

ARM

MULTI-FUNCTIONAL HIGH FEED CUTTER
FOR MOULD & DIE MACHINING



*M*plus...

ARM

MULTI-FUNCTIONAL HIGH FEED CUTTER FOR MOULD & DIE MACHINING

ARM is a new multifunctional high-performance cutter that provides process stability even at high feed rates. Its individual design as well as the advanced technical features promise high material removal rates combined with effective chip control.



PRODUCT RANGE

ARM09:

- Arbor type: DC Ø 40 – 66 mm
- Shank type: DC Ø 25 – 35 mm
- Weldon type: DC Ø 25 – 32 mm
- Screw in type: DC Ø 25 – 42 mm

ARM11:

- Arbor type: DC Ø 50 – 80 mm
- Shank type: DC Ø 32 mm
- Screw in type: DC Ø 32 – 35 mm

APPLICATION

- Mould & die machining
- Roughing
- High feed cutting
- Face milling
- Copying
- Helical milling
- Pocketing



BENEFITS

- High metal removal rates
- Near nett shape material remaining
- Porcess stability and security
- High rigidity for high feed rates
- Long tool life in both soft and hard materials
- Economic cost / performance ratio due to 4 cutting edges
- For high volume roughing
- Proven performance for machining of plastic injection moulds
- Versatile range of cutters available





IDEAL FOR DEEP CAVITIES

- Internal coolant holes for air blow increases reliability due to effective chip disposal
- Ideal for high volume machining

HIGH PRODUCTIVITY FOR ROUGHING APPLICATIONS

- Time saving when machining high hardness plastic injection moulds and forging dies
- Ideal for high feed machining path strategies

COST EFFICIENT SOLUTION

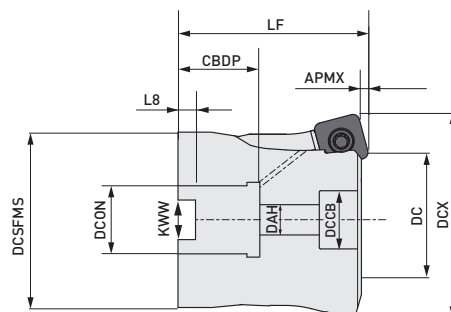
- Economical 4 cutting edges
- Reinforced cutting edge geometry
- Versatile VP15TF grade for varied applications
- The micro-grain substrate and Miracle coating provide excellent welding resistance



ARM

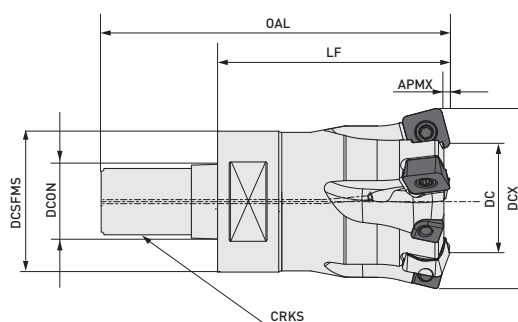
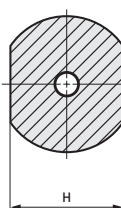
HIGH FEED MILLING CUTTER FOR MOULD & DIE

ARBOR TYPE



Order Number	Stock	Teeth	DCX	DC	LF	DCON	CBDP	DAH	DCSFMS	KWW	L8	APMX	DCCB	Inserts
NEW ARM09-040A05R	●	5	40	22.9	40	16	18	9	38.5	8.4	5.6	1.4	12	
NEW ARM09-042A05R	●	5	42	24.9	40	16	18	9	38.5	8.4	5.6	1.4	12	
NEW ARM09-050A06R	●	6	50	33	40	22	20	11	49	10.4	6.3	1.4	17	SPMX094506
NEW ARM09-052A07R	●	7	52	35	40	22	20	11	49	10.4	6.3	1.4	17	
NEW ARM09-066A08R	●	8	66	48.9	50	22	20	11	60	10.4	6.3	1.4	17	
NEW ARM11-050A05R	●	5	50	29.4	40	22	20	11	49	10.4	6.3	1.8	17	
NEW ARM11-052A05R	●	5	52	31.4	40	22	20	11	49	10.4	6.3	1.8	17	
NEW ARM11-063A06R	●	6	63	42.4	50	22	20	11	60	10.4	6.3	1.8	17	SPMX115506
NEW ARM11-066A07R	●	7	66	45.4	50	22	20	11	60	10.4	6.3	1.8	17	
NEW ARM11-080A08R	●	8	80	59.3	50	27	22	13	64	12.4	7	1.8	19	

SCREW-IN TYPE

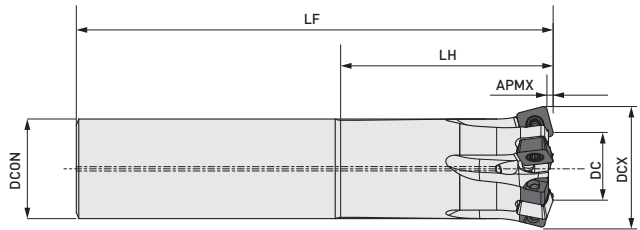


Order Number	Stock	Teeth	DCX	DC	LF	DCON	DCSFMS	OAL	H	CRKS	APMX	Inserts
NEW ARM09R252AM12	●	2	25	8	35	12.5	21	56	19	M12	1.4	
NEW ARM09R324AM16	●	4	32	15	43	17	29	66	22	M16	1.4	SPMX094506
NEW ARM09R354AM16	●	4	35	17.9	43	17	29	66	22	M16	1.4	
NEW ARM09R425AM16	●	5	42	24.9	43	17	29	66	22	M16	1.4	
NEW ARM11R323AM16	●	3	32	11.7	43	17	29	66	22	M16	1.8	SPMX115506
NEW ARM11R353AM16	●	3	35	14.6	43	17	29	66	22	M16	1.8	

