

D Size	D Tolerance
Ø1 ~ 12	+0 ~ -0.02 mm

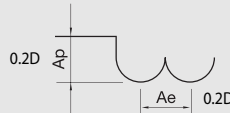
### 2DBE / 3DBE / 4DBE

### Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	2 D B E				3 D B E				4 D B E			
	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	16,000	400	0.20	0.20	16,000	480	0.20	0.20	16,000	700	0.20	0.20
Graphite	16,000	800	0.40	0.40	16,000	960	0.40	0.40	16,000	1,200	0.40	0.40
Graphite	16,000	1,450	0.60	0.60	16,000	1,740	0.60	0.60	16,000	2,000	0.60	0.60
Graphite	16,000	2,100	0.80	0.80	16,000	2,520	0.80	0.80	16,000	3,100	0.80	0.80
Graphite	15,500	2,550	1.00	1.00	15,500	3,060	1.00	1.00	15,000	3,800	1.00	1.00
Graphite	15,000	2,950	1.20	1.20	15,000	3,540	1.20	1.20	15,000	4,400	1.20	1.20
Graphite	13,000	3,000	1.60	1.60	13,000	3,600	1.60	1.60	13,000	4,500	1.60	1.60
Graphite	11,500	3,000	2.00	2.00	12,000	3,600	2.00	2.00	12,000	4,600	2.00	2.00
Graphite	10,700	3,200	2.40	2.40	10,000	3,840	2.40	2.40	10,000	4,700	2.40	2.40

Depth of Cut



- If the effective length is long, reduce the RPM and feed maximum 20%.
- If the effective length of your tool does not show above the table, use the shorten effective length of parameter and reduce the parameters in the same proportion.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same proportion.