

Tungaloy

Member IMC Group

Tungaloy Report No. 381-E

MILLLINE Indexable endmills

TUNGMEISTER



New endmilling innovation!!



The most effective tooling solution with the option of hundreds of tools!
Tool changeover times can be measurably reduced!

Features

► **Reduces tool changeover times drastically!!**

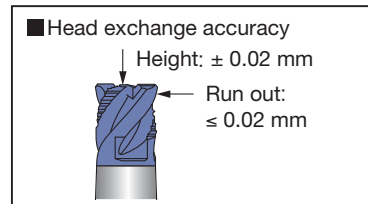
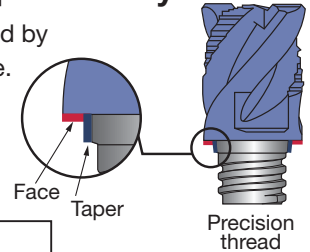
- Machine downtime is decreased considerably.
- Enables users to only change cutting head, simplifying set-ups.

Increases productivity by 90%



► **Highly accurate repeatability**

- Accuracy can be maintained by touching the taper and face.
- Repeatability is guaranteed and is not a concern for machine operators.



► **The weight of the tool to be disposed is reduced**

- Reduces tool disposal

For example: $\varnothing 12$ mm / square endmill

TUNGMEISTER: OAL 20 mm → weight 20 g
conventional solid endmill: OAL 80 mm → weight 140 g

► **No regrinding cost**

- No laborious endmill regrinding required.
- Easily replaceable heads eliminate the use of worn cutting edges.
- All tools can be used to breakage point or maximum wear point as no regrinding is necessary.

1 **Wide range of cutting heads**

23 kinds of cutting heads are available. The head exchange is easy and highly accurate with the precision thread.

Flexible combinations
TungMeister can be applied to all kinds of endmill machining applications.

2 **Three kinds of shank material**

Users can choose the most suitable combination according to the machining parameters, length and rigidity required.



Power Up



Straight shank & neck



Straight shank & neck (carbide)



Straight shank & taper neck



Straight (for grooving)






- Steel: For general purpose
- Carbide: For highly accurate machining due to excellent rigidity
- Tungsten: Reduced chattering due to high vibration damping capacity

Overview

Head

Head	Square	Toroidal	Ball	Drilling (Centering drill)	Chamfering	Slotting
Appearance						
Page	P. 4 ~ 7	P. 8 ~ 10	P.11 ~ 13	P. 14 ~ 16	P. 17, 18	P. 19 ~ 22

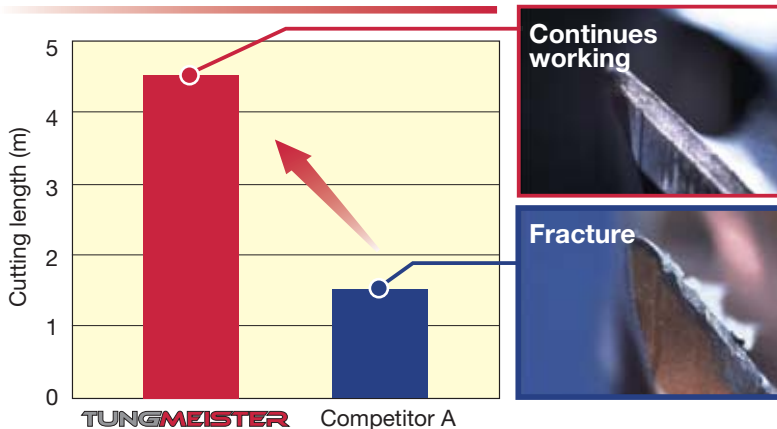
Shank

Shank	Straight	Weldon	Straight	Straight	Adaptor for TungFlex
Neck	Straight	Straight	Taper	(Grooving)	
Appearance					
Steel	●	●	●	●	●
Carbide	●	-	●	●	-
Carbide (with coolant hole)	-	-	-	●	-
Tungsten (with coolant hole)	●	-	●	-	-
Page	P. 22, 23	P. 23	P. 24	P. 25	P. 25

Cutting performance

Work material : SUS304 / X5CrNi18-10 (200HB)	Grade: AH725	Machine : Horizontal M/C BT40
Head : VEE100L07.0R05-04S06	Shank: VSSD10L075S06-S	Holder : Collet chuck
(ø10 mm, square type, 4 flutes)	(Straight shank & neck, steel)	Coolant : Dry

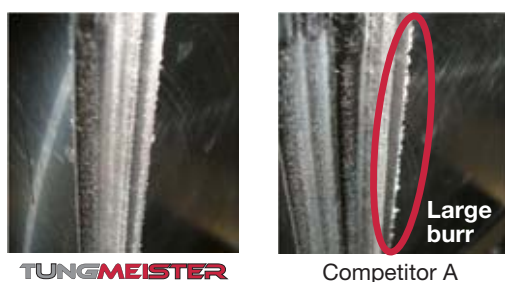
Comparison of milling for stainless steels



Cutting speed : $V_c = 100$ m/min
Feed per tooth: $f_z = 0.07$ mm/t
Depth of cut : $a_p = 5$ mm
Width of cut : $a_e = 1.5$ mm

- Competitor A cutting edges fractured after 1.7 minutes machining and 1.5 m cutting length.
- The TungMeister cutting edges maintain operation after 5 minutes machining.

Comparison of milling surface on stainless steels



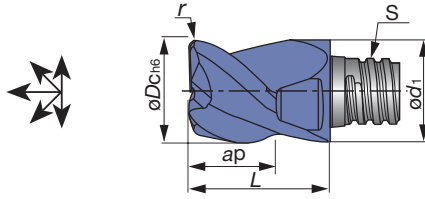
Cutting speed : $V_c = 130$ m/min
Feed per tooth: $f_z = 0.05$ mm/t
Depth of cut : $a_p = 5$ mm
Width of cut : $a_e = 2$ mm

- When machining tough stainless steel the burr with the TungMeister is minimal. However, competitor A has a large burr when working under the same conditions.

Heads

● Square

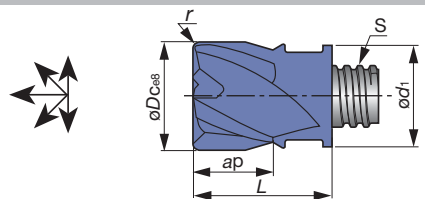
VEE 3 flutes, 45° helix (for general purpose)



ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r	S	L		
VEE080L05.0R00-03S05	●	3	45°	8	7.7	5	0	S05	10.0	KEYV-S05	7
VEE100L07.0R00-03S06	●	3	45°	10	9.7	7	0	S06	13.0	KEYV-S06	10
VEE120L09.0R00-03S08	●	3	45°	12	11.7	9	0	S08	16.5	KEYV-S08	15

VED / VEE 4 flutes, 30° & 45° helix (for general purpose, corner radii: 0 ~ 4.0 mm)



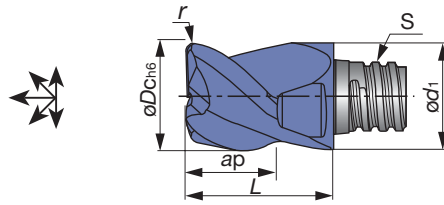
ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r	S	L		
VEE060L05.0R00-04S05	●	4	45°	6	8	5	0	S05	10.0	KEYV-S05	7
VEE080L05.0R00-04S05	●	4	45°	8	7.7	5	0	S05	10.0		
VED080L05.0R05-04S05	●	4	30°	8	7.7	5	0.5	S05	10.0		
VED080L05.0R10-04S05	●	4	30°	8	7.7	5	1.0	S05	10.0		
VED080L05.0R15-04S05	●	4	30°	8	7.7	5	1.5	S05	10.0		
VEE100L07.0R00-04S06	●	4	45°	10	9.7	7	0	S06	13.0	KEYV-S06	10
VED100L07.0R05-04S06	●	4	30°	10	9.7	7	0.5	S06	13.0		
VEE100L07.0R05-04S06	●	4	45°	10	9.7	7	0.5	S06	13.0		
VED100L07.0R10-04S06	●	4	30°	10	9.7	7	1.0	S06	13.0		
VED100L07.0R10-04S06	●	4	45°	10	9.7	7	1.0	S06	13.0		
VEE120L09.0R00-04S08	●	4	45°	12	11.7	9	0	S08	16.5	KEYV-S08	15
VED120L09.0R05-04S08	●	4	30°	12	11.7	9	0.5	S08	16.5		
VEE120L09.0R05-04S08	●	4	45°	12	11.7	9	0.5	S08	16.5		
VED120L09.0R10-04S08	●	4	30°	12	11.7	9	1.0	S08	16.5		
VED120L09.0R10-04S08	●	4	45°	12	11.7	9	1.0	S08	16.5		
VEE160L12.0R00-04S10	●	4	45°	16	15.3	12	0	S10	20.5	KEYV-S10	28
VED160L12.0R05-04S10	●	4	30°	16	15.3	12	0.5	S10	20.5		
VEE160L12.0R05-04S10	●	4	45°	16	15.3	12	0.5	S10	20.5		
VED160L12.0R10-04S10	●	4	30°	16	15.3	12	1.0	S10	20.5		
VEE160L12.0R10-04S10	●	4	45°	16	15.3	12	1.0	S10	20.5		
VED160L12.0R15-04S10	●	4	30°	16	15.3	12	1.5	S10	20.5		
VEE160L12.0R15-04S10	●	4	45°	16	15.3	12	1.5	S10	20.5		
VED160L12.0R20-04S10	●	4	30°	16	15.3	12	2.0	S10	20.5		
VEE160L12.0R20-04S10	●	4	45°	16	15.3	12	2.0	S10	20.5		
VED160L12.0R30-04S10	●	4	30°	16	15.3	12	3.0	S10	20.5		
VEE160L12.0R30-04S10	●	4	45°	16	15.3	12	3.0	S10	20.5		
VED160L12.0R40-04S10	●	4	30°	16	15.3	12	4.0	S10	20.5	KEYV-S12	28
VEE160L12.0R40-04S10	●	4	45°	16	15.3	12	4.0	S10	20.5		
VEE200L15.0R00-04S12	●	4	45°	20	18.3	15	0	S12	25.5		
VED200L15.0R05-04S12	●	4	30°	20	18.3	15	0.5	S12	25.5		
VED200L15.0R10-04S12	●	4	30°	20	18.3	15	1.0	S12	25.5		
VED200L15.0R20-04S12	●	4	30°	20	18.3	15	2.0	S12	25.5		
VED200L15.0R30-04S12	●	4	30°	20	18.3	15	3.0	S12	25.5		

● : Stocked items
Packing Quantity = 2 pcs.

