

## TECHNICAL INFORMATION - METRIC PRODUCTS

Diamond Coated tools offer both a wide range of applications and the opportunity for significant cost reductions. The most common materials to benefit from Diamond are GRAPHITE, GREEN CERAMIC, GLASS FIBER PRODUCTS and PLASTICS.

The following Tables will provide you Starting Parameters for Graphite, Green Ceramic and Glass Fiber Products.

- ◎ ZAMUS GRA MATE
- ◎ METRIC SIZE

MATERIAL : GRAPHITE				
Endmill dia. Metric	Machine speed rpm	Cutting speed m/min.	Operation	Feed rate mpt
.5	20,000 ~ 40,000	24.4 ~ 48.8	Finishing	0.0002 ~ 0.0005
1	18,000 ~ 40,000	45.7 ~ 91.5	Finishing	0.0128 ~ 0.0257
1.5	12,000 ~ 40,000	53.4 ~ 182.9	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
3.0	6,000 ~ 40,000	61.0 ~ 403.9	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
5	4,000 ~ 40,000	61.0 ~ 548.8	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
6	3,000 ~ 36,700	61.0 ~ 716.5	General	0.0514 ~ 0.1028
			Finishing	0.0257 ~ 0.0514
8	2,500 ~ 31,800	61.0 ~ 792.7	General	0.0514 ~ 0.1028
			Finishing	0.0257 ~ 0.0514
10	2,000 ~ 28,500	61.0 ~ 853.6	General	0.0771 ~ 0.1280
			Finishing	0.0257 ~ 0.0771
12	1,500 ~ 23,000	61.0 ~ 914.6	General	0.0771 ~ 0.1280
			Finishing	0.0257 ~ 0.0771

◎ ZAMUS GRA MATE

◎ METRIC SIZE

MATERIAL : GREEN CERAMIC				
Endmill dia. Metric	Machine speed rpm	Cutting speed m/min.	Operation	Feed rate mpt
.5	6,000 ~ 19,500	7.6 ~ 21.3	Finishing	0.0002 ~ 0.0005
1	6,000 ~ 19,500	15.2 ~ 45.7	Finishing	0.0128 ~ 0.0257
1.5	6,000 ~ 19,500	30.5 ~ 91.5	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
3.0	4,800 ~ 16,000	61.0 ~ 213.4	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
5	4,100 ~ 15,000	61.0 ~ 213.4	General	0.0257 ~ 0.0514
			Finishing	0.0128 ~ 0.0257
6	3,000 ~ 12,000	61.0 ~ 243.9	General	0.0514 ~ 0.1028
			Finishing	0.0257 ~ 0.0514
8	2,500 ~ 11,000	61.0 ~ 274.4	General	0.0514 ~ 0.1028
			Finishing	0.0257 ~ 0.0514
10	2,000 ~ 10,800	61.0 ~ 304.9	General	0.0771 ~ 0.1280
			Finishing	0.0257 ~ 0.0771
12	1,500 ~ 10,000	61.0 ~ 304.9	General	0.0771 ~ 0.1280
			Finishing	0.0257 ~ 0.0771

- ◎ ZAMUS GRA MATE
- ◎ METRIC SIZE

## MATERIAL: GLASS FIBER PRODUCTS

Endmill dia. Metric	Machine speed rpm	Cutting speed m/min.	Operation	Feed rate mpt
1.5	3,700 ~ 7,300	18.3 ~ 36.6	General	0.0257 ~ 0.002
	5,200 ~ 10,400	26.2 ~ 51.8	Finishing	0.0128 ~ 0.0257
3	3,600 ~ 7,300	36.6 ~ 73.2	General	0.0128 ~ 0.0257
	5,200 ~ 9,200	51.8 ~ 91.5	Finishing	0.0064 ~ 0.1285
5	4,100 ~ 7,100	61.0 ~ 106.7	General	0.0257 ~ 0.0514
	6,100 ~ 10,200	91.5 ~ 152.4	Finishing	0.0128 ~ 0.0257
6	4,600 ~ 6,900	91.5 ~ 137.2	General	0.0257 ~ 0.0514
	5,300 ~ 8,400	106.7 ~ 167.7	Finishing	0.0128 ~ 0.0257
8	4,300 ~ 6,100	106.7 ~ 152.4	General	0.0257 ~ 0.0514
	4,300 ~ 7,300	106.7 ~ 182.9	Finishing	0.0128 ~ 0.0257
10	4,100 ~ 5,600	121.9 ~ 167.7	General	0.0514 ~ 0.1028
	3,500 ~ 6,600	106.7 ~ 198.2	Finishing	0.0257 ~ 0.0514
12	3,400 ~ 4,600	137.2 ~ 182.9	General	0.0514 ~ 0.1028
	2,600 ~ 5,700	106.7 ~ 228.7	Finishing	0.0257 ~ 0.0514