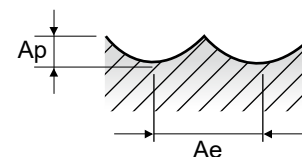


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER**
G8D62 SERIES

4 FLUTE BALL NOSE

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	5	Non-alloy steel	0.05D	0.02D	Vc	340	340	340	340	340	340	340	340	340
					fz	0.071	0.08	0.09	0.101	0.116	0.128	0.145	0.144	0.144
					RPM	36075	27056	21645	18038	13528	10823	9019	6764	5411
					FEED	10245	8658	7792	7287	6277	5541	5231	3896	3117
	8-9	Low alloy steel	0.05D	0.02D	Vc	340	340	340	340	340	340	340	340	340
					fz	0.071	0.08	0.09	0.101	0.116	0.128	0.145	0.144	0.144
					RPM	36075	27056	21645	18038	13528	10823	9019	6764	5411
					FEED	10245	8658	7792	7287	6277	5541	5231	3896	3117
	11.1 - 11.2	High alloyed steel, and tool steel	0.05D	0.02D	Vc	340	340	340	340	340	340	340	340	340
					fz	0.071	0.08	0.09	0.101	0.116	0.128	0.145	0.144	0.144
					RPM	36075	27056	21645	18038	13528	10823	9019	6764	5411
					FEED	10245	8658	7792	7287	6277	5541	5231	3896	3117
H	38.1 - 38.2	Hardened steel	0.05D	0.02D	Vc	285	285	280	285	285	285	285	285	285
					fz	0.06	0.07	0.081	0.092	0.103	0.111	0.125	0.129	0.126
					RPM	30239	22680	17825	15120	11340	9072	7560	5670	4536
					FEED	7257	6350	5775	5564	4672	4028	3780	2926	2286
	39.1		0.05D	0.02D	Vc	230	230	230	230	230	230	230	230	230
					fz	0.05	0.06	0.071	0.082	0.096	0.104	0.115	0.119	0.119
					RPM	24404	18303	14642	12202	9151	7321	6101	4576	3661
					FEED	4881	4393	4158	4002	3514	3046	2806	2178	1743
	39.2		0.05D	0.02D	Vc	210	210	210	210	210	210	210	210	205
					fz	0.045	0.055	0.067	0.077	0.089	0.095	0.097	0.096	0.096
					RPM	22282	16711	13369	11141	8356	6685	5570	4178	3263
					FEED	4011	3676	3583	3431	2975	2540	2161	1604	1253
	39.3		0.05D	0.02D	Vc	145	145	145	145	145	145	145	145	140
					fz	0.04	0.05	0.062	0.072	0.082	0.096	0.094	0.096	0.097
					RPM	15385	11539	9231	7692	5769	4615	3846	2885	2228
					FEED	2462	2308	2289	2215	1892	1772	1446	1108	864
	40	Chilled Cast Iron	0.05D	0.02D	Vc	340	340	340	340	340	340	340	340	340
					fz	0.071	0.08	0.09	0.101	0.116	0.128	0.145	0.144	0.144
					RPM	36075	27056	21645	18038	13528	10823	9019	6764	5411
					FEED	10245	8658	7792	7287	6277	5541	5231	3896	3117
	41	Hardened Cast Iron	0.05D	0.02D	Vc	285	285	280	285	285	285	285	285	285
					fz	0.06	0.07	0.081	0.092	0.103	0.111	0.125	0.129	0.126
					RPM	30239	22680	17825	15120	11340	9072	7560	5670	4536
					FEED	7257	6350	5775	5564	4672	4028	3780	2926	2286



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