

Size R0.5~R6

DCB

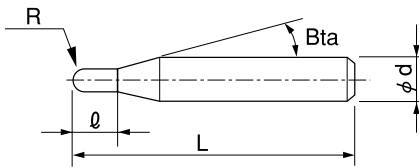


Material Applications (☆ Highly Recommended ● Recommended ○ Suggested)

Work Material															
Carbon Steels S45C S55C	Alloy Steels SK / SCM SUS	Prehardened Steels NAK HPM	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										
							○	☆	○	○	●				○

Features

Diamond coated 2 flute ball for milling Graphite Electrodes.
 New diamond coating, with a highly adhesive base layer, offers excellent wear resistance and longer tool life.



The shank taper angle shown is not an exact value and to avoid contact with the work piece, we recommend the user controls the precise value of this angle. Shank taper angle should not make contact with the work piece.

Total 9 models

Unit (mm)

Model Number	Radius of Ball Nose R	Length of Cut ℓ	Shank Taper Angle Bta	Overall Length L	Shank Diameter φd	Price (¥)
DCB 2010	R0.5	5	16°	60	4	16,000
DCB 2020	R1	10	16°	70	4	17,000
DCB 2030	R1.5	15	16°	80	4	21,000
DCB 2040	R2	20	—	100	4	24,000
DCB 2050	R2.5	20	—	100	5	28,000
DCB 2060	R3	30	—	150	6	41,500
DCB 2080	R4	40	—	150	8	45,000
DCB 2100	R5	50	—	180	10	57,500
DCB 2120	R6	55	—	180	12	87,500

Milling Conditions for DCB

WORK MATERIAL		GRAPHITE			
Model Number	Radius Ball Nose (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p Axial Depth (mm)	a_e Radial Depth (mm)
2010	R0.5	10,000	140	0.1	0.3
2020	R1	10,000	300	0.2	0.6
2030	R1.5	10,000	900	0.3	0.9
2040	R2	10,000	900	0.4	1.2
2050	R2.5	10,000	1,200	0.5	1.5
2060	R3	10,000	1,460	0.6	1.8
2080	R4	7,500	1,350	0.8	2.4
2100	R5	6,000	1,440	1	3
2120	R6	5,000	1,400	1.2	3.6

◆ High speed milling

WORK MATERIAL		GRAPHITE			
Model Number	Radius Ball Nose (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p Axial Depth (mm)	a_e Radial Depth (mm)
2010	R0.5	50,000	700	0.1	0.3
2020	R1	45,000	1,350	0.2	0.6
2030	R1.5	30,000	2,700	0.3	0.9
2040	R2	22,500	2,025	0.4	1.2
2050	R2.5	18,000	2,160	0.5	1.5
2060	R3	15,000	2,190	0.6	1.8
2080	R4	11,500	2,300	0.8	2.4
2100	R5	9,000	2,340	1	3
2120	R6	7,500	2,250	1.2	3.6

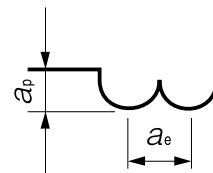
Note:

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

For Finishing
Milling Amount (mm)

a_p : Axial Depth (mm)

a_e : Radial Depth (mm) = P_f



DCB Series
Aluminum:A7075
Milling Video



DCB Series
Graphite:TTK-5(80HS)
Milling Video



Square

Square

Radius

Radius

Ball / Long
Shank Ball

Ball

Ball

Taper

Taper

Spiral
V CutterDrill
Thread Mill

EURO Series

Technical Data