

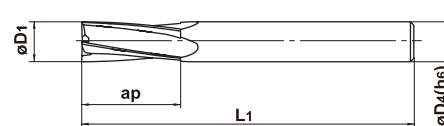
DIAMOND COATED END MILLS

DFC4JC

End mill, Semi long cut length, 4 flute



CFRP



Type1



$6 \leq D1 \leq 12$				
0 $- 0.03$				
$D4=6$	$8 \leq D4 \leq 10$	$D4=12$		
0 $- 0.008$	0 $- 0.009$	0 $- 0.011$		



● 4 flute end mill with CVD diamond coating for CFRP machining.

Unit : mm

Order Number	D1	ap	L1	D4	Flutes	Stock	Type
DFC4JCD0600	6	20	70	6	4	★	1
D0800	8	30	80	8	4	★	1
D1000	10	30	90	10	4	★	1
D1200	12	30	100	12	4	★	1

RECOMMENDED CUTTING CONDITIONS

Work material	CFRP	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	11000	950
8	8000	780
10	6400	700
12	5300	650

- 1) Cutting conditions may differ considerably due to the type of CFRP, the rigidity of the machine or the clamping and geometry of the workpiece. Please use the above table as a standard starting point.
- 2) When high machining accuracy is needed, or large burrs or delamination occurs, we recommend reducing the feed rate.
- 3) When the depth of cut is greater than 0.8D1, we recommend reducing the feed rate.
- 4) Please take precautions against dust.

★ : Inventory maintained in Japan.