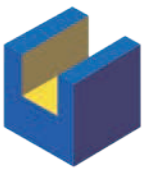
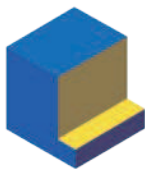
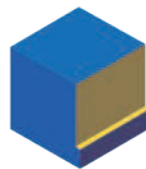


Speed & Feed Recommendations

27 Fractional	CUT	SPEED	FEED (inch/flute)				
	Type	sfm	1/4	5/16	3/8	1/2	3/4
CFRP, AFRP (Carbon Fiber, Aramid Fiber)	Slot	400	0.0016	0.0025	0.0030	0.0040	0.0048
	Profile	500	0.0016	0.0025	0.0030	0.0040	0.0048
	Light	825	0.0037	0.0057	0.0069	0.0092	0.0110
GFRP (Fiberglass)	Slot	320	0.0016	0.0025	0.0030	0.0040	0.0048
	Profile	400	0.0016	0.0025	0.0030	0.0040	0.0048
	Light	660	0.0037	0.0057	0.0069	0.0092	0.0110
CARBON, GRAPHITE	Slot	480	0.0020	0.0031	0.0038	0.0050	0.0060
	Profile	600	0.0020	0.0031	0.0038	0.0050	0.0060
	Light	990	0.0046	0.0072	0.0086	0.0115	0.0138
PLASTIC	Slot	800	0.0020	0.0031	0.0038	0.0050	0.0060
	Profile	1000	0.0020	0.0031	0.0038	0.0050	0.0060
	Light	1650	0.0046	0.0072	0.0086	0.0115	0.0138
MACHINABLE CERAMIC, MACHINABLE GLASS	Slot	40	0.0008	0.0013	0.0015	0.0020	0.0024
	Profile	50	0.0008	0.0013	0.0015	0.0020	0.0024
	Light	85	0.0018	0.0029	0.0034	0.0046	0.0055

CUT TYPE		
SLOT	PROFILE	LIGHT*
Rw = D ₁ Ad = D ₁	Rw = .5 x D ₁ Ad = 1.5 x D ₁	Rw = .05 x D ₁ Ad = L ₂
		

$$\text{rpm} = \text{sfm} \times 3.82 / D_1$$

$$\text{ipm} = (\text{inch/flute}) \times \text{no. of flutes} \times \text{rpm}$$

- 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)