4C100	
	5x	KIT-MVX0750X5C100-*	MVX0750X5C100	
	6x	KIT-MVX0750X6C100-*	MVX0750X6C100	
0.812 (13/16")	2x	KIT-MVX0812X2C100-*	MVX0812X2C100	SOMX073505
	3x	KIT-MVX0812X3C100-*	MVX0812X3C100	
	4x	KIT-MVX0812X4C100-*	MVX0812X4C100	
	5x	KIT-MVX0812X5C100-*	MVX0812X5C100	
	6x	KIT-MVX0812X6C100-*	MVX0812X6C100	
0.875 (7/8")	2x	KIT-MVX0875X2C100-*	MVX0875X2C100	SOMX073505
	3x	KIT-MVX0875X3C100-*	MVX0875X3C100	
	4x	KIT-MVX0875X4C100-*	MVX0875X4C100	
	5x	KIT-MVX0875X5C100-*	MVX0875X5C100	
	6x	KIT-MVX0875X6C100-*	MVX0875X6C100	
0.937 (15/16")	2x	KIT-MVX0937X2C100-*	MVX0937X2C100	SOMX084005
	3x	KIT-MVX0937X3C100-*	MVX0937X3C100	
	4x	KIT-MVX0937X4C100-*	MVX0937X4C100	
	5x	KIT-MVX0937X5C100-*	MVX0937X5C100	
	6x	KIT-MVX0937X6C100-*	MVX0937X6C100	
1"	2x	KIT-MVX1000X2C125-*	MVX1000X2C125	SOMX084005
	3x	KIT-MVX1000X3C125-*	MVX1000X3C125	
	4x	KIT-MVX1000X4C125-*	MVX1000X4C125	
	5x	KIT-MVX1000X5C125-*	MVX1000X5C125	
	6x	KIT-MVX1000X6C125-*	MVX1000X6C125	
1.062 1-1/16")	2x	KIT-MVX1062X2C125-*	MVX1062X2C125	SOMX084005
	3x	KIT-MVX1062X3C125-*	MVX1062X3C125	
	4x	KIT-MVX1062X4C125-*	MVX1062X4C125	
	5x	KIT-MVX1062X5C125-*	MVX1062X5C125	
	6x	KIT-MVX1062X6C125-*	MVX1062X6C125	

Drill Diameter	xD	PART#	Drill	Insert
1.125 (1-1/8")	2x	KIT-MVX1125X2C125-*	MVX1125X2C125	SOMX094506
	3x	KIT-MVX1125X3C125-*	MVX1125X3C125	
	4x	KIT-MVX1125X4C125-*	MVX1125X4C125	
	5x	KIT-MVX1125X5C125-*	MVX1125X5C125	
	6x	KIT-MVX1125X6C125-*	MVX1125X6C125	
1.187 (1-3/16")	2x	KIT-MVX1187X2C125-*	MVX1187X2C125	SOMX094506
	3x	KIT-MVX1187X3C125-*	MVX1187X3C125	
	4x	KIT-MVX1187X4C125-*	MVX1187X4C125	
	5x	KIT-MVX1187X5C125-*	MVX1187X5C125	
	6x	KIT-MVX1187X6C125-*	MVX1187X6C125	
1.250 (1-1/4")	2x	KIT-MVX1250X2C150-*	MVX1250X2C150	SOMX094506
	3x	KIT-MVX1250X3C150-*	MVX1250X3C150	
	4x	KIT-MVX1250X4C150-*	MVX1250X4C150	
	5x	KIT-MVX1250X5C150-*	MVX1250X5C150	
	6x	KIT-MVX1250X6C150-*	MVX1250X6C150	
1.312 (1-5/16")	2x	KIT-MVX1312X2C150-*	MVX1312X2C150	SOMX115506
	3x	KIT-MVX1312X3C150-*	MVX1312X3C150	
	4x	KIT-MVX1312X4C150-*	MVX1312X4C150	
	5x	KIT-MVX1312X5C150-*	MVX1312X5C150	
	6x	KIT-MVX1312X6C150-*	MVX1312X6C150	
1.375 (1-3/8")	2x	KIT-MVX1375X2C150-*	MVX1375X2C150	SOMX115506
	3x	KIT-MVX1375X3C150-*	MVX1375X3C150	
	4x	KIT-MVX1375X4C150-*	MVX1375X4C150	
	5x	KIT-MVX1375X5C150-*	MVX1375X5C150	
	6x	KIT-MVX1375X6C150-*	MVX1375X6C150	
1.437 (1-7/16")	2x	KIT-MVX1437X2C150-*	MVX1412X2C150	SOMX115506
	3x	KIT-MVX1437X3C150-*	MVX1412X3C150	
	4x	KIT-MVX1437X4C150-*	MVX1412X4C150	
	5x	KIT-MVX1437X5C150-*	MVX1412X5C150	
	6x	KIT-MVX1437X6C150-*	MVX1412X6C150	
1.500 (1-1/2")	2x	KIT-MVX1500X2C150-*	MVX1500X2C150	SOMX115506
	3x	KIT-MVX1500X3C150-*	MVX1500X3C150	
	4x	KIT-MVX1500X4C150-*	MVX1500X4C150	
	5x	KIT-MVX1500X5C150-*	MVX1500X5C150	
	6x	KIT-MVX1500X6C150-*	MVX1500X6C150	
1.562 (1-9/16")	2x	KIT-MVX1562X2C150-*	MVX1562X2C150	SOMX115506
	3x	KIT-MVX1562X3C150-*	MVX1562X3C150	
	4x	KIT-MVX1562X4C150-*	MVX1562X4C150	
	5x	KIT-MVX1562X5C150-*	MVX1562X5C150	
	6x	KIT-MVX1562X6C150-*	MVX1562X6C150	

Drill Diameter	xD	PART#	Drill	Insert
1.625 (1-5/8")	2x	KIT-MVX1625X2C150-*	MVX1625X2C150	SOMX136008
	3x	KIT-MVX1625X3C150-*	MVX1625X3C150	
	4x	KIT-MVX1625X4C150-*	MVX1625X4C150	
	5x	KIT-MVX1625X5C150-*	MVX1625X5C150	
	6x	KIT-MVX1625X6C150-*	MVX1625X6C150	
1.687 (1-11/16")	2x	KIT-MVX1687X2C150-*	MVX1687X2C150	SOMX136008
	3x	KIT-MVX1687X3C150-*	MVX1687X3C150	
	4x	KIT-MVX1687X4C150-*	MVX1687X4C150	
	5x	KIT-MVX1687X5C150-*	MVX1687X5C150	
	6x	KIT-MVX1687X6C150-*	MVX1687X6C150	
1.750 (1-3/4")	2x	KIT-MVX1750X2C150-*	MVX1750X2C150	SOMX136008
	3x	KIT-MVX1750X3C150-*	MVX1750X3C150	
	4x	KIT-MVX1750X4C150-*	MVX1750X4C150	
	5x	KIT-MVX1750X5C150-*	MVX1750X5C150	
1.812 (1-13/16")	2x	KIT-MVX1812X2C150-*	MVX1812X2C150	SOMX136008
	3x	KIT-MVX1812X3C150-*	MVX1812X3C150	
	4x	KIT-MVX1812X4C150-*	MVX1812X4C150	
	5x	KIT-MVX1812X5C150-*	MVX1812X5C150	
1.875 (1-7/8")	2x	KIT-MVX1875X2C150-*	MVX1875X2C150	SOMX136008
	3x	KIT-MVX1875X3C150-*	MVX1875X3C150	
	4x	KIT-MVX1875X4C150-*	MVX1875X4C150	
	5x	KIT-MVX1875X5C150-*	MVX1875X5C150	
1.937 (1-15/16")	2x	KIT-MVX1937X2C150-*	MVX1937X2C150	SOMX136008
	3x	KIT-MVX1937X3C150-*	MVX1937X3C150	
	4x	KIT-MVX1937X4C150-*	MVX1937X4C150	
	5x	KIT-MVX1937X5C150-*	MVX1937X5C150	
2"	2x	KIT-MVX2000X2C150-*	MVX2000X2C150	SOMX136008
	3x	KIT-MVX2000X3C150-*	MVX2000X3C150	
	4x	KIT-MVX2000X4C150-*	MVX2000X4C150	
	5x	KIT-MVX2000X5C150-*	MVX2000X5C150	
2.125 (2-1/8")	2x	KIT-MVX2125X2C150-*	MVX2125X2C150	SOMX136008
	3x	KIT-MVX2125X3C150-*	MVX2125X3C150	
	4x	KIT-MVX2125X4C150-*	MVX2125X4C150	
	5x	KIT-MVX2125X5C150-*	MVX2125X5C150	
2.250 (2-1/4")	2x	KIT-MVX2250X2C150-*	MVX2250X2C150	SOMX187008
	3x	KIT-MVX2250X3C150-*	MVX2250X3C150	
	4x	KIT-MVX2250X4C150-*	MVX2250X4C150	
	5x	KIT-MVX2250X5C150-*	MVX2250X5C150	
2.375 (2-3/8")	2x	KIT-MVX2375X2C150-*	MVX2375X2C150	SOMX187008
	3x	KIT-MVX2375X3C150-*	MVX2375X3C150	
	4x	KIT-MVX2375X4C150-*	MVX2375X4C150	
	5x	KIT-MVX2375X5C150-*	MVX2375X5C150	
2.500 (2-1/2")	2x	KIT-MVX2500X2C150-*	MVX2500X2C150	SOMX187008
	3x	KIT-MVX2500X3C150-*	MVX2500X3C150	
	4x	KIT-MVX2500X4C150-*	MVX2500X4C150	
	5x	KIT-MVX2500X5C150-*	MVX2500X5C150	

* DESIGNATES THE INSERTS' GRADES: **"C"** = (10) MC5020 (10) VP15TF **"S"** = (10) MC1020 & (10) VP15TF **"VP"** = (20) VP15TF

FREE CUTTERS PROMO

WSX 445

45° CUTTERS

SEE PAGE 19

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	WSX445UR2403FA20M	3	30
1.5	WSX445UR2404FA20M	4	30
2	WSX445UR3203FA20M	3	30
2	WSX445UR3204FA20M	4	40
2.5	WSX445UR4004FA20M	4	40
2.5	WSX445UR4005FA20M	5	40
3	WSX445UR4804FA20M	4	40
3	WSX445UR4806FA20M	6	50

SEE PAGE 19

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	WSX445UR1503SA	3	30
1.5	WSX445UR1504SA	4	30
2	WSX445UR0203AA	3	30
2	WSX445UR0205AA	5	40
2.5	WSX445UR2504CA	4	40
2.5	WSX445UR2505CA	5	40
2.5	WSX445UR2506CA	6	40
3	WSX445UR0304CA	4	40
3	WSX445UR0306CA	6	50
3	WSX445UR0308CA	8	50
4	WSX445UR0405EA	5	50
4	WSX445UR0407EA	7	50
4	WSX445UR0410EA	10	60
5	WSX445UR0506EA	6	60
5	WSX445UR0508EA	8	60
5	WSX445UR0512EA	12	80
6	WSX445UR0607EA	7	70
6	WSX445UR0610EA	10	80
6	WSX445UR0616EA	16	100
8	WSX445UR0808MN	8	90
8	WSX445UR0812MN	12	110
8	WSX445UR0820MN	20	140
10	WSX445UR1010MN	10	110
10	WSX445UR1014MN	14	120
12	WSX445UR1214MN	14	180

AQX

MULTI-FUNCTIONAL INDEXABLE END-MILLS

STANDARD FLUTE

SEE PAGE 13

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
.625	AQXUR102WA10S	2	20
.750	AQXUR122WA12S	2	20
1.000	AQXUR162WA16S	2	20
1.250	AQXUR202WA20S	2	20
.625	AQXUR102SA10L	2	20
.672	AQXUR112SA10L	2	20
.750	AQXUR122SA12L	2	20
.797	AQXUR132SA12L	2	20
1.000	AQXUR162SA16L	2	20
1.047	AQXUR172SA16L	2	20
1.250	AQXUR202SA20L	2	20
1.297	AQXUR212SA20L	2	20

EXTENDED FLUTE

SEE PAGE 13

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
.750	AQXUR124WA12S	4	20
1.000	AQXUR164WA16S	4	20
1.250	AQXUR204WA20S	4	20
.750	AQXUR124SA12L	4	30
.797	AQXUR134SA12L	4	30
1.000	AQXUR164SA16L	4	20
1.047	AQXUR174SA16L	4	20
1.250	AQXUR204SA20L	4	20
1.297	AQXUR214SA20L	4	30

ARP5

CUTTERS FOR
- HI-TEMP ALLOYS
- EXOTICS
- TITANIUM

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	ARP5UPR1603FA16M	3	50
1	ARP5UPR1602SA16L	2	40
1.25	ARP5UPR2004FA20M	4	50
1.25	ARP5UPR2003SA20L	3	50

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	ARP5UR1504SA	4	60
1.5	ARP5UR1505SA	5	60
2	ARP5UR0206AA	6	60
2	ARP5UR0207AA	7	60
2.5	ARP5UR2507CA	7	70
2.5	ARP5UR2508CA	8	70

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	ARP5UPR1603AM1235	3	50
1.25	ARP5UPR2004AM1640	4	50

MITSUBISHI

FREE CUTTERS PROMO

DIAEDGE

ARP6

CUTTERS FOR
- HI-TEMP ALLOYS
- EXOTICS
- TITANIUM

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.25	ARP6UPR2003FA20M	3	40
1.25	ARP6UPR2002SA20L	2	30
1.5	ARP6UPR2004FA20M	4	40
1.5	ARP6UPR2403SA20L	3	40
2	ARP6UPR3205FA24M	5	50
2	ARP6UPR3204SA24L	4	50

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	ARP6UPR1504SA	4	40
2	ARP6UPR0205SA	5	50
2	ARP6UPR0206SA	6	50
2.5	ARP6UPR2506CA	6	50
2.5	ARP6UPR2507CA	7	50
3	ARP6UPR0308CA	8	60
3	ARP6UPR0309CA	9	60
4	ARP6UPR0409EA	9	70
4	ARP6UPR0411EA	11	70

SEE PAGE 20

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.25	ARP6UPR2003AM1640	3	40
1.5	ARP6UPR2004AM1640	4	40

ASPX

CUTTERS FOR
- TITANIUM
- HI-TEMP ALLOYS

SEE PAGE 18

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	ASPX4UR2.0003AA21A15	15	80
2.5	ASPX4UR2.5004CA25A24	24	110
3	ASPX4UR3.0005DA29A35	35	160

WITH HSK SHANK

SEE PAGE 18

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
3	ASPX4UR485H100A050SA	60	350
3	ASPX4UR485H125A050SA	60	400

ASX 400

90° CUTTERS
INDEXABLE END-MILLS

Cutter Dia.	Cutter Part#	Shank	# of Inserts	# of Inserts Required for Free Cutter
1.25	ASX400R202W20	1.25	2	20
1.5	ASX400R243W20	1.25	3	20
2	ASX400R324W20	1.25	4	20

SHOULDER MILLS

SEE PAGE 18

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	ASX400R0203	3	20
2	ASX400R0204	4	20
2	ASX400R0205	5	20
2.5	ASX400R2504	4	20
2.5	ASX400R2505	5	20
2.5	ASX400R2506	6	20
3	ASX400R0304C	4	20
3	ASX400R0306C	6	30
3	ASX400R0308C	8	30
4	ASX400R0405E	5	30
4	ASX400R0407E	7	30
4	ASX400R0410E	10	40
5	ASX400R0506E	6	40
5	ASX400R0508E	8	40
5	ASX400R0512E	12	50
6	ASX400R0608E	8	50
6	ASX400R0612E	12	50
6	ASX400R0615E	15	60
8	ASX400R0810M	10	80
8	ASX400R0816M	16	90
8	ASX400R0819M	19	90
10	ASX400R1012M	12	90
10	ASX400R1018M	18	90
10	ASX400R1022M	22	100

ASX 445

45° FACE MILLS

SEE PAGE 18

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	ASX445R0204	4	20
2	ASX445R0205	5	20
2.5	ASX445R2504	4	20
2.5	ASX445R2505	5	20
3	ASX445R0304C	4	20
3	ASX445R0306C	6	30
3	ASX445R0308C	8	30
4	ASX445R0405E	5	30
4	ASX445R0407E	7	30
4	ASX445R0410E	10	40
5	ASX445R0506E	6	40
5	ASX445R0508E	8	40
5	ASX445R0512E	12	50
6	ASX445R0607E	7	50
6	ASX445R0610E	10	60
6	ASX445R0616E	16	70
8	ASX445R0808M	8	60
8	ASX445R0812M	12	70
8	ASX445R0820M	20	80
10	ASX445R1010M	10	70
10	ASX445R1014M	14	80
10	ASX445R1024M	24	90

BRP

MILLING CUTTERS
USING ROUND INSERTS

SEE PAGE 19

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	BRP6UPR1503X	3	30
2	BRP6UPR0204	4	40
2.5	BRP6UPR2505	5	40
3	BRP6UPR0306C	6	50
4	BRP6UPR0407E	7	60

AXD4000
AXD7000

CUTTERS FOR
- ALUMINUM
- DIFFICULT TO MACHINE METALS

SEE PAGE 18

AXD4000

Cutter Dia.	Insert Corner Radius	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	.016-.125	AXD4000UR162SA12SA	2	20
1	.016-.125	AXD4000UR162SA16LA	2	20
1	.016-.125	AXD4000UR162SA16SA	2	20
1	.157-.197	AXD4000UR162SA12SB	2	20
1	.157-.197	AXD4000UR162SA16LB	2	20
1	.157-.197	AXD4000UR162SA16SB	2	20
1.25	.016-.125	AXD4000UR202SA20LA	2	20
1.25	.016-.125	AXD4000UR202SA20SA	2	20
1.25	.157-.197	AXD4000UR202SA20LB	2	20
1.25	.157-.197	AXD4000UR202SA20SB	2	20
1.5	.016-.125	AXD4000UR243SA20LA	3	20
1.5	.016-.125	AXD4000UR243SA20SA	3	20
1.5	.157-.197	AXD4000UR243SA20LB	3	20
1.5	.157-.197	AXD4000UR243SA20SB	3	20

AXD7000

Cutter Dia.	Insert Corner Radius	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.25	.031-.125	AXD7000UR202SA20SA	2	10
1.25	.157-.197	AXD7000UR202SA20SB	2	10
1.5	.031-.125	AXD7000UR402SA24SA	4	10
1.5	.157-.197	AXD7000UR402SA24SB	4	10

ARBOR MOUNTED CUTTERS

SEE PAGE 18

AXD4000

Cutter Dia.	Insert Corner Radius	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	.016-.125	AXD4000UR1502A	2	20
1.5	.016-.125	AXD4000UR1503A	3	20
1.5	.157-.197	AXD4000UR1503B	3	20
2	.016-.125	AXD4000UR0202A	2	20
2	.016-.125	AXD4000UR0203A	3	20
2	.016-.125	AXD4000UR0204A	4	20
2	.016-.125	AXD4000AUR.0004AAD	4	20
2	.157-.197	AXD4000UR0204B	4	20
2	.157-.197	AXD4000AUR.0004AAE	4	20
2.5	.016-.125	AXD4000UR02504CA	4	20
3	.016-.125	AXD4000UR0303CA	3	30
3	.016-.125	AXD4000UR0303DA	3	30
3	.016-.125	AXD4000UR0305CA	5	30
3	.016-.125	AXD4000UR0305DA	5	30
3	.157-.197	AXD4000UR0303CB	3	20
3	.157-.197	AXD4000UR0305DB	5	30
3	.157-.197	AXD4000UR0305CB	5	30
4	.016-.125	AXD4000UR0404EA	4	30
4	.016-.125	AXD4000UR0406EA	6	30
5	.016-.125	AXD4000UR0505EA	5	30
5	.016-.125	AXD4000UR0507EA	7	30

AXD7000

Cutter Dia.	Insert Corner Radius	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	.031-.125	AXD7000UR0203A	3	20
2	.157-.197	AXD7000UR0203B	3	20
3	.031-.125	AXD7000UR0303DA	3	20
3	.157-.197	AXD7000UR0303DB	3	20
5	.031-.125	AXD7000UR0405EA	5	30
5	.031-.125	AXD7000UR0506EA	6	30

BRP

INDEXABLE END-MILLS

USING ROUND INSERTS

SEE PAGE 19

Series	Cutter Dia.	Cutter Part#	Cutter Length	# of Inserts	# of Inserts Required for Free Cutter
BRP3	0.5	BRP3UNR081W08	2.78	1	20
	0.5	BRP3UNR081LW08	6.00	1	20
	0.625	BRP3UNR101W10	3.50	1	20
	0.625	BRP3UNR101LW10	6.00	1	20
	0.75	BRP3UNR122W12	4.00	2	20
	0.75	BRP3UNR122ELW12	10.00	2	30
	1	BRP3UNR163W16	4.50	3	30
	1	BRP3UNR163ELW16	10.00	3	40
BRP4	0.625	BRP4UNR101W10	3.50	1	20
	0.625	BRP4UNR101LW10	6.00	1	20
	0.75	BRP4UNR121W12	4.00	1	20
	0.75	BRP4UNR121LW12	7.00	1	20
	1	BRP4UNR162W16	4.50	2	20
	1	BRP4UNR162ELW16	10.00	2	30
	1.25	BRP4UNR203W20	5.00	3	30
	1.25	BRP4UNR203ELW20	12.00	3	40
BRP6	1.25	BRP6UNR202W20	5.00	2	20
	1.25	BRP6UNR202ELS20	12.00	2	30
	1.5	BRP6UNR243W20	5.00	3	30
	1.5	BRP6UNR243ELS20	12.00	3	30
	2	BRP6UNR324W20	5.00	4	40
	2	BRP6UNR324ELS20	12.00	4	40
	2.5	BRP6UNR405W20	5.00	5	40

MITSUBISHI

FREE CUTTERS PROMO

DIAEDGE

VPX CUTTERS WITH TANGENTIAL INSERTS

INDEXABLE END MILLS

SEE PAGE 16

VPX200

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
.0625	VPX200UR1002FA10S	2	20
.0625	VPX200UR1002SA10L	2	20
.0625	VPX200UR1002SA10S	2	20
0.750	VPX200UR1202FA10S	2	20
0.750	VPX200UR1202FA12S	2	20
0.750	VPX200UR1202SA10S	2	20
0.750	VPX200UR1202SA12L	2	20
0.750	VPX200UR1202SA12S	2	20
0.750	VPX200UR1203FA10S	3	20
0.750	VPX200UR1203FA12S	3	20
0.750	VPX200UR1203SA10S	3	20
0.750	VPX200UR1203SA12S	3	20
0.875	VPX200UR1402SA12L	2	20
1	VPX200UR1603FA12S	3	20
1	VPX200UR1603FA16S	3	20
1	VPX200UR1603SA12L	3	20
1	VPX200UR1603SA12S	3	20
1	VPX200UR1603SA16L	3	20
1	VPX200UR1603SA16S	3	20
1	VPX200UR1604FA12S	4	20
1	VPX200UR1604FA16S	4	20
1	VPX200UR1604SA12S	4	20
1	VPX200UR1604SA16S	4	20
1.25	VPX200UR1803SA16L	3	20
1.250	VPX200UR1.2503SA	3	20
1.250	VPX200UR2003FA16S	3	20
1.250	VPX200UR2003FA20S	3	20
1.250	VPX200UR2003SA16L	3	20
1.250	VPX200UR2003SA16L	3	20
1.250	VPX200UR2003SA20L	3	20
1.250	VPX200UR2003SA20S	3	20
1.250	VPX200UR2004FA20S	4	20
1.250	VPX200UR2004SA20S	4	20
1.250	VPX200UR2004FA16S	5	20
1.250	VPX200UR2005FA20S	5	20
1.250	VPX200UR2005SA16S	5	20
1.250	VPX200UR2005SA20S	5	20
1.500	VPX200UR2404FA20S	4	20
1.500	VPX200UR2404SA20L	4	30
1.500	VPX200UR2404SA20S	4	20
1.500	VPX200UR2406FA20S	6	30
1.500	VPX200UR2406SA20S	6	30

VPX300

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	VPX300UR1602SA16S	2	20
1	VPX300UR1602SA16L	2	20
1	VPX300UR1602FA16S	2	20
1.125	VPX300UR1802SA16L	2	20
1.250	VPX300UR2002SA20S	2	20
1.250	VPX300UR2002SA16S	2	20
1.250	VPX300UR2002FA20S	2	20
1.250	VPX300UR2002FA16S	2	20
1.250	VPX300UR2003SA20S	3	20
1.250	VPX300UR2003SA20L	3	20
1.250	VPX300UR2003SA16S	3	20
1.250	VPX300UR2003SA16L	3	20
1.250	VPX300UR2003FA20S	3	20
1.250	VPX300UR2003FA16S	3	20
1.5	VPX300UR2402SA20S	2	20
1.5	VPX300UR2402FA20S	2	20
1.5	VPX300UR2403SA20S	3	20
1.5	VPX300UR2403SA20L	3	20
1.5	VPX300UR2403FA20S	3	20

MILLING CUTTERS

SEE PAGE 16

VPX200

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.250	VPX200UR1.2505SA	5	30
1.500	VPX200UR1.5004AA	4	20
1.500	VPX200UR1.5004SA	4	20
1.500	VPX200UR1.5006AA	6	30
1.500	VPX200UR1.5006SA	6	30
2	VPX200UR2.0005AA	5	30
2	VPX200UR2.0007AA	7	30
2.500	VPX200UR2.5006CA	6	30
2.500	VPX200UR2.5009CA	9	40

VPX300

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	VPX300UR1.5003SA	3	20
1.5	VPX300UR1.5004SA	4	20
2	VPX300UR2.0004AA	4	20
2	VPX300UR2.0006AA	6	30
2.5	VPX300UR2.5006AA	6	30
2.5	VPX300UR2.5008AA	8	30
3	VPX300UR3.0007AA	7	30
3	VPX300UR3.0010AA	10	40

WJX HIGH FEED CUTTERS

SEE PAGE 15

INDEXABLE END MILLS

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	WJX09UR1602FA16S	2	20
1	WJX09UR1602SA16L	2	20
1	WJX09UR1603FA16S	3	20
1	WJX09UR1603FA16L	3	20
1.125	WJX09UR1802FA16S	2	20
1.125	WJX09UR1802SA16L	2	20
1.125	WJX09UR1803FA16S	3	30
1.125	WJX09UR1803SA16L	3	30
1.25	WJX09UR2002FA20S	2	20
1.25	WJX09UR2002SA20L	2	20
1.25	WJX09UR2003FA20S	3	30
1.25	WJX09UR2003SA20L	3	30
1.5	WJX09UR2403FA20S	3	30
1.5	WJX09UR2403SA20L	3	30
1.5	WJX09UR2404FA20S	4	30
1.5	WJX09UR2404SA20L	4	30

MODULAR MILLING HEADS SCREW ON TYPE

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1.5	WJX09UR1.5004SA	4	30
2	WJX09UR2.0004AA	4	30
2	WJX09UR2.0006AA	6	30
2.5	WJX09UR2.5005CA	5	40
2.5	WJX09UR2.5007CA	7	40

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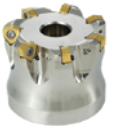
MILLING CUTTERS WJX09



Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	WJX09UR1602AM1235	2	20
1	WJX09UR1603AM1235	3	20
1.125	WJX09UR1802AM1235	2	20
1.125	WJX09UR1803AM1235	3	30
1.25	WJX09UR2002AM1645	2	20
1.25	WJX09UR2003AM1645	3	30
1.375	WJX09UR2202AM1645	2	20
1.375	WJX09UR2203AM1645	3	30
1.375	WJX09UR2204AM1645	4	30

WJX14

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	WJX14UR2.0003AA	3	20
2	WJX14UR2.0004AA	4	20
2.5	WJX14UR2.5004CA	4	20
2.5	WJX14UR2.5005CA	5	30
3	WJX14UR3.0005CA	5	30
3	WJX14UR3.0005DA	5	30
3	WJX14UR3.0006CA	6	30
3	WJX14UR3.0006DA	6	30
4	WJX14UR4.0006EA	6	30
4	WJX14UR4.0007EA	7	40
5	WJX14UR5.0007EA	7	40
5	WJX14UR5.0009EA	9	40
6	WJX14UR6.0009EA	9	50

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VPX MODULAR MILLING HEADS SCREW-ON TYPE

VPX200

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
0.750	VPX200UR1202AM1030	2	20
0.750	VPX200UR1203AM1030	3	20
0.875	VPX200UR1402AM1030	2	20
0.875	VPX200UR1403AM1030	3	20
1	VPX200UR1603AM1235	3	20
1	VPX200UR1604AM1235	4	20
1.25	VPX200UR1803AM1235	3	20
1.25	VPX200UR1804AM1235	4	20
1.250	VPX200UR2003AM1640	3	20
1.250	VPX200UR2004AM1640	4	20
1.250	VPX200UR2005AM1640	5	30
1.375	VPX200UR2203AM1640	3	20
1.375	VPX200UR2205AM1640	5	30
1.500	VPX200UR2404AM1640	4	20
1.500	VPX200UR2406AM1640	6	30
2	VPX200UR1002AM0830	2	20

VPX300

Cutter Dia.	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
1	VPX300UR1602AM1235	2	20
1.125	VPX300UR1802AM1235	2	20
1.250	VPX300UR2002AM1235	2	20
1.25	VPX300UR2003AM1235	3	20
1.375	VPX300UR2202AM1235	2	20
1.375	VPX300UR2203AM1235	3	20
1.5	VPX300UR2403AM1235	3	20
1.5	VPX300UR2404AM1235	4	20

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WWX MILLING CUTTERS INDEXABLE END MILLS

SEE PAGE 17

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	WWX400UR3203FA20M	3	30
2	WWX400UR3204FA20M	4	30
2.5	WWX400UR4003FA20M	3	30
2.5	WWX400UR4004FA20M	4	40
2.5	WWX400UR4005FA20M	5	40
3	WWX400UR4804FA20M	4	40
3	WWX400UR4805FA20M	5	40
3	WWX400UR4807FA20M	7	50

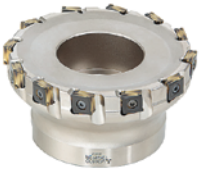
MILLING CUTTERS

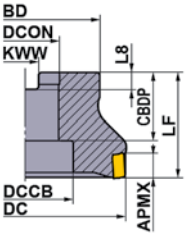
SEE PAGE 17

Cutter Diameter	Cutter Part#	# of Inserts	# of Inserts Required for Free Cutter
2	WWX400UR2.0003AA	3	30
2	WWX400UR2.0004AA	4	30
2.5	WWX400UR2.5003CA	3	30
2.5	WWX400UR2.5004CA	4	30
2.5	WWX400UR2.5005CA	5	40
3	WWX400UR3.0004CA	4	40
3	WWX400UR3.0005CA	5	40
3	WWX400UR3.0007CA	7	50
4	WWX400UR4.0005CA	5	50
4	WWX400UR4.0007CA	7	50
4	WWX400UR4.0009EA	9	60
5	WWX400UR5.0006EA	6	60
5	WWX400UR5.0008EA	8	60
5	WWX400UR5.0012EA	12	70
6	WWX400UR6.0008EA	8	70
6	WWX400UR6.0010EA	10	80
6	WWX400UR6.0014EA	14	100
8	WWX400UR8.0010MN	10	100
8	WWX400UR8.0012MN	12	110
8	WWX400UR8.0016MN	16	120
10	WWX400UR10.0012MN	12	120
10	WWX400UR10.0014MN	14	130
10	WWX400UR10.0018MN	18	150

VOX 90° SHOULDER MILLING CUTTERS FOR MILLING CAST-IRON

APMX= .394"





INSERTS: SONX1206
WIPER INSERTS: WOEX1206

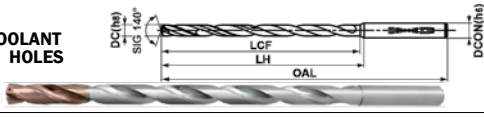
DC	Part#	# of Inserts	LF	DCON	KWW	# of Inserts Required for Free Cutter
2	VOX400UR0203C	3	2.00	1.00	0.375	30
2	VOX400UR0205C	5	2.00	1.00	0.375	40
2.5	VOX400UR2504C	3	2.00	1.00	0.375	40
2.5	VOX400UR2506C	6	2.00	1.00	0.375	50
2.5	VOX400UR2508C	8	2.00	1.00	0.375	50
3	VOX400UR0304C	4	2.00	1.00	0.375	50
3	VOX400UR0308C	8	2.00	1.00	0.375	50
3	VOX400UR0310C	10	2.00	1.00	0.375	50
4	VOX400UR0406E	6	2.00	1.50	0.625	60
4	VOX400UR0410E	10	2.00	1.50	0.625	60
4	VOX400UR0412E	12	2.00	1.50	0.625	70
5	VOX400UR0508E	8	2.00	1.50	0.625	70
5	VOX400UR0512E	12	2.00	1.50	0.625	70
5	VOX400UR0516E	16	2.00	1.50	0.625	80
6	VOX400UR0610F	10	2.50	2.00	0.750	80
6	VOX400UR0616F	16	2.50	2.00	0.750	80
6	VOX400UR0620F	20	2.50	2.00	0.750	90
8	VOX400UR0812F	12	2.50	2.50	1.000	100
8	VOX400UR0820F	20	2.50	2.50	1.000	110
8	VOX400UR0826F	16	2.50	2.50	1.000	120
10	VOX400UR1016F	16	2.50	2.50	1.000	120
10	VOX400UR1024F	24	2.50	2.50	1.000	130
10	VOX400UR1034F	34	2.50	2.50	1.000	150

MITSUBISHI DIAEDGE HIGH PERFORMANCE CARBIDE DRILLS

- COATED
- WITH OR WITHOUT COOLANT HOLES

MVS

- WITH COOLANT HOLES

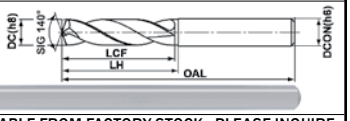


WITH COATED GRADE DP120

- PROVIDES BETTER WEAR RESISTANCE & TOOL LIFE
- LOW FRICTION PROVIDES BETTER PROTECTION FROM OXIDATION AT HIGHER TEMPERATURES

