

4 Flutes NON-COAT for Graphite Milling



Size $\phi 2 \sim \phi 20$

CGE

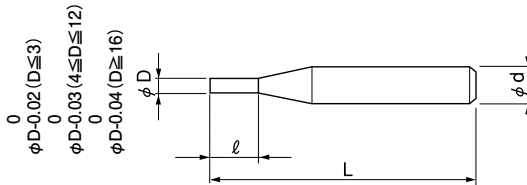


Material Applications (☆ Highly Recommended ● Recommended ○ Suggested)

		Work Material													
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Cast Iron	Aluminum Alloys	Graphite	Copper	Plastics	Glass Filled Plastics	Titanium Alloys	Heat Resistant Alloys	Cemented Carbide	Hard Brittle (Non-Metallic) Materials
			~55HRC	~60HRC	~70HRC										
S45C S55C	SK / SCM SUS	NAK HPM					○	☆	○	○	○				

Features

Designed for Graphite.
Specific carbide grade offers wear and abrasion resistance.
High helix angle reduces chipping of the work material.



Total 10 models

Unit (mm)

Model Number	Outside Diameter ϕD	Length of Cut ℓ	Overall Length L	Shank Diameter ϕd	Price (¥)
CGE 4020	2	15	60	3	16,800
CGE 4030	3	30	80	3	16,800
CGE 4040	4	30	90	4	17,700
CGE 4050	5	35	100	6	18,900
CGE 4060	6	40	150	6	19,320
CGE 4080	8	40	150	8	24,200
CGE 4100	10	45	180	10	30,580
CGE 4120	12	55	200	12	36,850
CGE 4160	16	70	200	16	56,430
CGE 4200	20	70	200	20	87,230

Milling Conditions for CGE

WORK MATERIAL		GRAPHITE	
Velocity		$V_c = 100 \sim 200 \text{ m/min}$	
Model Number	Outside Diameter (mm)	Spindle Speed (min^{-1})	Feed Rate (mm/min)
4020	2	15,900	300
4030	3	15,900	500
4040	4	15,900	650
4050	5	12,700	750
4060	6	10,600	850
4080	8	8,000	950
4100	10	6,400	1,000
4120	12	5,310	1,000
4160	16	3,980	1,000
4200	20	3,180	1,000

Milling Amount for side milling (mm)

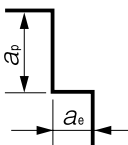
$$a_p = 0.5D$$

$$a_e = 0.05D$$

D : Outside Diameter

a_p : Axial Depth (mm)

a_e : Radial Depth (mm)



Note:

- Use a milling machine dedicated for Graphite.
- Recommend air blow for Graphite.

