

CGB Graphite milling example

Work material : Graphite ISEM-8
Work size : 150 x 150 x 150 mm
Coolant : Air blow
Cycle time : 2hr 18min

CGB series for graphite



~ Milling condition ~

Process	Tools	Spindle Speed (min^{-1})	Feed Rate (mm/min)	a_p (mm)	a_e (mm)	Allowance (mm)
Roughing	CGB 2100 (R5 x 50)	6,400	6,000	2.5	4.0	0.3
Semi-finishing	CGB 2060 (R3 x 30)	11,000	8,000	0.5	0.5	0.1
Finishing	CGB 2040 (R2 x 20)	16,000	6,000	0.2	0.2	0
Finishing	CPRB 2020-22 (R1 x EL22)	30,000	4,000	0.03	0.03	0