

G9A42 SERIES
MULTI FLUTE ROUGHING - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0
P	1-4	Non-alloy steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	5	Non-alloy steel	0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
	6-7	Low alloy steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	8-9	Low alloy steel	0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
	10	High alloyed steel, and tool steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	11.1 - 11.2	High alloyed steel, and tool steel	0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
M	14.1	Stainless steel	0.05D	1.0D	Vc	135	135	135	135	135	140	130	130	145
					fz	0.022	0.022	0.028	0.034	0.039	0.038	0.039	0.038	0.038
					RPM	7162	5371	4297	3581	3069	2785	2299	2069	1846
					FEED	473	355	481	487	479	423	359	314	351
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	Vc	40	40	35	40	35	35	35	35	40
					fz	0.026	0.024	0.036	0.04	0.037	0.032	0.038	0.041	0.06
					RPM	2122	1592	1114	1061	796	696	619	557	509
					FEED	166	115	160	170	118	89	94	91	153
H	40	Chilled Cast Iron	0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521

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

