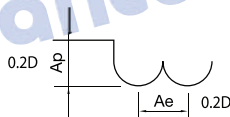


3DTB		Cutting Condition				
Material		Graphite				
Radius	Effective Length	Angle θ	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.5	20	0°30	18,900	360	0.20	0.20
"	30	0°30	17,955	342	0.18	0.18
"	40	0°30	17,057	325	0.16	0.16
"	25	1°	17,577	335	0.20	0.20
"	35	1°	16,698	318	0.18	0.18
"	50	1°	15,863	302	0.16	0.16
R 0.75	30	0°30	17,850	384	0.30	0.30
"	40	0°30	16,958	365	0.28	0.28
"	50	0°30	16,110	347	0.26	0.26
"	40	1°	16,065	346	0.30	0.30
"	50	1°	14,940	321	0.28	0.28
"	60	1°	13,895	299	0.26	0.26
R 1	40	0°30	17,325	720	0.40	0.40
"	50	0°30	15,593	648	0.36	0.36
"	60	0°30	14,702	559	0.32	0.32
"	50	1°	14,524	588	0.36	0.36
"	60	1°	12,630	525	0.32	0.32
"	70	1°	11,367	472	0.19	0.19
R 2	80	0°30	13,466	1,824	0.80	0.80
"	100	1°	12,120	1,642	0.76	0.76
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.