

RECOMMENDED CUTTING CONDITIONS

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

- 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.
- 2) When high machining accuracy is needed, or large burrs or delamination occurs, we recommend reducing the feed rate.
- 3) When the depth of cut is greater than $0.8D_1$, we recommend reducing the feed rate.
- 4) Please take precautions against dust.