25M, 27M (METRIC)	Cut Type	Speed m/min	Feed (mm/flute)				
			6	8	10	12	16
● CFRP, AFRP (Carbon Fiber, Aramid Fiber)	Slot	120	0.040	0.065	0.075	0.100	0.120
	Profile	150	0.040	0.065	0.075	0.100	0.120
	Light	250	0.095	0.145	0.175	0.235	0.280
● GFRP (Fiberglass)	Slot	100	0.040	0.065	0.075	0.100	0.120
	Profile	120	0.040	0.065	0.075	0.100	0.120
	Light	200	0.095	0.145	0.175	0.235	0.280
● CARBON, GRAPHITE	Slot	145	0.050	0.080	0.095	0.125	0.150
	Profile	185	0.050	0.080	0.095	0.125	0.150
	Light	300	0.115	0.185	0.220	0.290	0.350
● PLASTIC	Slot	245	0.050	0.080	0.095	0.125	0.150
	Profile	305	0.050	0.080	0.095	0.125	0.150
	Light	505	0.115	0.185	0.220	0.290	0.350
MACHINABLE CERAMIC, MACHINABLE GLASS	Slot	10	0.020	0.035	0.040	0.050	0.060
	Profile	15	0.020	0.035	0.040	0.050	0.060
	Light	25	0.045	0.075	0.085	0.115	0.140

Cut Type

Slot	Profile	Light
27M	25M, 27M	25M, 27M
$Rw = D_1$	$Rw = .5 \times D_1$	$Rw = .05 \times D_1$
$Ad = D_1$	$Ad = 1.5 \times D_1$	$Ad = L_2$

$rpm = (1000 \times m/min) / (3.14 \times D_1)$

$mm/min = (mm/flute) \times no. \ of \ flutes \times rpm$

- maximum recommended depths shown
- adjust speed and feed based upon resin type and/or fiber structure
- reduce speed when overheating causes melting or damage to resin
- reduce feed if delamination or fraying occurs
- finish cuts typically require reduced feed and cutting depths
- rates shown are for use without coolant; rates may be increased with coolant use
- dust collection is vital when machining dry
- diamond coating will increase tool life in graphite and composite materials
- refer to the SGS Tool Wizard for more complete
  technical information (available at)