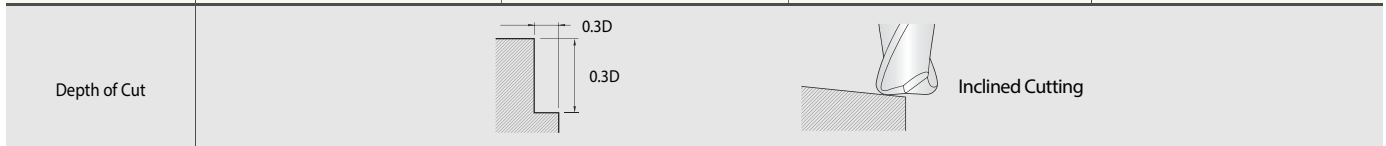


D Size	D Tolerance
Ø0.2 ~ 6	+0 ~ -0.02 mm

### 2DCR / 4DCR Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	2 D C R				4 D C R			
	Graphite							
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
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



- 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.