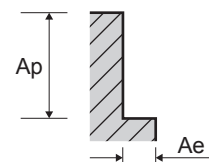


RECOMMENDED CUTTING CONDITIONS

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

G9J58 SERIES		6 FLUTE - SIDE CUTTING				Diameter (Ø)					
ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	6.0	8.0	10.0	12.0	16.0	
P	3-4	Non-alloy steel	0.05D	1.5D	Vc	105	106	104	107	106	
					fz	0.030	0.038	0.045	0.053	0.062	
	RPM		5590	4210	3320	2835	2105				
	FEED		995	960	900	895	785				
	5	Non-alloy steel	0.03D	1.5D	Vc	70	71	70	71	71	
					fz	0.030	0.038	0.045	0.053	0.062	
	RPM		3725	2810	2215	1890	1405				
	FEED		675	640	600	600	520				
	7	Low alloy steel	0.05D	1.5D	Vc	105	106	104	107	106	
					fz	0.030	0.038	0.045	0.053	0.062	
RPM	5590		4210	3320	2835	2105					
FEED	995		960	900	895	785					
8-9	Low alloy steel	0.03D	1.5D	Vc	70	71	70	71	71		
				fz	0.030	0.038	0.045	0.053	0.062		
RPM		3725	2810	2215	1890	1405					
FEED		675	640	600	600	520					
11.1 11.2	High alloyed steel, and tool steel	0.03D	1.5D	Vc	70	71	70	71	71		
				fz	0.030	0.038	0.045	0.053	0.062		
RPM		3725	2810	2215	1890	1405					
FEED		675	640	600	600	520					
K	15-16	Grey cast iron	0.05D	1.5D	Vc	105	106	104	107	106	
					fz	0.030	0.038	0.045	0.053	0.062	
	RPM		5590	4210	3320	2835	2105				
	17-18	Nodular cast iron	0.05D	1.5D	Vc	105	106	104	107	106	
					fz	0.030	0.038	0.045	0.053	0.062	
	RPM		5590	4210	3320	2835	2105				
19-20	Malleable cast iron	0.05D	1.5D	Vc	105	106	104	107	106		
				fz	0.030	0.038	0.045	0.053	0.062		
RPM		5590	4210	3320	2835	2105					
H	38.1	Hardened steel	0.03D	1.5D	Vc	54	54	54	54	54	
					fz	0.023	0.029	0.033	0.039	0.046	
					RPM	2860	2160	1730	1440	1080	
					FEED	400	370	340	340	300	
	38.2		Hardened steel	0.02D	1D	Vc	43	44	43	43	44
						fz	0.018	0.023	0.027	0.032	0.038
						RPM	2270	1730	1380	1135	865
						FEED	250	235	220	215	195
	40	Chilled Cast Iron		0.03D	1.5D	Vc	70	71	70	71	71
						fz	0.030	0.038	0.045	0.053	0.062
						RPM	3725	2810	2215	1890	1405
						FEED	675	640	600	600	520
41	Hardened Cast Iron		0.02D	1D	Vc	43	44	43	43	44	
					fz	0.018	0.023	0.027	0.032	0.038	
					RPM	2270	1730	1380	1135	865	
					FEED	250	235	220	215	195	



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