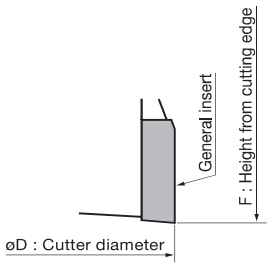
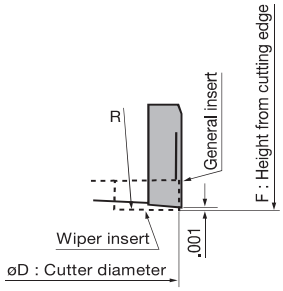
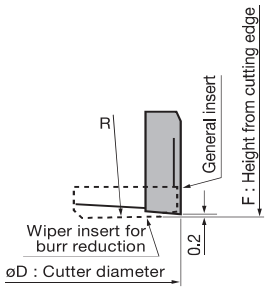
DPD24

Standard cutting conditions

Work materials	Grades	Roughing		Finishing	
		Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)	Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)
Aluminum alloys (Si < 13%)	DX140	650 ~ 4900	.002 ~ .008	650 ~ 4900	.002 ~ .010
Aluminum alloys (Si ≥ 13%)		650 ~ 1300		650 ~ 1300	
Copper alloys		650 ~ 1650		650 ~ 1650	

Note : • Use of water-soluble cutting fluid is recommended.
• Dry cutting is also possible. However, wet cutting excels in chipbreaking and attaining superior surface quality.
• DPD24-type is not designed to cope with the centrifugal force and dynamic balance at high speed over 1,500 SFM. Therefore, the cutting speed in the outer diameter of mill should not exceed 1,500 SFM.

How to put each insert together

			For general	Accuracy of machining surface priority	Burr reduction priority
Applicable insert	General insert	YDEN2405PDFR-D	◎	◎	◎
	Wiper insert	YDEN2405PDFR-WD	–	◎	–
	Wiper insert for burr reduction	YDEN2405PDFR-BD	–	–	◎
	Number of Inserts by type		All general	1 or 2 wiper inserts in cutter body	General insert : Burr wiper insert = 1 : 1
Specification of insert setting					
Accuracy of machining surface (roughness and undulation)			△	◎	○
Burr of machining surface			△	○	◎

△ Optimal
◎ 2nd Choice
○ General