

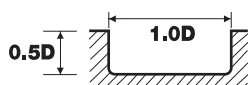


## SGED29 Series

CRX S

### Slotting

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	50000	1000	155	0.010	50000	1000	155	0.010	50000	700	155	0.007
2	50000	1800	315	0.018	50000	1700	315	0.017	50000	1400	315	0.014
3	50000	2600	470	0.026	44500	2350	420	0.026	50000	2100	470	0.021
4	50000	3680	630	0.037	33400	2100	420	0.031	50000	2600	630	0.026
5	50000	4300	785	0.043	27000	2100	425	0.039	50000	3400	785	0.034
6	44500	4670	840	0.052	22300	2100	420	0.047	50000	4200	940	0.042
8	33400	4560	840	0.068	16700	2100	420	0.063	50000	5700	1255	0.057
10	26700	4770	840	0.089	13370	2100	420	0.079	40000	5500	1255	0.069
12	22200	4660	835	0.105	11100	2100	420	0.095	33500	5600	1265	0.084

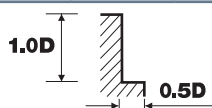


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### Side Cutting

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	50000	1400	155	0.014	50000	1200	155	0.012	50000	1200	155	0.012
2	50000	2800	315	0.028	50000	2500	315	0.025	50000	2500	315	0.025
3	50000	4200	470	0.042	50000	3700	470	0.037	50000	3700	470	0.037
4	50000	5300	630	0.053	50000	4700	630	0.047	50000	5000	630	0.050
5	50000	6500	785	0.065	40000	4800	630	0.060	50000	6500	785	0.065
6	50000	7850	940	0.079	33400	4900	630	0.073	50000	7500	940	0.075
8	37500	7850	940	0.105	25000	4700	630	0.094	50000	8400	1255	0.084
10	30000	7850	940	0.131	20000	4800	630	0.120	40000	8400	1255	0.105
12	25000	7850	940	0.157	16700	4700	630	0.141	33500	8400	1265	0.125



N

S

M

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P

BACK TO

RANGE INDEX

ULTIMATE

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