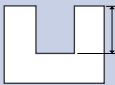



List 7441: DG-LN-EML

Contouring

Work Material	Graphite			
	Slotting		Side Milling	
Cutting Speed	123 SFM		123 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	15,000	33	15,000	47
3/64	10,000	22	10,000	32
1/16	7,500	16	7,500	23
3/32	5,000	11	5,000	16
1/8	3,760	8	3,760	12
3/16	2,500	5	2,500	8
1/4	1,930	4	1,930	6

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%).