

**G8A02, G8A37** SERIES

**4 FLUTE - SIDE CUTTING**

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

| ISO | VDI 3323 | Material Description               | Ae                 | Ap    | Parameter | Diameter (Ø) |       |       |       |       |       |       |       |       |       |       |       |
|-----|----------|------------------------------------|--------------------|-------|-----------|--------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|     |          |                                    |                    |       |           | 1.0          | 2.0   | 3.0   | 4.0   | 5.0   | 6.0   | 8.0   | 10.0  | 12.0  | 16.0  | 20.0  |       |
| P   | 5        | Non-alloy steel                    | 0.03D              | 1.0D  | Vc        | 150          | 210   | 205   | 210   | 245   | 245   | 250   | 245   | 250   | 245   | 245   |       |
|     |          |                                    |                    |       | fz        | 0.008        | 0.013 | 0.02  | 0.027 | 0.032 | 0.037 | 0.048 | 0.056 | 0.066 | 0.077 | 0.083 |       |
|     |          |                                    |                    |       | RPM       | 47746        | 33423 | 21751 | 16711 | 15597 | 12998 | 9947  | 7799  | 6631  | 4874  | 3899  |       |
|     |          |                                    |                    |       | FEED      | 1528         | 1738  | 1740  | 1805  | 1996  | 1924  | 1910  | 1747  | 1751  | 1501  | 1294  |       |
|     | 8-9      | Low alloy steel                    | 0.03D              | 1.0D  | Vc        | 150          | 210   | 205   | 210   | 245   | 245   | 250   | 245   | 250   | 245   | 245   |       |
|     |          |                                    |                    |       | fz        | 0.008        | 0.013 | 0.02  | 0.027 | 0.032 | 0.037 | 0.048 | 0.056 | 0.066 | 0.077 | 0.083 |       |
|     |          |                                    |                    |       | RPM       | 47746        | 33423 | 21751 | 16711 | 15597 | 12998 | 9947  | 7799  | 6631  | 4874  | 3899  |       |
|     |          |                                    |                    |       | FEED      | 1528         | 1738  | 1740  | 1805  | 1996  | 1924  | 1910  | 1747  | 1751  | 1501  | 1294  |       |
|     | 11.1     | High alloyed steel, and tool steel | 0.03D              | 1.0D  | Vc        | 150          | 210   | 205   | 210   | 245   | 245   | 250   | 245   | 250   | 245   | 245   |       |
|     |          |                                    |                    |       | fz        | 0.008        | 0.013 | 0.02  | 0.027 | 0.032 | 0.037 | 0.048 | 0.056 | 0.066 | 0.077 | 0.083 |       |
|     |          |                                    |                    |       | RPM       | 47746        | 33423 | 21751 | 16711 | 15597 | 12998 | 9947  | 7799  | 6631  | 4874  | 3899  |       |
|     |          |                                    |                    |       | FEED      | 1528         | 1738  | 1740  | 1805  | 1996  | 1924  | 1910  | 1747  | 1751  | 1501  | 1294  |       |
|     | 11.2     | High alloyed steel, and tool steel | 0.03D              | 1.0D  | Vc        | 120          | 165   | 165   | 165   | 195   | 195   | 195   | 195   | 200   | 195   | 195   |       |
|     |          |                                    |                    |       | fz        | 0.007        | 0.012 | 0.018 | 0.025 | 0.03  | 0.034 | 0.043 | 0.051 | 0.06  | 0.071 | 0.078 |       |
|     |          |                                    |                    |       | RPM       | 38197        | 26261 | 17507 | 13130 | 12414 | 10345 | 7759  | 6207  | 5305  | 3879  | 3104  |       |
|     |          |                                    |                    |       | FEED      | 1070         | 1261  | 1261  | 1313  | 1490  | 1407  | 1335  | 1266  | 1273  | 1102  | 968   |       |
| H   | 38.1     | Hardened steel                     | 0.03D              | 1.0D  | Vc        | 120          | 165   | 165   | 165   | 195   | 195   | 195   | 195   | 200   | 195   | 195   |       |
|     |          |                                    |                    |       | fz        | 0.007        | 0.012 | 0.018 | 0.025 | 0.03  | 0.034 | 0.043 | 0.051 | 0.06  | 0.071 | 0.078 |       |
|     |          |                                    |                    |       | RPM       | 38197        | 26261 | 17507 | 13130 | 12414 | 10345 | 7759  | 6207  | 5305  | 3879  | 3104  |       |
|     |          |                                    |                    |       | FEED      | 1070         | 1261  | 1261  | 1313  | 1490  | 1407  | 1335  | 1266  | 1273  | 1102  | 968   |       |