MVE

- WITHOUT COOLANT HOLES



- NOTE: MANY MORE SIZES AVAILABLE FROM FACTORY STOCK - PLEASE INQUIRE

DC (Dia.) mm	DC (Dia.) Dec.	DC (Dia.) Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
1.588	.0625	1/16	2	MVS0159X02S030	.327	2.689	3
			7	MVS0159X07S030	.642	2.689	3
			12	MVS0159X12S030	.957	2.689	3
			20	MVS0159X20S030	1.469	3.083	3
			25	MVS0159X25S030	1.783	3.398	3
			30	MVS0159X30S030	2.098	3.752	3
1.600	.0630		2	MVS0160X02S030	.327	2.689	3
			7	MVS0160X07S030	.642	2.689	3
			12	MVS0160X12S030	.957	2.689	3
			20	MVS0160X20S030	1.469	3.083	3
			25	MVS0160X25S030	1.783	3.398	3
			30	MVS0160X30S030	2.098	3.752	3
2.000	.0787		2	MVS0200X02S030	.406	2.689	3
			7	MVS0200X07S030	.803	2.693	3
			12	MVS0200X12S030	1.197	2.693	3
			20	MVS0200X20S030	1.827	3.323	3
			25	MVS0200X25S030	2.220	3.717	3
			30	MVS0200X30S030	2.614	4.031	3
2.382	.0938	3/32	2	MVS0238X02S030	.488	2.929	3
			7	MVS0238X07S030	.961	2.929	3
			12	MVS0238X12S030	1.433	2.929	3
			20	MVS0238X20S030	2.181	3.717	3
			25	MVS0238X25S030	2.654	4.228	3
			30	MVS0238X30S030	3.126	4.661	3
2.500	.0984		2	MVS0250X02S030	.504	2.929	3
			7	MVS0250X07S030	1.004	2.933	3
			12	MVS0250X12S030	1.516	2.933	3
			20	MVS0250X20S030	2.303	3.720	3
			25	MVS0250X25S030	2.776	4.232	3
			30	MVS0250X30S030	3.287	4.665	3
2.779	.1094	7/64	2	MVS0278X02S030	.567	3.205	3
			7	MVS0278X07S030	1.122	3.209	3
			12	MVS0278X12S030	1.673	3.209	3
			20	MVS0278X20S030	2.539	4.075	3
			25	MVS0278X25S030	3.091	4.626	3
			30	MVS0278X30S030	3.642	5.217	3
3.000	.1181		2	MVE0300X02S060	.650	2.185	6
			2	MVS0300X02S060PL	.650	2.185	6
			3	MVS0300X03S060	.850	2.858	6
			5	MVS0300X05S060	1.126	3.213	6
			8	MVS0300X08S060	1.402	3.213	6
			10	MVS0300X10S060	1.555	3.563	6
			15	MVS0300X15S060	2.146	4.154	6
			20	MVS0300X20S060	2.736	4.744	6
			25	MVS0300X25S060	3.327	5.335	6
			30	MVS0300X30S060	3.917	5.925	6
			35	MVS0300X35S060	4.547	6.555	6
			40	MVS0300X40S060	5.138	7.146	6
3.175	.1250	1/8	2	MVE0318X02S060	.732	2.189	6
			2	MVS0318X02S060PL	.728	2.185	6
			3	MVS0318X03S060	.850	3.016	6
			5	MVS0318X05S060	1.283	3.449	6
			8	MVS0318X08S060	1.638	3.449	6
			10	MVS0318X10S060	1.835	3.843	6
			15	MVS0318X15S060	2.504	4.512	6
			20	MVS0318X20S060	3.213	5.220	6
			25	MVS0318X25S060	3.882	5.890	6
			30	MVS0318X30S060	4.591	6.598	6
			35	MVS0318X35S060	5.299	7.307	6
			40	MVS0318X40S060	5.929	7.937	6
3.300	.1299		2	MVE0330X02S060	.732	2.189	6
			2	MVS0330X02S060PL	.728	2.185	6
			3	MVS0330X03S060	.850	3.016	6
			5	MVS0330X05S060	1.283	3.449	6
			8	MVS0330X08S060	1.638	3.449	6
			10	MVS0330X10S060	1.835	3.843	6
			15	MVS0330X15S060	2.504	4.512	6
			20	MVS0330X20S060	3.213	5.220	6
			25	MVS0330X25S060	3.882	5.890	6
			30	MVS0330X30S060	4.591	6.598	6
3.800	.1496	#25	2	MVE0380X02S060	.815	2.193	6
			2	MVS0380X02S060PL	.811	2.189	6
			3	MVS0380X03S060	.933	3.177	6
			5	MVS0380X05S060	1.445	3.650	6
			8	MVS0380X08S060	1.839	3.650	6
			10	MVS0380X10S060	2.075	4.083	6
			15	MVS0380X15S060	2.862	4.870	6
			20	MVS0380X20S060	3.650	5.657	6
			25	MVS0380X25S060	4.437	6.445	6
			30	MVS0380X30S060	5.224	7.232	6
3.969	.1563	5/32	2	MVE0397X02S060	.815	2.193	6
			2	MVS0397X02S060PL	.811	2.189	6
			3	MVS0397X03S060	.933	3.177	6
			5	MVS0397X05S060	1.445	3.650	6
			8	MVS0397X08S060	1.839	3.650	6
			10	MVS0397X10S060	2.075	4.083	6
			15	MVS0397X15S060	2.862	4.870	6
			20	MVS0397X20S060	3.650	5.657	6
			25	MVS0397X25S060	4.437	6.445	6
			30	MVS0397X30S060	5.224	7.232	6
			35	MVS0397X35S060	6.012	8.020	6
			40	MVS0397X40S060	6.799	8.807	6
4.000	.1575		2	MVE0400X02S060	.815	2.193	6
			2	MVS0400X02S060PL	.811	2.189	6
			3	MVS0400X03S060	.933	3.177	6
			5	MVS0400X05S060	1.445	3.650	6
			8	MVS0400X08S060	1.839	3.650	6
			10	MVS0400X10S060	2.075	4.083	6
			15	MVS0400X15S060	2.862	4.870	6
			20	MVS0400X20S060	3.650	5.657	6
			25	MVS0400X25S060	4.437	6.445	6
			30	MVS0400X30S060	5.224	7.232	6
			35	MVS0400X35S060	6.012	8.020	6
			40	MVS0400X40S060	6.799	8.807	6
4.100	.1614		2	MVE0410X02S060	.894	2.489	6
			2	MVS0410X02S060PL	.890	2.465	6
			3	MVS0410X03S060	1.012	3.413	6
			5	MVS0410X05S060	1.602	3.965	6
			8	MVS0410X08S060	2.075	3.965	5
			10	MVS0410X10S060	2.350	4.437	6
			15	MVS0410X15S060	3.217	5.303	6
			20	MVS0410X20S060	4.122	6.209	6
			25	MVS0410X25S060	4.988	7.075	6
			30	MVS0410X30S060	5.894	7.980	6
4.200	.1654		2	MVE0420X02S060	.898	2.472	6
			2	MVS0420X02S060PL	.894	2.469	6
			3	MVS0420X03S060	1.016	3.417	6
			5	MVS0420X05S060	1.606	3.969	6
			8	MVS0420X08S060	2.079	3.969	6
			10	MVS0420X10S060	2.354	4.441	6
			15	MVS0420X15S060	3.220	5.307	6
			20	MVS0420X20S060	4.126	6.213	6
			25	MVS0420X25S060	4.992	7.079	6
			30	MVS0420X30S060	5.898	7.984	6
4.366	.1719	11/64	2	MVE0437X02S060	.898	2.472	6
			2	MVS0437X02S060PL	.894	2.469	6
			3	MVS0437X03S060	1.016	3.417	6
			5	MVS0437X05S060	1.606	3.969	6
			8	MVS0437X08S060	2.079	3.969	6
			10	MVS0437X10S060	2.354	4.441	6
			15	MVS0437X15S060	3.220	5.307	6
			20	MVS0437X20S060	4.126	6.213	6
			25	MVS0437X25S060	4.992	7.079	6

DC (Dia.) mm	DC (Dia.) Dec.	DC (Dia.) Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
			30	MVS0437X30S060	5.898	7.984	6
			35	MVS0437X35S060	6.764	8.850	6
			40	MVS0437X40S060	7.709	9.795	6
4.500	.1772	#16	2	MVE0450X02S060	.898	2.472	6
			2	MVS0450X02S060PL	.894	2.469	6
			3	MVS0450X03S060	1.016	3.417	6
			5	MVS0450X05S060	1.606	3.969	6
			8	MVS0450X08S060	2.079	3.969	6
			10	MVS0450X10S060	2.354	4.441	6
			15	MVS0450X15S060	3.220	5.307	6
			20	MVS0450X20S060	4.126	6.213	6
			25	MVS0450X25S060	4.992	7.079	6
			30	MVS0450X30S060	5.898	7.984	6
			35	MVS0450X35S060	6.764	8.850	6
			40	MVS0450X40S060	7.709	9.795	6
4.763	.1875	3/16	2	MVE0476X02S060	.980	2.476	6
			2	MVS0476X02S060PL	.976	2.472	6
			3	MVS0476X03S060	1.118	3.579	6
			5	MVS0476X05S060	1.768	4.169	6
			8	MVS0476X08S060	2.280	4.169	6
			10	MVS0476X10S060	2.594	4.681	6
			15	MVS0476X15S060	3.579	5.665	6
			20	MVS0476X20S060	4.563	6.650	6
			25	MVS0476X25S060	5.547	7.634	6
			30	MVS0476X30S060	6.531	8.618	6
			35	MVS0476X35S060	7.516	9.602	6
			40	MVS0476X40S060	8.500	10.587	6
5.000	.1969		2	MVE0500X02S060	.980	2.476	6
			2	MVS0500X02S060PL	.976	2.472	6
			3	MVS0500X03S060	1.118	3.579	6
			5	MVS0500X05S060	1.768	4.169	6
			8	MVS0500X08S060	2.280	4.169	6
			10	MVS0500X10S060	2.594	4.681	6
			15	MVS0500X15S060	3.579	5.665	6
			20	MVS0500X20S060	4.563	6.650	6
			25	MVS0500X25S060	5.547	7.634	6
			30	MVS0500X30S060	6.531	8.618	6
			35	MVS0500X35S060	7.516	9.602	6
			40	MVS0500X40S060	8.500	10.587	6
5.100	.2008	#7	2	MVE0510X02S060	1.059	2.634	6
			2	MVS0510X02S060PL	1.055	2.630	6
			3	MVS0510X03S060	1.118	3.264	6
			5	MVS0510X05S060	1.768	3.972	6
			8	MVS0510X08S060	2.437	4.681	6
			10	MVS0510X10S060	2.870	5.035	6
			15	MVS0510X15S060	3.933	6.098	6
5.160	.2032	13/64	2	MVE0516X02S060	1.059	2.634	6
			2	MVS0516X02S060PL	1.055	2.630	6
			3	MVS0516X03S060	1.118	3.264	6
			5	MVS0516X05S060	1.768	3.972	6
			8	MVS0516X08S060	2.437	4.681	6
			10	MVS0516X10S060	2.870	5.035	6
			15	MVS0516X15S060	3.933	6.098	6
			20	MVS0516X20S060	5.035	7.201	6
			25	MVS0516X25S060	6.098	8.264	6
			30	MVS0516X30S060	7.201	9.366	6
			35	MVS0516X35S060	8.264	10.429	6
			40	MVS0516X40S060	9.484	11.650	6
5.558	.2188	7/32	2	MVE0556X02S060	1.142	2.638	6
			2	MVS0556X02S060PL	1.138	2.634	6
			3	MVS0556X03S060	1.220	3.268	6
			5	MVS0556X05S060	1.923	3.976	6
			8	MVS0556X08S060	2.638	4.685	6
			10	MVS0556X10S060	3.110	5.276	6
			15	MVS0556X15S060	4.291	6.457	6
			20	MVS0556X20S060	5.472	7.638	6
			25	MVS0556X25S060	6.654	8.819	6
			30	MVS0556X30S060	7.835	10.000	6
			35	MVS0556X35S060	9.016	11.181	6
			40	MVS0556X40S060	10.276	12.441	6
5.800	.2283	#1	2	MVE0580X02S060	1.146	2.642	6
			2	MVS0580X02S060PL	1.138	2.634	6
			3	MVS0580X03S060	1.224	3.272	6
			5	MVS0580X05S060	1.933	3.980	6
			8	MVS0580X08S060	2.642	4.689	6
			10	MVS0580X10S060	3.114	5.280	6
			20	MVS0580X20S060	5.476	7.642	6
5.954	.2344	15/64, A	2	MVE0595X02S060	1.146	2.642	6
			2	MVS0595X02S060PL	1.138	2.634	6
			3	MVS0595X03S060	1.224	3.272	6
			5	MVS0595X05S060	1.933	3.980	6
			8	MVS0595X08S060	2.642	4.689	6
			10	MVS0595X10S060	3.114	5.280	6
			15	MVS0595X15S060	4.295	6.461	6
			20	MVS0595X20S060	5.476	7.642	6
			25	MVS0595X25S060	6.657	8.823	6
			30	MVS0595X30S060	7.839	10.004	6
			35	MVS0595X35S060	9.020	11.185	6
			40	MVS0595X40S060	10.280	12.445	6
6.000	.2362		2	MVE0600X02S060	1.146	2.642	6
			2	MVS0600X02S060PL	1.138	2.634	6
			3	MVS0600X03S060	1.224	3.272	6
			5	MVS0600X05S060	1.933	3.980	6
			8	MVS0600X08S060	2.642	4.689	6
			10	MVS0600X10S060	3.114	5.280	6
			15	MVS0600X15S060	4.295	6.461	6
			20	MVS0600X20S060	5.476	7.642	6
			25	MVS0600X25S060	6.657	8.823	6
			30	MVS0600X30S060	7.839	10.004	6
			35	MVS0600X35S060	9.020	11.185	6
			40	MVS0600X40S060	10.280	12.445	6
6.350	.2500	1/4, E	2	MVE0635X02S080	1.268	2.961	8
			2	MVS0635X02S080PL	1.260	2.953	8
			3	MVS0635X03S080	1.327	3.512	8
			5	MVS0635X05S080	2.094	4.339	8
			8	MVS0635X08S080	2.882	5.165	8
			10	MVS0635X10S080	3.394	5.598	8
			15	MVS0635X15S080	4.654	6.858	8
			20	MVS0635X20S080	5.953	8.157	8
			25	MVS0635X25S080	7.213	9.417	8
			30	MVS0635X30S080	8.512	10.717	8
			35	MVS0635X35S080	9.772	12.055	8
			40	MVS0635X40S080	11.071	13.276	8
6.500	.2559		2	MVE0650X02S080	1.268	2.961	8
			2	MVS0650X02S080PL	1.260	2.953	8
			3	MVS0650X03S080	1.327	3.512	8
			5	MVS0650X05S080	2.094	4.339	8
			8	MVS0650X08S080	2.882	5.165	8
			10	MVS0650X10S080	3.394	5.598	8
			15	MVS0650X15S080	4.654	6.858	8
			20	MVS0650X20S080	5.953	8.157	8
			25	MVS0650X25S080	7.213	9.417	8
			30	MVS0650X30S080	8.512	10.717	8
			35	MVS0650X35S080	9.772	12.055	8
			40	MVS0650X40S080	11.071	13.276	8
6.528	.2570	F	2	MVE0653X02S080	1.386	2.961	8
			2	MVS0653X02S080PL	1.378	2.953	8
			3	MVS0653X03S080	1.425	3.512	8
			5	MVS0653X05S080	2.252	4.339	8
			8	MVS0653X08S080	3.079	5.165	8
			10	MVS0653X10S080	3.630	5.835	8
			15	MVS0653X15S080	5.008	7.213	8

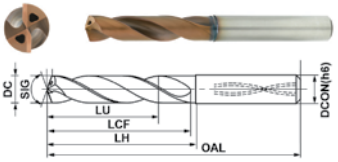
DC (Dia.) mm	DC (Dia.) Dec.	DC (Dia.) Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
6.528	2.570	F	20	MVS0653X20S080	6.386	8.591	8
			25	MVS0653X25S080	7.764	9.969	8
			30	MVS0653X30S080	9.142	11.346	8
			35	MVS0653X35S080	10.520	12.724	8
			40	MVS0653X40S080	11.858	14.063	8
6.747	.2657	17/64	2	MVE0675X02S080	1.386	2.961	8
			2	MVS0675X02S080PL	1.382	2.957	8
			3	MVS0675X03S080	1.425	3.512	8
			5	MVS0675X05S080	2.252	4.339	8
			8	MVS0675X08S080	3.079	5.165	8
			10	MVS0675X10S080	3.630	5.835	8
			15	MVS0675X15S080	5.008	7.213	8
			20	MVS0675X20S080	6.386	8.591	8
			25	MVS0675X25S080	7.764	9.969	8
			30	MVS0675X30S080	9.142	11.346	8
			35	MVS0675X35S080	10.520	12.724	8
			40	MVS0675X40S080	11.858	14.063	8
6.900	.2717		2	MVE0690X02S080	1.390	2.965	8
			2	MVS0690X02S080PL	1.382	2.957	8
			3	MVS0690X03S080	1.429	3.465	8
			5	MVS0690X05S080	2.256	4.343	8
			8	MVS0690X08S080	3.083	5.169	8
			10	MVS0690X10S080	3.634	5.839	8
			15	MVS0690X15S080	5.012	7.217	8
			20	MVS0690X20S080	6.390	8.594	8
			25	MVS0690X25S080	7.768	9.972	8
			30	MVS0690X30S080	9.146	11.350	8
7.144	.2813	9/32, K	2	MVE0714X02S080	1.390	3.161	8
			2	MVS0714X02S080PL	1.382	3.154	8
			3	MVS0714X03S080	1.528	3.752	8
			5	MVS0714X05S080	2.413	4.697	8
			8	MVS0714X08S080	3.319	5.642	8
			10	MVS0714X10S080	3.909	6.154	8
			15	MVS0714X15S080	5.366	7.610	8
			20	MVS0714X20S080	6.862	9.106	8
			25	MVS0714X25S080	8.319	10.563	8
			30	MVS0714X30S080	9.815	12.059	8
			35	MVS0714X35S080	11.272	13.516	8
			40	MVS0714X40S080	12.650	14.894	8
7.541	.2969	19/64	2	MVE0754X02S080	1.512	3.165	8
			2	MVS0754X02S080PL	1.504	3.157	8
			3	MVS0754X03S080	1.630	3.756	8
			5	MVS0754X05S080	2.575	4.701	8
			8	MVS0754X08S080	3.520	5.646	8
			10	MVS0754X10S080	4.150	6.394	8
			15	MVS0754X15S080	5.724	7.969	8
			20	MVS0754X20S080	7.299	9.543	8
			25	MVS0754X25S080	8.874	11.118	8
			30	MVS0754X30S080	10.449	12.693	8
			35	MVS0754X35S080	12.024	14.268	8
			40	MVS0754X40S080	13.441	15.685	8
7.700	.3031		2	MVE0770X02S080	1.512	3.165	8
			2	MVS0770X02S080PL	1.504	3.157	8
			3	MVS0770X03S080	1.630	3.756	8
			5	MVS0770X05S080	2.575	4.701	8
			8	MVS0770X08S080	3.520	5.646	8
7.938	.3125	5/16	2	MVE0794X02S080	1.512	3.165	8
			2	MVS0794X02S080PL	1.508	3.161	8
			3	MVS0794X03S080	1.630	3.756	8
			5	MVS0794X05S080	2.575	4.701	8
			8	MVS0794X08S080	3.520	5.646	8
			10	MVS0794X10S080	4.150	6.394	8
			15	MVS0794X15S080	5.724	7.969	8
			20	MVS0794X20S080	7.299	9.543	8
			25	MVS0794X25S080	8.874	11.118	8
			30	MVS0794X30S080	10.449	12.693	8
			35	MVS0794X35S080	12.024	14.268	8
			40	MVS0794X40S080	13.441	15.685	8
8.000	.3150		2	MVE0800X02S080	1.516	3.169	8
			2	MVS0800X02S080PL	1.508	3.161	8
			3	MVS0800X03S080	1.634	3.760	8
			5	MVS0800X05S080	2.579	4.705	8
			8	MVS0800X08S080	3.524	5.650	8
			10	MVS0800X10S080	4.154	6.398	8
			15	MVS0800X15S080	5.728	7.972	8
			20	MVS0800X20S080	7.303	9.547	8
			30	MVS0800X30S080	10.453	12.697	8
			35	MVS0800X35S080	12.028	14.272	8
			40	MVS0800X40S080	13.445	15.689	8
8.335	.3282	21/64	2	MVE0833X02S100	1.516	3.366	10
			2	MVS0833X02S100PL	1.508	3.358	10
			3	MVS0833X03S100	1.732	3.996	10
			5	MVS0833X05S100	2.736	5.059	10
			8	MVS0833X08S100	3.760	6.122	10
			10	MVS0833X10S100	4.429	6.713	10
			15	MVS0833X15S100	6.083	8.366	10
			20	MVS0833X20S100	7.776	10.059	10
			25	MVS0833X25S100	9.429	11.713	10
			30	MVS0833X30S100	11.122	13.406	10
			35	MVS0833X35S100	12.776	15.059	10
			40	MVS0833X40S100	14.429	16.713	10
8.433	.3320	Q	2	MVE0843X02S100	1.516	3.366	10
			2	MVS0843X02S100PL	1.508	3.358	10
			3	MVS0843X03S100	1.732	3.996	10
			5	MVS0843X05S100	2.736	5.059	10
			8	MVS0843X08S100	3.760	6.122	10
			10	MVS0843X10S100	4.429	6.713	10
			15	MVS0843X15S100	6.083	8.366	10
			20	MVS0843X20S100	7.776	10.059	10
			25	MVS0843X25S100	9.429	11.713	10
			30	MVS0843X30S100	11.122	13.406	10
			35	MVS0843X35S100	12.776	15.059	10
			40	MVS0843X40S100	14.429	16.713	10
8.732	.3438	11/32	2	MVE0873X02S100	1.638	3.370	10
			2	MVS0873X02S100PL	1.630	3.362	10
			3	MVS0873X03S100	1.835	4.000	10
			5	MVS0873X05S100	2.898	5.063	10
			8	MVS0873X08S100	3.961	6.126	10
			10	MVS0873X10S100	4.669	6.953	10
			15	MVS0873X15S100	6.441	8.724	10
			20	MVS0873X20S100	8.213	10.496	10
			25	MVS0873X25S100	9.984	12.268	10
			30	MVS0873X30S100	11.756	14.039	10
			35	MVS0873X35S100	13.528	15.811	10
			40	MVS0873X40S100	15.417	17.701	10
8.800	.3465		2	MVE0880X02S100	1.638	3.370	10
			2	MVS0880X02S100PL	1.630	3.362	10
			3	MVS0880X03S100	1.835	4.000	10
			5	MVS0880X05S100	2.898	5.063	10
			8	MVS0880X08S100	3.961	6.126	10
			10	MVS0880X10S100	4.669	6.953	10
			15	MVS0880X15S100	6.441	8.724	10
			20	MVS0880X20S100	8.213	10.496	10
			25	MVS0880X25S100	9.984	12.268	10
			30	MVS0880X30S100	11.756	14.039	10
9.128	.3594	23/64	2	MVE0913X02S100	1.642	3.571	10
			2	MVS0913X02S100PL	1.630	3.559	10
			3	MVS0913X03S100	1.937	4.240	10
			5	MVS0913X05S100	3.059	5.421	10
			8	MVS0913X08S100	4.201	6.602	10
			10	MVS0913X10S100	4.949	7.232	10
			15	MVS0913X15S100	6.799	9.083	10
			20	MVS0913X20S100	8.689	10.972	10

DC (Dia.) mm	DC (Dia.) Dec.	DC (Dia.) Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
9.128	.3594	23/64	25	MVS0913X25S100	10.539	12.823	10
			30	MVS0913X30S100	12.429	14.713	10
			35	MVS0913X35S100	14.280	16.563	10
9.525	.3750	3/8	2	MVE0953X02S100	1.760	3.571	10
			2	MVS0953X02S100PL	1.752	3.563	10
			3	MVS0953X03S100	2.035	4.240	10
			5

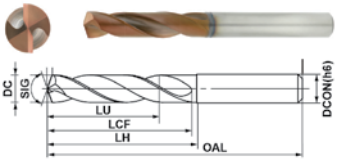
MITSUBISHI DIAEDGE — HIGH PERFORMANCE CARBIDE DRILLS FOR HI-TEMP ALLOYS

DSA

DSAS - WITH COOLANT HOLES

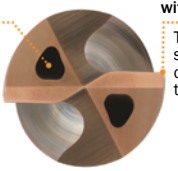


DSAE - WITHOUT COOLANT HOLES



TRI-Cooling Technology

The unique hole geometry increases the coolant flow rate, resulting in high lubricity and cooling effect. (available in sizes over: ø. 1969 inch or ø 5 mm)



Straight Cutting Edge with Single-Pass Honing

The tough straight cutting edge with single-pass honing enables stable chip formation as well as preventing the cutting edge from chipping.

MORE SIZES AVAILABLE PLEASE CALL

140° POINT

Grade for Machining of Heat Resistant Alloys DP9020

provides both high wear and fracture resistance, leading to longer tool life

Special Margin

This specially designed thin margin minimizes contact area with hole surface and workpiece materials in combination with tri-cooling technology to reduce cutting heat and prevent the generation of work-hardening making it especially suited for the machining of heat resistant alloys.

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
3.000	.1181		3	DSAE0300X03S060	.846	2.776	6
			3	DSAS0300X03S060	.846	2.776	6
			5	DSAS0300X05S060	1.122	3.091	6
3.175	.1250	1/8	3	DSAS0318X03S060	.850	2.780	6
			5	DSAS0318X05S060	1.126	3.094	6
3.200	.1260		3	DSAS0320X03S060	.850	2.78	6
			5	DSAS0320X05S060	1.126	3.094	6
3.260	.1283		3	DSAS0326X03S060	.850	2.780	6
3.300	.1299		3	DSAS0330X03S060	.850	2.780	6
			5	DSAS0330X05S060	1.126	3.094	6
3.800	.1496	#25	3	DSAS0380X03S060	.894	2.783	6
			5	DSAS0380X05S060	1.209	3.098	6
3.969	.1563	5/32	3	DSAS0397X03S060	.894	2.783	6
			5	DSAS0397X05S060	1.209	3.098	6
4.000	.1575		3	DSAE0400X03S060	.894	2.783	6
			3	DSAS0400X03S060	.894	2.783	6
			5	DSAS0400X05S060	1.209	3.098	6
4.100	.1614		3	DSAS0410X03S060	.972	2.902	6
			5	DSAS0410X05S060	1.327	3.256	6
4.200	.1654		3	DSAS0420X03S060	.976	2.906	6
			5	DSAS0420X05S060	1.331	3.260	6
4.366	.1719	11/64	3	DSAS0437X03S060	.976	2.906	6
			5	DSAS0437X05S060	1.331	3.260	6
4.500	.1772	#16	3	DSAE0450X03S060	.976	2.906	6
			3	DSAS0450X03S060	.976	2.906	6
			5	DSAS0450X05S060	1.331	3.260	6
4.763	.1875	3/16	3	DSAS0476X03S060	1.020	2.988	6
			5	DSAS0476X05S060	1.413	3.382	6
5.000	.1969		3	DSAE0500X03S060	1.138	3.224	6
			3	DSAS0500X03S060	1.138	3.224	6
			5	DSAS0500X05S060	1.571	3.539	6
5.100	.2008	#7	3	DSAE0510X03S060	1.138	3.224	6
			3	DSAS0510X03S060	1.138	3.224	6
			5	DSAS0510X05S060	1.571	3.539	6

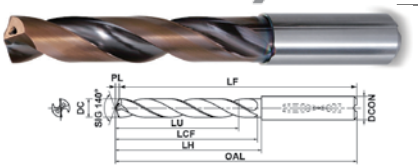
DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
5.160	.2032	13/64	3	DSAS0516X03S060	1.142	3.228	6
			5	DSAS0516X05S060	1.575	3.543	6
5.557	.2188	7/32	3	DSAS0556X03S060	1.224	3.232	6
			5	DSAS0556X05S060	1.697	3.547	6
5.800	.2283	#1	3	DSAS0580X03S060	1.224	3.232	6
			5	DSAS0580X05S060	1.697	3.547	6
5.954	.2344	15/64, A	3	DSAS0595X03S060	1.224	3.232	6
			5	DSAS0595X05S060	1.697	3.547	6
6.000	.2362		3	DSAE0600X03S060	1.224	3.232	6
			3	DSAS0600X03S060	1.224	3.232	6
			5	DSAS0600X05S060	1.697	3.547	6
6.350	.2500	1/4, E	3	DSAS0635X03S080	1.346	3.433	8
			5	DSAS0635X05S080	1.858	3.787	8
6.500	.2559		3	DSAS0650X03S080	1.346	3.433	8
			5	DSAS0650X05S080	1.858	3.787	8
6.747	.2657	17/64	3	DSAS0675X03S080	1.429	3.594	8
			5	DSAS0675X05S080	1.980	3.909	8
6.900	.2717	I	3	DSAE0690X03S080	1.429	3.594	8
			3	DSAS0690X03S080	1.429	3.594	8
			5	DSAS0690X05S080	1.980	3.909	8
7.144	.2813	9/32, K	3	DSAS0714X03S080	1.551	3.598	8
			5	DSAS0714X05S080	2.142	4.110	8
7.541	.2969	19/64	3	DSAS0754X03S080	1.634	3.602	8
			5	DSAS0754X05S080	2.264	4.114	8
7.700	.3031		3	DSAS0770X03S080	1.634	3.602	8
			5	DSAS0770X05S080	2.264	4.114	8
7.938	.3125	5/16	3	DSAS0794X03S080	1.634	3.602	8
			5	DSAS0794X05S080	2.264	4.114	8
8.000	.3150		3	DSAE0800X03S080	1.634	3.602	8
			3	DSAS0800X03S080	1.634	3.602	8
			5	DSAS0800X05S080	2.264	4.114	8

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
8.335	.3282	21/64	3	DSAS0833X03S100	1.752	3.839	10
			5	DSAS0833X05S100	2.421	4.508	10
8.732	.3438	11/32	3	DSAS0873X03S100	1.835	4.039	10
			5	DSAS0873X05S100	2.543	4.630	10
8.800	.3465		3	DSAS0880X03S100	1.835	4.039	10
			5	DSAS0880X05S100	2.543	4.630	10
9.100	.3583	T	3	DSAS0910X03S100	1.361	4.047	10
			5	DSAS0910X05S100	2.709	4.835	10
9.525	.3750	3/8	3	DSAS0953X03S100	1.961	4.047	10
			5	DSAS0953X05S100	2.709	4.835	10
9.600	.3780		3	DSAS0960X03S100	1.961	4.047	10
			5	DSAS0960X05S100	2.709	4.835	10
9.922	.3907	25/64	3	DSAS0992X03S100	2.039	4.047	10
			5	DSAS0992X05S100	2.827	4.835	10
10.000	.3937		3	DSAE1000X03S100	2.039	4.047	10
			3	DSAS1000X03S100	2.039	4.047	10
			5	DSAS1000X05S100	2.827	4.835	10
10.319	.4063	13/32	3	DSAS1032X03S120	2.161	4.445	12
			5	DSAS1032X05S120	2.988	5.350	12
10.716	.4219	27/64	3	DSAS1072X03S120	2.244	4.646	12

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF Inch	OAL Inch	DCON mm
10.716	.4219	27/64	5	DSAS1072X05S120	3.110	5.591	12
10.810	.4252		3	DSAS1080X03S120	2.244	4.646	12
			5	DSAS1080X05S120	3.110	5.591	12
10.900	.4291		3	DSAS1090X03S120	2.244	4.646	12
			5	DSAS1090X05S120	3.110	5.591	12
11.000	.4331		3	DSAE1100X03S120	2.244	4.646	12
			3	DSAS1100X03S120	2.244	4.646	12
			5	DSAS1100X05S120	3.110	5.591	12
11.113	.4375	7/16	3	DSAS1111X03S120	2.366	4.650	12
			5	DSAS1111X05S120	3.272	5.594	12
11.510	.4532	29/64	3	DSAS1151X03S120	2.449	4.654	12
			5	DSAS1151X05S120	3.394	5.598	12
11.900	.4685		3	DSAS1190X03S120	2.449	4.654	12
			5	DSAS1190X05S120	3.394	5.598	12
12.300	.4843		3	DSAS1230X03S140	2.567	4.890	14
			5	DSAS1230X05S140	3.551	5.913	14
12.700	.5000	1/2	3	DSAS1270X03S140	2.650	5.051	14
			5	DSAS1270X05S140	3.673	6.154	14
13.500	.5315		3	DSAS1350X03S140	2.776	5.059	14
			5	DSAS1350X05S140	3.839	6.161	14

MITSUBISHI DIAEDGE — HIGH PERFORMANCE CARBIDE DRILLS FOR STAINLESS STEEL

MMS



SHOWN HERE ARE SOME OF THE MOST POPULAR SIZES. MANY MORE SIZES ARE STOCKED AT THE FACTORY — PLEASE INQUIRE.

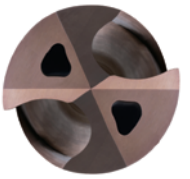
1 Unique coolant hole geometry

Employs new TRI-cooling technology. Coolant volume increased by unique hole shape. (Coolant holes on drills larger than ø.2362")

PAT.P.

2 Wavy cutting edge for stainless steel

The concave edge improves sharpness, whereas the convex edge improves overall cutting edge strength.



3 Special margin to reduce cutting resistance

Suitable margin width for stainless steels. Lower cutting resistance offering higher machining performance.

4 Carbide grade DP7020

Special substrate for stainless steels, with a PVD coating offering improved lubricity.

