

# MIRACLE END DF

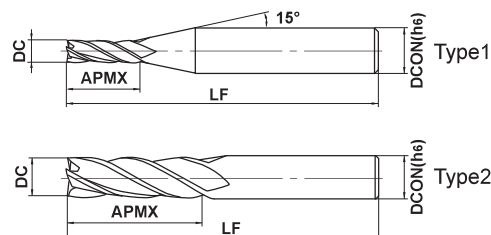
## DF4JC

End mill, Semi long cut length, 4 flute, For graphite



CARBIDE

Aluminium Alloy	Copper Alloy	Graphite	GFRP CFRP	Machinable Ceramics
○	○	○	○	○



	3 ≤ DC ≤ 12				
	$\begin{matrix} 0 \\ -0.02 \end{matrix}$				
	DCON=6	8 ≤ DCON ≤ 10	DCON=12		
	$\begin{matrix} 0 \\ -0.008 \end{matrix}$	$\begin{matrix} 0 \\ -0.009 \end{matrix}$	$\begin{matrix} 0 \\ -0.011 \end{matrix}$		

● 4 flute end mill with original diamond coating for graphite machining.

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DF4JCD0300	3	12	60	6	4	●	1
DF4JCD0400	4	16	60	6	4	●	1
DF4JCD0600	6	24	60	6	4	●	2
DF4JCD0800	8	28	70	8	4	●	2
DF4JCD1000	10	35	90	10	4	●	2
DF4JCD1200	12	36	110	12	4	●	2

### RECOMMENDED CUTTING CONDITIONS

Work material	Graphite				Copper, Copper alloys				
	Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of Cut (mm)	Cutting Width (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of Cut (mm)	Cutting Width (mm)
	3	22000	2500	6	0.15	10600	280	6	0.15
	4	18000	2900	8	0.2	8000	330	8	0.2
	6	14000	3200	12	0.3	6400	380	12	0.3
	8	10500	2900	16	0.4	4000	420	16	0.4
	10	8700	2600	20	0.5	3200	460	20	0.5
	12	7200	2200	24	0.6	2700	460	24	0.6

Depth of cut		DC: Dia.
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- 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.