



X5070 END MILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

G8A02, G8A37 SERIES

4 FLUTE - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)										
						1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	5	Non-alloy steel	0.03D	1.0D	Vc	150	210	205	210	245	245	250	245	250	245	245
					fz	0.008	0.013	0.02	0.027	0.032	0.037	0.048	0.056	0.066	0.077	0.083
					RPM	47746	33423	21751	16711	15597	12998	9947	7799	6631	4874	3899
					FEED	1528	1738	1740	1805	1996	1924	1910	1747	1751	1501	1294
	8-9	Low alloy steel	0.03D	1.0D	Vc	150	210	205	210	245	245	250	245	250	245	245
					fz	0.008	0.013	0.02	0.027	0.032	0.037	0.048	0.056	0.066	0.077	0.083
					RPM	47746	33423	21751	16711	15597	12998	9947	7799	6631	4874	3899
					FEED	1528	1738	1740	1805	1996	1924	1910	1747	1751	1501	1294
	11.1	High alloyed steel, and tool steel	0.03D	1.0D	Vc	150	210	205	210	245	245	250	245	250	245	245
					fz	0.008	0.013	0.02	0.027	0.032	0.037	0.048	0.056	0.066	0.077	0.083
					RPM	47746	33423	21751	16711	15597	12998	9947	7799	6631	4874	3899
					FEED	1528	1738	1740	1805	1996	1924	1910	1747	1751	1501	1294
11.2	High alloyed steel, and tool steel	0.03D	1.0D	Vc	120	165	165	165	195	195	195	195	200	195	195	
				fz	0.007	0.012	0.018	0.025	0.03	0.034	0.043	0.051	0.06	0.071	0.078	
				RPM	38197	26261	17507	13130	12414	10345	7759	6207	5305	3879	3104	
				FEED	1070	1261	1261	1313	1490	1407	1335	1266	1273	1102	968	
H	38.1	Hardened steel	0.03D	1.0D	Vc	120	165	165	165	195	195	195	195	200	195	195
					fz	0.007	0.012	0.018	0.025	0.03	0.034	0.043	0.051	0.06	0.071	0.078
					RPM	38197	26261	17507	13130	12414	10345	7759	6207	5305	3879	3104
					FEED	1070	1261	1261	1313	1490	1407	1335	1266	1273	1102	968
	38.2	Hardened steel	0.03D	1.0D	Vc	80	110	110	110	130	130	130	130	130	130	130
					fz	0.007	0.012	0.018	0.025	0.03	0.034	0.043	0.051	0.06	0.07	0.079
					RPM	25465	17507	11671	8754	8276	6897	5173	4138	3448	2586	2069
					FEED	713	840	840	875	993	938	890	844	828	724	654
	39.1	Hardened steel	0.03D	1.0D	Vc	65	90	90	90	100	100	100	100	100	100	100
					fz	0.005	0.009	0.014	0.019	0.023	0.026	0.033	0.038	0.045	0.053	0.059
					RPM	20690	14324	9549	7162	6366	5305	3979	3183	2653	1989	1592
					FEED	414	516	535	544	586	552	525	484	478	422	376
39.2	Hardened steel	0.03D	1.0D	Vc	50	70	70	70	80	80	80	80	80	80	80	
				fz	0.004	0.007	0.011	0.015	0.018	0.021	0.026	0.03	0.036	0.042	0.048	
				RPM	15915	11141	7427	5570	5093	4244	3183	2546	2122	1592	1273	
				FEED	255	312	327	334	367	356	331	306	306	267	244	
39.3	Hardened steel	0.03D	1.0D	Vc	40	60	60	60	70	70	70	70	70	70	70	
				fz	0.004	0.007	0.009	0.013	0.016	0.018	0.022	0.025	0.03	0.036	0.041	
				RPM	12732	9549	6366	4775	4456	3714	2785	2228	1857	1393	1114	
				FEED	204	267	229	248	285	267	245	223	223	201	183	
40	Chilled Cast Iron	0.03D	1.0D	Vc	120	165	165	165	195	195	195	195	200	195	195	
				fz	0.007	0.012	0.018	0.025	0.03	0.034	0.043	0.051	0.06	0.071	0.078	
				RPM	38197	26261	17507	13130	12414	10345	7759	6207	5305	3879	3104	
				FEED	1070	1261	1261	1313	1490	1407	1335	1266	1273	1102	968	
41	Hardened Cast Iron	0.03D	1.0D	Vc	80	110	110	110	130	130	130	130	130	130	130	
				fz	0.007	0.012	0.018	0.025	0.03	0.034	0.043	0.051	0.06	0.07	0.079	
				RPM	25465	17507	11671	8754	8276	6897	5173	4138	3448	2586	2069	
				FEED	713	840	840	875	993	938	890	844	828	724	654	