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF	OAL	DCON
3.0	.1181		3	MMS0300X3DB	.827	2.756	6
			5	MMS0300X5DB	1.102	3.071	6
3.175	.1250	1/8	3	MMS0318X3D060	.827	2.756	6
			5	MMS0318X5D060	1.102	3.071	6
3.3	.1299		3	MMS0330X3DB	.827	2.756	6
			5	MMS0330X5DB	1.102	3.071	6
3.8	.1496	25	3	MMS0380X3DB	.866	2.756	6
			5	MMS0380X5DB	1.181	3.071	6
3.969	.1562	5/32	3	MMS0397X3D060	.866	2.756	6
			5	MMS0397X5D060	1.181	3.071	6
4.0	.1575		3	MMS0400X3DB	.866	2.756	6
			5	MMS0400X5DB	1.181	3.071	6
4.1	.1614		3	MMS0410X3DB	.945	2.874	6
			5	MMS0410X5DB	1.299	3.228	6
4.2	.1654		3	MMS0420X3DB	.945	2.874	6
			5	MMS0420X5DB	1.299	3.228	6
4.366	.1719	11/64	3	MMS0437X3D060	.945	2.874	6
			5	MMS0437X5D060	1.299	3.228	6
4.5	.1772	16	3	MMS0450X3DB	.945	2.874	6
			5	MMS0450X5DB	1.299	3.228	6
4.763	.1875	3/16	3	MMS0476X3D060	.984	2.953	6
			5	MMS0476X5D060	1.378	3.346	6
5.0	.1969		3	MMS0500X3DB	.984	2.953	6
			5	MMS0500X5DB	1.378	3.346	6
5.1	.2008	7	3	MMS0510X3DB	1.102	3.189	6
			5	MMS0510X5DB	1.535	3.504	6
5.159	.2031	13/64	3	MMS0516X3D060	1.102	3.189	6
			5	MMS0516X5D060	1.535	3.504	6
5.556	.2188	7/32	3	MMS0556X3D060	1.181	3.189	6
			5	MMS0556X5D060	1.654	3.504	6
5.8	.2283	1	3	MMS0580X3DB	1.181	3.189	6
			5	MMS0580X5DB	1.654	3.504	6

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF	OAL	DCON
5.953	.2344	15/64	3	MMS0595X3D060	1.181	3.189	6
			5	MMS0595X5D060	1.654	3.504	6
6.0	.2362		3	MMS0600X3DB	1.181	3.189	6
			5	MMS0600X5DB	1.654	3.504	6
6.350	.2500	1/4, E	3	MMS0635X3D080	1.299	3.386	8
			5	MMS0635X5D080	1.811	3.740	8
6.5	.2599		3	MMS0650X3DB	1.299	3.386	8
			5	MMS0650X5DB	1.811	3.740	8
6.528	.2570	F	3	MMS0653X3D080	1.378	3.543	8
			5	MMS0653X5D080	1.929	3.858	8
6.747	.2656	17/64	3	MMS0675X3D080	1.378	3.543	8
			5	MMS0675X5D080	1.929	3.858	8
6.9	.2717	I	3	MMS0690X3DB	1.378	3.543	8
			5	MMS0690X5DB	1.929	3.858	8
7.144	.2812	9/32	3	MMS0714X3D080	1.496	3.543	8
			5	MMS0714X5D080	2.087	4.055	8
7.541	.2969	19/64	3	MMS0754X3D080	1.545	3.543	8
			5	MMS0754X5D080	2.205	4.055	8
7.7	.3031		3	MMS0770X3DB	1.545	3.543	8
			5	MMS0770X5DB	2.205	4.055	8
7.938	.3125	5/16	3	MMS0794X3D080	1.545	3.543	8
			5	MMS0794X5D080	2.205	4.055	8
8.0	.3150		3	MMS0800X3DB	1.545	3.543	8
			5	MMS0800X5DB	2.205	4.055	8
8.334	.3281	21/64	3	MMS0833X3D100	1.693	3.780	10
			5	MMS0833X5D100	2.632	4.449	10
8.433	.3320	Q	3	MMS0843X3D100	1.693	3.780	10
			5	MMS0843X5D100	2.632	4.449	10
8.731	.3438	11/32	3	MMS0873X3D100	1.772	3.976	10
			5	MMS0873X5D100	2.480	4.567	10
8.8	.3465		3	MMS0880X3DB	1.772	3.976	10
			5	MMS0880X5DB	2.480	4.567	10

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF	OAL	DCON
9.128	.3594	23/64	3	MMS0913X3D100	1.890	3.976	10
			5	MMS0913X5D100	2.638	4.764	10
9.525	.3750	3/8	3	MMS0953X3D100	1.969	3.976	10
			5	MMS0953X5D100	2.756	4.764	10
9.6	.3780		3	MMS0960X3DB	1.969	3.976	10
			5	MMS0960X5DB	2.756	4.764	10
9.922	.3906	25/64	3	MMS0992X3D100	1.969	3.976	10
			5	MMS0992X5D100	2.756	4.764	10
10.0	.3937		3	MMS1000X3DB	1.969	3.976	10
			5	MMS1000X5DB	2.756	4.764	10
10.319	.4062	13/32	3	MMS1032X3D120	2.087	4.370	12
			5	MMS1032X5D120	2.913	5.276	12
10.716	.4219	27/64	3	MMS1072X3D120	2.165	4.657	12
			5	MMS1072X5D120	3.031	5.276	12
10.8	.4252		3	MMS1080X3DB	2.165	4.657	12
			5	MMS1080X5DB	3.031	5.276	12
10.9	.4291		3	MMS1090X3DB	2.165	4.657	12
			5	MMS1090X5DB	3.031	5.276	12
11.0	.4331		3	MMS1100X3DB	2.165	4.657	12
			5	MMS1100X5DB	3.031	5.276	12
11.113	.4375	7/16	3	MMS1111X3D120	2.283	4.567	12
			5	MMS1111X5D120	3.189	5.512	12
11.509	.4531	29/64	3	MMS1151X3D120	2.362	4.567	12
			5	MMS1151X5D120	3.037	5.512	12
11.9	.4685	15/32	3	MMS1190X3DB	2.362	4.567	12
			5	MMS1190X5DB	3.037	5.512	12
12.3	.4843	31/64	3	MMS1230X3DB	2.480	4.803	14
			5	MMS1230X5DB	3.465	5.827	14
12.7	.5000	1/2	3	MMS1270X3DB	2.559	4.803	14
			5	MMS1270X5DB	3.583	5.827	14
13.5	.5315	17/32	3	MMS1350X3DB	2.877	4.961	14
			5	MMS1350X5DB	3.740	6.063	14

DC (Dia.) mm	Dec.	Inch	xD	PART#	LCF	OAL	DCON
14.288	.5625	9/16	3	MMS1429X3D160	2.874	5.315	16
			5	MMS1429X5D160	4.016	6.496	16
14.684	.5761	37/64	3	MMS1468X3D160	2.953	5.315	16
			5	MMS1468X5D160	4.134	6.496	16
15.081	.5938	19/32	3	MMS1508X3D160	3.071	5.472	16
			5	MMS1508X5D160	4.291	6.732	16
15.5	.6102		3	MMS1550X3DB	3.071	5.472	16
			5	MMS1550X5DB	4.291	6.732	16
15.875	.6250	5/8	3	MMS1588X3D160	3.150	5.472	16
			5	MMS1588X5D160	4.409	6.732	16
16.272	.6406	41/64	3	MMS1627X3D180	3.268	5.709	18
			5	MMS1627X5D180	4.567	7.047	18
16.5	.6496		3	MMS1650X3DB	3.268	5.709	18
			5	MMS1650X5DB	4.567	7.047	18
16.669	.6562	21/32	3	MMS1667X3D180	3.346	5.709	18
			5	MMS1667X5D180	4.685	7.047	18
17.463	.6875	11/16	3	MMS1746X3D180	3.465	5.866	18
			5	MMS1746X5D180	4.843	7.283	18
17.5	.6890		3	MMS1750X3DB	3.465	5.866	18
			5	MMS1750X5DB	4.843	7.283	18
18.256	.7188	23/32	3	MMS1826X3D200	3.661	6.181	20
			5	MMS1826X5D200	5.118	7.677	20
18.5	.7283		3	MMS1850X3DB	3.661	6.181	20
			5	MMS1850X5DB	5.118	7.677	20
19.447	.7656	49/64	3	MMS1945X3D200	3.858	6.339	20
			5	MMS1945X5D200	5.394	7.913	20
19.844	.7812	25/32	3	MMS1984X3D200	3.937	6.339	20
			5	MMS1984X5D200	5.512	7.913	20
20.0	.7874		3	MMS2000X3DB	3.937	6.339	20
			5	MMS2000X5DB	5.512	7.913	20

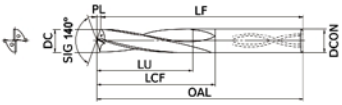
MITSUBISHI DIAEDGE — HIGH PERFORMANCE CARBIDE DRILLS FOR ALUMINUM & CAST IRON

MAS

DC	PART#	LU	LCF	OAL	DCON	Rolled Thread Tap Size
.1250	MAS01250MB	.398	.968	2.543	.1575	
.1406	MAS01406MB	.447	1.128	2.703	.1575	
.1495	MAS01495MB	.475	1.129	2.704	.1575	10-24NC
.1563	MAS01563MB	.497	1.130	2.705	.1575	
.1590	MAS01590MB	.506	1.249	2.824	.1969	10-32NF
.1719	MAS01719MB	.547	1.251	2.826	.1969	
.1875	MAS01875MB	.596	1.333	2.908	.1969	
.2031	MAS02031MB	.646	1.454	3.029	.2362	
.2165	MAS02165MB	.688	1.456	3.031	.2362	
.2188	MAS02188MB	.696	1.575	3.150	.2362	
.2344	MAS02344MB	.745	1.578	3.153	.2362	
.2500	MAS02500MB	.795	1.700	3.353	.2756	1/16-27NS
.2570	MAS02570MB	.817	1.701	3.354	.2756	5/16-18NC
.2656	MAS02656MB	.845	1.702	3.355	.2756	
.2720	MAS02720MB	.865	1.704	3.357	.2756	5/16-24NF
.2812	MAS02812MB	.894	1.941	3.594	.3150	

PLEASE CALL FOR SIZES NOT SHOWN BELOW

COATING: HTi10



- Helical coolant hole enables high speed machining.
- High hole accuracy.
- Pre-hole drilling for rolled tap.

DC	PART#	LU	LCF	OAL	DCON	Rolled Thread Tap Size
.2969	MAS02969MB	.944	1.944	3.597	.3150	
.3125	MAS03125MB	.994	1.947	3.600	.3150	3/8-16NC
.3281	MAS03281MB	1.043	2.029	3.761	.3543	1/8-27NPT
.3320	MAS03320MB	1.056	2.029	3.761	.3543	3/8-24NF
.3438	MAS03438MB	1.093	2.032	3.764	.3543	
.3594	MAS03594MB	1.143	2.152	3.884	.3937	
.3680	MAS03680MB	1.170	2.154	3.886	.3937	7/16-14NC
.3750	MAS03750MB	1.193	2.155	3.887	.3937	
.3906	MAS03906MB	1.242	2.158	3.890	.3937	7/16-20NF
.4062	MAS04062MB	1.292	2.239	4.050	.4331	
.4219	MAS04219MB	1.342	2.242	4.053	.4331	1/2-13, 1/2-12

DC	PART#	LU	LCF	OAL	DCON	Rolled Thread Tap Size
.4375	MAS04375MB	1.391	2.442	4.253	.4724	1/4-18NPT
.4531	MAS04531MB	1.441	2.444	4.255	.4724	1/2-20, 1/4-18NS
.4688	MAS04688MB	1.491	2.447	4.258	.4724	
.4844	MAS04844MB	1.540	2.647	4.616	.5118	9/16-12NC
.5000	MAS05000MB	1.590	2.650	4.619	.5118	
.5118	MAS05118MB	1.628	2.652	4.621	.5118	
.5156	MAS05156MB	1.640	2.850	4.818	.5512	9/16-18NF
.5312	MAS05312MB	1.689	2.853	4.821	.5512	5/8-11NC
.5469	MAS05469MB	1.739	2.856	4.824	.5512	
.5625	MAS05625MB	1.789	2.937	5.220	.5906	3/8-18NPT
.5781	MAS05781MB	1.838	2.940	5.223	.5906	5/8-18NF

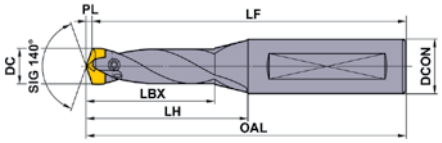
DC	PART#	LU	LCF	OAL	DCON	Rolled Thread Tap Size
.5937	MAS05937MB	1.888	3.100	5.384	.6299	3/8-18NS
.6094	MAS06094MB	1.938	3.103	5.387	.6299	
.6250	MAS06250MB	1.988	3.106	5.390	.6299	
.6406	MAS06406MB	2.037	3.267	5.550	.6693	
.6563	MAS06563MB	2.087	3.269	5.552	.6693	3/4-10NC
.6718	MAS06718MB	2.136	3.468	5.752	.7087	
.6875	MAS06875MB	2.186	3.471	5.755	.7087	3/4-16NF
.7031	MAS07031MB	2.236	3.474	5.758	.7087	1/2-14NPT
.7188	MAS07188MB	2.286	3.674	5.958	.7480	
.7344	MAS07344MB	2.335	3.677	5.961	.7480	7/8-9, 1/2-14NS
.7500	MAS07500MB	2.385	3.877	6.161	.7874	
.7656	MAS07656MB	2.435	3.879	6.163	.7874	
.7812	MAS07812MB	2.484	3.882	6.166	.7874	

Note 1) MAS drills bigger than .2031" have a recess in the end face. Note 2) MAS drills are suitable for use with shrink fit holders.

MITSUBISHI DIAEDGE

MODULAR DRILLING SYSTEMS USING CARBIDE HEADS

STAW UP TO .7188" DIA.



1.5xD 3xD 5xD 8xD

- Internal Coolant
- Wavy cutting edge design for good chip control.
- Highly rigid clamping system offers stability and reliability for small hole drilling.

(METRIC DRILLS AVAILABLE)

DC	xD	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	Insert
.3906	1.5	STAWSS0026	.661	.937	1.33	3.22	3.15	.625	STAWN0025TH
	3	STAWSN0026	1.252	1.531	1.92	3.81	3.74		
	5	STAWMN0026	2.039	2.311	2.71	4.60	4.53		
	8	STAWLN0026	3.220	3.501	3.89	5.78	5.71		
.4062	1.5	STAWSS0026	.661	.940	1.33	3.22	3.15	.625	STAWN0026TH
	3	STAWSN0026	1.252	1.534	1.92	3.81	3.74		
	5	STAWMN0026	2.039	2.314	2.71	4.60	4.53		
	8	STAWLN0026	3.220	3.504	3.89	5.78	5.71		
.4219	1.5	STAWSS0027	.697	.943	1.34	3.23	3.15	.625	STAWN0027TH
	3	STAWSN0027	1.315	1.537	1.93	3.82	3.74		
	5	STAWMN0027	2.142	2.317	2.72	4.61	4.53		
	8	STAWLN0027	3.382	3.507	3.90	5.79	5.71		
.4375	1.5	STAWSS0028	.728	1.064	1.50	3.39	3.31	.625	STAWN0028TH
	3	STAWSN0028	1.378	1.690	2.13	4.02	3.94		
	5	STAWMN0028	2.244	2.680	3.11	5.00	4.92		
	8	STAWLN0028	3.543	3.860	4.29	6.18	6.10		
.4531	1.5	STAWSS0030	.764	1.067	1.50	3.39	3.31	.625	STAWN0029TH
	3	STAWSN0030	1.441	1.693	2.13	4.02	3.94		
	5	STAWMN0030	2.346	2.683	3.11	5.00	4.92		
	8	STAWLN0030	3.705	3.863	4.29	6.18	6.10		
.4688	1.5	STAWSS0030	.764	1.069	1.51	3.40	3.31	.625	STAWN0030TH
	3	STAWSN0030	1.441	1.695	2.14	4.03	3.94		
	5	STAWMN0030	2.346	2.685	3.12	5.01	4.92		
	8	STAWLN0030	3.705	3.865	4.30	6.19	6.10		
.4844	1.5	STAWSS0031	.795	1.148	1.63	3.52	3.43	.625	STAWN0031TH
	3	STAWSN0031	1.504	1.858	2.33	4.22	4.13		

DC	xD	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	Insert
.4844	5	STAWMN0031	2.449	2.848	3.32	5.21	5.12	.625	STAWN0031TH
	8	STAWLN0031	3.866	4.218	4.70	6.59	6.50		
.5000	1.5	STAWSS0032	.831	1.151	1.63	3.52	3.43	.625	STAWN0032TH
	3	STAWSN0032	1.567	1.861	2.33	4.22	4.13		
	5	STAWMN0032	2.551	2.851	3.32	5.21	5.12		
	8	STAWLN0032	4.028	4.221	4.70	6.59	6.50		
.5156	1.5	STAWSS0034	.862	1.274	1.79	3.67	3.58	.625	STAWN0033TH
	3	STAWSN0034	1.630	2.024	2.53	4.42	4.33		
	5	STAWMN0034	2.654	3.004	3.52	5.40	5.31		
	8	STAWLN0034	4.189	4.584	5.09	6.98	6.89		
.5312	1.5	STAWSS0034	.862	1.277	1.80	3.68	3.58	.625	STAWN0034TH
	3	STAWSN0034	1.630	2.027	2.54	4.43	4.33		
	5	STAWMN0034	2.654	3.007	3.53	5.41	5.31		
	8	STAWLN0034	4.189	4.587	5.10	6.99	6.89		
.5469	1.5	STAWSS0035	.898	1.280	1.80	3.68	3.58	.625	STAWN0035TH
	3	STAWSN0035	1.693	2.030	2.54	4.43	4.33		
	5	STAWMN0035	2.756	3.010	3.53	5.41	5.31		
	8	STAWLN0035	4.350	4.590	5.10	6.99	6.89		
.5625	1.5	STAWSS0036	.925	1.322	1.87	3.76	3.66	.625	STAWN0036TH
	3	STAWSN0036	1.752	2.192	2.74	4.63	4.53		
	5	STAWMN0036	2.854	3.372	3.92	5.81	5.71		
	8	STAWLN0036	4.508	4.902	5.49	7.38	7.28		
.5781	1.5	STAWSS0037	.961	1.325	1.88	3.77	3.66	.625	STAWN0037TH
	3	STAWSN0037	1.815	2.195	2.75	4.64	4.53		
	5	STAWMN0037	2.957	3.375	3.93	5.82	5.71		
	8	STAWLN0037	4.669	4.905	5.50	7.39	7.28		

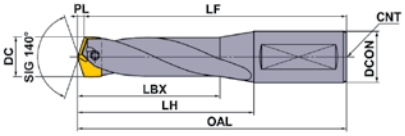
DC	xD	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	Insert
.5938	1.5	STAWSS0039	.992	1.408	2.00	3.97	3.86	.750	STAWN0038TH
	3	STAWSN0039	1.878	2.468	3.06	5.03	4.92		
	5	STAWMN0039	3.059	3.648	4.24	6.21	6.10		
	8	STAWLN0039	4.831	5.228	5.94	7.91	7.80		
.6094	1.5	STAWSS0039	.992	1.411	2.00	3.97	3.86	.750	STAWN0039TH
	3	STAWSN0039	1.878	2.471	3.06	5.03	4.92		
	5	STAWMN0039	3.059	3.651	4.24	6.21	6.10		
	8	STAWLN0039	4.831	5.231	5.94	7.91	7.80		
.6250	1.5	STAWSS0041	1.028	1.454	2.08	4.05	3.94	.750	STAWN0040T
	3	STAWSN0041	1.941	2.474	3.26	5.23	5.12		
	5	STAWMN0041	3.161	3.654	4.64	6.61	6.50		
	8	STAWLN0041	4.992	5.544	6.33	8.30	8.19		
.6406	1.5	STAWSS0041	1.028	1.457	2.09	4.06	3.94	.750	STAWN0041T
	3	STAWSN0041	1.941	2.477	3.27	5.24	5.12		
	5	STAWMN0041	3.161	3.657	4.65	6.62	6.50		
	8	STAWLN0041	4.992	5.547	6.34	8.31	8.19		
.6563	1.5	STAWSS0044	1.094	1.539	2.21	4.18	4.06	.750	STAWN0042T
	3	STAWSN0044	2.067	2.519	3.47	5.43	5.31		
	5	STAWMN0044	3.366	3.859	4.84	6.81	6.69		
	8	STAWLN0044	5.315	5.859	6.66	8.62	8.50		
.6719	1.5	STAWSS0044	1.094	1.542	2.21	4.18	4.06	.750	STAWN0043T
	3	STAWSN0044	2.067	2.522	3.47	5.43	5.31		
	5	STAWMN0044	3.366	3.862	4.84	6.81	6.69		
	8	STAWLN0044	5.315	5.862	6.66	8.62	8.50		
.6875	1.5	STAWSS0044	1.094	1.545	2.22	4.19	4.06	.750	STAWN0044T
	3	STAWSN0044	2.067	2.525	3.48	5.44	5.31		
	5	STAWMN0044	3.366	3.865	4.85	6.82	6.69		
	8	STAWLN0044	5.315	5.865	6.67	8.63	8.50		
.7031	1.5	STAWSS0046	1.161	1.588	2.30	4.26	4.13	.750	STAWN0045T
	3	STAWSN0046	2.193	2.648	3.67	5.64	5.51		
	5	STAWMN0046	3.571	4.068	5.05	7.02	6.89		
	8	STAWLN0046	5.638	6.188	6.98	8.95	8.82		
.7188	1.5	STAWSS0046	1.161	1.591	2.30	4.26	4.13	.750	STAWN0046T
	3	STAWSN0046	2.193	2.651	3.67	5.64	5.51		
	5	STAWMN0046	3.571	4.071	5.05	7.02	6.89		
	8	STAWLN0046	5.638	6.191	6.98	8.95	8.82		

* The above dimensions are for when installing the inserts.

MITSUBISHI DIAEDGE

MODULAR DRILLING SYSTEM WITH REPLACEABLE CARBIDE HEADS

TAW UP TO 1.1875" DIA.



- Internal Coolant
- Wavy cutting edge design for good chip control.
- Serration geometry for accurate insert location.

3xD

DC	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	CNT	Insert
.7344	TAWSN0049	2.319	2.811	4.032	6.282	6.148	1.000	1/8-27	TAWNH0047T
.7500									TAWNH0048T
.7656									TAWNH0049T
.7813	TAWSN0051	2.441	2.977	4.040	6.290	6.148	1.000	1/8-27	TAWNH0050T
.7969									TAWNH0051T
.8125	TAWSN0054	2.567	3.101	4.046	6.296	6.148	1.000	1/8-27	TAWNH0052T
.8281									TAWNH0053T
.8438									TAWNH0054T
.8594	TAWSN0056	2.693	3.266	4.250	6.500	6.344	1.000	1/8-27	TAWNH0055T
.8750									TAWNH0056T
.8906	TAWSN0059	2.819	3.390	4.256	6.506	6.344	1.000	1/8-27	TAWNH0057T
.9063									TAWNH0058T
.9219									TAWNH0059T
.9375	TAWSN0061	2.945	3.557	4.502	6.877	6.706	1.250	1/4-18	TAWNH0060T
.9531									TAWNH0061T
.9688	TAWSN0100	3.071	3.641	4.507	6.882	6.706	1.250	1/4-18	TAWNH0062T
.9844									TAWNH0063T
1.0000									TAWNH0100T
1.0156	TAWSN0102	3.193	3.807	4.713	7.088	6.903	1.250	1/4-18	TAWNH0101T
1.0313									TAWNH0102T
1.0469	TAWSN0105	3.319	3.892	4.719	7.094	6.903	1.250	1/4-18	TAWNH0103T
1.0625									TAWNH0104T
1.0781									TAWNH0105T
1.0938	TAWSN0107	3.445	4.018	4.923	7.298	7.099	1.250	1/4-18	TAWNH0106T
1.1094									TAWNH0107T
1.1250	TAWSN0110	3.571	4.142	5.126	7.501	7.296	1.250	1/4-18	TAWNH0108T
1.1406									TAWNH0109T
1.1563									TAWNH0110T
1.1719	TAWSN0112	3.697	4.307	5.134	7.509	7.296	1.250	1/4-18	TAWNH0111T
1.1875									TAWNH0112T

5xD

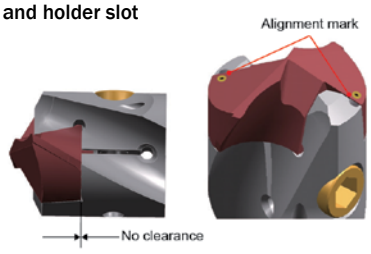
DC	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	CNT	Insert
.7344	TAWMN0049	3.776	4.347	5.410	7.660	7.526	1.000	1/8-27	TAWNH0047T
.7500									TAWNH0048T
.7656									TAWNH0049T
.7813	TAWMN0051	3.976	4.591	5.614	7.864	7.722	1.000	1/8-27	TAWNH0050T
.7969									TAWNH0051T
.8125	TAWMN0054	4.181	4.794	5.620	7.870	7.722	1.000	1/8-27	TAWNH0052T
.8281									TAWNH0053T
.8438									TAWNH0054T
.8594	TAWMN0056	4.386	5.038	5.825	8.075	7.919	1.000	1/8-27	TAWNH0055T
.8750									TAWNH0056T
.8906	TAWMN0059	4.591	5.241	6.225	8.475	8.313	1.000	1/8-27	TAWNH0057T
.9063									TAWNH0058T
.9219									TAWNH0059T
.9375	TAWMN0061	4.795	5.486	6.470	8.845	8.674	1.250	1/4-18	TAWNH0060T
.9531									TAWNH0061T
.9688	TAWMN0100	5.000	5.688	6.672	9.047	8.871	1.250	1/4-18	TAWNH0062T
.9844									TAWNH0063T
1.0000									TAWNH0100T
1.0156	TAWMN0102	5.201	5.933	6.878	9.253	9.068	1.250	1/4-18	TAWNH0101T
1.0313									TAWNH0102T
1.0469	TAWMN0105	5.406	6.136	7.081	9.456	9.265	1.250	1/4-18	TAWNH0103T
1.0625									TAWNH0104T
1.0781									TAWNH0105T
1.0938	TAWMN0107	5.610	6.380	7.286	9.661	9.462	1.250	1/4-18	TAWNH0106T
1.1094									TAWNH0107T
1.1250	TAWMN0110	5.815	6.583	7.488	9.863	9.658	1.250	1/4-18	TAWNH0108T
1.1406									TAWNH0109T
1.1563									TAWNH0110T
1.1719	TAWMN0112	6.020	6.788	7.890	10.265	10.052	1.250	1/4-18	TAWNH0111T
1.1875									TAWNH0112T

8xD

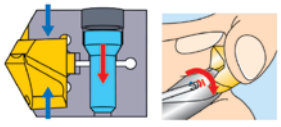
DC	Holder PART#	Dimensions* LU	LBX	LH	OAL	LF	DCON	CNT	Insert
.7344	TAWLN0049	5.961	6.512	7.417	9.669	9.535	1.000	1/8-27	TAWNH0047T
.7500									TAWNH0048T
.7656									TAWNH0049T
.7813	TAWLN0051	6.280	6.835	7.740	9.992	9.850	1.000	1/8-27	TAWNH0050T
.7969									TAWNH0051T
.8125	TAWLN0054	6.602	7.156	8.101	10.353	10.205	1.000	1/8-27	TAWNH0052T
.8281									TAWNH0053T
.8438									TAWNH0054T
.8594	TAWLN0056	6.925	7.479	8.424	10.676	10.520	1.000	1/8-27	TAWNH0055T
.8750									TAWNH0056T
.8906	TAWLN0059	7.248	7.800	8.942	11.193	11.031	1.000	1/8-27	TAWNH0057T
.9063									TAWNH0058T
.9219									TAWNH0059T
.9375	TAWLN0061	7.571	8.124	9.305	11.679	11.508	1.250	1/4-18	TAWNH0060T
.9531									TAWNH0061T
.9688	TAWLN0100	7.894	8.444	9.625	11.999	11.823	1.250	1/4-18	TAWNH0062T
.9844									TAWNH0063T
1.0000									TAWNH0100T
1.0156	TAWLN0102	8.213	8.768	9.949	12.323	12.138	1.250	1/4-18	TAWNH0101T
1.0313									TAWNH0102T
1.0469	TAWLN0105	8.535	9.089	10.270	12.644	12.453	1.250	1/4-18	TAWNH0103T
1.0625									TAWNH0104T
1.0781									TAWNH0105T
1.0938	TAWLN0107	8.858	9.412	10.593	12.967	12.768	1.250	1/4-18	TAWNH0106T
1.1094									TAWNH0107T
1.1250	TAWLN0110	9.181	9.733	10.914	13.288	13.083	1.250	1/4-18	TAWNH0108T
1.1406									TAWNH0109T
1.1563									TAWNH0110T
1.1719	TAWLN0112	9.504	10.056	11.433	13.807	13.594	1.250	1/4-18	TAWNH0111T
1.1875									TAWNH0112T

* The above dimensions are for when installing the inserts.

Check there is no gap between the bottom of the insert and holder slot



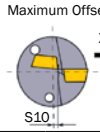
After the insert has been set in the holder slot, tighten the inner screw while pushing the insert lightly into the pocket as shown

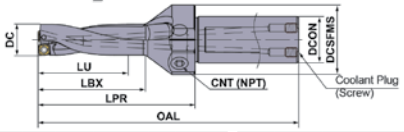


MITSUBISHI DIAEDGE

MVX INDEXABLE DRILLS

HIGHLY RIGID BODY ALLOWS UP TO 6xD DEPTH OF CUT





DC	DEPTH OF CUT	PART	LU	LBX	LPR	OAL	DCON	DCSFMS	S10	Insert Type
.562	Dx 2	MVX0562X2C075	1.12	1.40	2.19	4.19	.750	1.25	.026	SOOX05
	Dx 3	MVX0562X3C075	1.69	1.96	2.75	4.75	.750	1.25	.026	SOOX05
	Dx 4	MVX0562X4C075	2.25	2.52	3.32	5.32	.750	1.25	.026	SOOX05
	Dx 5*	MVX0562X5F075	2.81	3.09	3.61	5.61	.750	.98	.026	SOOX05
.593	Dx 2	MVX0593X2C075	1.19	1.46	2.25	4.25	.750	1.25	.016	SOOX05
	Dx 3	MVX0593X3C075	1.78	2.06	2.85	4.85	.750	1.25	.016	SOOX05
	Dx 4	MVX0593X4C075	2.37	2.65	3.44	5.44	.750	1.25	.016	SOOX05
	Dx 5*	MVX0593X5F075	2.97	3.24	3.77	5.77	.750	.98	.016	SOOX05
.625	Dx 2	MVX0625X2C075	1.25	1.53	2.32	4.32	.750	1.25	.013	SOOX05
	Dx 3	MVX0625X3C075	1.88	2.15	2.94	4.94	.750	1.25	.013	SOOX05
	Dx 4	MVX0625X4C075	2.50	2.78	3.57	5.57	.750	1.25	.013	SOOX05
	Dx 5*	MVX0625X5F075	3.13	3.40	3.93	5.93	.750	.98	.013	SOOX05
.656	Dx 2	MVX0656X2C075	1.31	1.59	2.38	4.38	.750	1.25	.009	SOOX05
	Dx 3	MVX0656X3C075	1.97	2.24	3.04	5.04	.750	1.25	.009	SOOX05
	Dx 4	MVX0656X4C075	2.62	2.90	3.69	5.69	.750	1.25	.009	SOOX05
	Dx 5*	MVX0656X5F075	3.28	3.56	4.08	6.08	.750	.98	.009	SOOX05
.687	Dx 2	MVX0687X2C100	1.37	1.65	2.72	4.97	1.000	1.50	.023	SOOX06
	Dx 3	MVX0687X3C100	2.06	2.34	3.41	5.66	1.000	1.50	.023	SOOX06
	Dx 4	MVX0687X4C100	2.75	3.03	4.09	6.34	1.000	1.50	.023	SOOX06
	Dx 5	MVX0687X5C100	3.44	3.71	4.78	7.03	1.000	1.50	.023	SOOX06
	Dx 6	MVX0687X6C100	4.12	4.40	5.47	7.72	1.000	1.50	.023	SOOX06
.750	Dx 2	MVX0750X2C100	1.50	1.78	2.91	5.16	1.000	1.50	.016	SOOX06
	Dx 3	MVX0750X3C100	2.25	2.53	3.66	5.91	1.000	1.50	.016	SOOX06
	Dx 4	MVX0750X4C100	3.00	3.28	4.41	6.66	1.000	1.50	.016	SOOX06
	Dx 5	MVX0750X5C100	3.75	4.03	5.16	7.41	1.000	1.50	.016	SOOX06
	Dx 6	MVX0750X6C100	4.50	4.78	5.91	8.16	1.000	1.50	.016	SOOX06
.812	Dx 2	MVX0812X2C100	1.62	1.90	3.01	5.26	1.000	1.50	.027	SOOX07
	Dx 3	MVX0812X3C100	2.44	2.71	3.82	6.07	1.000	1.50	.027	SOOX07
	Dx 4	MVX0812X4C100	3.25	3.53	4.63	6.88	1.000	1.50	.027	SOOX07
	Dx 5	MVX0812X5C100	4.06	4.34	5.44	7.69	1.000	1.50	.027	SOOX07
	Dx 6	MVX0812X6C100	4.87	5.15	6.26	8.51	1.000	1.50	.027	SOOX07
.875	Dx 2	MVX0875X2C100	1.75	2.03	3.12	5.37	1.000	1.50	.020	SOOX07
	Dx 3	MVX0875X3C100	2.63	2.90	4.00	6.25	1.000	1.50	.020	SOOX07
	Dx 4	MVX0875X4C100	3.50	3.78	4.87	7.12	1.000	1.50	.020	SOOX07
	Dx 5	MVX0875X5C100	4.38	4.65	5.75	8.00	1.000	1.50	.020	SOOX07
	Dx 6	MVX0875X6C100	5.25	5.53	6.62	8.87	1.000	1.50	.020	SOOX07
.937	Dx 2	MVX0937X2C100	1.87	2.15	3.24	5.49	1.000	1.50	.037	SOOX08
	Dx 3	MVX0937X3C100	2.81	3.09	4.17	6.42	1.000	1.50	.037	SOOX08
	Dx 4	MVX0937X4C100	3.75	4.03	5.11	7.36	1.000	1.50	.037	SOOX08
	Dx 5	MVX0937X5C100	4.69	4.96	6.05	8.30	1.000	1.50	.037	SOOX08
	Dx 6	MVX0937X6C100	5.62	5.90	6.99	9.24	1.000	1.50	.037	SOOX08
1.000	Dx 2	MVX1000X2C125	2.00	2.28	3.35	5.73	1.250	1.75	.030	SOOX08
	Dx 3	MVX1000X3C125	3.00	3.28	4.35	6.73	1.250	1.75	.030	SOOX08
	Dx 4	MVX1000X4C125	4.00	4.28	5.35	7.73	1.250	1.75	.030	SOOX08
	Dx 5	MVX1000X5C125	5.00	5.28	6.35	8.73	1.250	1.75	.030	SOOX08
	Dx 6	MVX1000X6C125	6.00	6.28	7.35	9.73	1.250	1.75	.030	SOOX08

