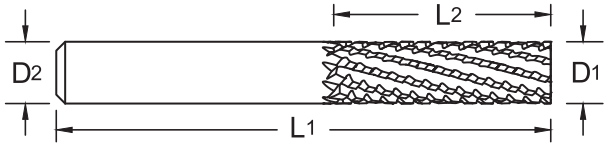
Diamond Coated Routers Series 239



Diamond grind GemX coated


Bur End


End Mill


Safe End

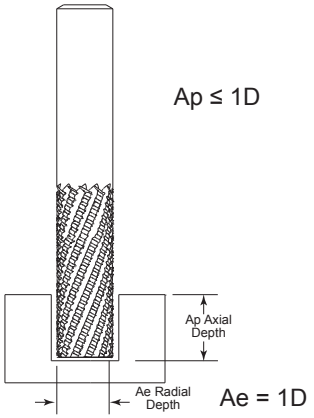
Tool Number	EDP	Diameter D1	Shank Diameter D2	OAL L1	Flute Length L2	# Flutes (RHC)	End Cut
23912500BGX	23900	1/8	1/8	1-1/2	1/4	6	Bur
23912510EGX	23902	1/8	1/8	1-1/2	3/8	6	End Mill
23912520EGX	23904	1/8	1/8	1-1/2	1/2	8	End Mill
23918700BGX	23906	3/16	3/16	2	3/8	6	Bur
23918710EGX	23908	3/16	3/16	2	9/16	6	End Mill
23918720EGX	23910	3/16	3/16	2	3/4	8	End Mill
23925000BGX	23912	1/4	1/4	2-1/2	1/2	8	Bur
23925010BGX	23914	1/4	1/4	2-1/2	3/4	10	Bur
23925010EGX	23916	1/4	1/4	2-1/2	3/4	10	End Mill
23925020BGX	23918	1/4	1/4	3	1	10	Bur
23925020EGX	23920	1/4	1/4	3	1	10	End Mill
23925030GX	23922	1/4	1/4	4	1-1/4	12	Safe
23931200EGX	23924	5/16	5/16	2-1/2	1	10	End Mill
23937500BGX	23926	3/8	3/8	2-1/2	3/4	12	Bur
23937510BGX	23928	3/8	3/8	3	1-1/8	12	Bur
23937510EGX	23930	3/8	3/8	3	1-1/8	12	End Mill
23937520BGX	23932	3/8	3/8	4	1-1/2	12	Bur
23937520EGX	23934	3/8	3/8	4	1-1/2	12	End Mill
23937530GX	23936	3/8	3/8	4	2	12	Safe
23950000BGX	23938	1/2	1/2	3	1	14	Bur
23950000EGX	23940	1/2	1/2	3	1	14	End Mill
23950010GX	23942	1/2	1/2	4	2	16	Safe
23950010BGX	23944	1/2	1/2	4	2	16	Bur

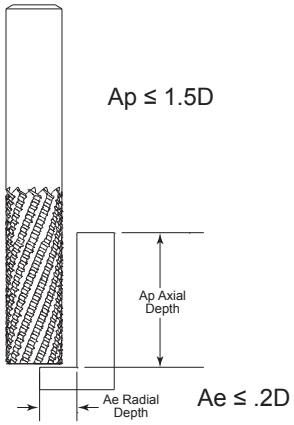
*Stock available for desired end features with a quicker turnaround than most manufacturing suppliers!

TECH
Page 178

Diamond Coated Routers Series 239

Recommended Cutting Data - Inch





Slotting 300 (Sfm)		
Tool Diameter	RPM	IPM
1/8	9000	10
3/16	6000	12
1/4	5000	15
5/16	4000	18
3/8	3000	20
1/2	2000	25

Slotting 600 (Sfm)		
Tool Diameter	RPM	IPM
1/8	18000	20
3/16	12000	25
1/4	9000	30
5/16	7000	35
3/8	6000	40
1/2	5000	50

Feed adjustment to part thickness	
≤ 0.5D	x 150%
0.5D - 1D	x 120%
1D - 2D	x 80%
3D-4D	x 50%

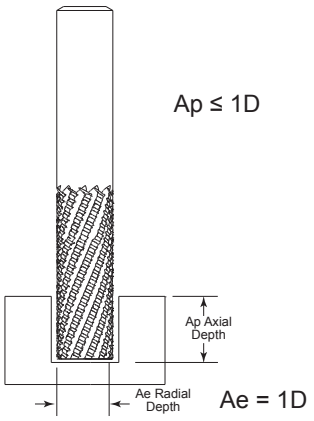
Side Milling 400 (Sfm)		
Tool Diameter	RPM	IPM
1/8	12000	20
3/16	8000	25
1/4	6000	30
5/16	5000	35
3/8	4000	40
1/2	3000	50

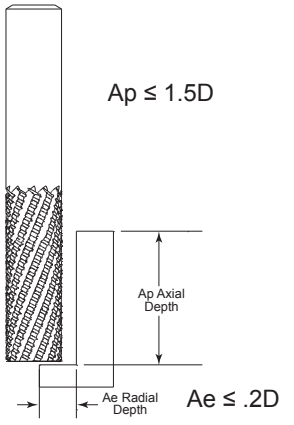
Side Milling 800 (Sfm)		
Tool Diameter	RPM	IPM
1/8	24000	40
3/16	16000	50
1/4	12000	60
5/16	10000	70
3/8	8000	80
1/2	6000	100

** Tool must have end grind to slot.

Note: The parameters in this table are for common material thickness of 1/4". You must use the Radial Depth (Ae) of 20% or less for Side Milling. For best surface finish conventional mill is recommended. Higher feed rates are possible but surface finish may change.

Recommended Cutting Data - Metric





Slotting 90 (m/min)		
Tool Diameter	RPM	mm/ min
3	9000	254
5	6000	304
6	5000	381
8	4000	457
10	3000	508
12	2000	635

Slotting 182 (m/min)		
Tool Diameter	RPM	mm/ min
3	18000	508
5	12000	635
6	9000	762
8	7000	889
10	6000	1016
12	5000	1270

Feed adjustment to part thickness	
≤ 0.5D	x 150%
0.5D - 1D	x 120%
1D - 2D	x 80%
3D-4D	x 50%

Side Milling 120(m/min)		
Tool Diameter	RPM	mm/ min
3	12000	508
5	8000	635
6	6000	762
8	5000	889
10	4000	1016
12	3000	1270

Side Milling 240 (m/min)		
Tool Diameter	RPM	mm/ min
3	24000	1016
5	16000	1270
6	12000	1524
8	10000	1778
10	8000	2032
12	6000	2540

** Tool must have end grind to slot.

Note: The parameters in this table are for common material thickness of 6mm. You must use the Radial Depth (Ae) of 20% or less for Side Milling. For best surface finish conventional mill is recommended. Higher feed rates are possible but surface finish may change.

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.