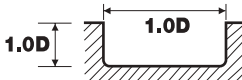
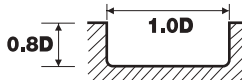
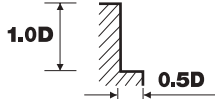
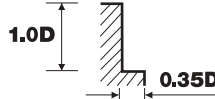


4 & 5 FLUTE CORNER RADIUS CARBIDE ROUGHER

G9D67, G9D68, G9D75, G9D76, G9D77 & G9D69 Series

CUTTING DATA

Slotting & Side Cutting

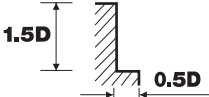
MATERIAL	ALLOYED STEELS, CARBON STEELS & TOOL STEELS				ALLOYED STEELS, CARBON STEELS, TOOL STEELS & PRE HARDENED STEELS			
	CAST IRON				CAST IRON			
Hardness	~ HRc 35				HRc 35 ~ HRc 45			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
SLOTTING								
6	12000	1550	225	0.032	10600	1100	200	0.026
8	9000	1650	225	0.046	8100	1180	205	0.036
10	7200	1650	225	0.057	6400	1180	200	0.046
12	6000	1540	225	0.064	5400	1140	205	0.053
16	4500	1500	225	0.067	4100	1050	205	0.051
20	3600	1330	225	0.074	3200	900	200	0.056
								
SIDE CUTTING								
6	15800	2570	300	0.041	14300	1850	270	0.032
8	11900	2700	300	0.057	10700	1950	270	0.046
10	9500	2700	300	0.071	8500	1950	265	0.057
12	8000	2570	300	0.080	7100	1850	270	0.065
16	6000	2450	300	0.082	5400	1750	270	0.065
20	4800	2140	300	0.089	4300	1500	270	0.070
								

4 & 5 FLUTE CORNER RADIUS HSS-PM ROUGHER

GAE53 Series

CUTTING DATA

Side Cutting

MATERIAL	STRUCTURAL STEEL & CARBON STEEL				STRUCTURAL STEEL, & CARBON STEEL				CARBON STEEL ALLOY STEEL & TOOL STEEL				PRE HARDENED STEEL, ALLOY STEEL & TOOL STEEL				STAINLESS STEEL			
					CAST IRON															
Hardness	-				~ HRc 20				HRc 20 ~ 30				HRc 30 ~ 40				-			
Strength	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
6	3250	240	60	0.019	2500	185	48	0.018	1800	120	34	0.017	1500	110	28	0.018	1750	130	33	0.019
8	2750	300	70	0.027	2150	240	54	0.028	1550	170	38	0.027	1200	130	32	0.028	1450	170	36	0.029
10	2150	430	70	0.050	1700	330	54	0.049	1200	205	38	0.043	1000	170	32	0.041	1150	200	36	0.045
12	1800	430	70	0.060	1400	350	54	0.063	1000	240	38	0.059	850	190	32	0.055	950	245	36	0.064
14	1550	430	70	0.055	1200	350	54	0.073	850	240	38	0.069	700	190	32	0.065	850	245	36	0.074
16	1400	430	70	0.063	1100	350	54	0.081	750	240	38	0.080	600	190	32	0.075	700	245	36	0.085
18	1200	430	70	0.072	1000	350	54	0.085	700	240	38	0.086	550	190	32	0.082	650	245	36	0.093
20	1100	445	70	0.080	850	350	54	0.101	600	240	38	0.100	500	190	32	0.092	600	245	36	0.107
																				

RPM: revolutions per minute Feed: mm per minute Vc: surface speed (metres per minute) Fz: feed per tooth