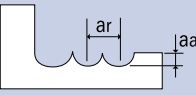
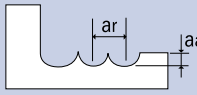




List 7430: DG-EBML

Contouring

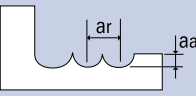
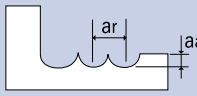
Work Material	Graphite			
	Roughing		Finishing	
Cutting Speed	164 SFM		164 SFM	
Depth of Cut				
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min
Inch				
1/32	20,000	95	20,000	95
3/64	13,365	63	13,365	63
1/16	10,025	47	10,025	47
3/32	6,680	32	6,680	32
1/8	5,010	24	5,010	24
3/16	3,340	16	3,340	16
1/4	2,505	12	2,505	12
3/8	1,670	8	1,670	8
1/2	1,255	6	1,255	6

Set the ramping angle to be approximately 0.5°.

- 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.
- 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.
- If the workpiece gets chipped or if the operation requires a higher level of milling precision, lower the feed rate as necessary.
- Depending on the shape, if the workpiece chatters, lower the speed and feed rate using the same ratio.
- 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.
- During milling, keep the runout at the tip of the end mill to be less than 0.0004 inches (0.01 mm).
- If a cut involves the shaping of a corner, 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 60%).

List 7431: DG-LN-EBML

Contouring

Work Material	Graphite			
	Roughing		Finishing	
Cutting Speed	82 SFM		82 SFM	
Depth of Cut				
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min
Inch				
1/32	10,000	31	10,000	31
3/64	6,685	21	6,685	21
1/16	5,015	16	5,015	16
3/32	3,340	11	3,340	11
1/8	2,505	8	2,505	8
3/16	1,670	5	1,670	5
1/4	1,255	4	1,255	4
3/8	835	3	835	3
1/2	630	2	630	2

Set the ramping angle to be approximately 0.5°.

- 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.
- 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.
- If the workpiece gets chipped or if the operation requires a higher level of milling precision, lower the feed rate as necessary.
- Depending on the shape, if the workpiece chatters, lower the speed and feed rate using the same ratio.
- 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.
- During milling, keep the runout at the tip of the end mill to be less than 0.0004 inches (0.01 mm).
- If a cut involves the shaping of a corner, 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 60%).

