MITSUBISHI MATERIALS

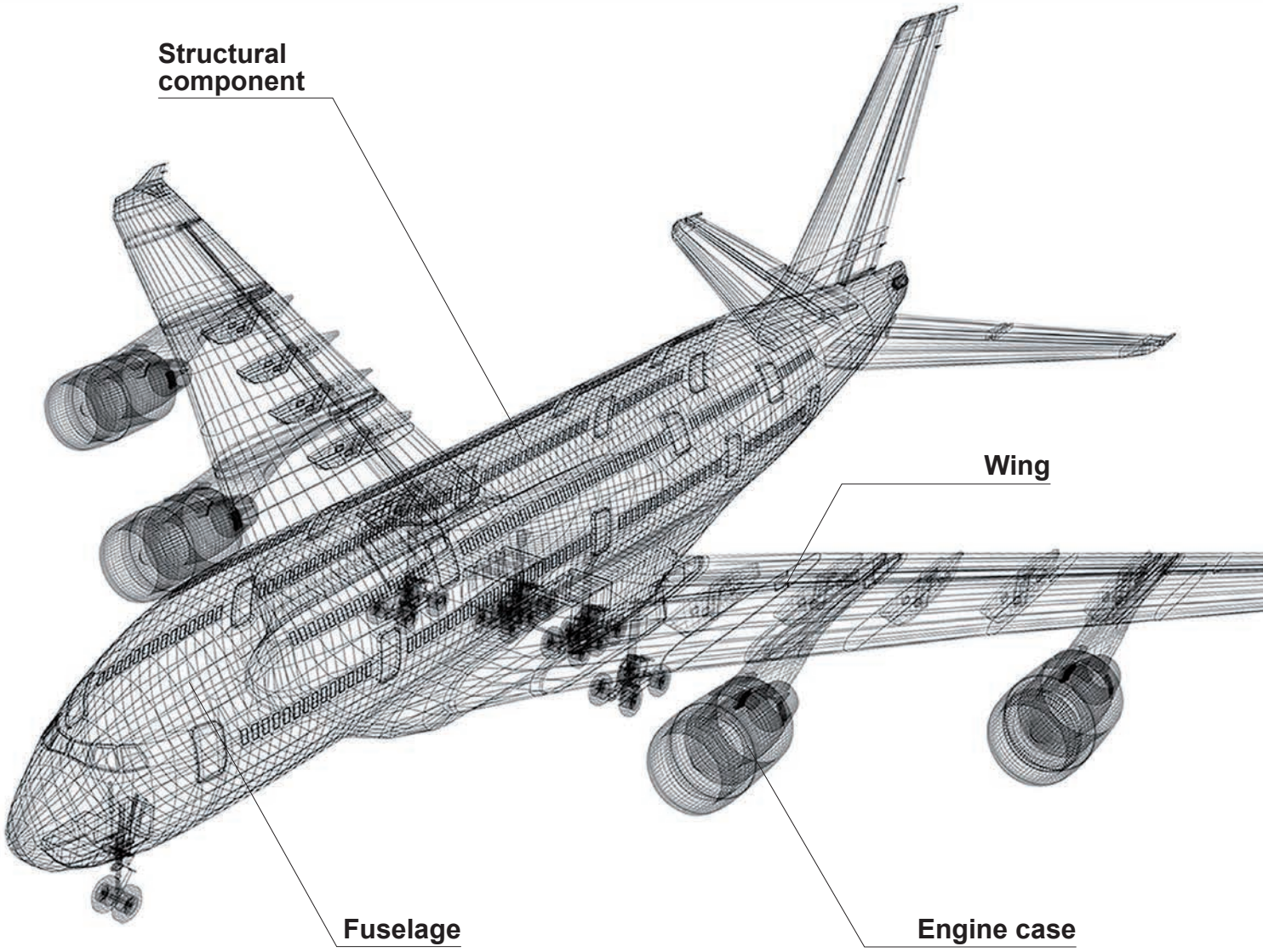
P713G

SOLUTIONS FOR COMPOSITE

SOLUTION

High strength carbon fiber is widely used in the aeronautic and bicycle frames and wind power generation blades for light extremely short due to the high strength. In addition, it is effective material machining where delamination and burr is liable to occur

