Recommended Cutting Conditions

DIAMILL

Machining data for composite material

Material		Cutting Speed Vc(m/min)							
		RRFE		RCFE		RCOM		RDCF	
		Shouldering	Slotting	Shouldering	Slotting	Shouldering	Slotting	Shouldering	Slotting
CFRP	CFRP	100-300	50-120	100-300	50-120	50-200	50-120	100-300	50-120
	Honeycomb	150-250	100-200	150-250	100-200	-	-	-	-
GFRP	GFRP	50-150	30-70	50-150	30-70	50-100	30-70	50-150	30-70
	Honeycomb	150-250	100-200	150-250	100-200	-	-	-	-