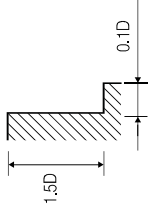


### 4 FLUTE, SQUARE GE504 ...series

MATERIAL	RPM	GRAPHITE	FEED
DIAMETER			
3.0	20000		1600
4.0	18000		1900
5.0	14000		2400
6.0	11000		2800
8.0	8000		2600
10.0	6500		2400
12.0	5500		2400
16.0	4200		2450
20.0	3300		2400

\* Please reduce cutting speed 50% from the above table when using long and extra long type

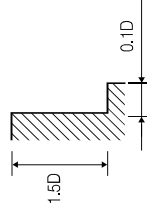


RPM=rev./min.  
FEED=mm/min.

### 2날 스퀘어 GE ...series

MATERIAL	RPM	GRAPHITE	FEED
DIAMETER			
0.4	40000		200
0.6	40000		350
0.8	40000		550
1.0	40000		700
2.0	25000		800
3.0	20000		800
4.0	18000		950
5.0	14000		1200
6.0	11000		1400
8.0	8000		1300
10.0	6500		1200
12.0	5500		1200

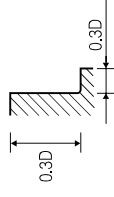
\* Please reduce cutting speed 50% from the above table when using long and extra long type



RPM=rev./min.  
FEED=mm/min.

### 4 FLUTE, CORNER RADIUS WGR504 ... series

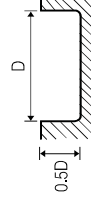
MATERIAL	RPM	GRAPHITE	FEED
DIAMETER			
4.0	40000		3500
6.0	40000		5600
8.0	32000		5600
10.0	26000		5700
12.0	21000		5450
16.0	15800		5450
20.0	12800		5500



RPM=rev./min.  
FEED=mm/min.

### 2 FLUTE, CORNER RADIUS WGR502 ... series

MATERIAL	RPM	GRAPHITE	FEED
DIAMETER			
0.4	40000		640
0.6	40000		640
0.8	40000		800
1.0	40000		960
1.2	40000		1200
1.5	40000		1440
2.0	40000		1600
3.0	27000		1900
4.0	20000		2300
5.0	16000		2300
6.0	14000		2300



RPM=rev./min.  
FEED=mm/min.