AEROSPACE



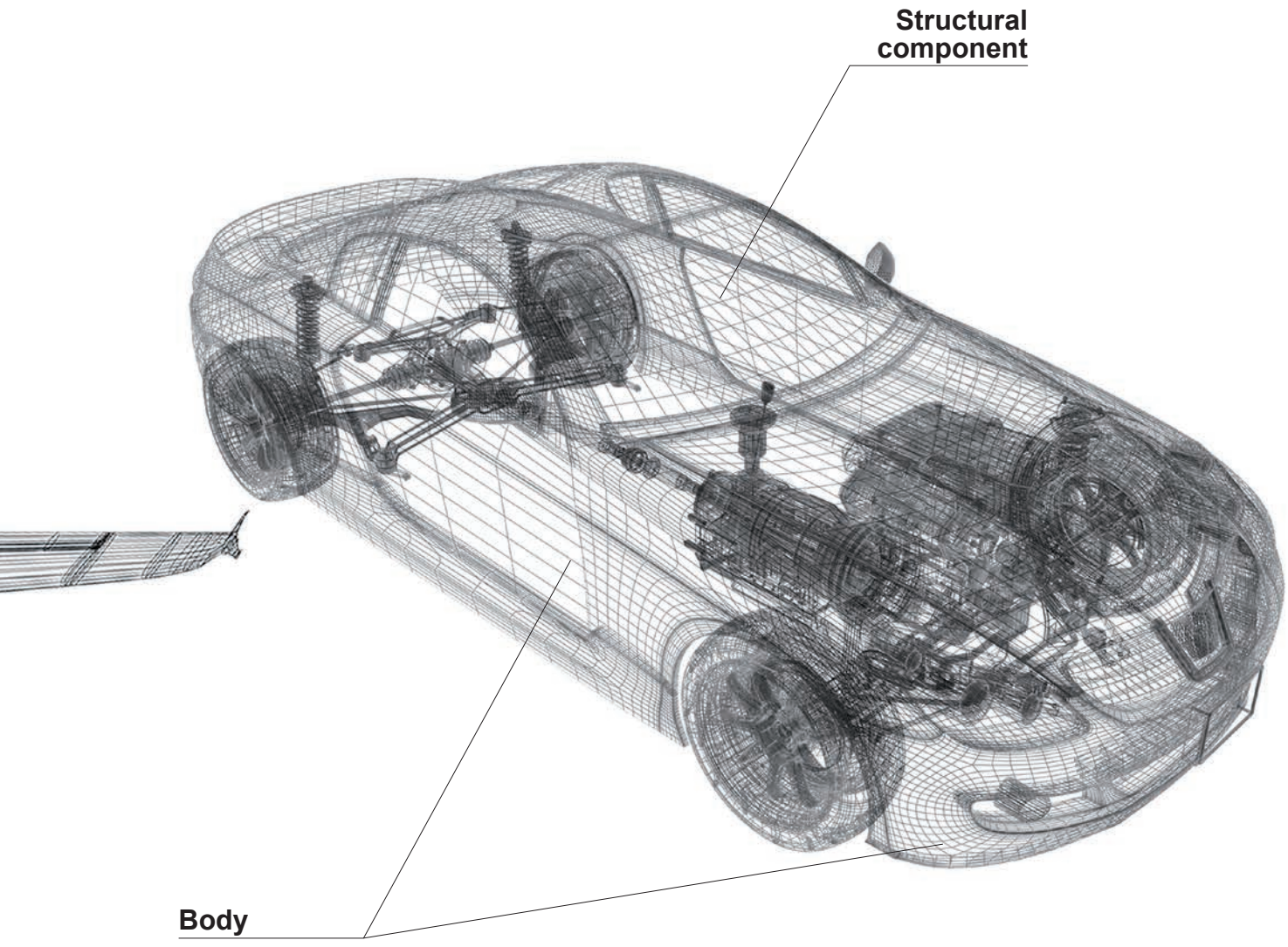
Drilling

The CVD diamond coating and cemented carbide drill equipped with an edge shape optimized by application and high abrasion resistance provide stability that minimizes burr and delamination.

FOR CFRP

automobile industries, as well as in wheelchairs, F1 chassis, structures that require strength. However, the life of such tools is to use tools with a high abrasion resistance coating in composite during cutting due to the laminate structure.

AUTOMOTIVE

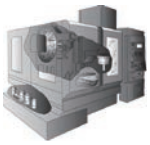
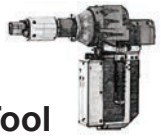
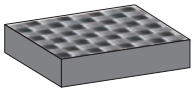
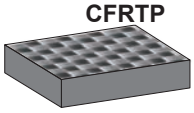
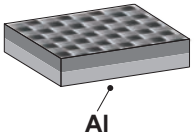
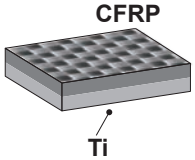
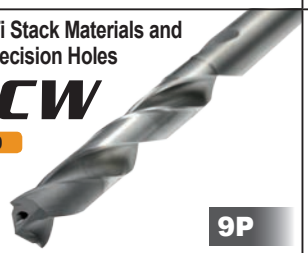


Trimming

The end mill that combines an optimized edge shape and high wear resistance CVD diamond coating maintains high quality.

DRILLING TOOLS

DRILL

	CNC 		Hand Tool 
CFRP  CFRTP 	**Standalone CFRP** **MCC** DD2105  5P The cutting edge angle = 90° setting minimizes cutting resistance in the thrust direction. This controls delamination and maintains good hole quality.	**For CFRP/CFRTP** **CFRP/Al Stack Materials and High Precision Holes** **MCW** DD2110  9P	**Hand Tool (Standalone CFRP)** **MCCH** DT2030  10P The hand tool ultra-hard substrate with enhanced strength prevents sudden breakages and maintains high-quality holes. The double angle design controls the thrust and enables a stable cutting speed even in hand tool machining.
CFRP Al 	**CFRP/Al Stack Materials** **MCA** DD2110  6P The groove design that wraps up chips also minimizes gaps of CFRP and aluminum hole diameter in addition to preventing contact between the chips and the CFRP hole wall surface.	The unique cutting edge shape with V-shaped grooves on the cutting edge controls the flow of chips generated at the outer circumference. Furthermore, this minimizes the hole diameter gaps in stack materials. Burr on the hole exit side is controlled by shifting the cutting load to the rotating shaft.	**CFRP/Al Stack Materials and Hand Tools** **MCAH** DT2030  10P The hand tool ultra-hard substrate with enhanced strength prevents sudden breakages and produces highly reliable hole machining. The combination of the groove shape and optimal twisting ensures compatibility of the aluminum chip dividing and discharging. This leads to stable hole machining even in CFRP and aluminum stack material machining.
CFRP Ti 	**CFRP/Ti Stack Materials** **MCT** TF15  8P The sharp cutting edge in titanium machining which requires good CFRP hole quality and machining that minimizes the generation of cutting heat with low thermal conductivity achieves high-quality CFRP and titanium stack material hole machining.	**CFRP/Ti Stack Materials and High Precision Holes** **MCW** HTi10  9P The unique cutting edge shape with V-shaped grooves on the cutting edge controls the flow of chips generated at the outer circumference. Furthermore, this minimizes the hole diameter gaps in stack materials. Burr on the hole exit side is controlled by shifting the cutting load to the rotating shaft.	