DC	DEPTH OF CUT	PART	LU	LBX	LPR	OAL	DCON	DCSFMS	S10	Insert Type
1.062	Dx 2	MVX1062X2C125	2.12	2.40	3.46	5.84	1.250	1.75	.022	SOOX08
	Dx 3	MVX1062X3C125	3.19	3.46	4.53	6.90	1.250	1.75	.022	SOOX08
	Dx 4	MVX1062X4C125	4.25	4.53	5.59	7.96	1.250	1.75	.022	SOOX08
	Dx 5	MVX1062X5C125	5.31	5.59	6.65	9.03	1.250	1.75	.022	SOOX08
	Dx 6	MVX1062X6C125	6.37	6.65	7.71	10.09	1.250	1.75	.022	SOOX08
1.125	Dx 2	MVX1125X2C125	2.25	2.53	3.64	6.01	1.250	1.75	.040	SOOX09
	Dx 3	MVX1125X3C125	3.38	3.65	4.76	7.14	1.250	1.75	.040	SOOX09
	Dx 4	MVX1125X4C125	4.50	4.78	5.89	8.26	1.250	1.75	.040	SOOX09
	Dx 5	MVX1125X5C125	5.63	5.90	7.01	9.39	1.250	1.75	.040	SOOX09
	Dx 6	MVX1125X6C125	6.75	7.03	8.14	10.51	1.250	1.75	.040	SOOX09
1.187	Dx 2	MVX1187X2C125	2.37	2.65	3.76	6.13	1.250	1.75	.033	SOOX09
	Dx 3	MVX1187X3C125	3.56	3.84	4.94	7.32	1.250	1.75	.033	SOOX09
	Dx 4	MVX1187X4C125	4.75	5.03	6.13	8.51	1.250	1.75	.033	SOOX09
	Dx 5	MVX1187X5C125	5.94	6.21	7.32	9.69	1.250	1.75	.033	SOOX09
	Dx 6	MVX1187X6C125	7.12	7.40	8.51	10.88	1.250	1.75	.033	SOOX09
1.250	Dx 2	MVX1250X2C150	2.50	2.78	3.87	6.62	1.500	2.00	.025	SOOX09
	Dx 3	MVX1250X3C150	3.75	4.03	5.12	7.87	1.500	2.00	.025	SOOX09
	Dx 4	MVX1250X4C150	5.00	5.28	6.37	9.12	1.500	2.00	.025	SOOX09
	Dx 5	MVX1250X5C150	6.25	6.53	7.62	10.37	1.500	2.00	.025	SOOX09
	Dx 6	MVX1250X6C150	7.50	7.78	8.87	11.62	1.500	2.00	.025	SOOX09
1.312	Dx 2	MVX1312X2C150	2.62	2.90	4.40	7.15	1.500	2.00	.049	SOOX11
	Dx 3	MVX1312X3C150	3.94	4.21	5.71	8.46	1.500	2.00	.049	SOOX11
	Dx 4	MVX1312X4C150	5.25	5.53	7.02	9.77	1.500	2.00	.049	SOOX11
	Dx 5	MVX1312X5C150	6.56	6.84	8.33	11.08	1.500	2.00	.049	SOOX11
	Dx 6	MVX1312X6C150	7.87	8.15	9.65	12.40	1.500	2.00	.049	SOOX11
1.375	Dx 2	MVX1375X2C150	2.75	3.03	4.52	7.27	1.500	2.00	.041	SOOX11
	Dx 3	MVX1375X3C150	4.13	4.40	5.90	8.65	1.500	2.00	.041	SOOX11
	Dx 4	MVX1375X4C150	5.50	5.78	7.27	10.02	1.500	2.00	.041	SOOX11
	Dx 5	MVX1375X5C150	6.88	7.15	8.65	11.40	1.500	2.00	.041	SOOX11
	Dx 6	MVX1375X6C150	8.25	8.53	10.02	12.77	1.500	2.00	.041	SOOX11
1.437	Dx 2	MVX1437X2C150	2.87	3.15	4.65	7.40	1.500	2.00	.036	SOOX11
	Dx 3	MVX1437X3C150	4.31	4.59	6.08	8.83	1.500	2.00	.036	SOOX11
	Dx 4	MVX1437X4C150	5.75	6.03	7.52	10.27	1.500	2.00	.036	SOOX11
	Dx 5	MVX1437X5C150	7.19	7.46	8.96	11.71	1.500	2.00	.036	SOOX11
	Dx 6	MVX1437X6C150	8.62	8.90	10.40	13.15	1.500	2.00	.036	SOOX11
1.500	Dx 2	MVX1500X2C150	3.00	3.28	4.77	7.52	1.500	2.00	.031	SOOX11
	Dx 3	MVX1500X3C150	4.50	4.78	6.27	9.02	1.500	2.00	.031	SOOX11
	Dx 4	MVX1500X4C150	6.00	6.28	7.77	10.52	1.500	2.00	.031	SOOX11
	Dx 5	MVX1500X5C150	7.50	7.78	9.27	12.02	1.500	2.00	.031	SOOX11
	Dx 6	MVX1500X6C150	9.00	9.28	10.77	13.52	1.500	2.00	.031	SOOX11
1.562	Dx 2	MVX1562X2C150	3.12	3.40	4.90	7.65	1.500	2.00	.021	SOOX11
	Dx 3	MVX1562X3C150	4.69	4.96	6.46	9.21	1.500	2.00	.021	SOOX11
	Dx 4	MVX1562X4C150	6.25	6.53	8.02	10.77	1.500	2.00	.021	SOOX11
	Dx 5	MVX1562X5C150	7.81	8.09	9.58	12.33	1.500	2.00	.021	SOOX11
	Dx 6	MVX1562X6C150	9.37	9.65	11.15	13.90	1.500	2.00	.021	SOOX11

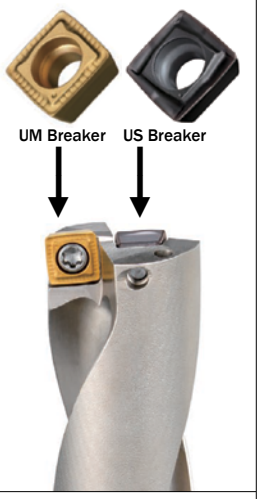
DC	DEPTH OF CUT	PART	LU	LBX	LPR	OAL	DCON	DCSFMS	S10	Insert Type
1.625	Dx 2	MVX1625X2C150	3.25	3.53	5.02	7.77	1.500	2.00	.053	SOOX13
	Dx 3	MVX1625X3C150	4.88	5.15	6.65	9.40	1.500	2.00	.053	SOOX13
	Dx 4	MVX1625X4C150	6.50	6.78	8.27	11.02	1.500	2.00	.053	SOOX13
	Dx 5	MVX1625X5C150	8.13	8.40	9.90	12.65	1.500	2.00	.053	SOOX13
	Dx 6	MVX1625X6C150	9.75	10.03	11.52	14.27	1.500	2.00	.053	SOOX13
1.687	Dx 2	MVX1687X2C150	3.37	3.65	5.15	7.90	1.500	2.00	.047	SOOX13
	Dx 3	MVX1687X3C150	5.06	5.34	6.83	9.58	1.500	2.00	.047	SOOX13
	Dx 4	MVX1687X4C150	6.75	7.03	8.52	11.27	1.500	2.00	.047	SOOX13
	Dx 5	MVX1687X5C150	8.44	8.71	10.21	12.96	1.500	2.00	.047	SOOX13
	Dx 6	MVX1687X6C150	10.12	10.40	11.90	14.65	1.500	2.00	.047	SOOX13
1.750	Dx 2	MVX1750X2C150	3.50	3.78	5.27	8.02	1.500	2.00	.041	SOOX13
	Dx 3	MVX1750X3C150	5.25	5.53	7.02	9.77	1.500	2.00	.041	SOOX13
	Dx 4	MVX1750X4C150	7.00	7.28	8.77	11.52	1.500	2.00	.041	SOOX13
	Dx 5	MVX1750X5C150	8.75	9.03	10.52	13.27	1.500	2.00	.041	SOOX13
1.812	Dx 2	MVX1812X2C150	3.62	3.90	5.40	8.15	1.500	2.00	.031	SOOX13
	Dx 3	MVX1812X3C150	5.44	5.71	7.21	9.96	1.500	2.00	.031	SOOX13
	Dx 4	MVX1812X4C150	7.25	7.53	9.02	11.77	1.500	2.00	.031	SOOX13
	Dx 5	MVX1812X5C150	9.06	9.34	10.83	13.58	1.500	2.00	.031	SOOX13
1.875	Dx 2	MVX1875X2C150	3.75	4.03	5.60	8.35	1.500	2.48	.072	SOOX16
	Dx 3	MVX1875X3C150	5.63	5.90	7.48	10.23	1.500	2.48	.072	SOOX16
	Dx 4	MVX1875X4C150	7.50	7.78	9.35	12.10	1.500	2.48	.072	SOOX16
	Dx 5	MVX1875X5C150	9.38	9.65	11.23	13.98	1.500	2.48	.072	SOOX16
1.937	Dx 2	MVX1937X2C150	3.87	4.15	5.73	8.48	1.500	2.48	.066	SOOX16
	Dx 3	MVX1937X3C150	5.81	6.09	7.66	10.41	1.500	2.48	.066	SOOX16
	Dx 4	MVX1937X4C150	7.75	8.03	9.60	12.35	1.500	2.48	.066	SOOX16
	Dx 5	MVX1937X5C150	9.69	9.96	11.54	14.29	1.500	2.48	.066	SOOX16
2.000	Dx 2	MVX2000X2C150	4.00	4.28	5.85	8.60	1.500	2.48	.060	SOOX16
	Dx 3	MVX2000X3C150	6.00	6.28	7.85	10.60	1.500	2.48	.060	SOOX16
	Dx 4	MVX2000X4C150	8.00	8.28	9.85	12.60	1.500	2.48	.060	SOOX16
	Dx 5	MVX2000X5C150	10.00	10.28	11.85	14.60	1.500	2.48	.060	SOOX16
2.125	Dx 2	MVX2125X2C150	4.25	4.53	6.10	8.85	1.500	2.48	.047	SOOX16
	Dx 3	MVX2125X3C150	6.38	6.65	8.23	10.98	1.500	2.48	.047	SOOX16
	Dx 4	MVX2125X4C150	8.50	8.78	10.35	13.10	1.500	2.48	.047	SOOX16
	Dx 5	MVX2125X5C150	10.63	10.90	12.48	15.23	1.500	2.48	.047	SOOX16
2.250	Dx 2	MVX2250X2C150	4.50	4.78	6.35	9.10	1.500	2.68	.057	SOOX18
	Dx 3	MVX2250X3C150	6.75	7.03	8.60	11.35	1.500	2.68	.057	SOOX18
	Dx 4	MVX2250X4C150	9.00	9.28	10.85	13.60	1.500	2.68	.057	SOOX18
	Dx 5	MVX2250X5C150	11.25	11.53	13.10	15.85	1.500	2.68	.057	SOOX18
2.375	Dx 2	MVX2375X2C150	4.75	5.03	6.60	9.35	1.500	2.68	.044	SOOX18
	Dx 3	MVX2375X3C150	7.13	7.40	8.98	11.73	1.500	2.68	.044	SOOX18
	Dx 4	MVX2375X4C150	9.50	9.78	11.35	14.10	1.500	2.68	.044	SOOX18
	Dx 5	MVX2375X5C150	11.88	12.15	13.73	16.48	1.500	2.68	.044	SOOX18
2.500	Dx 2	MVX2500X2C150	5.00	5.28	6.85	9.60	1.500	2.68	.031	SOOX18
	Dx 3	MVX2500X3C150	7.50	7.78	9.35	12.10	1.500	2.68	.031	SOOX18
	Dx 4	MVX2500X4C150	10.00	10.28	11.85	14.60	1.500	2.68	.031	SOOX18
	Dx 5	MVX2500X5C150	12.50	12.78	14.35	17.10	1.500	2.68	.031	SOOX18

* Side Coolant Not Available

INSERTS

		1st Recommendation		When Outer Insert Fractures	
		Outer Insert	Inner Insert	Outer Insert	Inner Insert
P	Mild Steels, Alloy Steels	MC1020	VP15TF	VP15TF	VP15TF
		UM Breaker	UM Breaker	UM Breaker	UM Breaker
M	Stainless Steels	MC1020	VP15TF	VP15TF	VP15TF
		UM Breaker	US Breaker	UM Breaker	US Breaker
K	Cast Irons	MC1020	VP15TF	VP15TF	VP15TF
		UM Breaker	UM Breaker	UM Breaker	UM Breaker
H	Hardened Steels	MC1020	DP8020	VP15TF	DP8020
		UM Breaker	UH Breaker	UM Breaker	UH Breaker
N	Aluminum Alloys	TF15	TF15		
		UN Breaker	UN Breaker		

- Optimum positioning of the outer & inner inserts results in both inserts having the same contact area, sharing the load and resulting in less deformation.



Shape	Drill Dia.	PART#	IC	S	RE	D1	MC5020	MC1020	VP15TF	DP8020	TF15	Geometry
UM	ø.562" - ø.656"	SOMX-052704-UM	.197	.106	.016	.098	●	●	●			ø.562"–ø.656"
	ø.687" - ø.750"	SOMX-063005-UM	.236	.118	.020	.114	●	●	●			
	ø.812" - ø.875"	SOMX-073505-UM	.276	.138	.020	.138	●	●	●			
	ø.937" - ø1.062"	SOMX-084005-UM	.327	.157	.020	.157	●	●	●			
	ø1.125" - ø1.250"	SOMX-094506-UM	.382	.177	.024	.181	●	●	●			
	ø1.312" - ø1.562"	SOMX-115506-UM	.457	.217	.024	.185	●	●	●			ø.687"–ø2.500"
	ø1.625" - ø1.812"	SOMX-136008-UM	.543	.236	.031	.185	●	●	●			
	ø1.875" - ø2.125"	SOMX-166508-UM	.650	.256	.031	.220	●	●	●			
General Purpose	ø2.250" - ø2.500"	SOMX-187008-UM	.717	.276	.031	.220	●	●	●			
US	ø.687" - ø.750"	SOMX-063005-US	.236	.118	.020	.114			●			
	ø.812" - ø.875"	SOMX-073505-US	.276	.138	.020	.138			●			
	ø.937" - ø1.062"	SOMX-084005-US	.327	.157	.020	.157			●			
	ø1.125" - ø1.250"	SOMX-094506-US	.382	.177	.024	.181			●			
	ø1.312" - ø1.562"	SOMX-115506-US	.457	.217	.024	.185			●			
	ø1.625" - ø1.812"	SOMX-136008-US	.543	.236	.031	.185			●			
	ø1.875" - ø2.125"	SOMX-166508-US	.650	.256	.031	.220			●			
For Stainless Steels and Inner Edge	ø2.250" - ø2.500"	SOMX-187008-US	.717	.276	.031	.220			●			
UH	ø.687" - ø.750"	SOMX-062905-UH	.236	.114	.020	.114				●		
	ø.812" - ø.875"	SOMX-073405-UH	.276	.134	.020	.138				●		
	ø.937" - ø1.062"	SOMX-083905-UH	.327	.154	.020	.157				●		
	ø1.125" - ø1.250"	SOMX-094406-UH	.382	.173	.024	.181				●		
	ø1.312" - ø1.562"	SOMX-115406-UH	.457	.213	.024	.185				●		
	ø1.625" - ø1.812"	SOMX-135908-UH	.543	.232	.031	.185				●		
	ø1.875" - ø2.125"	SOMX-166408-UH	.650	.252	.031	.220				●		
Strong Cutting Edge Type and Inner Edge	ø2.250" - ø2.500"	SOMX-186908-UH	.717	.272	.031	.220				●		
UN	ø.687" - ø.750"	SOGX-063005-UN	.236	.118	.020	.114					●	
	ø.812" - ø.875"	SOGX-073505-UN	.276	.138	.020	.138					●	
	ø.937" - ø1.062"	SOGX-084005-UN	.327	.157	.020	.157					●	
	ø1.125" - ø1.250"	SOGX-094506-UN	.382	.177	.024	.181					●	
	ø1.312" - ø1.562"	SOGX-115506-UN	.457	.217	.024	.185					●	
	ø1.625" - ø1.812"	SOGX-136008-UN	.543	.236	.031	.185					●	
	ø1.875" - ø2.125"	SOGX-166508-UN	.650	.256	.031	.220					●	
For Aluminum Alloys	ø2.250" - ø2.500"	SOGX-187008-UN	.717	.276	.031	.220					●	

Note: 1) MC1020 and MC5020 are made exclusively for use as an outer insert.

GRADES

MC1020
MC1020 is a CVD coated grade for higher cutting speeds.
The main properties are high wear and high plastic deformation resistance for reliability.

VP15TF
VP15TF is a PVD coated grade suitable for a wide range of applications. The micro-grain substrate and Miracle coating provide excellent welding resistance.

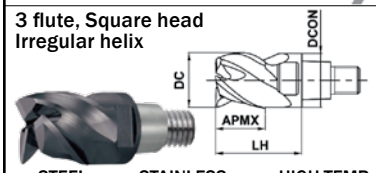
MC5020
MC5020 is a CVD coated grade suitable for drilling cast irons.
It has excellent abrasion resistance and gives long tool life by controlling chipping and thermal cracking that can occur when drilling nodular cast irons.

DP8020
With the combination of a tough, special carbide substrate and high-hardness Ti-Al-Si coating, DP8020 is a PVD coated carbide grade suitable for hardened steels (45HRC or lower) and preventing fracture in steels and cast irons.

MITSUBISHI DIAEDGE — MODULAR ULTRA MICRO GRAIN CARBIDE MILLING HEADS

HOLDERS SHOWN BELOW

3 flute, Square head Irregular helix



- STEEL • STAINLESS • HIGH-TEMP
- Shoulder milling, slot milling and plunging
- Irregular helix controls vibration

PART#	DC	APMX	LH	DCON	
IMX10S3HV0375P	.375	.300	.630	.363	GRADE EP7020
IMX12S3HV0500P	.500	.400	.789	.488	
IMX16S3HV0625P	.625	.500	.945	.605	
IMX20S3HV0750P	.750	.600	1.181	.730	
IMX25S3HV1000P	1.000	.800	1.500	.980	

4 flute, Irregular helix Square head

- STEEL • STAINLESS • HIGH-TEMP
- Shoulder milling, slot milling and plunging
- Irregular helix controls vibration

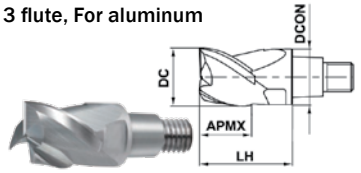
HEADS WITHOUT COOLANT HOLES

PART#	DC	APMX	LH	DCON	
IMX10S4HV0375M	.375	.375	.630	.363	GRADE EP7020
IMX12S4HV0500M	.500	.500	.789	.488	
IMX16S4HV0625M	.625	.625	.945	.605	
IMX20S4HV0750M	.750	.750	1.181	.730	
IMX25S4HV1000M	1.000	1.000	1.500	.980	

HEADS WITH COOLANT HOLES

PART#	DC	APMX	LH	DCON	
IMX10S4HV0375MS	.375	.375	.630	.363	GRADE EP7020
IMX12S4HV0500MS	.500	.500	.789	.488	
IMX16S4HV0625MS	.625	.625	.945	.605	
IMX20S4HV0750MS	.750	.750	1.181	.730	
IMX25S4HV1000MS	1.000	1.000	1.500	.980	

3 flute, For aluminum



- Grade ET2020 • High efficiency machining

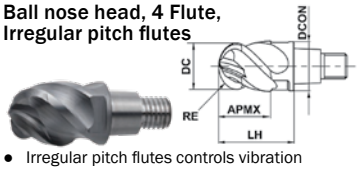
HEADS WITH SQUARE CORNER

PART#	DC	APMX	LH	DCON
IMX10S3A0375P	.375	.300	.630	.363
IMX12S3A0500P	.500	.400	.789	.488
IMX16S3A0625P	.625	.500	.945	.605
IMX20S3A0750P	.750	.600	1.181	.730
IMX25S3A1000P	1.000	.800	1.500	.980

HEADS WITH CORNER RADIUS

PART#	DC	RE	APMX	LH	DCON
IMX10C3A0375R015P	.375	.015	.300	.630	.363
IMX10C3A0375R030P	.375	.030	.300	.630	.363
IMX12C3A0500R015P	.500	.015	.400	.789	.488
IMX12C3A0500R030P	.500	.030	.400	.789	.488
IMX16C3A0625R030P	.625	.030	.500	.945	.605
IMX16C3A0625R060P	.625	.060	.500	.945	.605
IMX20C3A0750R030P	.750	.030	.600	1.181	.730
IMX20C3A0750R060P	.750	.060	.600	1.181	.730
IMX25C3A1000R060P	1.000	.060	.800	1.500	.980
IMX25C3A1000R125P	1.000	.125	.800	1.500	.980

Ball nose head, 4 Flute, Irregular pitch flutes



- Irregular pitch flutes controls vibration
- STEEL • STAINLESS • HIGH-TEMP

HEADS WITHOUT COOLANT HOLES

PART#	RE	DC	APMX	LH	DCON	
IMX10B4HV0375M	.1875	.375	.395	.630	.363	GRADE EP7020
IMX12B4HV0500M	.2500	.500	.520	.789	.488	
IMX16B4HV0625M	.3125	.625	.645	.945	.605	
IMX20B4HV0750M	.3750	.750	.800	1.181	.730	
IMX25B4HV1000M	.5000	1.000	1.050	1.500	.980	

HEADS WITH COOLANT HOLES

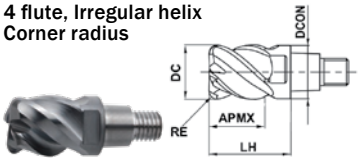
PART#	RE	DC	APMX	LH	DCON	
IMX10B4HV0375ME	.1875	.375	.395	.630	.363	GRADE EP7020
IMX12B4HV0500ME	.2500	.500	.520	.789	.488	
IMX16B4HV0625ME	.3125	.625	.645	.945	.605	
IMX20B4HV0750ME	.3750	.750	.800	1.181	.730	
IMX25B4HV1000ME	.5000	1.000	1.050	1.500	.980	

Holder & Head Combination

Holder Series Description	Head Series Description
IMX 10	IMX 10
IMX 12	IMX 12
IMX 16	IMX 16
IMX 20	IMX 20
IMX 25	IMX 25

Holder & head combination should be the same.

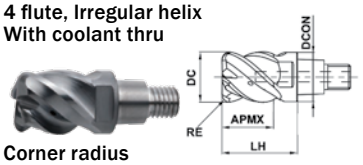
4 flute, Irregular helix Corner radius



- STEEL • STAINLESS • HIGH-TEMP
- Shoulder milling, slot milling and plunging
- Irregular helix controls vibration

PART#	DC	RE	APMX	LH	DCON	
IMX10C4HV0375R015M	.375	.015	.375	.630	.363	GRADE EP7020
IMX10C4HV0375R030M	.375	.030	.375	.630	.363	
IMX10C4HV0375R060M	.375	.060	.375	.630	.363	
IMX12C4HV0500R015M	.500	.015	.500	.789	.488	
IMX12C4HV0500R030M	.500	.030	.500	.789	.488	
IMX12C4HV0500R060M	.500	.060	.500	.789	.488	
IMX16C4HV0625R015M	.625	.015	.625	.945	.605	
IMX16C4HV0625R030M	.625	.030	.625	.945	.605	
IMX16C4HV0625R060M	.625	.060	.625	.945	.605	
IMX20C4HV0750R030M	.750	.030	.750	1.181	.730	
IMX20C4HV0750R060M	.750	.060	.750	1.181	.730	
IMX20C4HV0750R125M	.750	.125	.750	1.181	.730	
IMX20C4HV0750R190M	.750	.190	.750	1.181	.730	
IMX20C4HV0750R250M	.750	.250	.750	1.181	.730	
IMX25C4HV1000R030M	1.000	.030	1.000	1.500	.980	
IMX25C4HV1000R060M	1.000	.060	1.000	1.500	.980	
IMX25C4HV1000R125M	1.000	.125	1.000	1.500	.980	
IMX25C4HV1000R190M	1.000	.190	1.000	1.500	.980	
IMX25C4HV1000R250M	1.000	.250	1.000	1.500	.980	

4 flute, Irregular helix With coolant thru

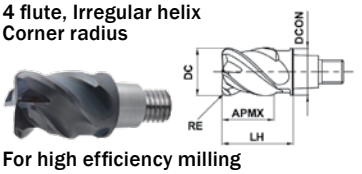


Corner radius

- STEEL • STAINLESS • HIGH-TEMP
- Shoulder milling, slot milling and plunging
- Irregular helix controls vibration
- Coolant thru for each cutting edge

PART#	DC	RE	APMX	LH	DCON	
IMX10C4HV0375R030MS	.375	.030	.375	.630	.363	GRADE EP7020
IMX12C4HV0500R030MS	.500	.030	.500	.789	.488	
IMX16C4HV0625R030MS	.625	.030	.625	.945	.605	
IMX20C4HV0750R030MS	.750	.030	.750	1.181	.730	
IMX25C4HV1000R030MS	1.000	.030	1.000	1.500	.980	

4 flute, Irregular helix Corner radius



For high efficiency milling

- FOR STEEL & HARDENED STEEL
- Irregular helix controls vibration

PART#	DC	RE	APMX	LH	DCON	
IMX10C4FV0375R090M	.375	.090	.395	.630	.363	GRADE EP6120
IMX12C4FV0500R090M	.500	.090	.520	.789	.488	
IMX16C4FV0625R125M	.625	.125	.645	.945	.605	
IMX20C4FV0750R125M	.750	.125	.800	1.181	.730	
IMX25C4FV1000R190M	1.000	.190	1.050	1.500	.980	

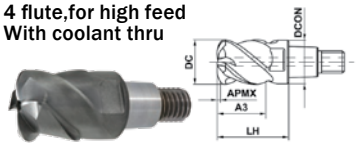
6, 10 & 12 flute, Irregular helix Corner radius

For high efficiency milling

- Shoulder milling, slot milling and plunging
- Irregular helix controls vibration

PART#	DC	RE	APMX	LH	DCON	
IMX10C6HV0375R030M	.375	.030	.395	.630	.363	GRADE EP7020
IMX12C6HV0500R030M	.500	.030	.520	.789	.488	
IMX16C10HV0625R030M	.625	.030	.645	.945	.605	
IMX20C12HV0750R030M	.750	.030	.800	1.181	.730	
IMX25C12HV1000R030M	1.000	.030	1.050	1.500	.980	

4 flute,for high feed With coolant thru

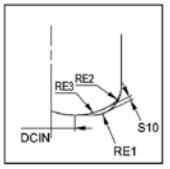


Duplex corner radius

- The duplex corner radius and 4 flute geometry enables efficient machining at higher feed rates
- End face center coolant thru provides a stable supply of coolant
- Steel, stainless, hi-temp, hardened steel
- Duplex corner radius end mill is not suitable for corner radius machining due to the possibility of leaving unmachined areas

PART#	DC	RE1	APMX	A3	LH	DCON	RMPX	
IMX10C4FD0375MC	.375	.076	.024	.395	.630	.363	2.3°	GRADE EP7020
IMX12C4FD0500MC	.500	.086	.033	.520	.789	.488	3.6°	
IMX16C4FD0625MC	.625	.110	.039	.645	.945	.605	2.8°	
IMX20C4FD0750MC	.750	.117	.047	.800	1.181	.730	3.6°	
IMX25C4FD1000MC	1.000	.171	.067	1.050	1.500	.980	4.5°	

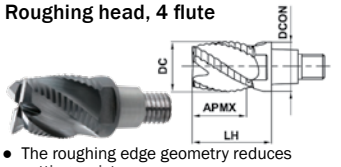
RMPX = Max. Ramping Angle



When using this iMX-C4FD-C, please program as an radius cutter.
The approximate remaining stocks for program are as the left table.

PART#	RE1	Duplex Corner Radius			
		S10	DCIN	RE2	RE3
IMX10C4FD0375MC	.076	.009	.134	.060	.181
IMX12C4FD0500MC	.086	.014	.196	.060	.236
IMX16C4FD0625MC	.110	.017	.236	.080	.315
IMX20C4FD0750MC	.117	.020	.314	.080	.354
IMX25C4FD1000MC	.171	.028	.394	.120	.472

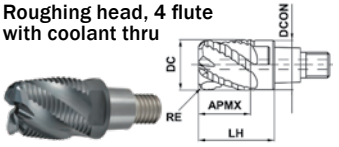
Roughing head, 4 flute



- The roughing edge geometry reduces cutting resistance.
- Effective when rigidity of the machine or workpiece material is low.

PART#	DC	APMX	LH	DCON	
IMX10R4F0375M	.375	.395	.630	.363	GRADE EP7020
IMX12R4F0500M	.500	.520	.789	.488	
IMX16R4F0625M	.625	.645	.945	.605	
IMX20R4F0750M	.750	.800	1.181	.730	
IMX25R4F1000M	1.000	1.050	1.500	.980	

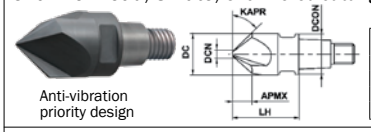
Roughing head, 4 flute with coolant thru



- The roughing edge geometry reduces cutting resistance. Effective when rigidity of the machine or workpiece material is low.
- Center through coolant thru provides excellent chip evacuation.
- Steel, stainless, hi-temp

PART#	DC	RE	APMX	LH	DCON
IMX10RC4F100R05010C	10	0.5	10.5	16	9.7
IMX10RC4F100R10010C	10	1	10.5	16	9.7
IMX12RC4F120R05012C	12	0.5	12.5	19	11.7
IMX12RC4F120R10012C	12	1	12.5	19	11.7
IMX12RC4F120R15012C	12	1.5	12.5	19	11.7
IMX12RC4F120R20012C	12	2	12.5	19	11.7
IMX16RC4F160R05016C	16	0.5	16.5	24	15.5
IMX16RC4F160R10016C	16	1	16.5	24	15.5
IMX16RC4F160R15016C	16	1.5	16.5	24	15.5
IMX16RC4F160R20016C	16	2	16.5	24	15.5
IMX16RC4F160R30016C	16	3	16.5	24	15.5
IMX20RC4F200R05021C	20	0.5	21	30	19.5
IMX20RC4F200R10021C	20	1	21	30	19.5
IMX20RC4F200R20021C	20	2	21	30	19.5
IMX20RC4F200R30021C	20	3	21	30	19.5

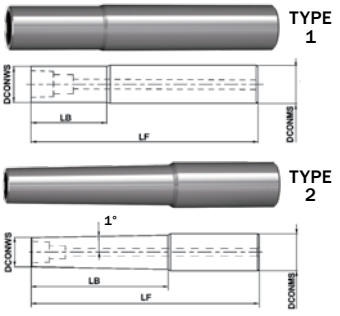
Chamfer head, 3 flute, Chamfered cutting head suitable for inner and outer circumference



Anti-vibration priority design

PART#	DC	APMX	KAPR	DCH	LH	DCON
IMX10CH3L0375A45	.375	.157	45°	.060	.630	.363
IMX12CH3L0500A45	.500	.220	45°	.060	.789	.488
IMX16CH3L0625A45	.625	.283	45°	.060	.945	.605
IMX20CH3L0750A45	.750	.345	45°	.060	1.181	.730

CARBIDE HOLDERS



PART#	Type	LB	DCONWS	LF	DCONMS
IMX10-U0375N049L27C	1	.495	.363	2.755	.375
IMX10-U0375N124L35C	1	1.245	.363	3.543	.375
IMX10-U0375N199L43C	1	1.995	.363	4.330	.375
IMX10-A0500N199L43C	2	1.995	.363	4.330	.500
IMX12-U0500N071L31C	1	.711	.488	3.149	.500
IMX12-U0500N171L39C	1	1.711	.488	3.937	.500
IMX12-U0500N271L51C	1	2.711	.488	5.118	.500
IMX12-A0625N271L51C	2	2.711	.488	5.118	.625
IMX16-U0625N093L31C	1	.930	.605	3.149	.625
IMX16-U0625N218L43C	1	2.180	.605	4.330	.625
IMX16-U0625N343L59C	1	3.430	.605	5.905	.625
IMX16-A0750N343L59C	2	3.430	.605	5.905	.750
IMX20-U0750N106L35C	1	1.069	.730	3.543	.750
IMX20-U0750N256L51C	1	2.569	.730	5.118	.750
IMX20-U0750N406L70C	1	4.069	.730	7.086	.750
IMX20-A1000N406L70C	2	4.069	.730	7.086	1.000
IMX25-U1000N150L43C	1	1.500	.980	4.330	1.000
IMX25-U1000N350L62C	1	3.500	.980	6.299	1.000

Note 1) The fastening size of the holder and head should be the same.

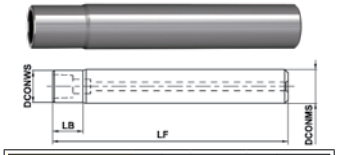
Note 2) Inch head should be mounted in inch holder.

Chamfer head, 6 flute

Suitable for outer circumference.
Multiple cutting design for extended tool life.

PART#	DC	APMX	KAPR	DCN	LH	DCON
IMX12CH6V0500A45	.500	.190	45°	.120	.789	.488
IMX16CH6V0625A45	.625	.252	45°	.120	.945	.605
IMX20CH6V0750A45	.750	.315	45°	.120	1.181	.730

STEEL HOLDERS



PART#	Type	LB	DCONWS	LF	DCONMS
IMX10-U0375N030L27S	1	.308	.363	2.755	.375
IMX10-G0500L23S	2	—	.500	2.362	.500
IMX12-U0500N046L31S	1	.461	.488	3.149	.500
IMX12-G0625L27S	2	—	.625	2.755	.625
IMX16-U0625N061L31S	1	.618	.605	3.149	.625
IMX16-G0750L27S	2	—	.750	2.755	.750
IMX20-U0750N069L35S	1	.694	.730	3.543	.750
IMX20-G1000L31S	2	—	1.000	3.149	1.000
IMX25-U1000N100L43S	1	1.000	.980	4.330	1.000
IMX25-G1250L39S	2	—	1.250	3.937	1.250

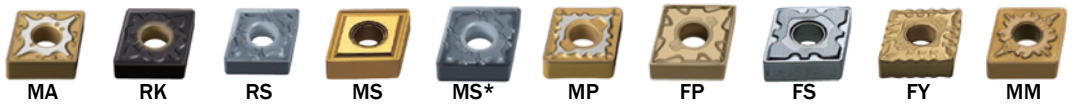
Note 1) The fastening size of the holder and head should be the same.

Note 2) Inch head should be mounted in inch holder.

MITSUBISHI DIAEDGE

COATED CARBIDE INSERTS FOR TURNING
CARBIDE GRADES AND CHIPBREAKERS

POPULAR CHIP-BREAKERS



MA RK RS MS MS* MP FP FS FY MM

LP LM LS RP HX RM HL LK MK

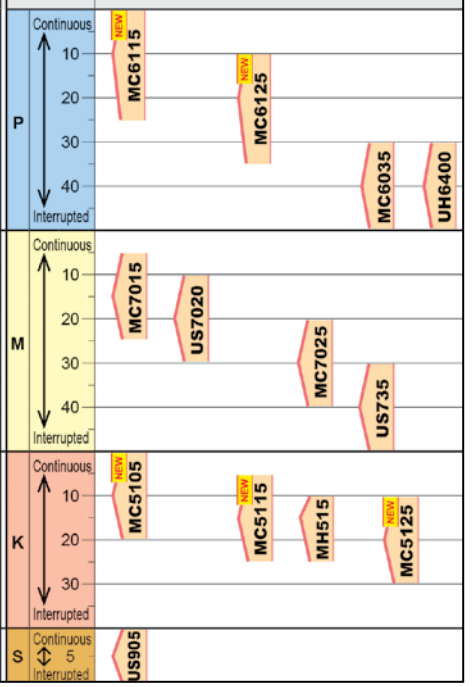
* NEW MS CHIPBREAKER FOR GRADES: MP9005, MP9015, MP9025, & MT9015

CVD COATED CARBIDE INSERTS -

- Improve wear and fracture resistance

	Work Material	Cutting Mode	Recommended Grade	Recommended Cutting Speed (SFM)
P	Steel	Continuous Cutting	NEW MC6115	1115 (705 – 1575)
			NEW MC6125	1080 (690 – 1525)
		Interrupted Cutting	MC6035	490 (260 – 665)
M	Stainless Steel	Continuous Cutting	MC7015	720 (510 – 935)
			MC7025	590 (460 – 720)
		Continuous and Interrupted Cutting	US735	425 (245 – 605)
K	Cast Iron Ductile Cast Iron	Continuous Cutting	NEW MC5105	1418 (540 – 2295)
			NEW MC5115	875 (490 – 1260)
		Interrupted Cutting	NEW MC5125	490 (260 – 720)
S	Heat Resistant Alloy	Continuous and Interrupted Cutting	US905	70 (45 – 95)

ISO — Grades and Application Range

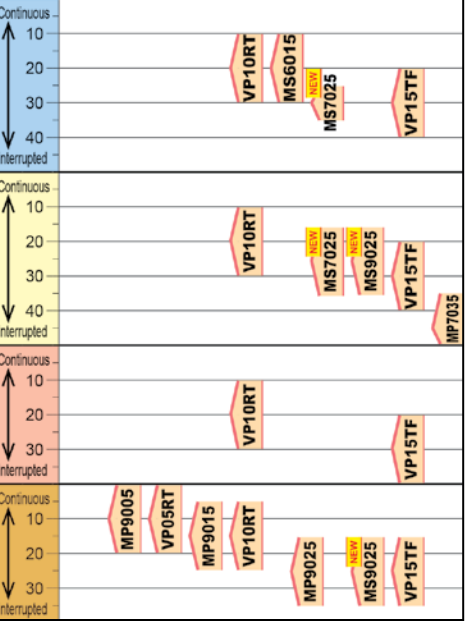


PVD COATED CARBIDE INSERTS -

- PVD coating prolongs tool life.
- Coating of tools with sharp edges without changing the edge quality.