VEE

3 flutes, 38° helix, for roughing before keyways (corner radii: 0.2 ~ 0.4 mm)

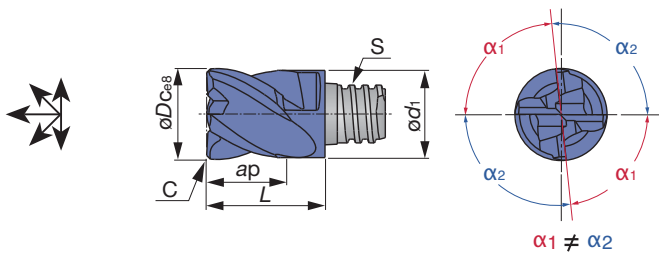


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N-m)
				øDc	ød1	ap	r	S	L		
VEE077L04.0R02-03S05	●	3	38°	7.7	7.7	4	0.2	S05	10.0	KEYV-S05	7
VEE097L05.0R03-03S06	●	3	38°	9.7	9.7	5	0.3	S06	13.0	KEYV-S06	10
VEE117L07.0R03-03S08	●	3	38°	11.7	11.7	7	0.3	S08	16.5	KEYV-S08	15
VEE157L08.0R03-03S10	●	3	38°	15.7	15.3	8	0.3	S10	20.5	KEYV-S10	28
VEE197L12.0R04-03S12	●	3	38°	19.7	18.3	12	0.4	S12	25.5	KEYV-S12	28

VEE-I

4 flutes, 38° helix, irregular-pitch flutes (chatter free)

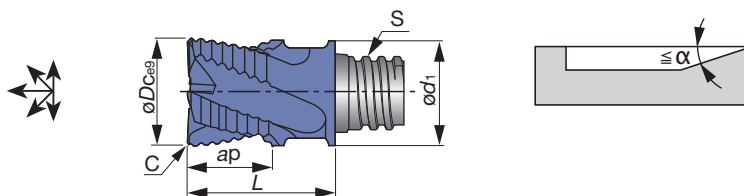


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N-m)
				øDc	ød1	ap	C	S	L		
VEE080L05.0C30I04S05	●	4	38°	8	7.7	5	0.3	S05	10.0	KEYV-S05	7
VEE100L07.0C40I04S06	●	4	38°	10	9.7	7	0.4	S06	13.0	KEYV-S06	10
VEE120L09.0C50I04S08	●	4	38°	12	11.7	9	0.5	S08	16.5	KEYV-S08	15
VEE160L12.0C60I04S10	●	4	38°	16	15.3	12	0.6	S10	20.5	KEYV-S10	28
VEE200L15.0C60I04S12	●	4	38°	20	18.3	15	0.6	S12	25.5	KEYV-S12	28

VEE-R

4 / 5 / 6 flutes, 45° helix, for roughing



ap = Max. depth of cut
S = Connection screw size

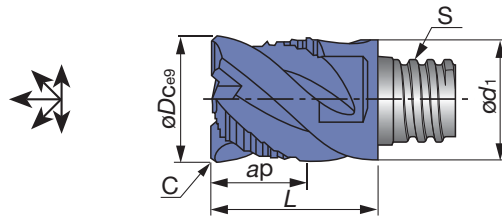
Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N-m)
				øDc	ød1	ap	C	S	L	α		
VEE080L05.0C25R04S05	●	4	45°	8	7.7	5	0.25	S05	10.0	90°	KEYV-S05	7
VEE100L07.0C30R04S06	●	4	45°	10	9.7	7	0.3	S06	13.0	90°	KEYV-S06	10
VEE120L09.0C35R04S08	●	4	45°	12	11.7	9	0.35	S08	16.5	90°	KEYV-S08	15
VEE160L12.0C40R05S10	●	5	45°	16	15.3	12	0.4	S10	20.5	7°	KEYV-S10	28
VEE200L15.0C40R06S12	●	6	45°	20	18.3	15	0.4	S12	25.5	3°	KEYV-S12	28

● : Stocked items
Packing Quantity = 2 pcs.

● Square

VEE-C

4 flutes, 45° helix (combined edges for finishing & roughing)

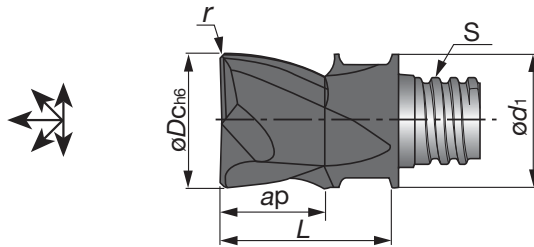


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	C	S	L		
VEE080L05.0C30C04S05	●	4	45°	8	7.7	5	0.3	S05	10.0	KEYV-S05	7
VEE100L07.0C30C04S06	●	4	45°	10	9.7	7	0.3	S06	13.0	KEYV-S06	10
VEE120L09.0C40C04S08	●	4	45°	12	11.7	9	0.4	S08	16.5	KEYV-S08	15
VEE160L12.0C60C04S10	●	4	45°	16	15.3	12	0.6	S10	20.5	KEYV-S10	28
VEE200L15.0C60C04S12	●	4	45°	20	18.3	15	0.6	S12	25.5	KEYV-S12	28

VEE-A

2 flutes, 45° helix, for aluminium machining (corner radii: 0.5 ~ 1.0 mm)

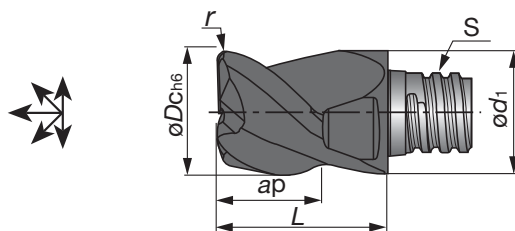


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade KS15F	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r	S	L		
VEE100L07.0R05A02S06	●	2	45°	10	9.7	7	0.5	S06	13.0	KEYV-S06	10
VEE100L07.0R10A02S06	●	2	45°	10	9.7	7	1.0	S06	13.0		
VEE120L09.0R05A02S08	●	2	45°	12	11.7	9	0.5	S08	16.5	KEYV-S08	15

VEE-A

3 flutes, 45° helix, for aluminium machining (corner radii: 0 ~ 2.0 mm)



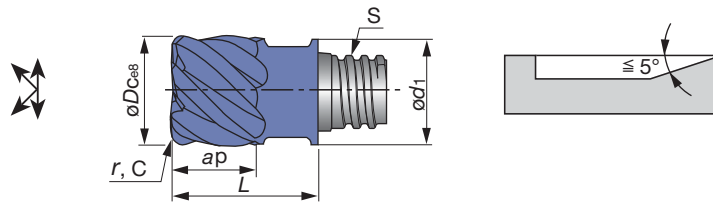
ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade KS15F	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r	S	L		
VEE080L05.0R05A03S05	●	3	45°	8	7.7	5	0.5	S05	10.0	KEYV-S05	7
VEE100L06.0R05A03S06	●	3	45°	10	9.7	6	0.5	S06	13.0		
VEE100L06.0R10A03S06	●	3	45°	10	9.7	6	1.0	S06	13.0	KEYV-S06	10
VEE120L08.0R05A03S08	●	3	45°	12	11.7	8	0.5	S08	16.5		
VEE120L08.0R10A03S08	●	3	45°	12	11.7	8	1.0	S08	16.5	KEYV-S08	15
VEE160L10.0R00A03S10	●	3	45°	16	15.3	10	0	S10	20.5		
VEE160L10.0R10A03S10	●	3	45°	16	15.3	10	1.0	S10	20.5	KEYV-S10	28
VEE160L10.0R20A03S10	●	3	45°	16	15.3	10	2.0	S10	20.5		
VEE200L12.0R05A03S12	●	3	45°	20	18.3	12	0.5	S12	25.5	KEYV-S12	28
VEE200L12.0R10A03S12	●	3	45°	20	18.3	12	1.0	S12	25.5		
VEE200L12.0R20A03S12	●	3	45°	20	18.3	12	2.0	S12	25.5		

● : Stocked items
Packing Quantity = 2 pcs.

VEE / VED

6 flutes, 30°, 45° & 50° helix (without central edge, corner radii: 0 ~ 1.5 mm)

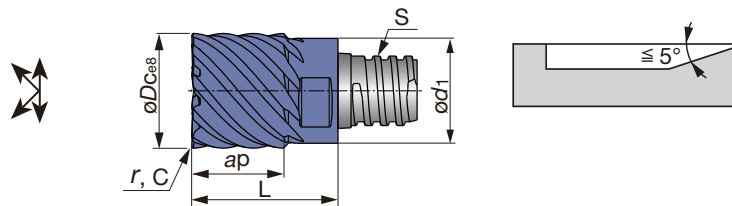


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grades		No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N-m)
	AH725	AH750			ϕD_c	ϕd_1	ap	r	C	S	L		
VEE080L05.0R05-06S05	●		6	45°	8	7.7	5	0.5	-	S05	10.0	KEYV-S05	7
VEE080L05.0R10-06S05	●		6	45°	8	7.7	5	1.0	-	S05	10.0		
VEE080L05.0R15-06S05	●		6	45°	8	7.7	5	1.5	-	S05	10.0		
VEE080L05.0C10-06S05		●	6	50°	8	7.7	5	-	0.1	S05	10.0		
VEE100L07.0R00-06S06	●		6	45°	10	9.7	7	0	-	S06	13.0	KEYV-S06	10
VED100L07.0R05-06S06	●		6	30°	10	9.7	7	0.5	-	S06	13.0		
VEE100L07.0R05-06S06	●		6	45°	10	9.7	7	0.5	-	S06	13.0		
VED100L07.0R10-06S06	●		6	30°	10	9.7	7	1.0	-	S06	13.0		
VEE100L07.0R10-06S06	●		6	45°	10	9.7	7	1.0	-	S06	13.0		
VED100L07.0R15-06S06	●		6	30°	10	9.7	7	1.5	-	S06	13.0		
VEE100L07.0R15-06S06	●		6	45°	10	9.7	7	1.5	-	S06	13.0		
VEE100L07.0C10-06S06		●	6	50°	10	9.7	7	-	0.1	S06	13.0		
VEE120L09.0R00-06S08	●		6	45°	12	11.7	9	0	-	S08	16.5	KEYV-S08	15
VED120L09.0R05-06S08	●		6	30°	12	11.7	9	0.5	-	S08	16.5		
VED120L09.0R10-06S08	●		6	30°	12	11.7	9	1.0	-	S08	16.5		
VEE120L09.0R10-06S08	●		6	45°	12	11.7	9	1.0	-	S08	16.5		
VEE120L09.0R15-06S08	●		6	45°	12	11.7	9	1.5	-	S08	16.5		
VEE120L09.0C10-06S08		●	6	50°	12	11.7	9	-	0.1	S08	16.5		

VEE / VED

8 / 10 flutes, 30° & 50° helix (without central edge, corner radii: 0.5 ~ 2.0 mm)



ap = Max. depth of cut
S = Connection screw size

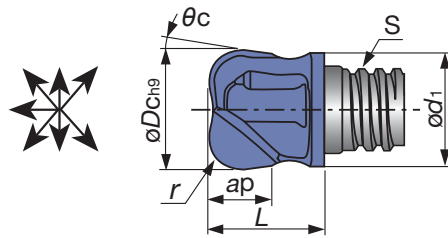
Cat. No.	Grades		No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N-m)
	AH725	AH750			ϕD_c	ϕd_1	ap	r	C	S	L		
VED160L12.0R05-08S10	●		8	30°	16	15.3	12	0.5	-	S10	20.5	KEYV-S10	28
VED160L12.0R10-08S10	●		8	30°	16	15.3	12	1.0	-	S10	20.5		
VED160L12.0R16-08S10	●		8	30°	16	15.3	12	1.6	-	S10	20.5		
VED160L12.0R20-08S10	●		8	30°	16	15.3	12	2.0	-	S10	20.5		
VEE160L12.0C20-08S10		●	8	50°	16	15.3	12	-	0.2	S10	20.5		
VED200L15.0R10-10S12	●		10	30°	20	18.3	15	1.0	-	S12	25.5	KEYV-S12	28
VED200L15.0R20-10S12	●		10	30°	20	18.3	15	2.0	-	S12	25.5		
VEE200L15.0C20-10S12		●	10	50°	20	18.3	15	-	0.2	S12	25.5		

● : Stocked items
Packing Quantity = 2 pcs.

