

RECOMMENDED CUTTING CONDITIONS

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

G9J60 SERIES

3&4 FLUTE ROUGHING - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-4	Non-alloy steel	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945
	5	Non-alloy steel	0.3D	1.5D	Vc	210	208	215	204	217	204
					fz	0.023	0.030	0.028	0.033	0.040	0.039
					RPM	11160	8280	6840	5400	4320	3240
					FEED	755	755	755	720	685	505
	6-7	Low alloy steel	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945
	8-9	Low alloy steel	0.3D	1.5D	Vc	210	208	215	204	217	204
					fz	0.023	0.030	0.028	0.033	0.040	0.039
					RPM	11160	8280	6840	5400	4320	3240
					FEED	755	755	755	720	685	505
	10	High alloyed steel, and tool steel	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945
	11.1	High alloyed steel, and tool steel	0.3D	1.5D	Vc	210	208	215	204	217	204
					fz	0.023	0.030	0.028	0.033	0.040	0.039
					RPM	11160	8280	6840	5400	4320	3240
					FEED	755	755	755	720	685	505
M	14.1	Stainless steel	0.3D	1.5D	Vc	143	143	144	143	149	136
					fz	0.023	0.030	0.028	0.034	0.042	0.038
					RPM	7560	5670	4590	3780	2970	2160
					FEED	515	515	515	515	500	325
K	15-16	Grey cast iron	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945
	17-18	Nodular cast iron	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945
	19-20	Malleable cast iron	0.3D	1.5D	Vc	265	262	260	271	271	271
					fz	0.050	0.067	0.063	0.075	0.100	0.113
					RPM	14040	10440	8280	7200	5400	4320
					FEED	2090	2090	2090	2160	2160	1945

