

DEB (M.A. Ford® PCD End Mill Ball) Series

A straight flute PCD tipped ball nose end mill available in 1 or 2 flutes depending on tool size. These end mills combine a PCD tip with a carbide body for maximum rigidity and optimal performance. Offers excellent results in CFRP (Carbon-Fiber-Reinforced Polymer), fiberglass, aluminum and other very abrasive materials.

Standard Flute PCD Ball End Mills - Inch

Center Cutting

Tool No.	EDP	D1	D2	L1	L2	L3	# of Flutes
DE1B1250	90119	1/8	1/8	1-1/2	1/4	.650	1
DE1B1875	90120	3/16	3/16	2	5/16	.875	1
DE2B2500	90121	1/4	1/4	2	3/8	.875	2
DE2B3750	90122	3/8	3/8	2-1/2	1/2	1	2
DE2B5000	90123	1/2	1/2	3	5/8	1-1/2	2
DE2B6250	90124	5/8	5/8	3-1/4	7/8	1-3/4	2
DE2B7500	90125	3/4	3/4	4	1	2	2

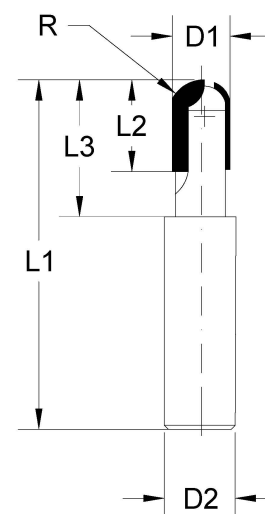
Additional sizes available upon request.

Standard Flute PCD Ball End Mills - Metric

Center Cutting

Tool No.	EDP	D1	D2	L1	L2	L3	# of Flutes
DE1BM0300	90126	3	3	38	6	15	1
DE1BM0400	90127	4	4	50	6	17	1
DE1BM0500	90128	5	5	50	8	20	1
DE2BM0600	90129	6	6	64	10	24	2
DE2BM0800	90130	8	8	64	10	27	2
DE2BM1000	90131	10	10	75	15	35	2
DE2BM1200	90132	12	12	75	15	35	2
DE2BM1600	90133	16	16	92	20	42	2
DE2BM2000	90134	20	20	100	25	50	2

Additional sizes available upon request.



Safety Note

Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.

CFRP Milling Parameters

DES & DEB Series

Diameter	Speed	Speed	Feed
inch	SFM	RPM	IPT
3/16	450	9168	0.0030
1/4	450	6876	0.0040
3/8	450	4584	0.0045
1/2	450	3438	0.0050
5/8	450	2750	0.0060

DES & DEB Series

Diameter	Speed	Speed	Feed
mm	SMM	RPM	mmPT
5	140	9168	0.0800
6	140	6876	0.1000
10	140	4584	0.1150
12	140	3438	0.1300
16	140	2750	0.1500

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