Toroidal

VRB / VRC

2 flutes, 0° / 15° helix, 5° / 7° relief angle



ap = Max. depth of cut
S = Connection screw size

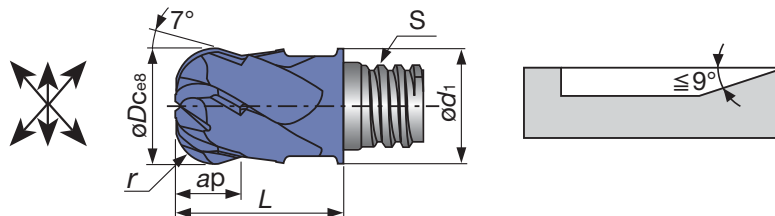
Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N·m)
				ϕDc	ϕd_1	ap	r	θ_c	S	L		
VRC100L07.0R05-02S06	●	2	15°	10	9.5	7	0.5	5°	S06	12.4	KEYV-S06	10
VRC100L07.0R10-02S06	●	2	15°	10	9.5	7	1.0	5°	S06	12.4		
VRB100L06.0R20-02S06	●	2	0°	10	9.2	6	2.0	7°	S06	12.4		
VRB120L05.7R30-02S06	●	2	0°	12	9.5	5.7	3.0	7°	S06	9.1	*KEYV-S08	15
VRB120L05.4R40-02S06	●	2	0°	12	9.5	5.4	4.0	7°	S06	9.1		
VRB120L06.3R16-02S08	●	2	0°	12	11.5	5.9	1.6	7°	S08	11.1	KEYV-S08	15
VRB120L06.2R20-02S08	●	2	0°	12	11.5	6.2	2.0	7°	S08	11.1		
VRB120L06.1R25-02S08	●	2	0°	12	11.5	5.8	2.5	7°	S08	11.1		
VRB120L06.1R30-02S08	●	2	0°	12	11.5	5.7	3.0	7°	S08	11.1		
VRB120L05.9R40-02S08	●	2	0°	12	11.5	5.5	4.0	7°	S08	11.1	KEYV-S10	28
VRB160L08.0R50-02S10	●	2	0°	16	15.2	8	5.0	7°	S10	20.2		
VRB200L11.1R30-02S12	●	2	0°	20	18.3	11	3.0	7°	S12	17.0	KEYV-S12	28
VRB200L11.5R40-02S12	●	2	0°	20	18.3	11.3	4.0	7°	S12	17.3		
VRB200L11.5R50-02S12	●	2	0°	20	18.3	11.3	5.0	7°	S12	17.3		
VRB200L11.4R60-02S12	●	2	0°	20	18.3	11.2	6.0	7°	S12	17.3		
VRB200L11.3R80-02S12	●	2	0°	20	18.3	11.1	8.0	7°	S12	17.3		

● Suitable for contouring operation

* Some heads require different size of wrench.

VRD

6 flutes, 30° helix, 7° back taper sided



ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				ϕDc	ϕd_1	ap	r	S	L		
VRD080L04.0R20-06S05	●	6	30°	8	7.7	4	2.0	S05	10.0	KEYV-S05	7
VRD100L05.0R30-06S06	●	6	30°	10	9.7	5	3.0	S06	13.0	KEYV-S06	10
VRD120L07.0R40-06S08	●	6	30°	12	11.7	7	4.0	S08	16.5	KEYV-S08	15
VRD160L09.0R50-06S10	●	6	30°	16	15.3	9	5.0	S10	20.5	KEYV-S10	28

● : Stocked items
Packing Quantity = 2 pcs.

■ Standard cutting conditions: Shoulder milling / Slotting

(VEE: 3 flutes, VED/VEE: 4 flutes, VEE-A, VEE-I, VEE-R, VEE-C, VRB, VRC, VRD)

Work materials	Hardness	Shoulder milling					Slot milling				
		Cutting speed V_c (m/min)	Tool diameter ϕD_c (mm)	Feed per tooth f_z (mm/t)	Depth of cut a_p (mm)	Width of cut a_e (mm)	Cutting speed V_c (m/min)	Tool diameter ϕD_c (mm)	Feed per tooth f_z (mm/t)	Depth of cut a_p (mm)	
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	130 (80-180)				$0.25 \times \phi D_c$				$0.5 \times \phi D_c$	
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	100 (60-140)									
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	90 (60-120)									
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	70 (40-100)									
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	140 (80-200)									$\phi 6$: 0.05 (0.03-0.07)
Ductile cast irons FCD400 etc (GGG40 etc)											$\phi 8$: 0.07 (0.05-0.09)
Aluminium alloys (Si < 13%)	-	300 (200-700)									$\phi 10$: 0.09 (0.07-0.12)
Aluminium alloys (Si \geq 13%)	-	200 (100-300)									$\phi 12$: 0.10 (0.08-0.13)
Titanium alloys Ti-6Al-4V etc	-	60 (40-80)									$\phi 16$: 0.12 (0.09-0.15)
Heat-resistant alloys Inconel 718 etc	-	30 (20-40)									$\phi 20$: 0.13 (0.10-0.17)
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40 ~ 50 HRC	60 (40-80)	$0.6 \times \phi D_c$	$0.05 \times \phi D_c$						$0.2 \times \phi D_c$	
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50 ~ 60 HRC	40 (20-60)									

■ Standard cutting conditions: Shoulder milling

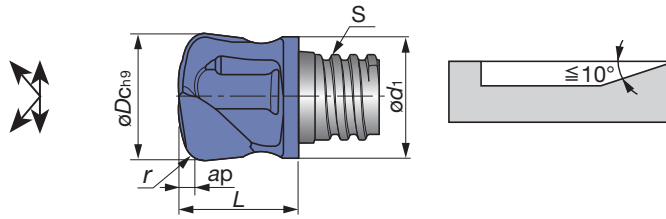
(VED / VEE: 6 flutes, VED / VEE: 8, 10 flutes)

Work materials	Hardness (HRC)	Shoulder milling				
		Cutting speed V_c (m/min)	Tool diameter ϕD_c (mm)	Feed per tooth f_z (mm/t)	Depth of cut a_p (mm)	Width of cut a_e (mm)
Titanium alloys Ti-6Al-4V etc	-	90 (60 - 120)	$\phi 8$: 0.07 (0.05-0.09) $\phi 10$: 0.09 (0.07-0.12) $\phi 12$: 0.10 (0.08-0.13) $\phi 16$: 0.12 (0.09-0.15) $\phi 20$: 0.13 (0.10-0.17)		$0.6 \times \phi D_c$	$0.02 \times \phi D_c$
Heat-resistant alloys Inconel 718 etc	-	40 (30 - 60)				
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40 ~ 50	120 (80 - 160)				
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50 ~ 60	60 (40 - 90)				

Toroidal

VFX

2 flutes, 0° helix, for high feed milling



ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r ⁽¹⁾	S	L		
VFX100L00.6R20-02S06	●	2	0°	10	9.6	0.6	2.0	S06	12.5	KEYV-S06	10
VFX120L01.0R25-02S08	●	2	0°	12	11.5	1.0	2.5	S08	11.1	KEYV-S08	15
VFX160L01.1R30-02S10	●	2	0°	16	15.2	1.1	3.0	S10	20.0	KEYV-S10	28
VFX200L01.5R33-02S12	●	2	0°	20	18.3	1.5	3.3	S12	17.5	KEYV-S12	28

(1) Corner radius for CAM programming

Note: For VFX head, taper neck shank or Tungsten shank should be recommended.

● : Stocked items
Packing Quantity = 2 pcs.

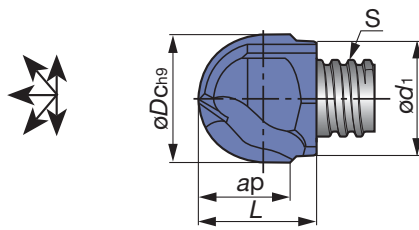
Standard cutting conditions: Pocketing with high feed (VFX)

Work materials	Hardness	Cutting speed Vc (m/min)	ø10		ø12		ø16		ø20		Width of cut ae (mm)
			Feed per tooth fz (mm/t)	Depth of cut ap (mm)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)	
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	150 (100-200)	0.5 (0.3-0.7)	0.5	0.6 (0.4-0.8)	0.5	0.7 (0.5-0.9)	0.75	0.8 (0.6-1.0)	1.0	0.6 x øDc
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	130 (80-180)	0.4 (0.2-0.6)	0.5	0.5 (0.3-0.7)	0.5	0.6 (0.4-0.8)	0.75	0.7 (0.5-0.9)	1.0	0.6 x øDc
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	120 (80-160)	0.3 (0.2-0.5)	0.4	0.3 (0.2-0.5)	0.4	0.4 (0.3-0.6)	0.5	0.4 (0.3-0.6)	0.75	0.6 x øDc
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	80 (60-100)	0.4 (0.2-0.6)	0.4	0.4 (0.2-0.6)	0.4	0.5 (0.3-0.7)	0.5	0.5 (0.3-0.7)	0.75	0.6 x øDc
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	160 (100-220)	0.5 (0.3-0.7)	0.5	0.6 (0.4-0.8)	0.75	0.7 (0.5-0.9)	0.75	0.8 (0.6-1.0)	1.0	0.6 x øDc
Ductile cast irons FCD400 etc (GGG40 etc)			0.4 (0.2-0.6)	0.5	0.5 (0.3-0.7)	0.75	0.6 (0.4-0.8)	0.75	0.7 (0.5-0.9)	1.0	0.6 x øDc
Titanium alloys Ti-6Al-4V etc	-	60 (40-80)	0.3 (0.2-0.5)	0.4	0.3 (0.2-0.5)	0.4	0.4 (0.2-0.6)	0.5	0.4 (0.2-0.6)	0.5	0.25 x øDc
Heat-resistant alloys Inconel 718 etc	-	30 (20-40)	0.2 (0.1-0.3)	0.3	0.2 (0.1-0.3)	0.3	0.2 (0.1-0.3)	0.4	0.2 (0.1-0.3)	0.4	0.25 x øDc
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40~ 50 HRC	60 (40-80)	0.3 (0.2-0.4)	0.3	0.3 (0.2-0.4)	0.3	0.4 (0.3-0.5)	0.4	0.4 (0.3-0.5)	0.4	0.45 x øDc
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50~ 60 HRC	40 (20-60)	0.15 (0.1-0.2)	0.2	0.15 (0.1-0.2)	0.2	0.2 (0.1-0.3)	0.3	0.2 (0.1-0.3)	0.3	0.25 x øDc

● Ball

VBB-BM

2 flutes, 0° helix (for general purpose)



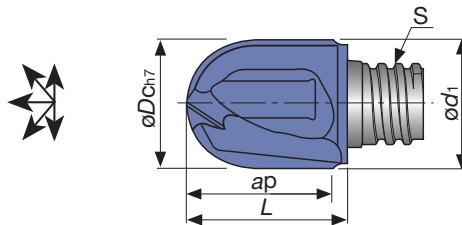
ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				$\varnothing Dc$	$\varnothing d_1$	ap	S	L		
VBB080L08.0-BM-02S05	●	2	0°	8	7.6	8	S05	10.0	KEYV-S05	7
VBB100L10.0-BM-02S06	●	2	0°	10	9.5	10	S06	12.4	KEYV-S06	10
VBB120L12.0-BM-02S08	●	2	0°	12	11.5	11.5	S08	15.3	KEYV-S08	15
VBB160L16.0-BM-02S10	●	2	0°	16	15.2	16	S10	19.1	KEYV-S10	28

- For roughing

VBB-BG

2 flutes, 0° helix (for high precision)

