

- Endmills for CFRP, GFRP, glass/carbon fiber, graphite, copper, copper alloy, nonferrous and non-metallic materials.
- Outstanding performance in machining of various composite materials.
- Excellent wear resistance by applying high hardness coating layer.
- Minimize built up edge by low friction diamond coating technology.

2

WC

NANO  
DIA.  
Coating

DI  
+0 -0.01

DI  
-0.005 -0.015

20°  
Helix Angle

Ø2~Ø5.5    Ø6~Ø12

D Size	D Tolerance
Ø2 ~ 5.5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm

: mm

## 2DDCA

### Cutting Condition

• RPM: rev./min    • Feed: mm/min

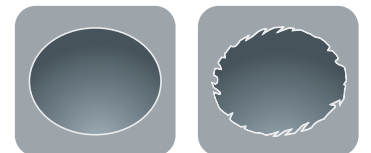
Material	CFRP			
Outside Diameter	RPM	FEED	V/C	Fz
Ø2	15,900	960	100 ~ 150	0.03 ~ 0.07
Ø2.5	12,700	760	"	"
Ø3	10,600	630	"	"
Ø4	7,960	480	"	"
Ø5	6,370	380	"	"
Ø6	5,300	320	"	"
Ø8	3,980	240	"	"
Ø9	3,540	210	"	"
Ø10	3,180	190	"	"
Ø11	2,890	175	"	"
Ø12	2,650	160	"	"

- Above the parameters are based on V/C 100 with Fz 0.03. Actual machining can be changed depending on your machining purpose and condition of your machine.
- 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.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.

### ■ JJTOOLS drills benefit

Minimize burr by the best drill design

#### Machining Sample



2DDCA type

Other manufacturer