

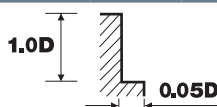
6 FLUTE CORNER RADIUS 45° HELIX

G8A39 Series

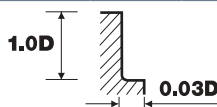
CUTTING DATA

Side Cutting

MATERIAL	ALLOY STEEL & HEAT RESISTANT STEEL				HARDENED STEEL							
Hardness	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				HRc 50 ~ HRc 55			
Diameter	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
6	24800	5350	465	0.036	23500	4900	445	0.035	16000	4900	300	0.051
8	20000	5500	505	0.046	19000	5000	480	0.044	12000	4600	300	0.064
10	16000	4900	505	0.051	15500	4500	485	0.048	9500	4100	300	0.072
12	13000	4500	490	0.058	12500	4100	470	0.055	8000	3800	300	0.079
16	10000	4000	505	0.067	9700	3700	490	0.064	6000	3400	300	0.094
20	8000	3350	505	0.070	7800	3400	490	0.073	4800	3200	300	0.111



MATERIAL	HARDENED STEEL				HARDENED STEEL				HIGH HARDENED STEEL			
	STAINLESS STEEL											
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
6	13500	3300	255	0.041	10500	2100	200	0.033	8000	1450	150	1.208
8	10000	3100	250	0.052	8000	2000	200	0.042	6000	1400	150	1.167
10	8000	2900	250	0.060	6400	1800	200	0.047	4800	1300	150	1.083
12	6600	2500	250	0.063	5300	1600	200	0.050	4000	1150	150	0.958
16	5000	2300	250	0.077	4000	1250	200	0.052	3000	870	150	0.725
20	4000	2100	250	0.088	3200	1020	200	0.053	2400	690	150	0.575



NOTE: For long & extra long types the feed should be reduced by around 50%.

CBN TURNING



SUPERB PERFORMANCE IN HARDENED STEELS & CAST IRON

- For cutting heat treated steel, cast iron, sintered materials and heat resistant super alloys
- Coated, regrindable, single use and multi-edge types
- Exceptional surface finish, CBN can replace grinding

call **01924 869610** or visit www.cutwel.co.uk



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

