



Value series
ø 3mm Shank End Mills

VDLCLB NEW

DLCCOAT
2 Flutes Long Neck Ball End Mills
for Copper Electrode Milling



Our reduced shank diameter contributes to conserving the limited resources of cemented carbide.



UNION TOOL CO.

Recommended for improved milling quality and cost reduction!

New $\phi 3$ mm shank

Union Tool's new standard: Value series



$\phi 3$ mm Shank (h4 tolerance) × Overall length 38 mm

Fixed size of $\phi 3$ Shank x Overall Length 38 mm

$\phi 3$ shank is used to save valuable carbide material. h4 tolerance is compatible for both shrink fit and collet holders. More series to follow in the future.

Cost effective

PCB drills mass production technology is applied to end mills.

To attain affordable prices, we applied our existing and proven automatic mass production technology for blank rods, flute grinding, coating and inspection to these new end mills.

High Quality

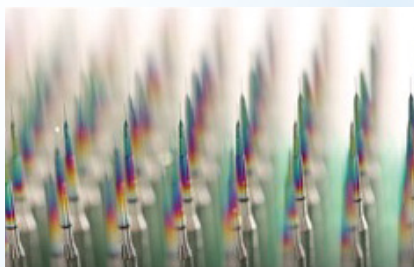
Small diameter V series are high-precision as a result of using the latest in-house technologies.

We developed new grinding machines specialized for small diameter end mills for high-precision milling that will innovate manufacturing technology for high-precision, high-efficiency milling.



Our in-house developed production facility for PCB tools

PCB: Printed Circuit Board



Over 5million coated PCB tools manufactured every month



Carefully crafted in Mitsuke of Niigata prefecture

VDLCLB

Value Series DLCCOAT Longneck Ball

DLCCOAT

2 Flutes Short Shank Long Neck Ball End Mills

Super
MG

DLC



R
±0.002

R0.05~R0.2

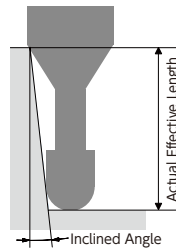
R
±0.003

R0.25~R1

Shank Dia
0/-0.003

Back Taper
Geometry

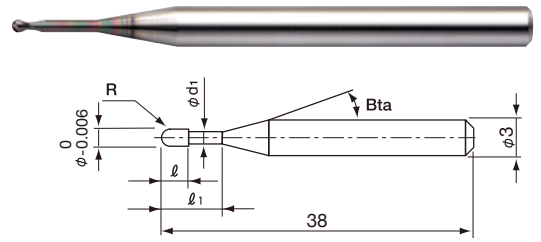
Except for R0.05~R0.15



Label Sample



Diameter and Ball R accuracy measurements are printed on the label to support High Precision milling.



The shank taper angle shown is not an exact value and to avoid contact with the work piece, we recommend the user controls the precise value of this angle. Shank taper angle should not make contact with the work piece.

Material Applications (☆ Highly Recommended ◎ Recommended ○ Suggested)

CARBON STEELS S45C S55C	ALLOY STEELS SK / SCM SUS	PREHARDENED STEELS NAK HPM	HARDENED STEELS			CAST IRON	ALUMINUM ALLOYS	GRAPHITE	COPPER	PLASTICS	GLASS FILLED PLASTICS	TITANIUM ALLOYS	HEAT RESISTANT ALLOYS	CEMENTED CARBIDE	HARD BRITTLE (NON-METALLIC) MATERIALS
			~ 55HRC	~ 60HRC	~ 70HRC										
							◎		☆						

Total 32 models

Unit(mm)

