

CNC / NC Tools Parameter for Ceramic materials (Dekton, Neolith, Lapitec)



Photo	Items	Specification	Purpose	RPM	Feeding speed	Remarks
	Absolute - TT(K) (Finger bit)	Ø20 x L35 x N8 x ½"Gas x bottom seg	Cutting	5200	Soft & Medium Dekton (200~250mm/min) Hard Dekton (150mm/min)	1) Start with the feeding speed : 150 mm/min around 1~2meter at the beginning. 2) Bottom segment is not for drilling but for milling
	Easy Bit-K	Ø20 x H20 x M12 / standard type	Cutting or Rabbeting	7200~ 9000	400mm/min	Cutting depth :0.5mm/pass
	Easy Bit-Prop(K)	Ø10 x H10 x 1/2"Gas / standard type		10000	600mm/min	Cutting depth : 1~2.0mm/pass
		Ø15 x H20 x 1/2"Gas / standard type		8500	500mm/min	
	Core Drill-K	1 ¾"(Ø35) x UL40 x TL50 x T1.5 x ½"Gas X 4 slits	Boring	3000	15~20mm/min	Please start with feeding speed (Z axis) 10mm/min at the beginning
		1 ¾"(Ø25) x UL40 x TL50 x T1.5 x ½"Gas X 4 slits		4500		
	Maxmiller-K (Gauging wheel)	Ø91 x PCD63/3-Ø6.5/H15 x M7ICE x #40	Calibrating	3500	600mm/min	Cutting depth : 2.0mm/ pass
	KeramiCUT	14"(Ø350)	Straight	1800~ 2200	32"(800mm) ~ 40"(1000mm)/min	Advance(Special Note) RPM: 2800~3000 F/S: 2~3m/min on 12mm Ceramic RPM: 2700~2800 F/S: 1.2~1.9m/min on 20mm Ceramic
			Miter		16"(400mm)/min	
		16"(Ø400)	Straight	1960	32"(800mm) ~ 40"(1000mm)/min	Advance(Special Note) RPM: 2600~2700 F/S: 2~3m/min on 12mm Ceramic RPM: 2500~2600 F/S: 1.2~1.9m/min on 20mm Ceramic
			Miter		16"(400mm)/min	
		18"(Ø450)	Straight	1420~ 1450	32"(800mm) ~ 40"(1000mm)/min	
			Miter		16"(400mm)/min	

Above parameters can be changed in accordance with working conditions