

### 6 FLUTE 45° HELIX END MILL

G9F85

### CUTTING DATA

Side Cutting

Material	Non-Alloyed Steel & Alloy Steel				Alloy Steel & Heat Resistant Steel				Hardened Steel				Cast Iron			
Hardness	~ HRC30				HRC30 - HRC50				HRC50 - HRC60				~ HRC30			
Strength	~ 1000N/mm <sup>2</sup>				1000 ~ 1750N/mm <sup>2</sup>				1750 ~ 2080N/mm <sup>2</sup>				~ 1000N/mm <sup>2</sup>			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
3	8650	825	82	0.024	5750	555	54	0.024	4750	344	45	0.018	8650	825	82	0.024
4	6600	858	83	0.033	4400	581	55	0.033	3600	357	45	0.025	6600	858	83	0.033
5	6250	990	98	0.026	4150	660	65	0.027	3200	383	50	0.02	6250	990	98	0.026
6	5175	924	98	0.03	3450	627	65	0.03	2650	369	50	0.023	5175	924	98	0.03
8	3900	891	98	0.038	2600	594	65	0.038	2000	344	50	0.029	3900	891	98	0.038
10	3075	831	97	0.045	2050	555	64	0.045	1600	317	50	0.033	3075	831	97	0.045
12	2625	831	99	0.053	1750	555	66	0.053	1825	317	69	0.029	2625	831	99	0.053
14	2230	770	98	0.058	1500	515	66	0.057	1130	280	50	0.041	2230	770	98	0.058
16	1950	726	98	0.062	1300	482	65	0.062	1000	278	50	0.046	1950	726	98	0.062
18	1720	670	97	0.065	1150	455	65	0.066	880	265	50	0.05	1720	670	97	0.065
20	1550	641	97	0.069	1025	429	64	0.07	800	251	50	0.052	1550	641	97	0.069

  

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### 3-4 FLUTE FINE PITCH RIPPER

G9F87 Series

### CUTTING DATA

Side Cutting

Material	Non-Alloyed Steel Alloy Steel & Tool Steel				Alloy Steel & Heat Resistant Steel				Stainless Steel				HRSA's			
Hardness	~ HRC30				HRC30 - HRC38				HRC38 - HRC45				-			
Strength	~ 1000N/mm <sup>2</sup>				1000 ~ 1200N/mm <sup>2</sup>				1200 ~ 1400N/mm <sup>2</sup>				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
6	13250	1970	250	0.050	10550	710	200	0.022	7150	480	135	0.022	2050	160	40	0.026
8	9850	1970	250	0.067	7800	710	195	0.023	5350	480	135	0.022	1550	150	40	0.024
10	7800	1970	245	0.063	6450	710	205	0.028	4350	480	135	0.028	1100	160	35	0.036
12	6800	2040	255	0.075	5100	680	190	0.033	3550	480	135	0.034	1000	160	40	0.040
14	5800	2040	255	0.088	4400	710	195	0.040	3050	480	135	0.039	750	110	35	0.037
16	5100	2040	255	0.100	4100	650	205	0.040	2800	430	140	0.038	700	90	35	0.032
18	4400	1970	250	0.112	3750	610	210	0.041	2300	360	130	0.039	600	90	35	0.038
20	4100	1840	260	0.112	3050	480	190	0.039	2050	310	130	0.038	550	90	35	0.041
25	3650	1830	285	0.100	2700	530	210	0.039	1850	350	145	0.038	500	90	40	0.060

  

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