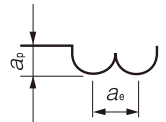
Model Number	Radius of Ball Nose R	Effective Length ℓ_1	Length of Cut ℓ	Neck Diameter ϕd_1	Shank Taper Angle Bta	Effective Length by Inclined Angles					Series
						30°	1°	1° 30'	2°	3°	
VDLCLB 2001-003	R0.05	0.3	0.08	0.092	11°	0.35	0.37	0.39	0.41	0.46	VDLCLB
VDLCLB 2001-005	R0.05	0.5	0.08	0.092	11°	0.56	0.59	0.62	0.66	0.74	VDLCLB
VDLCLB 2002-005	R0.1	0.5	0.16	0.18	11°	0.64	0.67	0.70	0.74	0.83	VDLCLB
VDLCLB 2002-010	R0.1	1	0.16	0.18	11°	1.17	1.22	1.28	1.35	1.51	VDLCLB
VDLCLB 2002-015	R0.1	1.5	0.16	0.18	11°	1.68	1.77	1.86	1.95	2.19	VDLCLB
VDLCLB 2003-010	R0.15	1	0.24	0.28	11°	1.16	1.22	1.27	1.34	1.49	VDLCLB
VDLCLB 2003-020	R0.15	2	0.24	0.28	11°	2.21	2.31	2.43	2.55	2.86	VDLCLB
VDLCLB 2004-010	R0.2	1	0.32	0.38	11°	1.16	1.21	1.27	1.33	1.48	VDLCLB
VDLCLB 2004-020	R0.2	2	0.32	0.38	11°	2.20	2.31	2.42	2.54	2.84	VDLCLB
VDLCLB 2004-030	R0.2	3	0.32	0.38	11°	3.25	3.40	3.57	3.76	4.21	VDLCLB
VDLCLB 2004-040	R0.2	4	0.32	0.38	11°	4.30	4.50	4.73	4.98	5.58	VDLCLB
VDLCLB 2005-020	R0.25	2	0.4	0.48	11°	2.20	2.30	2.41	2.53	2.82	VDLCLB
VDLCLB 2005-030	R0.25	3	0.4	0.48	11°	3.25	3.40	3.57	3.75	4.19	VDLCLB
VDLCLB 2005-040	R0.25	4	0.4	0.48	11°	4.29	4.50	4.72	4.97	5.56	VDLCLB
VDLCLB 2006-020	R0.3	2	0.48	0.58	11°	2.20	2.30	2.40	2.52	2.80	VDLCLB
VDLCLB 2006-030	R0.3	3	0.48	0.58	11°	3.25	3.39	3.56	3.74	4.17	VDLCLB
VDLCLB 2006-040	R0.3	4	0.48	0.58	11°	4.29	4.49	4.71	4.96	5.54	VDLCLB
VDLCLB 2006-050	R0.3	5	0.48	0.58	11°	5.34	5.59	5.87	6.18	6.91	VDLCLB
VDLCLB 2006-060	R0.3	6	0.48	0.58	11°	6.39	6.69	7.03	7.40	8.28	VDLCLB
VDLCLB 2008-030	R0.4	3	0.64	0.78	11°	3.24	3.38	3.54	3.72	4.14	VDLCLB
VDLCLB 2008-040	R0.4	4	0.64	0.78	11°	4.29	4.48	4.70	4.94	5.51	VDLCLB
VDLCLB 2008-060	R0.4	6	0.64	0.78	11°	6.38	6.68	7.01	7.38	8.24	VDLCLB
VDLCLB 2010-020	R0.5	2	0.8	0.97	11°	2.22	2.31	2.41	2.52	2.77	VDLCLB
VDLCLB 2010-030	R0.5	3	0.8	0.97	11°	3.27	3.41	3.56	3.73	4.14	VDLCLB
VDLCLB 2010-040	R0.5	4	0.8	0.97	11°	4.32	4.51	4.72	4.95	5.51	VDLCLB
VDLCLB 2010-060	R0.5	6	0.8	0.97	11°	6.41	6.70	7.03	7.39	8.25	VDLCLB
VDLCLB 2010-080	R0.5	8	0.8	0.97	11°	8.50	8.90	9.34	9.83	10.99	VDLCLB
VDLCLB 2015-040	R0.75	4	1.2	1.45	11°	4.26	4.43	4.63	4.85	5.36	VDLCLB
VDLCLB 2015-060	R0.75	6	1.2	1.45	11°	6.35	6.63	6.94	7.28	8.10	VDLCLB
VDLCLB 2020-040	R1	4	1.6	1.95	11°	4.25	4.41	4.59	4.79	5.27	VDLCLB
VDLCLB 2020-060	R1	6	1.6	1.95	11°	6.34	6.61	6.90	7.23	8.01	VDLCLB
VDLCLB 2020-080	R1	8	1.6	1.95	11°	8.43	8.80	9.21	9.67	No Interference	VDLCLB

