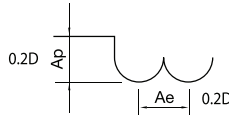


2GBE		Cutting Condition			
Material		Graphite			
Radius	Effective Length	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.25	5	25,000	320	0.10	0.10
R 0.5	10	21,850	380	0.20	0.20
"	20	19,665	342	0.18	0.18
"	30	18,682	325	0.15	0.15
R 0.75	10	21,850	646	0.30	0.30
"	20	19,665	630	0.27	0.27
"	30	18,682	580	0.23	0.23
R 1	15	19,950	760	0.40	0.40
"	20	17,955	684	0.36	0.36
"	30	16,160	616	0.32	0.32
"	40	13,736	523	0.26	0.26
"	50	10,988	419	0.21	0.21
R 1.5	20	17,575	1378	0.60	0.60
"	30	15,818	1240	0.54	0.54
"	40	14,236	1116	0.49	0.49
"	50	12,100	948	0.44	0.44
R 2	20	15,200	1995	0.80	0.80
"	35	13,680	1796	0.72	0.72
"	45	12,312	1616	0.61	0.61
R 2.5	25	14,725	2423	1.00	1.00
"	50	11,780	1938	0.80	0.80
R 3	25	14,250	2803	1.20	1.20
R 4	30	12,350	2850	1.60	1.60
R 5	—	10,925	2898	2.00	2.00
R 6	—	9,975	2993	2.40	2.40
R 8	—	7,600	2375	3.20	3.20
R 10	—	6,175	1900	4.00	4.00
Depth of Cut					

- In case of long effective length, reduce the RPM and feed by 20% or less.
- If the effective length of your tool does not show above the table, use the shorten effective length of parameter and reduce the parameters in the same proportion.
- If there is no parameter for the angle of your tool, refer to the previous angle and adjust compare to it.
- Adjust the value of the feed and Ap based on the effective length and taper angle and adjust the milling condition.
- Use the table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same production.
- The edge of the precisely grinded. If you want to measure the tool and to avoid damaging on the flutes, use non-contac measuring method.