

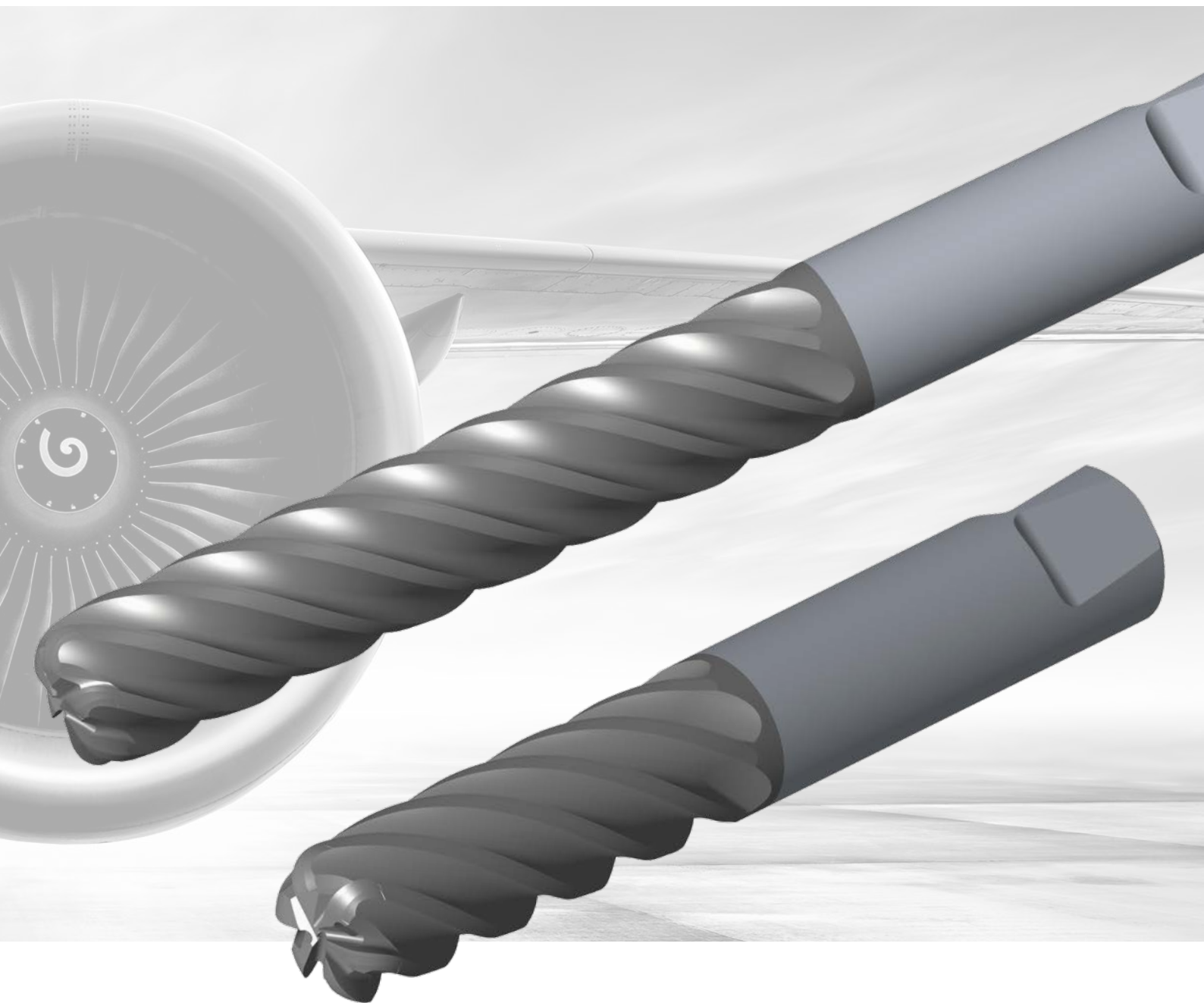
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# VQ 6 FLUTE END MILLS

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DYNAMIC MILLING

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# VQ6

## 6 FLUTE END MILLS

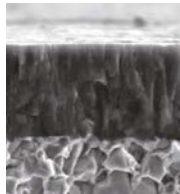


### INTERNAL COOLANT HOLES

- For improved performance with faster chip evacuation when pocket machining

### OPTIMIZED GEOMETRY

- Designed for dynamic milling
- Special cutting edge preparation for stable machining of titanium and Inconel
- APMX: up to 5xDC



### COATING TECHNOLOGY

- Smooth surface technology "Zero- $\mu$  Surface"
- Newly developed (Al,Cr)N group coating
- Super-fine particle, super-hard substrate material

### X-TREME SHANK

- Optimized to fit the NIKKEN X-TREME chuck anti pull-out system

## APPLICATION EXAMPLE

**Ti17 pocket machining with dynamic tool path**



**Finished pocket, wall and corner**



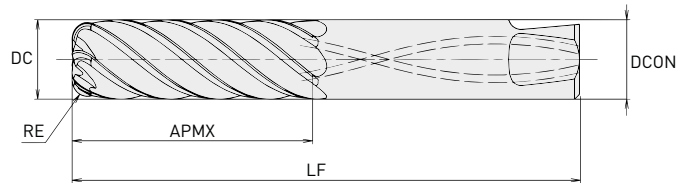
Tool	VQ6D25R6-SH35-S70535
Vc (m/min)	80
fz (mm/tooth)	0.08
ap (mm)	max. 75
ae (mm)	2.5

Tool	VQ6D25R6-SH35-S70535
Vc (m/min)	60
fz (mm/tooth)	0.08
ap (mm)	max. 75
ae (mm)	0.3

# VQ6

M

S



Order Number	DC	RE	APMX	LF	DCON	Flutes
VQ6D25R4-SH20-S70528	25	4	50	140	25	6
VQ6D25R4-SH30-S70530	25	4	75	160	25	6
VQ6D25R4-SH50-S70531	25	4	125	210	25	6
VQ6D25R6-SH25-S70533	25	6	62.5	160	25	6
VQ6D25R6-SH35-S70535	25	6	87.5	175	25	6
VQ6D25R6-SH50-S70536	25	6	125	210	25	6

Note: Inventory maintained in France

## RECOMMENDED CUTTING CONDITIONS

	M				S												
	Material	15-5PH				Ti6V				Ti17				Inconel718			
		APMX	Vc (m/min)	fz (mm/tooth)	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/tooth)	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/tooth)	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/tooth)	ae (mm)
ROUGHING	50			10	50			10	50			7.5	50			5	50
	62.5	90	0.08	5	62.5	50	0.08	5	62.5	50	0.08	5	62.5	30	0.06	3.5	62.5
	75	-	-	2.5	75	-	-	2.5	75	-	-	2.5	75	-	-	2.5	75
	87.5	130	0.12	2.5	50	80	0.12	2.5	50	80	0.12	2.5	50	40	0.08	2.5	50
	125			2.5	50			2.5	50			2.5	50			2.5	50
FINISHING	50																
	62.5	150	0.06			60	0.06			60	0.06			30	0.04		
	75	-	-	≥ 0.5	≥ APMX	-	-	≥ 0.5	≥ APMX	-	-	≥ 0.5	≥ APMX	-	-	≥ 0.5	≥ APMX
	87.5	200	0.08			150	0.08			120	0.08			50	0.06		
	125																

1. For larger widths of cut (ae), a lower cutting speed (Vc) is recommended.

**FRANCE**

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