G9B84, G9B85 SERIES

4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)									
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	5		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
	6-7	Low alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	8-9		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
	10	High alloyed steel, and tool steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	11.1 - 11.2		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
M	14.1	Stainless steel	0.1D	1.0D	Vc	25	35	35	35	40	40	45	45	45	45
					fz	0.002	0.004	0.006	0.009	0.018	0.024	0.029	0.042	0.044	0.045
					RPM	7958	7427	5570	3714	3183	2546	2387	1790	1432	1194
					FEED	64	119	134	134	229	244	277	301	252	215
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	60	55	55	55	60	55
					fz	0.008	0.013	0.017	0.026	0.035	0.044	0.065	0.093	0.116	0.155
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459
					FEED	611	607	649	607	668	616	759	814	886	905
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070
H	40	Chilled Cast Iron	1.0D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216

※ The FEED, in long & extra long types, should be reduced by around 50%