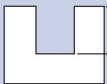





List 7440: DG-EML

Contouring

Work Material	Graphite			
	Slotting		Side Milling	
Cutting Speed	246 SFM		246 SFM	
Depth of Cut	 $Aa = 0.1D$		 $Aa = 1D$ $Ar = 0.1D$	
Mill Dia. Inch	Speed RPM	Feed in/min	Speed RPM	Feed in/min
1/32	25,000	100	25,000	142
3/64	20,000	66	20,000	95
1/16	15,000	50	15,000	71
3/32	10,000	33	10,000	47
1/8	7,520	25	7,520	35
3/16	5,010	16	5,010	24
1/4	3,860	12	3,860	18
3/8	2,500	8	2,500	12
1/2	1,880	6	1,880	9

Set the ramping angle to be approximately 3°.

1. Adjust the speed, the feed rate, and the depth of cut to suit your operating conditions, such as the milling shape, machine rigidity, tool holder rigidity, and work holding force.
2. If you are unable to reach the speed and feed rate indicated in the table above, lower the speed and feed rate using the same ratio.
3. If the workpiece gets chipped or if the operation requires a higher level of milling precision, lower the feed rate as necessary.
4. Depending on the shape, if the workpiece chatters, lower the speed and feed rate using the same ratio.
5. To mill graphite, use a dedicated milling machine. To prevent inhalation of dust, use a dust collector and a dust mask when working around graphite.
6. During milling, keep the runout at the tip of the end mill to be less than 0.0004 inches (0.01 mm).
7. If a cut involves the shaping of a corner during side milling, use the corner radius process of the program, or adjust the speed so that it will not cause chattering, and reduce the speed at the corner at the same time (approximately 40%).

