



D Size	D Tolerance
Ø0.5 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.01 ~ -0.025 mm

1MEM / 1REM

• RPM: rev./min • Feed: mm/min

Material	Acrylic			Alloy Steels		
	Outside Diameter	RPM	FEED	Ap (Axial Depth)	RPM	FEED
Ø1	32,000	2,000	2.5	23,000	1,300	2.5
Ø2	32,000	2,200	5	23,000	1,500	5
Ø3	25,000	2,400	7.5	18,000	1,700	7.5
Ø4	20,000	2,400	10	15,000	1,800	10
Ø5	15,000	2,200	12.5	12,000	1,800	12.5
Ø6	13,500	2,300	15	10,000	1,800	15
Ø8	10,000	2,400	20	7,800	1,900	20
Ø10	8,000	2,400	25	6,000	2,000	25
Ø12	7,000	2,200	30	5,000	1,900	30

Depth of Cut	
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- 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.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- 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.