



Series 120 Fractional	Vc (SFM)		Diameter (D ₁) (inch)						
			1/8	3/16	1/4	5/16	3/8	7/16	1/2
CFRP, AFRP (Carbon Fiber, Aramid Fiber)	320	RPM	9779	6519	4890	3912	3260	2794	2445
	(256-384)	Fr	0.0006	0.0008	0.0012	0.0015	0.0018	0.0021	0.0024
		Feed (IPM)	5.9	5.2	5.9	5.9	5.9	5.9	5.9
GFRP (Fiberglass)	240	RPM	7334	4890	3667	2934	2445	2096	1834
	(192-288)	Fr	0.0006	0.0008	0.0012	0.0015	0.0018	0.0021	0.0024
		Feed (IPM)	4.4	3.9	4.4	4.4	4.4	4.4	4.4
CARBON, GRAPHITE	400	RPM	12224	8149	6112	4890	4075	3493	3056
	(320-480)	Fr	0.0008	0.0012	0.0016	0.0020	0.0024	0.0028	0.0032
		Feed (IPM)	9.8	9.8	9.8	9.8	9.8	9.8	9.8

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

$$\text{ipm} = (\text{inch} / \text{revolution}) \times \text{rpm}$$

adjust speed and / or feed based on resin type and / or fiber structure

refer to the SGS Tool Wizard for complete technical information ()

Series 120 Metric	Vc (m/min)		Diameter (D ₁) (mm)						
			2.5	3	4	6	8	10	12
CFRP, AFRP (Carbon Fiber, Aramid Fiber)	100	RPM	12722	10602	7951	5301	3976	3181	2650
	(80-120)	Fr	0.015	0.018	0.020	0.030	0.038	0.046	0.053
		Feed (mm/min)	191	191	159	159	151	146	140
GFRP (Fiberglass)	75	RPM	9542	7951	5963	3976	2982	2385	1988
	(65-90)	Fr	0.015	0.018	0.020	0.030	0.038	0.046	0.053
		Feed (mm/min)	143	143	119	119	113	110	105
CARBON, GRAPHITE	120	RPM	15266	12722	9542	6361	4771	3817	3181
	(96-144)	Fr	0.020	0.024	0.030	0.041	0.051	0.061	0.071
		Feed (mm/min)	305	305	286	261	243	233	226

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

$$\text{mm} / \text{min} = (\text{mm} / \text{revolution}) \times \text{rpm}$$

adjust speed and / or feed based on resin type and / or fiber structure

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