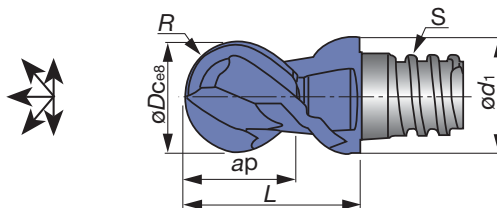


ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade AH750	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				$\varnothing Dc$	$\varnothing d_1$	ap	S	L		
VBB080L08.0-BG-02S05	●	2	0°	8	7.6	8	S05	10.0	KEYV-S05	7
VBB100L10.0-BG-02S06	●	2	0°	10	9.6	10	S06	12.4	KEYV-S06	10
VBB120L12.0-BG-02S08	●	2	0°	12	11.5	12	S08	15.3	KEYV-S08	15
VBB160L16.0-BG-02S10	●	2	0°	16	15.2	16	S10	19.1	KEYV-S10	28

VBD-BG

2 flutes, 30° helix (for high precision)



ap = Max. depth of cut
 S = Connection screw size

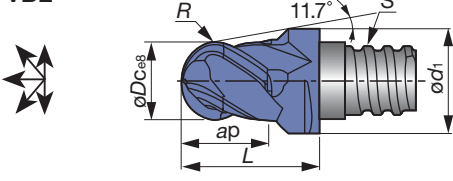
Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)	
				$\varnothing Dc$	$\varnothing d_1$	ap	R	S			L
VBD080L05.0-BG-02S05	●	2	30°	8	7.7	5	3.982 ⁽¹⁾	S05	10.0	KEYV-S05	7
VBD100L07.0-BG-02S06	●	2	30°	10	9.7	7	4.982 ⁽¹⁾	S06	13.0	KEYV-S06	10
VBD120L09.0-BG-02S08	●	2	30°	12	11.7	9	5.978 ⁽²⁾	S08	16.5	KEYV-S08	15
VBD160L09.5-BG-02S10	●	2	30°	16	15.3	9	7.978 ⁽²⁾	S10	20.5	KEYV-S10	28

- The tolerance of R : (1) ± 0.010 (2) ± 0.012

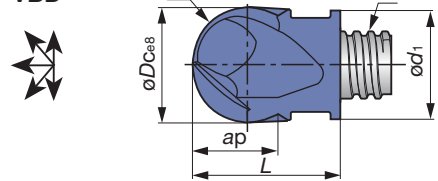
● : Stocked items
Packing Quantity = 2 pcs.

VBD / VBE-BG 4 flutes, 30° & 45° helix (for high precision)

VBE



VBD



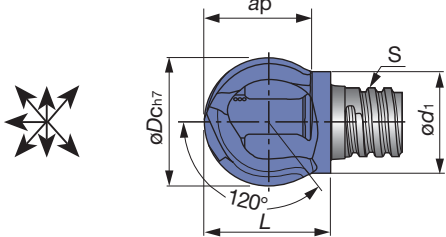
P M K S H
 Steel Stainless Cast Iron Superalloys ^{Hard} Materials

ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	R	S	L		
VBE060L05.5-BG-04S05	●	4	45°	6	8.0	5.5	2.987 ⁽¹⁾	S05	10.0	KEYV-S05	7
VBD080L05.0-BG-04S05	●	4	30°	8	7.7	5	3.982 ⁽¹⁾	S05	10.0	KEYV-S05	7
VBD100L07.0-BG-04S06	●	4	30°	10	9.7	7	4.982 ⁽¹⁾	S06	13.0	KEYV-S06	10
VBD120L09.0-BG-04S08	●	4	30°	12	11.7	9	5.978 ⁽²⁾	S08	16.5	KEYV-S08	15
VBD160L12.0-BG-04S10	●	4	30°	16	15.3	12	7.978 ⁽²⁾	S10	20.5	KEYV-S10	28
VBD200L15.0-BG-04S12	●	4	30°	20	18.3	15	9.972 ⁽²⁾	S12	25.5	KEYV-S12	28

• The tolerance of R : (1) ± 0.010 (2) ± 0.012

VBB-SG 2 flutes, 0° helix, spherical designed edge



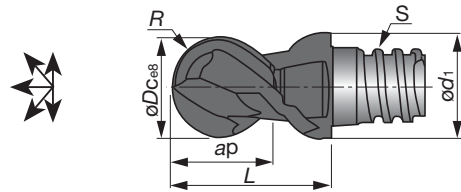
P M K S H
 Steel Stainless Cast Iron Superalloys ^{Hard} Materials

ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				øDc	ød1	ap	S	L		
VBB100L08.0-SG-02S05	●	2	0°	10	7.6	8	S05	10.1	KEYV-S05	7
VBB120L09.6-SG-02S06	●	2	0°	12	9.6	9.6	S06	11.6	*KEYV-S08	10
VBB160L12.9-SG-02S08	●	2	0°	16	11.5	12.9	S08	15.4	*KEYV-S10	15
VBB200L16.1-SG-02S10	●	2	0°	20	15.2	16.1	S10	18.5	KEYV-S10	28

• For pull-cutting on the vertical wall
 * Some heads require different size of wrench.

VBE-BGA 2 flutes, 45° helix, for aluminium machining



N
 Non-ferrous

ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade KS15F	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	R	S	L		
VBE080L05.0-BGA02S05	●	2	45°	8	7.7	5	3.982 ⁽¹⁾	S05	10.0	KEYV-S05	7
VBE100L07.0-BGA02S06	●	2	45°	10	9.7	7	4.982 ⁽¹⁾	S06	13.0	KEYV-S06	10
VBE120L09.0-BGA02S08	●	2	45°	12	11.7	9	5.987 ⁽²⁾	S08	16.5	KEYV-S08	15
VBE160L12.0-BGA02S10	●	2	45°	16	15.3	12	7.978 ⁽²⁾	S10	20.5	KEYV-S10	28
VBE200L15.0-BGA02S12	●	2	45°	20	18.3	15	9.972 ⁽²⁾	S12	25.5	KEYV-S12	28

• The tolerance of R : (1) ± 0.010 (2) ± 0.012

● : Stocked items
 Packing Quantity = 2 pcs.

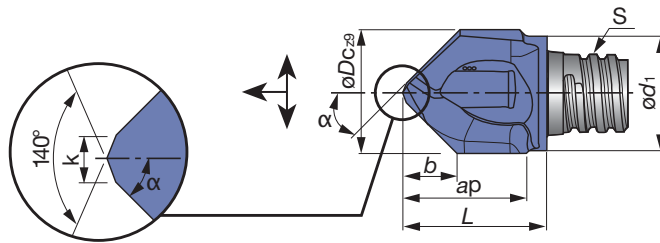
■ Standard cutting conditions: Profiling (VBB-BM / BG / SG, VBD-BG, VBE-BGA)

Work materials	Hardness	Profiling (for roughing)					Profiling (for semi-finishing and finishing)				
		Cutting speed Vc (m/min)	Tool diameter øDc (mm)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)	Pick feed Pf (mm)	Cutting speed Vc (m/min)	Tool diameter øDc (mm)	Feed per tooth fz (mm/t)	Depth of cut ap (mm)	Pick feed Pf (mm)
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	150 (100-200)	ø6: 0.05 (0.03-0.07) ø8: 0.06 (0.04-0.08) ø10: 0.07 (0.05-0.10) ø12: 0.08 (0.06-0.11) ø16: 0.09 (0.07-0.13) ø20: 0.11 (0.08-0.15)			0.4 x øDc	180 (120-250)				
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	130 (80-180)					160 (100-220)				
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	120 (80-160)					150 (100-200)				
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	80 (60-100)					100 (80-120)				
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	160 (100-220)					200 (120-280)				
Ductile cast irons FCD400 etc (GGG40 etc)											
Aluminium alloys (Si < 13%)	-	300 (200-700)					500 (300-1000)				
Aluminium alloys (Si ≥ 13%)	-	200 (100-300)					300 (150-400)				
Titanium alloys Ti-6Al-4V etc	-	60 (40-80)					70 (50-100)				
Heat-resistant alloys Inconel 718 etc	50~ 60 HRC	30 (20-40)					40 (30-50)				
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	-	60 (40-80)	70 (50-100)								
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50~ 60 HRC	40 (20-60)		50 (30-80)							

● Drilling

VCP

2 flutes, 0° helix, for spot drilling, chamfering and countersinking



b = Max. hole depth
ap = Max. depth of cut
S = Connection screw size

Point angle = 60°

Cat. No	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)								Wrench	Torque (N·m)
				ϕDc	$\phi d1$	ap	b	S	L	k	α		
VCP100L09.5A30-02S06	●	2	0°	10.0	9.5	8.5	7.5	S06	11.75	1.5	30°	KEYV-S06	10
VCP120L12.0A30-02S08	●	2	0°	12.0	11.5	11	9.2	S08	15.4	1.5	30°	KEYV-S08	15
VCP160L15.0A30-02S10	●	2	0°	16.0	15.2	16	12.0	S10	20.2	2.5	30°	KEYV-S10	28

● Min. chamfering: $\phi 1.5$ mm

Point angle = 90°

Cat. No	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)								Wrench	Torque (N·m)
				ϕDc	$\phi d1$	ap	b	S	L	k	α		
VCP080L07.7A45-02S05	●	2	0°	8.0	7.6	7.5	3.7	S05	9.75	1.0	45°	KEYV-S05	7
VCP083L07.9A45-02S05	●	2	0°	8.3	7.6	7.5	3.8	S05	10.0	1.0	45°		
VCP100L09.0A45-02S06	●	2	0°	10.0	9.5	9.5	4.4	S06	11.75	1.5	45°	KEYV-S06	10
VCP104L09.0A45-02S06	●	2	0°	10.4	9.5	9.5	4.6	S06	11.75	1.5	45°		
VCP120L12.0A45-02S08	●	2	0°	12.0	11.5	11.5	5.4	S08	15.4	1.5	45°	KEYV-S08	15
VCP124L12.0A45-02S08	●	2	0°	12.4	11.5	11.5	5.6	S08	15.4	1.5	45°		
VCP160L15.0A45-02S10	●	2	0°	16.0	15.2	15	7.1	S10	18.8	1.5	45°	KEYV-S10	28
VCP165L15.0A45-02S10	●	2	0°	16.5	15.2	15	7.1	S10	18.8	1.5	45°		

● Min. chamfering: $\phi 1.5$ mm

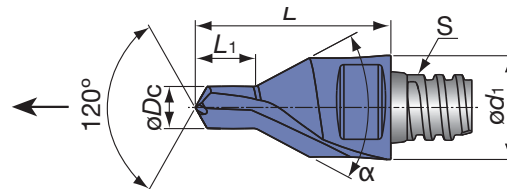
Point angle = 120°

Cat. No	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)								Wrench	Torque (N·m)
				ϕDc	$\phi d1$	ap	b	S	L	k	α		
VCP100L09.5A60-02S06	●	2	0°	10.0	9.5	9.5	2.7	S06	12.7	1.5	60°	KEYV-S06	10
VCP120L12.0A60-02S08	●	2	0°	12.0	11.5	11.5	3.3	S08	15.2	1.5	60°	KEYV-S08	15
VCP160L15.5A60-02S10	●	2	0°	16.0	15.2	16	4.4	S10	19.9	1.5	60°	KEYV-S10	28

● Min. chamfering: $\phi 1.5$ mm

VDP

2 flutes, for center drilling (DIN332)



ap = Max. depth of cut
S = Connection screw size

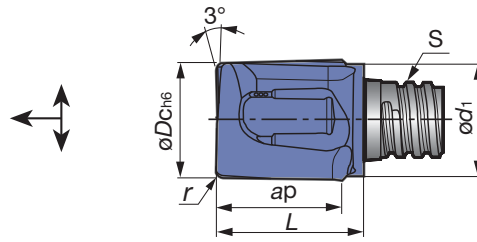
Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				ϕDc	$\phi d1$	L1	S	L	α		
VDP328L04.6A30-02S05	●	2	-	3.28	8	4.6	S05	15.0	60°	KEYV-S05	7
VDP412L05.9A30-02S06	●	2	-	4.12	10	5.9	S06	19.0	60°	KEYV-S06	10
VDP513L07.2A30-02S08	●	2	-	5.13	12	7.2	S08	23.0	60°	KEYV-S08	15
VDP646L08.9A30-02S10	●	2	-	6.46	16	8.9	S10	28.0	60°	KEYV-S10	28

● : Stocked items
Packing Quantity = 2 pcs.

