



DPB2000 (Milling Condition)



Danger of fire by spark incidence or heat caused by tool breakage can happen during processing.
Confirm fire prevention countermeasure beforehand necessarily before use.

Work Material	GRAPHITE		COPPER ALLOYS	
Radius of Ball Nose	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
R0.5	20,000~40,000	800~2,000	20,000~40,000	800~3,000
R0.75	18,000~35,000	1,200~2,000	18,000~30,000	1,200~3,000
R1.0	12,000~30,000	1,200~2,000	12,000~20,000	1,200~3,000
R1.5	10,000~20,000	1,200~2,000	16,000~20,000	1,800~4,000
R2.0	10,000~15,000	1,300~2,000	16,000~20,000	2,100~4,000
R3.0	9,000~16,000	1,500~2,100	13,300~20,000	1,600~4,000
R4.0	8,000~12,000	1,400~2,200	10,000~16,000	1,400~3,200
R5.0	6,000~10,000	1,280~2,400	8,000~12,800	1,280~3,000
R6.0	4,000~8,000	1,200~1,900	6,600~10,000	1,190~2,660
DEPTH OF CUT	Ad = 0.1D Pf = 0.3D		Ad = 0.05D Pf = 0.3D	

1. Use a rigid and precise machine and holder.
2. Recommend water soluble fluids.