

Diamond Coated End Mills for Graphite (For Finishing)

DF End Mill Series **DF2XLBF**

The combination of optimized cutting edges and a diamond coating greatly enhances cutting performance.

Note that excellent finished surfaces can be achieved with graphite!

End Cutting Edge Geometry



Crystallized Diamond Coating

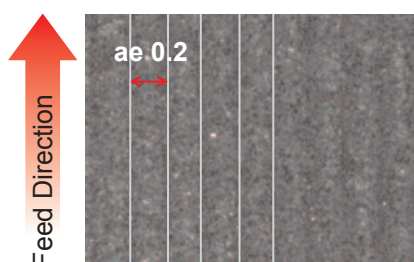
Optimization of the coating film provides even higher sharpness.



Seamless Cutting Edge

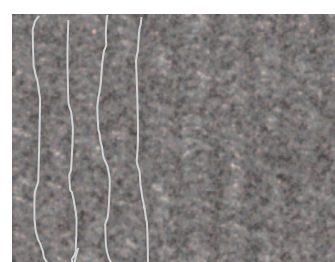
Outstanding finishes are possible even for wall surface machining using minor cutting edges.

Plane Surface Comparison (Graphite ISO-63)



DF2XLBF

The regular cutter path guarantees excellent sharpness.



Conventional

Poor sharpness can cause the cutter path to be crushed.

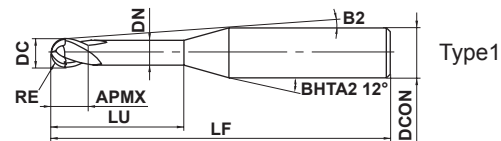
Diamond Coated End Mills for Graphite (For Finishing)

DF2XLBF (For Finishing) NEW

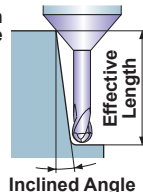
Ball nose, Medium cut length, 2 flute, Long neck, For graphite



Aluminum Alloy	Copper Alloy	Graphite	Zirconia (Before Sintering)	Rigid Composite Resin (Composite Resin)	Machineable Ceramics
○	◎	◎	◎	◎	○



Effective Length
for Inclined Angle



R	0.3 ≤ RE ≤ 1	1.5 ≤ RE			
	±0.005	±0.01			
h5	DCON=4				
	0	-0.008			

● DC long-neck ball end mills are ideal for finished surfaces of non-ferrous metals.

Order Number	RE	DC	APMX	LU	DN	B2	LF	DCON	No.F.*	Stock	Type	Effective Length for Inclined Angle			
												30'	1°	2°	3°
												DF2XLBFR0030N100	0.3	0.6	0.45
DF2XLBFR0050N120	0.5	1	1.5	12	0.86	4.6°	50	4	2	●	1	12.6	13.2	14.4	15.9
DF2XLBFR0050N160	0.5	1	1.5	16	0.86	3.8°	50	4	2	●	1	16.8	17.5	19.2	21.3
DF2XLBFR0050N200	0.5	1	1.5	20	0.86	3.2°	50	4	2	●	1	21	21.9	24	26.6
DF2XLBFR0100N160	1	2	3	16	1.86	2.9°	50	4	2	●	1	16.7	17.4	19	*
DF2XLBFR0100N200	1	2	3	20	1.86	2.4°	50	4	2	●	1	20.9	21.8	23.9	*
DF2XLBFR0150N160	1.5	3	4.5	16	2.86	1.7°	50	4	2	●	1	16.7	17.3	18.9	20.8
DF2XLBFR0150N200	1.5	3	4.5	20	2.86	1.4°	50	4	2	●	1	20.8	21.7	23.7	26.1

* Number of Flutes

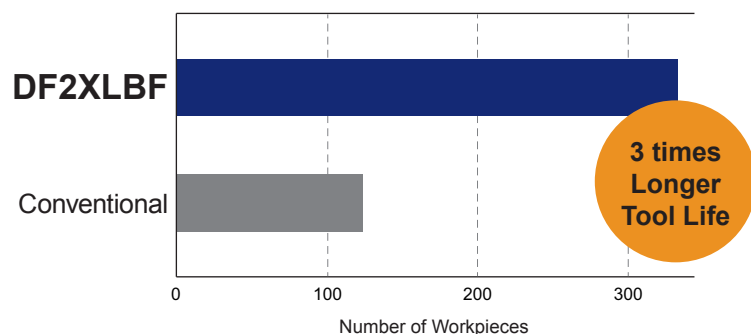
RE = Radius of Ball Nose
DC = Dia.
APMX = Length of Cut

LU = Neck Length
DN = Neck Dia.
B2 = Tangential Clearance Angle

LF = Overall Length
DCON = Shank Dia.

