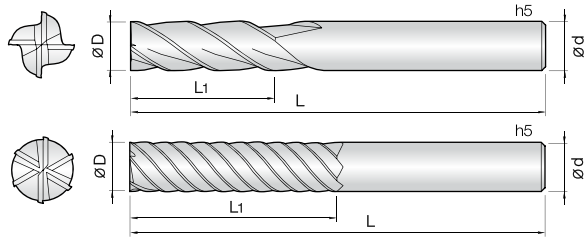


# 4&6DEM

4&6 Flutes Diamond Coated End Mills for Graphite



D Size	D Tolerance
Ø2 ~ 16	+0 ~ -0.02 mm

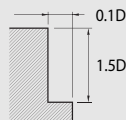
## 2DEM / 3DEM / 4 & 6DEM

### Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	2DEM				4DEM				6DEM			
	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Graphite												
Ø0.2	40,000	100	0.3	0.02	-	-	-	-	-	-	-	-
Ø0.4	40,000	200	0.6	0.04	-	-	-	-	-	-	-	-
Ø0.6	40,000	350	0.9	0.06	-	-	-	-	-	-	-	-
Ø0.8	40,000	550	1.2	0.08	-	-	-	-	-	-	-	-
Ø1	40,000	700	1.5	0.10	-	-	-	-	-	-	-	-
Ø2	25,000	800	3.0	0.20	-	-	-	-	-	-	-	-
Ø3	20,000	800	4.5	0.30	20,000	1,600	4.5	0.3	-	-	-	-
Ø4	18,000	950	6.0	0.40	18,000	1,900	6.0	0.4	-	-	-	-
Ø5	14,000	1,200	7.5	0.50	14,000	2,400	7.5	0.5	-	-	-	-
Ø6	11,000	1,400	9.0	0.60	11,000	2,800	9.0	0.6	22,200	8,000	9	0.6
Ø8	8,000	1,300	12.0	0.80	8,000	2,600	12.0	0.8	16,800	8,000	12	0.8
Ø10	6,500	1,200	15.0	1.00	6,500	2,400	15.0	1.0	13,400	8,000	15	1.0
Ø12	5,500	1,200	18.0	1.20	5,500	2,400	18.0	1.2	11,350	6,700	18	1.2
Ø16	5,500	1,200	24.0	1.60	-	-	-	-	8,400	5,000	24	1.6

Depth of Cut



- If the effective length is long, reduce the RPM and feed in the same proportion.
- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Use a machine with low vibration and good rigidity (Ø1 or less, the vibration tolerance management should be within 5 µm).
- For graphite milling, air blow method is recommended.