

DIAMOND COATED END MILLS

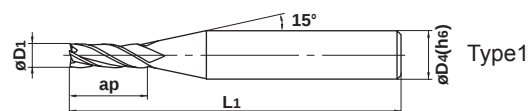
DF4JC

End mill, Semi long cut length, 4 flute, For graphite

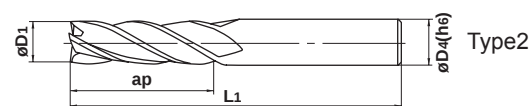


Aluminium Alloy

Graphite

GFRP
CFRPMachineable
Ceramics

Type1



Type2



$3 \leq D_1 \leq 12$				
0 - 0.02				
$D_4 = 6$	$8 \leq D_4 \leq 10$	$D_4 = 12$		
0 - 0.008	0 - 0.009	0 - 0.011		

- 4 flute end mill with original diamond coating for graphite machining.

Unit : mm

Order Number	D1	ap	L1	D4	Flutes	Stock	Type
DF4JCD0300	3	12	60	6	4	●	1
D0400	4	16	60	6	4	●	1
D0600	6	24	60	6	4	●	2
D0800	8	28	70	8	4	●	2
D1000	10	35	90	10	4	●	2
D1200	12	36	110	12	4	●	2

RECOMMENDED CUTTING CONDITIONS

Work material	Graphite	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	22000	2500
4	18000	2900
6	14000	3200
8	10500	2900
10	8700	2600
12	7200	2200
Depth of cut		
	D: Dia.	

- When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
- Use a milling machine dedicated for graphite.
- If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : Inventory maintained.