

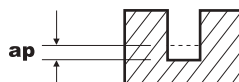
2 FLUTE LONG NECK

G8A45 Series

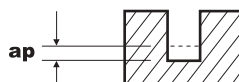
CUTTING DATA

Slotting

MATERIAL	ALLOY STEEL & HEAT RESISTANT STEEL					HARDENED STEEL				
	STAINLESS STEEL					HRC 45 ~ HRC 55				
Hardness	HRC 30 ~ HRC 45					HRC 45 ~ HRC 55				
Diameter	RPM	Feed	Vc	Fz	ap	RPM	Feed	Vc	Fz	ap
0.2	50000	300~350	31	0.003~0.004	0.006~0.016	50000	265~310	31	0.003~0.003	0.005~0.013
0.3	43000~50000	330~420	41~47	0.004~0.004	0.006~0.015	39900~46200	265~310	38~44	0.003~0.003	0.004~0.011
0.4	31400~50000	350~590	39~63	0.006~0.006	0.005~0.028	30500~35200	295~340	38~44	0.005~0.005	0.003~0.020
0.5	25650~33000	370~470	40~52	0.007~0.007	0.006~0.035	23750~26000	285~315	37~41	0.006~0.006	0.004~0.025
0.6	20900~35200	330~560	39~66	0.008~0.008	0.007~0.030	19900~22000	260~290	38~41	0.007~0.007	0.005~0.021
0.8	16150~26400	360~590	41~66	0.011~0.011	0.009~0.040	15200~16700	280~310	38~42	0.009~0.009	0.006~0.028
1	12300~18700	350~540	39~59	0.014~0.014	0.011~0.028	10500~11500	250~280	33~36	0.012~0.012	0.008~0.020
1.2	10450~17600	350~590	39~66	0.017~0.017	0.025~0.070	9100~10000	250~280	34~38	0.014~0.014	0.015~0.042
1.5	9100~17600	430~830	43~83	0.024~0.024	0.017~0.077	7000~8000	250~280	33~38	0.018~0.018	0.012~0.055
2	6350~10550	340~570	40~66	0.027~0.027	0.021~0.140	6100~6700	270~300	38~42	0.022~0.022	0.015~0.100
3	4300~7050	550~900	41~66	0.064~0.064	0.056~0.210	3990~4600	445~515	38~43	0.056~0.056	0.040~0.150
4	3200~5300	400~675	40~67	0.063~0.064	0.074~0.280	3000~3400	335~380	38~43	0.056~0.056	0.053~0.200



MATERIAL	HIGH HARDENED STEEL					COPPER				
	HRC 65 ~ HRC 70					-				
Hardness	HRC 65 ~ HRC 70					-				
Diameter	RPM	Feed	Vc	Fz	ap	RPM	Feed	Vc	Fz	ap
0.2	50000	225~265	31	0.002~0.003	0.005~0.012	50000	455~530	31	0.005~0.005	0.010~0.022
0.3	23900~32300	105~185	23~30	0.002~0.003	0.003~0.007	48000~50000	550~640	45~47	0.006~0.006	0.010~0.025
0.4	18300~24600	120~200	23~31	0.003~0.004	0.002~0.012	48000~50000	790~920	60~63	0.008~0.009	0.008~0.048
0.5	14200~18000	115~130	22~28	0.004~0.004	0.003~0.015	44000~50000	800~1150	69~79	0.009~0.012	0.010~0.060
0.6	11900~15500	100~120	22~29	0.004~0.004	0.003~0.013	37500~50000	770~1250	71~94	0.01~0.013	0.011~0.051
0.8	9000~11700	110~125	23~29	0.006~0.005	0.004~0.017	28500~47000	770~1300	72~118	0.014~0.014	0.015~0.068
1	6300~8050	100~115	20~25	0.008~0.007	0.005~0.012	22500~34000	810~1300	71~107	0.018~0.019	0.018~0.048
1.2	5400~7000	100~115	20~26	0.009~0.008	0.009~0.026	22500~31500	950~1350	85~119	0.021~0.021	0.036~0.101
1.5	4300~5500	100~115	20~26	0.012~0.01	0.007~0.033	14500~25000	770~1320	68~118	0.027~0.026	0.028~0.132
2	3600~4700	100~120	23~30	0.014~0.013	0.009~0.060	11500~18500	770~1250	72~116	0.033~0.034	0.036~0.240
3	2400~3200	105~310	23~30	0.022~0.048	0.024~0.090	9000~13000	1400~2110	85~123	0.078~0.081	0.096~0.360
4	1800~2400	75~230	23~30	0.021~0.048	0.032~0.120	6750~9750	1050~1575	85~123	0.078~0.081	0.128~0.480



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