

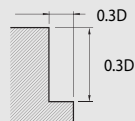
| D Size | D Tolerance |
|----------|---------------|
| Ø0.2 ~ 6 | +0 ~ -0.02 mm |

2DCR / 4DCR Cutting Condition

• RPM: rev./min • Feed: mm/min

| Material | 2 D C R | | | | 4 D C R | | | |
|----------|---------|-------|-------------------|--------------------|---------|-------|-------------------|--------------------|
| | RPM | FEED | Ap Axial Depth | Ae Radial Depth | RPM | FEED | Ap Axial Depth | Ae Radial Depth |
| Graphite | | | | | | | | |
| Ø0.2 | 40,000 | 100 | 0.06 | 0.06 | - | - | - | - |
| Ø0.4 | 40,000 | 200 | 0.12 | 0.12 | - | - | - | - |
| Ø0.5 | 40,000 | 300 | 0.15 | 0.15 | - | - | - | - |
| Ø0.6 | 40,000 | 400 | 0.18 | 0.18 | - | - | - | - |
| Ø0.8 | 40,000 | 500 | 0.24 | 0.24 | - | - | - | - |
| Ø1 | 40,000 | 900 | 0.30 | 0.30 | - | - | - | - |
| Ø2 | 36,000 | 900 | 0.60 | 0.60 | 40,000 | 2,800 | 0.60 | 0.60 |
| Ø3 | 32,000 | 1,300 | 0.90 | 0.90 | 40,000 | 3,150 | 0.90 | 0.90 |
| Ø4 | 26,000 | 1,500 | 1.20 | 1.20 | 40,000 | 3,500 | 1.2 | 1.2 |
| Ø5 | 24,000 | 1,100 | 1.50 | 1.50 | - | - | - | - |
| Ø6 | 21,000 | 1,100 | 1.80 | 1.80 | 40,000 | 5,600 | 1.8 | 1.8 |
| Ø8 | - | - | - | - | 32,000 | 5,600 | 2.4 | 2.4 |
| Ø10 | - | - | - | - | 26,000 | 5,700 | 3.0 | 3.0 |
| Ø12 | - | - | - | - | 21,000 | 5,500 | 3.6 | 3.6 |
| Ø16 | - | - | - | - | 15,800 | 5,500 | 4.8 | 4.8 |

Depth of Cut



- 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.