

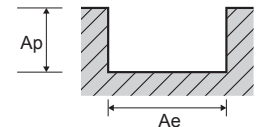
RECOMMENDED CUTTING CONDITIONS

G9F41 / G9J54 SERIES 2 FLUTE - SLOTTING

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

ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	Diameter (Ø)																		
						1.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	6.5	8.0	9.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	49	48	53	58	62	66	70	72	73	75	77	77	78	76	74	75	81	80	79
					fz	0.004	0.008	0.010	0.012	0.014	0.020	0.025	0.028	0.031	0.035	0.040	0.048	0.056	0.060	0.064	0.065	0.062	0.063	0.062
	RPM		15450	10100	8500	7380	6600	6000	5550	5090	4650	4340	4100	3770	3100	2690	2350	2000	1850	1600	1250			
	FEED		115	160	170	180	190	240	275	285	290	305	325	360	350	325	300	260	230	200	155			
	5	Non-alloy steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	29	28	35	37	39	41	43	43	43	45	47	46	46	46	46	47	51	50	47
					fz	0.004	0.008	0.010	0.013	0.016	0.020	0.024	0.027	0.031	0.036	0.041	0.045	0.050	0.050	0.050	0.048	0.048	0.050	0.050
	RPM		9200	6000	5550	4710	4100	3730	3400	3040	2750	2600	2500	2250	1850	1630	1450	1250	1150	1000	750			
	FEED		70	90	110	120	130	150	165	165	170	190	205	205	185	165	145	120	110	100	75			
	6-7	Low alloy steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	49	48	53	58	62	66	70	72	73	75	77	77	78	76	74	75	81	80	79
					fz	0.004	0.008	0.010	0.012	0.014	0.020	0.025	0.028	0.031	0.035	0.040	0.048	0.056	0.060	0.064	0.065	0.062	0.063	0.062
	RPM		15450	10100	8500	7380	6600	6000	5550	5090	4650	4340	4100	3770	3100	2690	2350	2000	1850	1600	1250			
	FEED		115	160	170	180	190	240	275	285	290	305	325	360	350	325	300	260	230	200	155			
8-9	Low alloy steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	29	28	35	37	39	41	43	43	43	45	47	46	46	46	46	47	51	50	47	
				fz	0.004	0.008	0.010	0.013	0.016	0.020	0.024	0.027	0.031	0.036	0.041	0.045	0.050	0.050	0.048	0.048	0.050	0.050		
RPM		9200	6000	5550	4710	4100	3730	3400	3040	2750	2600	2500	2250	1850	1630	1450	1250	1150	1000	750				
FEED		70	90	110	120	130	150	165	165	170	190	205	205	185	165	145	120	110	100	75				
10	High alloyed steel, and tool steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	49	48	53	58	62	66	70	72	73	75	77	77	78	76	74	75	81	80	79	
				fz	0.004	0.008	0.010	0.012	0.014	0.020	0.025	0.028	0.031	0.035	0.040	0.048	0.056	0.060	0.064	0.065	0.062	0.063	0.062	
RPM		15450	10100	8500	7380	6600	6000	5550	5090	4650	4340	4100	3770	3100	2690	2350	2000	1850	1600	1250				
FEED		115	160	170	180	190	240	275	285	290	305	325	360	350	325	300	260	230	200	155				
11.1 11.2	High alloyed steel, and tool steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	29	28	35	37	39	41	43	43	43	45	47	46	46	46	46	47	51	50	47	
				fz	0.004	0.008	0.010	0.013	0.016	0.020	0.024	0.027	0.031	0.036	0.041	0.045	0.050	0.050	0.048	0.048	0.050	0.050		
RPM		9200	6000	5550	4710	4100	3730	3400	3040	2750	2600	2500	2250	1850	1630	1450	1250	1150	1000	750				
FEED		70	90	110	120	130	150	165	165	170	190	205	205	185	165	145	120	110	100	75				
M	14.1	Stainless steel	1D	0.5D (Up to Ø3 : 0.2D)	Vc	24	29	29	30	32	34	36	36	36	38	40	39	39	39	39	40	40	38	38
					fz	0.004	0.007	0.009	0.012	0.016	0.020	0.025	0.028	0.032	0.036	0.039	0.046	0.053	0.055	0.058	0.057	0.061	0.067	0.063
K	15-16	Grey cast iron	1D	1.0D	Vc	63	61	63	62	62	62	62	62	62	61	60	60	60	62	63	58	62	60	60
					fz	0.005	0.008	0.012	0.015	0.018	0.021	0.024	0.027	0.030	0.037	0.043	0.052	0.061	0.069	0.078	0.103	0.120	0.144	0.192
	RPM		20200	13050	10100	7890	6550	5640	4950	4390	3950	3530	3200	2940	2400	2190	2000	1550	1400	1200	950			
	FEED		220	220	240	235	240	240	240	240	240	260	275	305	295	305	310	320	335	345	365			
	17-18	Nodular cast iron	1D	1.0D	Vc	63	61	63	62	62	62	62	62	62	61	60	60	60	62	63	58	62	60	60
					fz	0.005	0.008	0.012	0.015	0.018	0.021	0.024	0.027	0.030	0.037	0.043	0.052	0.061	0.069	0.078	0.103	0.120	0.144	0.192
	RPM		20200	13050	10100	7890	6550	5640	4950	4390	3950	3530	3200	2940	2400	2190	2000	1550	1400	1200	950			
	FEED		220	220	240	235	240	240	240	240	240	260	275	305	295	305	310	320	335	345	365			
	19-20	Malleable cast iron	1D	1.0D	Vc	63	61	63	62	62	62	62	62	62	61	60	60	60	62	63	58	62	60	60
					fz	0.005	0.008	0.012	0.015	0.018	0.021	0.024	0.027	0.030	0.037	0.043	0.052	0.061	0.069	0.078	0.103	0.120	0.144	0.192
	RPM		20200	13050	10100	7890	6550	5640	4950	4390	3950	3530	3200	2940	2400	2190	2000	1550	1400	1200	950			
	FEED		220	220	240	235	240	240	240	240	240	260	275	305	295	305	310	320	335	345	365			
H	38.1 40	Hardened steel Chilled Cast Iron	1D	0.5D (Up to Ø3 : 0.2D)	Vc	29	28	35	37	39	41	43	43	43	45	47	46	46	46	46	47	51	50	47
					fz	0.004	0.008	0.010	0.013	0.016	0.020	0.024	0.027	0.031	0.036	0.041	0.045	0.050	0.050	0.048	0.048	0.050	0.050	
RPM	9200	6000	5550	4710	4100	3730	3400	3040	2750	2600	2500	2250	1850	1630	1450	1250	1150	1000	750					
FEED	70	90	110	120	130	150	165	165	170	190	205	205	185	165	145	120	110	100	75					

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



SUPER HARDENED
HSS END MILL

COATED CARBIDE END MILL
FOR GENERAL

COATED CARBIDE END MILL
FOR HEAVY CUTTING

COATED CARBIDE END MILL
FOR HARDENED MATERIAL

COATED CARBIDE DRILL
FOR GENERAL