

G9132, G9134 X-Coating

4 FLUTE DRILL MILL - CHAMFERING & SIDE CUTTING

SFM = ft./min. IPT = in./tooth
RPM = rev./min. IPM = in./min.

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)								
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
P	1-2	Non-alloy steel	SFM	250	250	250	250	250	250	250	250	250
			RPM	7700	5130	3850	3080	2570	2200	1930	1540	1280
			IPT	.00104	.00162	.00205	.00289	.00333	.00355	.00378	.00475	.00605
			IPM	16	17	16	18	17	16	15	15	16
	3-4		SFM	185	185	185	185	185	185	185	185	185
			RPM	5600	3740	2800	2240	1870	1600	1400	1120	930
			IPT	.00077	.00123	.00154	.00233	.00276	.00343	.00409	.00455	.00585
			IPM	9	9	9	10	10	11	11	10	11
	5		SFM	160	160	160	160	160	160	160	160	160
			RPM	4920	3280	2460	1970	1640	1410	1230	980	820
			IPT	.00078	.00116	.00171	.00276	.00299	.00328	.00358	.00465	.00597
			IPM	8	8	8	11	10	9	9	9	10
	6	Low alloy steel	SFM	250	250	250	250	250	250	250	250	250
			RPM	7700	5130	3850	3080	2570	2200	1930	1540	1280
			IPT	.00104	.00162	.00205	.00289	.00333	.00355	.00378	.00475	.00605
			IPM	16	17	16	18	17	16	15	15	16
	7		SFM	185	185	185	185	185	185	185	185	185
			RPM	5600	3740	2800	2240	1870	1600	1400	1120	930
			IPT	.00077	.00123	.00154	.00233	.00276	.00343	.00409	.00455	.00585
			IPM	9	9	9	10	10	11	11	10	11
	8-9		SFM	160	160	160	160	160	160	160	160	160
			RPM	4920	3280	2460	1970	1640	1410	1230	980	820
			IPT	.00078	.00116	.00171	.00276	.00299	.00328	.00358	.00465	.00597
			IPM	8	8	8	11	10	9	9	9	10
	10	High alloyed steel, and tool steel	SFM	250	250	250	250	250	250	250	250	250
			RPM	7700	5130	3850	3080	2570	2200	1930	1540	1280
			IPT	.00104	.00162	.00205	.00289	.00333	.00355	.00378	.00475	.00605
			IPM	16	17	16	18	17	16	15	15	16
	11.1		SFM	160	160	160	160	160	160	160	160	160
			RPM	4920	3280	2460	1970	1640	1410	1230	980	820
			IPT	.00078	.00116	.00171	.00276	.00299	.00328	.00358	.00465	.00597
			IPM	8	8	8	11	10	9	9	9	10
M	14.1	Stainless steel	SFM	135	135	135	135	135	135	135	135	135
			RPM	4190	2800	2100	1680	1400	1200	1050	840	700
			IPT	.00085	.00116	.00146	.00186	.00205	.00292	.00379	.00388	.00582
			IPM	7	7	6	6	6	7	8	7	8
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM	185	185	185	185	185	185	185	185	185
			RPM	5600	3740	2800	2240	1870	1600	1400	1120	930
			IPT	.00077	.00123	.00154	.00233	.00276	.00343	.00409	.00455	.00585
			IPM	9	9	9	10	10	11	11	10	11
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	SFM	690	690	690	690	690	690	690	690	690
			RPM	21050	14030	10520	8420	7020	6010	5260	4210	3510
			IPT	.00161	.00259	.00332	.00459	.00532	.00569	.00605	.00838	.01063
			IPM	68	73	70	77	75	68	64	71	75