VCLCLB Milling Conditions

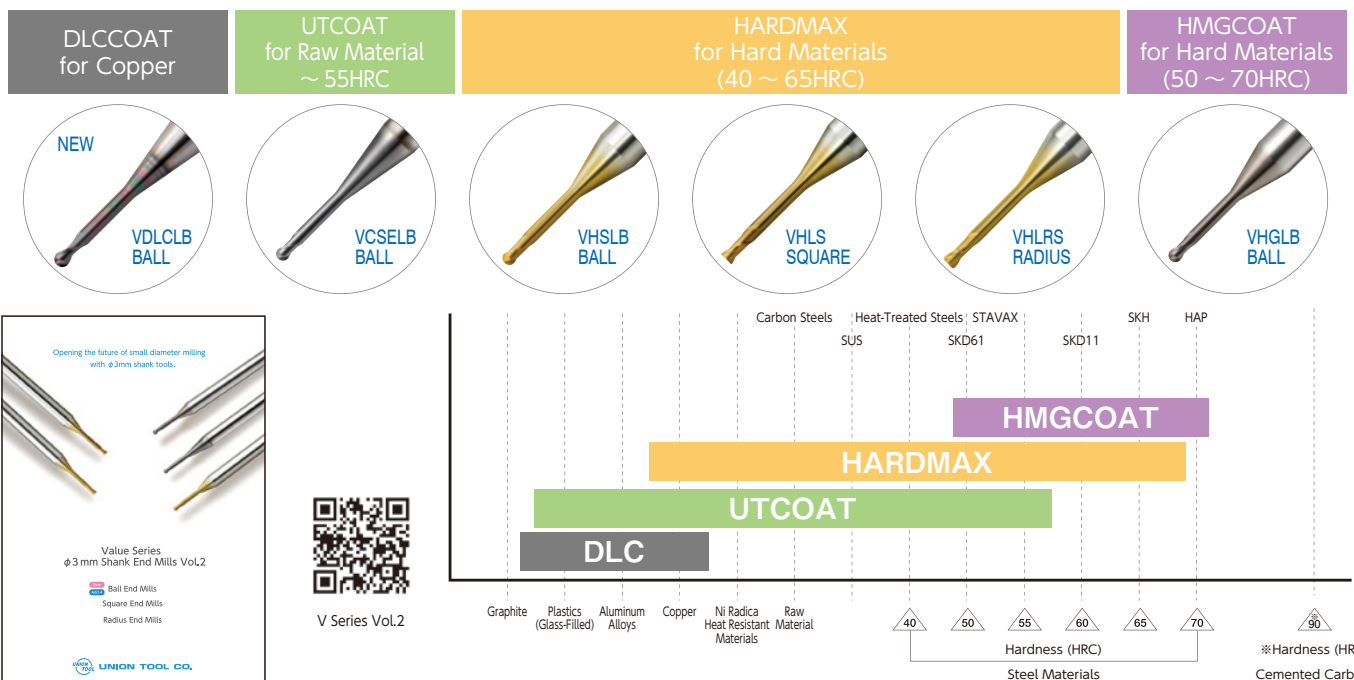
WORK MATERIAL			COPPER / ALUMINUM ALLOY				TUNGSTEN COPPER			
Model Number	Radius of Ball Nose (mm)	Effective Length (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)
2001-003	R0.05	0.3	43,600	220	0.01	0.01	32,700	160	0.008	0.008
2001-005	R0.05	0.5	43,600	160	0.007	0.007	32,700	110	0.005	0.005
2002-005	R0.1	0.5	43,600	550	0.025	0.05	32,700	380	0.02	0.04
2002-010	R0.1	1	43,600	440	0.02	0.04	32,700	270	0.015	0.03
2002-015	R0.1	1.5	32,900	250	0.015	0.03	24,700	120	0.008	0.02
2003-010	R0.15	1	43,600	760	0.03	0.07	32,700	550	0.03	0.07
2003-020	R0.15	2	39,200	390	0.02	0.03	29,400	200	0.01	0.02
2004-010	R0.2	1	43,600	1,090	0.05	0.1	32,700	760	0.04	0.08
2004-020	R0.2	2	43,600	650	0.035	0.06	32,700	380	0.02	0.05
2004-030	R0.2	3	35,000	470	0.02	0.04	29,200	230	0.01	0.03
2004-040	R0.2	4	27,300	270	0.008	0.015	19,600	110	0.005	0.01
2005-020	R0.25	2	43,600	870	0.08	0.15	32,700	550	0.08	0.15
2005-030	R0.25	3	38,200	650	0.06	0.1	29,500	390	0.06	0.08
2005-040	R0.25	4	32,700	440	0.04	0.08	24,000	220	0.025	0.05
2006-020	R0.3	2	43,600	1,750	0.12	0.2	32,700	1,310	0.12	0.2
2006-030	R0.3	3	43,600	1,090	0.1	0.14	32,700	760	0.08	0.1
2006-040	R0.3	4	32,700	760	0.07	0.1	27,300	440	0.04	0.06
2006-050	R0.3	5	29,500	650	0.05	0.08	24,000	330	0.02	0.04