	Work Material	Recommended Grade	Recommended Cutting Speed (SFM)
P	Steel	VP10RT	395 (330 – 490)
		VP15TF	330 (165 – 490)
M	Stainless Steel	VP10RT	395 (330 – 490)
		VP15TF	330 (260 – 440)
		MP7035	395 (280 – 510)
K	Cast Iron	VP10RT	395 (330 – 490)
		VP15TF	395 (330 – 490)
S	Heat Resistant Alloy	MP9005	260 (165 – 360)
		MP9015	195 (115 – 280)
		MP9025	100 (80 – 150)

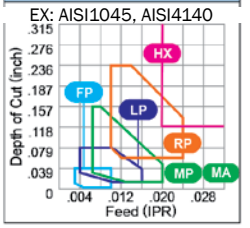
ISO — Grades and Application Range



CHIPBREAKER SELECTION FOR NEGATIVE INSERTS

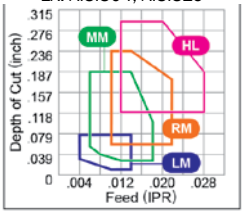
P Carbon Steel · Alloy Steel (180–280HB)

EX: AISI1045, AISI4140



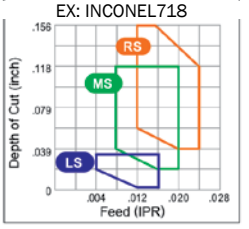
M Stainless Steel (≤200HB)

EX: AISI304, AISI316



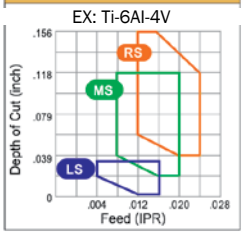
S Ni, Co-Based Alloy

EX: INCONEL718



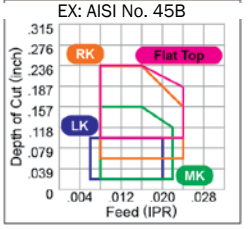
S Titanium Alloy

EX: Ti-6Al-4V



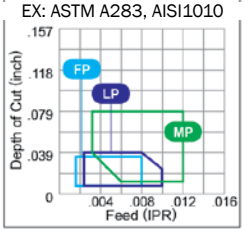
K Cast Iron (≤350MPa)

EX: AISI No. 45B



P Mild Steel

EX: ASTM A283, AISI1010



MITSUBISHI

MITSUBISHI DIAEDGE — TURNING INSERTS

* FIRST CHOICE

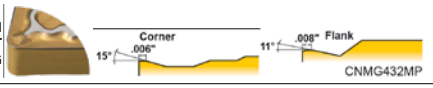
STEEL - GRADE SERIES 6000

GRADE	FOR MATERIALS	APPLICATION
MC6115	STEEL ALLOYS AND CARBON STEELS	CONTINUOUS CUTTING - FINISHING
MC6125		* MEDIUM CUTTING
MC6035		INTERRUPTED CUTTING

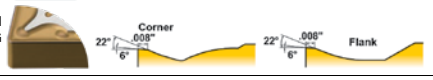
MAIN CHIPBREAKERS

LP LIGHT CUTTING

MP MEDIUM TO LIGHT CUTTING



MA* MEDIUM CUTTING



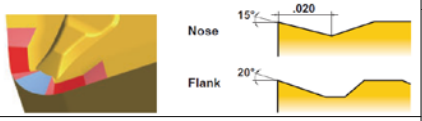
RP ROUGH CUTTING

STAINLESS STEEL - GRADE SERIES 7000

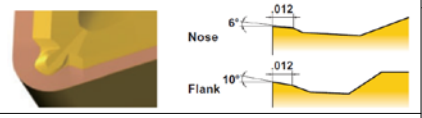
GRADE	FOR MATERIALS	APPLICATION
MC7015	STAINLESS STEEL EX: AISI 304 AISI 316	CONTINUOUS CUTTING
MC7025		* MEDIUM CUTTING
MP7035		ROUGH CUTTING

MAIN CHIPBREAKERS

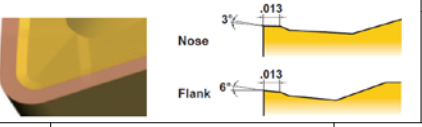
LM LIGHT CUTTING



MM* MED CUTTING



RM ROUGH CUTTING

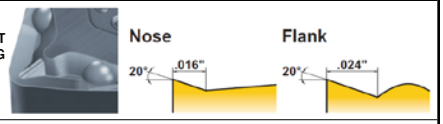


HI-TEMP & TITANIUM - GRADE SERIES 9000

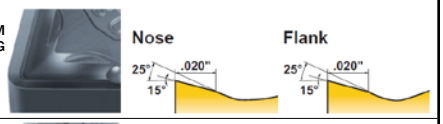
GRADE	FOR MATERIALS	APPLICATION
MP9005	HEAT RESISTANT ALLOYS, HI-TEMP ALLOYS (EX. INCONEL)	FINISH-MEDIUM CUTTING
MP9015		* MEDIUM-ROUGH CUTTING
MP9025		INTERRUPTED-LIGHT-ROUGH CUTTING
MT9005	TITANIUM ALLOYS	HIGH SPEED CUTTING
MT9015		GENERAL CUTTING

MAIN CHIPBREAKERS

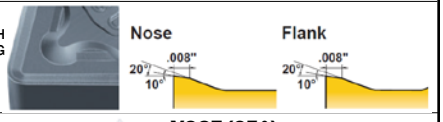
LS LIGHT CUTTING



MS MEDIUM CUTTING



RS* ROUGH CUTTING



CCGT (80°)

- 80° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
CCGT-21.50.2	1/4	3/32	.004	.110
CCGT-21.50.5			.008	
CCGT-32.50.2	3/8	5/32	.004	.1732
CCGT-32.50.5			.008	
CCGT-32.51			.016	

CCMT

- 80° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
CCMT-21.50	1/4	3/32	.004	.110
CCMT-21.50.5			.008	.110
CCMT-21.51			.016	.110
CCMT-21.52			.031	.110
CCMT-2.51.50	5/16	3/32	.004	.134
CCMT-2.51.50.5			.008	.134
CCMT-32.50	3/8	5/32	.004	.1732
CCMT-32.50.5			.008	.1732
CCMT-32.51			.016	.1732
CCMT-32.52			.031	.1732
CCMT-431	1/2	3/16	.016	.2165
CCMT-432			.031	.2165

CNGG (80°)

- 80° Diamond
- Negative

PART #	I.C.	THICK	RADIUS	HOLE
CNGG-43V5	1/2	3/16	.002	.2031
CNGG-430.2			.004	
CNGG-430.5			.008	
CNGG-431			.016	
CNGG-432			.031	

CNMG (80°)

- 80° Diamond
- Negative

PART #	I.C.	THICK	RADIUS
CNMG-431*	1/2	3/16	1/64
CNMG-432*			1/32
CNMG-433*			3/64
CNMG-434*			1/16
CNMG-542*	5/8	1/4	1/32
CNMG-543*			3/64
CNMG-544*			1/16
CNMG-642*	3/4		1/32
CNMG-643*			3/64
CNMG-644*			1/16
CNMG-646*			3/32

CPGT

- 80° Diamond
- 11° Positive

PART #	I.C.	THICK	RADIUS	HOLE
CPGT-2.51.50.5	5/16	3/32	.008	.134
CPGT-2.51.51	5/16	3/32	.016	.134
CPGT-320.5	3/8	3/8	.008	.1732
CPGT-321	3/8	3/8	.016	.1732

CPMH

- 80° Diamond
- 11° Positive

PART #	I.C.	THICK	RADIUS	HOLE
CPMH-2.51.50.5FV	5/16	3/32	.008	.134
CPMH-2.51.51FV	5/16	3/32	.016	.134
CPMH-320.5FV	3/8	1/8	.008	.1732
CPMH-321FV	3/8	1/8	.016	.1732
CPMH-322FV	3/8	1/8	.031	.1732

CPMT

- 80° Diamond
- 11° Positive

PART #	I.C.	THICK	RADIUS	HOLE
CPMT-21.51	1/4	3/32	1/64	.110
CPMT-21.52		3/32	1/32	
CPMT-2.51.51	5/16	3/32	1/64	.134
CPMT-2.51.52		3/32	1/32	
CPMT-2.522		1/8	1/32	
CPMT-321	3/8	1/8	1/64	.1732
CPMT-322		1/8	1/32	
CPMT-32.51	3/8	5/32	1/64	
CPMT-32.52		5/32	1/32	
CPMT-432	1/2	3/16	1/32	.2165
CPMT-532	5/8	3/16	1/32	.256

DCGT

- 55° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
DCGT-21.5V5	1/4	3/32	.002	.110
DCGT-21.50.2	1/4	3/32	.004	.110
DCGT-21.50.5	1/4	3/32	.008	.110
DCGT-21.51	1/4	3/32	.016	.110
DCGT-32.5V5	3/8	5/32	.002	.1732
DCGT-32.50.2	3/8	5/32	.004	.1732
DCGT-32.50.5	3/8	5/32	.008	.1732
DCGT-32.51	3/8	5/32	.016	.1732
DCGT-32.52	3/8	5/32	.031	.1732

DCMT (55°)

- 55° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
DCMT-21.50.5	1/4	3/32	.008	.110
DCMT-21.51			.016	
DCMT-21.52			.031	
DCMT-32.50.5	3/8	5/32	.008	.1732
DCMT-32.51			.016	
DCMT-32.52			.031	

DNMG (55°)

- 55° Diamond
- Negative

PART #	I.C.	THICKNESS	RADIUS
DNMG-432	1/2	3/16	1/32
DNMG-433			3/64
DNMG-442	1/2	1/4	1/32
DNMG-443			3/64
DNMG-542	5/8	1/4	1/32
DNMG-543			3/64
DNMG-544			1/16

RCMT

- Round
- 7° Positive

PART #	I.C.	THICK	HOLE
RCMT-0602	.236	.094	.110
RCMT-0803	.315	.125	.134
RCMT-10T3	.394	.156	.173
RCMT-1204	.472	.187	.173
RCMT-1606	.630	.250	.2165

RNMG

- Round
- Negative

PART #	I.C.	THICK	HOLE
RNMG-43	1/2	3/16	.2031

SCMT

- Square
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
SCMT-32.51	3/8	5/32	1/64	.1732
SCMT-32.52			1/32	
SCMT-431	1/2	3/16	1/64	.2165
SCMT-432			1/32	
SCMT-433			3/64	

SNMG (90°)

- Square
- Negative

PART #	I.C.	THICK	RADIUS
SNMG-321	3/8	1/8	1/64
SNMG-322			1/32
SNMG-323			3/64
SNMG-431	1/2	3/16	1/64
SNMG-432			1/32
SNMG-433			3/64
SNMG-434			1/16
SNMG-543	5/8	1/4	3/64
SNMG-634	3/4	3/16	1/16
SNMG-642	3/4	1/4	1/32
SNMG-643			3/64
SNMG-644			1/16
SNMG-866	1	3/8	3/32

SPMT

- Square
- 11° Positive

PART #	I.C.	THICK	RADIUS	HOLE
SPMT-21.51	1/4	3/32	1/64	.1102
SPMT-2.51.52	5/16	3/32	1/32	.134
SPMT-2.522		1/8	1/32	
SPMT-321	3/8	1/8	1/64	.130
SPMT-322		1/8	1/32	
SPMT-32.52	3/8	5/32	1/32	.1732
SPMT-432	1/2	3/16	1/32	.2165
SPMT-532	5/8	3/16	1/32	.256

TCGT

- Triangular
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
TCGT-630EFM	3/16	3/32	.004	.090
TCGT-630.5EFM			.008	
TCGT-1.81.50EFM	7/32	3/32	.004	.098
TCGT-1.81.50.5EFM			.008	
TCGT-21.50EFM	1/4	3/32	.004	.110
TCGT-21.50.5EFM			.008	

TCMT

- Triangular
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
TCMT-21.50.5	1/4	3/32	.008	.110
TCMT-21.51			.016	
TCMT-21.52			.031	
TCMT-32.50	3/8	5/32	.008	.1693
TCMT-32.51			.016	
TCMT-32.52			.031	
TCMT-32.53			.047	

TNMG (60°)

- Triangular
- Negative

PART #	I.C.	THICK	RADIUS
TNMG-221	1/4	1/8	1/64
TNMG-222			1/32
TNMG-321	3/8	1/8	1/64
TNMG-322			1/32
TNMG-331	3/8	3/16	1/64
TNMG-332			1/32
TNMG-333			3/64
TNMG-334			1/16
TNMG-431	1/2	3/16	1/64
TNMG-432			1/32
TNMG-433			3/64
TNMG-434			1/16
TNMG-542	5/8	1/4	1/32
TNMG-543			3/64
TNMG-544			1/16
TNMG-666	3/4	3/8	3/32

TPMT (60°)

- Triangle
- 11° Positive

PART #	I.C.	THICK	RADIUS	HOLE
TPMT-1.81.51	7/32	3/32	.016	.098
TPMT-21.50.5	1/4	3/32	.008	.110
TPMT-21.51			.016	
TPMT-21.52			.031	
TPMT-32.51	3/8	5/32	.016	.173
TPMT-32.52			.031	

VBMT (35°)

- 35° Diamond
- 5° Positive

PART #	I.C.	THICK	RADIUS	HOLE
VBMT-220.5	1/4	1/8	.008	.115
VBMT-221			.016	
VBMT-222			.031	
VBMT-330.5	3/8	3/16	.008	.173
VBMT-331			.016	
VBMT-332			.031	

VCGT (35°)

- 35° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
VCGT-220.2	1/4	1/8	.004	.115
VCGT-220.5			.008	
VCGT-221			.016	
VCGT-2.520.2	5/16		.004	.134
VCGT-2.520.5			.006	
VCGT-2.521			.016	
VCGT-331	3/8	3/16	.016	.173
VCGT-332			.031	
VCGT-333			.047	

VCMT (35°)

- 35° Diamond
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
VCMT-1.51.50.5LP	3/16	3/32	.008	.097
VCMT-1.51.51LP			.016	
VCMT-220.5LS	1/4	1/8	.008	.110
VCMT-221LM			.016	
VCMT-222LM			.031	
VCMT-331LM	3/8	3/16	.016	.173
VCMT-332LM			.031	

VNMG (35°)

- 35° Diamond
- Negative

PART #	I.C.	THICKNESS	RADIUS
VNMG-331	3/8	3/16	1/64
VNMG-332			1/32
VNMG-333			3/64
VNMG-432	1/2	3/16	1/32
VNMG-433			3/64

WCMT (80°)

- Trigon
- 7° Positive

PART #	I.C.	THICK	RADIUS	HOLE
WCMT-1.210.5	5/32	1/16	.008	.091
WCMT-1.211			.016	
WCMT-1.51.50.5	3/16	3/32	.008	.091
WCMT-1.51.51			.016	
WCMT-21.50.5	1/4	3/32	.008	.110
WCMT-21.51			.016	
WCMT-21.52			.031	
WCMT-32.51	3/8	5/32	.016	.173
WCMT-32.52			.031	

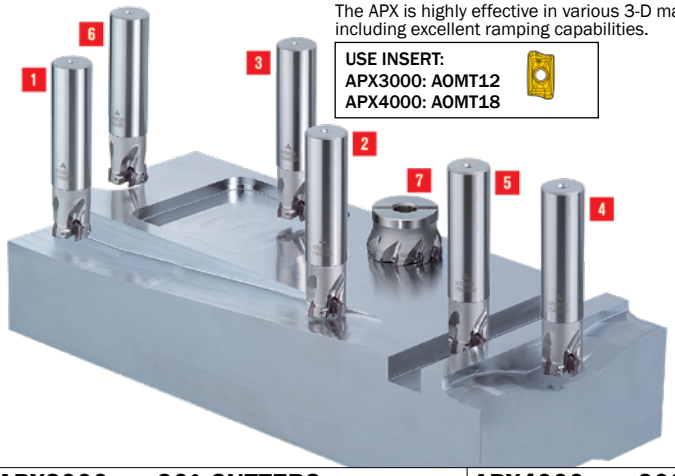
WNMG (80°)

- Trigon
- Negative

PART #	I.C.	THICK	RADIUS
WNMG-331	3/8	3/16	1/64
WNMG-332			1/32
WNMG-333			3/64
WNMG-431	1/2	3/16	1/64
WNMG-432			1/32
WNMG-433			3/64
WNMG-543	5/8	1/4	3/64

FREE CUTTER PROMO — SEE PAGES 2-4

MITSUBISHI DIAEDGE — APX3000/APX4000 MULTI-FUNCTIONAL INDEXABLE CUTTERS



The APX is highly effective in various 3-D machining operations including excellent ramping capabilities.

USE INSERT:
APX3000: AOMT12
APX4000: AOMT18

1. Shoulder Milling
2. Ramping
3. Pocket Milling
4. 3-D Profile Milling
5. Slot Milling
6. Helical Milling
7. Face Milling

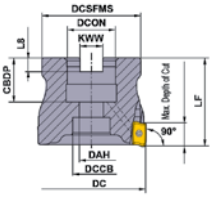
TYPE 'A' CUTTERS TAKE INSERTS WITH CORNER RADIUS = .008" - .079" AND TYPE 'B' CUTTERS TAKE INSERTS WITH CORNER RADIUS = .094" - .125"

High Rigidity Cutter Bodies

Rigidity has been increased by using a larger amount of backing metal behind the insert. Resistance to corrosion and abrasion on the cutter bodies made possible by using a superior highly heat resistant alloy and a special surface treatment.The cutter bodies are designed with through coolant holes to improve cooling and chip disposal.

WITH COOLANT HOLES

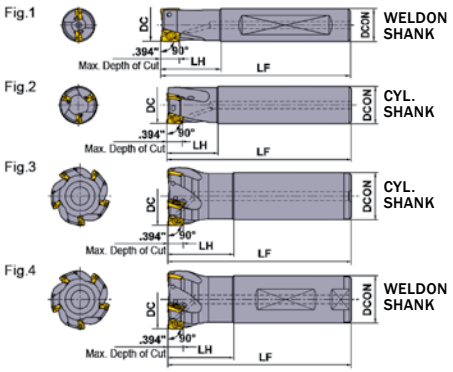
90° FACE MILLS



APX3000 90° CUTTERS

- Low resistance insert and high rigidity body.
- Ideal chip control.
- High wall accuracy can be produced by using this cutter and unique insert geometry.

USE INSERT AOMT12



STANDARD LENGTH INDEXABLE END-MILLS

Type	Insert RE	Part#	z(1)	dc	dcon	lf	lh	rmpx	Fig.
A Holders	.008 – .079"	APX3000UR081FA10SA	1	.500	.625	3.250	1.120	6°	1
		APX3000UR081SA08SA	1	.500	.500	3.250	1.120	6°	2
		APX3000UR102FA10SA	2	.625	.625	3.625	1.190	11.5°	1
		APX3000UR102SA10SA	2	.625	.625	3.625	1.190	11.5°	2
		APX3000UR122FA12SA	2	.750	.750	4.375	1.380	7.5°	1
		APX3000UR122SA12SA	2	.750	.750	4.375	1.380	7.5°	2
		APX3000UR123FA12SA	3	.750	.750	4.375	1.380	7.5°	1
		APX3000UR123SA12SA	3	.750	.750	4.375	1.380	7.5°	2
		APX3000UR163FA12SA	3	1.000	.750	4.375	1.570	4.5°	4
		APX3000UR163SA12SA	3	1.000	.750	4.375	1.570	4.5°	3
		APX3000UR164FA12SA	4	1.000	.750	4.375	1.570	4.5°	4
		APX3000UR164SA12SA	4	1.000	.750	4.375	1.570	4.5°	3
		APX3000UR163FA16SA	3	1.000	1.000	4.750	1.570	4.5°	1
		APX3000UR163SA16SA	3	1.000	1.000	4.750	1.570	4.5°	2
		APX3000UR164FA16SA	4	1.000	1.000	4.750	1.570	4.5°	1
		APX3000UR164SA16SA	4	1.000	1.000	4.750	1.570	4.5°	2
		APX3000UR205FA20SA	5	1.250	1.250	5.125	1.970	3.1°	1
		APX3000UR205SA20SA	5	1.250	1.250	5.125	1.970	3.1°	2
		APX3000UR246FA20SA	6	1.500	1.250	5.125	1.970	2.3°	4
		APX3000UR246SA20SA	6	1.500	1.250	5.125	1.970	2.3°	3
B Holders	.094" – .125"	APX3000UR081SA08SB	1	.500	.500	3.250	1.120	6°	2
		APX3000UR102SA10SB	2	.625	.625	3.625	1.190	11.5°	2
		APX3000UR122SA12SB	2	.750	.750	4.375	1.380	7.5°	2
		APX3000UR123SA12SB	3	.750	.750	4.375	1.380	7.5°	2
		APX3000UR163SA12SB	3	1.000	.750	4.375	1.570	4.5°	3
		APX3000UR164SA12SB	4	1.000	.750	4.375	1.570	4.5°	3
		APX3000UR163SA16SB	3	1.000	1.000	4.750	1.570	4.5°	2
		APX3000UR164SA16SB	4	1.000	1.000	4.750	1.570	4.5°	2
		APX3000UR205SA20SB	5	1.250	1.250	5.125	1.970	3.1°	2
		APX3000UR246SA20SB	6	1.500	1.250	5.125	1.970	2.3°	3

LONG LENGTH INDEXABLE END-MILLS

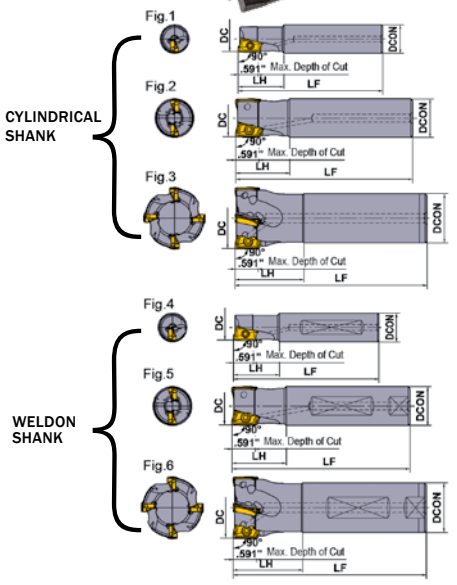
Type	Insert RE	Part#	z(1)	dc	dcon	lf	lh	rmpx	Fig.
A Holders	.008 – .079	APX3000UR122SA12LA	2	.750	.750	7.250	1.380	7.5°	2
		APX3000UR162SA16LA	2	1.000	1.000	8.500	1.570	4.5°	2
		APX3000UR163SA16LA	3	1.000	1.000	8.500	1.570	4.5°	2
		APX3000UR203SA20LA	3	1.250	1.250	9.000	1.970	3.1°	2
		APX3000UR204SA20LA	4	1.250	1.250	9.000	1.970	3.1°	2
		APX3000UR243SA20LA	3	1.500	1.250	9.000	1.970	2.3°	3
		APX3000UR244SA20LA	4	1.500	1.250	9.000	1.970	2.3°	3
B Holders	.094 – .125	APX3000UR122SA12LB	2	.750	.750	7.250	1.380	7.5°	2
		APX3000UR162SA16LB	2	1.000	1.000	8.500	1.570	4.5°	2
		APX3000UR163SA16LB	3	1.000	1.000	8.500	1.570	4.5°	2
		APX3000UR203SA20LB	3	1.250	1.250	9.000	1.970	3.1°	2
		APX3000UR204SA20LB	4	1.250	1.250	9.000	1.970	3.1°	2
		APX3000UR243SA20LB	3	1.500	1.250	9.000	1.970	2.3°	3
		APX3000UR244SA20LB	4	1.500	1.250	9.000	1.970	2.3°	3

(1) Z = NO. OF INSERTS

APX4000 90° CUTTERS

APX4000UR□□□SA□□ = CYL. SHANK
APX4000UR□□□FA□□ = WELDON SHANK

USE INSERT: AOMT18



STANDARD LENGTH INDEXABLE END-MILLS

Type	Insert RE	Part#	z(1)	dc	dcon	lf	lh	rmpx	Fig.
A Holders	.016" – .079"	APX4000UR121FA12SA	1	.750	.750	4.000	1.250	14°	4
		APX4000UR121SA12SA	1	.750	.750	4.000	1.250	14°	1
		APX4000UR162SA12SA	2	1.000	.750	4.000	1.250	11°	3
		APX4000UR162FA16SA	2	1.000	1.000	4.500	1.250	11°	4
		APX4000UR162SA16SA	2	1.000	1.000	4.500	1.250	11°	2
		APX4000UR202FA20SA	2	1.250	1.250	5.000	1.750	7°	5
		APX4000UR202SA20SA	2	1.250	1.250	5.000	1.750	7°	2
		APX4000UR203FA20SA	3	1.250	1.250	5.000	1.750	7°	5
		APX4000UR203SA20SA	3	1.250	1.250	5.000	1.750	7°	2
		APX4000UR243FA20SA	3	1.500	1.250	5.000	1.750	7°	6
		APX4000UR243SA20SA	3	1.500	1.250	5.000	1.750	7°	3
		APX4000UR244FA20SA	4	1.500	1.250	5.000	1.750	7°	6
		APX4000UR244SA20SA	4	1.500	1.250	5.000	1.750	7°	3
B Holders	.125" – .157"	APX4000UR121FA12SB	1	.750	.750	4.000	1.250	14°	4
		APX4000UR162FA16SB	2	1.000	1.000	4.500	1.250	11°	5
		APX4000UR202FA20SB	2	1.250	1.250	5.000	1.750	7°	5
		APX4000UR203FA20SB	3	1.250	1.250	5.000	1.750	7°	5
		APX4000UR243FA20SB	3	1.500	1.250	5.000	1.750	7°	6
		APX4000UR244FA20SB	4	1.500	1.250	5.000	1.750	7°	6

LONG INDEXABLE END-MILLS

Type	Insert RE	Part#	z(1)	dc	dcon	lf	lh	rmpx	Fig.
A Holders	.016" – .079"	APX4000UR162SA16LA	2	1.000	1.000	8.500	1.250	11°	2
		APX4000UR202SA20LA	2	1.250	1.250	9.000	1.750	7°	2
		APX4000UR203SA20LA	3	1.250	1.250	9.000	1.750	7°	2
		APX4000UR243SA24LA	3	1.500	1.500	9.000	1.750	7°	2
		APX4000UR244SA24LA	4	1.500	1.500	9.000	1.750	7°	2
		APX4000UR243SA24ELA	3	1.500	1.500	14.000	1.750	7°	2
B Holders	.125" – .157"	APX4000UR162SA16LB	2	1.000	1.000	8.500	1.250	11°	2
		APX4000UR202SA20LB	2	1.250	1.250	9.000	1.750	7°	2
		APX4000UR203SA20LB	3	1.250	1.250	9.000	1.750	7°	2
		APX4000UR243SA24LB	3	1.500	1.500	9.000	1.750	7°	2
		APX4000UR244SA24LB	4	1.500	1.500	9.000	1.750	7°	2
		APX4000UR243SA24ELB	3	1.500	1.500	14.000	1.750	7°	2

(1) Z = NO. OF INSERTS

APX3000: MAX DEPTH OF CUT = .394"

Type	Insert RE	Part#	z(1)	dc	lf	dcon	CBDP	DAH	DSCFMS	KWW	lB	DCCB	RMPX
A Holders	.008 – .079	APX3000R1504A	4	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.4°
		APX3000R1505A	5	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.4°
		APX3000R1506A	6	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.4°
		APX3000R0205A	5	2.000	1.575	.750	.748	.415	1.811	.313	.187	.600	1.6°
		APX3000R0207A	7	2.000	1.575	.750	.748	.415	1.811	.313	.187	.600	1.6°
		APX3000R2506A	6	2.500	1.969	1.000	1.024	.539	2.360	.375	.219	.787	1.3°
		APX3000R0306A	6	3.000	1.969	1.000	1.024	.539	2.756	.375	.219	.787	1.0°
		APX3000R0309A	9	3.000	1.969	1.000	1.024	.539	2.756	.375	.219	.787	1.0°
B Holders	.094 – .125	APX3000R1504B	4	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.5°
		APX3000R1505B	5	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.5°
		APX3000R1506B	6	1.500	1.575	.750	.748	.415	1.320	.313	.187	.600	2.5°
		APX3000R0205B	5	2.000	1.575	.750	.748	.415	1.811	.313	.187	.600	1.6°
		APX3000R0207B	7	2.000	1.575	.750	.748	.415	1.811	.313	.187	.600	1.6°
		APX3000R2506B	6	2.500	1.969	1.000	1.024	.539	2.360	.375	.219	.787	1.3°
		APX3000R0306B	6	3.000	1.969	1.000	1.024	.539	2.756	.375	.219	.787	1.0°
		APX3000R0309B	9	3.000	1.969	1.000	1.024	.539	2.756	.375	.219	.787	1.0°

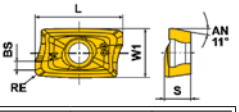
APX4000: MAX DEPTH OF CUT = .591"

Type	Insert RE	Part#	R	z(1)	dc	lf	dcon	CBDP	DAH	DSCFMS	KWW	lB	DCCB	RMPX
A Holders	.016 – .079	APX4000UR0204A	•	4	2.000	1.625	.750	.748	.415	1.875	.313	.187	.600	4°
		APX4000UR0205A	•	5	2.000	1.625	.750	.748	.415	1.875	.313	.187	.600	4°
		APX4000UR2505CA	•	5	2.500	2.000	1.000	1.024	.539	2.375	.375	.219	.787	2°
		APX4000UR0306DA	•	6	3.000	2.500	1.250	1.260	.669	2.874	.500	.281	1.024	2°
		APX4000UR0307DA	•	7	3.000	2.500	1.250	1.260	.669	2.874	.500	.281	1.024	2°
		APX4000UR0408EA	•	8	4.000	2.500	1.500	1.181	.787	3.799	.625	.375	1.181	1.5°
B Holders	.125 – .157	APX4000UR0204B	•	4	2.000	1.625	.750	.748	.415	1.875	.313	.187	.600	4°
		APX4000UR0205B	•	5	2.000	1.625	.750	.748	.415	1.875	.313	.187	.600	4°
		APX4000UR2505CB	•	5	2.500	2.000	1.000	1.024	.539	2.375	.375	.219	.787	2°
		APX4000UR0306DB	•	6	3.000	2.500	1.250	1.260	.669	2.874	.500	.281	1.024	2°
		APX4000UR0307DB	•	7	3.000	2.500	1.250	1.260	.669	2.874	.500	.281	1.024	2°
		APX4000UR0408EB	•	8	4.000	2.500	1.500	1.181	.787	3.799	.625	.375	1.181	1.5°

(1) Z = NO. OF INSERTS

INSERTS

FOR APX3000

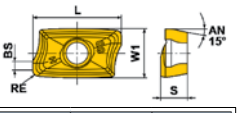


AOMT12

PART#	L	W1	S	RE
AOMT-1236□□PEER-M*/H*	.472	.260	.142	□□
AOGT-1236□□PEFR-GM(1)	.472	.260	.142	□□

(1) FOR ALUMINUM * M = CENERAL CHIPBREAKER, H = STRONG EDGE CHIPBREAKER
'□□' DESIGNATES CORNER RADIUS: 02=.008, 04=.016, 08= 031, 10=.039, 12=.047
16=.063, 20=.079, 24=.094, 30=.118, 32=.125

FOR APX4000



AOMT18

PART#	L	W1	S	RE
AOMT-1848□□PEER-M*/H*	.709	.354	.189	□□
AOGT-1848□□PEFR-GM(1)	.709	.354	.189	□□

(1) FOR ALUMINUM * M = CENERAL CHIPBREAKER, H = STRONG EDGE CHIPBREAKER
'□□' DESIGNATES CORNER RADIUS: 02=.008, 04=.016, 08= 031, 10=.039, 12=.047
16=.063, 20=.079, 24=.094, 30=.118, 32=.125

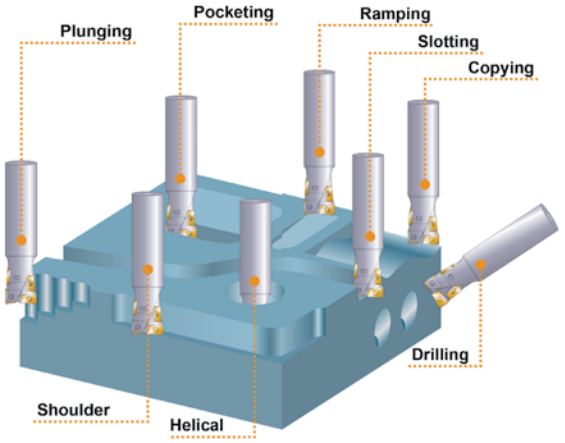
CARBIDE GRADES

		Coated							
		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT
P	Steel		●	✱				●	✱
M	Stainless Steels				◐			◐	✱
K	Cast Irons	●						✱	
S	Heat Resistant Alloys, Titanium Alloys					●	✱	●	
H	Hardened Steels							◐	

MITSUBISHI

MITSUBISHI DIAEDGE

AQX MULTI-FUNCTIONAL INDEXABLE END-MILLS

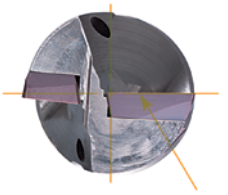


- **One Insert Type**
  Tool management is simplified by using only one type of insert for all 4 cutting edges.
  By rotating the inserts it's possible to use inserts twice.

Insert Rotation

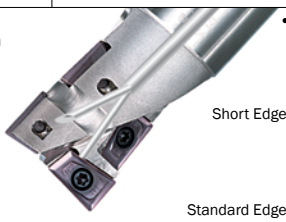
- **2 Insert Bottom Cutting Edge**
  The lower cutting edge consists of 2 inserts, resulting in higher cutting edge strength and increased tool life.

