

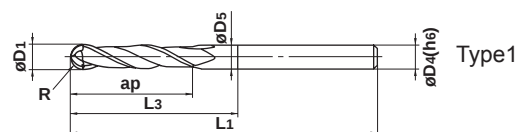
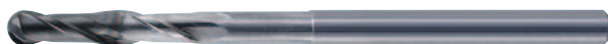
DF2MB

Ball nose, Medium cut length, 2 flute, For graphite



CARBIDE

Aluminium Alloy	Graphite	GFRP CFRP	Machineable Ceramics
○	◎	○	○



	3 ≤ R ≤ 6				
	±0.01				
	D4=6	8 ≤ D4 ≤ 10	D4=12		
	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$	$\begin{smallmatrix} 0 \\ -0.011 \end{smallmatrix}$		

- 2 flute ball nose end mill with original diamond coating for graphite machining.

Unit : mm

Order Number	R	D1	ap	L3	D5	L1	D4	Flutes	Stock	Type
DF2MBR0300A100	3	6	30	50	5.85	100	6	2	●	1
R0300A150	3	6	30	50	5.85	150	6	2	●	1
R0400A110	4	8	40	60	7.85	110	8	2	●	1
R0400A150	4	8	40	60	7.85	150	8	2	●	1
R0500A120	5	10	50	70	9.7	120	10	2	●	1
R0500A180	5	10	50	70	9.7	180	10	2	●	1
R0600A130	6	12	55	75	11.7	130	12	2	●	1
R0600A200	6	12	55	75	11.7	200	12	2	●	1

RECOMMENDED CUTTING CONDITIONS

Work material		Graphite			
R (mm)	Overall length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
R3	100	10000—16000	1200—2100	0.6	1.5
	150	6000—10000	600—1200	0.4	1.2
R4	110	9000—12000	1500—2200	0.8	2
	150	5000— 9000	700—1500	0.6	1.6
R5	120	7500—10000	1700—2400	1	2.5
	180	5000— 7500	1000—1700	0.8	2
R6	130	6000— 8000	1300—1900	1.2	3
	200	4000— 6000	800—1300	1	2.5
Depth of cut					

- 1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
- 2) Use a milling machine dedicated for graphite.
- 3) 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.

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS