

# RECOMMENDED CUTTING CONDITIONS

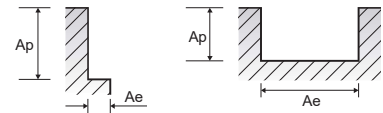
## G9J64, G9J65, G9J66, G9J67 SERIES

### 4 FLUTE MULTIFLUX HELIX

Vc = (m/min.)  
 fz = (mm/tooth)  
 RPM = (rev/min.)  
 FEED = (mm/min.)

ISO	VDI 3323	Material Description	SIDE CUTTING		SLOTTING		Parameter	Diameter (Ø)														
			Ae	Ap	Ae	Ap		3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0						
								Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM
P	1-4	Non-alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	106	106	106	106	106	118	118	118	118	118	118	118	118	118	118
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	0.065	0.065	0.065	0.065	0.065	0.065
	5	Non-alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	75	75	75	75	75	82	82	82	82	82	82	82	82	82	82
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	0.065	0.065	0.065	0.065	0.065	0.065
	6-7	Low alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	106	106	106	106	106	118	118	118	118	118	118	118	118	118	118
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	0.065	0.065	0.065	0.065	0.065	0.065
	8-9	Low alloy steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	75	75	75	75	75	82	82	82	82	82	82	82	82	82	82
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	0.065	0.065	0.065	0.065	0.065	0.065
	10-11.1	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	45	45	45	45	45	49	49	49	49	49	49	49	49	49	49
							fz	0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.037	0.045	0.045	0.045	0.045	0.045	0.045	0.045
M	12-13	Stainless steel	0.1D	1.5D (1.2D)	0.1D	0.8D	Vc	104	104	104	104	104	104	104	104	104	104	104	104	104		
							fz	0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.045	0.055	0.055	0.055	0.055	0.055	0.055	0.055
	14.1	Stainless steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	10990	8246	6594	5495	4123	3297	2751	2058	1652	1652	1652	1652	1652		
							fz	175	200	238	287	364	448	427	371	364	364	364	364	364	364	
	14.2	Stainless steel	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	74	74	74	74	74	74	74	74	74	74	74	74	74		
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.077	0.077	0.077	0.077	0.077	0.077	
K	15-16	Grey cast iron	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	78	78	78	78	78	86	86	86	86	86	86	86			
							fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.065	0.081	0.081	0.081	0.081			
	17-18	Nodular cast iron	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	8316	6237	4991	4158	3122	2744	2282	1715	1372	1372	1372				
							fz	200	249	280	333	424	525	529	445	445	445	445				
	19-20	Malleable cast iron	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	78	78	78	78	78	86	86	86	86	86	86	86			
							fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.065	0.081	0.081	0.081				
19-20	Malleable cast iron	0.3D	1.5D (1.2D)	0.1D	0.8D	Vc	8316	6237	4991	4158	3122	2744	2282	1715	1372	1372	1372					
						fz	200	249	280	333	424	525	529	445	445	445						

\*( ) : Short length



SUPER HARDENED HSS END MILL  
 COATED CARBIDE END MILL FOR GENERAL  
 COATED CARBIDE END MILL FOR HEAVY CUTTING  
 COATED CARBIDE END MILL FOR HARDENED MATERIAL  
 COATED CARBIDE DRILL FOR GENERAL