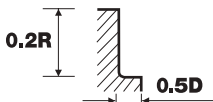
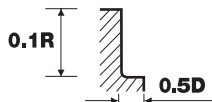
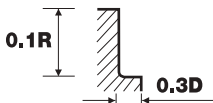
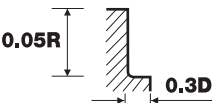


4 FLUTE CORNER RADIUS HIGH FEED

G8B59 & G8B54 Series

CUTTING DATA

Side Cutting

MATERIAL		HARDENED STEEL																			
Hardness		~ HRc 40				HRc 40 ~ HRc 50				HRc 50 ~ HRc 55				HRc 55 ~ HRc 60				HRc 60 ~ HRc 65			
Dia.	Rad.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
NORMAL SPEED																					
2	0.5	13500	6500	85	0.120	9550	3800	60	0.099	5500	2200	35	0.100	3200	1000	20	0.078	2200	550	15	0.063
3	0.5	9550	6500	90	0.170	6900	4150	65	0.150	4550	2750	45	0.151	2850	1150	25	0.101	1900	610	20	0.080
4	0.5	7950	7000	100	0.220	5750	4600	70	0.200	4000	3200	50	0.200	2550	1350	30	0.132	1750	700	20	0.100
5	0.5	6500	7300	100	0.281	4800	4800	75	0.250	3400	3200	55	0.235	2200	1600	35	0.182	1500	700	25	0.117
6	0.5	5800	7650	110	0.330	4100	4900	75	0.299	2900	3500	55	0.302	1850	1850	35	0.250	1350	795	25	0.147
6	1	5800	7650	110	0.330	4100	4900	75	0.299	2900	3500	55	0.302	1850	1850	35	0.250	1350	795	25	0.147
8	1	4350	7650	110	0.440	3050	4900	75	0.402	2200	3500	55	0.398	1400	1850	35	0.330	995	795	25	0.200
8	2	4350	7650	110	0.440	3050	4900	75	0.402	2200	3500	55	0.398	1400	1850	35	0.330	995	795	25	0.200
10	1	3500	7650	110	0.546	2450	4900	75	0.500	1750	3500	55	0.500	1100	1850	35	0.420	795	795	25	0.250
10	2	3500	7650	110	0.546	2450	4900	75	0.500	1750	3500	55	0.500	1100	1850	35	0.420	795	795	25	0.250
12	2	2900	7650	110	0.659	2050	4900	75	0.598	1450	3500	55	0.603	925	1850	35	0.500	665	795	25	0.299
12	3	2900	7650	110	0.659	2050	4900	75	0.598	1450	3500	55	0.603	925	1850	35	0.500	665	795	25	0.299
16	3	2200	7650	110	0.869	1550	4900	80	0.790	1100	3500	55	0.795	700	1850	35	0.661	500	795	25	0.398
																					
HIGH SPEED																					
2	0.5	29000	15000	180	0.129	22000	9800	140	0.111	15000	7850	95	0.131	11000	4450	70	0.101	8700	2450	55	0.070
3	0.5	22000	16000	205	0.182	17000	10000	160	0.147	12500	8000	200	0.160	9500	4600	90	0.121	6900	2500	65	0.091
4	0.5	17000	17500	215	0.257	13000	12000	165	0.231	11000	9200	140	0.209	8000	5500	100	0.172	5600	2900	70	0.129
5	0.5	15000	18000	235	0.300	11000	12500	175	0.284	10000	10000	155	0.250	7000	6000	110	0.214	4900	3100	75	0.158
6	0.5	13500	18500	255	0.343	10500	13800	200	0.329	9000	11000	170	0.306	6400	6400	120	0.250	4500	3600	85	0.200
6	1	13500	18500	255	0.343	10500	13800	200	0.329	9000	11000	170	0.306	6400	6400	120	0.250	4500	3600	85	0.200
8	1	10000	18500	250	0.463	8000	14000	200	0.438	6800	11000	170	0.404	4800	6700	120	0.349	3400	4100	85	0.301
8	2	10000	18500	250	0.463	8000	14000	200	0.438	6800	11000	170	0.404	4800	6700	120	0.349	3400	4100	85	0.301
10	1	8000	18500	250	0.578	6400	14000	200	0.547	5400	11000	170	0.509	3800	6800	120	0.447	2700	3800	85	0.352
10	2	8000	18500	250	0.578	6400	14000	200	0.547	5400	11000	170	0.509	3800	6800	120	0.447	2700	3800	85	0.352
12	2	6600	18500	250	0.701	5300	14000	200	0.660	4500	11000	170	0.611	3200	7000	120	0.547	2250	3600	85	0.400
12	3	6600	18500	250	0.701	5300	14000	200	0.660	4500	11000	170	0.611	3200	7000	120	0.547	2250	3600	85	0.400
16	3	5000	18500	250	0.925	3900	14000	195	0.897	3300	11000	165	0.833	2400	7000	120	0.729	1650	3300	85	0.500
																					

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