

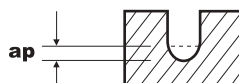
2 FLUTE BALL NOSE LONG NECK

G8A46 & G8A54 Series

CUTTING DATA

Slotting

MATERIAL		ALLOY STEEL & HEAT RESISTANT STEEL					HARDENED STEEL				
							STAINLESS STEEL				
Hardness		HRc 30 ~ HRc 45					<HRc 55				
Dia.	Rad.	RPM	Feed	Vc	Fz	ap	RPM	Feed	Vc	Fz	ap
0.2	0.1	50000	300~350	31	0.012~0.014	0.006~0.016	50000	265~310	31	0.011~0.012	0.005~0.013
0.3	0.15	48000~50000	480~520	45~47	0.020~0.021	0.010~0.017	48000~50000	440~460	45~47	0.018~0.018	0.008~0.014
0.4	0.2	48000~50000	720~790	60~63	0.030~0.032	0.013~0.032	48000~50000	450~550	60~63	0.019~0.022	0.011~0.026
0.5	0.25	34100~49500	600~870	54~78	0.035~0.035	0.007~0.028	31900~35200	490~540	50~55	0.031~0.031	0.005~0.023
0.6	0.3	28600~40700	590~850	54~77	0.041~0.042	0.007~0.034	26400~29700	480~540	50~56	0.036~0.036	0.006~0.028
0.8	0.4	22000~30800	640~890	55~77	0.058~0.058	0.016~0.064	19800~22000	490~550	50~55	0.049~0.05	0.013~0.052
1	0.5	17600~24200	600~850	55~76	0.068~0.070	0.008~0.080	15400~17600	470~540	48~55	0.061~0.061	0.007~0.065
1.2	0.6	14300~18700	590~780	54~70	0.083~0.083	0.024~0.032	12000~14000	480~540	45~53	0.080~0.077	0.020~0.026
1.5	0.75	11000~14300	580~760	52~67	0.105~0.106	0.031~0.048	10000~11500	480~540	47~54	0.096~0.094	0.025~0.039
2	1	8500~11000	590~800	53~69	0.139~0.145	0.024~0.160	7900~8800	470~530	50~55	0.119~0.12	0.020~0.130
3	1.5	5700~8200	730~1000	54~77	0.256~0.244	0.064~0.240	5300~5800	590~650	50~55	0.223~0.224	0.052~0.195
4	2	4300~6200	680~990	54~78	0.316~0.319	0.080~0.320	3950~4400	550~620	50~55	0.299~0.282	0.065~0.026



MATERIAL		HIGH HARDENED STEEL					COPPER				
		< HRc 65					-				
Dia.	Rad.	RPM	Feed	Vc	Fz	ap	RPM	Feed	Vc	Fz	ap
0.2	0.1	50000	225~265	31~31	0.009~0.011	0.005~0.012	50000	455~530	31~31	0.018~0.021	0.010~0.022
0.3	0.15	46000~50000	390~420	43~47	0.017~0.017	0.007~0.013	48000~50000	690~790	45~47	0.029~0.032	0.002~0.023
0.4	0.2	46000~50000	400~460	58~63	0.017~0.018	0.010~0.024	48000~50000	1000~1150	60~63	0.042~0.046	0.019~0.048
0.5	0.25	31900~35200	440~480	50~55	0.028~0.027	0.005~0.021	49000~50000	1100~1400	77~79	0.045~0.056	0.010~0.042
0.6	0.3	26400~29700	400~480	50~56	0.030~0.032	0.006~0.025	42000~50000	1100~1700	79~94	0.052~0.068	0.011~0.050
0.8	0.4	19800~22000	440~500	50~55	0.044~0.045	0.012~0.048	31000~50000	1100~2250	78~126	0.071~0.090	0.024~0.096
1	0.5	15400~17600	440~500	48~55	0.057~0.057	0.006~0.060	24000~49500	1100~2200	75~156	0.092~0.089	0.012~0.120
1.2	0.6	12000~14000	420~480	45~53	0.070~0.069	0.018~0.024	28500~38500	1480~1950	107~145	0.104~0.101	0.036~0.048
1.5	0.75	10000~11500	420~480	47~54	0.084~0.083	0.023~0.036	17000~28500	1100~1950	80~134	0.129~0.137	0.046~0.072
2	1	7900~8800	440~480	50~55	0.111~0.109	0.018~0.120	12600~24000	1100~2150	79~151	0.175~0.179	0.036~0.240
3	1.5	5300~5800	550~620	50~55	0.208~0.214	0.048~0.120	11900~17000	1850~2700	112~160	0.311~0.318	0.096~0.360
4	2	3850~4400	530~570	48~55	0.275~0.259	0.060~0.240	6600~12500	1260~2500	83~157	0.382~0.400	0.120~0.480



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