2006-060	R0.3	6	27,300	550	0.04	0.06	21,800	220	0.01	0.03
2008-030	R0.4	3	43,600	2,180	0.15	0.3	32,700	1,530	0.15	0.3
2008-040	R0.4	4	38,200	1,750	0.12	0.2	29,500	1,090	0.1	0.16
2008-060	R0.4	6	32,700	1,090	0.08	0.15	21,800	550	0.05	0.1
2010-020	R0.5	2	39,100	2,740	0.25	0.4	30,000	2,050	0.25	0.4
2010-030	R0.5	3	39,100	2,740	0.25	0.4	30,000	1,960	0.25	0.4
2010-040	R0.5	4	39,100	2,350	0.2	0.4	29,500	1,560	0.2	0.4
2010-060	R0.5	6	34,500	1,840	0.14	0.3	26,200	1,150	0.1	0.25
2010-080	R0.5	8	27,300	1,090	0.12	0.2	19,600	550	0.06	0.1
2015-040	R0.75	4	25,500	2,270	0.3	0.6	21,300	1,700	0.3	0.6
2015-060	R0.75	6	25,500	2,040	0.3	0.6	21,300	1,530	0.3	0.6
2020-040	R1	4	18,700	2,490	0.45	0.8	14,000	1,500	0.45	0.8
2020-060	R1	6	18,700	2,080	0.45	0.8	14,000	1,250	0.45	0.8
2020-080	R1	8	18,700	1,800	0.4	0.8	13,500	1,200	0.4	0.8

Note:

- Decrease the feed rate more than 50% from the milling parameters when slot milling.
- Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed, or when chattering occurs.
- Recommend wet coolant for Copper, Aluminum alloy and Tungsten-Copper.



Find the best coating for your material applications!



DLCCOAT added to the existing HMGCOAT, HARDMAX and UTCOAT!
An even more expanded material applications range is now available!