- **Center Cutting Edge**
  The AQX is designed with a center cutting edge, making it possible to drill, helical mill and pocket without a prepared hole.



Center Cutting Edge

- **Through Coolant Holes**
  The body is designed with through coolant holes to improve cooling and chip disposal.
  The AQX is also available without coolant holes.



- **Short Edge Type**
  An economical short edge type body is available with only 2 inserts for short depth of cut applications.

Short Edge Type

Standard Edge Type

MULTI-FUNCTIONAL MILLING

AQX

P M K N S H

- Air / coolant through.
- The center bottom cutting edge enables drilling and end milling without prepared hole.

Fig.1

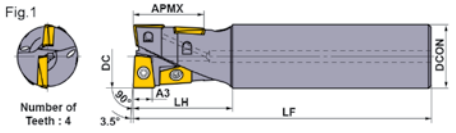


Fig.2

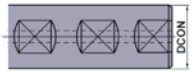
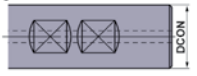
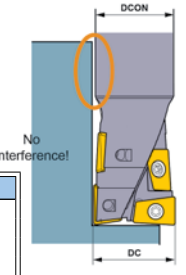


Fig.3



Right hand tool holder only.

- **Undercut Type Standardized**
  The cutting edge diameter DC has been designed so that it is larger than the shank diameter DCON, making it possible to machine vertical faces without any interference.



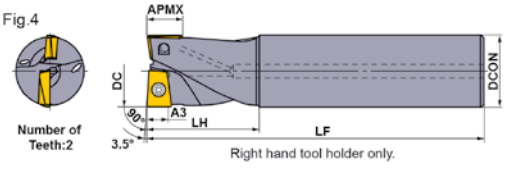
CUTTER	DC	DCON
AQXUR11□SA10L	.672	.625
AQXUR13□SA12L	.797	.750
AQXUR17□SA16L	1.047	1.000
AQXUR21□SA20L	1.297	1.250
AQXUR24□□A20□	1.500	1.250

- **Standard Edge Type KAPR: 90°**

Type	Order Number	Dimensions (inch) DC	lf	dcon	lh	a3*1	apmx	Fig.	Insert Screw	Wrench	Insert
Standard	AQXUR124WA12S	.750	4.125	.750	1.375	.219	.750	3	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR164WA16S	1.000	4.875	1.000	1.625	.281	1.000	2	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR204WA20S	1.250	5.250	1.250	2.000	.375	1.250	2	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR244WA20S	1.500	5.625	1.250	2.375	.438	1.500	2	TS5	②TKY25D	QOG/MT1959R-OO
Long	AQXUR124SA12L	.750	7.250	.750	2.375	.219	.750	1	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR134SA12L	.797	7.250	.750	1.375	.219	.750	1	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR164SA16L	1.000	8.500	1.000	3.000	.281	1.000	1	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR174SA16L	1.047	8.500	1.000	1.625	.281	1.000	1	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR204SA20L	1.250	9.000	1.250	3.500	.375	1.250	1	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR214SA20L	1.297	9.000	1.250	2.000	.375	1.250	1	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR244SA20L	1.500	9.500	1.250	2.375	.438	1.500	1	TS5	②TKY25D	QOG/MT1959R-OO

*2 Clamp Torque (lbf-in) : TS25=8.9, TS32=8.9, TS407=31, TS5=66

Fig.4



Right hand tool holder only.

- **Short Edge Type KAPR: 90°**

Type	Order Number	Dimensions (inch) DC	lf	dcon	lh	a3*1	apmx	Fig.	Insert Screw	Wrench	Insert
Standard	AQXUR102WA10S	.625	3.688	.625	1.125	.188	.281	3	TS2A	①TKY06F	QOG/MT0830R-OO
	AQXUR122WA12S	.750	4.125	.750	1.375	.219	.344	3	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR162WA16S	1.000	4.875	1.000	1.625	.281	.469	2	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR202WA20S	1.250	5.250	1.250	2.000	.375	.563	2	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR242WA20S	1.500	5.625	1.250	2.375	.438	.688	2	TS55	②TKY25D	QOG/MT1959R-OO
Long	AQXUR102SA10L	.625	6.875	.625	2.000	.188	.281	4	TS2A	①TKY06F	QOG/MT0830R-OO
	AQXUR112SA10L	.672	6.875	.625	1.125	.188	.281	4	TS2A	①TKY06F	QOG/MT0830R-OO
	AQXUR122SA12L	.750	7.250	.750	2.375	.219	.344	4	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR132SA12L	.797	7.250	.750	1.375	.219	.344	4	TS25	①TKY08F	QOG/MT0934R-OO
	AQXUR162SA16L	1.000	8.500	1.000	3.000	.281	.469	4	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR172SA16L	1.047	8.500	1.000	1.625	.281	.469	4	TS32	②TKY08D	QOG/MT1443R-OO
	AQXUR202SA20L	1.250	9.000	1.250	3.500	.375	.563	4	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR212SA20L	1.297	9.000	1.250	2.000	.375	.563	4	TS407	②TKY15D	QOG/MT1651R-OO
	AQXUR242SA20L	1.500	9.500	1.250	2.375	.438	.688	4	TS55	②TKY25D	QOG/MT1959R-OO

(Note) When exceeding A3 depth of cut, reduce feed rates by 50%(Do not exceed APMX depth of cut).
*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts.
*2 Clamp Torque (lbf-in) : TS2A=5.3, TS25=8.9, TS33=8.9, TS407=31, TS5=66

Inserts

Shape	Part#	L	LE	W1	S	RE	Geometry
	QOMT-0830R-M2	.350	.291	.220	.120	.031	
	QOMT-0934R-M2	.401	.342	.264	.134	.031	
	QOMT-1443R-M2	.528	.469	.350	.169	.031	
	QOMT-1651R-M2	.650	.571	.433	.200	.031	
	QOMT-1959R-M2	.768	.709	.512	.232	.031	
FOR ALUMINUM	QOGT-0830R-G1	.350	.291	.220	.120	.016	
	QOGT-0934R-G1	.401	.342	.264	.134	.016	
	QOGT-1443R-G1	.528	.469	.350	.169	.016	
	QOGT-1651R-G1	.650	.571	.433	.200	.016	
	QOGT-1959R-G1	.768	.709	.512	.232	.016	

Grade Selection

Cutting Conditions (Guide):

●: Stable Cutting ◐: General Cutting ✤: Interrupted Cutting

Workpiece Material	P	Steel	●	◐				◐	✤			
	M	Stainless Steels			●	◐		◐	✤			
	K	Cast Irons							✤			
	N	Non-Ferrous Metals									◐	
	S	Heat Resistant Alloys, Titanium Alloys					●	◐				
	H	Hardened Steels						◐				

Shape	Part	DC	Class	Honing	Coated MP6120	MP6130	MP7130	MP7140	MP9120	VP15TF	VP20RT	Carbide HTi10		
	QOMT-0830R-M2	.625, .672	M	E	●	●	●	●	●	●	●			
	QOMT-0934R-M2	.750, .797	M	E	●	●	●	●	●	●	●			
	QOMT-1443R-M2	1.000, 1.047	M	E	●	●	●	●	●	●	●			
	QOMT-1651R-M2	1.250, 1.297	M	E	●	●	●	●	●	●	●			
	QOMT-1959R-M2	1.500	M	E	●	●	●	●	●	●	●			
FOR ALUMINUM	QOGT-0830R-G1	.625, .672	G	E*	●				●	*		●		
	QOGT-0934R-G1	.750, .797	G	E*	●				●			●		
	QOGT-1443R-G1	1.000, 1.047	G	E*	●				●			●		
	QOGT-1651R-G1	1.250, 1.297	G	E*	●				●	*		●		
	QOGT-1959R-G1	1.500	G	E*	●				●			●		

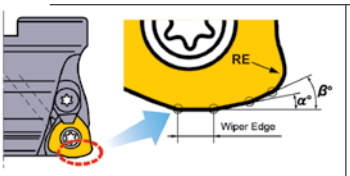
* HTi10 insert honing is "F" type.

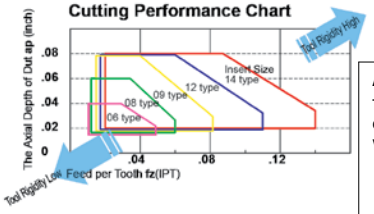
Honing:
E: round F: Sharp

MITSUBISHI DIAEDGE

AJX ULTRA HIGH FEED MILLING CUTTERS

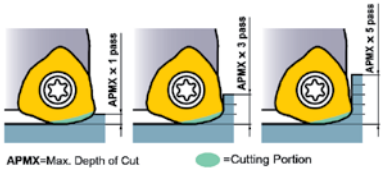
- **Ultra High Feed Cutting**
  Employing a double phased straight cutting edge to form the lead angle α and β with a wiper edge, the AJX can achieve an ultra high feed rate of up to .138 IPT for the ultimate efficiency in rough machining.





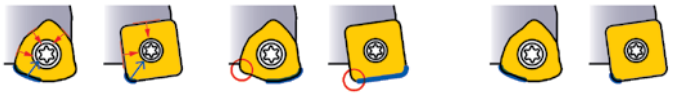
Anti-Vibration Properties

The AJX always uses the same portion of the cutting edge thereby maintaining stable cutting even when the tool overhang is long.



Triangular Insert Shape is Ideal for Safe Multi-Functional Milling

■ Edge Used During Machining



Insert pocket is designed to ensure precise positioning and provide secure multi directional clamping.

The unused edge is protected even during pocket milling and ramping.

Even if the ramping angle is steep, the left side of the cutting edge is designed to be used and therefore not be damaged.

Preventing Chip Packing Problems

The indents engineered into the inner and outer cutting edges maintain a large clearance preventing chip packing problems.
This provides improved efficiency and a more stable cutting performance when ramping and sinking compared to conventional products.

MULTI-FUNCTIONAL MILLING

AJX

P	M	K
N	S	H

INDEXABLE END-MILLS

Fig.1 "FA" Flat Shank

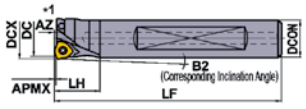


Fig.2

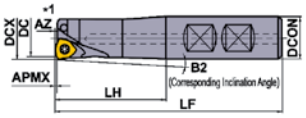


Fig.3

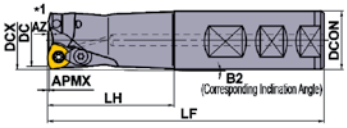
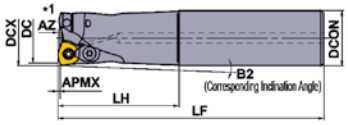


Fig.4



PART#	DCX	LF	DC	LH	DCON	B2	APMX	RMPX*	Fig.	z(1)	Insert
AJXU06R102FA10S	.625	3.750	.346	1.250	.625	2.12	.039	3	1	2	JOMO06T2
AJXU06R102SA10M	.625	5.750	.346	1.500	.625	1.75	.039	3	4	2	JOMO06T2
AJXU06R102SA10L	.625	5.750	.346	2.750	.625	0.93	.039	3	4	2	JOMO06T2
AJXU06R112FA10S	.688	3.750	.409	.750	.625	—	.039	2.5	1	2	JOMO06T2
AJXU06R112SA10L	.688	5.750	.409	.750	.625	—	.039	2.5	4	2	JOMO06T2
AJXU08R122WA12S	.750	4.750	.417	2.000	.750	1.31	.059	3.5	2	2	JOMO0803
AJXU06R123SA12M	.750	7.000	.472	2.375	.750	1.11	.039	1.7	4	3	JOMO06T2
AJXU08R122SA12L	.750	7.000	.417	4.000	.750	0.64	.059	3.5	4	2	JOMO0803
AJXU08R142FA12S	.875	4.750	.535	1.250	.750	—	.059	3	1	2	JOMO0803
AJXU08R142SA12L	.875	7.000	.535	1.250	.750	—	.059	3	4	2	JOMO0803
AJXU09R162WA16S	1.000	5.625	.602	2.375	1.000	1.1	.079	4	3	2	JDMO09T3
AJXU08R163SA16M	1.000	8.000	.661	2.750	1.000	0.94	.059	2	4	3	JOMO0803
AJXU09R162SA16L	1.000	8.000	.602	4.750	1.000	0.54	.079	4	4	2	JDMO09T3
AJXU09R182FA16S	1.125	5.625	.728	1.625	1.000	—	.079	3	1	2	JDMO09T3
AJXU09R182SA16L	1.125	8.000	.728	1.625	1.000	—	.079	3	4	2	JDMO09T3
AJXU12R202WA20S	1.250	6.000	.789	2.750	1.250	0.94	.079	4	3	2	JDMO1204
AJXU09R203SA20M	1.250	8.000	.854	3.125	1.250	0.82	.079	3.3	4	3	JDMO09T3
AJXU12R202SA20L	1.250	8.000	.789	4.750	1.250	0.54	.079	4	4	2	JDMO1204
AJXU12R243WA20S	1.500	6.000	1.038	2.000	1.250	—	.079	3	3	3	JDMO1204
AJXU09R244SA20M	1.500	10.000	1.114	2.375	1.250	—	.079	2.4	4	4	JDMO09T3
AJXU12R243SA20L	1.500	10.000	1.038	2.000	1.250	—	.079	3	4	3	JDMO1204
AJXU12R243SA24L	1.500	10.000	1.038	2.750	1.500	0.94	.079	3	4	3	JDMO1204
AJXU14R323WA24S	2.000	6.000	1.534	2.000	1.500	—	.079	4.2	3	3	JDMO1204

(1) z = No. of inserts
* RMPX = Max. ramping angle

MILLING CUTTERS

Fig.1

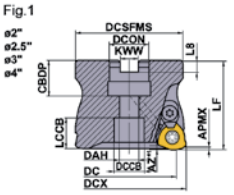
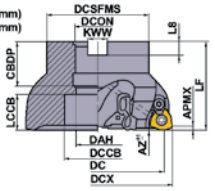


Fig.2



DCX	Set Bolt	Geometry
2.000" 2.500", 3.000" 4.000"	HSCU37513H HSCU50014H HSCU75016H	①
4.921" 6.299"	MBAU75016H MBAU100016H	②

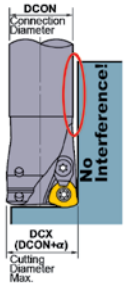
PART#	DCX	DC	LF	DCON	WT (lbs)	APMX	RMPX	Fig.	z(1)	Insert
AJXU12R0203	2.000	1.539	2.00	.75	.888	.059	2°	1	3	JDMO1204
AJXU12R0204	2.000	1.539	2.00	.75	.866	.059	2°	1	4	JDMO1204
AJXU09R0205	2.000	1.606	2.00	.75	.925	.039	1.1°	1	5	JDMO09T3
AJXU14R2503C	2.500	2.032	2.00	1.00	1.393	.079	2.8°	1	3	JDMO1405
AJXU14R2504C	2.500	2.032	2.00	1.00	1.338	.079	2.8°	1	4	JDMO1405
AJXU12R2505C	2.500	2.039	2.00	1.00	1.427	.059	1.5°	1	5	JDMO1204
AJXU14R0304C	3.000	2.532	2.00	1.00	2.133	.079	1.8°	1	4	JDMO1405
AJXU14R0305C	3.000	2.532	2.00	1.00	2.078	.079	1.8°	1	5	JDMO1405
AJXU12R0306C	3.000	2.543	2.00	1.00	2.274	.059	1.2°	1	6	JDMO1204
AJXU14R0405E	4.000	3.531	2.50	1.50	4.806	.079	1.2°	1	5	JDMO1405
AJXU14R0406E	4.000	3.531	2.50	1.50	4.981	.079	1.2°	1	6	JDMO1405
AJXU12R0407E	4.000	3.539	2.50	1.50	5.283	.059	0.8°	1	7	JDMO1204
AJX14RA12505E	4.921	4.457	2.48	1.50	7.275	.079	0.8°	2	5	JDMO1405
AJX14RA12507E	4.921	4.457	2.48	1.50	7.275	.079	0.8°	2	7	JDMO1405
AJX14RA16006F	6.299	5.835	2.48	2.00	11.023	.079	0.5°	2	6	JDMO1405
AJX14RA16008F	6.299	5.835	2.48	2.00	11.023	.079	0.5°	2	8	JDMO1405

(1) z = No. of inserts
* RMPX = Max. ramping angle

No Workpiece Material Interference

Some AJX shank types are designed with an oversized cutting diameter for workpiece material and chip clearance, as shown. Ideal for deep cutting and reduces the need for special long tools.

CUTTER	DCX	DCON
AJXU06R112□A10□	.688	.625
AJXU08R142□A12□	.875	.750
AJXU09R182□A16□	1.125	1.000
AJXU09R244SA20M	1.500	1.250
AJXU12R243□A20□	1.500	1.250
AJXU14R323WA24S	2.000	1.500



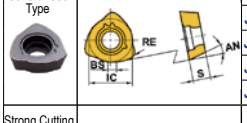
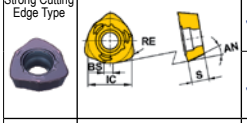
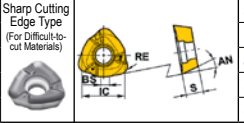
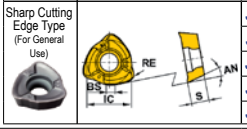
MODULAR MILLING HEADS & SHANKS

HEADS AVAILABLE IN SIZES AS SHOWN BELOW. PLEASE CALL FOR DETAILS.

DCX DIA.	PART#
.625	AJXU06R102AM0830
.750	AJXU08R122AM1030
.750	AJXU06R123AM1030
.875	AJXU08R142AM1030
.875	AJXU06R143AM1030
1.000	AJXU09R162AM1235
1.000	AJXU08R163AM1235
1.125	AJXU09R182AM1235
1.125	AJXU08R183AM1235
1.250	AJXU09R203AM1645
1.375	AJXU09R223AM1645

		FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140	VP15TF	VP30RT
		Coated									
P	Steel	●	◐	✤						◐	✤
M	Stainless Steels				◐	✤				◐	✤
K	Cast Irons	●								✤	
S	Heat Resistant Alloys, Titanium Alloys						◐	✤	✤	◐	
H	Hardened Steels									◐	

●: Stable Cutting ◐: General Cutting
✤: Interrupted Cutting

Inserts	Part#	AN	IC	S	BS	RE	FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	MP9140	VP15TF	VP30RT
General Use Type 	JOMW-06T215ZZSR-FT	13°	.250	.109	.047	.059	●	●	●	●	●	●	●		●	●
	JOMW-080320ZZSR-FT	13°	.315	.125	.055	.079	●	●	●	●	●	●	●		●	●
	JDMW-09T320ZDSR-FT	15°	.375	.156	.071	.079	●	●	●	●	●	●	●		●	●
	JDMW-120420ZDSR-FT	15°	.472	.187	.098	.079	●	●	●	●	●	●	●		●	●
	JDMW-140520ZDSR-FT	15°	.551	.219	.110	.079	●	●	●	●	●	●	●		●	●
Strong Cutting Edge Type 	JDMT-120420ZDSR-ST	15°	.472	.187	.098	.079	●	●	●	●	●				●	●
	JDMT-140520ZDSR-ST	15°	.551	.219	.110	.079	●	●	●	●	●				●	●
Sharp Cutting Edge Type (For Difficult-to-cut Materials) 	JOMT-06T216ZZER-JL	13°	.250	.109	.047	.063				●	●	●	●	●		
	JOMT-080322ZZER-JL	13°	.315	.125	.055	.087				●	●	●	●	●		
	JDMT-09T323ZDER-JL	15°	.375	.156	.071	.091				●	●	●	●	●		
	JDMT-120423ZDER-JL	15°	.472	.187	.098	.091				●	●	●	●	●		
	JDMT-140523ZDER-JL	15°	.551	.219	.110	.091				●	●	●	●	●		
Sharp Cutting Edge Type (For General Use) 	JOMT-06T215ZZSR-JM	13°	.250	.109	.047	.059	●	●	●	●	●	●	●		●	●
	JOMT-080320ZZSR-JM	13°	.315	.125	.055	.079	●	●	●	●	●	●	●		●	●
	JDMT-09T320ZDSR-JM	15°	.375	.156	.071	.079	●	●	●	●	●	●	●		●	●
	JDMT-120420ZDSR-JM	15°	.472	.187	.098	.079	●	●	●	●	●	●	●		●	●
	JDMT-140520ZDSR-JM	15°	.551	.219	.110	.079	●	●	●	●	●	●	●		●	●

FREE CUTTER PROMO — SEE PAGES 2-4

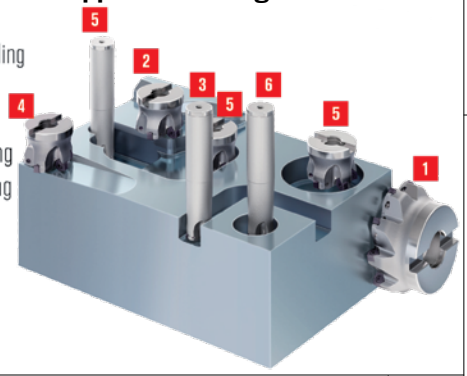
MITSUBISHI DIAEDGE

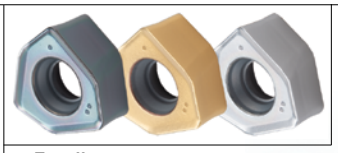
WJX HIGH FEED MILLING CUTTERS

USING DOUBLE SIDED INSERTS

Multi-functional Application Range

1. Face Milling
2. Shoulder Milling
3. Slot Milling
4. Ramping
5. Pocket Milling
6. Helical Milling





- Excellent tool life
- Insert held in dovetail pockets
- Wiper cutting edge enables fine surface finish
- The insert's straight cutting edge allows for high feed machining
- Positive insert ramping performance sharpness

WJX

MULTI-FUNCTIONAL MILLING

P M K N S H

INDEXABLE END-MILLS

USE INSERT: JOMU-0905

WJX09

CYLINDRICAL SHANK

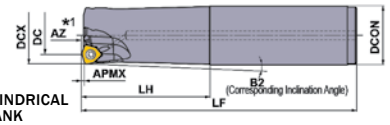


Fig.1

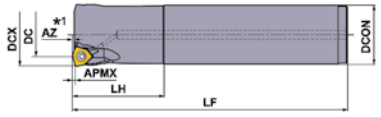


Fig.2

WELDON SHANK

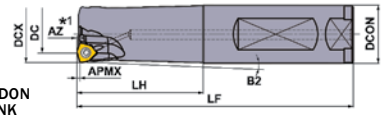


Fig.3

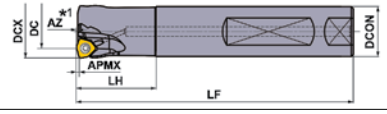


Fig.4

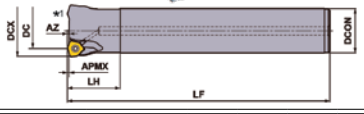
Fig.	PART#	DCX	DC	LF	LH	DCON	APMX	z(1)	Insert
3	WJX09UR1602FA16S	1.000	.565	5.625	2.375	1.000	.047	2	JOMU0905
3	WJX09UR1603FA16S	1.000	.565	5.625	2.375	1.000	.047	3	
1	WJX09UR1602SA16L	1.000	.565	8.000	4.750	1.000	.047	2	
1	WJX09UR1603SA16L	1.000	.565	8.000	4.750	1.000	.047	3	
4	WJX09UR1802FA16S	1.125	.687	5.625	1.625	1.000	.047	2	
4	WJX09UR1803FA16S	1.125	.687	5.625	1.625	1.000	.047	3	
2	WJX09UR1802SA16L	1.125	.687	8.000	1.625	1.000	.047	2	
2	WJX09UR1803SA16L	1.125	.687	8.000	1.625	1.000	.047	3	
3	WJX09UR2002FA20S	1.250	.811	6.000	2.750	1.250	.047	2	
3	WJX09UR2003FA20S	1.250	.811	6.000	2.750	1.250	.047	3	
1	WJX09UR2002SA20L	1.250	.811	8.000	4.750	1.250	.047	2	
1	WJX09UR2003SA20L	1.250	.811	8.000	4.750	1.250	.047	3	
4	WJX09UR2403FA20S	1.500	1.060	6.000	2.000	1.250	.047	3	
4	WJX09UR2404FA20S	1.500	1.060	6.000	2.000	1.250	.047	4	
2	WJX09UR2403SA20L	1.500	1.060	10.000	2.000	1.250	.047	3	
2	WJX09UR2404SA20L	1.500	1.060	10.000	2.000	1.250	.047	4	

(1) z = No. of inserts

WJX14

INDEXABLE END-MILLS

USE INSERT: JOMU-1407

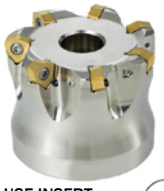


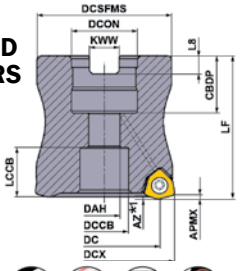
PART#	DCX	DC	LF	LH	DCON	APMX	z(1)
WJX14R5003SA42S	50	34.5	150	50	42	2	3
WJX14R5003SA42L	50	34.5	250	50	42	2	3

(1) z = No. of inserts

WJX09

ARBOR MOUNTED MILLING CUTTERS





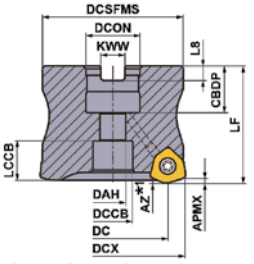
USE INSERT: JOMU-0905

PART#	DCX	DC	LF	DCON	APMX	z(1)	Insert
WJX09UR1.5004SA	1.500	1.060	1.750	.500	.047	4	JOMU0905
WJX09UR2.0004AA	2.000	1.557	2.000	.750	.047	4	
WJX09UR2.0006AA	2.000	1.557	2.000	.750	.047	6	
WJX09UR2.5005CA	2.500	2.057	2.000	1.000	.047	5	
WJX09UR2.5007CA	2.500	2.057	2.000	1.000	.047	7	

(1) z = No. of inserts

WJX14

ARBOR MOUNTED MILLING CUTTERS



USE INSERT: JOMU-1407

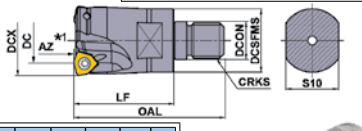
PART#	DCX	DC	LF	DCON	APMX	RMPX	z(1)	Insert
WJX14UR2.0003AA	2.000	1.388	2.000	.750	.079	4.3°	3	JOMU1407
WJX14UR2.0004AA	2.000	1.388	2.000	.750	.079	4.3°	4	
WJX14UR2.5004CA	2.500	1.887	2.000	1.000	.079	3°	4	
WJX14UR2.5005CA	2.500	1.887	2.000	1.000	.079	3°	5	
WJX14UR3.0005CA	3.000	2.387	2.000	1.000	.079	2.2°	5	
WJX14UR3.0006CA	3.000	2.387	2.000	1.000	.079	2.2°	6	
WJX14UR3.0005DA	3.000	2.387	2.500	1.250	.079	2.2°	5	
WJX14UR3.0006DA	3.000	2.387	2.500	1.250	.079	2.2°	6	
WJX14UR4.0006EA	4.000	3.386	2.500	1.500	.079	1.5°	6	
WJX14UR4.0007EA	4.000	3.386	2.500	1.500	.079	1.5°	7	
WJX14UR5.0007EA	5.000	4.386	2.500	1.500	.079	1.1°	7	
WJX14UR5.0009EA	5.000	4.386	2.500	1.500	.079	1.1°	9	
WJX14UR6.0009FA	6.000	5.386	2.500	2.000	.079	0.9°	9	

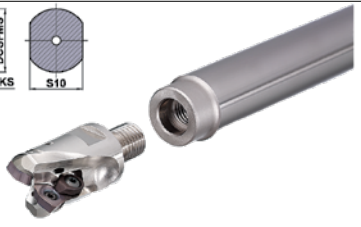
(1) z = No. of inserts

MODULAR MILLING CUTTERS

SCREW IN TYPE WJX09

USE INSERT: JOMU-0905





PART#	DCX	DC	LF	OAL	DCON	DCSFMS	S10	CRKS	APMX	z(1)
WJX09UR1602AM1235	1.000	.565	1.378	2.244	.492	.925	.748	M12	.047	2
WJX09UR1603AM1235	1.000	.565	1.378	2.244	.492	.925	.748	M12	.047	3
WJX09UR1802AM1235	1.125	.687	1.378	2.244	.492	.925	.748	M12	.047	2
WJX09UR1803AM1235	1.125	.687	1.378	2.244	.492	.925	.748	M12	.047	3
WJX09UR2002AM1645	1.250	.811	1.772	2.677	.669	1.122	.945	M16	.047	2
WJX09UR2003AM1645	1.250	.811	1.772	2.677	.669	1.122	.945	M16	.047	3
WJX09UR2202AM1645	1.375	.936	1.772	2.677	.669	1.122	.945	M16	.047	2
WJX09UR2203AM1645	1.375	.936	1.772	2.677	.669	1.122	.945	M16	.047	3
WJX09UR2204AM1645	1.375	.936	1.772	2.677	.669	1.122	.945	M16	.047	4

(1) z = No. of inserts

Chip Breaker System

FINISHING — MEDIUM — ROUGHING

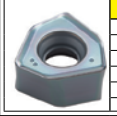
L Breaker — M Breaker — R Breaker

■ INSERTS

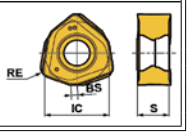
Workpiece Material										
P	Steel	●	◐	✚					◐	✚
M	Stainless Steels	◔			◔	✚			◔	✚
K	Cast Irons								✚	
S	Heat Resistant Alloys, Titanium Alloys						◐	✚	◐	
H	Hardened Steels								◔	

Cutting Conditions (Guide): ●: Stable Cutting ◐: General Cutting ✚: Unstable Cutting

Edge Preparation (Honing): E: Round

Shape	Part#	Class	Edge Preparation	MC7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	IC	S	BS	RE
	JOMU-090512ZZER-L	M	E	●	●	●	●	●	●	●	●	●	.375	.186	.035	.047
	JOMU-090512ZZER-M	M	E	●	●	●	●	●	●	●	●	●	.375	.187	.035	.047
	JOMU-090512ZZER-R	M	E	●	●	●					●	●	.375	.190	.035	.047
	JOMU-140715ZZER-L	M	E	●	●	●	●	●	●	●	●	●	.551	.259	.051	.059
	JOMU-140715ZZER-M	M	E	●	●	●	●	●	●	●	●	●	.551	.261	.051	.059
	JOMU-140715ZZER-R	M	E	●	●	●					●	●	.551	.266	.051	.059

Geometry

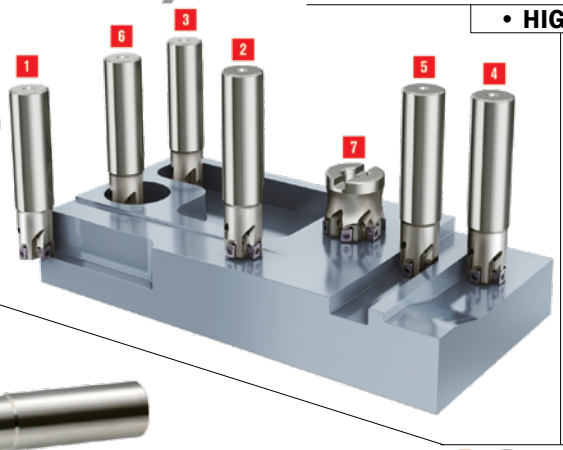


FREE CUTTER PROMO — SEE PAGES 2-4

MITSUBISHI DIAEDGE VPX MULTI FUNCTIONAL CUTTERS WITH TANGENTIAL INSERTS

• HIGH EFFICIENCY • DEEP SHOULDER MILLING

1. Shoulder Milling
2. Ramping
3. Pocket Milling
4. 3-D Profile Milling
5. Slot Milling
6. Helical Milling
7. Face Milling



SEE NEXT PAGE FOR EXTENDED FLUTE VPX CUTTERS

VPX INDEXABLE END-MILLS

P | M | K | N | S | H | 90° KAPR

CYLINDRICAL SHANK

Fig.1

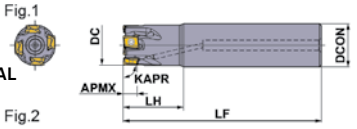
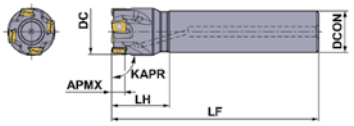


Fig.2



WELDON SHANK

Fig.3

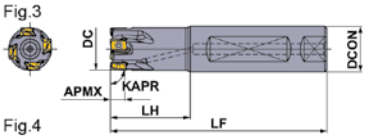
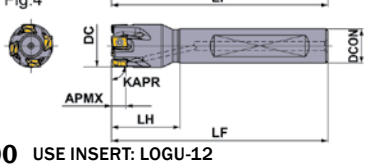


