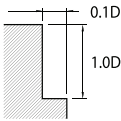


2GEM/4GEM/6GEM					Cutting Condition							
	2GEM				4GEM				6GEM			
Material	Graphite				Graphite				Graphite			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 1	36,000	700	1.00	0.10	-	-	-	-	-	-	-	-
Ø 2	28,000	700	2.00	0.20	-	-	-	-	-	-	-	-
Ø 3	18,000	800	3.00	0.30	18,000	1,600	3.00	0.30	-	-	-	-
Ø 4	16,000	1,000	4.00	0.40	16,000	2,000	4.00	0.40	-	-	-	-
Ø 5	15,000	1,200	5.00	0.50	15,000	2,400	5.00	0.50	-	-	-	-
Ø 6	12,000	1,300	6.00	0.60	12,000	2,600	6.00	0.60	23,400	2,880	6.00	0.60
Ø 8	10,000	1,500	8.00	0.80	10,000	3,000	8.00	0.80	19,500	3,900	8.00	0.80
Ø 10	8,000	1,400	10.00	1.00	8,000	2,800	10.00	1.00	15,600	4,800	10.00	1.00
Ø 12	6,500	1,400	12.00	1.20	6,500	2,800	12.00	1.20	12,675	4,800	12.00	1.20
Ø 16	5,800	1,300	16.00	1.60	5,800	2,600	16.00	1.60	11,310	5,400	16.00	1.60
Ø 20	5,000	1,200	20.00	2.00	5,000	2,400	20.00	2.00	9,750	5,400	20.00	2.00
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-contac 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.