■ Standard cutting conditions: Drilling (VCP, VDP)

Work materials	Hardness	Cutting speed Vc (m/min)	Feed: <i>f</i> (mm/rev)				
			VDP328	VDP412	VDP513	VDP646	VCP
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	60 (40-80)	0.06 (0.04-0.08)	0.07 (0.05-0.10)	0.07 (0.05-0.10)	0.09 (0.06-0.12)	0.09 (0.06-0.12)
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	40 (30-50)	0.06 (0.04-0.08)	0.07 (0.05-0.10)	0.07 (0.05-0.10)	0.09 (0.06-0.12)	0.09 (0.06-0.12)
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	25 (20-30)	0.06 (0.04-0.08)	0.07 (0.05-0.10)	0.07 (0.05-0.10)	0.09 (0.06-0.12)	0.09 (0.06-0.12)
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	20 (15-25)	0.06 (0.04-0.08)	0.07 (0.05-0.10)	0.07 (0.05-0.10)	0.09 (0.06-0.12)	0.09 (0.06-0.12)
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	80 (60-100)	0.07 (0.05-0.09)	0.09 (0.07-0.12)	0.09 (0.07-0.12)	0.15 (0.12-0.18)	0.15 (0.12-0.18)
Ductile cast irons FCD400 etc (GGG40 etc)			0.06 (0.04-0.08)	0.07 (0.05-0.10)	0.07 (0.05-0.10)	0.12 (0.10-0.15)	0.12 (0.10-0.15)
Titanium alloys Ti-6Al-4V etc	-	20 (15-25)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)
Heat-resistant alloys Inconel 718 etc	-	15 (10-20)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40~ 50 HRC	20 (15-25)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)	0.05 (0.04-0.07)
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50~ 60 HRC	15 (10-20)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)	0.04 (0.03-0.06)

VGC 2 flutes, 0° helix, for counter boring



P M K S H
 Steel Stainless Cast Iron Superalloys Materials

ap = Max. depth of cut
 S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	r	S	L		
VGC078L08.0R02-02S05	●	2	10°	7.8	7.6	8	0.2	S05	10.0	KEYV-S05	7
VGC080L08.0R04-02S05	●	2	10°	8.0	7.6	8	0.4	S05	10.0		
VGC080L08.0R10-02S05	●	2	10°	8.0	7.6	8	1.0	S05	10.0		
VGC080L08.0R20-02S05	●	2	10°	8.0	7.6	8	2.0	S05	10.0		
VGC098L09.0R03-02S06	●	2	10°	9.8	9.5	9.5	0.3	S06	12.4	KEYV-S06	10
VGC100L09.0R04-02S06	●	2	10°	10.0	9.5	9.5	0.4	S06	12.4		
VGC100L09.0R10-02S06	●	2	10°	10.0	9.5	9.5	1.0	S06	12.4		
VGC100L09.0R20-02S06	●	2	10°	10.0	9.5	9.5	2.0	S06	12.4		
VGC117L10.0R03-02S08	●	2	10°	11.7	11.5	10	0.3	S08	14.2	KEYV-S08	15
VGC120L10.0R04-02S08	●	2	10°	12.0	11.5	10	0.4	S08	14.2		
VGC120L10.0R10-02S08	●	2	10°	12.0	11.5	10	1.0	S08	14.2		
VGC120L10.0R20-02S08	●	2	10°	12.0	11.5	10	2.0	S08	14.2		
VGC157L15.0R03-02S10	●	2	10°	15.7	15.2	15	0.3	S10	19.0	KEYV-S10	28
VGC160L15.0R04-02S10	●	2	10°	16.0	15.2	15	0.4	S10	19.0		
VGC160L15.0R08-02S10	●	2	10°	16.0	15.2	15	0.8	S10	19.0		

● Can drill with step feed

● : Stocked items
 Packing Quantity = 2 pcs.

Standard cutting conditions: Counter boring (VGC)

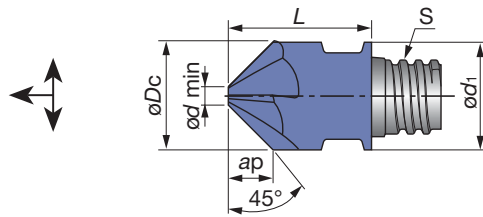
Work materials	Hardness	Cutting speed Vc (m/min)	Feed f (mm/rev)
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	60 (40-80)	0.06 (0.04-0.08)
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	40 (30-50)	0.06 (0.04-0.08)
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	25 (20-30)	0.06 (0.04-0.08)
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	20 (15-25)	0.06 (0.04-0.08)
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	80 (60-100)	0.07 (0.05-0.09)
Ductile cast irons FCD400 etc (GGG40 etc)			0.06 (0.04-0.08)
Titanium alloys Ti-6Al-4V etc	-	20 (15-25)	0.05 (0.04-0.07)
Heat-resistant alloys Inconel 718 etc	-	15 (10-20)	0.04 (0.03-0.06)
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40 ~ 50 HRC	20 (15-25)	0.05 (0.04-0.07)
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50 ~ 60 HRC	15 (10-20)	0.04 (0.03-0.06)

- When drilling, the step feed (woodpeckering feed) operation should be applied with the depth of 0.3 - 0.5 mm per step.
- Apply the same cutting conditions as the VEE type head when conducting shoulder milling or slotting operations.

● Chamfering

VCA

4 / 6 flutes, 0° helix, chamfering and countersinking (without center edge)

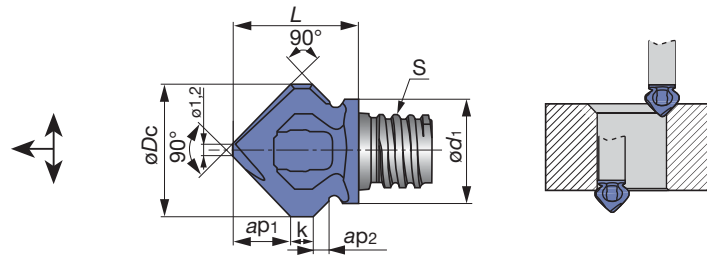


ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	ød1	ap	ødmin	S	L		
VCA100L04.0A45-04S06	●	4	0°	10.0	10.0	4	1.95	S06	13.00	KEYV-S06	10
VCA120L05.0A45-04S08	●	4	0°	12.0	12.0	5	1.95	S08	16.50	KEYV-S08	15
VCA127L05.3A45-04S08	●	4	0°	12.7	12.7	5.3	1.98	S08	16.50		
VCA160L06.5A45-06S10	●	6	0°	16.0	16.0	6.5	3.00	S10	20.30	KEYV-S10	28
VCA200L07.5A45-06S12	●	6	0°	20.0	18.3	7.5	5.00	S12	25.50	KEYV-S12	28

VCW

2 flutes, 0° helix, for double chamfering



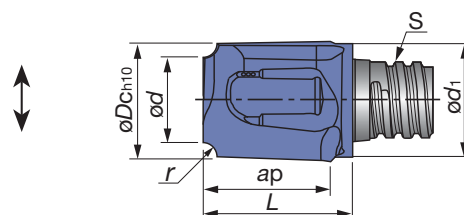
ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N·m)
				øDc	ød1	ap1	ap2	k	S	L		
VCW118L05.0A45-02S06	●	2	0°	11.8	9.3	5.0	1.2	2.0	S06	11.20	*KEYV-S08	10

- Available for chamfering of reverse side
- * Some heads require different size of wrench.

VCR

2 flutes, 0° helix, for concave radius milling



ap = Max. depth of cut
S = Connection screw size

Cat. No.	Grade AH725	No. of flutes	Helix angle	Dimensions (mm)							Wrench	Torque (N·m)
				øDc	ød1	ød	ap	r	S	L		
VCR080L07.5R10-02S05	●	2	0°	8.0	7.6	5.8	7.5	1.0	S05	10.5	KEYV-S05	7
VCR100L09.5R16-02S06	●	2	0°	10.0	9.5	6.8	9.5	1.6	S06	12.5	KEYV-S06	10
VCR100L09.5R25-02S06	●	2	0°	10.0	9.5	5.1	9.5	2.5	S06	12.5		
VCR127L12.0R30-02S08	●	2	0°	12.7	12.2	6.5	12	3.0	S08	15.6	KEYV-S08	15
VCR127L12.0R40-02S08	●	2	0°	12.7	12.2	4.7	12	4.0	S08	15.6		
VCR160L15.0R50-02S10	●	2	0°	16.0	15.2	6.2	15	5.0	S10	19.1	KEYV-S10	28
VCR200L07.0R60-02S12	●	2	0°	20.0	18.3	8.0	7.0	6.0	S12	17.4	KEYV-S12	28

● : Stocked items
Packing Quantity = 2 pcs.

Standard cutting conditions: Chamfering and countersinking (VCA, VCW, VCR, VCP)

Work materials	Hardness	Cutting speed Vc (m/min)	Feed per tooth f (mm/t)
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300 HB	80 (60-100)	0.09 (0.06-0.12)
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300 HB	60 (50-80)	0.09 (0.06-0.12)
Prehardened steel PX5, NAK80 etc	30 ~ 40 HRC	50 (40-70)	0.09 (0.06-0.12)
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200 HB	40 (30-50)	0.09 (0.06-0.12)
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250 HB	100 (80-120)	0.09 (0.06-0.12)
Ductile cast irons FCD400 etc (GGG40 etc)			0.09 (0.06-0.12)
Aluminium alloys	-	150 (100-200)	0.1 (0.08-0.15)
Titanium alloys Ti-6Al-4V etc	-	40 (30-50)	0.07 (0.05-0.10)
Heat-resistant alloys Inconel 718 etc	-	30 (20-40)	0.06 (0.04-0.08)
Hardened steel SKD61, SKT4 etc (X40CrMoV5 1, 55NiCrMoV6 etc)	40 ~ 50 HRC	40 (30-50)	0.07 (0.05-0.10)
Hardened steel SKD11, SKH etc (X153CrMoV12, HS18-0-1 etc)	50 ~ 60 HRC	30 (20-40)	0.06 (0.04-0.08)

Tolerance of tool diameter

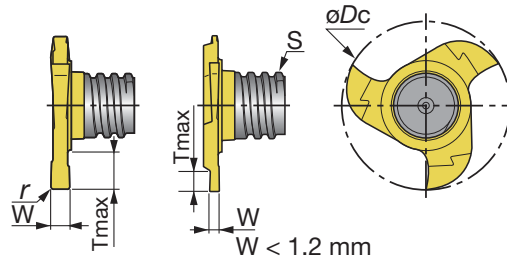
Basic dimensions (mm)		Permissible dimensional deviations (µm)						
>	≤	e8	e9	h6	h7	h9	h10	z9
6	10	-25 -47	-25 -61	0 -9	0 -15	0 -36	0 -58	+78 +42
10	14	-32 -59	-32 -75	0 -11	0 -18	0 -43	0 -70	+93 +50
14	18	-32 -59	-32 -75	0 -11	0 -18	0 -43	0 -70	+103 +60
18	30	-40 -73	-40 -92	0 -13	0 -21	0 -52	0 -84	-

