PCD TIPPED END MILLS

Fresas de metal duro com pontas de PCD | Fresas de carburo con puntas de PCD

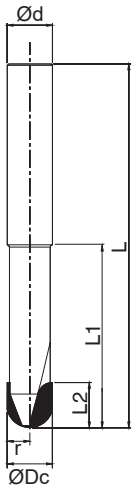
palbit CUTTING TOOLS SOLUTIONS

NEW

PCD

SINCE 1916

HARDMILL BALL NOSE

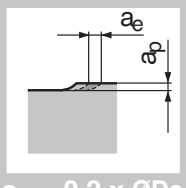
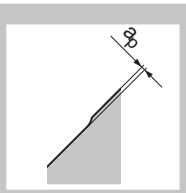


(1) Geometry code	(2) Grade code Reference Referência Referencia		N PCD D6 PDP410	Dimensions | Dimensões | Dimensiones (mm) ØDc	Ød	L	L1	L2	r
1180079	DBNS 1 030 050 150 060	1	◈	3	3	60	30	5	1,50
1180080	DBNS 1 040 100 200 040	1	◈	4	4	60	30	10	2,00
1180081	DBNS 2 060 100 300 060	2	◈	6	6	80	40	10	3,00
1180082	DBNS 2 080 100 400 080	2	◈	8	8	80	40	10	4,00
1180083	DBNS 2 100 100 500 100	2	◈	10	10	80	40	10	5,00
1180084	DBNS 2 120 100 600 120	2	◈	12	12	100	60	10	6,00

◈ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta

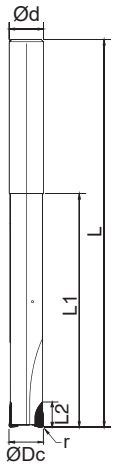
Order code = (1) Geometry Code + (2) Grade Code

Material Group	Correction factor	V_c (m/min)
Aluminium cast alloys 5% < Si ≤ 12%	1,6	790-1000
Aluminium cast alloys 12% < Si	1,5	790-1000
Fibre-reinforced synthetics	1,0	400-500
Graphite	1,0	700-850

ØD	 a_e = 0.2 x ØDc a_p = 0.1 x ØDc	 a_p = 0.05 x ØDc
	f_z (mm/t)	f_z (mm/t)
3	0,020	0,022
4	0,025	0,028
6	0,035	0,040
8	0,050	0,055
10	0,060	0,070
12	0,075	0,078

Please note that the value fz from the table above must be multiplied with the corresponding correction factor.

HARDMILL BULL NOSE



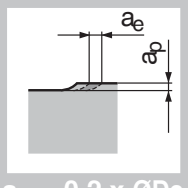
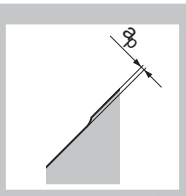
(1) Geometry code	(2) Grade code: Reference Referência Referencia		N PCD D6 PDP410	Dimensions | Dimensões | Dimensiones (mm) ØDc	Ød	L	L1	L2	r
1180073	DSNS 1 030 050 030 040	1	⚙	3	4	60	30	5	0,30
1180075	DSNL 2 040 050 030 040	2	⚙	4	4	75	45	5	0,30
1180076	DSNL 2 060 060 030 060	2	⚙	6	6	100	60	6	0,30
1180077	DSNL 2 080 060 030 080	2	⚙	8	8	125	80	6	0,30
1180074	DSNL 2 100 060 050 100	2	⚙	10	10	150	100	6	0,30
1180078	DSNL 2 120 070 050 120	2	⚙	12	12	150	100	7	0,30

⚙ Stock item | Produto de stock | Itens de stock

◯ Available under request | Disponível sobre consulta | Disponible bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

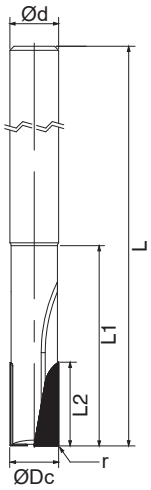
Material Group	Correction factor	V_c (m/min)
Aluminium cast alloys 5% < Si ≤ 12%	1,6	790-1000
Aluminium cast alloys 12% < Si	1,5	790-1000
Fibre-reinforced synthetics	1,0	400-500
Graphite	1,0	700-850

ØD	 a_e = 0.2 x ØDc a_p = 0.1 x ØDc	 a_p = 0.05 x ØDc
	f_z (mm/t)	f_z (mm/t)
3	0,020	0,022
4	0,025	0,028
6	0,035	0,040
8	0,050	0,055
10	0,060	0,070
12	0,075	0,078

Please note that the value fz from the table above must be multiplied with the corresponding correction factor.

HARDMILL STRAIGHT EDGE

NEW



(1) Geometry code	(2) Grade code – Reference Referência Referencia		N PCD D6 PDP410	Dimensions | Dimensões | Dimensiones (mm) ØDc	Ød	L	L1	L2	r
1180011	DSNS 2 040 060 010 060	2	◎	4	6	51	6,40	6	0,10
1180012	DSNS 2 050 080 010 060	2	◎	5	6	51	8,40	8	0,10
1180006	DSNS 2 060 080 010 060	2	◎	6	6	63	21	8	0,10
1180013	DSNS 2 080 080 010 080	2	◎	8	8	63	27	8	0,10
1180014	DSNS 2 080 120 010 080	2	◎	8	8	63	27	12	0,10
1180015	DSNS 2 100 080 010 100	2	◎	10	10	72	32	8	0,10
1180016	DSNS 2 100 160 010 100	2	◎	10	10	72	32	16	0,10
1180017	DSNS 2 120 080 010 120	2	◎	12	12	83	38	8	0,10
1180018	DSNS 2 120 160 010 120	2	◎	12	12	83	38	16	0,10
1180019	DSNS 3 140 080 010 140	3	◎	14	14	83	38	8	0,10
1180020	DSNS 3 140 160 010 140	3	◎	14	14	83	38	16	0,10
1180021	DSNS 3 160 120 010 160	3	◎	16	16	100	52	12	0,10
1180022	DSNS 3 160 200 010 160	3	◎	16	16	100	52	20	0,10

◎ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

order code = (1) Geometry Code + (2) Grade Code

NON-FERROUS MATERIALS | Materiais não ferrosos | Materiales no ferrosos

ISO	Workpiece Material	Vc (m/min) min	Vc (m/min) max	fz (mm/t) min	fz (mm/t) max	Coolant
N	Aluminium <6%Si	200	6000	0,05	0,30	Emulsion / MQL
	Aluminium <12%Si	200	4000	0,05	0,25	
	Aluminium >12%Si	200	2000	0,05	0,20	
	Cooper/Cooper Alloys	250	3000	0,03	0,30	

SYNTHETICS MATERIALS | Materiais sintéticos | Materiales sintéticos

ISO	Workpiece Material	Vc (m/min) min	Vc (m/min) max	fz (mm/t) min	fz (mm/t) max	Coolant
N	Graphit	150	2500	0,05	0,40	Dry/ Air
	GFRP, CFRP	200	3000	0,05	0,40	Dry/ Air
	Plastics (Termo/Duroplast)	100	2500	0,05	0,30	Emulsion/MQL
	Acrylic (PMMA)	100	1200	0,01	0,25	Emulsion /MQL
	Laminate	100	1200	0,02	0,50	Dry/Air

These recommended parameters are only approximate values. It can be necessary to adjust them regarding to the specific machining operation.