

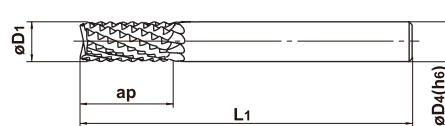
DFCJRT

Cross-nick type end mill, Semi long cut length



CARBIDE

CFRP



Type1

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS

h6

D4=6	8≤D4≤10	D4=12		
$\begin{matrix} 0 \\ -0.008 \end{matrix}$	$\begin{matrix} 0 \\ -0.009 \end{matrix}$	$\begin{matrix} 0 \\ -0.011 \end{matrix}$		

- Cross-nick type end mill with original CVD diamond coating for CFRP machining.

Unit : mm

Order Number	D1	ap	L1	D4	Flutes	Stock	Type
DFCJRTO600	6	20	70	6	10	★	1
D0800	8	30	80	8	10	★	1
D1000	10	30	90	10	12	★	1
D1200	12	30	100	12	12	★	1

RECOMMENDED CUTTING CONDITIONS

Work material	CFRP	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	11000	1200
8	8000	1000
10	6400	900
12	5300	850

- 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.