● JISB0401-2: 1998 (ISO286-2: 1988) extract

● Slotting

VST

3 flutes, for slotting



S = Connection screw size

Cat. No.	Grade GH130	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				øDc	W ^{±0.02}	r	S	Tmax		
VST157W1.50R010-3S06	●	3	-	15.7	1.50	0.10	S06	2.8	KEYV-177	10
VST157W1.57R020-3S06	●	3	-	15.7	1.57	0.20	S06	2.8		
VST157W2.00R020-3S06	●	3	-	15.7	2.00	0.20	S06	2.8		
VST157W2.39R020-3S06	●	3	-	15.7	2.39	0.20	S06	2.8		
VST157W2.50R020-3S06	●	3	-	15.7	2.50	0.20	S06	2.8		
VST157W3.00R020-3S06	●	3	-	15.7	3.00	0.20	S06	2.8		
VST157W3.17R020-3S06	●	3	-	15.7	3.17	0.20	S06	2.8		
VST177W1.20R005-3S06	●	3	-	17.7	1.20 ⁽¹⁾	0.05	S06	3.8		
VST177W1.40R005-3S06	●	3	-	17.7	1.40 ⁽¹⁾	0.05	S06	3.8		
VST177W1.50R010-3S06	●	3	-	17.7	1.50	0.10	S06	3.8		
VST177W1.57R020-3S06	●	3	-	17.7	1.57	0.20	S06	3.8		
VST177W1.70R005-3S06	●	3	-	17.7	1.70 ⁽¹⁾	0.05	S06	3.8		
VST177W2.00R020-3S06	●	3	-	17.7	2.00	0.20	S06	3.8		
VST177W2.20R110-3S06	●	3	-	17.7	2.20	1.10	S06	3.8		
VST177W2.39R020-3S06	●	3	-	17.7	2.39	0.20	S06	3.8		
VST177W2.50R020-3S06	●	3	-	17.7	2.50	0.20	S06	3.8		
VST177W3.00R020-3S06	●	3	-	17.7	3.00	0.20	S06	3.8		
VST177W3.17R020-3S06	●	3	-	17.7	3.17	0.20	S06	3.8		

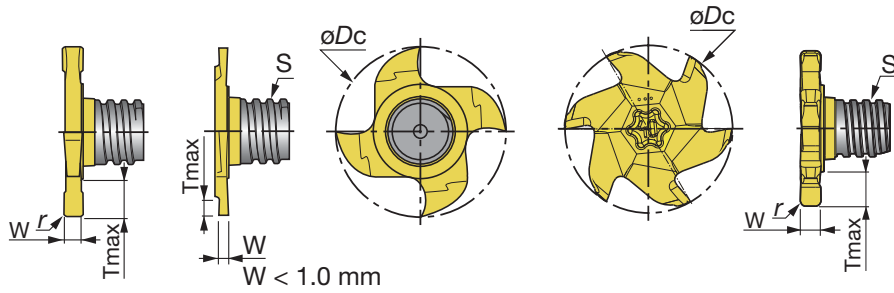
(1) W is based on DIN471 / 472

● : Stocked items
Packing Quantity = 2 pcs.

Slotting

VST

4 / 6 flutes, for slotting



S = Connection screw size

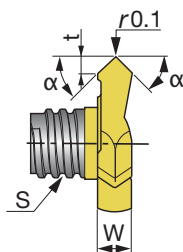
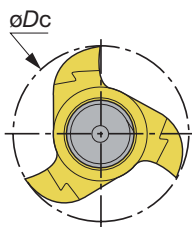
Cat. No.	Grade GH130	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				øDc	W±0.02	r	S	Tmax		
VST217W0.76R000-4S08	●	4	-	21.7	0.76 ⁽¹⁾	0.00	S08	1.5	KEYV-217	15
VST217W0.86R000-4S08	●	4	-	21.7	0.86 ⁽¹⁾	0.00	S08	1.7		
VST217W0.96R000-4S08	●	4	-	21.7	0.96 ⁽¹⁾	0.00	S08	1.9		
VST217W1.00R005-4S08	●	4	-	21.7	1.00	0.05	S08	2.0		
VST217W1.20R005-4S08	●	4	-	21.7	1.20 ⁽¹⁾	0.05	S08	4.5		
VST217W1.40R005-4S08	●	4	-	21.7	1.40 ⁽¹⁾	0.05	S08	4.5		
VST217W1.57R000-4S08	●	4	-	21.7	1.57	0.00	S08	4.5		
VST217W1.70R010-4S08	●	4	-	21.7	1.70 ⁽¹⁾	0.10	S08	4.5		
VST217W1.95R020-4S08	●	4	-	21.7	1.95 ⁽¹⁾	0.20	S08	4.5		
VST217W2.00R020-4S08	●	4	-	21.7	2.00	0.20	S08	4.5		
VST217W2.25R020-4S08	●	4	-	21.7	2.25 ⁽¹⁾	0.20	S08	4.5		
VST217W2.39R020-4S08	●	4	-	21.7	2.39	0.20	S08	4.5		
VST217W2.50R020-4S08	●	4	-	21.7	2.50	0.20	S08	4.5		
VST217W2.75R020-4S08	●	4	-	21.7	2.75 ⁽¹⁾	0.20	S08	4.5		
VST217W3.00R020-4S08	●	4	-	21.7	3.00	0.20	S08	4.5		
VST217W3.17R020-4S08	●	4	-	21.7	3.17	0.20	S08	4.5		
VST217W3.25R020-4S08	●	4	-	21.7	3.25 ⁽¹⁾	0.20	S08	4.5		
VST217W4.00R020-4S08	●	4	-	21.7	4.00	0.20	S08	4.5		
VST217W4.25R020-4S08	●	4	-	21.7	4.25 ⁽¹⁾	0.20	S08	4.5		
VST217W4.75R020-4S08	●	4	-	21.7	4.75	0.20	S08	4.5		
VST217W5.25R020-4S08	●	4	-	21.7	5.25 ⁽¹⁾	0.20	S08	4.5		
VST277W2.50R020-6S10	●	6	-	27.7	2.50	0.20	S10	6.0	KEYV-T40L	28
VST277W5.25R020-6S10	●	6	-	27.7	5.25	0.20	S10	6.0		
VST277W10.0R020-6S10	●	6	-	27.7	10.00	0.20	S10	6.0		

(1) W is based on DIN471 / 472

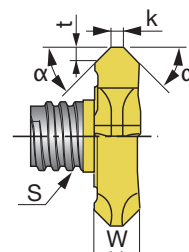
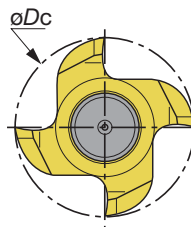
VST-A45

3 / 4 flutes, for chamfering

VST177



VST217



S = Connection screw size

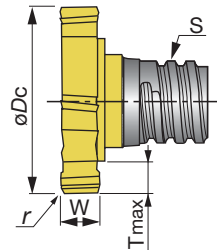
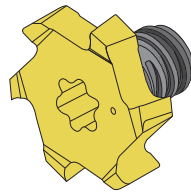
Cat. No.	Grade GH130	No. of flutes	Helix angle	Dimensions (mm)						Wrench	Torque (N·m)
				øDc	W	α	S	t	k		
VST177L01.40A45-3S06	●	3	-	17.7	3.40	45°	S06	1.4	-	KEYV-177	10
VST217L01.70A45-4S08	●	4	-	21.7	5.50	45°	S08	1.7	1.5	KEYV-217	15

● : Stocked items
Packing Quantity = 2 pcs.

Slotting

VTB

6 flutes, for slotting

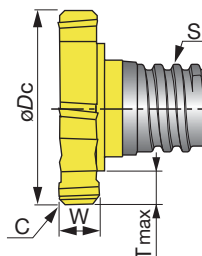
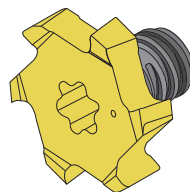


S = Connection screw size

Cat. No.	Grade GH130	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				$\varnothing Dc_{-0.05}^0$	$W_{\pm 0.02}$	T_{max}	S	r		
VTB135W3.00R04-06S05	●	6	-	13.5	3	2.65	S05	0.4	KEYV-T20	7
VTB135W4.00R04-06S05	●	6	-	13.5	4	2.65	S05	0.4		
VTB160W2.00R04-06S06	●	6	-	16.0	2	2.90	S06	0.4	KEYV-T25	10
VTB160W3.00R04-06S06	●	6	-	16.0	3	2.90	S06	0.4		
VTB160W4.00R04-06S06	●	6	-	16.0	4	2.90	S06	0.4		
VTB165W2.00R04-06S06	●	6	-	16.5	2	3.15	S06	0.4	KEYV-T20	
VTB165W3.00R04-06S06	●	6	-	16.5	3	3.15	S06	0.4	KEYV-T25	
VTB165W4.00R04-06S06	●	6	-	16.5	4	3.15	S06	0.4		
VTB195W4.00R04-06S08	●	6	-	19.5	4	3.45	S08	0.4	KEYV-T30L	15
VTB195W5.00R04-06S08	●	6	-	19.5	5	3.45	S08	0.4		
VTB195W6.00R04-06S08	●	6	-	19.5	6	3.45	S08	0.4		
VTB225W5.00R04-06S08	●	6	-	22.5	5	4.95	S08	0.4	KEYV-T40L	
VTB225W6.00R04-06S08	●	6	-	22.5	6	4.95	S08	0.4		
VTB225W8.00R04-06S08	●	6	-	22.5	8	4.95	S08	0.4		
VTB250W6.00R04-06S08	●	6	-	25.0	6	5.90	S08	0.4	KEYV-T50L	28
VTB250W8.00R04-06S08	●	6	-	25.0	8	5.90	S08	0.4		
VTB250W5.00R04-06S10	●	6	-	25.0	5	4.30	S10	0.4		
VTB250W6.00R04-06S10	●	6	-	25.0	6	4.30	S10	0.4		
VTB250W8.00R04-06S10	●	6	-	25.0	8	4.30	S10	0.4		

VTB-15

6 flutes, for chamfered slotting



S = Connection screw size

Cat. No.	Grade GH130	No. of flutes	Helix angle	Dimensions (mm)					Wrench	Torque (N·m)
				$\varnothing Dc_{-0.05}^0$	$W_{\pm 0.05}$	T_{max}	S	C		
VTB135W2.00C15-06S05	●	6	-	13.5	2.0	2.65	S05	0.15	KEYV-T20	7

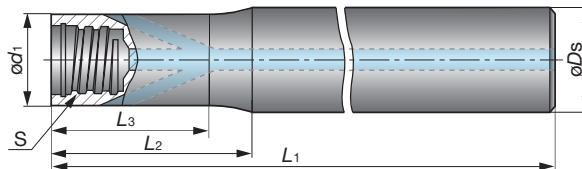
● : Stocked items
Packing Quantity = 2 pcs.

