

G9424, G9G44, G9A68, G9444, G9527, G9445, G9G45, G9452 SERIES

2 FLUTE - SLOTTING

Vc= m/min.
fz= mm/tooth
RPM= rev/min.
FEED=mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	1.0D	0.5D (UptoØ3:0.2D)	Vc	45	45	50	55	65	70	70	70	70	75	75	70	
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
	5		1.0D	0.5D (UptoØ3:0.2D)	FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
					Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
	6-7	Low alloy steel	1.0D	0.5D (UptoØ3:0.2D)	RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72
					Vc	45	45	50	55	65	70	70	70	70	75	75	70	
	8-9		1.0D	0.5D (UptoØ3:0.2D)	fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
10	High alloyed steel, and tool steel	1.0D	0.5D (UptoØ3:0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45	
				fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05	
				RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716	
11.1 - 11.2		1.0D	0.5D (UptoØ3:0.2D)	FEED	64	85	95	119	159	158	196	179	127	115	98	99	72	
				Vc	45	45	50	55	65	70	70	70	70	75	75	70		
				fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063	
M	14.1	Stainless steel	1.0D	0.5D (UptoØ3:0.2D)	RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
					Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
K	15-20	Greycastiron Nodularcastiron Malleablecastiron	1.0D	1.0D	fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	20	25	25	30	35	35	35	35	35	35	35	35	
					fz	0.003	0.007	0.009	0.016	0.025	0.031	0.04	0.053	0.059	0.058	0.059	0.068	0.064
					RPM	6366	5305	3979	3183	2785	2228	1857	1393	1114	928	796	696	557
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	FEED	38	74	72	102	139	138	149	148	131	108	94	95	71
					Vc	60	55	60	55	60	55	55	55	60	55	55	55	55
					fz	0.005	0.008	0.012	0.018	0.024	0.03	0.043	0.063	0.077	0.102	0.119	0.145	0.189
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875
					FEED	191	187	229	210	229	210	251	276	294	298	298	317	331
					Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
	29.1	Non Metallic Materials	1.0D	1.0D	fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	357	386	446	462	468	462	492	496	489	483	481	490	490
H	40	Chilled Cast Iron	1.0D	0.5D (UptoØ3:0.2D)	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
	40	Chilled Cast Iron	1.0D	0.5D (UptoØ3:0.2D)	FEED	204	282	334	334	333	334	368	376	368	368	372	372	368
					Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.004	0.007	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066	0.078	0.085	0.11
	40	Chilled Cast Iron	1.0D	0.5D (UptoØ3:0.2D)	RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	204	282	334	334	333	334	368	376	368	368	372	372	368
					Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
	40	Chilled Cast Iron	1.0D	0.5D (UptoØ3:0.2D)	fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72

IJ The FEED, in long & extra long types, should be reduced by around 50%

