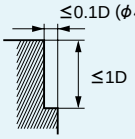
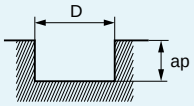
RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material		Graphite	
Dia. (mm)	Neck length (mm)	Revolution (min^{-1})	Feed rate (mm/min)
1	6	30000	1300
	8	25000	1000
	10	22000	700
1.5	10	25000	1200
	16	18000	800
2	10	22000	1500
	16	19000	1100
	20	16000	800
3	16	21000	1900
	20	18000	1500
	30	14000	1000
4	20	18000	2400
	40	13000	1500
6	30	14000	3200
8	30	10500	2900
10	30	8700	2600
12	30	7200	2200
Depth of cut		≤0.05D (D<ϕ4) ≤0.1D (ϕ4≤D)  ≤1D D:Dia.	

Slotting

Work material		Graphite		
Dia. (mm)	Neck length (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	6	30000	1000	0.1
	8	25000	700	0.08
	10	22000	500	0.06
1.5	10	25000	1100	0.14
	16	18000	600	0.1
2	10	22000	1200	0.2
	16	19000	800	0.16
	20	16000	600	0.12
3	16	21000	1400	0.3
	20	18000	1100	0.25
	30	14000	700	0.2
4	20	18000	1800	0.5
	40	13000	900	0.4
6	30	14000	2300	1.2
8	30	10500	2000	2
10	30	8700	1900	3
12	30	7200	1700	4
Depth of cut		 D ap D:Dia.		

1) When high machining accuracy is needed, or the workpiece becomes chipped, we recommend lowering the feed rate.
2) Use a milling machine dedicated for graphite.
3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.