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# DCCC

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INDEXABLE END MILL

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FOR DEEP SHOULDER MILLING AND SLOTTING

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HIGH RIGIDITY  
FOR HIGH  
PERFORMANCE  
AND RELIABILITY

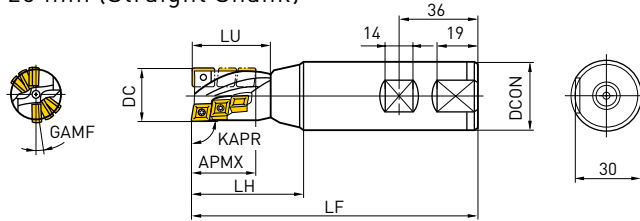
# DCCC

## INDEXABLE END MILL

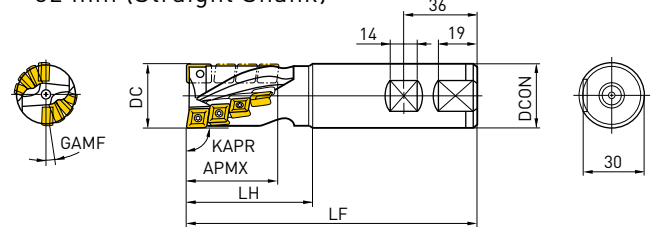
### FOR DEEP SHOULDER MILLING AND SLOTTING



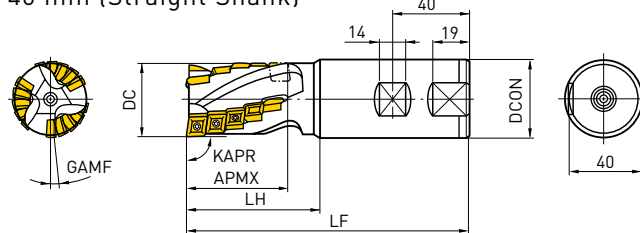
φ 25 mm (Straight Shank)



φ32 mm (Straight Shank)



φ 40 mm (Straight Shank)

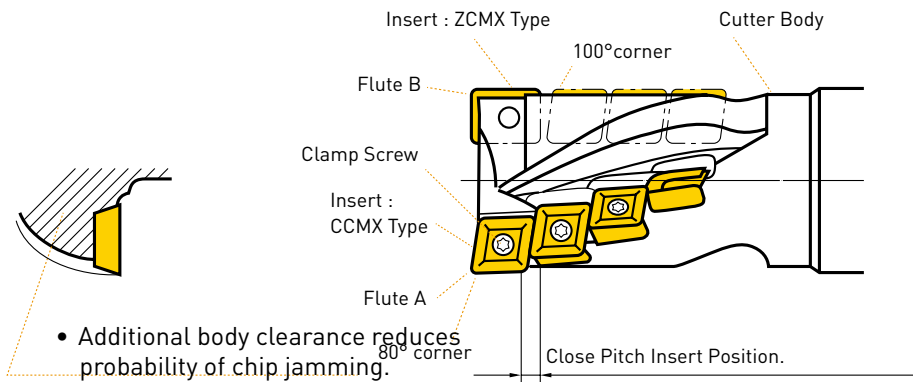


DC	Order Number	Stock	Number of Teeth			Dimensions (mm)						Number of Insert				
			R	Flutes	Total	Bottom	LF	DCON	LH	LU	APMX	GAMF	Peripheral and Bottom Inserts		Bottom Insert (One pocket only)	
													CCMX08 3508EN-A	CCMX09 T308EN-	ZCMX08 3508ER-A	ZCMX09 T308ER-○
25	DCCCR2506S32	●	2	6	2	130	32	50	36	27	8°	5	-	1	-	
	DCCCR2510S32	●	2	10	2	150	32	70	56	44	8°	9	-	1	-	
32	DCCCR3208S32	●	2	8	2	140	32	60	-	43	8°36'	-	7	-	1	
	DCCCR3212S32	●	2	12	2	160	32	80	-	63	8°36'	-	11	-	1	
40	DCCCR4015S40	●	3	15	3	150	40	70	-	53	5°31'	-	14	-	1	
	DCCCR4015S42	★	3	15	3	150	42	70	-	53	5°31'	-	14	-	1	
	DCCCR4024S40	●	3	24	3	180	40	100	-	83	5°31'	-	23	-	1	
	DCCCR4024S42	★	3	24	3	180	42	100	-	83	5°31'	-	23	-	1	

KAPR:90°

Right hand tool holder only.

