

Workpiece	Graphite	
Diameter (mm)	RPM	FEED
0.5	16,000	480
0.75	16,000	640
1	16,000	800
1.5	16,000	1,450
2	16,000	2,100
3	15,000	2,950
4	13,000	3,000
5	11,500	3,050
6	10,500	3,150
8	8,555	2,960

RPM = rev/min
FEED = mm/min