ARM

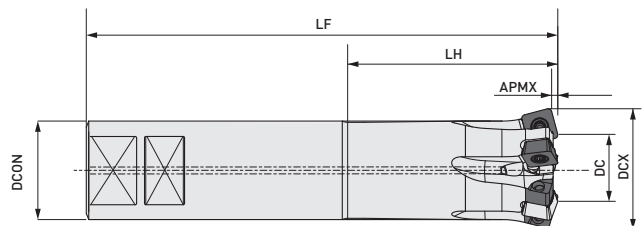
HIGH FEED MILLING CUTTER FOR MOULD & DIE

CYLINDRICAL SHANK



Order Number	Stock	Teeth	DCX	DCON	DC	LF	LH	APMX	Inserts
NEW ARM09R252SA25S	●	2	25	25	8	140	40	1.4	
NEW ARM09R252SA25L	●	2	25	25	8	200	40	1.4	
NEW ARM09R324SA32S	●	4	32	32	15	150	50	1.4	SPMX094506
NEW ARM09R324SA32L	●	4	32	32	15	200	50	1.4	
NEW ARM09R354SA32S	●	4	35	32	17.9	150	50	1.4	
NEW ARM11R323SA32S	●	3	32	32	11.7	150	50	1.8	SPMX115506

WELDON SHANK



Order Number	Stock	Teeth	DCX	DCON	DC	LF	LH	APMX	Inserts
NEW ARM09R252WA25S	●	2	25	25	8	140	40	1.4	SPMX094506
NEW ARM09R324WA32S	●	4	32	32	15	150	50	1.4	

INSERTS

Order Number	VP15TF	IC	S	RE	Shape
NEW SPMX094506ZHEN-FT	●	9.7	4.4	0.6	
NEW SPMX094506ZNSN-FT	●	9.7	4.4	0.6	
NEW SPMX115506ZHEN-FT	●	11.6	5.4	0.6	
NEW SPMX115506ZNSN-FT	●	11.6	5.4	0.6	

SPARE PARTS

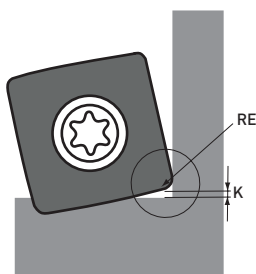
Insert Type	Clamping Screw	Set Bolt	Wrench
SPMX094506	 TPS4C	M8-C	 TIP15W -C
		M10-C	
SPMX115506	 TPS43C	M10-C	
		M12-C	

RECOMMENDED CUTTING CONDITIONS

Material	Hardness	Insert	Grade	Standard Milling				High Feed Milling			
				Vc	fz	ap	ae	Vc	fz	ap	ae
Mild Steel	<180HB	SPMX094506	VP15TF	170 (120-220)	1.2	0.5/1	100%	200	1.4	0.5	100%
		SPMX115506									
Carbon Steel, Alloy Steel	180-280HB	SPMX094506	VP15TF	150 (100-200)	1	0.5/0.7	100%	200	1.2	0.5	100%
		SPMX115506									
P Carbon Steel, Alloy Steel	280-350HB	SPMX094506	VP15TF	120 (80-150)	1	0.5/0.7	100%	180	1.2	0.4	100%
		SPMX115506									
Alloy Tool Steel	<350HB	SPMX094506	VP15TF	120 (80-140)	1	0.5/0.7	100%	180	0.8	0.4	100%
		SPMX115506									
Pre-hardened Steel	35-45HRC	SPMX094506	VP15TF	100 (70 (50-90)	0.8	0.4/0.6	100%	150	0.8	0.4	100%
		SPMX115506									
M Stainless Steel	<200HB	SPMX094506	VP15TF	100 (60-120)	0.4	0.5/1	100%	—	—	—	—
		SPMX115506									
PH, Duplex	>200HB	SPMX094506	VP15TF	70 (50-90)	0.4	0.3/0.5	100%	—	—	—	—
		SPMX115506									
K Gray Cast Iron	<200HB	SPMX094506	VP15TF	150 (100-200)	1.2	0.5/0.8	100%	—	—	—	—
		SPMX115506									
Ductile Cast Iron	<450MPa	SPMX094506	VP15TF	120 (80-160)	1	0.4/0.6	100%	—	—	—	—
		SPMX115506									
H Hardened Steel	40-55HRC	SPMX094506	VP15TF	70 (50-90)	0.6	0.3/0.5	100%	120	0.6	0.3	100%
		SPMX115506									

NOTE FOR PROGRAMMING

When using ARM cutters, please program as an RE radius cutter.
The approximate uncut portions for the program are as follows:



Insert size	RE	K
09	2.3	1.6
11	2.695	2.1

(mm)

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Order Code: MP200E 

Published: 2017.09 (3.1 DP), printed in Germany