

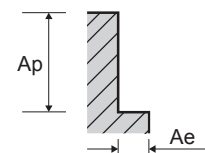
RECOMMENDED CUTTING CONDITIONS

GFJ74 SERIES

6 FLUTES - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-4	Non-alloy steel	0.05D	1.5D	Vc	123	123	121	124	123	123
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	6,500	4,900	3,850	3,300	2,450	1,950
					FEED	1,165	1,125	1,050	1,050	915	810
	5	Non-alloy steel	0.05D	1.5D	Vc	82	83	82	83	83	82
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	4,350	3,300	2,600	2,200	1,650	1,300
					FEED	790	745	705	705	610	540
	6-7	Low alloy steel	0.05D	1.5D	Vc	123	123	121	124	123	123
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	6,500	4,900	3,850	3,300	2,450	1,950
					FEED	1,165	1,125	1,050	1,050	915	810
	8-9	Low alloy steel	0.03D	1.5D	Vc	82	83	82	83	83	82
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	4,350	3,300	2,600	2,200	1,650	1,300
					FEED	790	745	705	705	610	540
	10	High alloyed steel, and tool steel	0.05D	1.5D	Vc	123	123	121	124	123	123
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	6,500	4,900	3,850	3,300	2,450	1,950
					FEED	1,165	1,125	1,050	1,050	915	810
	11.1 11.2	High alloyed steel, and tool steel	0.05D	1.5D	Vc	82	83	82	83	83	82
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	4,350	3,300	2,600	2,200	1,650	1,300
					FEED	790	745	705	705	610	540
H	38.1	Hardened steel	0.03D	1.5D	Vc	82	83	82	83	83	82
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	4,350	3,300	2,600	2,200	1,650	1,300
					FEED	790	745	705	705	610	540
	38.2 39.1	Hardened steel	0.03D	1.5D	Vc	63	63	63	62	63	63
					fz	0.023	0.029	0.033	0.040	0.047	0.053
					RPM	3,350	2,500	2,000	1,650	1,250	1,000
					FEED	460	430	400	400	350	315
	39.2	Hardened steel	0.02D	1.5D	Vc	50	50	50	49	50	50
					fz	0.019	0.023	0.027	0.032	0.038	0.044
					RPM	2,650	2,000	1,600	1,300	1,000	800
					FEED	295	275	255	250	225	210
	40	Chilled Cast Iron	0.03D	1.5D	Vc	82	83	82	83	83	82
					fz	0.030	0.038	0.045	0.053	0.062	0.069
					RPM	4,350	3,300	2,600	2,200	1,650	1,300
					FEED	790	745	705	705	610	540



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