

Cutting Data for Graphite

Based on a slot of 1d radial x 0.25d axial depth or a finishing cut of 0.1d radial depth x 1d axial depth of cut.

2071 / 2101 Series Cyber End Mill for Graphite

DIAMETER	FEED PER TOOTH (mm)	SPINDLE SPEED R.P.M.
2mm	0.010	max. available
3mm	0.015	max. available
4mm	0.020	max. available
5mm	0.025	max. available
6mm	0.030	max. available
8mm	0.030	max. available
10mm	0.040	max. available
12mm	0.040	max. available

2072 / 2092 / 4072 Series Cyber Ball Nose End Mill for Graphite

TOOL DIAMETER (ød)	DEPTH OF CUT (mm)	STEPOVER (mm)	R.P.M.	Feed (mm / min)
2	0.1	0.2	20000	1200
3	0.1	0.2	20000	1400
4	0.2	0.2	20000	1600
5	0.2	0.2	20000	2000
6	0.2	0.2	20000	2400
8	0.2	0.2	20000	2600
10	0.3	0.2	20000	2800
12	0.3	0.2	20000	3000

2111 / 2102 Cutting Data for Graphite and Composites

TOOL DIAMETER (ød)	FEED PER TOOTH	SPINDLE SPEED RPM
2	0.01mm - 0.03mm	Max Available
3	0.02mm - 0.04mm	Max Available
4	0.025mm - 0.045mm	Max Available
5	0.03mm - 0.05mm	Up to 40,000 RPM
6	0.035mm - 0.06mm	Up to 37,000 RPM
8	0.04mm - 0.07mm	Up to 30,000 RPM
10	0.04mm - 0.10mm	Up to 25,000 RPM
12	0.045mm - 0.12mm	Up to 22,000 RPM
16	0.05mm - 0.15mm	Up to 16,000 RPM
20	0.06mm - 0.20mm	Up to 14,000 RPM

In general, roughing operations are run at the lower RPM's, finishing at higher. Similarly a finishing operation will utilise a lower feed per tooth than a roughing operation.