

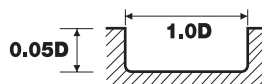
2 FLUTE CORNER RADIUS LONG NECK

G8A60 Series

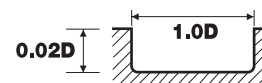
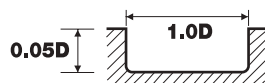
CUTTING DATA

Slotting

MATERIAL	ALLOY STEEL & HEAT RESISTANT STEEL				HARDENED STEEL				HARDENED STEEL			
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				STAINLESS STEEL			
Hardness	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				<HRc 55			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.5	50000	144	80	0.001	45000	110	70	0.001	40000	85	65	0.001
0.6	50000	185	95	0.002	45000	140	85	0.002	40000	110	75	0.001
0.8	50000	235	125	0.002	40000	170	100	0.002	30000	115	75	0.002
1	48000	590	150	0.006	38000	460	120	0.006	25500	285	80	0.006
2	33300	670	210	0.010	26000	540	165	0.010	17500	335	110	0.010
3	21800	670	205	0.015	17300	540	165	0.016	11500	335	110	0.015
4	16700	700	210	0.021	13200	560	165	0.021	8800	350	110	0.020
5	15700	810	245	0.026	12500	645	195	0.026	8300	395	130	0.024
6	13100	755	245	0.029	10350	615	195	0.030	6900	385	130	0.028
8	9880	740	250	0.037	7800	575	195	0.037	5200	355	130	0.034
10	7800	670	245	0.043	6150	540	195	0.044	4100	330	130	0.040
12	6650	672	250	0.051	5250	540	200	0.051	3500	330	130	0.047



MATERIAL	HARDENED STEEL								HIGH HARDENED STEEL			
	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc65-70			
Hardness	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc65-70			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.5	33000	55	50	0.001	25000	30	40	0.001	20000	20	30	0.250
0.6	30000	65	55	0.001	25000	40	45	0.001	20000	25	40	0.278
0.8	25000	70	65	0.001	19000	45	50	0.001	16000	28	40	0.280
1	20500	170	65	0.004	16000	105	50	0.003	12500	70	40	0.700
2	14500	205	90	0.007	11000	130	70	0.006	9500	90	60	0.643
3	9500	205	90	0.011	7500	130	70	0.009	6400	90	60	0.643
4	7200	215	90	0.015	5600	135	70	0.012	4750	95	60	0.679
5	6400	230	100	0.018	5100	145	80	0.014	4450	105	70	0.656
6	5300	225	100	0.021	4200	140	80	0.017	3700	100	70	0.625
8	4000	205	100	0.026	3200	130	80	0.020	2800	95	70	0.594
10	3200	190	100	0.030	2550	120	80	0.024	2200	90	70	0.563
12	2650	190	100	0.036	2100	120	80	0.029	1860	90	70	0.563



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

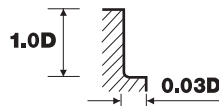
2 FLUTE CORNER RADIUS LONG NECK

G8A60 Series

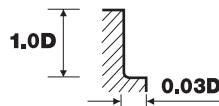
CUTTING DATA

Side Cutting

MATERIAL	ALLOY STEEL & HEAT RESISTANT STEEL				HARDENED STEEL				HARDENED STEEL			
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				STAINLESS STEEL			
Hardness	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				<HRc 55			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.5	50000	205	80	0.002	45000	160	70	0.002	40000	125	65	0.002
0.6	50000	265	95	0.003	45000	200	85	0.002	40000	160	75	0.002
0.8	50000	335	125	0.003	40000	245	100	0.003	30000	165	75	0.003
1	48000	840	150	0.009	38000	656	120	0.009	25500	408	80	0.008
2	33300	960	210	0.014	26000	776	165	0.015	17500	480	110	0.014
3	21800	960	205	0.022	17300	776	165	0.022	11500	480	110	0.021
4	16700	1000	210	0.030	13200	800	165	0.030	8800	500	110	0.028
5	15700	1160	245	0.037	12500	920	195	0.037	8300	568	130	0.034
6	13100	1080	245	0.041	10350	880	195	0.043	6900	552	130	0.040
8	9880	1056	250	0.053	7800	824	195	0.053	5200	508	130	0.049
10	7800	960	245	0.062	6150	776	195	0.063	4100	472	130	0.058
12	6650	960	250	0.072	5250	776	200	0.074	3500	472	130	0.067



MATERIAL	HARDENED STEEL								HIGH HARDENED STEEL			
	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc65-70			
Hardness	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc65-70			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.5	33000	80	50	0.001	25000	45	40	0.001	20000	30	30	0.001
0.6	30000	90	55	0.002	25000	60	45	0.001	20000	35	40	0.001
0.8	25000	100	65	0.002	19000	65	50	0.002	16000	40	40	0.001
1	20500	248	65	0.006	16000	152	50	0.005	12500	100	40	0.004
2	14500	296	90	0.010	11000	184	70	0.008	9500	132	60	0.007
3	9500	296	90	0.016	7500	184	70	0.012	6400	132	60	0.010
4	7200	308	90	0.021	5600	192	70	0.017	4750	136	60	0.014
5	6400	328	100	0.026	5100	208	80	0.020	4450	152	70	0.017
6	5300	320	100	0.030	4200	204	80	0.024	3700	148	70	0.020
8	4000	292	100	0.037	3200	188	80	0.029	2800	136	70	0.024
10	3200	272	100	0.043	2550	176	80	0.035	2200	128	70	0.029
12	2650	272	100	0.051	2100	176	80	0.042	1860	128	70	0.034



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