

Diamond Type end mill

(Metric) DIAMOND TYPE COMPOSITE END MILL surface speed and chip load table								
	Surface Speed m/min	Chip load by cutter diameter mm / REVOLUTION					Depth of cut	
		1.0 mm	1.5 mm	2.0 mm	3.175 mm	6.0 mm	Axial	Radial
Roughing	150-210	0.03302	0.05334	0.06604	0.10668	0.21336	1 x Tool dia.	1 x Tool dia.
Profiling		0.0381	0.06096	0.0762	0.12192	0.24638	1 x Tool dia.	0.2 x Tool dia.

(Imperial) DIAMOND TYPE COMPOSITE END MILL surface speed and chip load table								
	Surface Speed SFM	Chip load by cutter diameter in / REVOLUTION					Depth of cut	
		1.0 mm	1.5 mm	2.0 mm	3.175 mm	6.0 mm	Axial	Radial
Roughing	500-700	0.0013	0.0021	0.0026	0.0042	0.0084	1 x Tool dia.	1 x Tool dia.
Profiling		0.0015	0.0024	0.003	0.0048	0.0097	1 x Tool dia.	0.2 x Tool dia.

*-All recommended speed and feed parameters are suggested starting values. These values can be adjusted according to needs.

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4 Flute end mill

(Metric) 4 FLUTE FINISHING END MILL surface speed and chip load table								
	Surface Speed m/min	Chip load by cutter diameter mm / TOOTH					Depth of cut	
		1.0 mm	1.5 mm	2.0 mm	3.0 mm	6.0 mm	Axial	Radial
Finishing	145-200	0.00762	0.01524	0.01778	0.03048	0.05842	3 x Tool dia.	0.05 x Tool dia.

(Imperial) 4 FLUTE FINISHING END MILL surface speed and chip load table								
	Surface Speed SFM	Chip load by cutter diameter in / TOOTH					Depth of cut	
		1.0 mm	1.5 mm	2.0 mm	3.0 mm	6.0 mm	Axial	Radial
Finishing	480-650	0.0003	0.0006	0.0007	0.0012	0.0023	3 x Tool dia.	0.05 x Tool dia.

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