

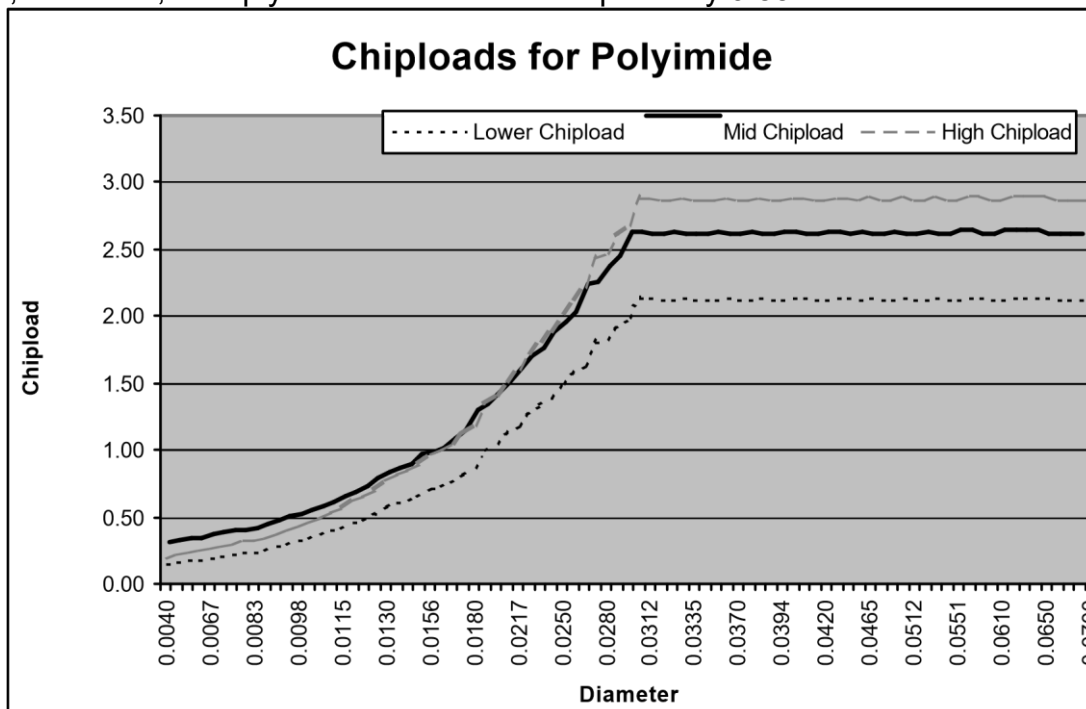
	(inch)	(Inches/min)	(k-rpm)	(inches/min)	(inches)		(mils/rev)	
3.05mm	0.1201	50	20	1000	-0.038	500	2.50	629
3.10mm	0.1220	50	20	1000	-0.038	500	2.50	638
3.15mm	0.1240	50	20	1000	-0.039	500	2.50	649
1/8	0.1250	50	20	1000	-0.039	500	2.50	654
3.20mm	0.1260	40	20	1000	-0.018	400	2.00	659
3.25mm	0.1280	40	20	1000	-0.018	400	2.00	670
#30	0.1285	40	20	1000	-0.019	400	2.00	672
3.30mm	0.1299	40	20	1000	-0.019	400	2.00	680
3.35mm	0.1319	40	20	1000	-0.019	400	2.00	690
3.40mm	0.1339	40	20	1000	-0.019	400	2.00	701
3.45mm	0.1358	40	20	1000	-0.019	400	2.00	711
#29	0.1360	40	20	1000	-0.019	400	2.00	712
3.50mm	0.1378	40	20	1000	-0.019	400	2.00	721
3.55mm	0.1398	40	20	1000	-0.019	400	2.00	732
#28	0.1405	40	20	1000	-0.019	400	2.00	735
9/64	0.1406	40	20	1000	-0.019	400	2.00	736
3.60mm	0.1417	40	20	1000	-0.019	400	2.00	742
3.65mm	0.1437	40	20	1000	-0.020	400	2.00	752
#27	0.1440	40	20	1000	-0.020	400	2.00	754
3.70mm	0.1457	40	20	1000	-0.020	400	2.00	762
#26	0.1470	40	20	1000	-0.020	400	2.00	769
3.75mm	0.1476	40	20	1000	-0.020	400	2.00	772
#25	0.1495	40	20	1000	-0.020	400	2.00	782
3.80mm	0.1496	40	20	1000	-0.020	400	2.00	783
3.85mm	0.1516	40	20	1000	-0.020	400	2.00	793
#24	0.1520	40	20	1000	-0.020	400	2.00	795
3.90mm	0.1535	40	20	1000	-0.020	400	2.00	803
#23	0.1540	40	20	1000	-0.020	400	2.00	806
3.95	0.1555	40	20	1000	-0.020	400	2.00	814
5/32	0.1562	30	20	1000	-0.020	400	1.50	817
#22	0.1570	30	20	1000	-0.020	400	1.50	822
4.00mm	0.1575	30	20	1000	-0.020	300	1.50	824
#21	0.1590	30	20	1000	-0.021	300	1.50	832
4.05mm	0.1594	30	20	1000	-0.021	300	1.50	834
#20	0.1610	30	20	1000	-0.021	300	1.50	843
4.10mm	0.1614	30	20	1000	-0.021	300	1.50	845
4.15mm	0.1634	30	20	1000	-0.021	300	1.50	855
4.20mm	0.1654	30	20	1000	-0.021	300	1.50	866
#19	0.1660	30	20	1000	-0.021	300	1.50	869
4.25mm	0.1673	30	20	1000	-0.021	300	1.50	876
4.30mm	0.1693	30	20	1000	-0.021	300	1.50	886
#18	0.1695	30	20	1000	-0.021	300	1.50	887
4.35mm	0.1713	30	20	1000	-0.021	300	1.50	896
11/64	0.1719	30	20	1000	-0.021	300	1.50	900
#17	0.1730	30	20	1000	-0.021	300	1.50	905
4.40mm	0.1732	30	20	1000	-0.021	300	1.50	906
4.45mm	0.1752	30	20	1000	-0.022	300	1.50	917
#16	0.1770	30	20	1000	-0.022	300	1.50	926

