

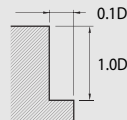
D Size	D Tolerance
Ø6 ~ 12	-0.01 ~ -0.025 mm
Ø16 ~ 20	-0.015 ~ -0.03 mm

2GEM / 4GEM / 6GEM

Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	2 G E M				4 G E M				6 G E M			
	Graphite				Graphite				Graphite			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
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



- 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 ($\varnothing 1$ or less, the vibration tolerance management should be within 5 μm).
- For graphite milling, air blow method is recommended.