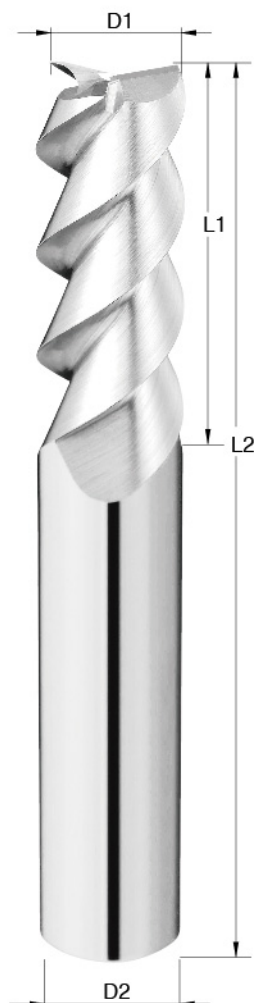


## D MILL

## DEC

► Square / for **N**

unit: mm



MG

3 Flutes

55°

Finishing

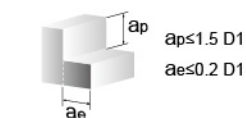
Planing

Slotting

Side

Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
DEC 0206	2.0	6	50	6
DEC 0306	3.0	9	50	6
DEC 0406	4.0	12	50	6
DEC 0506	5.0	15	50	6
DEC 0606	6.0	18	50	6
DEC 0808	8.0	20	60	8
DEC 1010	10.0	30	75	10
DEC 1212	12.0	30	75	12
DEC 1616	16.0	45	100	16
DEC 2020	20.0	45	100	20

## ▼ Depth of cut



## ▼ Recommended cutting condition for DEC

MATERIAL	Aluminum 1070		Aluminum alloy 2014 / 4032 / 5052 / 6061 / 7075		Aluminum alloy AC85		
	Dia. (D1)	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min
2		37000	2400(950)	16000	1000(380)	20000	1300(500)
3		35000	2400(1050)	14000	1000(500)	18000	1300(600)
4		26000	2400(1200)	11000	1000(600)	13000	1300(720)
5		21000	2400(1200)	9000	1000(600)	10000	1300(720)
6		17000	2400(1200)	7000	1000(600)	9000	1300(720)
8		13000	2400(1200)	5500	1000(700)	7000	1300(880)
10		11000	2400(1400)	4400	1000(700)	5500	1300(880)
12		8800	2400(1400)	3600	1000(880)	4500	1300(880)
16		6500	2400(1200)	3000	1000(600)	3500	1300(1000)
20		5300	2400(1200)	2200	1000(600)	2500	1300(700)

( ): Grooving