

DFC END MILLS

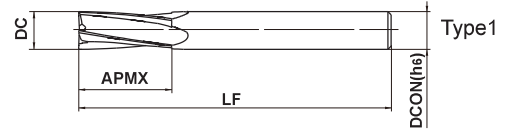
DFC4JC

Diamond coating endmill, 4 flute



CARBIDE

CFRP



SQUARE

	6 ≤ DC ≤ 12				
	$\begin{matrix} 0 \\ -0.03 \end{matrix}$				
	DCON=6	8 ≤ DCON ≤ 10	DCON=12		
	$\begin{matrix} 0 \\ -0.008 \end{matrix}$	$\begin{matrix} 0 \\ -0.009 \end{matrix}$	$\begin{matrix} 0 \\ -0.011 \end{matrix}$		

BALL

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

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
DFC4JCD0600	6	20	70	6	4	●	1
DFC4JCD0800	8	30	80	8	4	●	1
DFC4JCD1000	10	30	90	10	4	●	1
DFC4JCD1200	12	30	100	12	4	●	1

RADIUS

TAPER

Note) Please contact Mitsubishi Materials for geometries and through coolant types that are non-standard.

RECOMMENDED CUTTING CONDITIONS

Work material	CFRP	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	11000	950
8	8000	780
10	6400	700
12	5300	650

SOLID END MILLS

- 1) Cutting conditions may differ considerably due to the kind of CFRP, the rigidity of the machine, or the clamping and geometry of the workpiece. Please use the above table as a guideline.
- 2) When high machining accuracy is needed or if large burrs or delamination occur, we recommend reducing the feed rate.
- 3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.
- 4) Please take precautions against dust.

● : Inventory maintained in Japan.