

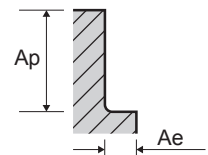
# RECOMMENDED CUTTING CONDITIONS

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	
	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	
	5	Low alloy steel	0.05D	2D	RPM	5570	4150	3350	2850	2450	1850	1600	1400
					FEED	223	140	155	195	195	195	195	175
	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	
6-7	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		
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		
8-9	High alloyed steel, and tool steel	0.05D	2D	RPM	8754	6450	5200	4450	3850	2900	2000	1650	
				FEED	385	185	225	230	230	245	245	195	
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	Grey cast iron	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		
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		
11.1 11.2	Nodular cast iron	0.05D	2D	RPM	5570	4150	3350	2850	2450	1850	1600	1400	
				FEED	223	140	155	195	195	195	195	175	
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		
K	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		
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		
H	Hardened steel	0.02D	2D	RPM	5570	4150	3350	2850	2450	1850	1600	1400	
				FEED	223	140	155	195	195	195	195	175	
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		
H	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		
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		
H	Hardened Cast Iron	0.05D	2D	RPM	3979	3050	2500	2200	1900	1500	1150	950	
				FEED	143	95	100	115	115	115	115	80	



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