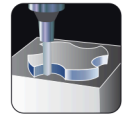


4 flute square end / ball nose diamond coated carbide end mills

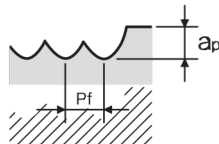


		HYP-EMS-DIAMOND / EBM DIAMOND					
		Graphite		Green Ceramic Thermoset Plastic		Fibre Filler Plastic	
Vc	50 ~ 900 m/min		25 ~ 420 m/min		40 ~ 240 m/min		
Ø	Speed (min-1)	Fz (mm)	Speed (min-1)	Fz (mm)	Speed (min-1)	Fz (mm)	
2	40,000	0.025 ~ 0.05	20,000	0.025 ~ 0.05	11,000	0.025 ~ 0.05	
3	40,000	0.025 ~ 0.05	16,000	0.025 ~ 0.05	10,500	0.025 ~ 0.05	
4	40,000	0.025 ~ 0.05	16,000	0.025 ~ 0.05	10,500	0.025 ~ 0.05	
5	40,000	0.025 ~ 0.05	15,000	0.025 ~ 0.05	10,000	0.025 ~ 0.05	
6	36,000	0.050 ~ 0.10	12,500	0.050 ~ 0.10	9,000	0.040 ~ 0.08	
8	32,000	0.050 ~ 0.10	12,000	0.050 ~ 0.10	8,000	0.050 ~ 0.10	
10	28,000	0.075 ~ 0.12	11,500	0.075 ~ 0.12	7,000	0.075 ~ 0.12	
12	24,000	0.075 ~ 0.12	11,000	0.075 ~ 0.12	6,000	0.075 ~ 0.12	
16	19,000	0.075 ~ 0.12	8,750	0.075 ~ 0.12	4,750	0.075 ~ 0.12	
20	15,000	0.075 ~ 0.12	7,000	0.075 ~ 0.12	3,800	0.075 ~ 0.12	

- (1) For high speed / feed milling reduce the depth of cut.
 (2) Reduce speeds & feeds 30% for slotting > 0.5D.

		HYP-EMS-DIAMOND / EBM DIAMOND					
		Aluminium Alloys		MMC		Copper Alloys	
Vc	50 ~ 2400 m/min		30 ~ 225 m/min		100 ~ 2000 m/min		
Ø	Speed (min-1)	Fz (mm)	Speed (min-1)	Fz (mm)	Speed (min-1)	Fz (mm)	
2	25,000	0.025 ~ 0.05	20,000	0.025 ~ 0.05	25,000	0.025 ~ 0.05	
3	24,000	0.025 ~ 0.05	16,000	0.025 ~ 0.05	24,000	0.025 ~ 0.05	
4	20,000	0.025 ~ 0.05	16,000	0.025 ~ 0.05	20,000	0.025 ~ 0.05	
5	16,000	0.025 ~ 0.05	15,000	0.025 ~ 0.05	16,000	0.025 ~ 0.05	
6	12,000	0.040 ~ 0.08	12,000	0.040 ~ 0.08	12,000	0.040 ~ 0.08	
8	9,500	0.050 ~ 0.10	9,500	0.050 ~ 0.10	9,500	0.050 ~ 0.10	
10	8,000	0.075 ~ 0.12	8,000	0.075 ~ 0.12	8,000	0.075 ~ 0.12	
12	6,000	0.075 ~ 0.12	6,000	0.075 ~ 0.12	6,000	0.075 ~ 0.12	
16	4,750	0.075 ~ 0.12	4,750	0.075 ~ 0.12	4,750	0.075 ~ 0.12	
20	3,900	0.075 ~ 0.12	3,900	0.075 ~ 0.12	3,900	0.075 ~ 0.12	

Dia	ap	pf
D < 3	0.02D	0.05D
D > 3	0.1D	0.2D



Dia	ap	ae
D < 3	0.5D	0.05D
D > 3	1D	0.1D