Milling Example of Copper Electrode Model (Tough Pitch Copper)

R1 x Effective length 8mm

The comparison example of VDLCLB($\phi 3$ shank) and DLCLB($\phi 4$ shank)

Comparison of tool wearing

<Condition>

Work material : Tough Pitch Copper
 Coolant : Oil mist
 Milling shape : $\square 20 \text{ mm} \times 20 \text{ mm} \times \text{height } 8 \text{ mm}$

<Tool>*1

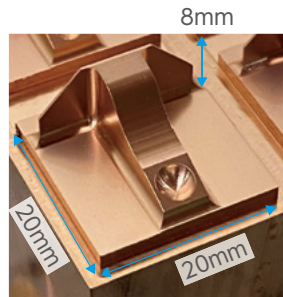
VDLCLB 2020-080 ($\phi 3$ shank)
 DLCLB 2020-080 ($\phi 4$ shank)

*1 1 for roughing to semi-finishing, 1 for finishing
 total 2 ea.

*2 Both models are set so that the overhang of shank is 2 mm.

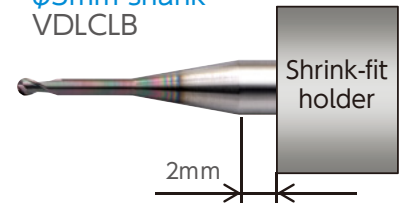


VDLCLB
Milling Video

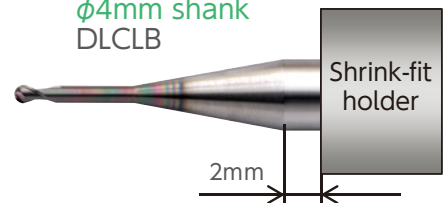


Milling shape

$\phi 3 \text{ mm}$ shank
VDLCLB

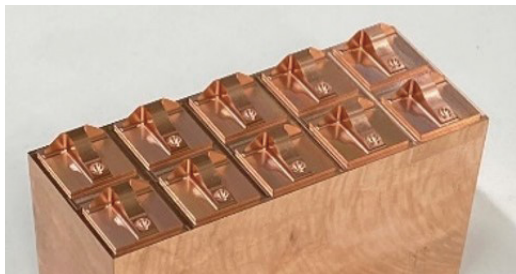


$\phi 4 \text{ mm}$ shank
DLCLB



No.	Milling Process	Spindle speed (min ⁻¹)	Feed rate (mm/min)	a_p (mm)	a_e (mm)	Allowance (mm)	Cycle time/ 1 pc
1	Roughing	18,700	1,800	0.4	0.8	0.08	14 min. 6 sec.
2	Semi-finishing	18,700	1,800	0.05	0.05	0.03	1 h 17 min. 24 sec.
3	Finishing	18,700/ 30,000(Bottom)	900	0.03	0.03	0	1 h 17 min. 0 sec.
						Total	2 h 48 min. 30 sec.

VDLCLB($\phi 3$ shank)
Milling application



DLCLB($\phi 4$ shank)
Milling application



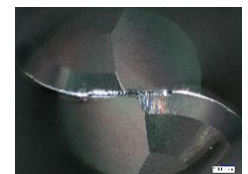
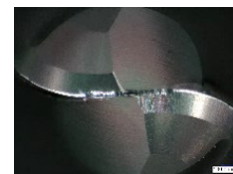
【Tool after 10pcs milling】

VDLCLB
($\phi 3$ shank)

DLCLB
($\phi 4$ shank)

