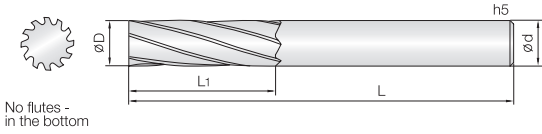


# 8~12CPE

## 8~12 Flutes Finishing End Mills for Composite



- Endmills for CFRP, GFRP, glass/carbon fiber, graphite, nonferrous and non-metallic materials.
- Outstanding performance in machining of various composite materials.
- Excellent wear resistance by applying high hardness coating layer.
- Minimize built up edge by low friction diamond coating technology.

Ø6~Ø12

D Size	D Tolerance
Ø6 ~ 12	-0.01 ~ -0.025 mm

: mm

### 8~12CPE

### Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	CFRP				GFRP			
	Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth
Ø6	8,400	840	6	2.1	4116	378	6	2.1
Ø8	6,200	860	8	2.8	3038	387	8	2.8
Ø10	5,100	780	10	3.5	2499	351	10	3.5
Ø12	4,150	750	12	4.2	2034	338	12	4.2

Depth of Cut

- In case of long effective length, reduce the RPM and feed by 20% or less.
- 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.
- Above the value of the table is based on 8 flutes. If you use more than 8 flutes of endmill, raise up the RPM and Feed in a same proportion compared to the same diameter.
- 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.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.