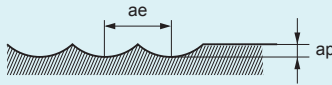
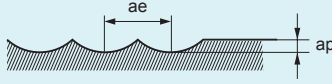


Recommended Cutting Conditions

(mm)

Work Material			Graphite				Zirconia (Before Sintering)			
DC	RE	LU	n (min ⁻¹)	vf (mm/min)	ap	ae	n (min ⁻¹)	vf (mm/min)	ap	ae
0.6	R0.3	10	35000	1000	0.05	0.015	26000	600	0.06	0.03
1	R0.5	10	40000	2000	0.10	0.200	26000	600	0.10	0.05
		16	35000	1500	0.09	0.200	26000	600	0.08	0.04
		20	30000	1100	0.08	0.200	26000	600	0.08	0.04
2	R1	16	30000	2000	0.20	0.500	18000	1400	0.06	0.80
		20	30000	2000	0.20	0.500	18000	1200	0.50	0.60
3	R1.5	16	28000	3000	0.30	0.900	15000	1600	0.90	0.90
		20	25000	2500	0.20	0.900	15000	1400	0.60	0.80
Depth of Cut										

Work Material			Copper, Copper Alloys				Rigid Composite Resin (Composite Resin)			
DC	RE	LU	n (min ⁻¹)	vf (mm/min)	ap	ae	n (min ⁻¹)	vf (mm/min)	ap	ae
0.6	R0.3	10	30000	600	0.005	0.040	28000	450	0.050	0.050
1	R0.5	10	33000	1400	0.010	0.100	25000	900	0.100	0.100
		16	25000	800	0.007	0.080	25000	700	0.080	0.080
		20	20000	500	0.005	0.050	25000	600	0.080	0.080
2	R1	16	30000	1800	0.050	0.200	25000	2100	0.800	0.800
		20	20000	1200	0.040	0.200	25000	1800	0.500	0.500
3	R1.5	16	28000	3000	0.300	0.300	25000	2400	1.000	1.000
		20	25000	2500	0.200	0.300	25000	2100	0.800	0.800
Depth of Cut										

(Note 1) When high machining accuracy is needed, or the work materials becomes chipped, we recommend lowering the revolution and the feed rate.

(Note 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and the feed rate proportionately.

(Note 3) When drying and machining work materials that contain resin, be careful of tool breakage and mechanical problems (as there is a possibility of blockage caused by cutting chips).

(Note 4) Use a milling machine dedicated for graphites.