

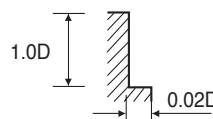
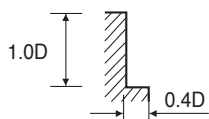
YG D-POWER CFRP END MILLS

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, MULTI FLUTE DUAL HELIX
VOLLHARTMETALL, MULTI SCHNEIDEN DOPPEL HELIX**

GUF40 SERIES

MATERIAL	CFRP				GFRP				CFRP				GFRP			
	DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc
6.0	7950	1115	150	0.035	4240	425	80	0.025	10610	1995	200	0.047	5300	740	100	0.035
8.0	5960	1610	150	0.045	3180	590	80	0.031	7950	2955	200	0.062	3970	955	100	0.040
10.0	4770	1575	150	0.055	2540	565	80	0.037	6360	2940	200	0.077	3180	860	100	0.045
12.0	3970	2065	150	0.065	2120	730	80	0.043	5300	3900	200	0.092	2650	1060	100	0.050

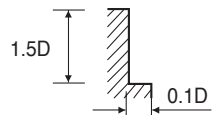
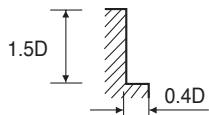


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

**CARBIDE, 4 FLUTE
VOLLHARTMETALL, 4 SCHNEIDEN**

GUF39 SERIES

MATERIAL	CFRP				GFRP				CFRP				GFRP			
	DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc
6.0	10610	1485	200	0.035	5300	530	100	0.025	10610	1190	200	0.028	5300	530	100	0.025
8.0	7950	1430	200	0.045	3970	490	100	0.031	7950	1145	200	0.036	3970	445	100	0.028
10.0	6360	1400	200	0.055	3180	470	100	0.037	6360	1120	200	0.044	3180	405	100	0.032
12.0	5300	1380	200	0.065	2650	455	100	0.043	5300	1100	200	0.052	2650	370	100	0.035



RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t