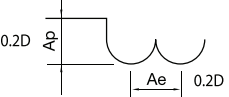


2GTB		Cutting Condition				
Material		Graphite				
Radius	Effective Length	Angle θ	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.5	20	0°30	18,000	300	0.20	0.20
"	30	0°30	17,100	285	0.18	0.18
"	40	0°30	16,245	271	0.16	0.16
"	25	1°	16,740	279	0.20	0.20
"	35	1°	15,903	265	0.18	0.18
"	50	1°	15,108	252	0.16	0.16
R 0.75	30	0°30	17,000	320	0.30	0.30
"	40	0°30	16,150	304	0.28	0.28
"	50	0°30	15,343	289	0.26	0.26
"	30	1°	15,300	288	0.30	0.30
"	50	1°	14,229	268	0.28	0.28
"	60	1°	13,233	249	0.26	0.26
R 1	40	0°30	16,500	600	0.40	0.40
"	50	0°30	14,850	540	0.36	0.36
"	70	0°30	13,365	486	0.32	0.32
"	60	1°	12,029	437	0.36	0.36
"	90	1°	10,224	372	0.32	0.32
R 2	70	0°30	13,500	1,600	0.80	0.80
"	80	1°	12,825	1,520	0.76	0.76
R 3	100	0°30	11,000	2,200	1.20	1.20
"	100	1°	10,780	2,156	1.20	1.20
R 5	83	0°30	9,600	2,250	2.00	2.00
R 6	110	0°30	7,500	2,300	2.40	2.40
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 this 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 proportion.