

TECHNICAL DATA | ZAMUS GRA MATE |

MATERIAL : GRAPHITE

Endmill dia.(Inch)	Machine speed(rpm)	Cutting speed(sfm)	Operation	Feedipt rate(ipt)
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
1/16	12,000 ~ 40,000	175 ~ 600	Finishing	0.0005 ~ 0.001
1/8	6,000 ~ 40,000	200 ~ 1325	General	0.001 ~ 0.002
1/8	6,000 ~ 40,000	200 ~ 1325	Finishing	0.0005 ~ 0.001
3/16	4,000 ~ 40,000	200 ~ 1800	General	0.001 ~ 0.002
3/16	4,000 ~ 40,000	200 ~ 1800	Finishing	0.0005 ~ 0.001
1/4	3,000 ~ 36,700	200 ~ 2350	General	0.002 ~ 0.004
1/4	3,000 ~ 36,700	200 ~ 2350	Finishing	0.001 ~ 0.002
5/16	2,500 ~ 31,800	200 ~ 2600	General	0.002 ~ 0.004
5/16	2,500 ~ 31,800	200 ~ 2600	Finishing	0.001 ~ 0.002
3/8	2,000 ~ 28,500	200 ~ 2.800	General	0.003 ~ 0.005
3/8	2,000 ~ 28,500	200 ~ 2.800	Finishing	0.001 ~ 0.003
1/2	1,500 ~ 23,000	200 ~ 3,000	General	0.003 ~ 0.005
1/2	1,500 ~ 23,000	200 ~ 3,000	Finishing	0.001 ~ 0.003

MATERIAL : GREEN CERAMIC

Endmill dia.(Inch)	Machine speed(rpm)	Cutting speed(sfm)	Operation	Feedipt rate(ipt)
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
1/16	6,000 ~ 19,500	100 ~ 300	Finishing	0.0005 ~ 0.001
1/8	4,800 ~ 16,000	200 ~ 700	General	0.001 ~ 0.002
1/8	4,800 ~ 16,000	200 ~ 700	Finishing	0.0005 ~ 0.001
3/16	4,100 ~ 15,000	200 ~ 700	General	0.001 ~ 0.002
3/16	4,100 ~ 15,000	200 ~ 700	Finishing	0.0005 ~ 0.001
1/4	3,000 ~ 12,000	200 ~ 800	General	0.002 ~ 0.004
1/4	3,000 ~ 12,000	200 ~ 800	Finishing	0.001 ~ 0.002
5/16	2,500 ~ 11,000	200 ~ 900	General	0.002 ~ 0.004
5/16	2,500 ~ 11,000	200 ~ 900	Finishing	0.001 ~ 0.002
3/8	2,000 ~ 10,800	200 ~ 1,000	General	0.003 ~ 0.005
3/8	2,000 ~ 10,800	200 ~ 1,000	Finishing	0.001 ~ 0.003
1/2	1,500 ~ 10,000	200 ~ 1,300	General	0.003 ~ 0.005
1/2	1,500 ~ 10,000	200 ~ 1,300	Finishing	0.001 ~ 0.003

MATERIAL : GLASS FIBER PRODUCTS

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