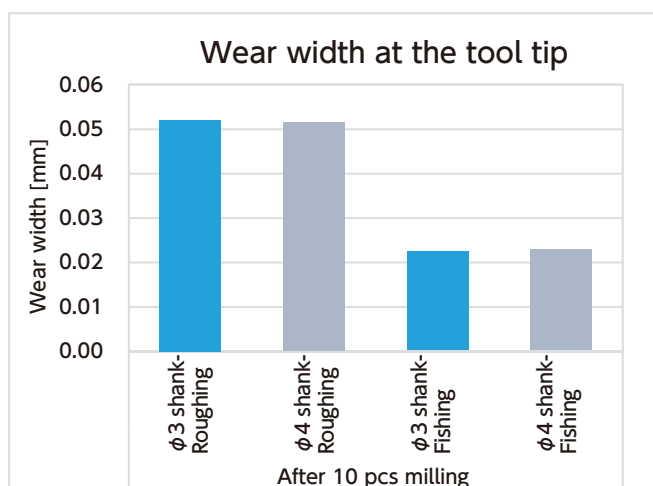
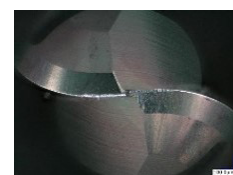
Roughing to
Semi-finishing

Cycle time:
15 h 15 min



Finishing

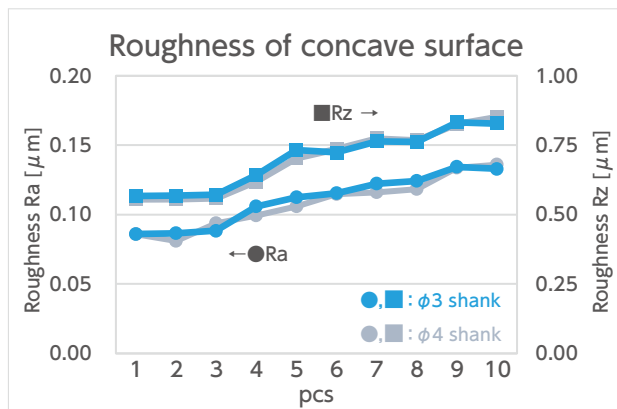
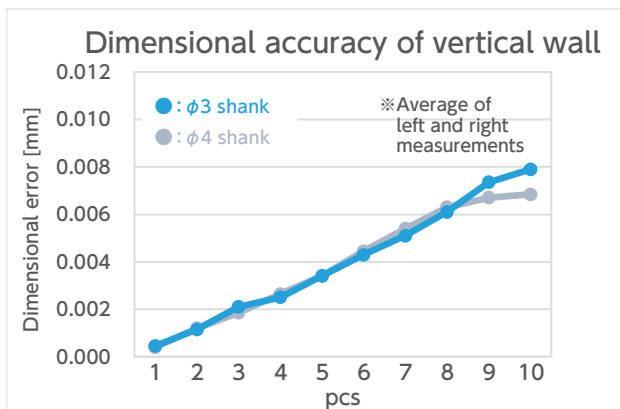
Cycle time:
12 h 50 min.



No difference of tool wearing with regard to the shank diameter gap.

Comparison of dimensional accuracy and roughness

Measuring for dimensional accuracy of vertical wall and roughness of concave surface.



Both the dimensional accuracy and roughness gave very similar results, with no difference with regard to the shank diameter gap.



Advisory for Safe Use of UNIMAX Tungsten Carbide End Mills

Correct application and operation is strongly advised to avoid clogging, abrasion, etc., that could cause serious accidents or injuries. Ignition or sparks generated during milling could lead to fire or extreme damage to the work piece. End Mills are made with very sharp cutting edges and must be handled with extra care.

- Never touch the cutting edge with your bare hands, as this could cause serious injury. Special caution is required when opening the package.
- Dropping the tool could cause breakage or flying debris, leading to serious injury.
- During milling, unexpected impact or shock on the tool could cause breakage or flying debris. Ensure to use protective items such as safety glasses and a face guard.
- For best results, fine parameter adjustment may be required, depending on the materials; milling shape and strategy; machine rigidity and spindle capability.
- Use a machine that has high rigidity and generates a low level of vibration.
- Do not use flammable cutting oils.

Advisory for regrinding UNIMAX Tungsten Carbide End Mills

- Never regrind the tool without wearing safety glasses and a face guard.



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<https://www.uniontool.co.jp/en/>

Price & Specifications are subject to change without notice.