



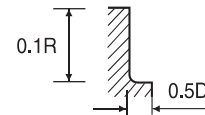
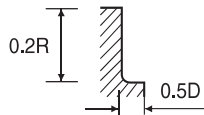
**RECOMMENDED CUTTING CONDITIONS**

**CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS HIGH FEED**

**G859, G854 SERIES**

**■ NORMAL SPEED**

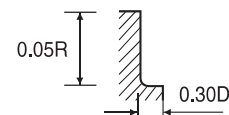
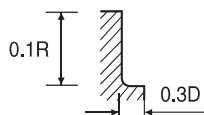
MATERIAL		HARDENED STEELS									
HARDNESS		~ HRC40		HRC40 ~ HRC50		HRC50 ~ HRC55		HRC55 ~ HRC60		HRC60 ~ HRC65	
DIAMETER		RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	× R0.5	13500	255.9	9550	149.6	5500	86.6	3200	39.4	2200	21.7
3.0	× R0.5	9550	255.9	6900	163.4	4550	108.3	2850	45.3	1900	24.0
4.0	× R0.5	7950	275.6	5750	181.1	4000	126.0	2550	53.2	1750	27.6
5.0	× R0.5	6500	287.4	4800	189.0	3400	126.0	2200	63.0	1500	27.6
6.0	× R0.5	5800	301.2	4100	192.9	2900	137.8	1850	72.8	1350	31.3
6.0	× R1.0	5800	301.2	4100	192.9	2900	137.8	1850	72.8	1350	31.3
8.0	× R1.0	4350	301.2	3050	192.9	2200	137.8	1400	72.8	995	31.3
8.0	× R2.0	4350	301.2	3050	192.9	2200	137.8	1400	72.8	995	31.3
10.0	× R1.0	3500	301.2	2450	192.9	1750	137.8	1100	72.8	795	31.3
10.0	× R2.0	3500	301.2	2450	192.9	1750	137.8	1100	72.8	795	31.3
12.0	× R2.0	2900	301.2	2050	192.9	1450	137.8	925	72.8	665	31.3
12.0	× R3.0	2900	301.2	2050	192.9	1450	137.8	925	72.8	665	31.3
16.0	× R3.0	2200	301.2	1550	192.9	1100	137.8	700	72.8	500	31.3



RPM = rev./min.  
FEED = inch/min.

**■ HIGH SPEED**

MATERIAL		HARDENED STEELS									
HARDNESS		~ HRC40		HRC40 ~ HRC50		HRC50 ~ HRC55		HRC55 ~ HRC60		HRC60 ~ HRC65	
DIAMETER		RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	× R0.5	29000	590.6	22000	385.8	15000	309.1	11000	175.2	8700	96.5
3.0	× R0.5	22000	629.9	17000	393.7	12500	315.0	9500	181.1	6900	98.4
4.0	× R0.5	17000	689.0	13000	472.4	11000	362.2	8000	216.5	5600	114.2
5.0	× R0.5	15000	708.7	11000	192.1	10000	393.7	7000	236.2	4900	122.1
6.0	× R0.5	13500	728.4	10500	543.3	9000	433.1	6400	252.0	4500	141.7
6.0	× R1.0	13500	728.4	10500	543.3	9000	433.1	6400	252.0	4500	141.7
8.0	× R1.0	10000	728.4	8000	551.2	6800	433.1	4800	263.8	3400	161.4
8.0	× R2.0	10000	728.4	8000	551.2	6800	433.1	4800	263.8	3400	161.4
10.0	× R1.0	8000	728.4	6400	551.2	5400	433.1	3800	267.7	2700	149.6
10.0	× R2.0	8000	728.4	6400	551.2	5400	433.1	3800	267.7	2700	149.6
12.0	× R2.0	6600	728.4	5300	551.2	4500	433.1	3200	275.6	2250	141.7
12.0	× R3.0	6600	728.4	5300	551.2	4500	433.1	3200	275.6	2250	141.7
16.0	× R3.0	5000	728.4	3900	551.2	3300	433.1	2400	275.6	1650	129.9



RPM = rev./min.  
FEED = inch/min.