| **2** | **WC** | **DIA.** Coating | **|D|** +0 −0.02 | **30°** Helix Angle | |

D Size	D Tolerance
∅0.2 ~ 12	+0 ~ − 0.02 mm

2DEM / 3DEM / 4 & 6DEM Cutting Condition

• RPM : rev./min   • Feed : mm/min

Outside Diameter	2 D E M Graphite				4 D E M Graphite				6 D E M Graphite			
Material	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
∅0.2	40,000	100	0.3	0.02	-	-	-	-	-	-	-	-
∅0.4	40,000	200	0.6	0.04	-	-	-	-	-	-	-	-
∅0.6	40,000	350	0.9	0.06	-	-	-	-	-	-	-	-
∅0.8	40,000	550	1.2	0.08	-	-	-	-	-	-	-	-
∅1	40,000	700	1.5	0.10	-	-	-	-	-	-	-	-
∅2	25,000	800	3.0	0.20	-	-	-	-	-	-	-	-
∅3	20,000	800	4.5	0.30	20,000	1,600	4.5	0.3	-	-	-	-
∅4	18,000	950	6.0	0.40	18,000	1,900	6.0	0.4	-	-	-	-
∅5	14,000	1,200	7.5	0.50	14,000	2,400	7.5	0.5	-	-	-	-
∅6	11,000	1,400	9.0	0.60	11,000	2,800	9.0	0.6	22,200	8,000	9	0.6
∅8	8,000	1,300	12.0	0.80	8,000	2,600	12.0	0.8	16,800	8,000	12	0.8
∅10	6,500	1,200	15.0	1.00	6,500	2,400	15.0	1.0	13,400	8,000	15	1.0
∅12	5,500	1,200	18.0	1.20	5,500	2,400	18.0	1.2	11,350	6,700	18	1.2
∅16	5,500	1,200	24.0	1.60	-	-	-	-	8,400	5,000	24	1.6

Depth of Cut

0.1D

1.5D
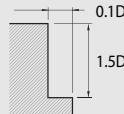
- If the effective length is long, reduce the RPM and feed in the same proportion.
- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on 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 (∅1 or less, the vibration tolerance management should be within 5 μm).
- For graphite milling, air blow method is recommended.