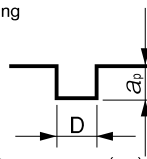


Milling Conditions for DCES (2 Flutes)

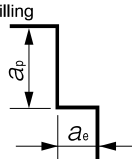
WORK MATERIAL			GRAPHITE				
Model Number	Outside Diameter (mm)	Length of Cut (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Side Milling		Slotting
					a_p Axial Depth (mm)	a_e Radial Depth (mm)	a_p Axial Depth (mm)
2002-0060	0.2	0.6	30,000	1,000	0.6	0.01	0.006
2005-0150	0.5	1.5	30,000	1,100	1.5	0.025	0.02
2010-0300	1	3	28,000	1,300	3	0.05	0.05
2015-0450	1.5	4.5	25,000	1,500	4.5	0.075	0.12
2020-0600	2	6	24,000	1,800	6	0.1	0.15
2030-0900	3	9	25,000	2,600	9	0.15	0.3
2040-1200	4	12	19,000	2,000	12	0.24	0.6
2060-1800	6	18	13,000	1,500	18	0.36	1.2

Slotting



D : Outside Diameter (mm)

Side Milling



Note:

- Use a milling machine dedicated for Graphite.
- Recommend air blow for Graphite.

Other series for Graphite milling

Square / Long Neck Square

(★ Highly Recommended ● Recommended ○ Suggested)

Number of Flutes, Tool Type	Model Number	Appearance	Coating	Size	Aluminum Alloys	Graphite	Copper	Plastics	Glass Filled Plastics	Hard Brittle (Non-Metallic) Materials	Page
4 flutes Square	CGE		Non-coat	$\phi 2 \sim \phi 20$	○	★	○	○	○		236
2 flutes Square	DCES 2000		DIA	$\phi 0.2 \sim \phi 6$	○	★	○	○	●	○	188
4 flutes Square	DCES 4000		DIA	$\phi 3 \sim \phi 10$	○	★	○	○	●	○	234
2 flutes Long Neck Square	DCLS		DIA	$\phi 0.4 \sim \phi 6$	○	★	○	○	●	○	266

Long Neck Radius

4 flutes Long Neck Radius	DCLRS		DIA	$\phi 1 \sim \phi 6$	○	★	○	○	●	○	396
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Ball / Long Neck Ball / Taper Neck Ball

2 flutes Ball	CGB 2000		Non-coat	R0.2~R6	○	★	○	○	○		440
4 flutes Ball	CGB 4000		Non-coat	R2~R10	○	★	○	○	○		458
2 flutes Ball	DCB		DIA	R0.5~R6	○	★	○	○	●	○	438
2 flutes Long Neck Ball	DCLB		DIA	R0.2~R3	○	★	○	○	●	○	512
2 flutes Taper Neck Ball	DCTNB		DIA	R0.5~R1	○	★	○	○	●	○	556

φ3mm Shank V Series

UDC-PCD Series

CBN Series

Square

Long Neck Square

Radius

Long Neck Radius

Taper Neck Radius

Ball / Long Shank Ball

Long Neck Ball

Taper Neck Ball

Taper

Barrel

Spiral V Cutter

Drill

Technical Data