

Series 120

| Series 120 Fractional | Vc (sfm) | | DC • in | | | | | | |
|---|-----------|------------|---------|--------|--------|--------|--------|--------|--------|
| | | | 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 | 0.0009 | 0.0012 | 0.0015 | 0.0018 | 0.0021 | 0.0024 |
| | | Feed (ipm) | 5.9 | 5.9 | 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 | 0.0009 | 0.0012 | 0.0015 | 0.0018 | 0.0021 | 0.0024 |
| | | Feed (ipm) | 4.4 | 4.4 | 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 |

rpm = Vc x 3.82 / DC
 ipm = Fr x rpm
 adjust speed and / or feed based on resin type and / or fiber structure
 refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)

| Series 120 Metric | Vc (m/min) | | DC • 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 | 0.012 | 0.014 | 0.019 | 0.028 | 0.038 | 0.047 | 0.057 |
| | | Feed (mm/min) | 150 | 150 | 150 | 150 | 150 | 150 | 150 |
| GFRP (Fiberglass) | 75 | RPM | 9542 | 7951 | 5963 | 3976 | 2982 | 2385 | 1988 |
| | (65-90) | Fr | 0.012 | 0.014 | 0.019 | 0.029 | 0.039 | 0.048 | 0.058 |
| | | Feed (mm/min) | 115 | 115 | 115 | 115 | 115 | 115 | 115 |
| CARBON, GRAPHITE | 120 | RPM | 15266 | 12722 | 9542 | 6361 | 4771 | 3817 | 3181 |
| | (96-144) | Fr | 0.015 | 0.018 | 0.025 | 0.037 | 0.049 | 0.062 | 0.074 |
| | | Feed (mm/min) | 235 | 235 | 235 | 235 | 235 | 235 | 235 |

rpm = (Vc x 1000) / (DC x 3.14)
 mm/min = Fr x rpm
 adjust speed and / or feed based on resin type and / or fiber structure
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