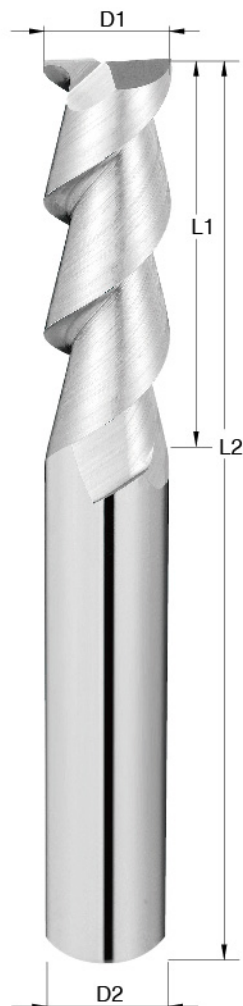


D MILL

DEA

► Square / for **N**

unit: mm



MG

2 Flutes

55°

Finishing

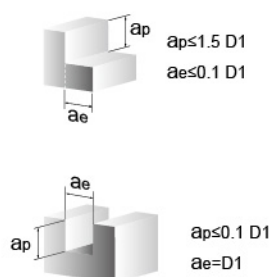
Planing

Slotting

Side

Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
DEA 0106	1.0	3	50	6
DEA 0206	2.0	6	50	6
DEA 0306	3.0	9	50	6
DEA 0406	4.0	12	50	6
DEA 0506	5.0	15	50	6
DEA 0606	6.0	18	50	6
DEA 0808	8.0	20	60	8
DEA 1010	10.0	30	75	10
DEA 1212	12.0	30	75	12
DEA 1616	16.0	45	100	16

▼ Depth of cut



▼ Recommended cutting condition for DEA

MATERIAL	Aluminum 1070		Aluminum alloy 2014 / 4032 / 5052 / 6061 / 7075		Aluminum alloy AC85		
	Dia. (D1)	SPEED (min ⁻¹)	FEED mm / min	SPEED (min ⁻¹)	FEED mm / min	SPEED (min ⁻¹)	FEED mm / min
2		37000	2000(800)	16000	850(350)	20000	1100(450)
3		35000	2000(900)	14000	850(450)	18000	1100(550)
4		26000	2000(1100)	11000	850(550)	13000	1100(660)
5		21000	2000(1100)	9000	850(550)	10000	1100(660)
6		17000	2000(1100)	7000	850(550)	9000	1100(660)
8		13000	2000(1100)	5500	850(650)	7000	1100(800)
10		11000	2000(1300)	4400	850(650)	5500	1100(800)
12		8800	2000(1300)	3600	850(800)	4500	1100(800)
16		6500	2000(1100)	3000	850(550)	3500	1100(900)

() : Grooving