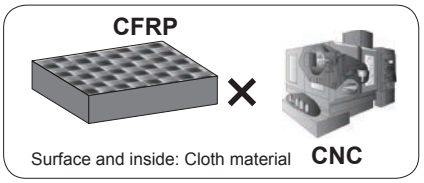
*CFRTP=Carbon Fiber Reinforced Thermoplastic Resin

END MILLS

Four Flutes

DFC4JC

The low resistance cutting edge with low helix angle reduces delamination and burrs when machining CFRP.

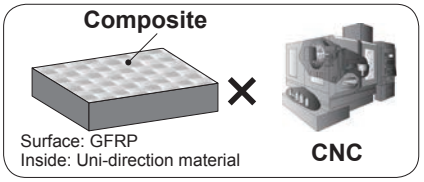


13P

Performance

DFCJRT

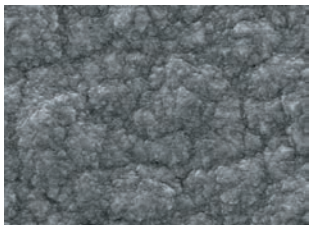
The cross-nick type cutting edge allows high efficiency machining due to lower cutting resistance and reduced temperatures.



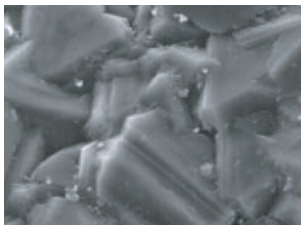
14P

Features

Proprietary CVD diamond coating



New coating grade

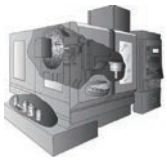


Conventional

The newly developed CVD diamond coated carbide material achieves outstanding abrasion resistance and smoothness due to a proprietary fine multilayer diamond crystal control technology.

DRILLING TOOLS

MCC



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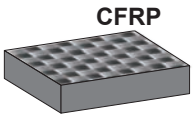
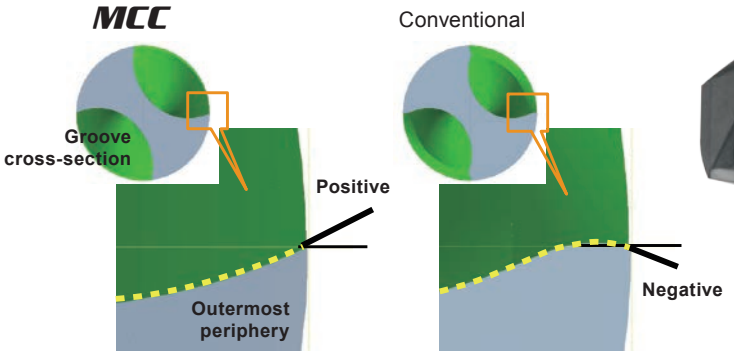


90° Cutting Edge Angle

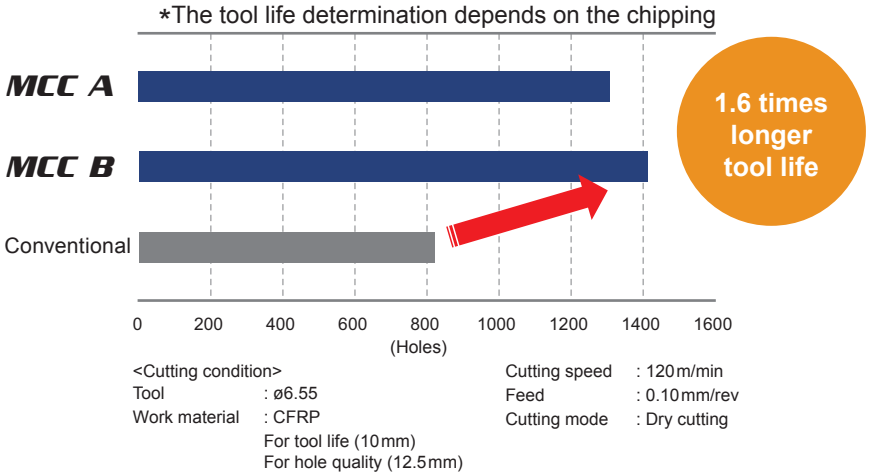
The acute cutting angle thoroughly reduces thrust and minimizes delamination.



Strong Rake Grooves

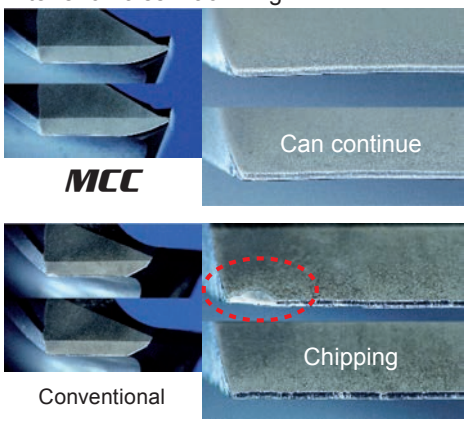
The cutting edge rake angle has been strengthened in the vertical direction on the axis of rotation. As a result, it is possible to minimize un-cutting and delamination on sharp cutting edges.