# DESIGN FEATURES OF DCCC TYPE END MILL

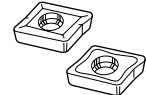
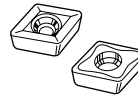


- All 4 cutting edges of CCMX insert are utilized, 80° corners in flute "A" and 100° corners on flute "B".

## SPARE PARTS

Tool Holder Number

\*



Clamp Screw

Wrench

Insert

Peripheral and Bottom Insert

Bottom Insert (One Pocket Only)

DCCR25

CS300890T

TKY08DS

CCMX083508EN-A

ZCMX083508ER-A

DCCR32

CS350990T

TKY10DS

CCMX09T308EN-A / B

ZCMX09T308ER-A / B


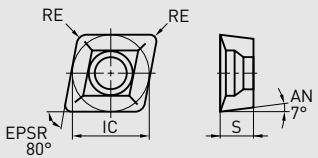
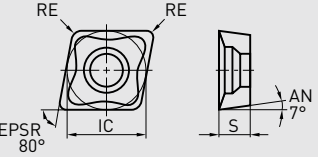

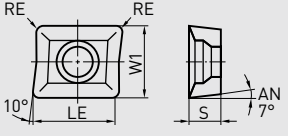
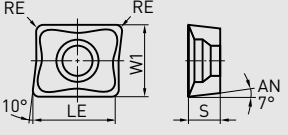
DCCR40

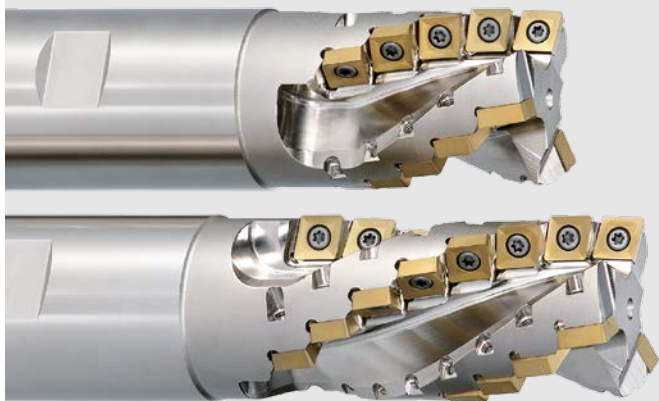
\* Clamp Torque (N • m) : CS300890T=1.0, CS350990T=2.5

### BENEFITS

- Different helical flute angles prevents chattering
- High rigidity tool for performance and reliability
- High-productivity for deep 2D profile milling

# INSERTS

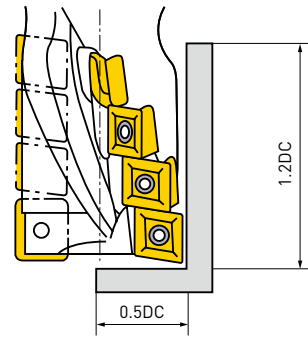
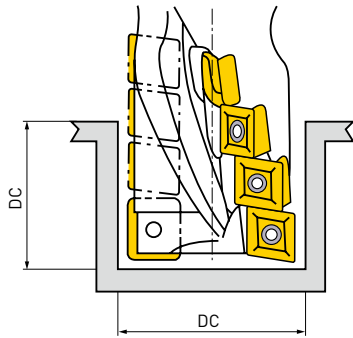
Material	P	Steel	●	●	●	●	Cutting Conditions:						
	M	Stainless Steel	●	●	●	●	●	●	●	●	●	●	●
	K	Cast Iron	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖
Honing: E = Round													
Shape	Order Number	Class	Honing	F7030	VP15TF	UP20M	UT120T	LE	W1	IC	S	RE	Geometry
	CCMX083508EN-A	M	E	●	★	★	-	-	7.94	3.5	0.8		
	CCMX09T308EN-A	M	E	●	●	★	-	-	9.525	3.97	0.8		
Strong Cutting Edge	CCMX09T308EN-B	M	E	●		★	-	-	9.525	3.97	0.8		
	ZCMX083508ER-A	M	E	●		★	10.4	7.94	-	3.5	0.8		
	ZCMX09T308ER-A	M	E	●	●	●	★	12	9.525	-	3.97	0.8	
Strong Cutting Edge	ZCMX09T308ER-B	M	E	●	★	★	12	9.525	-	3.97	0.8		



# RECOMMENDED CUTTING CONDITIONS

Cutting Mode A : Slot Milling (Standard Cutting Length Type)

