

New Graphite-End Mills



⊖ **GGT Roughing End Mills for machining graphite**



further information under:
WWW.POKOLM.COM

Roughing End Mills GGT alternated teeth, for machining graphite

0108 48

2 end teeth cutting,
plain shank, straight face,
centre cutting,
PVDiaN-diamond coated



SOLID CARBIDE END MILLS	Catalogue-No.	Geometric Parameters								Characteristics	
		d_1	l_2	l_3	d_3	l_1	r	d_2	z	KAC	PVDiaN
	0108 48 030	3	10	-	-	50	-	3	-	KAC	PVDiaN
	0108 48 040	4	10	-	-	50	-	4	-	KAC	PVDiaN
	0108 48 060	6	20	-	-	57	-	6	-	KAC	PVDiaN
	0108 48 080	8	20	-	-	60	-	8	-	KAC	PVDiaN
	0108 48 100	10	25	-	-	70	-	10	-	KAC	PVDiaN
	0108 48 120	12	30	-	-	85	-	12	-	KAC	PVDiaN
	0108 48 160	16	45	-	-	85	-	16	-	KAC	PVDiaN

applications:

- ➔ machining of all Graphite-materials
- ➔ considerable increase of chip volume and thus significant reduction of machining times
- ➔ new cutting edge geometries for 2 and 2.5 – D-operations with maximum cutting length

cutting data for machining of all Graphite-materials

d_1 (mm)	V_C (m/min) micro graphite	V_C (m/min) fine graphite	V_C (m/min) standard graphite	V_f (mm/min)	a_p (mm)	a_e (mm)
3	400	600	800	3000 - 5000	2	3
4	400	600	800	3500 - 5500	3	4
5	400	600	800	3750 - 6250	4	5
6	400	600	800	4000 - 7000	5	6
8	400	600	800	4500 - 8000	6	8
10	400	600	800	5000 - 8500	8	10
12	400	600	800	6000 - 9000	10	12
16	400	600	800	7000 - 10000	12	16