

Spotting & Chamfer Tools

MSD Indexable 90° Spotting
and Chamfer Tool

VCM Chamfer Mills

ACR Corner Rounding



Where **high performance** is the **standard**®



M.A. FORD MAX
RANGE

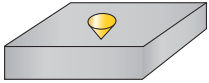
Performance, Precision, Economy

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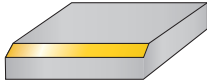
MSD Series

Indexable 90° Spotting and Chamfer Tool

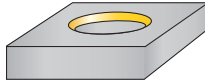
Spotting



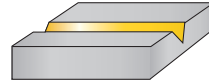
Chamfering



Countersinking



Grooving



Engraving



Features

- Diameter range 2-11mm and 3-20mm
- 3 or 4 edged insert for high cost efficiency
- For steel, stainless steel, cast iron, non-ferrous metals
- Multi-operation tool including **spotting**, **chamfering**, **countersinking**, **grooving** and **engraving**
- Suitable for milling and turning machines

Design

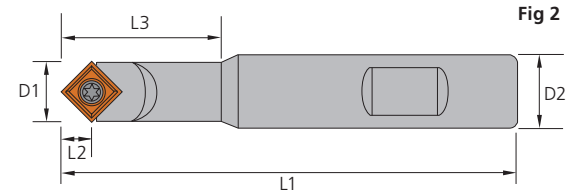
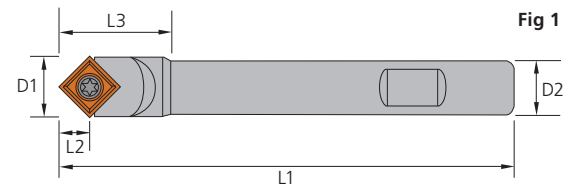
- MSD tool uses 0.4 & 0.8 radius insert for strength
- Suitable for wide application field



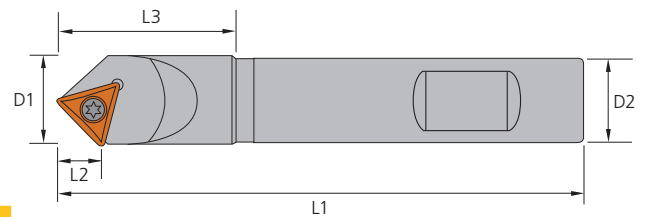
Radius protection design



MSD Indexable 90° Spotting and Chamfer Tool



EDP	Part Number	D1	D2	L1	L2	L3	Degree	Fig	Insert
FH1521	MSD-10-100-90D-SC09	2-11	10	100	5.2	29	90°	1	SCMX 09T3
FH1522	MSD-12-100-90D-SC09	2-11	12	100	5.2	29	90°	2	
FH1523	MSD-16-100-90D-SC09	2-11	16	100	5.2	29	90°	2	
FH1524	MSD-16-130-90D-SC09	2-11	16	130	5.2	29	90°	2	



EDP	Part Number	D1	D2	L1	L2	L3	Degree	Insert
FH1570	MSD-20-120-90D-TC16	3-20	20	120	9.6	42	90°	TCMX16T3

Inserts

EDP	Part Number	Grade	Insert
FW1417	SCMX09T304-S	FA5030	
FW4047	TCMX16T308-M	FA5030	

Spare Parts

EDP	Part Number	Description
FS1058	MS3520-SD	SC09 Spare Torx Screws
FS1059	MS3521-SD	TC16 Spare Torx Screws
FS1004	ETD-15	TX15 Torx Driver

Recommended Cutting Conditions

Spotting

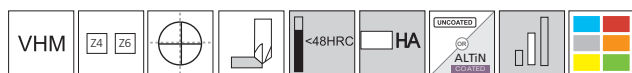
Material groups	ISO	Vc-m/min	Fr-mm/rev
Carbon Steels	P	60-220	0.05-0.10
Alloy Steels	P	50-180	0.04-0.08
Stainless Steels	M	30-120	0.03-0.06
Cast Irons	K	40-130	0.05-0.10
Pre-hardened	H	20-60	0.03-0.08

