DEB1000

N Non-ferrous

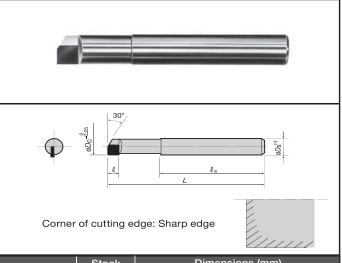| 1 No. of teeth | 0° Helix |

High speed endmill for aluminum

Note: • As cutting edge is very sharp, please handle carefully.
- Please keep the overhang length from milling chuck of tool as short as possible.
- Please use the endmill on a machine with sufficient rigidity.

Corner of cutting edge: Sharp edge

Cat. No.	Stock	Dimensions (mm)				
	DX140	$\varnothing D_C$	$\varnothing D_S$	ℓ	ℓ_S	L
DEB1040	○	4.0	6.0	3.5	32	45
DEB1050	○	5.0			35	50
DEB1060	○	6.0				55
DEB1070	○	7.0	8.0	5	37	
DEB1080	○	8.0				
DEB1090	○	9.0	10.0		40	60
DEB1100	○	10.0				
DEB1110	○	11.0	12.0		45	65
DEB1120	○	12.0				

▌Standard cutting conditions

DEB1000

For side milling $a_p \geq 3D$, $a_e = .004$ in

Work materials	Aluminum alloys, Copper alloys	
Speed v_C (SFM)	400 ~ 590	
Condition / Mill dia.(mm)	No. of revolutions n (min^{-1})	Table feed Vf (in/min)
ø4	12,000	5
ø5	9,600	
ø6	8,000	
ø8	6,000	
ø10	4,800	
ø12	4,000	4

- Set the protrusion length as short as possible. Reduce number of revolutions and table feed in order to prevent chattering when the protrusion length is long.
- Use the machine with high rigidity.
- Adjust the number of revolutions and the table feed according to the situation of use (depth of cut or machine rigidity etc.).

○ : Stocked in Japan

Most unmarked items are available on a RFQ basis, contact your sales rep for more information.

Relating pages   Technical reference (14-1)