

**4G MILL
END MILLS**

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

**G9D75
G9D67**

**G9D76
G9D68**

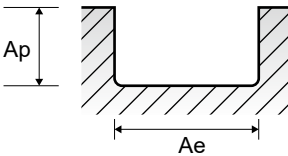
**G9D77
G9D69**

4&5 FLUTE CORNER RADIUS ROUGHING

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

SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
	4-5	Non-alloy steel	1.0D	0.8D	FEED	1528	1647	1633	1528	1500	1325
					Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
	6	Low alloy steel	1.0D	1.0D	RPM	10610	8157	6366	5438	4078	3183
					FEED	1103	1175	1171	1153	1040	891
	7-9	Low alloy steel	1.0D	0.8D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
	10	High alloyed steel, and tool steel	1.0D	1.0D	FEED	1528	1647	1633	1528	1500	1325
					Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
	11.1	High alloyed steel, and tool steel	1.0D	0.8D	RPM	10610	8157	6366	5438	4078	3183
					FEED	1103	1175	1171	1153	1040	891
	K 15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325



SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
	4-5	Non-alloy steel	0.35D	1.0D	FEED	2610	2722	2712	2546	2447	2125
					Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
	6	Low alloy steel	0.5D	1.0D	RPM	14324	10743	8435	7162	5371	4297
					FEED	1833	1977	1923	1862	1746	1504
	7-9	Low alloy steel	0.35D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
	10	High alloyed steel, and tool steel	0.5D	1.0D	FEED	2610	2722	2712	2546	2447	2125
					Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
	11.1	High alloyed steel, and tool steel	0.35D	1.0D	RPM	14324	10743	8435	7162	5371	4297
					FEED	1833	1977	1923	1862	1746	1504
	K 15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125