Fig.4



VPX200 USE INSERT: LOGU-09

PART#	DC	DCON	LF	LH	Fig.	APMX	RMPX*	z(1)	Insert
VPX200UR1002FA10S	.625	.625	3.625	1.250	3	.315	1.87°	2	LOGU09
VPX200UR1002SA10S	.625	.625	3.625	1.250	1	.315	1.87°	2	
VPX200UR1002SA10L	.625	.625	6.000	1.500	1	.315	1.87°	2	
VPX200UR1202FA10S	.750	.625	4.375	1.250	4	.315	1.43°	2	
VPX200UR1202SA10S	.750	.625	4.375	1.250	2	.315	1.43°	2	
VPX200UR1203FA10S	.750	.625	4.375	1.250	4	.315	1.43°	3	
VPX200UR1203SA10S	.750	.625	4.375	1.250	2	.315	1.43°	3	
VPX200UR1202FA12S	.750	.750	4.375	1.500	3	.315	1.43°	2	
VPX200UR1202SA12S	.750	.750	4.375	1.500	1	.315	1.43°	2	
VPX200UR1203FA12S	.750	.750	4.375	1.500	3	.315	1.43°	3	
VPX200UR1203SA12S	.750	.750	4.375	1.500	1	.315	1.43°	3	
VPX200UR1202SA12L	.750	.750	7.250	2.000	1	.315	1.43°	2	
VPX200UR1402SA12L	.875	.750	7.250	1.500	2	.315	1.14°	2	
VPX200UR1603FA12S	1.000	.750	4.750	1.500	4	.315	0.95°	3	
VPX200UR1603SA12S	1.000	.750	4.750	1.500	2	.315	0.95°	3	
VPX200UR1604FA12S	1.000	.750	4.750	1.500	4	.315	0.95°	4	
VPX200UR1604SA12S	1.000	.750	4.750	1.500	2	.315	0.95°	4	
VPX200UR1603SA12L	1.000	.750	8.500	1.500	2	.315	0.95°	3	
VPX200UR1603FA16S	1.000	1.000	4.750	1.750	3	.315	0.95°	3	
VPX200UR1603SA16S	1.000	1.000	4.750	1.750	1	.315	0.95°	3	
VPX200UR1604FA16S	1.000	1.000	4.750	1.750	3	.315	0.95°	4	
VPX200UR1604SA16S	1.000	1.000	4.750	1.750	1	.315	0.95°	4	
VPX200UR1603SA16L	1.000	1.000	8.500	2.500	1	.315	0.95°	3	
VPX200UR1803SA16L	1.125	1.000	8.500	1.750	2	.315	0.82°	3	
VPX200UR2003FA16S	1.250	1.000	5.125	1.750	4	.315	0.71°	3	
VPX200UR2003SA16S	1.250	1.000	5.125	1.750	2	.315	0.71°	3	
VPX200UR2005FA16S	1.250	1.000	5.125	1.750	4	.315	0.71°	5	
VPX200UR2005SA16S	1.250	1.000	5.125	1.750	2	.315	0.71°	5	
VPX200UR2003SA16L	1.250	1.000	9.000	1.750	2	.315	0.71°	3	
VPX200UR2003FA20S	1.250	1.250	5.125	2.000	3	.315	0.71°	3	
VPX200UR2003SA20S	1.250	1.250	5.125	2.000	1	.315	0.71°	3	
VPX200UR2004FA20S	1.250	1.250	5.125	2.000	3	.315	0.71°	4	
VPX200UR2004SA20S	1.250	1.250	5.125	2.000	1	.315	0.71°	4	
VPX200UR2005FA20S	1.250	1.250	5.125	2.000	3	.315	0.71°	5	
VPX200UR2005SA20S	1.250	1.250	5.125	2.000	1	.315	0.71°	5	
VPX200UR2003SA20L	1.250	1.250	9.000	3.000	1	.315	0.71°	3	
VPX200UR2404FA20S	1.500	1.250	5.125	2.000	4	.315	0.57°	4	
VPX200UR2404SA20S	1.500	1.250	5.125	2.000	2	.315	0.57°	4	
VPX200UR2406FA20S	1.500	1.250	5.125	2.000	4	.315	0.57°	6	
VPX200UR2406SA20S	1.500	1.250	5.125	2.000	2	.315	0.57°	6	
VPX200UR2404SA20L	1.500	1.250	9.000	2.000	2	.315	0.57°	4	

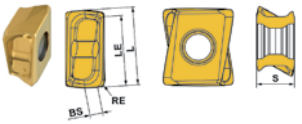
(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

VPX300 USE INSERT: LOGU-12

PART#	DC	DCON	LF	LH	APMX	RMPX*	Fig.	z(1)	Insert
VPX300UR1602FA16S	1.000	1.000	4.750	1.750	.433	2.07°	3	2	LOGU12
VPX300UR1602SA16S	1.000	1.000	4.750	1.750	.433	2.07°	1	2	
VPX300UR1602SA16L	1.000	1.000	8.500	2.500	.433	2.07°	1	2	
VPX300UR1802SA16L	1.125	1.000	8.500	1.750	.433	1.73°	2	2	
VPX300UR2002FA16S	1.250	1.000	5.125	1.750	.433	1.49°	4	2	
VPX300UR2002SA16S	1.250	1.000	5.125	1.750	.433	1.49°	2	2	
VPX300UR2003FA16S	1.250	1.000	5.125	1.750	.433	1.49°	4	3	
VPX300UR2003SA16S	1.250	1.000	5.125	1.750	.433	1.49°	2	3	
VPX300UR2003SA16L	1.250	1.000	9.000	1.750	.433	1.49°	2	3	
VPX300UR2002FA20S	1.250	1.250	5.125	2.000	.433	1.49°	3	2	
VPX300UR2002SA20S	1.250	1.250	5.125	2.000	.433	1.49°	1	2	
VPX300UR2003FA20S	1.250	1.250	5.125	2.000	.433	1.49°	3	3	
VPX300UR2003SA20S	1.250	1.250	5.125	2.000	.433	1.49°	1	3	
VPX300UR2003SA20L	1.250	1.250	9.000	3.000	.433	1.49°	1	3	
VPX300UR2402FA20S	1.500	1.250	5.125	2.000	.433	1.13°	4	2	
VPX300UR2402SA20S	1.500	1.250	5.125	2.000	.433	1.13°	2	2	
VPX300UR2403FA20S	1.500	1.250	5.125	2.000	.433	1.13°	4	3	
VPX300UR2403SA20S	1.500	1.250	5.125	2.000	.433	1.13°	2	3	
VPX300UR2403SA20L	1.500	1.250	9.000	2.000	.433	1.13°	2	3	

(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

INSERTS: LOGU-12



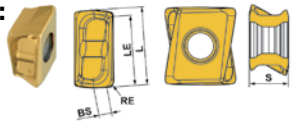
PART#	L	RE	LE	S	BS
LOGU-1207020PN□R-*	.488	.008	.445	.276	.118
LOGU-1207040PN□R-*	.488	.016	.445	.276	.110
LOGU-1207080PN□R-*	.488	.031	.445	.276	.102
LOGU-1207100PN□R-*	.488	.039	.445	.276	.098
LOGU-1207120PN□R-*	.488	.047	.445	.276	.094
LOGU-1207160PN□R-*	.488	.063	.445	.276	.071
LOGU-1207200PN□R-*	.488	.079	.445	.276	.055
LOGU-1207240PN□R-*	.488	.094	.445	.276	.047
LOGU-1207300PN□R-*	.488	.118	.445	.276	.024
LOGU-1207320PN□R-*	.488	.126	.445	.276	.016

□ = E: FOR STEEL, STAINLESS, HI-TEMP & CAST IRON, F: FOR ALUMINUM
* = L: FOR LOW CUTTING FORCES, M: FOR GENERAL USE

L breaker Focus on Cutting Edge Sharpness

M breaker Focus on Cutting Edge Strength

INSERTS: LOGU-09



PART#	L	RE	LE	S	BS
LOGU-0904020PN□R-*	.343	.008	.299	.169	.067
LOGU-0904040PN□R-*	.343	.016	.299	.169	.063
LOGU-0904080PN□R-*	.343	.031	.299	.169	.047
LOGU-0904100PN□R-*	.343	.039	.299	.169	.039
LOGU-0904120PN□R-*	.343	.047	.299	.169	.035
LOGU-0904160PN□R-*	.343	.063	.299	.169	.020

□ = E: FOR STEEL, STAINLESS, HI-TEMP & CAST IRON, F: FOR ALUMINUM
* = L: FOR LOW CUTTING FORCES, M: FOR GENERAL USE

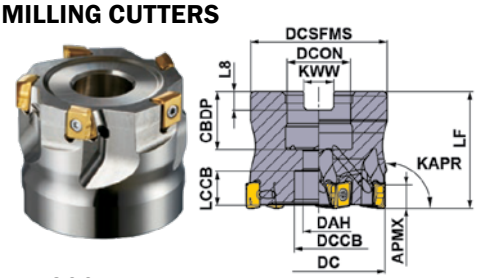
CARBIDE GRADES

		MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	TF15
P	Steels		●	✤				●	
M	Stainless Steels				◐			◐	
K	Cast Irons	◐						✤	
N	Non-Ferrous Materials								◐
S	Heat Resistant Alloys, Titanium Alloys					◐	✤	◐	
H	Hardened Steels							◐	

Cutting Conditions (Guide): ●: Stable Cutting ◐: General Cutting ✤: Unstable Cutting

Coated | Carbide

MILLING CUTTERS



VPX200 USE INSERT: LOGU-09

PART#	DC	LF	DCON	WT (lbs.)	APMX	RMPX*	z(1)	Insert
VPX200UR1.2503SA	1.250	1.375	.500	.120	.315	0.72°	3	LOGU09
VPX200UR1.2505SA	1.250	1.375	.500	.120	.315	0.72°	5	
VPX200UR1.5004SA	1.500	1.750	.500	.260	.315	0.57°	4	
VPX200UR1.5006SA	1.500	1.750	.500	.250	.315	0.57°	6	
VPX200UR1.5004AA	1.500	1.750	.750	.220	.315	0.57°	4	
VPX200UR1.5006AA	1.500	1.750	.750	.210	.315	0.57°	6	
VPX200UR2.0005AA	2.000	1.750	.750	.410	.315	0.41°	5	
VPX200UR2.0007AA	2.000	1.750	.750	.410	.315	0.41°	7	
VPX200UR2.5006CA	2.500	2.000	1.000	.740	.315	0.32°	6	
VPX200UR2.5009CA	2.500	2.000	1.000	.740	.315	0.32°	9	

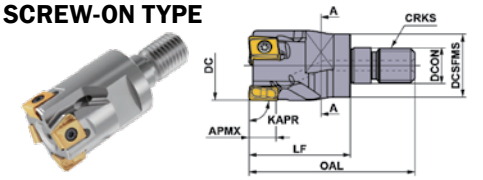
(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

VPX300 USE INSERT: LOGU-12

PART#	DC	LF	DCON	WT (lbs.)	APMX	RMPX*	z(1)	Insert
VPX300UR1.5003SA	1.500	1.750	.500	.240	.433	1.13°	3	LOGU12
VPX300UR1.5004SA	1.500	1.750	.500	.240	.433	1.13°	4	
VPX300UR2.0004AA	2.000	1.750	.750	.400	.433	0.78°	4	
VPX300UR2.0006AA	2.000	1.750	.750	.390	.433	0.78°	6	
VPX300UR2.5006CA	2.500	2.000	1.000	.700	.433	0.59°	6	
VPX300UR2.5008CA	2.500	2.000	1.000	.720	.433	0.59°	8	
VPX300UR3.0007CA	3.000	2.000	1.000	.940	.433	0.48°	7	
VPX300UR3.0010CA	3.000	2.000	1.000	.950	.433	0.48°	10	

(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

MODULAR MILLING HEADS SCREW-ON TYPE



VPX200 USE INSERT: LOGU-09

PART#	DC	DCON	DCSFMS	OAL	LF	S10	CRKS	APMX	RMPX*	z(1)
VPX200UR1002AM0830	.625	.335	.571	1.890	1.181	.394	M08	.315	1.87°	2
VPX200UR1202AM1030	.750	.413	.728	1.929	1.181	.551	M10	.315	1.43°	2
VPX200UR1203AM1030	.750	.413	.728	1.929	1.181	.551	M10	.315	1.43°	3
VPX200UR1402AM1030	.875	.413	.728	1.929	1.181	.551	M10	.315	1.14°	2
VPX200UR1403AM1030	.875	.413	.728	1.929	1.181	.551	M10	.315	1.14°	3
VPX200UR1603AM1235	1.000	.492	.925	2.244	1.378	.748	M12	.315	.95°	3
VPX200UR1604AM1235	1.000	.492	.925	2.244	1.378	.748	M12	.315	.95°	4
VPX200UR1803AM1235	1.125	.492	.925	2.244	1.378	.748	M12	.315	.82°	3
VPX200UR1804AM1235	1.125	.492	.925	2.244	1.378	.748	M12	.315	.82°	4
VPX200UR2003AM1640	1.250	.669	1.122	2.480	1.575	.945	M16	.315	.71°	3
VPX200UR2004AM1640	1.250	.669	1.122	2.480	1.575	.945	M16	.315	.71°	4
VPX200UR2005AM1640	1.250	.669	1.122	2.480	1.575	.945	M16	.315	.71°	5
VPX200UR2203AM1640	1.375	.669	1.122	2.480	1.575	.945	M16	.315	.64°	3
VPX200UR2205AM1640	1.375	.669	1.122	2.480	1.575	.945	M16	.315	.64°	5
VPX200UR2404AM1640	1.500	.669	1.122	2.480	1.575	.945	M16	.315	.57°	4
VPX200UR2406AM1640	1.500	.669	1.122	2.480	1.575	.945	M16	.315	.57°	6

(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

VPX300 USE INSERT: LOGU-12

PART#	DC	DCON	DCSFMS	OAL	LF	S10	CRKS	APMX	RMPX*	z(1)
VPX300UR1602AM1235	1.000	.492	.925	2.244	1.378	.748	M12	.433	2.07°	2
VPX300UR1802AM1235	1.125	.492	.925	2.244	1.378	.748	M12	.433	1.73°	2
VPX300UR2002AM1640	1.250	.669	1.122	2.480	1.575	.945	M16	.433	1.49°	2
VPX300UR2003AM1640	1.250	.669	1.122	2.480	1.575	.945	M16	.433	1.49°	3
VPX300UR2202AM1640	1.375	.669	1.122	2.480	1.575	.945	M16	.433	1.28°	2
VPX300UR2203AM1640	1.375	.669	1.122	2.480	1.575	.945	M16	.433	1.28°	3
VPX300UR2403AM1640	1.500	.669	1.122	2.480	1.575	.945	M16	.433	1.13°	3
VPX300UR2404AM1640	1.500	.669	1.122	2.480	1.575	.945	M16	.433	1.13°	4

(1) z = No. of inserts * RMPX = MAX RAMPING ANGLE

ARBORS FOR SCREW-ON HEADS ARE AVAILABLE IN A VARIETY OF STYLES

FREE CUTTER PROMO — SEE PAGES 2-4

MITSUBISHI DIAEDGE

VPX EXTENDED FLUTE MILLING CUTTERS FOR DEEP SHOULDER MILLING USING TANGENTIAL INSERTS

VPX INDEXABLE END-MILLS - EXTENDED

90° KAPR | F | R | P | M | K | N | S | H

LONG CUTTING EDGE

Fig.1

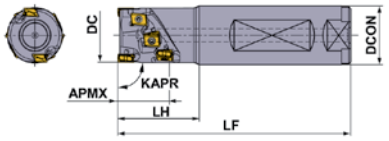
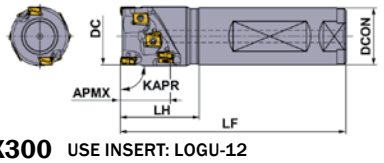


Fig.2



VPX200 USE INSERT: LOGU-09

PART#	DC	DCON	LF	LH	Fig.	APMX	RMPX*	#FL	z(1)
VPX200UR142FA12S0504	.875	.750	4.375	1.250	2	.551	1.14°	2	4
VPX200UR162FA16S0806	1.000	1.000	4.750	1.500	1	.827	0.95°	2	6
VPX200UR162FA16S1108	1.000	1.000	5.000	1.750	1	1.102	0.95°	2	8
VPX200UR182FA16S0806	1.125	1.000	4.750	1.500	2	.827	0.82°	2	6
VPX200UR182FA16S1108	1.125	1.000	5.000	1.750	2	1.102	0.82°	2	8
VPX200UR202FA20S1108	1.250	1.250	5.000	1.750	1	1.102	0.71°	2	8
VPX200UR203FA20S1112	1.250	1.250	5.000	1.750	1	1.102	0.71°	3	12
VPX200UR202FA20S1310	1.250	1.250	5.250	2.000	1	1.378	0.71°	2	10
VPX200UR203FA20S1315	1.250	1.250	5.250	2.000	1	1.378	0.71°	3	15
VPX200UR222FA20S1108	1.375	1.250	5.000	1.750	2	1.102	0.64°	2	8
VPX200UR223FA20S1112	1.375	1.250	5.000	1.750	2	1.102	0.64°	3	12
VPX200UR222FA20S1310	1.375	1.250	5.250	2.000	2	1.378	0.64°	2	10
VPX200UR223FA20S1315	1.375	1.250	5.250	2.000	2	1.378	0.64°	3	15
VPX200UR243FA20S1315	1.500	1.250	5.250	2.000	2	1.378	0.57°	3	15
VPX200UR244FA20S1320	1.500	1.250	5.250	2.000	2	1.378	0.57°	4	20
VPX200UR243FA20S1618	1.500	1.250	5.500	2.250	2	1.654	0.57°	3	18
VPX200UR244FA20S1624	1.500	1.250	5.500	2.250	2	1.654	0.57°	4	24

(1) z = No. of inserts * RMPX = Max. ramping angle

VPX300 USE INSERT: LOGU-12

PART#	DC	DCON	LF	LH	Fig.	APMX	RMPX*	#FL	z(1)
VPX300UR242FA20S0804	1.500	1.250	5.000	1.750	2	.827	1.13°	2	4
VPX300UR242FA20S1206	1.500	1.250	5.250	2.000	2	1.220	1.13°	2	6
VPX300UR242FA20S1608	1.500	1.250	5.500	2.500	2	1.654	1.13°	2	8

(1) z = No. of inserts * RMPX = Max. ramping angle

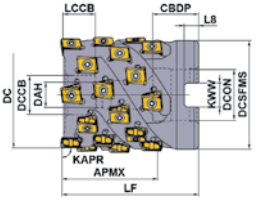
Double-sided insert that has revolutionized tangential insert machining.

- Single Flat Surface Improves Chip Evacuation and Protects Cutter Body

- Two-sided Structure Supports Insert Performance!
  A. Makes Possible Ramping
  B. Wiper Flats for Good Finish Surface
- Convex Shaped Insert for Improved Chip Evacuation

INSERTS SHOWN ON THE PREVIOUS PAGE

VPX SHELL MILLING CUTTERS



VPX200 USE INSERT: LOGU-09

PART#	DC	LF	DCON	WT (lbs.)	APMX	RMPX*	#FL	z(1)
VPX200UR1.2502AA1310	1.250	2.250	.500	.529	1.378	0.72°	2	10
VPX200UR1.2503AA1315	1.250	2.250	.500	.485	1.378	0.72°	3	15
VPX200UR1.5003AA1618	1.500	2.375	.500	.728	1.654	0.57°	3	18
VPX200UR1.5004AA1624	1.500	2.375	.500	.705	1.654	0.57°	4	24
VPX200UR2.0004AA1624	2.000	2.375	.750	1.279	1.654	0.41°	4	24
VPX200UR2.0005AA1630	2.000	2.375	.750	1.257	1.654	0.41°	5	30

(1) z = No. of inserts * RMPX = Max. ramping angle

VPX300 USE INSERT: LOGU-12

PART#	DC	LF	DCON	WT (lbs.)	APMX	RMPX*	#FL	z(1)
VPX300UR1.5002AA1206	1.500	2.000	.500	.573	1.220	1.13°	2	6
VPX300UR1.5002AA1608	1.500	2.375	.500	.661	1.654	1.13°	2	8
VPX300UR2.0003AA1209	2.000	2.250	.750	1.146	1.220	0.78°	3	9
VPX300UR2.0003AA1612	2.000	2.500	.750	1.213	1.654	0.78°	3	12
VPX300UR2.0003AA2015	2.000	3.000	.750	1.477	2.047	0.78°	3	15
VPX300UR2.5004AA1616	2.500	2.750	1.000	2.337	1.654	0.59°	4	16
VPX300UR2.5004AA2020	2.500	3.000	1.000	2.513	2.047	0.59°	4	20
VPX300UR3.0005AA2025	3.000	3.250	1.250	4.034	2.047	0.48°	5	25
VPX300UR3.0005AA2835	3.000	3.750	1.250	4.497	2.874	0.48°	5	35

(1) z = No. of inserts * RMPX = Max. ramping angle

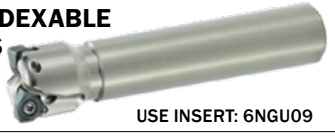
MITSUBISHI DIAEDGE

WWX MILLING CUTTERS

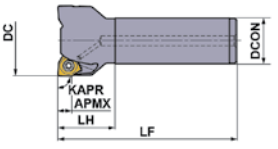
UTILIZING A DOUBLE SIDED THICK INSERT FOR HIGH RIGIDITY AND EXCELLENT CONTROL AND CHIP DAMAGE PREVENTION, ALONG WITH HIGH QUALITY SURFACE FINISH

WWX200=.236 inch
WWX400=.354 inch

WWX INDEXABLE END-MILLS



WWX400 USE INSERT: 6NGU14

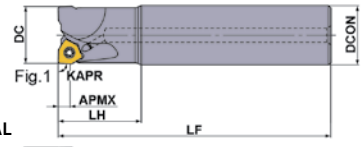


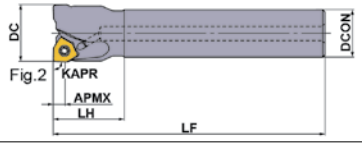
PART#	DC	LF	DCONMS	LH	WT (lbs.)	APMX	RMPX	z(1)
WWX400UR3203FA20M	2.000	4.750	1.250	1.500	1.7	.323	.4°	3
WWX400UR3204FA20M	2.000	4.750	1.250	1.500	1.7	.323	.4°	4
WWX400UR4003FA20M	2.500	4.750	1.250	1.500	2.1	.323	.26°	3
WWX400UR4004FA20M	2.500	4.750	1.250	1.500	2	.323	.26°	4
WWX400UR4005FA20M	2.500	4.750	1.250	1.500	2	.323	.26°	5
WWX400UR4804FA20M	3.000	4.750	1.250	1.500	2.5	.323	.16°	4
WWX400UR4805FA20M	3.000	4.750	1.250	1.500	2.4	.323	.16°	5
WWX400UR4807FA20M	3.000	4.750	1.250	1.500	2.3	.323	.16°	7

(1) z = No. of inserts

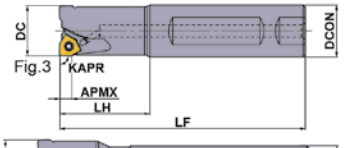
WWX200 USE INSERT: 6NGU09

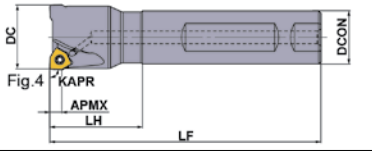
CYLINDRICAL SHANK





WELDON SHANK

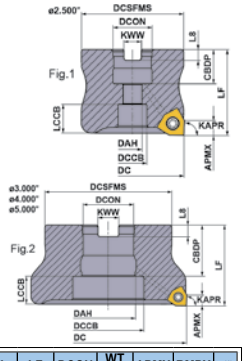




PART#	DC	Fig.	LF	DCONMS	LH	WT (lbs.)	APMX	z(1)
WWX200UR1602FA16S	1.000	3	4.750	1.000	1.750	.9	.197	2
WWX200UR1602SA16L	1.000	1	8.500	1.000	2.500	1.7	.197	2
WWX200UR1802SA16L	1.125	2	8.500	1.000	1.750	1.8	.197	2
WWX200UR2002FA16S	1.250	4	5.125	1.000	1.750	1.1	.197	2
WWX200UR2003FA16S	1.250	4	5.125	1.000	1.750	1.1	.197	3
WWX200UR2003SA16L	1.250	2	9.000	1.000	1.750	1.9	.197	3
WWX200UR2002FA20S	1.250	3	5.125	1.250	2.000	1.5	.197	2
WWX200UR2003FA20S	1.250	3	5.125	1.250	2.000	1.5	.197	3
WWX200UR2003SA20L	1.250	1	9.000	1.250	3.000	2.8	.197	3
WWX200UR2403FA20S	1.500	4	5.125	1.250	2.000	1.7	.197	3
WWX200UR2404FA20S	1.500	4	5.125	1.250	2.000	1.7	.197	4
WWX200UR2404SA20L	1.500	2	9.000	1.250	2.000	3.0	.197	4

(1) z = No. of inserts

WWX400 USE INSERT: 6NGU14



PART#	DC	Coolant Thru	Fig.	LF	DCON	WT (lbs.)	APMX	RMPX	z(1)
WWX400UR2.0003AA	2.000	Y		2.125	.750	1.1	.323	.4°	3
WWX400UR2.0004AA	2.000	Y		2.125	.750	1.1	.323	.4°	4
WWX400UR2.5003CA	2.500	Y	1	2.000	1.000	1.6	.323	.26°	3
WWX400UR2.5004CA	2.500	Y		2.000	1.000	1.5	.323	.26°	4
WWX400UR2.5005CA	2.500	Y		2.000	1.000	1.5	.323	.26°	5
WWX400UR3.0004CA	3.000	Y		2.000	1.000	2.1	.323	.16°	4
WWX400UR3.0005CA	3.000	Y		2.000	1.000	2.1	.323	.16°	5
WWX400UR3.0007CA	3.000	Y		2.000	1.000	1.9	.323	.16°	7
WWX400UR4.0005EA	4.000	Y		2.500	1.500	4.9	.323	—	5
WWX400UR4.0007EA	4.000	Y		2.500	1.500	4.8	.323	—	7
WWX400UR4.0009EA	4.000	Y		2.500	1.500	4.7	.323	—	9
WWX400UR5.0006EA	5.000	Y		2.500	1.500	7.6	.323	—	6
WWX400UR5.0008EA	5.000	Y		2.500	1.500	7.5	.323	—	8
WWX400UR5.0012EA	5.000	Y	2	2.500	1.500	7.3	.323	—	12
WWX400UR6.0008EA	6.000	Y		2.500	1.500	9.9	.323	—	8
WWX400UR6.0010EA	6.000	Y		2.500	1.500	9.8	.323	—	10
WWX400UR6.0014EA	6.000	Y		2.500	1.500	9.7	.323	—	14
WWX400UR8.0010MN	8.000	N		2.500	2.500	17.3	.323	—	10
WWX400UR8.0012MN	8.000	N		2.500	2.500	17.2	.323	—	12
WWX400UR8.0016MN	8.000	N		2.500	2.500	17	.323	—	16
WWX400UR10.0012MN	10.000	N		2.500	2.500	29.3	.323	—	12
WWX400UR10.0014MN	10.000	N		2.500	2.500	29.3	.323	—	14
WWX400UR10.0018MN	10.000	N		2.500	2.500	29	.323	—	18

(1) z = No. of inserts * RMPX = Max. ramping angle

WWX MILLING CUTTERS

Fig.1

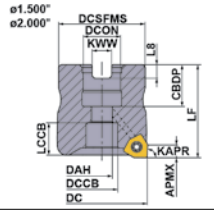
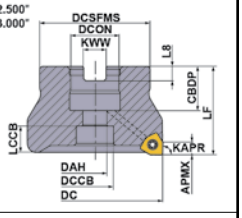


Fig.2



WWX200 USE INSERT: 6NGU09

PART#	DC	Fig.	LF	DCONMS	WT (lbs.)	APMX	Coolant Thru	z(1)
WWX200UR1.5003SA	1.500	1	1.750	.500	.6	.197	Y	3
WWX200UR1.5004SA	1.500	1	1.750	.500	.5	.197	Y	4
WWX200UR2.0004AA	2.000	1	1.750	.750	.9	.197	Y	4
WWX200UR2.0005AA	2.000	1	1.750	.750	.9	.197	Y	5
WWX200UR2.0006AA	2.000	1	1.750	.750	.9	.197	Y	6
WWX200UR2.5005CA	2.500	2	2.000	1.000	1.7	.197	Y	5
WWX200UR2.5006CA	2.500	2	2.000	1.000	1.6	.197	Y	6
WWX200UR2.5007CA	2.500	2	2.000	1.000	1.6	.197	Y	7
WWX200UR3.0005CA	3.000	2	2.000	1.000	2.2	.197	Y	5
WWX200UR3.0007CA	3.000	2	2.000	1.000	2.2	.197	Y	7
WWX200UR3.0009CA	3.000	2	2.000	1.000	2.1	.197	Y	9
WWX200UR4.0006EA	4.000	2	2.500	1.500	5.1	.197	Y	6
WWX200UR4.0008EA	4.000	2	2.500	1.500	5.0	.197	Y	8
WWX200UR4.0011EA	4.000	2	2.500	1.500	4.9	.197	Y	11
WWX200UR5.0007EA	5.000	2	2.500	1.500	7.8	.197	Y	7
WWX200UR5.0011EA	5.000	2	2.500	1.500	7.6	.197	Y	11
WWX200UR5.0014EA	5.000	2	2.500	1.500	7.6	.197	Y	14
WWX200UR6.0009EA	6.000	2	2.500	1.500	10.0	.197	N	9
WWX200UR6.0012EA	6.000	2	2.500	1.500	9.8	.197	N	12
WWX200UR6.0016EA	6.000	2	2.500	1.500	9.8	.197	N	16

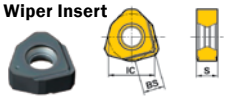
(1) z = No. of inserts

INSERTS FOR WWX

PART#	IC	S	S1	BS	RE
6NGU0906040PN□R-*	.354	.209	.240	.063	.016
6NGU0906080PN□R-*	.354	.209	.240	.047	.031
6NMU1409040PNER-*	.551	.276	.354	.067	.016
6NMU1409080PNER-*	.551	.276	.354	.051	.031
6NMU1409160PNER-*	.551	.276	.354	.002	.063
6NMU1409200PNER-*	.551	.276	.354	.002	.079

□ = E: FOR ALL METALS, F: FOR ALUMINUM
* = L: LIGHT CUT, M: MEDIUM CUT, R: ROUGH CUT

Wiper Insert



PART#	IC	S	BS
2NGU1406ZNER6C-M	.561	.248	.256

FREE CUTTER PROMO — SEE PAGES 2-4

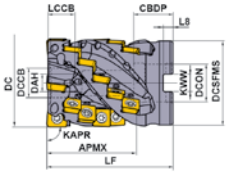
MITSUBISHI DIAEDGE

ASPX MILLING CUTTERS FOR MACHINING TITANIUM

DEEP SHOULDER MILLING

■ SHELL TYPE

90° KAPR



With Air/Coolant through: Shell type should be combined with a through coolant arbor.

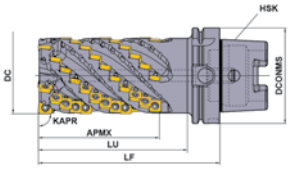
Inserts to be used:
Bottom: JPGX1404
Peripheral:SPGX1204

PART#	DC	DCON	APMX	KWW	LF	CBDP	DCSFMS	DAH	#FL	z*
ASPX4UR2.0003AA21A15	2.000	.750	2.126	.313	3.000	.748	1.750	.395	3	15
ASPX4UR2.5004CA25A24	2.500	1.000	2.520	.375	3.500	.945	2.375	.520	4	24
ASPX4UR3.0005DA29A35	3.000	1.250	2.953	.500	4.250	1.260	2.875	.645	5	35

*z = No. of inserts

■ HSK SHANK TYPE

With Air/Coolant through



The HSK shank type has a built-in movable coolant pipe for installation.