■ Standard cutting conditions: Slotting (VST, VTB)

Work materials	Hardness (HB)	VST type		VTB type	
		Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
Low carbon steels S45C, S55C etc (C45, C55 etc)	~ 300	130 (80-180)	0.10 (0.05-0.15)	130 (80-180)	0.13 (0.08-0.18)
High carbon steels SCM440, SCr415 etc (42CrMo4, 15Cr3 etc)	~ 300	90 (60-120)	0.08 (0.04-0.12)	90 (60-120)	0.10 (0.05-0.15)
Stainless steels SUS304, SUS316 etc (X5CrNi18-9, X5CrNiMo17-12-2 etc)	~ 200	80 (50-120)	0.08 (0.04-0.12)	80 (50-120)	0.10 (0.05-0.15)
Grey cast irons FC250, FC300 etc (GG25, GG30 etc)	150 ~ 250	150 (100-200)	0.10 (0.05-0.15)	150 (100-200)	0.13 (0.08-0.18)
Ductile cast irons FCD400 etc (GGG40 etc)			0.08 (0.04-0.12)		0.10 (0.05-0.15)
Aluminium alloys (Si < 13%)	-	300 (200-600)	0.10 (0.05-0.15)	300 (200-600)	0.13 (0.08-0.18)
Aluminium alloys (Si ≥ 13%)	-	200 (100-300)	0.08 (0.03-0.13)	200 (100-300)	0.10 (0.05-0.15)
Titanium alloys Ti-6Al-4V etc	-	50 (40-60)	0.08 (0.04-0.12)	50 (40-60)	0.10 (0.05-0.15)
Heat-resistant alloys Inconel 718 etc	-	25 (15-35)	0.06 (0.02-0.10)	25 (15-35)	0.06 (0.02-0.10)

Shanks

VSSD-W-A Straight shank and neck with coolant hole



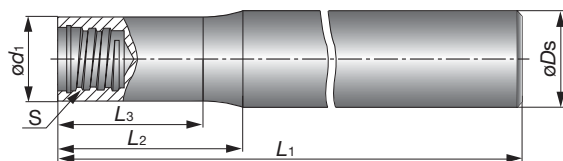
S = Connection screw size

Cat. No.	Stock	Dimensions (mm)						Shank material
		øDs	ød1	L1	L2	L3	S	
VSSD10L070S06-W-A	●	10	9.6	70	20	19	S06	Tungsten
VSSD10L090S06-W-A	●	10	9.6	90	40	39	S06	
VSSD10L110S06-W-A	●	10	9.6	110	60	59	S06	
VSSD12L070S08-W-A	●	12	11.5	70	20	19	S08	
VSSD12L090S08-W-A	●	12	11.5	90	40	39	S08	
VSSD12L110S08-W-A	●	12	11.5	110	60	59	S08	
VSSD12L130S08-W-A	●	12	11.5	130	80	79	S08	
VSSD16L070S10-W-A	●	16	15.2	70	20	18.5	S10	
VSSD16L090S10-W-A	●	16	15.2	90	40	36.5	S10	
VSSD16L110S10-W-A	●	16	15.2	110	60	58.5	S10	
VSSD16L130S10-W-A	●	16	15.2	130	80	78.5	S10	
VSSD20L090S12-W-A	●	20	18.3	90	40	37	S12	
VSSD20L130S12-W-A	●	20	18.3	130	80	77	S12	

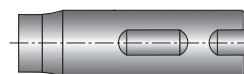
● : Stocked items

VSSD
Straight shank and neck

Cylindrical type



Weldon type

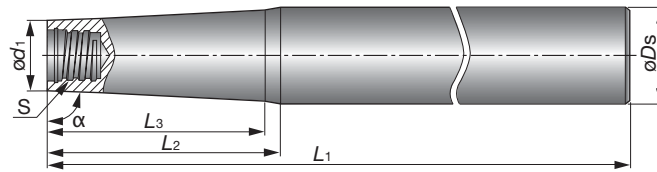


S = Connection screw size

Cat. No.	Stock	Dimensions (mm)						Shank style	Shank material
		$\varnothing D_s$	$\varnothing d_1$	L_1	L_2	L_3	S		
VSSD08L060S05-S	●	8	7.6	60	15	12.5	S05	Cylindrical	Steel
VSSD10L075S06-S	●	10	9.6	75	20	17.5	S06		
VSSD12L090S08-S	●	12	11.5	90	16	13.5	S08		
VSSD16L100S10-S	●	16	15.2	100	20	18	S10		
VSSD20L120S12-S	●	20	18.3	120	25	20.5	S12		
VSSD08L070S05-C	●	8	7.6	70	20	18.5	S05	Cylindrical	Carbide
VSSD08L090S05-C	●	8	7.6	90	40	38.5	S05		
VSSD08L110S05-C	●	8	7.6	110	60	58.5	S05		
VSSD10L070S06-C	●	10	9.6	70	20	18.5	S06		
VSSD10L090S06-C	●	10	9.6	90	40	38.5	S06		
VSSD10L110S06-C	●	10	9.6	110	60	58.5	S06		
VSSD10L150S06-C	●	10	9.6	150	100	98.5	S06		
VSSD12L070S08-C	●	12	11.5	70	20	18	S08		
VSSD12L090S08-C	●	12	11.5	90	40	38	S08		
VSSD12L110S08-C	●	12	11.5	110	60	58	S08		
VSSD12L130S08-C	●	12	11.5	130	80	78	S08		
VSSD16L090S10-C	●	16	15.2	90	40	38	S10		
VSSD16L110S10-C	●	16	15.2	110	60	58	S10		
VSSD16L130S10-C	●	16	15.2	130	80	78	S10		
VSSD16L150S10-C	●	16	15.2	150	100	98	S10		
VSSD20L090S12-C	●	20	18.3	90	40	37	S12		
VSSD20L130S12-C	●	20	18.3	130	80	77	S12		
VSSD20L200S12-C	●	20	18.3	200	120	117	S12		
VSSD12L055W05-S	●	12	7.6	55	3.8	-	S05	Weldon	Steel
VSSD16L065W06-S	●	16	9.5	65	6	-	S06		
VSSD16L065W08-S	●	16	11.5	65	4	-	S08		
VSSD20L070W10-S	●	20	15.2	70	4	-	S10		
VSSD25L075W12-S	●	25	18.3	75	7.2	-	S12		

● : Stocked items

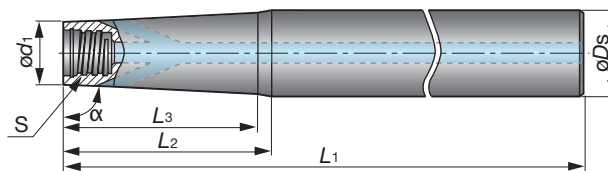
VTSD Straight shank and taper neck



S = Connection screw size

Cat. No.	Stock	Dimensions (mm)							Shank material	
		α	ϕD_s	ϕd_1	L_1	L_2	L_3	S		
VTSD12L080S05-S	●	85°	12	7.6	80	25	-	S05	Steel	
VTSD12L100S05-S	●	89°	12	7.6	100	35	29	S05		
VTSD16L125S06-S	●	85°	16	9.6	125	34	31	S06		
VTSD16L160S06-S	●	89°	16	9.6	160	55	46.5	S06		
VTSD16L140S08-S	●	85°	16	11.5	140	22	19	S08		
VTSD20L170S08-S	●	89°	20	11.5	170	80	69.5	S08		
VTSD20L140S10-S	●	85°	20	15.2	140	27.5	-	S10		
VTSD25L170S10-S	●	85°	25	15.2	170	56	-	S10		
VTSD20L190S10-S	●	89°	20	15.2	190	80	73	S10		
VTSD25L160S12-S	●	85°	25	18.3	160	40	-	S12		
VTSD32L190S12-S	●	85°	32	18.3	190	80	-	S12		
VTSD25L210S12-S	●	89°	25	18.3	210	100	94.5	S12		
VTSD12L110S05-C	●	89°	12	7.6	110	60	56	S05		Carbide
VTSD12L130S05-C	●	89°	12	7.6	130	80	77	S05		
VTSD16L150S05-C	●	89°	16	7.6	150	100	91	S05		
VTSD16L150S06-C	●	89°	16	9.6	150	100	98	S06		
VTSD16L170S06-C	●	89°	16	9.6	170	120	116.5	S06		
VTSD16L130S08-C	●	89°	16	11.5	130	80	76.5	S08		
VTSD16L150S08-C	●	89°	16	11.5	150	100	98	S08		
VTSD20L170S08-C	●	89°	20	11.5	170	120	112	S08		
VTSD20L170S10-C	●	89°	20	15.2	170	120	119	S10		
VTSD20L190S10-C	●	89°	20	15.2	190	140	-	S10		
VTSD20L210S10-C	●	89°	20	15.2	210	160	-	S10		
VTSD25L180S12-C	●	89°	25	18.3	180	120	115	S12		
VTSD25L250S12-C	●	89°	25	18.3	250	140	136.5	S12		

VTSD-W-A Straight shank and taper neck with coolant hole



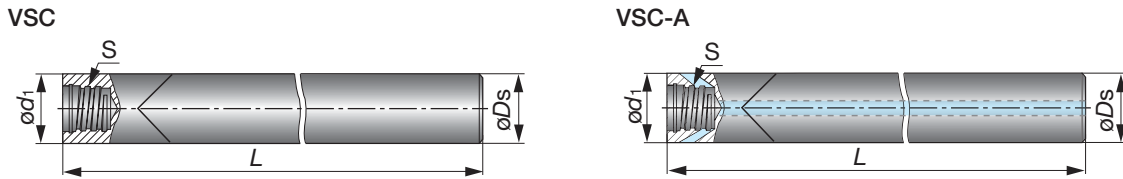
S = Connection screw size

Cat. No.	Stock	Dimensions (mm)							Shank material
		α	ϕD_s	ϕd_1	L_1	L_2	L_3	S	
VTSD12L110S06-W-A	●	89°	12	9.6	110	60	59	S06	Tungsten
VTSD16L170S06-W-A	●	89°	16	9.6	170	120	116	S06	

● : Stocked items

VSC

Straight shank for VST type slotting heads



S = Connection screw size

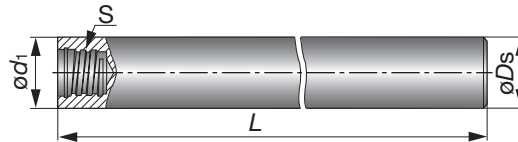
Cat. No.	Stock	Dimensions (mm)				Coolant hole	Shank material
		ϕD_s	ϕd_1	L	S		
VSC100L100S06-C	●	10	10	100	S06	without	Carbide
VSC120L100S08-C-A	●	12	12	100	S08	with	

Note:

- For VSC-C type shank, just VST slotting head is recommended. If other heads are used on the VSC-C shank, the depth of cut must be smaller than the max. ap in each head. The VSC-C type shank does not have external clearance, so the shank may interfere with the work piece.

VSTD

Straight shank for VTB type slotting heads



S = Connection screw size

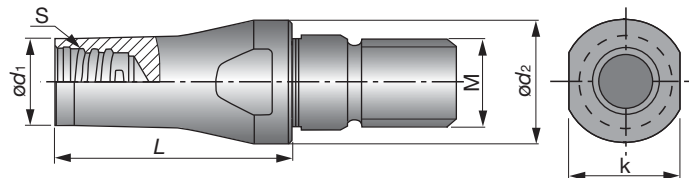
Cat. No.	Stock	Dimensions (mm)				Shank material
		ϕD_s	ϕd_1	L	S	
VSTD08L070S05-S	●	8	8	70	S05	Steel
VSTD10L080S06-S	●	10	10	80	S06	
VSTD12L090S08-S	●	12	12	90	S08	
VSTD16L100S10-S	●	16	16	100	S10	

Note:

- For VSTD type shank, just VTB grooving head is recommended. If other heads are used on the VSTD shank, the depth of cut must be smaller than the max. ap in each head. The VSTD type shank does not have external clearance, so the shank may interfere with the work piece.

