

## TECHNICAL INFORMATION - INCH 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
- ⊙ INCH SIZE

MATERIAL : GRAPHITE				
Endmill dia. Inch	Machine speed rpm	Cutting speed sfm	Operation	Feed rate ipt (inch)
1/64"	20,000 ~ 40,000	80 ~ 160	Finishing	0.0002 ~ 0.0005
1/32"	18,000 ~ 40,000	150 ~ 300	Finishing	0.0005 ~ 0.001
1/16"	12,000 ~ 40,000	175 ~ 600	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
1/8"	6,000 ~ 40,000	200 ~ 1325	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
3/16"	4,000 ~ 40,000	200 ~ 1800	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
1/4"	3,000 ~ 36,700	200 ~ 2350	General	0.002 ~ 0.004
			Finishing	0.001 ~ 0.002
5/16"	2,500 ~ 31,800	200 ~ 2600	General	0.002 ~ 0.004
			Finishing	0.001 ~ 0.002
3/8"	2,000 ~ 28,500	200 ~ 2.800	General	0.003 ~ 0.005
			Finishing	0.001 ~ 0.003
1/2"	1,500 ~ 23,000	200 ~ 3,000	General	0.003 ~ 0.005
			Finishing	0.001 ~ 0.003

- ◎ ZAMUS GRA MATE
- ◎ INCH SIZE

MATERIAL : GREEN CERAMIC				
Endmill dia. Inch	Machine speed rpm	Cutting speed sfm	Operation	Feed rate ipt (inch)
1/64"	6,000 ~ 19,500	25 ~ 70	Finishing	0.0002 ~ 0.0005
1/32"	6,000 ~ 19,500	50 ~ 150	Finishing	0.0005 ~ 0.001
1/16"	6,000 ~ 19,500	100 ~ 300	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
1/8"	4,800 ~ 16,000	200 ~ 700	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
3/16"	4,100 ~ 15,000	200 ~ 700	General	0.001 ~ 0.002
			Finishing	0.0005 ~ 0.001
1/4"	3,000 ~ 12,000	200 ~ 800	General	0.002 ~ 0.004
			Finishing	0.001 ~ 0.002
5/16"	2,500 ~ 11,000	200 ~ 900	General	0.002 ~ 0.004
			Finishing	0.001 ~ 0.002
3/8"	2,000 ~ 10,800	200 ~ 1,000	General	0.003 ~ 0.005
			Finishing	0.001 ~ 0.003
1/2"	1,500 ~ 10,000	200 ~ 1,300	General	0.003 ~ 0.005
			Finishing	0.001 ~ 0.003

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- ◎ INCH SIZE

MATERIAL : GLASS FIBER PRODUCTS				
Endmill dia. Inch	Machine speed rpm	Cutting speed sfm	Operation	Feed rate ipt (inch)
1/16"	3,700 ~ 7,300	60 ~ 120	General	0.001 ~ 0.002
	5,200 ~ 10,400	85 ~ 170	Finishing	0.0005 ~ 0.001
1/8"	3,600 ~ 7,300	120 ~ 240	General	0.0005 ~ 0.001
	5,200 ~ 9,200	170 ~ 300	Finishing	0.00025 ~ 0.005
3/16"	4,100 ~ 7,100	200 ~ 350	General	0.001 ~ 0.002
	6,100 ~ 10,200	300 ~ 500	Finishing	0.0005 ~ 0.001
1/4"	4,600 ~ 6,900	300 ~ 450	General	0.001 ~ 0.002
	5,300 ~ 8,400	350 ~ 550	Finishing	0.0005 ~ 0.001
5/16"	4,300 ~ 6,100	350 ~ 500	General	0.001 ~ 0.002
	4,300 ~ 7,300	350 ~ 600	Finishing	0.0005 ~ 0.001
3/8"	4,100 ~ 5,600	400 ~ 550	General	0.002 ~ 0.004
	3,500 ~ 6,600	350 ~ 650	Finishing	0.001 ~ 0.002
1/2"	3,400 ~ 4,600	450 ~ 600	General	0.002 ~ 0.004
	2,600 ~ 5,700	350 ~ 750	Finishing	0.001 ~ 0.002