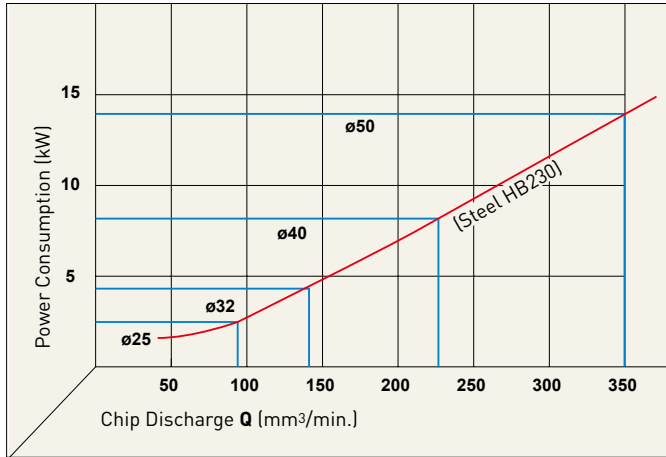
Cutting Mode B : Shoulder Milling (Standard Cutting Length Type)



Material	Hardness	Grade	Cutting Mode	Cutting Speed (m/min)	Table Feed (mm/min)			
					φ 25 mm	φ 32 mm	φ 40 mm	φ 50 mm
P Mild Steel	≤ 180HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	120 (100-140)	120 (100-140)
			B	180 (100-250)	200 (180-220)	200 (180-220)	230 (200-250)	230 (200-250)
Carbon Steel Alloy Steel	180-280HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	140 (120-150)	140 (120-150)
			B	180 (100-250)	150 (120-180)	150 (120-180)	180 (150-200)	180 (150-200)
	280-350HB	VP15TF	A	180 (100-250)	100 (80-120)	100 (80-120)	130 (100-150)	130 (100-150)
			B	180 (100-250)	120 (100-140)	120 (100-140)	150 (120-180)	150 (120-180)
High Alloy Steel	200-280HB	VP15TF	A	140 (100-180)	100 (80-120)	100 (80-120)	130 (100-150)	130 (100-150)
			B	140 (100-180)	120 (100-140)	120 (100-140)	150 (120-180)	150 (120-180)
M Stainless Steel	≤200HB	VP15TF	A	150 (100-200)	70 (50-90)	70 (50-90)	70 (50-90)	70 (50-90)
			B	150 (100-200)	100 (80-120)	100 (80-120)	120 (100-140)	120 (100-140)
K Cast Iron	Tensile Strength ≤450MPa	VP15TF	A	160 (100-220)	200 (180-220)	200 (180-220)	230 (200-250)	230 (200-250)
			B	160 (100-220)	230 (200-250)	230 (200-250)	260 (240-280)	260 (240-280)

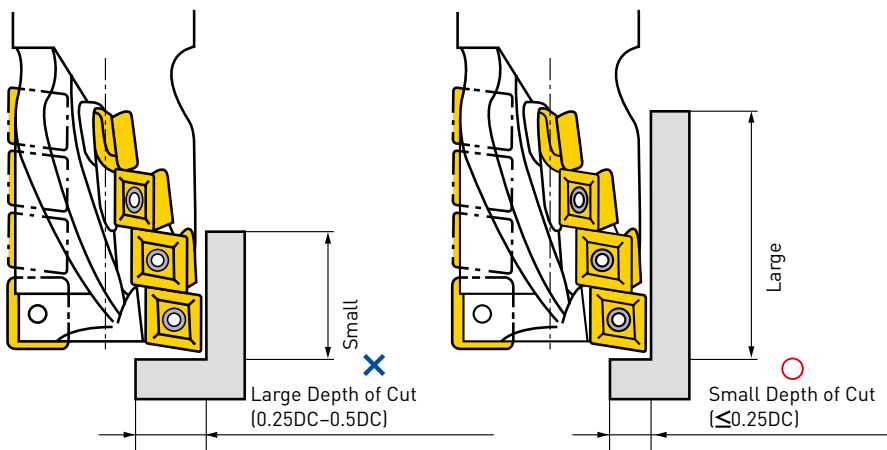
# POWER CONSUMPTION

- Please use the chart below for reference, please select the conditions that suits the machines power.
- Chip Discharge  $Q$  (mm<sup>3</sup>/min.) = Table Feed x Depth of Cut x Cutting Width / 1000



## FOR USE OF LONG CUTTING LENGTH TYPE

- Since the overhang from the milling chuck is long, a large width of cut will cause chattering and tool breakage.
- Keep the width of cut small and the depth of cut in axial direction large. (See the following illustration.)



# NOTES

A series of horizontal dotted lines for writing notes.

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