

DF END MILLS

CARBIDE

DF2XLB

Ball nose, Medium cut length, 2 flute, Long neck, For graphite

| Work material | | Graphite | | | | Copper, Copper alloys | | | |
|------------------|------------------------|------------------------------------|-----------------------|-------------------------|-------------------------|------------------------------------|-----------------------|-------------------------|-------------------------|
| R PRFRAD (mm) | Neck length LU (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Depth of cut ap (mm) | Depth of cut ae (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Depth of cut ap (mm) | Depth of cut ae (mm) |
| R0.75 | 8 | 40000 | 2800 | 0.15 | 0.45 | 40000 | 2400 | 0.07 | 0.15 |
| | 10 | 40000 | 2800 | 0.15 | 0.45 | 32000 | 1800 | 0.05 | 0.15 |
| | 16 | 35000 | 2000 | 0.15 | 0.3 | 20000 | 900 | 0.03 | 0.15 |
| | 30 | 27000 | 1000 | 0.1 | 0.3 | — | — | — | — |
| R1 | 8 | 40000 | 3000 | 0.23 | 0.7 | 40000 | 3000 | 0.1 | 0.2 |
| | 10 | 40000 | 3000 | 0.2 | 0.6 | 40000 | 2800 | 0.08 | 0.2 |
| | 12 | 35000 | 2500 | 0.2 | 0.6 | 35000 | 2300 | 0.08 | 0.2 |
| | 16 | 30000 | 2000 | 0.2 | 0.5 | 30000 | 1800 | 0.05 | 0.2 |
| | 20 | 30000 | 2000 | 0.2 | 0.5 | 20000 | 1200 | 0.04 | 0.2 |
| | 25 | 25000 | 1500 | 0.18 | 0.45 | 20000 | 1000 | 0.03 | 0.2 |
| | 40 | 20000 | 1000 | 0.15 | 0.4 | — | — | — | — |
| R1.5 | 16 | 28000 | 3000 | 0.3 | 0.9 | 28000 | 3000 | 0.3 | 0.3 |
| | 25 | 20000 | 2000 | 0.25 | 0.75 | 20000 | 2000 | 0.25 | 0.3 |
| | 40 | 16000 | 1500 | 0.2 | 0.6 | 16000 | 1500 | 0.2 | 0.3 |
| | 60 | 14000 | 1000 | 0.17 | 0.45 | — | — | — | — |
| R2 | 8 | 24000 | 3800 | 0.5 | 1.5 | 24000 | 3800 | 0.5 | 0.4 |
| | 20 | 21000 | 3300 | 0.5 | 1.5 | 21000 | 3300 | 0.4 | 0.4 |
| | 30 | 15000 | 2000 | 0.4 | 1.2 | 15000 | 2000 | 0.3 | 0.4 |
| | 40 | 13000 | 1600 | 0.35 | 1.0 | 13000 | 1600 | 0.25 | 0.4 |
| | 60 | 12000 | 1400 | 0.3 | 0.9 | 12000 | 1400 | 0.2 | 0.4 |
| R3 | 12 | 17000 | 2800 | 0.6 | 2.0 | 17000 | 2800 | 0.6 | 0.6 |
| Depth of cut | | | | | | | | | |

SOLID END MILLS

- 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.