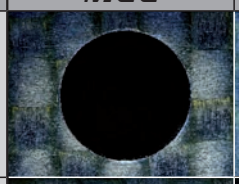
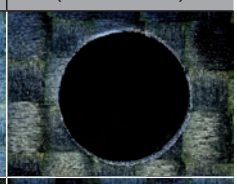
Comparison of Tool Life and Hole (Entrance/Exit)



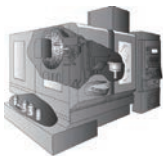
<Cutting condition>
Tool : ø6.55
Work material : CFRP
For tool life (10mm)
For hole quality (12.5mm)
Cutting speed : 120m/min
Feed : 0.10mm/rev
Cutting mode : Dry cutting

After 820 holes machining



	306 holes		588 holes		MCC (1192 holes)
	MCC	Conventional	MCC	Conventional	
Entrance					
Exit					

MCA



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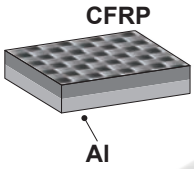
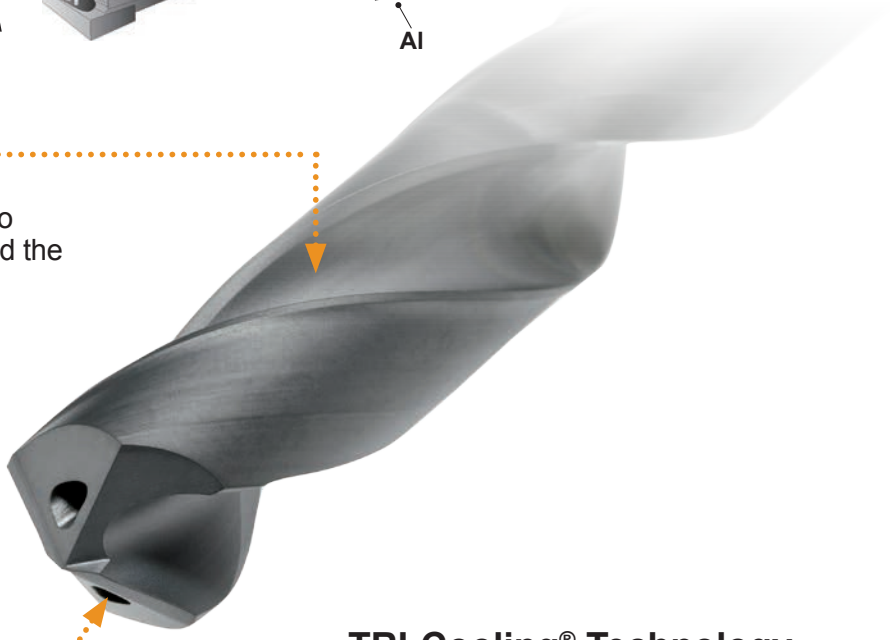


New Groove Structure

The groove design that covers up chips also minimizes back counter in addition to minimizing contact between the chips and the CFRP hole wall surface.

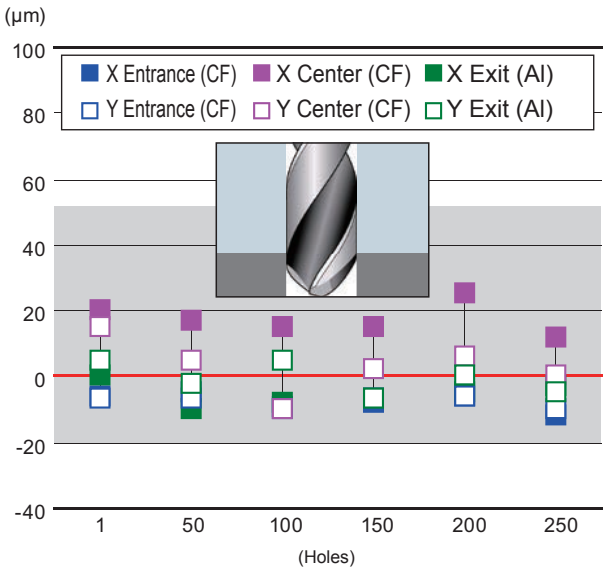


TRI-Cooling® Technology

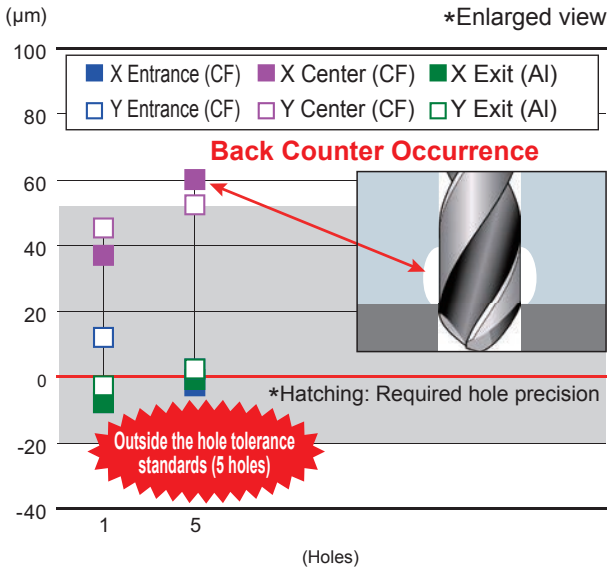
Controlling the cutting heat reduces deterioration of the CFRP hole precision caused by heat (improves the internal air effectiveness).

Groove Shape Effect

MCA



Conventional



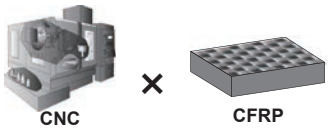
<Cutting condition>

Tool	: 2510"(ø6.38)	CF		Al	
Work material	: CF(11mm)+Al(5mm)	Cutting speed	: 100m/min	Cutting speed	: 100m/min
		Feed	: 0.15mm/rev	Feed	: 0.15mm/rev
				Cutting mode	: Internal air

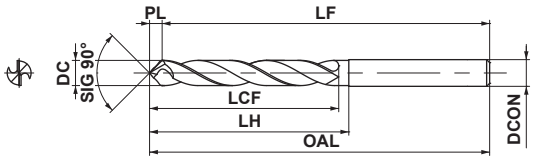
DRILLING TOOLS

MCC

Standalone CNC / CFRP



	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
h6	0 / −0.018	0 / −0.022	0 / −0.027	0 / −0.033
	0 / −0.008	0 / −0.009	0 / −0.011	0 / −0.013