Application Example

Tool Life Comparison (Reference Surface Roughness)



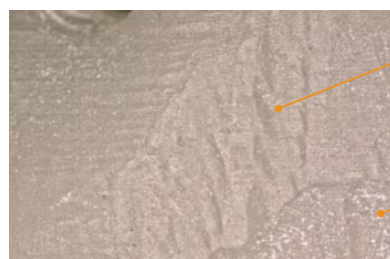
Comparison of Surface Roughness



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Workpiece

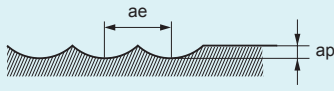


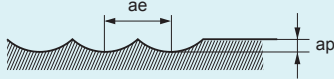
Conventional

● : Inventory maintained in Japan.

Recommended Cutting Conditions

(mm)

Work material			Graphite				Zirconia (Before Sintering)			
DC	RE	LU	n (min ⁻¹)	vf (mm/min)	ap	ae	n (min ⁻¹)	vf (mm/min)	ap	ae
0.6	R0.3	10	35000	1000	0.05	0.015	26000	600	0.06	0.03
1	R0.5	10	40000	2000	0.10	0.200	26000	600	0.10	0.05
		16	35000	1500	0.09	0.200	26000	600	0.08	0.04
		20	30000	1100	0.08	0.200	26000	600	0.08	0.04
2	R1	16	30000	2000	0.20	0.500	18000	1400	0.06	0.80
		20	30000	2000	0.20	0.500	18000	1200	0.50	0.60
3	R1.5	16	28000	3000	0.30	0.900	15000	1600	0.90	0.90
		20	25000	2500	0.20	0.900	15000	1400	0.60	0.80
Depth of cut										

Work material			Copper, Copper alloys				Rigid Composite Resin (Composite Resin)			
DC	RE	LU	n (min ⁻¹)	vf (mm/min)	ap	ae	n (min ⁻¹)	vf (mm/min)	ap	ae
0.6	R0.3	10	30000	600	0.005	0.040	28000	450	0.050	0.050
1	R0.5	10	33000	1400	0.010	0.100	25000	900	0.100	0.100
		16	25000	800	0.007	0.080	25000	700	0.080	0.080
		20	20000	500	0.005	0.050	25000	600	0.080	0.080
2	R1	16	30000	1800	0.050	0.200	25000	2100	0.800	0.800
		20	20000	1200	0.040	0.200	25000	1800	0.500	0.500
3	R1.5	16	28000	3000	0.300	0.300	25000	2400	1.000	1.000
		20	25000	2500	0.200	0.300	25000	2100	0.800	0.800
Depth of cut										

- 1) When high machining accuracy is needed, or the work materials becomes chipped, we recommend lowering the feed rate.
- 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.
- 3) When drying and machining work materials that contain resin, be careful of tool breakage and mechanical problems (as there is a possibility of blockage caused by cutting chips).
- 4) Use a milling machine dedicated for graphite.



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For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

 **MITSUBISHI MATERIALS CORPORATION**

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Overseas Sales Dept, Asian Region

KFC bldg., 8F, 1-6-1 Yokoami, Sumida-ku, Tokyo 130-0015, Japan
TEL +81-3-5819-8771 FAX +81-3-5819-8774

Overseas Sales Dept, European & American Region

KFC bldg., 8F, 1-6-1 Yokoami, Sumida-ku, Tokyo 130-0015, Japan
TEL +81-3-5819-8772 FAX +81-3-5819-8774

<http://www.mitsubishicarbide.com/en/>
(Tools specifications subject to change without notice.)