

120 (FRACTIONAL)	Speed (sfm)			Feed (inch/rev)				
	CVD	1/8	3/16	1/4	5/16	3/8	7/16	1/2
● CFRP, AFRP (Carbon Fiber, Aramid Fiber)	320	0.0006	0.0008	0.0012	0.0015	0.0018	0.0021	0.0024
● GFRP (Fiberglass)	240	0.0006	0.0008	0.0012	0.0015	0.0018	0.0021	0.0024
● CARBON, GRAPHITE	400	0.0008	0.0012	0.0016	0.0020	0.0024	0.0028	0.0032
Adjust speed and/or feed based upon resin type and/or fiber structure	rpm = sfm x 3.82 / D1			Refer to the SGS Tool Wizard for more complete technical information (available at)				
	ipm = (inch/rev) x rpm							

120-M (METRIC)	Speed (sfm)			Feed (mm/rev)				
	CVD	2.5	3	4.1	6	8	10	12
● CFRP, AFRP (Carbon Fiber, Aramid Fiber)	100	0.015	0.018	0.020	0.030	0.038	0.046	0.053
● GFRP (Fiberglass)	75	0.015	0.018	0.020	0.030	0.038	0.046	0.053
● CARBON, GRAPHITE	120	0.020	0.024	0.030	0.041	0.051	0.061	0.071
Adjust speed and/or feed based upon resin type and/or fiber structure	rpm = (1000 x m/min) / (3.14 x D1)			Refer to the SGS Tool Wizard for more complete technical information (available at)				
	mm/min = (mm/rev) x rpm							