



D Size	D Tolerance
$\varnothing 0.2 \sim 5$	+0 ~ -0.01 mm
$\varnothing 6 \sim 12$	-0.01 ~ -0.025 mm
$\varnothing 16$	-0.015 ~ -0.03 mm

### 2MLE

• RPM : rev./min • Feed : mm/min

Material	ABS /Acrylic			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ap Radial Depth
$\varnothing 0.2$	50,000	100	0.2	0.2
$\varnothing 0.4$	50,000	200	0.4	0.4
$\varnothing 0.5$	50,000	240	0.5	0.5
$\varnothing 0.6$	40,000	240	0.6	0.6
$\varnothing 0.8$	30,000	240	0.8	0.8
$\varnothing 1$	24,000	240	1	1
$\varnothing 2$	12,000	240	2	2
$\varnothing 3$	8,000	240	3	3
$\varnothing 4$	6,000	240	4	4
$\varnothing 5$	4,800	240	5	5
$\varnothing 6$	4,000	260	6	6
$\varnothing 8$	3,000	260	8	8
$\varnothing 10$	3,000	260	10	10
$\varnothing 12$	2,000	260	12	12
$\varnothing 16$	1,400	260	16	16

  

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.
- If the effective length is long, reduce the RPM and feed in the same proportion.
- 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, adjust RPM and feed in the same proportion.