

MICRO 100[®]

super carbide

the V-HEMOTH CARBIDE END-MILLS *Metric*

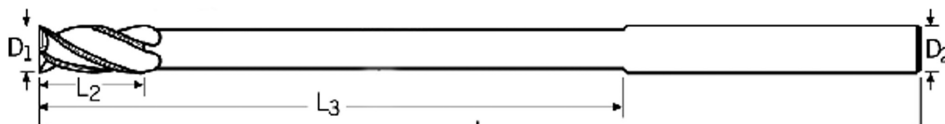


- Variable pitch
- High production / high speed milling
- Excellent surface finishes
- Eliminates chatter
- Reduces machine vibration
- Corner radius as standard
- All tools 10 mm and up have Weldon flats.

METRIC END MILLS | AITiN Coated

PART NUMBER	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	FLUTE LENGTH	CORNER RADIUS
VHMM-030-4X	3	4	50	8	0.5
VHMM-040-4X	4	4	50	11	0.5
VHMM-050-4X	5	6	57	16	0.5
VHMM-060-4X	6	6	57	16	0.5
VHMM-080-4X	8	8	63	19	0.5
VHMM-100-4X	10	10	72	22	0.6
VHMM-120-4X	12	12	83	26	0.6
VHMM-140-4X	14	14	83	26	0.7
VHMM-160-4X	16	16	92	32	0.7
VHMM-180-4X	18	18	92	32	0.7
VHMM-200-4X	20	20	104	38	0.8
VHMM-250-4X	25	25	127	38	0.8

Reduced neck diameter .5mm on all sizes



METRIC EXTRA-LONG LENGTH END MILLS | AITiN Coated

PART NUMBER	CUTTER DIAMETER D1	SHANK DIAMETER D2	OVERALL LENGTH L1	FLUTE LENGTH L2	REDUCED NECK L3	CORNER RADIUS
VLRM-040-4X	4	6	57	5	15	0.5
VLRM-050-4X	5	6	75	8	30	0.5
VLRM-060-4X	6	6	75	8	30	0.5
VLRM-080-4X	8	8	100	10	50	0.5
VLRM-100-4X	10	10	100	12	50	0.6
VLRM-120-4X	12	12	100	14	50	0.6
VLRM-140-4X	14	14	120	18	65	0.7
VLRM-160-4X	16	16	130	22	80	0.7
VLRM-200-4X	20	20	150	30	100	08
VLRM-250-4X	25	25	150	38	110	0.8

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METRIC BALL NOSE END MILLS | AITiN Coated

PART NUMBER	CUTTER DIA.	SHANK DIA.	OVERALL LENGTH	FLUTE LENGTH
VHBM-030-4X	3	4	50	8
VHBM-040-4X	4	4	50	11
VHBM-050-4X	5	6	57	16
VHBM-060-4X	6	6	57	16
VHBM-080-4X	8	8	63	19
VHBM-100-4X	10	10	72	22
VHBM-120-4X	12	12	83	26
VHBM-140-4X	14	14	83	26
VHBM-160-4X	16	16	92	32
VHBM-180-4X	18	18	92	32
VHBM-200-4X	20	20	104	38
VHBM-250-4X	25	25	127	38

METRIC BALL NOSE, LONG REACH END MILLS | AITiN Coated

PART NUMBER	CUTTER DIA.	SHANK DIA.	OVERALL LENGTH	FLUTE LENGTH	REDUCED NECK
VLBM-040-4X	4	6	57	5	15
VLBM-050-4X	5	6	75	8	30
VLBM-060-4X	6	6	75	8	30
VLBM-080-4X	8	8	100	10	50
VLBM-100-4X	10	10	100	12	50
VLBM-120-4X	12	12	100	14	50
VLBM-140-4X	14	14	120	18	35
VLBM-160-4X	16	16	130	22	80
VLBM-200-4X	20	20	150	30	100
VLBM-250-4X	25	25	150	38	110

SPEED & FEED SUGGESTED STARTING POINTS To achieve optimum results, variations may be necessary.

MATERIAL	TYPE OF CUT	SPEED (m/min)	FEED (mm per tooth)			
			6.0	12.0	16.0	20.0
Steel, Low Carbon	Slotting	90 - 110	.405	.081	.102	.132
	Roughing	120 - 135	.051	.102	.127	.163
Steel, Alloy	Slotting	90 - 100	.031	.066	.087	.112
	Roughing	95 - 110	.041	.087	.112	.142
Stainless Steel, Soft	Slotting	88 - 92	.031	.064	.079	.115
	Roughing	110 - 115	.041	.081	.102	.138
Stainless Steel, Hard	Slotting	80	.023	.046	.056	.076
	Roughing	95	.028	.056	.071	.107
Titanium Alloys	Slotting	75	.026	.051	.064	.082
	Roughing	82 - 90	.031	.059	.074	.091
High Temp Alloys	Slotting	20 - 25	.020	.031	.048	.070
	Roughing	28 - 32	.023	.036	.056	.079

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