VAD-M

Adapters of TungFlex



S = Connection screw size

Cat. No.	Stock	Dimensions (mm)						Shank material
		ϕd_1	ϕd_2	L	S	M	k	
VAD130L016S08-S-M8	●	11.7	13	16	S08	M8	11	Steel
VAD130L025S08-S-M8	●	11.7	13	25	S08	M8	11	
VAD180L020S08-S-M10	●	11.7	18	20	S08	M10	13	
VAD180L025S08-S-M10	●	11.7	18	25	S08	M10	11	
VAD210L020S08-S-M12	●	11.7	21	20	S08	M12	12.75	
VAD210L025S08-S-M12	●	11.7	21	25	S08	M12	12.75	

● : Stocked items

Designation system

● Shank

V SS D10 L070 S 06 - W - A

1 2 3 4 5 6 7 8

1 Series	
V	TungMeister

2 Shank type	
SS	Straight neck
TS	Taper neck
SC	Slotting
ST	for T-Slotting
AD	TungFlex adapter

3 Shank diameter (mm)	
D08	ø8
D10	ø10
D12	ø12
D16	ø16
D20	ø20
D25	ø25
VSC, VAD type	
100	ø10
120	ø12
130	ø13
180	ø18
210	ø21

4 Length (mm)	
L070	70

5 Shape of shank	
S	Cylindrical
W	Weldon

6 Connection screw size	
05	S05
06	S06
08	S08
10	S10
12	S12

7 Shank material	
S	Steel
C	Carbide
W	Tungsten

8 Additional feature	
A	with coolant hole
M	Thread size (TungFlex adapters)

● Head

● Square endmill

V E E 080 L05.0 R00 - 03 S05

1 2 3 4 5 6 7 8 9

● Ball nose endmill

V B D 200 L15.0 - BG - 04 S12

1 2 3 4 5 6 7 8 9

1 Series	
V	TungMeister

2 Cutting edge	
E	Square
B	Ball
R	Radius
FX	for high feed
CA	for chamfering
CP	Spot drilling
CW	for chamfering (front and back)
CR	for R chamfering
GC	for counter boring
DP	for center drilling
S	for slotting
T	for T-slot milling

3 Helix angle / Rake face	
B	0°
C	15°
D	30°
E	38° ~ 50°
F	60°
T	Land

4 Diameter (mm)	
060	ø6
200	ø20

5 Cutting edge length (mm)	
Length	
L07.0	7
L15.0	15
Groove width	
W1.50	1.5
W1.57	1.57
W10.0	10




6 Corner shape / Angle	
Nose radius	
R00	Sharp edge
R005	R0.05
R01	R0.1
R05	R0.5
R10	R1.0
Chamfer type	
C15	0.15 x 45°
C30	0.3 x 45°
C60	0.6 x 45°
Chamfering head	
A30	30°
A60	60°
R chamfering head	
R10	R1.0
R16	R1.6
Ball nose	
SG	Sphere / high precision
BM	Ball / general purpose
BG	Ball / high precision

7 Additional feature	
I	Irregular pitch
A	for aluminium
R	for roughing
C	Combined edge

8 The number of flutes	
General	
02	2
06	6
Grooving head VST type	
3	3
4	4

9 Connection screw size	
S05	S05
S06	S06
S08	S08
S10	S10
S12	S12

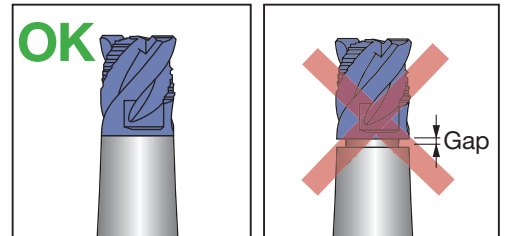
Wrench

Appearance	Cat. No.	Stock	Connection screw size	Torque (N-m)	Applicable head
	KEYV-S05	●	S05	7	Square Ball Radius Drilling Chamfering Counter boring
	KEYV-S06	●	S06	10	
	KEYV-S08	●	S08	15	
	KEYV-S10	●	S10	28	
	KEYV-S12	●	S12	28	
	KEYV-177	●	S06	10	Slotting VST type
	KEYV-217	●	S08	15	
	KEYV-T40L	●	S08 / S10	15	Slotting VST, VTB type
	KEYV-T20	●	S05	7	
			S06	10	
	KEYV-T25	●	S06	10	
	KEYV-T30L	●	S08	15	
KEYV-T50L	●	S08	28		
		S10			

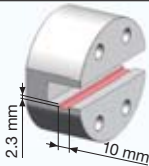
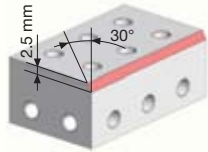
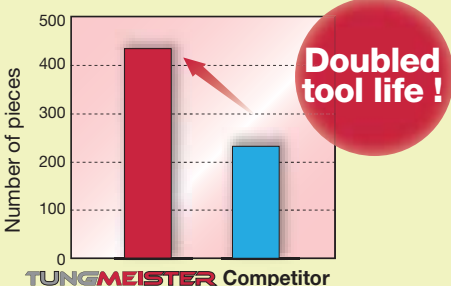
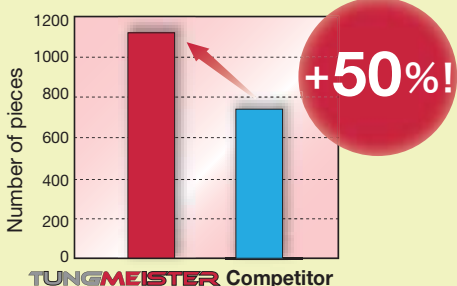
Note: Optional parts

CAUTIONARY POINTS IN USE

- The cutting heads specified by Tungaloy must be used. Avoid using alternate heads that are not Tungaloy products as this will damage the shank and can cause severe accident or injury.
- Before setting the head, clean the connection screw with an air blast or a wiping cloth to remove chips and other foreign matter that may remain.
- Do not apply the lubricant to the connection screw.
- Please use the correct "Wrench" with the correct cutting head. Tighten the head slowly until the face of the head contacts the shank. (Please refer to the picture shown on the right.) Re-tightening or over-tightening is not required. Excessive tightening may cause the cutting head to break.
- Do not apply excessive force or a hammer when tightening or exchanging the cutting heads.



Practical examples

Workpiece type		Machine parts	Machine parts
Shank		VSTD10L080S06-S (Steel, $\phi 10$)	VSSD16L100S10-S (Steel, $\phi 16$)
Head		VTB160W4.00R04-06S06 GH130 ($\phi 16$)	VCP160L15.0A30-02S10 AH725 ($\phi 16$)
Work material		Alloy steels SCM440 (42CrMo4)	Stainless steels SUS316 (X5CrNiMo17-12-2)
			
Cutting conditions	Cutting speed: V_c (m/min)	110	160
	Feed per tooth: f_z (mm/t)	0.07	0.1
	Depth of cut: a_p (mm)	2.3	2.5
	Width of cut: a_e (mm)	4 + 4 + 2	1.4
	Coolant	Dry	Dry
Results		 <p>Doubled tool life!</p> <p>TungMeister eliminates any need for regrinding.</p>	 <p>+50%!</p> <p>TungMeister reduces changeover time to 1/10 compared to competitor's solid endmill.</p>



Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima, 970-1144 Japan
Phone: +81-246-36-8501 Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394 Fax: +1-888-554-8392
www.tungaloyamerica.com

Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779 Fax: +1-519-758-5791
www.tungaloyamerica.com

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410 Fax: +52-449-929-5411
www.tungaloyamerica.com

Tungaloy do Brasil Comércio de Ferramentas de Corte Ltda.

Rua dos Sabias N.104
13280-000 Vinhedo, São Paulo, Brazil
Phone: +55-19-38262757 Fax: +55-19-38262757
www.tungaloy.co.jp/br

Tungaloy Germany GmbH

An der Alten Ziegelei 1
D-40789 Monheim, Germany
Phone: +49-2173-90420-0 Fax: +49-2173-90420-19
www.tungaloy.de

Tungaloy France S.A.S.

ZA Courtaboeuf - Le Rio, 1 rue de la Terre de feu
F-91952 Courtaboeuf Cedex, France
Phone: +33-1-6486-4300 Fax: +33-1-6907-7817
www.tungaloy.fr

Tungaloy Italia S.r.l.

Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1 Fax: +39-02-252012-65
www.tungaloy.it

Tungaloy Czech s.r.o

Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391 Fax: +420-532 123 392
www.tungaloy.cz

Tungaloy Ibérica S.L.

C/Miguel Servet, 43B, Nau 7, Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360 Fax: +34 93 876 2798
www.tungaloy.es

Tungaloy Scandinavia AB

S:t Lars Väg 42A
SE-22270 Lund, Sweden
Phone: +46-462119200 Fax: +46-462119207
www.tungaloy.se

Tungaloy Rus, LLC

36-G Kostukova str.
308012 Belgorod, Russia
Phone: +7 4722 58 57 57 Fax: +7 4722 58 57 83
www.tungaloy.co.jp/ru

Tungaloy Polska Sp. z o.o.

ul. Genewska 24
03-963 Warszawa, Poland
Phone: +48-22-617-0890 Fax: +48-22-617-0890
www.tungaloy.co.jp/pl

Tungaloy U.K. Ltd

The Technology Centre, Wolverhampton Science Park
Glaisher Drive, Wolverhampton, West Midlands WV10 9RU, UK
Phone: +44 121 309 0163 Fax: +44 121 270 9694
www.tungaloy.co.jp/uk salesinfo@tungaloyuk.co.uk

Tungaloy Hungary Kft

Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846 Fax: +36 1 781-6866
www.tungaloy.co.jp/hu info@tungaloytools.hu

Tungaloy Turkey

Dudullu Organize Sanayi Bolgesi DES
Sanayi Sitesi 1 Cadde Ticaret, Merkezi No. 3/7
34779 Umraniye Istanbul, Turkey
Phone: +90 216 540 04 67 Fax: +90 216 540 04 87
www.tungaloy.co.jp/tr info@tungaloy.com.tr

Tungaloy Cutting Tool (Shanghai) Co.,Ltd.

Rm No 401 No.88 Zhabei, Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880 Fax: +86-21-3621-1918
www.tungaloy.co.jp/tcts

Tungaloy Cutting Tool (Thailand) Co.,Ltd.

11th Floor, Sorachai Bldg. 23/7, Soi Sukhumvit 63
Klongtonnue, Wattana, Bangkok 10110, Thailand
Phone: +66-2-714-3130 Fax: +66-2-714-3134
www.tungaloy.co.th

Tungaloy Singapore (Pte.), Ltd.

31 Kaki Bukit Road 3, #05-19 TechLink
Singapore 417818
Phone: +65-6391-1833 Fax: +65-6299-4557
www.tungaloy.co.jp/tspl

Tungaloy India Pvt. Ltd.

Unit#13, B wing, 8th Floor, Kamala Mills Compound
Trade World, Lower Parel (West), Mumbai - 4000 13. India
Phone: +91-22-6124-8804 Fax: +91-22-6124-8899
www.tungaloy.co.jp/in

Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-cha
Beotkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161 Fax: +82-2-6393-8952
www.tungaloy.co.jp/krr

Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14, Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan, Malaysia
Phone: +603-7805-3222 Fax: +603-7804-8563
www.tungaloy.co.jp/my

Tungaloy Australia Pty Ltd

Unit 308/33 Lexington Drive
Bella Vista NSW 2153, Australia
Phone: +612-9672-6844 Fax: +612-9672-6866
www.tungaloy.co.jp/au

PT. Tungaloy Indonesia

Kompleks Grand Wisata Block AA-10 No.3-5 Cibitung
Bekasi 17510, Indonesia
Phone: +62-21-8261-5808 Fax: +62-21-8261-5809
www.tungaloy.co.jp/id

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