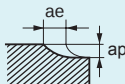


DIAMOND COATED END MILLS

DFPSRB

Corner radius end mill, Short cut length, 2–4 flute, High precision, For graphite

RECOMMENDED CUTTING CONDITIONS

Work material			Graphite			
Dia. (mm)	Corner radius (mm)	Neck length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.5	0.1	4	30000	1100	0.05	0.23
	0.1	5	28000	960	0.05	0.23
	0.1	6	25000	850	0.05	0.23
	0.1	10	22000	600	0.04	0.21
	0.1	15	20000	500	0.03	0.18
0.8	0.1	6	28000	1300	0.08	0.45
	0.1	8	22000	900	0.08	0.45
1	0.1	8	25000	1500	0.1	0.6
	0.1	12	22000	1300	0.1	0.6
	0.2	8	25000	1500	0.1	0.45
	0.2	12	22000	1300	0.1	0.45
	0.2	16	18000	1000	0.08	0.4
	0.2	20	15000	800	0.08	0.4
	0.2	30	12000	600	0.07	0.35
1.5	0.2	10	25000	2100	0.15	0.8
	0.2	20	18000	1400	0.15	0.8
2	0.2	12	22000	3000	0.2	1.2
	0.2	16	19000	2500	0.2	1.2
	0.2	20	16000	2000	0.2	1.2
	0.2	30	13000	1600	0.16	1
	0.2	40	11000	1200	0.14	0.8
3	0.2	20	18000	3000	0.3	2
	0.2	40	12000	1800	0.25	1.7
	0.5	20	18000	3000	0.3	1.5
4	0.2	20	18000	4200	0.4	2.7
	0.2	40	13000	2800	0.4	2.7
	0.5	20	18000	4200	0.4	2.3
	0.5	40	13000	2800	0.4	2.3
6	0.5	30	14000	4600	0.6	3.8
	1	30	14000	4600	0.6	3
8	0.5	30	10500	4000	0.8	5.3
	1	30	10500	4000	0.8	4.5
10	0.5	40	8700	3500	1	6.8
	1	40	8700	3500	1	6
12	0.5	40	7200	3000	1.2	8
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.