Size	Diameter	Feed	Speed	Retract	Z-Axis Offset	Hits	Chipload	SFM
	(inch)	(Inches/min)	(k-rpm)	(inches/min)	(inches)		(mils/rev)	
4.50mm	0.1772	30	20	1000	-0.022	300	1.50	927
4.55mm	0.1792	30	20	1000	-0.022	300	1.50	938
#15	0.1800	30	20	1000	-0.022	300	1.50	942
4.60mm	0.1811	30	20	1000	-0.022	300	1.50	948
#14	0.1820	30	20	1000	-0.022	300	1.50	952
4.65mm	0.1831	30	20	1000	-0.022	300	1.50	958
#13	0.1850	30	20	1000	-0.022	300	1.50	968
4.70mm	0.1850	30	20	1000	-0.022	300	1.50	968
4.75mm	0.1870	30	20	1000	-0.022	300	1.50	979
3/16	0.1875	30	20	1000	-0.022	300	1.50	981
4.80mm	0.1890	25	20	1000	-0.023	300	1.25	989
#12	0.1890	25	20	1000	-0.023	300	1.25	989
4.85mm	0.1909	25	20	1000	-0.023	300	1.25	999
#11	0.1910	25	20	1000	-0.023	300	1.25	1000
4.90mm	0.1929	25	20	1000	-0.023	300	1.25	1010
#10	0.1935	25	20	1000	-0.023	300	1.25	1013
4.95mm	0.1949	25	20	1000	-0.023	300	1.25	1020
#9	0.1960	25	20	1000	-0.023	300	1.25	1026
5.00mm	0.1968	25	20	1000	-0.023	300	1.25	1030
5.05mm	0.1988	25	20	1000	-0.023	300	1.25	1040
#8	0.1990	25	20	1000	-0.023	300	1.25	1041
5.10mm	0.2008	25	20	1000	-0.023	300	1.25	1051
#7	0.2010	23	20	1000	-0.023	250	1.15	1052
5.15mm	0.2028	23	20	1000	-0.023	250	1.15	1061
13/64	0.2031	23	20	1000	-0.023	250	1.15	1063
#6	0.2040	23	20	1000	-0.024	250	1.15	1068
5.20mm	0.2047	23	20	1000	-0.024	250	1.15	1071
#5	0.2055	23	20	1000	-0.024	250	1.15	1075
5.25mm	0.2067	23	20	1000	-0.024	250	1.15	1082
5.30mm	0.2087	23	20	1000	-0.024	250	1.15	1092
#4	0.2090	23	20	1000	-0.024	250	1.15	1094
5.35mm	0.2106	23	20	1000	-0.024	250	1.15	1102
5.40mm	0.2126	23	20	1000	-0.024	250	1.15	1113
#3	0.2130	23	20	1000	-0.024	250	1.15	1115
5.45mm	0.2146	23	20	1000	-0.024	250	1.15	1123
5.50mm	0.2165	23	20	1000	-0.024	250	1.15	1133
5.55mm	0.2185	23	20	1000	-0.024	250	1.15	1143
7/32	0.2188	23	20	1000	-0.024	250	1.15	1145
5.60mm	0.2205	23	20	1000	-0.025	250	1.15	1154
#2	0.2210	23	20	1000	-0.025	250	1.15	1157
5.65mm	0.2224	23	20	1000	-0.025	250	1.15	1164
5.70mm	0.2244	23	20	1000	-0.025	250	1.15	1174
5.75mm	0.2264	23	20	1000	-0.025	250	1.15	1185
#1	0.2280	23	20	1000	-0.025	200	1.15	1193
5.80mm	0.2283	23	20	1000	-0.025	200	1.15	1195
5.85mm	0.2302	23	20	1000	-0.025	200	1.15	1205
5.90mm	0.2323	23	20	1000	-0.025	200	1.15	1216
A	0.2340	23	20	1000	-0.025	150	1.15	1225

