



Folding and slotting end mills DIXI 7727

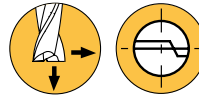
**A tool suitable
for all cutting tables.**

**Machine types: SBC,
MECANUMERIC, ZÜND....**

Need advice ?

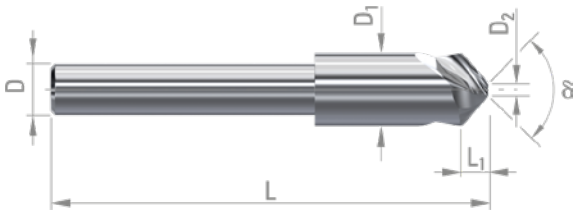
Contact us directly for personalized
support and a customized selection.





FOLDING AND SLOTTING END MILLS

- Folding and slotting end mills developed for bending and grooving operations in sandwich materials (Dibond®, Alucobond®).



○ good ⊙ excellent

ISO	P													M				K					
Materials description	Unalloyed steel					Low alloyed steel				High alloyed steel	Martensitic stainless steel	Austenitic stainless steel (DUPLIX/PH)				Grey cast iron	Nodular cast iron	Malleable cast iron					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	14.4	15	16	17	18	19	20
Recommendations																							

ISO	N												S					H				
Materials description	Wrought aluminium alloy		Cast aluminium alloy			Cu + Pb alloy	Cu alloy difficult	Gold, Silver	Graphite	Plastic Alu	Wood	Special alloy Ni / Co			Titanium, titanium alloy		Hardened steel	Hard cast iron				
VDI 3323	21	22	23	24	25	26	27	28	-	-	29	30	31	32	33-35	36	37	38	39	40	41	
Recommendations											⊙											

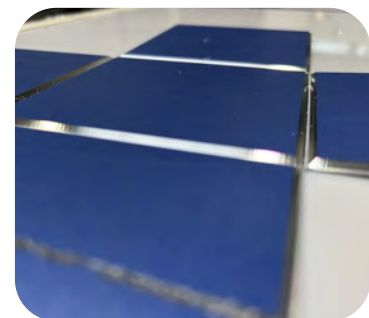
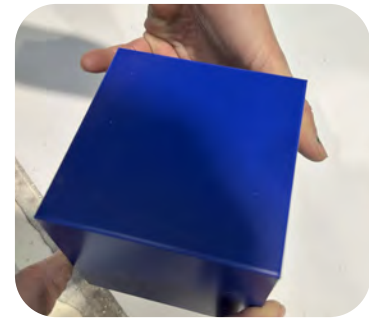
δ	D _{1h5}	L ₁	D _{h5}	D ₂	L	DLC*
90°	10	4.0	10	2	67	■
95°	6	1.8	6	2	60	■
95°	8	2.7	8	2	63	■
95°	10	3.7	6	2	60	■
95°	10	3.7	10	2	67	■
95°	12	4.6	12	2	84	■
135°	8	1.2	8	2	63	■
135°	10	1.7	6	2	60	■
135°	10	1.7	10	2	67	■
135°	12	2.1	12	2	84	■

* for non-ferrous material

	VDI 3323	DLC n [rpm]	ap (mm)	Vf (mm/min)	Vf (mm/min) plunge
N Plastic, Alu	29 - 30	16 - 18'000	1.00 - 2.00	800 - 1'300	300

EXAMPLE OF APPLICATION

Material: Aluminium
 Rotation = 18'000 rpm
 Feed rate = 0.9 mm/min
 Machine: SBC



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