

RECOMMENDED CUTTING CONDITIONS

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

G9J57 SERIES

4 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	0.05D	2D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
	5	Non-alloy steel	0.05D	2D	Vc	35	39	42	45	46	46	50	53
					fz	0.010	0.017	0.023	0.034	0.040	0.053	0.061	0.063
					RPM	5570	4150	3350	2850	2450	1850	1600	1400
					FEED	223	140	155	195	195	195	195	175
	6-7	Low alloy steel	0.05D	2D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
	8-9	Low alloy steel	0.05D	2D	Vc	35	39	42	45	46	46	50	53
					fz	0.010	0.017	0.023	0.034	0.040	0.053	0.061	0.063
					RPM	5570	4150	3350	2850	2450	1850	1600	1400
					FEED	223	140	155	195	195	195	195	175
	10	High alloyed steel, and tool steel	0.05D	2D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
	11.1 11.2	High alloyed steel, and tool steel	0.05D	2D	Vc	35	39	42	45	46	46	50	53
					fz	0.010	0.017	0.023	0.034	0.040	0.053	0.061	0.063
					RPM	5570	4150	3350	2850	2450	1850	1600	1400
					FEED	223	140	155	195	195	195	195	175
K	15-16	Grey cast iron	0.05D	2.0D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
	17-18	Nodular cast iron	0.05D	2.0D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
	19-20	Malleable cast iron	0.05D	2.0D	Vc	55	61	65	70	73	73	63	62
					fz	0.011	0.014	0.022	0.026	0.030	0.042	0.061	0.059
					RPM	8754	6450	5200	4450	3850	2900	2000	1650
					FEED	385	185	225	230	230	245	245	195
H	38.1 38.2	Hardened steel	0.02D	2D	Vc	25	29	31	35	36	38	36	36
					fz	0.009	0.016	0.020	0.026	0.030	0.038	0.050	0.042
					RPM	3979	3050	2500	2200	1900	1500	1150	950
					FEED	143	95	100	115	115	115	115	80
	40	Chilled Cast Iron	0.05D	2D	Vc	35	39	42	45	46	46	50	53
					fz	0.010	0.017	0.023	0.034	0.040	0.053	0.061	0.063
					RPM	5570	4150	3350	2850	2450	1850	1600	1400
					FEED	223	140	155	195	195	195	195	175
	41	Hardened Cast Iron	0.05D	2D	Vc	25	29	31	35	36	38	36	36
					fz	0.009	0.016	0.020	0.026	0.030	0.038	0.050	0.042
					RPM	3979	3050	2500	2200	1900	1500	1150	950
					FEED	143	95	100	115	115	115	115	80

