SKS GII-09 High Feed

INCH METRIC

Recommended Cutting Data for SKG-09

Material	Insert	Grade	SFM	IPT	DOC	WOC
Cast Iron	SDEW090312ZER	JC7518 (JC7550)	700	.040" - .050"	.025" - .035"	70%
Carbon Steel	SDEW090312ZER	JC7550	600	.030" - .050"	.025" - .035"	70%
Low Alloy Steel	SDEW090312ZER	JC7550	550	.030" - .050"	.025" - .035"	70%
Mold Steel	SDEW090312ZER	JC7550	500	.020" - .040"	.025" - .035"	60%
Tool & Die Steel	SDEW090312ZER	JC7518 (JC7550)	400	.010" - .020"	.020" - .030"	60%
Stainless (Austenitic)	SDEW090312ZER (SDET090312ZDER-SM)	JC7550	500	.035" - .045"	.020" - .030"	60%
Stainless (Martensitic)	SDEW090312ZER (SDET090312ZDER-SM)	JC7550	600	.035" - .045"	.020" - .030"	60%
Stainless (Super Duplex)	SDEW090312ZER (SDET090312ZDER-SM)	JC7518 (JC7550)	300	.015" - .020"	.020" - .030"	40%-60%
Titanium	SDEW090312ZER (SDET090312ZDER-SM)	JC7518 (JC7550)	200	.025" - .030"	.020" - .030"	60%
Inconel	SDEW090312ZER	JC7518 (JC7550)	100	.025" - .030"	.015" - .025"	40%-60%

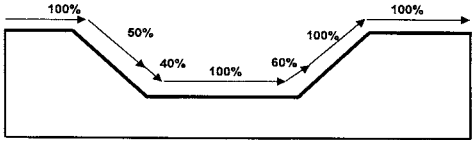
NOTE: 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.
2. RPM = 3.82 x SFM / Dia.
3. IPM = RPM x IPT x # of flutes (or teeth)

Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

NOTE: The above percentages should be applied, according to tool ratio.

Reduced Cutting Data For Cutting Pattern



NOTE: Feed should be reduced when cutting the above pattern

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