Hole Dia.		Drill Dia.		Order Number	Grade	Dimensions (mm)					
AWG *	inch	DC (mm)	inch		DD2105	LCF	LH	OAL	LF	PL	DCON
—	3/16	4.76	.1875	**MCC0476X03S060**	★	40	40	80	77.6	2.4	6
—	1/4	6.38	.251	**MCC0638X03S080**	★	50	50	90	86.8	3.2	8
—	5/16	7.96	.3125	**MCC0796X03S080**	★	50	50	90	86	4	8
—	3/8	9.55	.375	**MCC0955X03S100**	★	50	50	100	95.2	4.8	10
—	7/16	11.14	.4375	**MCC1114X03S120**	★	60	60	110	104.4	5.6	12

★**AWG :** American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP			
Dia. DC (inch)	Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)
.1875	**4.76**	100	6700	0.08 (0.05—0.12)	540
.251	**6.38**	100	5000	0.1 (0.05—0.12)	500
.3125	**7.96**	100	4000	0.1 (0.05—0.12)	400
.375	**9.55**	100	3400	0.1 (0.05—0.12)	340
.4375	**11.14**	100	2900	0.1 (0.05—0.12)	290

★ **: Inventory maintained in Japan. (Available Spring 2017)** ☐ **: Non stock, produced to order only. (Available Spring 2017)**

MCA

CNC / CFRP + Al

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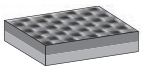
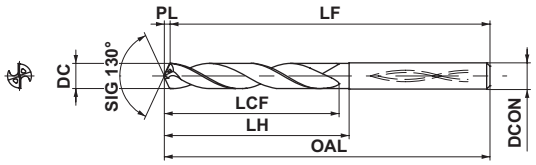


	3<DC≦6	6<DC≦10	10<DC≦18	18<DC≦20
h6	0 / −0.018	0 / −0.022	0 / −0.027	0 / −0.033
	0 / −0.008	0 / −0.009	0 / −0.011	0 / −0.013



Hole Dia.		Drill Dia.		Order Number	Grade	Dimensions (mm)					
AWG *	inch	DC (mm)	inch		DD2110	LCF	LH	OAL	LF	PL	DCON
—	1/4	6.38	.251	**MCA0638X05S070**	□	51	51	91	89.5	1.5	7
—	3/8	9.55	.375	**MCA0955X05S100**	□	77	77	118	115.8	2.2	10

∗**AWG :** American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP				Aluminum Alloy (Si<5%) A6061, A7075 etc.			
Dia. DC (inch)	Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)
.251	**6.38**	100	5000	0.15 (0.10—0.20)	750	100	5000	0.03 (0.02—0.04)	150
.375	**9.55**	100	3400	0.15 (0.10—0.20)	680	100	3400	0.03 (0.02—0.04)	100

MCT

CNC / CFRP + Ti

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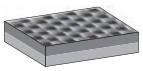
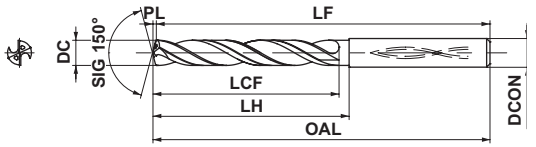


	3<DC≦6	6<DC≦10	10<DC≦18	18<DC≦20
h6	0 / −0.018	0 / −0.022	0 / −0.027	0 / −0.033
	0 / −0.008	0 / −0.009	0 / −0.011	0 / −0.013



Hole Dia.		Drill Dia.		Order Number	Grade	Dimensions (mm)					
AWG *	inch	DC (mm)	inch		TF15	LCF	LH	OAL	LF	PL	DCON
—	1/4	6.38	.251	**MCT0638X05S070**	□	47	47	96	95.1	0.9	7
—	3/8	9.55	.375	**MCT0955X05S100**	□	71	71	122	120.7	1.3	10

∗**AWG :** American Wire Gage

RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP				Titanium Alloy Ti-6Al-4V etc.				
Dia. DC (inch)	Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Peck machining (mm)
.251	**6.38**	100	5000	0.15 (0.10—0.20)	750	15	750	0.02 (0.01—0.03)	15	1
.375	**9.55**	100	3400	0.15 (0.10—0.20)	680	15	500	0.02 (0.01—0.03)	10	1

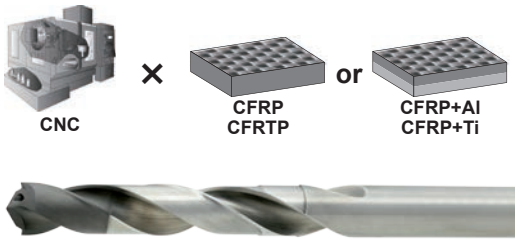
1) This condition is for when internal air or mist is used.

★ **: Inventory maintained in Japan. (Available Spring 2017)** □ **: Non stock, produced to order only. (Available Spring 2017)**

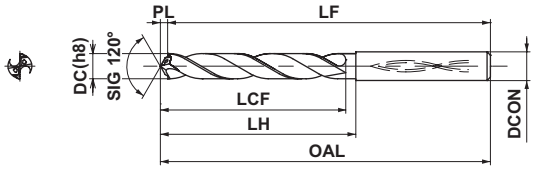
DRILLING TOOLS

MCW

Standalone CNC / CFRP and stack material high precision



	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
h6	0 −0.018	0 −0.022	0 −0.027	0 −0.033
	0 −0.008	0 −0.009	0 −0.011	0 −0.013



Hole Dia.		Drill Dia.		Order Number	Grade		Dimensions (mm)					
AWG *	inch	DC (mm)	inch		HTi10	DD2110	LCF	LH	OAL	LF	PL	DCON
—	1/4	6.38	.251	**MCW0638X05S070**	□		52	52	92	90.2	1.8	7
—	3/8	9.55	.375	**MCW0955X05S100**	□		73	73	119	116.2	2.8	10
—	1/4	6.38	.251	**MCW0638X05S070**		□	52	52	92	90.2	1.8	7
—	3/8	9.55	.375	**MCW0955X05S100**		□	73	73	119	116.2	2.8	10

