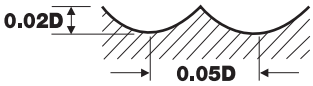
SGED28 Series

MATERIAL		WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
Dia.	Rad.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	0.5	50000	1000	155	0.010	42000	930	130	0.011	50000	750	155	0.008
2	1	47520	2068	300	0.022	24000	940	150	0.020	50000	1500	315	0.015
3	1.5	31200	1914	295	0.031	15800	870	150	0.028	47400	1800	445	0.019
4	2	22800	1936	285	0.042	11500	880	145	0.038	34500	1825	435	0.026
5	2.5	18500	1936	290	0.052	9300	880	145	0.047	28000	1825	440	0.033
6	3	15600	1892	295	0.061	7800	860	145	0.055	23500	1800	445	0.038
8	4	12000	1892	300	0.079	6000	860	150	0.072	18000	1800	450	0.050
10	5	9600	1936	300	0.101	4800	880	150	0.092	14500	1825	455	0.063
12	6	8000	1914	300	0.120	4000	870	150	0.109	12000	1825	450	0.076

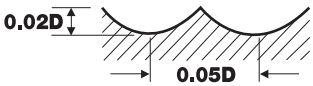


2 FLUTE BALL NOSE EXTENDED NECK

CUTTING DATA
Stepover Cutting

SGED27 Series

MATERIAL		WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
Dia.	Rad.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.5	0.25	50000	500	80	0.005	50000	500	80	0.005	50000	380	80	0.004
0.6	0.3	50000	700	95	0.007	50000	650	95	0.007	50000	450	95	0.005
0.8	0.4	50000	850	125	0.009	44000	770	110	0.009	50000	600	125	0.006
1	0.5	50000	1000	155	0.010	35000	770	110	0.011	50000	630	155	0.006
2	1	39600	1716	250	0.022	19800	780	125	0.020	50000	1250	315	0.013
3	1.5	26000	1584	245	0.030	13000	720	125	0.028	39000	1512	370	0.019
4	2	19000	1606	240	0.042	9500	730	120	0.038	28500	1533	360	0.027
5	2.5	15400	1606	240	0.052	7700	730	120	0.047	23100	1533	365	0.033
6	3	13000	1584	245	0.061	6500	720	125	0.055	19500	1512	370	0.039
8	4	10000	1584	250	0.079	5000	720	125	0.072	15000	1512	375	0.050
10	5	8000	1606	250	0.100	4000	730	125	0.091	12000	1533	375	0.064
12	6	6600	1606	250	0.122	3300	730	125	0.111	9900	1533	375	0.077



RPM: revolutions per minute **Feed:** mm per minute **Vc:** surface speed (metres per minute) **Fz:** feed per tooth