



A300 Seires ECSSF

Material	CFRP		GFRP	
Vc	160 ~ 220 m/min		100 ~ 160 m/min	
Dia. (d)	RPM	fz (mm/tooth)	RPM	fz (mm/tooth)
6	10080	0.020	6900	0.020
8	7560	0.030	5170	0.030
10	6050	0.030	4140	0.030
12	5040	0.035	3450	0.035
	$ap = 1.5d$ $ae \leq 0.35d$			

A300 Seires ECSSR

Material	CFRP		GFRP	
Vc	140 ~ 200 m/min		90 ~ 140 m/min	
Dia. (d)	RPM	fz (mm/tooth)	RPM	fz (mm/tooth)
6	9020	0.020	6100	0.020
8	6760	0.030	4570	0.030
10	5410	0.030	3660	0.030
12	4510	0.035	3050	0.035
	$ap = 2d$ $ae \leq 0.35d$			

1. Use as highly rigid and accurate machine as possible.
2. If the rpm available is lower than the recommend condition, please reduce the feed rate to the same ratio.
3. Use long shank type please reduce the rpm and feed rate.
4. The Feed and RPM may be changed depending on the M/C conditions ,lubricating and cooling system.