

DIAMOND COATED END MILLS**DF3XB**

Ball nose, 3 flute, Taper neck, For graphite

RECOMMENDED CUTTING CONDITIONS

Work material		Graphite			
R (mm)	Neck length (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut a_p (mm)	Depth of cut a_e (mm)
R0.5	30	20000	1100	0.05	0.13
	40	15000	750	0.04	0.11
	50	12000	500	0.03	0.1
R1	40	20000	1800	0.13	0.4
	60	15000	900	0.09	0.27
	80	12000	600	0.07	0.2
R1.5	60	14000	1700	0.15	0.45
	80	12000	1200	0.12	0.35
R2	100	10000	1100	0.2	0.5
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.