

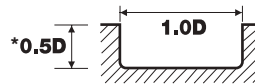
2 FLUTE

G9424, G9G44, G9445, G9G45 & G9452 Series

CUTTING DATA

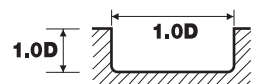
Slotting

MATERIAL	NON-ALLOYED STEEL ALLOY STEEL & TOOL STEEL				ALLOY STEEL & HEAT RESISTANT STEEL				STAINLESS STEEL			
	~ HRC30				HRC30 ~ HRC45				-			
Hardness	~ 1000N/mm ²				1000 ~ 1500N/mm ²				-			
Strength												
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	14300	105	45	0.004	8500	65	25	0.004	7150	50	20	0.003
1.5	9350	150	45	0.008	5550	85	25	0.008	5600	80	25	0.007
2	7850	160	50	0.010	5150	100	30	0.010	4300	80	25	0.009
3	6100	180	55	0.015	3800	120	35	0.016	3150	100	30	0.016
4	5150	255	65	0.025	3150	155	40	0.025	2650	130	35	0.025
5	4300	270	70	0.031	2550	160	40	0.031	2150	135	35	0.031
6	3800	300	70	0.039	2300	190	45	0.041	1950	155	35	0.040
8	2850	325	70	0.057	1700	170	45	0.050	1450	155	35	0.053
10	2200	280	70	0.064	1350	135	40	0.050	1150	135	35	0.059
12	1850	240	70	0.065	1150	110	45	0.048	950	110	35	0.058
14	1700	215	75	0.063	1050	100	45	0.048	850	100	35	0.059
16	1500	185	75	0.062	950	95	50	0.050	700	95	35	0.068
20	1150	145	70	0.063	700	70	45	0.050	550	70	35	0.064



*up to 3mm Diameter 0.2D

MATERIAL	CAST IRON				ALUMINIUM ALLOYS				COPPER. BRASS NON-FERROUS METALS			
	-				-				-			
Hardness	-				-				-			
Strength	-				-				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	18700	205	60	0.005	44000	330	140	0.004	24700	200	80	0.004
1.5	12100	205	55	0.008	27500	385	130	0.007	20300	300	95	0.007
2	9350	220	60	0.012	22000	460	140	0.010	16500	340	105	0.010
3	6050	220	55	0.018	15400	460	145	0.015	11000	340	105	0.015
4	4600	220	60	0.024	11000	460	140	0.021	8800	340	110	0.019
5	3650	220	55	0.030	9150	460	145	0.025	6800	340	105	0.025
6	2950	255	55	0.043	7600	485	145	0.032	5700	375	105	0.033
8	2200	275	55	0.063	5700	485	145	0.043	4400	375	110	0.043
10	1850	285	60	0.077	4600	485	145	0.053	3400	375	105	0.055
12	1450	295	55	0.102	3750	485	140	0.065	2850	375	105	0.066
14	1300	310	55	0.119	3300	485	145	0.073	2400	375	105	0.078
16	1100	320	55	0.145	2850	485	145	0.085	2200	375	110	0.085
20	900	340	55	0.189	2200	485	140	0.110	1700	375	105	0.110


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

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

