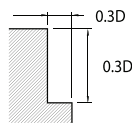
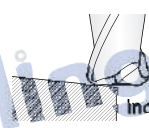


2DCR / 4DCR					Cutting Condition			
2DCR					4DCR			
Material	Graphite				Graphite			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 0.5	40,000	300	0.15	0.15	-	-	-	-
Ø 0.6	40,000	400	0.18	0.18	-	-	-	-
Ø 0.8	40,000	630	0.24	0.24	-	-	-	-
Ø 1	35,000	800	0.30	0.30	-	-	-	-
Ø 2	25,000	920	0.60	0.60	25,000	1,840	0.60	0.60
Ø 3	16,500	920	0.90	0.90	16,500	1,840	0.90	0.90
Ø 4	15,000	1,300	1.20	1.20	15,000	2,600	1.20	1.20
Ø 5	14,000	1,600	1.50	1.50	-	-	-	-
Ø 6	11,000	1,700	1.80	1.80	11,000	3,390	1.80	1.80
Ø 8	-	-	-	-	8,000	2,030	2.40	2.40
Ø 10	-	-	-	-	6,500	1,700	3.00	3.00
Ø 12	-	-	-	-	5,500	1,700	3.60	3.60
Ø 16	-	-	-	-	5,500	1,500	4.80	4.80

Depth of Cut		 Inclined Cutting
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- If the effective length is long, reduce the RPM and feed in the same proportion.
- For curved milling, set up the lower value of the pitch than the corner radius value of tool diameter.
- For curved milling, raise up the feed up to 50% in stable milling condition.
- For groove milling, set up the Ae value by considering of corner radius value.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Use the adequate coolant for work material and machining geometry and note for heat and ignition.