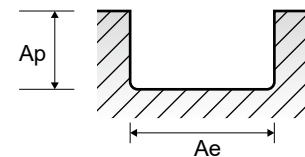


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**
G8A50 SERIES

2 FLUTE CORNER RADIUS - SLOTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.5	2.0	
P	5	Non-alloy steel	1.0D	0.05D	Vc	45	65	80	95	125	150	160	175	210	
					fz	0.002	0.002	0.004	0.005	0.006	0.008	0.009	0.011	0.013	
					RPM	47746	51725	50930	50399	49736	47746	42441	37136	33423	
					FEED	191	207	407	504	597	764	764	817	869	
	8-9	Low alloy steel	1.0D	0.05D	Vc	45	65	80	95	125	150	160	175	210	
					fz	0.002	0.002	0.004	0.005	0.006	0.008	0.009	0.011	0.013	
					RPM	47746	51725	50930	50399	49736	47746	42441	37136	33423	
					FEED	191	207	407	504	597	764	764	817	869	
	11.1	High alloyed steel, and tool steel	1.0D	0.05D	Vc	45	65	80	95	125	150	160	175	210	
					fz	0.002	0.002	0.004	0.005	0.006	0.008	0.009	0.011	0.013	
					RPM	47746	51725	50930	50399	49736	47746	42441	37136	33423	
					FEED	191	207	407	504	597	764	764	817	869	
11.2	1.0D		0.05D	Vc	40	55	70	85	100	120	130	145	165		
				fz	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013		
				RPM	42441	43768	44563	45094	39789	38197	34484	30770	26261		
				FEED	170	175	267	361	477	611	621	677	683		
H	38.1	Hardened steel	1.0D	0.05D	Vc	40	55	70	85	100	120	130	145	165	
					fz	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013	
					RPM	42441	43768	44563	45094	39789	38197	34484	30770	26261	
					FEED	170	175	267	361	477	611	621	677	683	
	38.2		1.0D	0.05D	Vc	40	50	65	75	75	80	85	100	110	
					fz	0.001	0.002	0.003	0.004	0.005	0.007	0.008	0.01	0.012	
					RPM	42441	39789	41380	39789	29842	25465	22547	21221	17507	
					FEED	85	159	248	318	298	357	361	424	420	
	39.1		1.0D	0.02D	Vc	30	40	50	55	65	65	75	80	90	
					fz	0.001	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.009	
					RPM	31831	31831	31831	29178	25863	20690	19894	16977	14324	
					FEED	64	64	127	175	207	207	239	238	258	
	39.2		1.0D	0.02D	Vc	25	30	40	45	50	50	55	60	70	
					fz	0.001	0.001	0.002	0.002	0.003	0.004	0.005	0.006	0.007	
					RPM	26526	23873	25465	23873	19894	15915	14589	12732	11141	
					FEED	53	48	102	95	119	127	146	153	156	
	40		Chilled Cast Iron	1.0D	0.05D	Vc	40	55	70	85	100	120	130	145	165
						fz	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
						RPM	42441	43768	44563	45094	39789	38197	34484	30770	26261
						FEED	170	175	267	361	477	611	621	677	683
	41		Hardened Cast Iron	1.0D	0.05D	Vc	40	50	65	75	75	80	85	100	110
						fz	0.001	0.002	0.003	0.004	0.005	0.007	0.008	0.01	0.012
						RPM	42441	39789	41380	39789	29842	25465	22547	21221	17507
						FEED	85	159	248	318	298	357	361	424	420



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