

RECOMMENDED CUTTING CONDITIONS

Work material	X	
	CFRP	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	11000	950
8	8000	780
10	6400	700
12	5300	650

Note 1) Cutting conditions may differ considerably due to the type of CFRP, the rigidity of the machine or the clamping and geometry of the workpiece. Please use the above table as a standard starting point.

Note 2) When high machining accuracy is needed, or large burrs or delamination occurs, we recommend reducing the feed rate.

Note 3) When the depth of cut is greater than 0.8DC, we recommend reducing the feed rate.

Note 4) Please take precautions against dust.