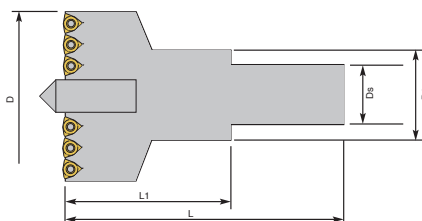


Milling Cutters



VMD Max Drill - MX Modular Shank Type



Note: Drill head complete with cartridges - Pilot Drill not included

(mm)

Model	Code No.	Price \$	D	Ds	D1	L1	L	Pilot Drill	Cartridge
VMD-045050	156000	891.35	1.77-1.97	13	28	50	85	PLD-1035 Tin-H	VMC-045050N/T
VMD-050055	156002	891.35	1.97-2.17	13	28	50	85	PLD-1035 Tin-H	VMC-050055N/T
VMD-055060	156004	933.61	2.17-2.36	16	32	60	100	PLD-1238 Tin-H	VMC-055060N/T
VMD-060065	156006	933.61	2.36-2.56	16	32	60	100	PLD-1238 Tin-H	VMC-060065N/T
VMD-065070	156008	1,022.49	2.56-2.76	16	32	60	100	PLD-1238 Tin-H	VMC-065070N/T
VMD-070075	156010	1,022.49	2.76-2.95	22	40	70	115	PLD-1238 Tin-H	VMC-070075N/T
VMD-075080	156012	1,065.09	2.95-3.15	22	40	70	115	PLD-1645 Tin-H	VMC-075080N/T
VMD-080085	156014	1,129.01	3.15-3.35	22	40	70	115	PLD-1645 Tin-H	VMC-080085N/T
VMD-085090	156016	989.94	3.35-3.54	27	48	70	120	PLD-1645 Tin-H	VMC-085090N/T
VMD-090095	156018	1,129.01	3.54-3.74	27	48	70	120	PLD-1645 Tin-H	VMC-090095N/T
VMD-095100	156020	1,214.21	3.74-3.94	27	48	70	120	PLD-1645 Tin-H	VMC-095100N/T
VMD-100105	156022	1,214.21	3.94-4.13	32	58	80	130	PLD-2045 Tin-H	VMC-100105N/T
VMD-105110	156024	1,214.21	4.13-4.33	32	58	80	130	PLD-2045 Tin-H	VMC-105110N/T
VMD-110115	156026	1,214.21	4.33-4.53	32	58	80	130	PLD-2045 Tin-H	VMC-110115N/T
VMD-115120	156028	1,448.55	4.53-4.72	40	70	90	145	PLD-2045 Tin-H	VMC-115120N/T
VMD-120125	156030	1,618.97	4.72-4.92	40	70	90	145	PLD-2556 Tin-H	VMC-120125N/T
VMD-125130	156032	1,385.25	4.92-5.12	40	70	90	145	PLD-2556 Tin-H	VMC-125130N/T
VMD-130135	156034	1,618.97	5.12-5.32	40	70	90	145	PLD-2556 Tin-H	VMC-130135N/T
VMD-135140	156036	1,618.97	5.32-5.51	40	70	90	145	PLD-2556 Tin-H	VMC-135140N/T
VMD-140150	156038	1,959.79	5.51-5.91	50	80	100	160	PLD-2556 Tin-H	VMC-140150N/T
VMD-150160	156040	1,959.79	5.91-6.30	50	80	100	160	PLD-2556 Tin-H	VMC-150160N/T
VMD-160170	156042	2,002.39	6.30-6.69	50	80	100	160	PLD-3068 Tin-H	VMC-160170N/T
VMD-170180	156043	2,556.23	6.69-7.09	50	80	100	160	PLD-3068 Tin-H	VMC-170180N/T

➤ P. E151

➤ P. E152

Recommended Speed & Feeds for VMD Max Drill

Material	Cutting Speed	Feed F (mm/rev) For Drill Diameter D (mm)							
		ø45~ø55	ø55~ø60	ø60~ø75	ø75~ø100	ø100~ø105	ø105~ø150	ø150~ø180	
Low Alloy Steel	<0.25%	120-180	0.06 - 0.10	0.07 - 0.11	0.08 - 0.12	0.1 - 0.14	0.14 - 0.2	0.08 - 0.12	0.1 - 0.14
High Alloy Steel	>0.25%	110-170	0.06 - 0.10	0.07 - 0.11	0.08 - 0.12	0.1 - 0.14	0.12 - 0.18	0.08 - 0.12	0.1 - 0.14
Low Alloy Steel	<300HRB	90-130	0.06 - 0.10	0.07 - 0.11	0.08 - 0.12	0.1 - 0.14	0.12 - 0.18	0.08 - 0.12	0.1 - 0.14
High Alloy Steel	>300HRB	60-100	0.05 - 0.07	0.05 - 0.07	0.06 - 0.08	0.06 - 0.1	0.09 - 0.13	0.06 - 0.08	0.06 - 0.1
Stainless Steel		60-110	0.04 - 0.07	0.04 - 0.11	0.06 - 0.12	0.08 - 0.14	0.1 - 0.18	0.06 - 0.12	0.08 - 0.14
Grey Cast Iron		120-180	0.07 - 0.13	0.07 - 0.15	0.08 - 0.16	0.1 - 0.18	0.12 - 0.22	0.08 - 0.16	0.1 - 0.18
Cast Iron & Nodular Cast Iron		100-180	0.04 - 0.13	0.07 - 0.15	0.08 - 0.16	0.1 - 0.25	0.12 - 0.26	0.08 - 0.16	0.1 - 0.25
Aluminum Forging Alloys		180-280	0.04 - 0.06	0.07 - 0.12	0.08 - 0.13	0.09 - 0.15	0.12 - 0.2	0.08 - 0.13	0.09 - 0.15
Aluminum Cast Alloys		120-270	0.04 - 0.06	0.06 - 0.12	0.08 - 0.13	0.09 - 0.15	0.12 - 0.2	0.08 - 0.13	0.09 - 0.15

Conversion examples:
 0.08mm= 0.0031 In/Rev
 0.12mm= 0.00472 In/Rev
 0.16mm= 0.0063 In/Rev

Conversion examples:
 60-100 (195-325 sfm)
 120-180 (390-585 sfm)