

YG 4G MILL END MILLS

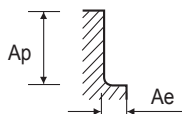
RECOMMENDED CUTTING CONDITIONS

GAE53 SERIES

4&5 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						6	8	10	12	14	16	18	20						
P	1	Non-alloy steel	0.5D	1.5D	SFM(Vc)	200	225	220	225	225	230	225	225						
					IPT(fz)	.0007	.0011	.0020	.0024	.0022	.0024	.0028	.0032						
					RPM	3250	2750	2150	1800	1550	1400	1200	1100						
	2		0.5D	1.5D	SFM(Vc)	155	175	175	175	175	180	185	175						
					IPT(fz)	.0007	.0011	.0019	.0025	.0023	.0025	.0028	.0032						
					RPM	2500	2150	1700	1400	1200	1100	1000	850						
	3-4		0.5D	1.5D	SFM(Vc)	110	130	125	125	125	125	130	125						
					IPT(fz)	.0007	.0011	.0017	.0024	.0022	.0025	.0027	.0031						
					RPM	1800	1550	1200	1000	850	750	700	600						
	5		0.5D	1.5D	SFM(Vc)	95	100	105	105	100	100	100	105						
					IPT(fz)	.0007	.0011	.0017	.0022	.0021	.0025	.0027	.0030						
RPM		1500			1200	1000	850	700	600	550	500								
6	0.5D	1.5D	SFM(Vc)	155	175	175	175	175	180	185	175								
			IPT(fz)	.0007	.0011	.0019	.0025	.0023	.0025	.0028	.0032								
			RPM	2500	2150	1700	1400	1200	1100	1000	850								
7	0.5D	1.5D	SFM(Vc)	110	130	125	125	125	125	130	125								
			IPT(fz)	.0007	.0011	.0017	.0024	.0022	.0025	.0027	.0031								
			RPM	1800	1550	1200	1000	850	750	700	600								
8-9	0.5D	1.5D	SFM(Vc)	95	100	105	105	100	100	100	105								
			IPT(fz)	.0007	.0011	.0017	.0022	.0021	.0025	.0027	.0030								
			RPM	1500	1200	1000	850	700	600	550	500								
10	0.5D	1.5D	SFM(Vc)	155	175	175	175	175	180	185	175								
			IPT(fz)	.0007	.0011	.0019	.0025	.0023	.0025	.0028	.0032								
			RPM	2500	2150	1700	1400	1200	1100	1000	850								
11.1	0.5D	1.5D	SFM(Vc)	95	100	105	105	100	100	100	105								
			IPT(fz)	.0007	.0011	.0017	.0022	.0021	.0025	.0027	.0030								
			RPM	1500	1200	1000	850	700	600	550	500								
M	14.1-14.2	Stainless steel	0.5D	1.5D	SFM(Vc)	110	120	120	115	125	115	120	125						
					IPT(fz)	.0007	.0012	.0017	.0025	.0023	.0028	.0030	.0032						
					RPM	1750	1450	1150	950	850	700	650	600						
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.5D	SFM(Vc)	155	175	175	175	175	180	185	175						
					IPT(fz)	.0007	.0011	.0019	.0025	.0023	.0025	.0028	.0032						
					RPM	2500	2150	1700	1400	1200	1100	1000	850						

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)



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 A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA