



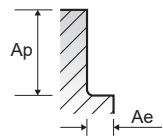
RECOMMENDED CUTTING CONDITIONS

G826 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

HIGH SPEED

ISO	VDI 3323	Material Description	HRc	Ae	Ap	Parameter	Diameter (Ø)					
							1/8	3/16	1/4	5/16	3/8	1/2
P	5	Non-alloy steel	32	0.3D	0.1R	SFM (vc)	685	810	820	820	835	850
						IPT (fz)	.0071	.0109	.0144	.0180	.0212	.0277
						RPM	21000	16500	12500	10000	8500	6500
						IPM (feed)	600	720	720	720	720	720
	8-9	Low alloy steel	32-38	0.3D	0.1R	SFM (vc)	685	810	820	820	835	850
						IPT (fz)	.0071	.0109	.0144	.0180	.0212	.0277
						RPM	21000	16500	12500	10000	8500	6500
						IPM (feed)	600	720	720	720	720	720
	11.1	High alloyed steel, and tool steel	35	0.3D	0.1R	SFM (vc)	685	810	820	820	835	850
						IPT (fz)	.0071	.0109	.0144	.0180	.0212	.0277
						RPM	21000	16500	12500	10000	8500	6500
						IPM (feed)	600	720	720	720	720	720
11.2	High alloyed steel, and tool steel	44	0.3D	0.1R	SFM (vc)	525	665	655	655	660	655	
					IPT (fz)	.0059	.0102	.0138	.0172	.0205	.0275	
					RPM	16000	13500	10000	8000	6700	5000	
					IPM (feed)	380	550	550	550	550	550	
H	38.1	Hardened steel	45-49	0.3D	0.1R	SFM (vc)	525	665	655	655	660	655
						IPT (fz)	.0059	.0102	.0138	.0172	.0205	.0275
						RPM	16000	13500	10000	8000	6700	5000
						IPM (feed)	380	550	550	550	550	550
	38.2	Hardened steel	50-55	0.3D	0.1R	SFM (vc)	395	565	555	555	560	565
						IPT (fz)	.0063	.0091	.0124	.0154	.0184	.0244
						RPM	12000	11500	8500	6800	5700	4300
						IPM (feed)	300	420	420	420	420	420
	39.1	Hardened steel	56-60	0.3D	0.05R	SFM (vc)	295	395	395	395	395	395
						IPT (fz)	.0047	.0078	.0104	.0130	.0156	.0208
						RPM	9000	8000	6000	4800	4000	3000
						IPM (feed)	170	250	250	250	250	250
	39.2	Hardened steel	61-65	0.3D	0.05R	SFM (vc)	215	280	280	280	280	280
						IPT (fz)	.0035	.0066	.0087	.0110	.0132	.0174
						RPM	6500	5700	4300	3400	2850	2150
						IPM (feed)	92	150	150	150	150	150
	40	Chilled Cast Iron	42	0.3D	0.1R	SFM (vc)	525	665	655	655	660	655
						IPT (fz)	.0059	.0102	.0138	.0172	.0205	.0275
						RPM	16000	13500	10000	8000	6700	5000
						IPM (feed)	380	550	550	550	550	550
	41	Hardened Cast Iron	55	0.3D	0.1R	SFM (vc)	395	565	555	555	560	565
						IPT (fz)	.0063	.0091	.0124	.0154	.0184	.0244
						RPM	12000	11500	8500	6800	5700	4300
						IPM (feed)	300	420	420	420	420	420

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)





**X5070
END MILLS**

RECOMMENDED CUTTING CONDITIONS

G826 SERIES

4 FLUTE CORNER RADIUS - SIDE CUTTING

NORMAL SPEED

ISO	VDI 3323	Material Description	HRc	Ae	Ap	Parameter	Diameter (Ø)					
							1/8	3/16	1/4	5/16	3/8	1/2
P	5	Non-alloy steel	32	0.5D	0.2R	SFM (vc)	295	370	360	370	375	365
						IPT (fz)	.0068	.0103	.0141	.0172	.0204	.0277
						RPM	9000	7500	5500	4500	3800	2800
						IPM (feed)	245	310	310	310	310	310
	8-9	Low alloy steel	32-38	0.5D	0.2R	SFM (vc)	295	370	360	370	375	365
						IPT (fz)	.0068	.0103	.0141	.0172	.0204	.0277
						RPM	9000	7500	5500	4500	3800	2800
						IPM (feed)	245	310	310	310	310	310
	11.1	Highalloyed steel, and tool steel	35	0.5D	0.2R	SFM (vc)	295	370	360	370	375	365
						IPT (fz)	.0068	.0103	.0141	.0172	.0204	.0277
						RPM	9000	7500	5500	4500	3800	2800
						IPM (feed)	245	310	310	310	310	310
11.2	Highalloyed steel, and tool steel	44	0.5D	0.2R	SFM (vc)	215	250	255	255	255	255	
					IPT (fz)	.0060	.0098	.0128	.0161	.0192	.0256	
					RPM	6500	5100	3900	3100	2600	1950	
					IPM (feed)	155	200	200	200	200	200	
H	38.1	Hardened steel	45-49	0.5D	0.2R	SFM (vc)	215	250	255	255	255	255
						IPT (fz)	.0060	.0098	.0128	.0161	.0192	.0256
						RPM	6500	5100	3900	3100	2600	1950
						IPM (feed)	155	200	200	200	200	200
	38.2	Hardened steel	50-55	0.5D	0.2R	SFM (vc)	140	185	185	180	180	185
						IPT (fz)	.0058	.0092	.0125	.0159	.0189	.0250
						RPM	4300	3800	2800	2200	1850	1400
						IPM (feed)	100	140	140	140	140	140
	39.1	Hardened steel	56-60	0.5D	0.1R	SFM (vc)	90	115	115	115	115	115
						IPT (fz)	.0040	.0074	.0100	.0125	.0150	.0199
						RPM	2700	2350	1750	1400	1170	880
						IPM (feed)	43	70	70	70	70	70
39.2	Hardened steel	61-65	0.5D	0.1R	SFM (vc)	60	80	80	80	80	80	
					IPT (fz)	.0032	.0045	.0060	.0075	.0089	.0119	
					RPM	1800	1650	1250	1000	840	630	
					IPM (feed)	23	30	30	30	30	30	
40	Chilled Cast Iron	42	0.5D	0.2R	SFM (vc)	215	250	255	255	255	255	
					IPT (fz)	.0060	.0098	.0128	.0161	.0192	.0256	
					RPM	6500	5100	3900	3100	2600	1950	
					IPM (feed)	155	200	200	200	200	200	
41	Hardened Cast Iron	55	0.5D	0.1R	SFM (vc)	140	185	185	180	180	185	
					IPT (fz)	.0058	.0092	.0125	.0159	.0189	.0250	
					RPM	4300	3800	2800	2200	1850	1400	
					IPM (feed)	100	140	140	140	140	140	

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)

