

GM818 SERIES 2 FLUTE CORNER RADIUS - **SLOTING**

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	1.0D	0.3D	SFM(Vc)	245	260	260	280	280	280
					IPT(fz)	.0006	.0009	.0013	.0018	.0021	.0020
					RPM	5940	5050	4210	3400	2720	2260
					IPM(FEED)	8	9	11	12	11	9
	5	Non-alloy steel	1.0D	0.3D	SFM(Vc)	150	165	165	180	180	195
					IPT(fz)	.0005	.0007	.0010	.0013	.0015	.0016
					RPM	3640	3200	2670	2180	1750	1580
					IPM(FEED)	4	4	5	6	5	5
	6-7	Low alloy steel	1.0D	0.3D	SFM(Vc)	245	260	260	280	280	280
					IPT(fz)	.0006	.0009	.0013	.0018	.0021	.0020
					RPM	5940	5050	4210	3400	2720	2260
					IPM(FEED)	8	9	11	12	11	9
8-9	Low alloy steel	1.0D	0.3D	SFM(Vc)	150	165	165	180	180	195	
				IPT(fz)	.0005	.0007	.0010	.0013	.0015	.0016	
				RPM	3640	3200	2670	2180	1750	1580	
				IPM(FEED)	4	4	5	6	5	5	
10	High alloyed steel, and tool steel	1.0D	0.3D	SFM(Vc)	245	260	260	280	280	280	
				IPT(fz)	.0006	.0009	.0013	.0018	.0021	.0020	
				RPM	5940	5050	4210	3400	2720	2260	
				IPM(FEED)	8	9	11	12	11	9	
11.1 - 11.2	High alloyed steel, and tool steel	1.0D	0.3D	SFM(Vc)	150	165	165	180	180	195	
				IPT(fz)	.0005	.0007	.0010	.0013	.0015	.0016	
				RPM	3640	3200	2670	2180	1750	1580	
				IPM(FEED)	4	4	5	6	5	5	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.3D	SFM(Vc)	245	260	260	280	280	280
					IPT(fz)	.0006	.0009	.0013	.0018	.0021	.0020
					RPM	5940	5050	4210	3400	2720	2260
					IPM(FEED)	8	9	11	12	11	9
H	38.1 - 38.2	Hardened steel	1.0D	0.3D	SFM(Vc)	100	115	115	115	115	115
					IPT(fz)	.0002	.0003	.0004	.0005	.0006	.0008
					RPM	2430	2230	1860	1400	1120	930
					IPM(FEED)	1	1	2	1	1	1
	40	Chilled Cast Iron	1.0D	0.3D	SFM(Vc)	150	165	165	180	180	195
					IPT(fz)	.0005	.0007	.0010	.0013	.0015	.0016
					RPM	3640	3200	2670	2180	1750	1580
					IPM(FEED)	4	4	5	6	5	5
	41	Hardened Cast Iron	1.0D	0.3D	SFM(Vc)	100	115	115	115	115	115
					IPT(fz)	.0002	.0003	.0004	.0005	.0006	.0008
					RPM	2430	2230	1860	1400	1120	930
					IPM(FEED)	1	1	2	1	1	1

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)