Size	Diameter	Feed	Speed	Retract	Z-Axis Offset	Hits	Chipload	SFM
	(inch)	(Inches/min)	(k-rpm)	(inches/min)	(inches)		(mils/rev)	
5.95mm	0.2343	23	20	1000	-0.026	150	1.15	1226
15/64	0.2344	23	20	1000	-0.026	150	1.15	1227
6.00mm	0.2362	23	20	1000	-0.026	150	1.15	1236
B	0.2380	23	20	1000	-0.026	150	1.15	1246
6.05mm	0.2382	23	20	1000	-0.026	150	1.15	1247
6.10mm	0.2402	23	20	1000	-0.026	150	1.15	1257
C	0.2420	23	20	1000	-0.026	150	1.15	1266
6.15mm	0.2421	23	20	1000	-0.026	150	1.15	1267
6.20mm	0.2441	23	20	1000	-0.026	150	1.15	1277
D	0.2460	23	20	1000	-0.026	150	1.15	1287
6.25mm	0.2461	23	20	1000	-0.026	150	1.15	1288
6.30mm	0.2480	23	20	1000	-0.026	150	1.15	1298
6.35mm	0.2500	23	20	1000	-0.027	150	1.15	1308
6.40mm	0.2520	23	20	1000	-0.027	150	1.15	1319
6.50mm	0.2559	23	20	1000	-0.027	150	1.15	1339
F	0.2570	23	20	1000	-0.027	150	1.15	1345
6.60mm	0.2598	23	20	1000	-0.027	150	1.15	1360

In some cases, there may be an opportunity to increase the chipload based on the application's robustness. Variables such as machine technology and condition, stack support materials, and tool design selection may allow the increased throughput with higher chiploads. Multiply the recommended chipload by 1.15 to reach the higher chipload.

If the application is not as robust due to heavy glass, high copper content, tight annular ring requirements, or similar, multiply the recommended chipload by 0.85.



Testing and data provided by Kyocera Precision Tools, Inc.