∗**AWG :** American Wire Gage

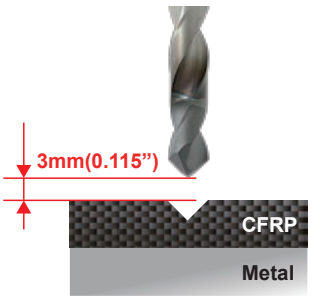
RECOMMENDED CUTTING CONDITIONS

Work Material		CFRP			
Dia. DC (inch)	Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)
.251	**6.38**	100	5000	0.15 (0.10—0.20)	750
.375	**9.55**	100	3400	0.15 (0.10—0.20)	680

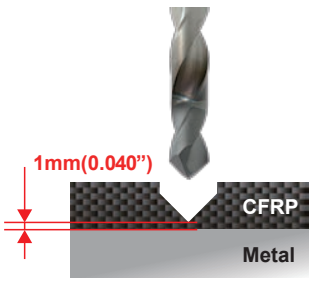
Work Material		Aluminum Alloy (Si<5%) A6061, A7075 etc.					Titanium Alloy Ti-6Al-4V etc.				
Dia. DC (inch)	Dia. DC (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Peck machining (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Peck machining (mm)
.251	**6.38**	100	5000	0.15 (0.10—0.20)	750	3	15	750	0.02 (0.01—0.03)	15	1
.375	**9.55**	100	3400	0.15 (0.10—0.20)	500	3	15	500	0.02 (0.01—0.03)	10	1

1) This condition is for when internal air or mist is used.
2) We recommend the same cutting conditions even in the case of dry machining.

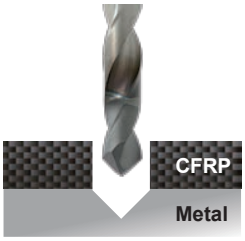
Peck Machining Method (Applicable for MCT and MCW)



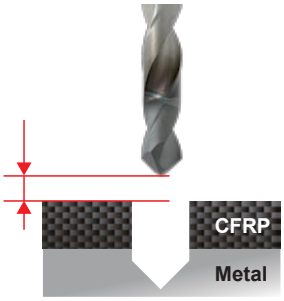
Set the machining start position to 3 mm above normal.



Refer to the recommend conditions for CFRP. Machine the cutting edge of the drill to at least 1 mm (0.040") before the metal.



Peck machine 3 mm (0.115") for aluminum and 1 mm (0.040") for titanium for the metal machining area.



Set it so that it returns to its start position during peck machining.

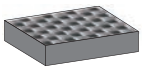
★ **: Inventory maintained in Japan. (Available Spring 2017)** □ **: Non stock, produced to order only. (Available Spring 2017)**

MCCH

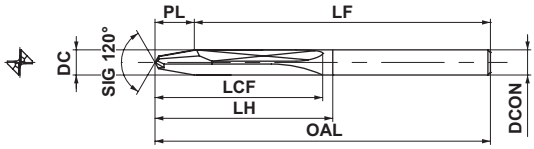
Hand tool / standalone CFRP


Hand Tool

×


CFRP

	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
	0 – 0.018	0 – 0.022	0 – 0.027	0 – 0.033
h6	0 – 0.008	0 – 0.009	0 – 0.011	0 – 0.013



Hole Dia.		Drill Dia.		Order Number	Grade	Dimensions (mm)					
AWG *	inch	DC (mm)	inch		DT2030	LCF	LH	OAL	LF	PL	DCON
#40	—	2.5	.0985	**MCCH0250X15S030**	★	50	50	100	95.4	4.6	3
#30	—	3.26	.1285	**MCCH0326X15S040**	★	50	50	100	94	6	4
#20	—	4.1	.1615	**MCCH0410X10S050**	★	50	50	100	92.5	7.5	5
#11	—	4.86	.1915	**MCCH0486X10S050**	★	50	50	100	91.1	8.9	5
—	1/4	6.38	.251	**MCCH0638X10S070**	★	50	50	100	88.3	11.7	7
—	3/8	9.55	.375	**MCCH0955X05S100**	★	50	50	100	82.5	17.5	10

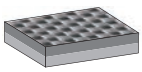
∗**AWG :** American Wire Gage

MCAH

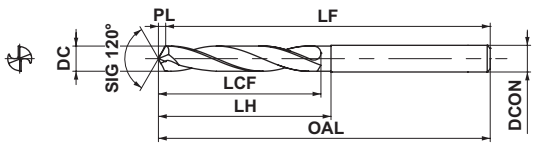
Hand tool / CFRP + Al


Hand Tool

×


CFRP+Al

	3<DC≤6	6<DC≤10	10<DC≤18	18<DC≤20
	0 – 0.018	0 – 0.022	0 – 0.027	0 – 0.033
h6	0 – 0.008	0 – 0.009	0 – 0.011	0 – 0.013



Hole Dia.		Drill Dia.		Order Number	Grade	Dimensions (mm)					
AWG *	inch	DC (mm)	inch		DT2030	LCF	LH	OAL	LF	PL	DCON
#40	—	2.5	.0985	**MCAH0250X15S030**	★	50	50	100	99.3	0.7	3
#30	—	3.26	.1285	**MCAH0326X15S040**	★	50	50	100	99.1	0.9	4
#20	—	4.1	.1615	**MCAH0410X10S050**	★	50	50	100	98.8	1.2	5
#11	—	4.86	.1915	**MCAH0486X10S050**	★	50	50	100	98.6	1.4	5
—	1/4	6.38	.251	**MCAH0638X10S070**	★	50	50	100	98.2	1.8	7
—	3/8	9.55	.375	**MCAH0955X05S100**	★	50	50	100	97.2	2.8	10

∗**AWG :** American Wire Gage

★ **: Inventory maintained in Japan. (Available Spring 2017)** □ **: Non stock, produced to order only. (Available Spring 2017)**

DRILLING TOOLS

Request sizes other than those in the inventory by inserting the code and numerical value in the □ of the following model numbers. Contact our sales department for details on the dimensions.

