

X-POWER PRO END MILLS

RECOMMENDED CUTTING CONDITIONS

GM839 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						2.0	3.0	4.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	0.05D	1.0D	SFM(Vc)	310	360	410	460	460	445	445
					IPT(fz)	.0002	.0004	.0007	.0012	.0017	.0018	.0019
					RPM	15040	11640	9950	7440	5580	4320	3600
					IPM(FEED)	14	17	30	35	37	32	27
	5	Non-alloy steel	0.05D	1.0D	SFM(Vc)	215	230	245	280	280	280	280
					IPT(fz)	.0002	.0004	.0008	.0012	.0015	.0014	.0014
					RPM	10430	7440	5940	4530	3400	2720	2260
					IPM(FEED)	10	11	18	21	20	16	13
	6-7	Low alloy steel	0.05D	1.0D	SFM(Vc)	310	360	410	460	460	445	445
					IPT(fz)	.0002	.0004	.0007	.0012	.0017	.0018	.0019
					RPM	15040	11640	9950	7440	5580	4320	3600
					IPM(FEED)	14	17	30	35	37	32	27
8-9	Low alloy steel	0.05D	1.0D	SFM(Vc)	215	230	245	280	280	280	280	
				IPT(fz)	.0002	.0004	.0008	.0012	.0015	.0014	.0014	
				RPM	10430	7440	5940	4530	3400	2720	2260	
				IPM(FEED)	10	11	18	21	20	16	13	
10	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	310	360	410	460	460	445	445	
				IPT(fz)	.0002	.0004	.0007	.0012	.0017	.0018	.0019	
				RPM	15040	11640	9950	7440	5580	4320	3600	
				IPM(FEED)	14	17	30	35	37	32	27	
11.1 - 11.2	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	215	230	245	280	280	280	280	
				IPT(fz)	.0002	.0004	.0008	.0012	.0015	.0014	.0014	
				RPM	10430	7440	5940	4530	3400	2720	2260	
				IPM(FEED)	10	11	18	21	20	16	13	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1.0D	SFM(Vc)	310	360	410	460	460	445	445
					IPT(fz)	.0002	.0004	.0007	.0012	.0017	.0018	.0019
					RPM	15040	11640	9950	7440	5580	4320	3600
					IPM(FEED)	14	17	30	35	37	32	27
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	SFM(Vc)	130	130	165	165	180	180	195
					IPT(fz)	.0001	.0002	.0002	.0004	.0006	.0007	.0007
					RPM	6310	4210	4000	2670	2180	1750	1580
					IPM(FEED)	2	3	3	4	6	5	4
	40	Chilled Cast Iron	0.05D	1.0D	SFM(Vc)	215	230	245	280	280	280	280
					IPT(fz)	.0002	.0004	.0008	.0012	.0015	.0014	.0014
					RPM	10430	7440	5940	4530	3400	2720	2260
					IPM(FEED)	10	11	18	21	20	16	13
	41	Hardened Cast Iron	0.05D	1.0D	SFM(Vc)	130	130	165	165	180	180	195
					IPT(fz)	.0001	.0002	.0002	.0004	.0006	.0007	.0007
					RPM	6310	4210	4000	2670	2180	1750	1580
					IPM(FEED)	2	3	3	4	6	5	4

SFM = Surface Feet per Minute
 RPM = Revolutions Per Minute
 IPT = Inches Per Tooth
 IPM = Inches Per Minute
 Ap : Inch (Axial Depth of Cut)
 Ae : Inch (Radial Depth of Cut)

