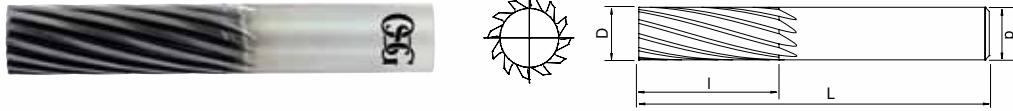


DIA-MFR

Finishing Router - Diamond Coated



EDP Number	Mill Diameter	Length of Cut	OAL	Shank Diameter	No. of Flutes	Stock	Price
	D	L	L	d			
26500316	1/4	3/4	2 1/2	1/4	8	○	
26501316	1/4	1	3	1/4	8	○	
26500616	3/8	1 1/8	3	3/8	12	○	
26501516	3/8	1 1/2	3	3/8	12	○	
26500716	1/2	1 1/2	4	1/2	14	○	
26501716	1/2	2	4	1/2	14	○	

Packed: 1 pc. Available Diamond coating only.

Recommended Cutting Conditions

Speed m/min.	Side Milling	
	120	250
Depth of Cut	Aa: Up to 1D / Ar: ≤ 0,2D	
Dia.	Feed mm/min.	Feed mm/min.
1/4	770	3.000
3/8	1.000	3.500
1/2	1.300	5.000

Note: This table's parameters are based on common material thickness of approximately 0.250" under excellent workholding conditions and less than 20% x D depth of cut (side milling). Please adjust your parameters properly for your application or call OSG for assistance. Conventional milling is recommended for better surface finishes. Higher feed rates are possible but quality of part and surface should be considered.

Overhang RPM Reduction: Recommended feed adjustments based on thickness of part.
(Above table is based on approximately 1xD thickness.)

≤0.5D	x 150%
0.5D-1D	x 120%
1D-2D	x 80%
3D-4D	x 50%



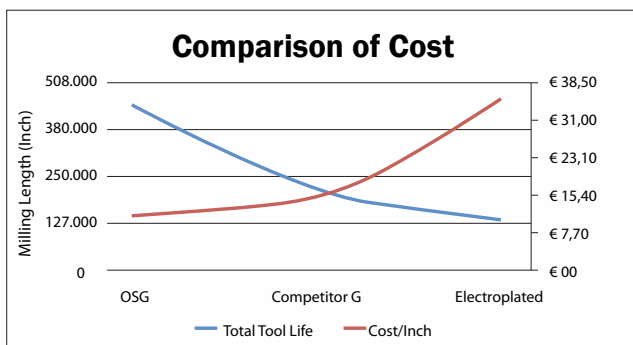
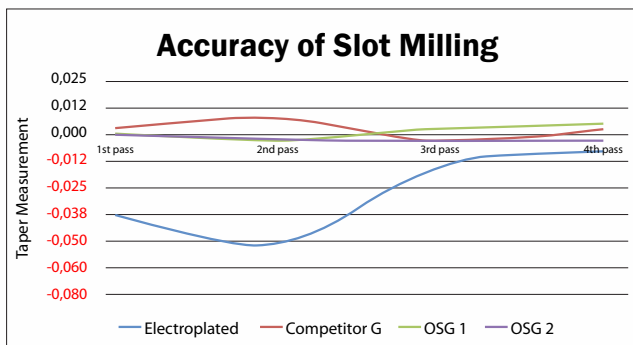
The DIA-MFR is a highly rigid multi-fluted finishing router designed for high precision & accuracy requirements. This router features a high rigid body with multi-flutes along with OSG's patented diamond coating.

Performance Highlights

The DIA-MFR showed the best accuracy versus carbide diamond coated competition as well as electroplated products.



Tool	OSG	Competitor G	Electroplated
Material	Carbon / Carbon		
Diameter	8 mm		
Milling Method	Slotting		
Speed	2700 RPM		9795 RPM
Feed	1.210 mm/min.		
DOC	Aa: 10 mm		
Coolant	Dry		



Applications

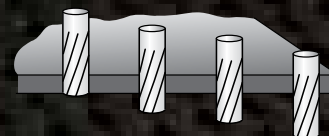
- ◆ Excellent for tight tolerance & high precision applications
- ◆ Can be used in combination with DIA-REC for roughing

Features

- ◆ Multi fluted for super finishes
- ◆ Large core for ultra rigidity

Flute Management

- ◆ By utilizing Flute Position Management*, tool life can be increased.



*To change the milling position at the flute