

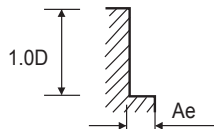
RECOMMENDED CUTTING CONDITIONS

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

4&5FLUTE MULTIPLE HELIX CORNER RADIUS - SIDE CUTTING

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	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995
					IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040
					RPM	15800	11900	9500	8000	6000	4800	3800
					IPM(FEED)	101	106	106	101	97	84	75
	3-5	0.35D	1.0D	SFM(Vc)	935	875	835	930	885	845	890	
				IPT(fz)	.0013	.0018	.0023	.0026	.0026	.0028	.0029	
				RPM	14300	10700	8500	7100	5400	4300	3400	
				IPM(FEED)	73	77	77	73	70	59	49	
	6	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995	
				IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040	
				RPM	15800	11900	9500	8000	6000	4800	3800	
				IPM(FEED)	101	106	106	101	97	84	75	
7-9	0.35D	1.0D	SFM(Vc)	935	875	835	930	885	845	890		
			IPT(fz)	.0013	.0018	.0023	.0026	.0026	.0028	.0029		
			RPM	14300	10700	8500	7100	5400	4300	3400		
			IPM(FEED)	73	77	77	73	70	59	49		
10	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995		
			IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040		
			RPM	15800	11900	9500	8000	6000	4800	3800		
			IPM(FEED)	101	106	106	101	97	84	75		
11.1-11.2	0.35D	1.0D	SFM(Vc)	935	875	835	930	885	845	890		
			IPT(fz)	.0013	.0018	.0023	.0026	.0026	.0028	.0029		
			RPM	14300	10700	8500	7100	5400	4300	3400		
			IPM(FEED)	73	77	77	73	70	59	49		
K	15	Grey cast iron	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995
					IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040
					RPM	15800	11900	9500	8000	6000	4800	3800
					IPM(FEED)	101	106	106	101	97	84	75
	16	0.35D	1.0D	SFM(Vc)	935	875	835	930	885	845	890	
				IPT(fz)	.0013	.0018	.0023	.0026	.0026	.0028	.0029	
				RPM	14300	10700	8500	7100	5400	4300	3400	
				IPM(FEED)	73	77	77	73	70	59	49	
	17	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995	
				IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040	
				RPM	15800	11900	9500	8000	6000	4800	3800	
				IPM(FEED)	101	106	106	101	97	84	75	
18	0.35D	1.0D	SFM(Vc)	935	875	835	930	885	845	890		
			IPT(fz)	.0013	.0018	.0023	.0026	.0026	.0028	.0029		
			RPM	14300	10700	8500	7100	5400	4300	3400		
			IPM(FEED)	73	77	77	73	70	59	49		
19-20	0.5D	1.0D	SFM(Vc)	1035	975	935	1045	980	940	995		
			IPT(fz)	.0016	.0022	.0028	.0032	.0032	.0035	.0040		
			RPM	15800	11900	9500	8000	6000	4800	3800		
			IPM(FEED)	101	106	106	101	97	84	75		

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