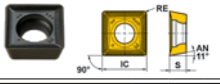
Inserts to be used:
Bottom: JPGX1404
Peripheral:SPGX1204

HSK	PART#	DC	LF	LU	DCONMS	APMX	#FL	z*
HSK-A100	ASPX4UR485H100A050SA	3.000	7.480	6.142	3.937	5.000	5	60
HSK-A125	ASPX4UR485H125A050SA	3.000	7.480	6.142	4.921	5.000	5	60

*z = No. of inserts

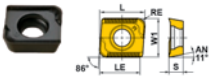
INSERTS

Peripheral 4 Corner



PART#	IC	S	RE
SPGX1204100PPER-JM	.500	.189	.039

Bottom 2 Corner



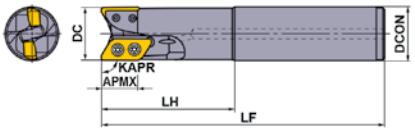
PART#	I	LE	W1	S	RE
JPGX-1404080PPER-JM	.595	.528	.500	.189	.031
JPGX-1404120PPER-JM	.593	.524	.500	.189	.047
JPGX-1404160PPER-JM	.591	.524	.500	.189	.063
JPGX-1404240PPER-JM	.586	.520	.500	.189	.094
JPGX-1404320PPER-JM	.580	.516	.500	.189	.126
JPGX-1404400PPER-JM	.576	.512	.500	.189	.157
JPGX-1404500PPER-JM	.570	.512	.500	.189	.197
JPGX-1404635PPER-JM	.563	.508	.500	.189	.250

Carbide grade: MP9140 for hi-temp and titanium

AXD4000 & AXD7000

FOR ALUMINUM & DIFFICULT TO CUT METALS

With Air/ coolant through



INDEXABLE END-MILLS

DC	Insert Corner Radius RE	PART#	z*	lf	lh	DCON	APMX	Insert
1.00	.016-.125	AXD4000UR162SA12SA	2	6.0	2.0	.75	.610	XDGX1750
1.00	.157-.197	AXD4000UR162SA12SB	2	6.0	2.0	.75	.583	
1.00	.016-.125	AXD4000UR162SA16SA	2	6.0	2.0	1.00	.610	
1.00	.157-.197	AXD4000UR162SA16SB	2	6.0	2.0	1.00	.583	
1.00	.016-.125	AXD4000UR162SA16LA	2	8.5	3.0	1.00	.610	
1.00	.157-.197	AXD4000UR162SA16LB	2	8.5	3.0	1.00	.583	
1.25	.016-.125	AXD4000UR202SA20SA	2	6.0	2.0	1.25	.610	
1.25	.157-.197	AXD4000UR202SA20SB	2	6.0	2.0	1.25	.583	
1.25	.016-.125	AXD4000UR202SA20LA	2	9.0	3.5	1.25	.610	
1.25	.157-.197	AXD4000UR202SA20LB	2	9.0	3.5	1.25	.583	
1.50	.016-.125	AXD4000UR243SA20SA	3	6.0	2.0	1.25	.610	
1.50	.157-.197	AXD4000UR243SA20SB	3	6.0	2.0	1.25	.583	
1.50	.016-.125	AXD4000UR243SA20LA	3	9.0	2.0	1.25	.610	
1.50	.157-.197	AXD4000UR243SA20LB	3	9.0	2.0	1.25	.583	
1.25	.031 - .125	AXD7000UR202SA20SA	2	6.0	2.0	1.25	.827	XDGX2270
1.25	.157 - .197	AXD7000UR202SA20SB	2	6.0	2.0	1.25	.803	
1.50	.031 - .125	AXD7000UR242SA24SA	2	7.0	3.0	1.50	.827	
1.50	.157 - .197	AXD7000UR242SA24SB	2	7.0	3.0	1.50	.803	

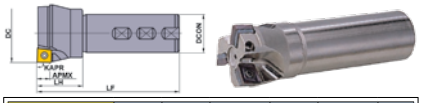
*z = No. of inserts

ASX GENERAL PURPOSE MILLING CUTTERS FOR ALL MATERIALS

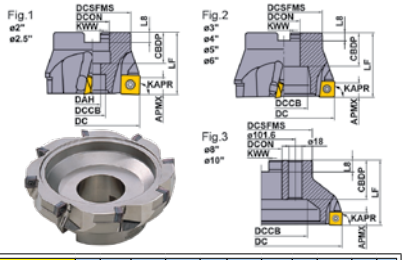
- STEEL • STAINLESS • HI-TEMP
- CAST IRON • ALUMINUM
- HARDENED STEEL

P M K N S H

ASX400 90° SHOULDER MILLING



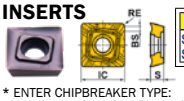
PART#	DC	LF	DCON	LH	APMX	z*
ASX400R202W20	1.250	4.750	1.250	1.500	.394	2
ASX400R243W20	1.500	4.750	1.250	1.500	.394	3
ASX400R324W20	2.000	4.750	1.250	1.575	.394	4



PART#	DC	LF	DCON	CDBP	DAH	DCCB	KWW	L8	APMX	Fig.	z(1)
ASX400R0203	2.0	1.575	.75	.748	.415	—	.313	.187	.394	1	3
ASX400R2504	2.5	1.575	.75	.748	.415	—	.313	.187	.394	1	4
ASX400R0304C	3.0	1.969	1.00	1.024	—	1.496	.375	.219	.394	2	4
ASX400R0405E	4.0	1.969	1.50	1.378	—	2.362	.625	.375	.394	2	5
ASX400R0506E	5.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	6
ASX400R0608E	6.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	8
ASX400R0810M	8.0	2.480	2.50	1.378	—	5.315	1.000	.560	.394	3	10
ASX400R1012M	10.0	2.480	2.50	1.378	—	7.087	1.000	.560	.394	3	12
ASX400R0204	2.0	1.575	.75	.748	.415	—	.313	.187	.394	1	4
ASX400R2505	2.5	1.575	.75	.748	.415	—	.313	.187	.394	1	5
ASX400R0306C	3.0	1.969	1.00	1.024	—	1.496	.375	.219	.394	2	6
ASX400R0407E	4.0	1.969	1.50	1.378	—	2.362	.625	.375	.394	2	7
ASX400R0508E	5.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	8
ASX400R0612E	6.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	12
ASX400R0816M	8.0	2.480	2.50	1.378	—	5.315	1.000	.560	.394	3	16
ASX400R1018M	10.0	2.480	2.50	1.378	—	7.087	1.000	.560	.394	3	18
ASX400R0205	2.0	1.575	.75	.748	.415	—	.313	.187	.394	1	5
ASX400R2506	2.5	1.575	.75	.748	.415	—	.313	.187	.394	1	6
ASX400R0308C	3.0	1.969	1.00	1.024	—	1.496	.375	.219	.394	2	8
ASX400R0410E	4.0	1.969	1.50	1.378	—	2.362	.625	.375	.394	2	10
ASX400R0512E	5.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	12
ASX400R0615E	6.0	2.480	1.50	1.378	—	2.362	.625	.375	.394	2	15
ASX400R0819M	8.0	2.480	2.50	1.378	—	5.315	1.000	.560	.394	3	19
ASX400R1022M	10.0	2.480	2.50	1.378	—	7.087	1.000	.560	.394	3	22

*z = No. of inserts

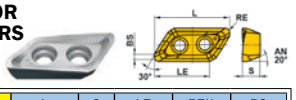
INSERTS



PART#	IC	S	BS	RE
SOET-12T308PEER-*	.500	.156	.055	.031
SOGT-12T308PEFR-JP(1)				

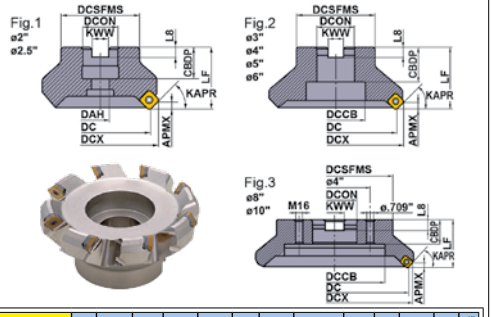
* ENTER CHIPBREAKER TYPE:
JL: FOR FINISH-LIGHT CUTTING, JM: FOR LIGHT-ROUGH CUTTING
JH: FOR MEDIUM CUTTING, FT: FOR HEAVY INTERRUPTED CUTTING
(1): FOR ALUMINUM
NOTE: WIPER INSERTS ARE AVAILABLE (WOEW12T308)

INSERTS FOR AXD CUTTERS



PART#	L	S	LE	RE**	BS
XDGX-1750**DF/ER-*	.764-.906	.197	.602-.665	.016-.197	.016-.067
XDGX-2270**DF/ER-*	1.063-1.181	.276	.799-.850	.031-.197	.016-.079

ASX445 45° FACE MILLING



PART#	DC	DCX	LF	DCON	CDBP	DAH	DCCB	DCSFMS	KWW	L8	APMX	Fig.	z(1)
ASX445R2504	2.5	3.009	1.575	.75	.748	.415	—	1.969	.313	.187	.236	1	4
ASX445R0304C	3.0	3.520	1.969	1.00	1.024	—	1.496	2.205	.375	.219	.236	2	4
ASX445R0405E	4.0	4.518	1.969	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	5
ASX445R0506E	5.0	5.513	2.480	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	6
ASX445R0607E	6.0	6.511	2.480	1.50	1.378	—	2.362	3.937	.625	.375	.236	2	7
ASX445R0808M	8.0	8.509	2.480	2.50	1.378	—	5.512	6.890	1.000	.560	.236	3	8
ASX445R1010M	10.0	10.508	2.480	2.50	1.378	—	7.087	8.661	1.000	.560	.236	3	10
ASX445R0204	2.0	2.513	1.575	.75	.748	.415	—	1.772	.313	.187	.236	1	4
ASX445R2505	2.5	3.009	1.575	.75	.748	.415	—	1.969	.313	.187	.236	1	5
ASX445R0306C	3.0	3.520	1.969	1.00	1.024	—	1.496	2.205	.375	.219	.236	2	6
ASX445R0407E	4.0	4.518	1.969	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	7
ASX445R0508E	5.0	5.513	2.480	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	8
ASX445R0610E	6.0	6.511	2.480	1.50	1.378	—	2.362	3.937	.625	.375	.236	2	10
ASX445R0812M	8.0	8.509	2.480	2.50	1.378	—	5.512	6.890	1.000	.560	.236	3	12
ASX445R1014M	10.0	10.508	2.480	2.50	1.378	—	7.087	8.661	1.000	.560	.236	3	14
ASX445R0205	2.0	2.513	1.575	.75	.748	.415	—	1.772	.313	.187	.236	1	5
ASX445R0308C	3.0	3.520	1.969	1.00	1.024	—	1.496	2.205	.375	.219	.236	2	8
ASX445R0410E	4.0	4.518	1.969	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	10
ASX445R0512E	5.0	5.513	2.480	1.50	1.378	—	2.362	3.150	.625	.375	.236	2	12
ASX445R0616E	6.0	6.511	2.480	1.50	1.378	—	2.362	3.937	.625	.375	.236	2	16
ASX445R0820M	8.0	8.509	2.480	2.50	1.378	—	5.512	6.890	1.000	.560	.236	3	20
ASX445R1024M	10.0	10.508	2.480	2.50	1.378	—	7.087	8.661	1.000	.560	.236	3	24

*z = No. of inserts

INSERTS

PART#	IC	S	BS	RE
SEET-13T3AGEN-JL*	.528	.156	.075	.059
SEMT-13T3AGSN-JM*				
SEMT-13T3AGSN-JH*				
SEMT-13T3AGSN-FT*				
SEGT-13T3AGFN-JP(1)	.528	.156	.087	-

* CHIPBREAKER DESIGNATION:
JL: FOR FINISH-LIGHT CUTTING, JM: FOR LIGHT-ROUGH CUTTING
JH: FOR MEDIUM-HEAVY CUTTING, FT: FOR HEAVY INTERRUPTED CUTTING
(1): FOR ALUMINUM
NOTE: WIPER INSERTS ARE AVAILABLE (WEEW13 & NP-WEEW13)
CARBIDE GRADES SHOWN BELOW

CARBIDE GRADES

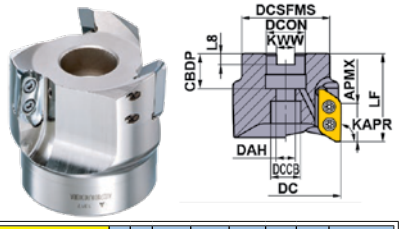
		F7010	F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545	NX2525	HTi10	HTi10ST
		Coated											Cermet		Carbide	
P	Steels	●	◐			◐	✱					◐	✱	◐	✱	●	●
M	Stainless Steels	◐	◐					◐	✱			◐	✱	◐	○		
K	Cast Ions				◐							✱			●		◐
N	Non-Ferrous Materials															◐	◐
S	Heat Resistant Alloys, Titanium Alloys									◐	✱	◐					
H	Hardened Steels											◐					

Cutting Conditions (Guide):
●: Stable Cutting
◐: General Cutting
✱: Unstable Cutting

*CHIPBREAKER: GL= LOW CUTTING RESISTANCE, GM = STRONG CUTTING EDGE, GLA= DESIGNED WITH ALMOST THE SAME CORNER R AS THAT OF THE WORKPIECE

** RE (CORNER RADIUS): 04= .016, 08= .031, 12= .047, 16= .063, 20= .079, 24= .094, 30= .118, 32= .125, 40= .157, 50= .197

ARBOR MOUNTED MILLING CUTTERS



SERIES	DC	RE*	PART#	z*	lf	DCON	APMX	CDBP	KWS	DAH	Insert
AXD4000	1.5	.016-.125	AXD4000UR1502A	2	2.0	.50	610	.630	.250	.276	XDGX1750
	1.5	.016-.125	AXD4000UR1503A	3	2.0	.50	.610				
	1.5	.157-.197	AXD4000UR1503B	3	2.0	.50	.583				
	2.0	.016-.125	AXD4000UR0202A	2	2.0	.75	.610	.748	.313	.413	
	2.0	.016-.125	AXD4000UR0203A	3	2.0	.75	.610				
	2.0	.157-.197	AXD4000UR0203B	3	2.0	.75	.583				
	2.0	.016-.125	AXD4000UR0204A	4	2.0	.75	.610				
	2.0	.157-.197	AXD4000UR0204B	4	2.0	.75	.583				
	2.5	.016-.125	AXD4000UR2504CA	4	2.0	1.00	.610	.984	.375	.539	
	3.0	.016-.125	AXD4000UR0303CA	3	2.0	1.00	.610	.945	.375		
	3.0	.157-.197	AXD4000UR0303CB	3	2.0	1.00	.583				
	3.0	.016-.125	AXD4000UR0305CA	5	2.0	1.00	.610				
	3.0	.157-.197	AXD4000UR0305CB	5	2.0	1.00	.583				
	3.0	.016-.125	AXD4000UR0303DA	3	2.5	1.25	.610	1.26	.500	.669	
	3.0	.016-.125	AXD4000UR0305DA	5	2.5	1.25	.610				
	3.0	.157-.197	AXD4000UR0305DB	5	2.5	1.25	.583				
	4.0	.016-.125	AXD4000UR0404EA	4	2.5	1.50	.610	1.575	.625	.787	
	4.0	.016-.125	AXD4000UR0406EA	6	2.5	1.50	.610				
	5.0	.016-.125	AXD4000UR0505EA	5	2.5	1.50	.610			-	
	5.0	.016-.125	AXD4000UR0507EA	7	2.5	1.50	.610				
AXD7000	2.000	.031-.125	AXD7000UR0203A	3	2.0	.75	.827	.748	.313	.415	XGDX2270
	2.000	.157-.197	AXD7000UR0203B	3	2.0	.75	.803				
	3.000	.031-.125	AXD7000UR0303DA	3	2.5	1.25	.827	1.260	.500	.669	
	3.000	.157-.197	AXD7000UR0303DB	3	2.5	1.25	.803				
	4.000	.031-.125	AXD7000UR0405EA	5	2.5	1.50	.827	1.181	.625	.787	
	5.000	.031-.125	AXD7000UR0506EA	6	2.5	1.50	.827	1.575	.625	2.205	
AXD4000A - CUTTERS WITH COOLANT HOLES											
	2.000	.016-.126	AXD4000AUR2.0004AAD	4	2.0	.75	.610	.748	.313	.413	XDGX1750
	2.000	.157-.197	AXD4000AUR2.0004AAE	4	2.0	.75	.583	.748	.313	.413	

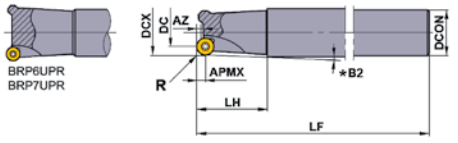
*z = No. of inserts RE = Insert's corner radius

MITSUBISHI DIAEDGE

BRP MULTI-FUNCTIONAL MILLING WITH ROUND INSERTS

BRP INDEXABLE END-MILLS

Fig.1



*Please allow for an inclination angle of B2+1°

Fig.2

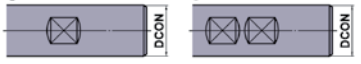
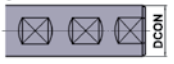


Fig.3

Fig.4



P M K N S H

*	PART#	DCX	DC	LF	DCON	LH	APMX	Fig.	Insert/R	z(1)
R	BRP3UNR081W08	.500	.177	2.781	.500	1.000	.146	2	RPMW07T200E RPMT07T200E-JS R = .156	1
	BRP3UNR101W10	.625	.303	3.500	.625	1.000	.146	3		1
	BRP3UNR122W12	.750	.429	4.000	.750	1.250	.146	3		2
	BRP3UNR163W16	1.000	.681	4.500	1.000	1.250	.146	4		3
L	BRP3UNR081LW08	.500	.177	6.000	.500	2.800	.146	1		1
	BRP3UNR101LW10	.625	.303	6.000	.625	2.800	.146	1		1
EL	BRP3UNR122ELW12	.750	.429	10.000	.750	5.100	.146	1		2
	BRP3UNR163ELW16	1.000	.681	10.000	1.000	5.100	.146	1		3
R	BRP4UNR101W10	.625	.244	3.500	.625	1.000	.177	3	RPMW09T300E RPMT09T300E-JS R=.187	1
	BRP4UNR121W12	.750	.366	4.000	.750	1.250	.177	3		1
	BRP4UNR162W16	1.000	.618	4.500	1.000	1.250	.177	4		2
	BRP4UNR203W20	1.250	.866	5.000	1.250	1.750	.177	4		3
L	BRP4UNR101LW10	.625	.244	6.000	.625	2.800	.177	1		1
	BRP4UNR121LW12	.750	.366	7.000	.750	3.900	.177	1		1
EL	BRP4UNR162ELW16	1.000	.618	10.000	1.000	5.100	.177	1		2
	BRP4UNR203ELW20	1.250	.866	12.000	1.250	7.100	.177	1		3
R	BRP6UPR202W20	1.250	.744	5.000	1.250	1.750	.240	4	RPMW120400E RPMT120400E-JS R = .250	2
	BRP6UPR243W20	1.500	.976	5.000	1.250	1.750	.240	4		3
	BRP6UPR324W20	2.000	1.492	5.000	1.250	1.750	.240	4		4
	BRP6UPR405W20	2.500	1.999	5.000	1.250	1.750	.240	4		5
EL	BRP6UPR202ELS20	1.250	.744	12.000	1.250	1.750	.240	1		2
	BRP6UPR243ELS20	1.500	.996	12.000	1.250	1.750	.240	1		3
	BRP6UPR324ELS20	2.000	1.492	12.000	1.250	1.750	.240	1		4
R	BRP7UPR323W20	2.000	1.370	5.000	1.250	1.750	.302	4	RPMW150600E RPMT150600E-JS R = .312	3
	BRP7UPR404W20	2.500	1.866	5.000	1.250	1.750	.302	4		4
EL	BRP7UPR323ELS20	2.000	1.370	12.000	1.250	1.750	.302	1		3

*R : Standard shank, L : Long shank, EL : Extra Long shank
(1) z = No. of inserts

BRP MILLING CUTTERS

Fig.1 ø1.5"

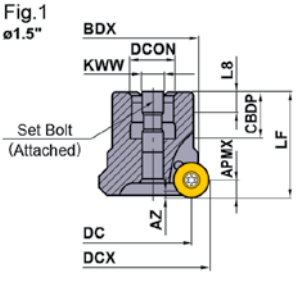
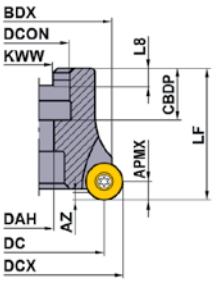
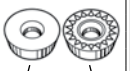


Fig.2 ø2" ø2.5" ø3" ø4"





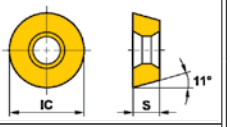
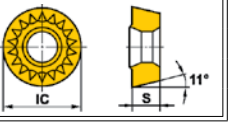
RPMW RPMT

PART#	DCX	DC	BDX	LF	DCON	CBDP	DAH	KWW	LB	Max. Depth of Cut AZ	Max. Depth of Cut APMX	Fig.	Insert/R	z(1)
BRP6UPR1503X	1.500	.996	1.228	2.000	.750	.748	—	.313	.187	.157	.240	1	RPMW120400E RPMT120400E-JS R = .250	3
BRP6UPR0204	2.000	1.492	1.715	2.000	.750	.748	.415	.313	.187	.157	.240	2		4
BRP6UPR2505	2.500	1.992	2.214	2.000	.750	.748	.415	.313	.187	.157	.240	2		5
BRP6UPR0306C	3.000	2.492	2.706	2.000	1.000	1.024	.539	.375	.219	.157	.240	2		6
BRP6UPR0407E	4.000	3.492	3.696	2.500	1.500	1.181	.787	.625	.375	.157	.240	2		7
BRP7UPR2504	2.500	1.866	2.165	2.000	.750	.748	.415	.313	.187	.217	.302	2	RPMW150600E RPMT150600E-JS R = .312	4
BRP7UPR0305C	3.000	2.366	2.649	2.000	1.000	.969	.539	.375	.219	.217	.302	2		5
BRP7UPR0406E	4.000	3.366	3.631	2.500	1.500	1.122	.787	.625	.375	.217	.302	2		6

INSERTS

Workpiece Material					
	P	Steel	●	◐	
	M	Stainless Steels	◐	◐	
	K	Cast Irons		✤	
	S	Heat Resistant Alloys, Titanium Alloys		◐	
	H	Hardened Steels		◐	

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting ✤: Unstable Cutting

Shape	Part	Class	Coated F7010	Coated VP15TF			Dimensions (inch) IC	Dimensions (inch) S	Geometry
	RPMW-120400E	M	●	●			.500	.188	
	RPMW-150600E	M		●			.625	.250	
	RPMT-07T200E-JS	M		●			.313	.109	
	RPMT-09T300E-JS	M		●			.375	.156	
	RPMT-120400E-JS	M		●			.500	.188	
	RPMT-150600E-JS	M		●			.625	.250	

MITSUBISHI DIAEDGE

WSX 45° FACE MILLING CUTTERS

WSX 445 ARBOR MOUNTED FACE MILLS

Fig.1 ø1.5" ø2" ø2.5" ø3"

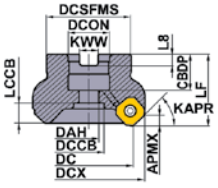
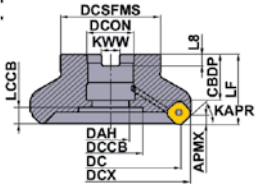


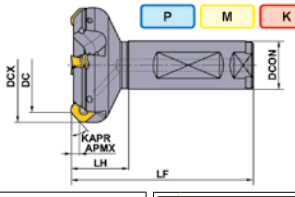
Fig.2 ø4" ø5" ø6"



WSX 445

45° KAPR

P M K N S H

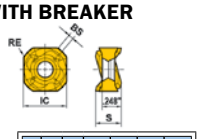


WITH COOLANT HOLES

Pitch	PART#	DC	DCX	LF	DCON	WT (lbs)	APMX	Fig.	Coolant Thru	z(1)	Insert
Coarse	WSX445UR1503SA	1.500	2.005	1.750	.500	.8	.197	1	Y	3	SNGU-1408 SNMU-1408 WNGU1406*
Fine	WSX445UR1504SA	1.500	2.005	1.750	.500	.7	.197	1	Y	4	
Coarse	WSX445UR0203AA	2.000	2.506	1.750	.750	1.2	.197	1	Y	3	
Fine	WSX445UR0204AA	2.000	2.506	1.750	.750	1.1	.197	1	Y	4	
Extra Fine	WSX445UR0205AA	2.000	2.506	1.750	.750	1.1	.197	1	Y	5	
Coarse	WSX445UR2504CA	2.500	3.006	2.000	1.000	2.0	.197	1	Y	4	
Fine	WSX445UR2505CA	2.500	3.006	2.000	1.000	2.0	.197	1	Y	5	
Extra Fine	WSX445UR2506CA	2.500	3.006	2.000	1.000	1.9	.197	1	Y	6	
Coarse	WSX445UR0304CA	3.000	3.506	2.000	1.000	2.6	.197	1	Y	4	
Fine	WSX445UR0306CA	3.000	3.506	2.000	1.000	2.5	.197	1	Y	6	
Extra Fine	WSX445UR0308CA	3.000	3.506	2.000	1.000	2.4	.197	1	Y	8	
Coarse	WSX445UR0405EA	4.000	4.506	2.500	1.500	5.9	.197	2	Y	5	
Fine	WSX445UR0407EA	4.000	4.506	2.500	1.500	5.8	.197	2	Y	7	
Extra Fine	WSX445UR0410EA	4.000	4.506	2.500	1.500	5.6	.197	2	Y	10	
Coarse	WSX445UR0506EA	5.000	5.506	2.500	1.500	8.5	.197	2	Y	6	
Fine	WSX445UR0508EA	5.000	5.506	2.500	1.500	8.3	.197	2	Y	8	
Extra Fine	WSX445UR0512EA	5.000	5.506	2.500	1.500	8.0	.197	2	Y	12	
Coarse	WSX445UR0607EA	6.000	6.506	2.500	1.500	10.6	.197	2	Y	7	
Fine	WSX445UR0610EA	6.000	6.506	2.500	1.500	10.4	.197	2	Y	10	
Extra Fine	WSX445UR0616EA	6.000	6.506	2.500	1.500	9.9	.197	2	Y	16	
Coarse	WSX445UR0808MN	8.000	8.506	2.500	2.500	19.1	.197	3	N	8	
Fine	WSX445UR0812MN	8.000	8.506	2.500	2.500	18.8	.197	3	N	12	
Extra Fine	WSX445UR0820MN	8.000	8.506	2.500	2.500	18.3	.197	3	N	20	
Coarse	WSX445UR1010MN	10.000	10.493	2.500	2.500	28.5	.197	3	N	10	
Fine	WSX445UR1014MN	10.000	10.493	2.500	2.500	29.2	.197	3	N	14	
Coarse	WSX445UR1214MN	12.000	12.493	2.500	2.500	48.1	.197	4	N	14	

(1) z = No. of inserts * WNGU1406 is a wiper insert

INSERTS WITH BREAKER



PART#	Class	Hand	Edge Prep.	IC	S	BS	RE
SNGU-140812ANFR-L	G	R	F	.551	.331	.059	.047
SNGU-140812ANER-L	G	R	E	.551	.331	.059	.047
SNGU-140812ANER-M	G	R	E	.551	.331	.059	.047
SNMU-140812ANER-M	M	R	E	.551	.331	.059	.047
SNMU-140812ANER-R	M	R	E	.551	.331	.059	.047
SNMU-140812ANER-H	M	R	E	.551	.331	.059	.047
SNGU-140812ANFL-L	G	L	F	.551	.331	.059	.047
SNGU-140812ANEL-L	G	L	E	.551	.331	.059	.047
SNGU-140812ANEL-M	G	L	E	.551	.331	.059	.047
SNMU-140812ANEL-M	M	L	E	.551	.331	.059	.047
SNMU-140812ANEL-R	M	L	E	.551	.331	.059	.047

Excellent surface finish can be achieved with one wiper. Set more than 2 wiper inserts, equally spaced, when the feed per revolution is larger than .315 IPR.

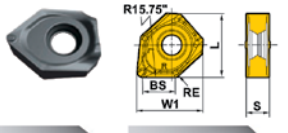
	PART	DC	DCX	LF	DCON	LH	APMX	z(1)	Insert
Coarse Pitch	WSX445UR2403FA20M	1.500	2.005	4.750	1.250	1.500	.197	3	SNGU1408 SNMU1408 WNGU1406*
	WSX445UR3203FA20M	2.000	2.506	4.750	1.250	1.500	.197	3	
	WSX445UR4004FA20M	2.500	3.006	4.750	1.250	1.500	.197	4	
	WSX445UR4804FA20M	3.000	3.506	4.750	1.250	1.500	.197	4	
Fine Pitch	WSX445UR2404FA20M	1.500	2.005	4.750	1.250	1.500	.197	4	
	WSX445UR3204FA20M	2.000	2.506	4.750	1.250	1.500	.197	4	
	WSX445UR4005FA20M	2.500	3.006	4.750	1.250	1.500	.197	5	
	WSX445UR4806FA20M	3.000	3.506	4.750	1.250	1.500	.197	6	

(1) z = No. of inserts * WNGU1406 is a wiper insert

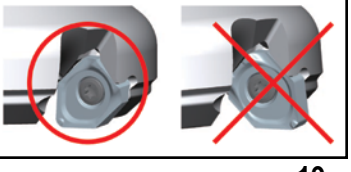
WIPER INSERTS

WNGU1406ANEN8C-M

L	W1	S	BS	RE
.664	.664	.236	.315	.039



■ Instructions for Use of Wiper Inserts

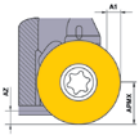


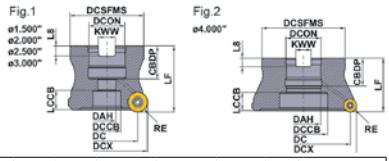
BASS TOOL & SUPPLY, INC.
2300 Fairway Park Dr.
Houston, TX 77092

MITSUBISHI DIAEDGE

ARP MILLING CUTTERS FOR DIFFICULT-TO-CUT MATERIALS

MULTI-FUNCTIONAL MILLING

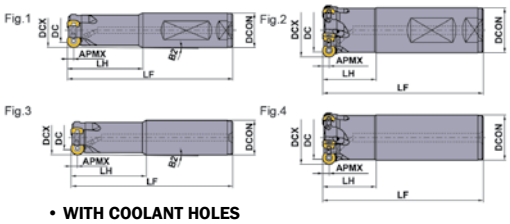




• **WITH COOLANT HOLES**

DCX	PART#	RE	Z(1)	Pitch	DC	LF	DCON	Max. Depth of Cut A1	Max. Depth of Cut AZ	RPMX	Fig.	Insert Type
1.500	ARP5UPR1504SA	.197	4	Fine	1.104	1.500	.500	.079	.047	2.8°	1	RP□T1040
1.500	ARP5UPR1505SA	.197	5	Extra Fine	1.104	1.500	.500	.079	.047	2.8°	1	RP□T1040
1.500	ARP6UPR1504SA	.236	4	Fine	1.026	1.500	.500	.079	.041	2.7°	1	RP□T1248
2.000	ARP5UPR0206AA	.197	6	Fine	1.604	1.750	.750	.079	.073	2.9°	1	RP□T1040
2.000	ARP5UPR0207AA	.197	7	Extra Fine	1.604	1.750	.750	.079	.073	2.9°	1	RP□T1040
2.000	ARP6UPR0205AA	.236	5	Fine	1.526	1.750	.750	.079	.067	2.8°	1	RP□T1248
2.000	ARP6UPR0206AA	.236	6	Extra Fine	1.526	1.750	.750	.079	.067	2.8°	1	RP□T1248
2.500	ARP5UPR2507CA	.197	7	Fine	2.104	2.000	1.000	.098	.098	2.9°	1	RP□T1040
2.500	ARP5UPR2508CA	.197	8	Extra Fine	2.104	2.000	1.000	.098	.098	2.9°	1	RP□T1040
2.500	ARP6UPR2506CA	.236	6	Fine	2.026	2.000	1.000	.098	.098	3.1°	1	RP□T1248
2.500	ARP6UPR2507CA	.236	7	Extra Fine	2.026	2.000	1.000	.098	.098	3.1°	1	RP□T1248
3.000	ARP6UPR0308CA	.236	8	Fine	2.526	2.000	1.000	.098	.098	2.4°	1	RP□T1248
3.000	ARP6UPR0309CA	.236	9	Extra Fine	2.526	2.000	1.000	.098	.098	2.4°	1	RP□T1248
4.000	ARP6UPR0409EA	.236	9	Fine	3.526	2.500	1.500	.098	.098	1.7°	2	RP□T1248
4.000	ARP6UPR0411EA	.236	11	Extra Fine	3.526	2.500	1.500	.098	.098	1.7°	2	RP□T1248

(1) Z = No. of inserts

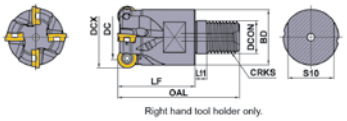


■ **Shank Type**
KAPR:R
GAMP : +4° GAMF : -6°
DCON=inch size

• **WITH COOLANT HOLES**

DCX	PART#	RE	Z(1)	DC	LF	LF	DCON	B2	Max. Depth of Cut A1	Max. Depth of Cut AZ	RPMX	Fig.	Insert Type
1.000	ARP5UPR1603FA16M	.197	3	.608	5.500	2.250	1.000	1.170°	.039	.018	1.9°	1	RP□T1040
1.000	ARP5UPR1602SA16L	.197	2	.608	7.000	3.000	1.000	.570°	.039	.018	1.9°	3	RP□T1040
1.250	ARP5UPR2004FA20M	.197	4	.858	6.000	2.750	1.250	.760°	.039	.026	1.9°	1	RP□T1040
1.250	ARP5UPR2003SA20L	.197	3	.858	8.000	4.750	1.250	1.010°	.039	.026	1.9°	3	RP□T1040
1.250	ARP6UPR2003FA20M	.236	3	.781	6.000	2.750	1.250	.950°	.039	.024	2.0°	1	RP□T1248
1.250	ARP6UPR2002SA20L	.236	2	.781	8.000	4.750	1.250	.510°	.039	.024	2.0°	3	RP□T1248
1.500	ARP6UPR2404FA20M	.236	4	1.028	6.000	2.000	1.250	-	.098	.041	2.7°	2	RP□T1248
1.500	ARP6UPR2403SA20L	.236	3	1.028	10.000	2.000	1.250	-	.098	.041	2.7°	4	RP□T1248
2.000	ARP6UPR3205FA24M	.236	5	1.528	6.000	2.000	1.500	-	.098	.067	2.8°	2	RP□T1248
2.000	ARP6UPR3204SA24L	.236	4	1.528	10.000	2.000	1.500	-	.098	.067	2.8°	4	RP□T1248

(1) Z = No. of inserts



Right hand tool holder only.

■ **Screw-in Type**
KAPR:R
GAMP : +4° GAMF : -6°–7°
With Coolant Hole

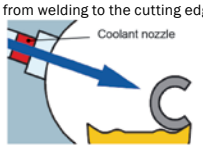
• **WITH COOLANT HOLES**

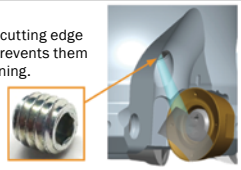
DCX	PART#	RE	Z(1)	DC	DCON	DCSFMS	OAL	LF	S10	CRKS	Max. Depth of Cut A1	Max. Depth of Cut AZ	RPMX	Insert Type
1.000	ARP5UPR1603AM1235	.197	3	.606	.492	.925	2.244	1.378	.748	M12	—	.016	1.9°	RP□T1040
1.250	ARP5UPR2004AM1640	.197	4	.856	.669	1.122	2.480	1.575	.945	M16	.039	.026	1.9°	RP□T1040
1.250	ARP6UPR2003AM1640	.236	3	.778	.669	1.122	2.480	1.575	.945	M16	.039	.024	2.0°	RP□T1248
1.500	ARP6UPR2404AM1640	.236	4	1.028	.669	1.122	2.480	1.575	.945	M16	.098	.045	2.7°	RP□T1248

(1) Z = No. of inserts

Improved Chip Removal with Coolant

The internal coolant is directed slightly above the rake face of the cutting edge so that it is aimed directly at the chip. Forcibly ejecting the chips prevents them from welding to the cutting edge, enabling higher efficiency machining.



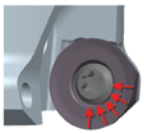


Use of the coolant nozzle discharges chips under high pressure and prevents welding of chips to the cutting edge.

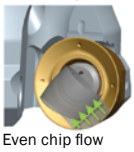
Choose 4 or 8 Indexing Faces According to the Depth of Cut

8 seating face inserts are economical for small depth of cut machining.

When the cutting depth is medium or higher, the rake face is in the same direction as the chip flow, achieving low cutting resistance.
(4 indexing face insert)



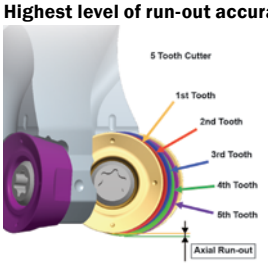
Rake design of 8 indexing face insert



Even chip flow

Rake design of 4 indexing face insert

Highest level of run-out accuracy increases tool life.



Highly accurate seating provides minimal change of run-out accuracy when indexing the inserts.

Compared to Conventional Tools

Axial Run-out 25% Improvement

CARBIDE GRADE SELECTION

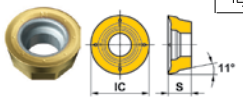
		MC7020	MP7130	MP9130	MP9140
M	Stainless Steels	●	●		
S	Heat Resistant Alloys, Titanium Alloys			✤	

Coated

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting
✤: Unstable Cutting

Edge Preparation (Honing):
E: Round

INSERTS



PART#	Type	IC	S	APMX 4 Seats	APMX 6 Seats
RPHT-1040M0E4-L	Low Resistance, High Precision	.394	.156	.197	–
RPMT-1040M0E4-L	Low Resistance	.394	.156	.197	–
RPMT-1040M0E8-L1	Low Resistance, 8 Seats	.394	.156	.197	.055
RPMT-1040M0E4-L2	Low Resistance, High Rigidity	.394	.156	.197	–
RPHT-1040M0E4-M	General, High Precision	.394	.156	.197	–
RPMT-1040M0E4-M	General Purpose	.394	.156	.197	–
RPMT-1040M0E8-M1	General, 8 Seats	.394	.156	.197	.055
RPMT-1040M0E4-M2	General, High Rigidity	.394	.156	.197	–
RPHT-1040M0E4-R	Reinforced Edge, High Precision	.394	.156	.197	–
RPMT-1040M0E4-R	Reinforced Edge	.394	.156	.197	–
RPMT-1040M0E8-R1	Reinforced Edge, 8 Seats	.394	.156	.197	.055
RPHT-1248M0E4-L	Low Resistance, High Precision	.472	.187	.236	–
RPMT-1248M0E4-L	Low Resistance	.472	.187	.236	–
RPMT-1248M0E8-L1	Low Resistance, 8 Seats	.472	.187	.236	.067
RPMT-1248M0E4-L2	Low Resistance, High Rigidity	.472	.187	.236	–
RPHT-1248M0E4-M	General, High Precision	.472	.187	.236	–
RPMT-1248M0E4-M	General Purpose	.472	.187	.236	–
RPMT-1248M0E8-M1	General, 8 Seats	.472	.187	.236	.067
RPMT-1248M0E4-M2	General, High Rigidity	.472	.187	.236	–
RPHT-1248M0E4-R	Reinforced Edge, High Precision	.472	.187	.236	–
RPMT-1248M0E4-R	Reinforced Edge	.472	.187	.236	–
RPMT-1248M0E8-R1	Reinforced Edge, 8 Seats	.472	.187	.236	.067