



# 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### G907, G928, G908, G929, G909, G930 SERIES

#### 4&5FLUTE MULTIPLE HELIX CORNER RADIUS - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-2	Non-alloy steel	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760
					IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032
					RPM	12000	9000	7200	6000	4500	3600	2900
					IPM(FEED)	61	65	65	61	59	52	46
	3-5	Non-alloy steel	1.0D	0.8D	SFM(Vc)	695	665	630	705	670	630	680
					IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025
					RPM	10600	8100	6400	5400	4100	3200	2600
					IPM(FEED)	43	47	47	45	41	35	33
	6	Low alloy steel	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760
					IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032
					RPM	12000	9000	7200	6000	4500	3600	2900
					IPM(FEED)	61	65	65	61	59	52	46
7-9	Low alloy steel	1.0D	0.8D	SFM(Vc)	695	665	630	705	670	630	680	
				IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025	
				RPM	10600	8100	6400	5400	4100	3200	2600	
				IPM(FEED)	43	47	47	45	41	35	33	
10	High alloyed steel, and tool steel	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760	
				IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032	
				RPM	12000	9000	7200	6000	4500	3600	2900	
				IPM(FEED)	61	65	65	61	59	52	46	
11.1-11.2	High alloyed steel, and tool steel	1.0D	0.8D	SFM(Vc)	695	665	630	705	670	630	680	
				IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025	
				RPM	10600	8100	6400	5400	4100	3200	2600	
				IPM(FEED)	43	47	47	45	41	35	33	
K	15	Grey cast iron	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760
					IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032
					RPM	12000	9000	7200	6000	4500	3600	2900
					IPM(FEED)	61	65	65	61	59	52	46
	16	Grey cast iron	1.0D	1.0D	SFM(Vc)	695	665	630	705	670	630	680
					IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025
					RPM	10600	8100	6400	5400	4100	3200	2600
					IPM(FEED)	43	47	47	45	41	35	33
	17	Nodular cast iron	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760
					IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032
					RPM	12000	9000	7200	6000	4500	3600	2900
					IPM(FEED)	61	65	65	61	59	52	46
18	Nodular cast iron	1.0D	1.0D	SFM(Vc)	695	665	630	705	670	630	680	
				IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025	
				RPM	10600	8100	6400	5400	4100	3200	2600	
				IPM(FEED)	43	47	47	45	41	35	33	
19-20	Malleable cast iron	1.0D	1.0D	SFM(Vc)	785	735	705	785	735	705	760	
				IPT(fz)	.0013	.0018	.0023	.0025	.0026	.0029	.0032	
				RPM	12000	9000	7200	6000	4500	3600	2900	
				IPM(FEED)	61	65	65	61	59	52	46	
H	40		1.0D	0.8D	SFM(Vc)	695	665	630	705	670	630	680
					IPT(fz)	.0010	.0014	.0018	.0021	.0020	.0022	.0025
					RPM	10600	8100	6400	5400	4100	3200	2600
					IPM(FEED)	43	47	47	45	41	35	33

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)

