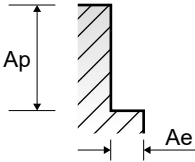


G8A39 SERIES **6 FLUTE - SIDE CUTTING**

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						6.0	8.0	10.0	12.0	16.0	20.0	
P	5	Non-alloy steel	0.05D	1.0D	Vc	120	121	121	122	121	121	
					fz	0.039	0.052	0.063	0.07	0.09	0.079	
					RPM	6366	4814	3852	3236	2407	1926	
					FEED	1490	1502	1456	1359	1300	913	
	8-9	Low alloy steel	0.05D	1.0D	Vc	120	121	121	122	121	121	
					fz	0.039	0.052	0.063	0.07	0.09	0.079	
					RPM	6366	4814	3852	3236	2407	1926	
					FEED	1490	1502	1456	1359	1300	913	
	11.1	High alloyed steel, and tool steel	0.05D	1.0D	Vc	120	121	121	122	121	121	
					fz	0.039	0.052	0.063	0.07	0.09	0.079	
					RPM	6366	4814	3852	3236	2407	1926	
					FEED	1490	1502	1456	1359	1300	913	
	11.2		0.05D	1.0D	Vc	106	108	106	106	108	110	
					fz	0.036	0.049	0.058	0.065	0.083	0.095	
					RPM	5623	4297	3374	2812	2149	1751	
					FEED	1215	1263	1174	1097	1070	998	
H	38.1	Hardened steel	0.05D	1.0D	Vc	106	108	106	106	108	110	
					fz	0.036	0.049	0.058	0.065	0.083	0.095	
					RPM	5623	4297	3374	2812	2149	1751	
					FEED	1215	1263	1174	1097	1070	998	
	38.2		0.05D	1.0D	Vc	95	97	94	95	97	98	
					fz	0.035	0.046	0.055	0.062	0.079	0.091	
					RPM	5040	3860	2992	2520	1930	1560	
					FEED	1058	1065	987	937	915	852	
	39.1		0.03D	1.0D	Vc	83	83	82	83	83	87	
					fz	0.033	0.044	0.053	0.059	0.076	0.072	
					RPM	4403	3302	2610	2202	1651	1385	
					FEED	872	872	830	780	753	598	
	39.2		0.03D	1.0D	Vc	72	72	72	72	72	75	
					fz	0.031	0.042	0.05	0.056	0.072	0.069	
					RPM	3820	2865	2292	1910	1432	1194	
					FEED	711	722	688	642	619	494	
	39.3		0.03D	1.0D	Vc	48	48	49	50	48	45	
					fz	0.028	0.037	0.045	0.05	0.064	0.071	
					RPM	2546	1910	1560	1326	955	716	
					FEED	428	424	421	398	367	305	
	40		Chilled Cast Iron	0.05D	1.0D	Vc	106	108	106	106	108	110
						fz	0.036	0.049	0.058	0.065	0.083	0.095
						RPM	5623	4297	3374	2812	2149	1751
						FEED	1215	1263	1174	1097	1070	998
	41		Hardened Cast Iron	0.05D	1.0D	Vc	95	97	94	95	97	98
						fz	0.035	0.046	0.055	0.062	0.079	0.091
						RPM	5040	3860	2992	2520	1930	1560
						FEED	1058	1065	987	937	915	852



HSS

CBN
END MILLS

i-Xmill
END MILLS

i-SMART
MODULAR
END MILLS

X5070
END MILLS

4G MILL
END MILLS

X-POWER
PRO
END MILLS

TitaNox-
POWER
END MILLS

JET-POWER
END MILLS

V7 PLUS
END MILLS

ALU-POWER
HPC
END MILLS

ALU-
POWER
END MILLS

D-POWER
GRAPHITE
END MILLS

CRX S
END MILLS

K-2
END MILLS

ONLY ONE
COATED PM60
END MILLS

TANK-
POWER
END MILLS

GENERAL
HSS
END MILLS

MILLING
CUTTERS

TECHNICAL
DATA