Order number

MC□ □□□□ X□D □□□

Hole Depth (l/d)
Size range : 2-5

Shank Dia. DCON
Size range : 030-200

Drill Dia. DC
Size range : 0300-2000
*Minimum diameter with internal coolant is ϕ4mm (ϕ.1575").

Applications
C : Standalone CNC / CFRP
A : CNC / CFRP + Al
T : CNC / CFRP + Ti
W : Standalone CNC / CFRP and stack material high precision
CH : Hand tool / standalone CFRP
AH : Hand tool / CFRP + Al

Size range of drill dia. : ϕ3mm-ϕ20mm
Size range of shank dia. : ϕ3mm -ϕ20mm
For cutting dia DC - Please indicate with 4 digits
E.g. ϕ3mm - 0300
For shank dia DCON - Please use 3 digits
E.g. ϕ12mm - 120
*For inch sizes please convert to metric
(1"= 25.4mm)

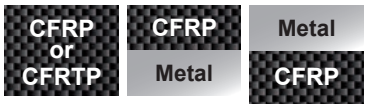
Work material

Type

- CFRP: Thermosetting and thermoplasticity
- Type of reinforcing fiber
- Metal: Aluminum or titanium, etc.

Combination

- Standalone CFRP or CFRTP
- CFRP + stack materials (aluminum or titanium)
- Lap joint method



Other

- Thickness for each work material
- Affixture of film

Equipment

Type

- CNC
- Hand Tool
- Power feeders etc.

Coolant

- Internal through
- Air, MQL and dry, etc.

Hole Quality

- Required hole diameter (upper and lower limit of tolerance)
- Surface roughness of the hole inner wall
- Metal burr height
- CFRP and metal hole diameter gap

CVD diamond coating with outstanding abrasion resistance and superior sharpness for high quality CFRP machining.

DFC Series

CVD diamond coated end mill for CFRP machining

DFCJRT

DFC4JC

Geometry for CFRP machining

DFC4JC

For finishing

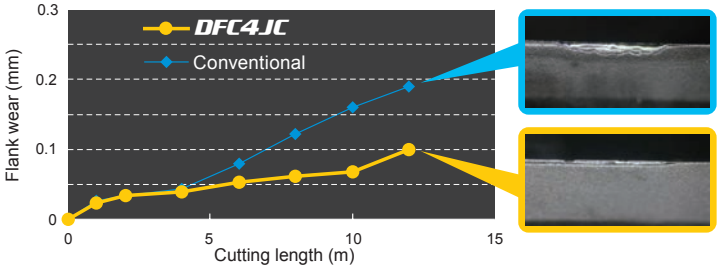
The low resistance cutting edge with low helix angle reduces delamination and burrs when machining CFRP.

DFCJRT

For efficient machining

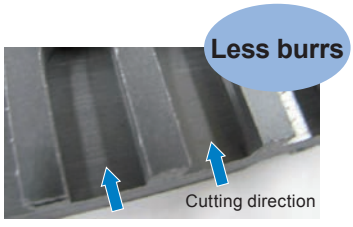
The cross-nick type cutting edge allows high efficiency machining due to lower cutting resistance and reduced temperatures.

■Long tool life

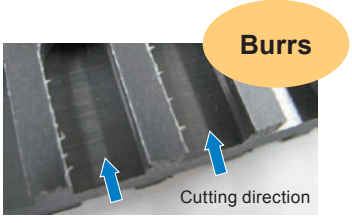


End mill	DFC4JCD1000 (ø10)
Work material	CFRP (Thick: 5.3mm)
Revolution	6400min^{-1} (200m/min)
Feed rate	800mm/min (0.03mm/tooth)
Coolant mode	Air blow

■Excellent surface finish



DFC4JC



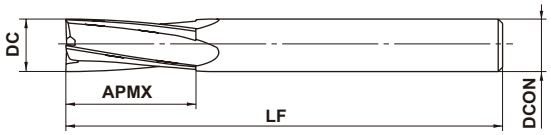
Conventional

End mill	DFC4JCD1000 (ø10)
Work material	CFRP (Thick: 6mm)
Revolution	6000min^{-1} (188m/min)
Feed rate	750mm/min (0.03mm/tooth)
Coolant mode	Air blow

MILLING TOOLS

DFC4JC

End mill, Semi long cut length, 4 flute, for CFRP



Type 1

6≤DC≤12		
0 - 0.03		
DCON=6	8≤DCON≤10	DCON=12
0 - 0.008	0 - 0.009	0 - 0.011

h6

Order Number	DC	APMX	LF	DCON	N	Stock	Type
DFC4JCD0600	6	20	70	6	4	★	1
DFC4JCD0800	8	30	80	8	4	★	1
DFC4JCD1000	10	30	90	10	4	★	1
DFC4JCD1200	12	30	100	12	4	★	1

Please contact Mitsubishi Materials for geometries and through coolant types other than standard.

RECOMMENDED CUTTING CONDITIONS

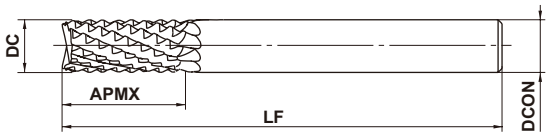
Work material	CFRP	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)
6	11000	950
8	8000	780
10	6400	700
12	5300	650

1) Cutting conditions may differ considerably due to the kind of CFRP, the rigidity of the machine, or the clamping and geometry of the workpiece. Please use the left table as a standard starting point.
2) When high machining accuracy is needed, or large burrs or delamination occurs, we recommend reducing the feed rate.
3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.
4) Please take precautions against dust.

