

G9H73, G9H74, G9H75, G9H76 SERIES

4 FLUTE MULTIFLUX HELIX

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

SIDE CUTTING										SLOTING				FEED = mm/min.									
ISO	VDI 3323	Material Description	Ae	Ap	Ae	Ap	Parameter	Diameter (Ø)															
								3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0							
P	1-4	Non-alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	106	106	106	106	106	118	118	118	118							
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065							
	RPM		11291	8470	6776	5642	4235	3745	3122	2338	1869												
	FEED		228	270	298	361	459	571	588	497	487												
	5	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	75	75	75	75	75	82	82	82	82								
						fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065								
	RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302													
	FEED	158	189	210	256	322	396	410	347	340													
	6-7	Low alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	106	106	106	106	106	118	118	118	118							
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065							
RPM	11291		8470	6776	5642	4235	3745	3122	2338	1869													
FEED	228		270	298	361	459	571	588	497	487													
8-9	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	75	75	75	75	75	82	82	82	82									
					fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065									
RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302														
FEED	158	189	210	256	322	396	410	347	340														
10 - 11.1	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	45	45	45	45	45	49	49	49	49								
						fz	0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.037	0.045								
RPM		4753	3563	2849	2380	1785	1561	1302	973	777													
FEED		56	84	91	105	137	168	168	144	140													
M	12-13	Stainless steel	0.1D	1.5D (1.2D)	0.1D	0.8D	Vc	104	104	104	104	104	104	104	104								
							fz	0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.045	0.055							
	RPM		10990	8246	6594	5495	4123	3297	2751	2058	1652												
	FEED		175	200	238	287	364	448	427	371	364												
	14.1	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	74	74	74	74	74	74	74	74									
						fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.077								
RPM	7875	5908	4725	3934	2954	2359	1967	1477	1183														
FEED	158	189	245	284	329	455	434	368	364														
14.2	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	67	67	67	67	67	67	67	67										
					fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.076									
RPM	7056	5292	4235	3528	2646	2114	1764	1323	1057														
FEED	140	168	221	256	298	406	389	329	322														
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	78	78	78	78	78	86	86	86	86							
							fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.065	0.081							
							RPM	8316	6237	4991	4158	3122	2744	2282	1715	1372							
							FEED	200	249	280	333	424	525	529	445	445							

*() : Short length