Chamfering, Countersinking, Grooving

Material groups	ISO	Vc-m/min	Fr-mm/rev
Carbon Steels	P	60-270	0.15-0.24
Alloy Steels	P	50-220	0.12-0.20
Stainless Steels	M	35-120	0.10-0.20
Cast Irons	K	60-220	0.15-0.25
Pre-hardened	H	20-60	0.03-0.08



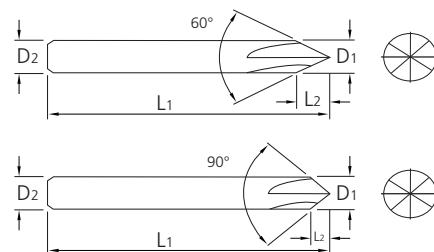
TuffCut® GP Chamfer Mills Series VCM60, VCM90



Z4 Z6

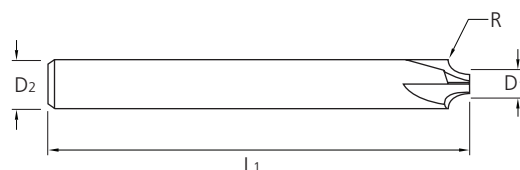
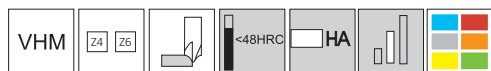


Z4 Z6



Series VCM60		Series VCM90		Tool Dimensions					
Uncoated	Coated	Uncoated	Coated	Ø D ¹	Ø D ²	Angle	L ¹	L ²	Z
VCM60 0400	VCM60 0400A	-	-	4.0	4.0	60°	51.0	3.3	4
-	-	VCM90 0400	VCM90 0400A	4.0	4.0	90°	51.0	1.8	4
VCM60 0600	VCM60 0600A	-	-	6.0	6.0	60°	64.0	5.0	4
-	-	VCM90 0600	VCM90 0600A	6.0	6.0	90°	64.0	2.8	4
VCM60 0800	VCM60 0800A	-	-	8.0	8.0	60°	64.0	6.8	4
-	-	VCM90 0800	VCM90 0800A	8.0	8.0	90°	64.0	3.8	4
VCM60 1000	VCM60 1000A	-	-	10.0	10.0	60°	73.0	8.5	6
-	-	VCM90 1000	VCM90 1000A	10.0	10.0	90°	73.0	4.8	6
VCM60 1200	VCM60 1200A	-	-	12.0	12.0	60°	84.0	10.0	6
-	-	VCM90 1200	VCM90 1200A	12.0	12.0	90°	84.0	5.8	6
VCM60 1600	VCM60 1600A	-	-	16.0	16.0	60°	93.0	13.5	6
-	-	VCM90 1600	VCM90 1600A	16.0	16.0	90°	93.0	7.8	6

TuffCut® GP Corner Rounding Series ACR



Series ACR	Tool Dimensions			
Tool No.	Ø D ¹	D ²	L ¹	R
ACR0300-0.25R	2.3 / 2.4	3.0	51.0	0.25
ACR0400-0.5R	2.8 / 2.9	4.0	51.0	0.5
ACR0500-0.75R	3.3 / 3.4	5.0	57.0	0.75
ACR0500-1.0R	2.7 / 2.9	5.0	57.0	1.0
ACR0600-1.5R	2.7 / 2.9	6.0	64.0	1.5
ACR0600-2.0R	1.7 / 1.9	6.0	64.0	2.0
ACR0800-2.0R	3.7 / 3.9	8.0	64.0	2.0
ACR1000-3.0R	3.7 / 3.9	10.0	73.0	3.0
ACR1200-4.0R	3.7 / 3.9	12.0	84.0	4.0
ACR1600-5.0R	5.7 / 5.9	16.0	93.0	5.0
ACR1600-6.0R	3.7 / 3.9	16.0	93.0	6.0