● : Inventory maintained in Japan. ★ : Inventory maintained in Japan. (Available Spring 2017)

DFCJRT

Cross-nick type end mill, Semi long cut length, for CFRP



Type 1

h6	DCON=6	8≤DCON≤10	DCON=12
	0 - 0.008	0 - 0.009	0 - 0.011

Order Number	DC	APMX	LF	DCON	N	Stock	Type
DFCJRTD0600	6	20	70	6	10	★	1
DFCJRTD0800	8	30	80	8	10	★	1
DFCJRTD1000	10	30	90	10	12	★	1
DFCJRTD1200	12	30	100	12	12	★	1

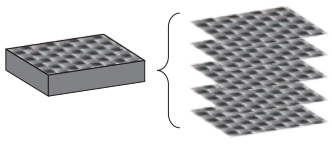
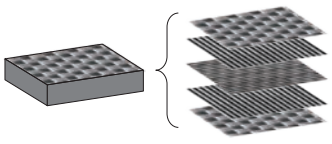
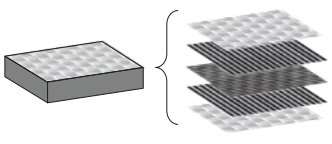
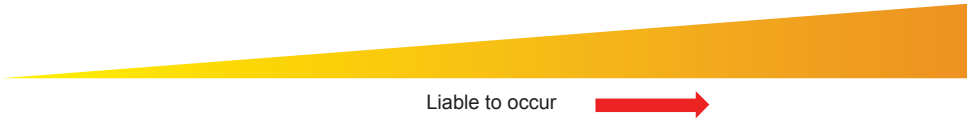
Please contact Mitsubishi Materials for geometries and through coolant types other than standard.

RECOMMENDED CUTTING CONDITIONS

Work material	CFRP	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)
6	11000	1200
8	8000	1000
10	6400	900
12	5300	850

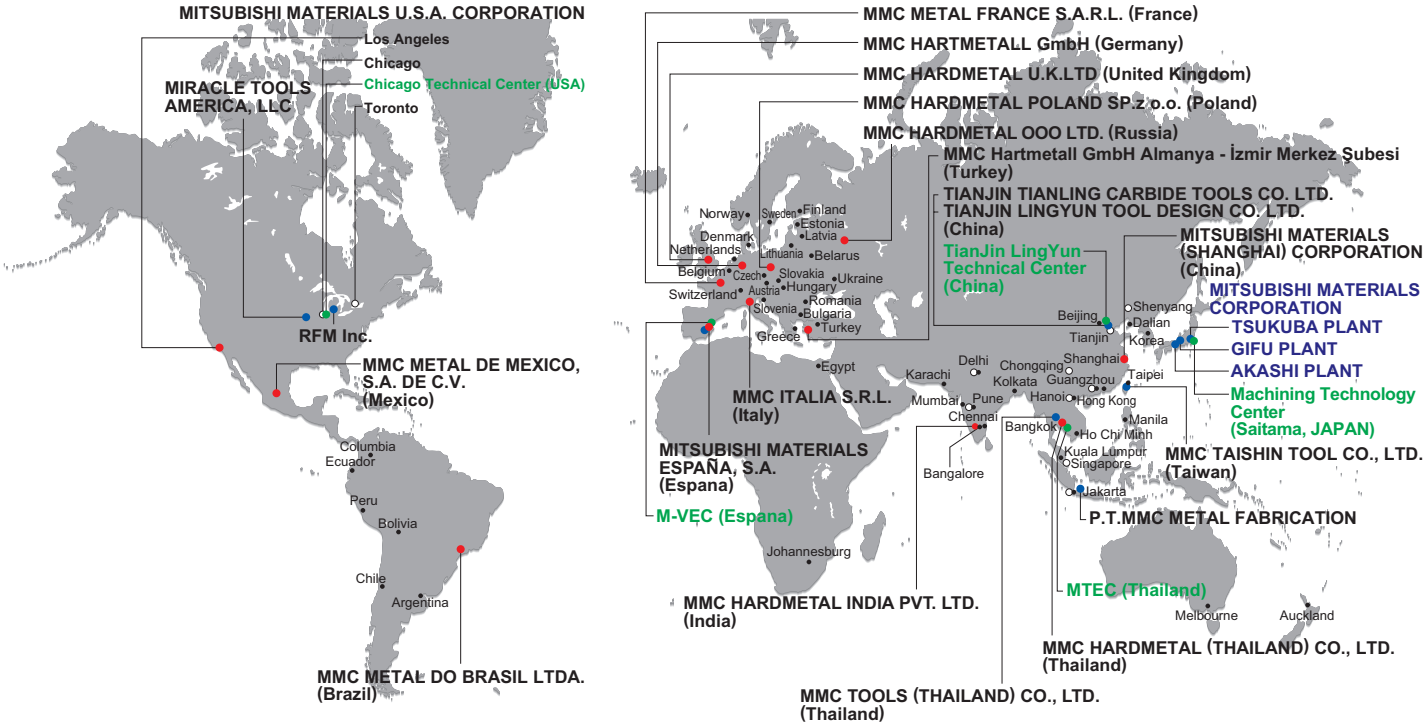
1) Cutting conditions may differ considerably due to the kind of CFRP, the rigidity of the machine, or the clamping and geometry of the workpiece. Please use the left table as a standard starting point.
2) When high machining accuracy is needed, or large burrs or delamination occurs, we recommend reducing the feed rate.
3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.
4) Please take precautions against dust.

Recommended Tools According to Type of CFRP

Type / End mill	Surface and inside: Cloth material	Surface → Cloth material Inside → Uni-direction material	Surface → Glass fiber material Inside → Uni-direction material
			
DFC4JC	◎	○	○
DFCJRT	○	○	◎
Burr			

● : Inventory maintained in Japan. ★ : Inventory maintained in Japan. (Available Spring 2017)

Global Network



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