



D Size	D Tolerance
Ø0.5 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.01 ~ -0.025 mm
Ø16 ~ 20	-0.015 ~ -0.03 mm

2GEM / 4GEM / 6GEM

Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	2 G E M				4 G E M				6 G E M			
	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Graphite												
Ø1	8,000	160	1.00	0.10	-	-	1.00	0.10	-	-	1.00	0.10
Ø2	8,000	250	2.00	0.20	-	-	2.00	0.20	-	-	2.00	0.20
Ø3	8,000	380	3.00	0.30	8,000	430	3.00	0.30	-	-	3.00	0.30
Ø4	8,000	510	4.00	0.40	8,000	570	4.00	0.40	-	-	4.00	0.40
Ø5	8,000	640	5.00	0.50	8,000	720	5.00	0.50	-	-	5.00	0.50
Ø6	8,000	770	6.00	0.60	8,000	860	6.00	0.60	8,000	960	6.00	0.60
Ø8	8,000	1,000	8.00	0.80	8,000	1,100	8.00	0.80	8,000	1,300	8.00	0.80
Ø10	8,000	1,250	10.00	1.00	8,000	1,400	10.00	1.00	8,000	1,600	10.00	1.00
Ø12	8,000	1,500	12.00	1.20	7,000	1,400	12.00	1.20	7,000	1,600	12.00	1.20
Ø16	8,000	1,600	16.00	1.60	7,000	1,500	16.00	1.60	7,000	1,800	16.00	1.60
Ø20	8,000	1,600	20.00	2.00	7,000	1,500	20.00	2.00	7,000	1,800	20.00	2.00

Depth of Cut

