

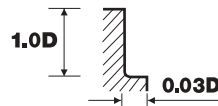
4 FLUTE CORNER RADIUS EXTENDED NECK

G8A47 & G8B08 Series

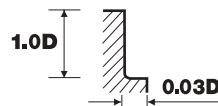
CUTTING DATA

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
1	48000	1184	150	0.006	38000	840	120	0.006	25500	568	80	0.006
2	33300	1400	210	0.011	26000	1000	165	0.010	17500	672	110	0.010
3	21800	1400	205	0.016	17300	1000	165	0.014	11500	672	110	0.015
4	16700	1440	210	0.022	13200	1040	165	0.020	8800	704	110	0.020
5	15700	1600	245	0.025	12500	1200	195	0.024	8300	800	130	0.024
6	13100	1560	245	0.030	10350	1120	195	0.027	6900	760	130	0.028
8	9880	1504	250	0.038	7800	1080	195	0.035	5200	720	130	0.035
10	7800	1400	245	0.045	6150	1008	195	0.041	4100	672	130	0.041
12	6650	1400	250	0.053	5250	1008	200	0.048	3500	672	130	0.048
16	4900	1200	245	0.061	3900	880	195	0.056	2600	584	130	0.056
20	3900	1040	245	0.067	3100	776	195	0.063	2050	520	130	0.063



MATERIAL	HARDENED STEEL								HIGH HARDENED STEEL			
	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc 65 ~ HRc 70			
Hardness	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc 65 ~ HRc 70			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	20500	344	65	0.004	16000	216	50	0.003	12500	140	40	0.700
2	14500	416	90	0.007	11000	256	70	0.006	9500	184	60	0.657
3	9500	416	90	0.011	7500	256	70	0.009	6400	184	60	0.657
4	7200	432	90	0.015	5600	268	70	0.012	4750	192	60	0.686
5	6400	464	100	0.018	5100	296	80	0.015	4450	216	70	0.675
6	5300	448	100	0.021	4200	280	80	0.017	3700	208	70	0.650
8	4000	416	100	0.026	3200	264	80	0.021	2800	192	70	0.600
10	3200	384	100	0.030	2550	248	80	0.024	2200	176	70	0.550
12	2650	384	100	0.036	2100	240	80	0.029	1860	176	70	0.550
16	2000	336	100	0.042	1600	216	80	0.034	1400	160	70	0.500
20	1600	304	100	0.048	1300	200	80	0.038	1100	144	70	0.450



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



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