

RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDPARAMETER

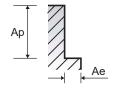
G9H73, G9H74, G9H75, G9H76 SERIES

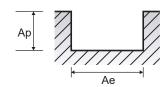
4 FLUTE MULTIFUL HELIX

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

			SIDE C	UTTING	SLOT	TING									FEED =	mm/min.
ISO	VDI			Ар	Ae	Ар	Parameter	Diameter (Ø)								
150	3323	Description	Ae	^ρ	\rac{1}{2}	Αþ	raiailletei	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	800.0	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 fz	75 0.005	75 0.008	75 0.011	75 0.016	75 0.027	82 0.038	82 0.047	82 0.053	82 0.065
							RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302
							FEED	158	189	210	256	322	396	410	347	340
							Vc	106	106	106	106	106	118	118	118	118
	6-7	Low alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	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 Vc	158 45	189 45	210 45	256 45	322 45	396	410 49	347 49	340 49
	10 - 11.1	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	0.1D	0.8D	vc fz	0.003	0.006	0.008	0.011	0.019	49 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	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	74
							fz RPM	0.005	0.008	0.013 4725	0.018	0.028	0.048	0.055	0.062 1477	0.077
							FEED	7875 158	5908 189	245	3934 284	2954 329	2359 455	1967 434	368	1183 364
							Vc	67	67	67	67	67	67	67	67	67
	14.2		0.3D	1.5D (1.2D)	0.1D	0.8D	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		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
	15-20						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





HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR

X1-EH END MILLS

X5070 END MILLS

4G MILL

X-POWER PRO END MILLS

POWER END MILLS

V7 PLUS

ALU-POWER HPC END MILLS

ALU-POWER END MILLS D-POWER

CRX S END MILLS

K-2 END MILLS

ONLY ONE COATED PM60 END MILLS

TANK POWER END MILLS

MILLING

TECHNICAL DATA