|     | 38.2     |                                    | 0.03D              | 1.0D  | Vc        | 80           | 110   | 110   | 110   | 130   | 130   | 130   | 130   | 130   | 130   | 130   |       |
|     |          |                                    |                    |       | fz        | 0.007        | 0.012 | 0.018 | 0.025 | 0.03  | 0.034 | 0.043 | 0.051 | 0.06  | 0.07  | 0.079 |       |
|     |          |                                    |                    |       | RPM       | 25465        | 17507 | 11671 | 8754  | 8276  | 6897  | 5173  | 4138  | 3448  | 2586  | 2069  |       |
|     |          |                                    |                    |       | FEED      | 713          | 840   | 840   | 875   | 993   | 938   | 890   | 844   | 828   | 724   | 654   |       |
|     | 39.1     |                                    | 0.03D              | 1.0D  | Vc        | 65           | 90    | 90    | 90    | 100   | 100   | 100   | 100   | 100   | 100   | 100   |       |
|     |          |                                    |                    |       | fz        | 0.005        | 0.009 | 0.014 | 0.019 | 0.023 | 0.026 | 0.033 | 0.038 | 0.045 | 0.053 | 0.059 |       |
|     |          |                                    |                    |       | RPM       | 20690        | 14324 | 9549  | 7162  | 6366  | 5305  | 3979  | 3183  | 2653  | 1989  | 1592  |       |
|     |          |                                    |                    |       | FEED      | 414          | 516   | 535   | 544   | 586   | 552   | 525   | 484   | 478   | 422   | 376   |       |
|     | 39.2     |                                    | 0.03D              | 1.0D  | Vc        | 50           | 70    | 70    | 70    | 80    | 80    | 80    | 80    | 80    | 80    | 80    |       |
|     |          |                                    |                    |       | fz        | 0.004        | 0.007 | 0.011 | 0.015 | 0.018 | 0.021 | 0.026 | 0.03  | 0.036 | 0.042 | 0.048 |       |
|     |          |                                    |                    |       | RPM       | 15915        | 11141 | 7427  | 5570  | 5093  | 4244  | 3183  | 2546  | 2122  | 1592  | 1273  |       |
|     |          |                                    |                    |       | FEED      | 255          | 312   | 327   | 334   | 367   | 356   | 331   | 306   | 306   | 267   | 244   |       |
|     | 39.3     |                                    | 0.03D              | 1.0D  | Vc        | 40           | 60    | 60    | 60    | 70    | 70    | 70    | 70    | 70    | 70    | 70    |       |
|     |          |                                    |                    |       | fz        | 0.004        | 0.007 | 0.009 | 0.013 | 0.016 | 0.018 | 0.022 | 0.025 | 0.03  | 0.036 | 0.041 |       |
|     |          |                                    |                    |       | RPM       | 12732        | 9549  | 6366  | 4775  | 4456  | 3714  | 2785  | 2228  | 1857  | 1393  | 1114  |       |
|     |          |                                    |                    |       | FEED      | 204          | 267   | 229   | 248   | 285   | 267   | 245   | 223   | 223   | 201   | 183   |       |
|     | 40       |                                    | Chilled Cast Iron  | 0.03D | 1.0D      | Vc           | 120   | 165   | 165   | 165   | 195   | 195   | 195   | 195   | 200   | 195   | 195   |
|     |          |                                    |                    |       |           | fz           | 0.007 | 0.012 | 0.018 | 0.025 | 0.03  | 0.034 | 0.043 | 0.051 | 0.06  | 0.071 | 0.078 |
|     |          |                                    |                    |       |           | RPM          | 38197 | 26261 | 17507 | 13130 | 12414 | 10345 | 7759  | 6207  | 5305  | 3879  | 3104  |
|     |          |                                    |                    |       |           | FEED         | 1070  | 1261  | 1261  | 1313  | 1490  | 1407  | 1335  | 1266  | 1273  | 1102  | 968   |
|     | 41       |                                    | Hardened Cast Iron | 0.03D | 1.0D      | Vc           | 80    | 110   | 110   | 110   | 130   | 130   | 130   | 130   | 130   | 130   | 130   |
|     |          |                                    |                    |       |           | fz           | 0.007 | 0.012 | 0.018 | 0.025 | 0.03  | 0.034 | 0.043 | 0.051 | 0.06  | 0.07  | 0.079 |
|     |          |                                    |                    |       |           | RPM          | 25465 | 17507 | 11671 | 8754  | 8276  | 6897  | 5173  | 4138  | 3448  | 2586  | 2069  |
|     |          |                                    |                    |       |           | FEED         | 713   | 840   | 840   | 875   | 993   | 938   | 890   | 844   | 828   | 724   | 654   |

