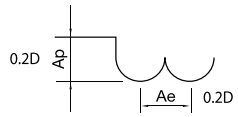
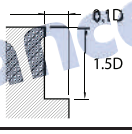
RPM : rev./min FEED : mm/min

2DBE / 3DBE / 4DBE	Cutting Condition											
	2DBE				3DBE				4DBE			
Material	Graphite				Graphite				Graphite			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 1	16,000	400	0.20	0.20	16,000	480	0.20	0.20	16,000	700	0.20	0.20
Ø 2	16,000	800	0.40	0.40	16,000	960	0.40	0.40	16,000	1,200	0.40	0.40
Ø 3	16,000	1,450	0.60	0.60	16,000	1,740	0.60	0.60	16,000	2,000	0.60	0.60
Ø 4	16,000	2,100	0.80	0.80	16,000	2,520	0.80	0.80	16,000	3,100	0.80	0.80
Ø 5	15,500	2,550	1.00	1.00	15,500	3,060	1.00	1.00	15,000	3,800	1.00	1.00
Ø 6	15,000	2,950	1.20	1.20	15,000	3,540	1.20	1.20	15,000	4,400	1.20	1.20
Ø 8	13,000	3,000	1.60	1.60	13,000	3,600	1.60	1.60	13,000	4,500	1.60	1.60
Ø 10	11,500	3,000	2.00	2.00	12,000	3,600	2.00	2.00	12,000	4,600	2.00	2.00
Ø 12	10,700	3,200	2.40	2.40	10,000	3,840	2.40	2.40	10,000	4,700	2.40	2.40
Depth of Cut												

- If the effective length is long, reduce the RPM and feed maximum 20%.
- 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.
- 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.

2DEM / 3DEM / 4&6DEM	Cutting Condition											
	2DEM				3DEM				4&6DEM			
Material	Graphite				Graphite				Graphite			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 0.6	40,000	350	0.90	0.06	–	–	–	–	–	–	–	–
Ø 0.8	40,000	550	1.20	0.08	–	–	–	–	–	–	–	–
Ø 1	40,000	700	1.50	0.10	–	–	–	–	–	–	–	–
Ø 2	25,000	800	3.00	0.20	–	–	–	–	–	–	–	–
Ø 3	16,500	800	4.50	0.30	16,500	1,600	4.50	0.30	–	–	–	–
Ø 4	15,000	1,200	6.00	0.40	15,000	2,400	6.00	0.40	–	–	–	–
Ø 5	14,000	1,400	7.50	0.50	14,000	2,800	7.50	0.50	–	–	–	–
Ø 6	11,000	1,500	9.00	0.60	11,000	3,000	9.00	0.60	21,450	6,200	9.00	0.60
Ø 8	8,000	1,800	12.00	0.80	8,000	3,600	12.00	0.80	15,600	7,400	12.00	0.80
Ø 10	6,500	1,200	15.00	1.00	6,500	3,000	15.00	1.00	12,675	6,200	15.00	1.00
Ø 12	5,500	1,500	18.00	1.20	5,500	3,000	18.00	1.20	10,725	6,200	18.00	1.20
Ø 16	5,500	1,300	24.00	1.60	–	–	–	–	10,725	5,300	24.00	1.60
Depth of Cut												

- If the effective length is long, reduce the RPM and feed in the same proportion.
- The edge of the flute precisely grinded. If you want to measure the tool and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine or found red heat on the material, adjust RPM and feed in the same proportion.
- Use a machine with low vibration and good rigidity (Ø1 or less, the vibration tolerance management should be within 5μm).
- For graphite milling, air blow method is recommended.