



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

G9432, G9G50, G9A69, G9448, G9540, G9449, G9G51, G9453 SERIES

4 FLUTE - SIDE CUTTING

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	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90	
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047	0.047	0.047		
	5		0.1D	1.0D	RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432	
					FEED	140	233	229	267	484	519	554	616	509	449	385	355	269	
	6-7	Low alloy steel	0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55	
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038	
	8-9		0.1D	1.0D	RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875	
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133	
	10	High alloyed steel, and tool steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90	
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047	0.047	0.047	0.047	
M	14.1	Stainless steel	0.1D	1.0D	RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432	
					FEED	140	233	229	267	484	519	554	616	509	449	385	355	269	
	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55	
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038	
	21~22	Aluminum-wrought alloy	0.1D	1.5D	RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875	
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133	
	23~25	Aluminum-cast, alloyed	0.1D	1.5D	Vc	25	35	35	35	40	40	45	45	45	45	45	50	45	
					fz	0.002	0.004	0.006	0.009	0.018	0.024	0.029	0.042	0.044	0.045	0.045	0.045	0.046	
	26-28	Copper and Copper Alloys (Bronze / Brass)	0.1D	1.5D	RPM	7958	7427	5570	3714	3183	2546	2387	1790	1432	1194	1023	995	716	
					FEED	64	119	134	134	229	244	277	301	252	215	184	179	132	
N	29.1	Non Metallic Materials	0.1D	1.5D	Vc	60	55	60	55	60	55	55	55	60	55	55	55	55	
					fz	0.008	0.013	0.017	0.026	0.035	0.044	0.065	0.093	0.116	0.155	0.182	0.22	0.288	
	30~32	Aluminum-cast, alloyed	0.1D	1.5D	RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875	
					FEED	611	607	649	607	668	616	759	814	886	905	910	963	1008	
	33~35	Aluminum-wrought alloy	0.1D	1.5D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140	
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095	0.108	0.125	0.163	
	36~38	Aluminum-cast, alloyed	0.1D	1.5D	RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228	
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411	1424	1442	1453	
	39~41	Copper and Copper Alloys (Bronze / Brass)	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105	
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096	0.115	0.125	0.162	
H	40	Chilled Cast Iron	0.1D	1.0D	RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671	
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070	1098	1094	1083	
	41~43	Non Metallic Materials	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105	
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096	0.115	0.125	0.162	
	44~46	Aluminum-wrought alloy	0.1D	1.5D	RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671	
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070	1098	1094	1083	
	47~49	Aluminum-cast, alloyed	0.1D	1.5D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55	
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038	
	50~52	Copper and Copper Alloys (Bronze / Brass)	0.1D	1.5D	RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875	
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133	

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

