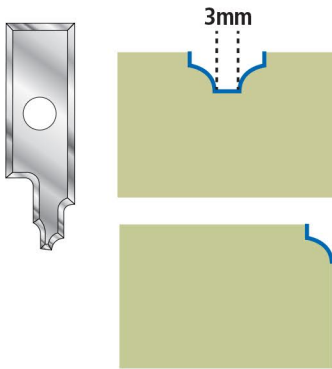


Bead Groove & Corner Round

RPM & Feed Rate Chart



Bead Groove & Corner Round
3 Sizes Available

inch/min

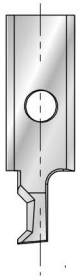
Cutting depth up to	1/8"	3/16"	1/4"	5/16"
Rotation speed RPM				
6000	59	52	47	43
7000	69	61	55	50
8000	79	69	63	57
9000	89	78	71	64
10000	98	87	79	71
11000	108	95	87	78
12000	118	104	94	85
13000	128	113	102	92
14000	138	121	110	99
15000	148	130	118	106
16000	157	139	126	113
17000	167	147	134	120
18000	177	156	142	128
19000	187	165	150	135
20000	197	173	157	142
21000	207	182	165	149
22000	217	191	173	156
23000	226	199	181	163
24000	236	208	189	170
25000	246	217	197	177
26000	256	225	205	184
27000	266	234	213	191
28000	276	243	220	198

mm/min

Cutting depth up to	3.2mm	4.76mm	6.35mm	7.93mm
Rotation speed RPM				
6000	1500	1320	1200	1080
7000	1750	1540	1400	1260
8000	2000	1760	1600	1440
9000	2250	1980	1800	1620
10000	2500	2200	2000	1800
11000	2750	2420	2200	1980
12000	3000	2640	2400	2160
13000	3250	2860	2600	2340
14000	3500	3080	2800	2520
15000	3750	3300	3000	2700
16000	4000	3520	3200	2880
17000	4250	3740	3400	3060
18000	4500	3960	3600	3240
19000	4750	4180	3800	3420
20000	5000	4400	4000	3600
21000	5250	4620	4200	3780
22000	5500	4840	4400	3960
23000	5750	5060	4600	4140
24000	6000	5280	4800	4320
25000	6250	5500	5000	4500
26000	6500	5720	5200	4680
27000	6750	5940	5400	4860
28000	7000	6160	5600	5040



G1853X04 G1853X08



Knives shown 1:1

Tool No.	B
3185040	0.5mm
3185036	1.0mm
3185002	1.5mm
3185037	1.8mm
3185041	2.3mm
3185042	3.3mm
3185012	3.6mm
3185043	4.3mm
3185013	4.6mm
*3185003	5.0mm
*3185044	5.5mm
*3185038	6.3mm
*3185039	8.3mm

inch/min

CUTTING & QUAD CHAMFERING

Material thickness up to	0.079"	0.118"	0.181"	0.220"
Rotation speed RPM				
6000	59	52	47	43
7000	69	61	55	50
8000	79	69	63	57
9000	89	78	71	64
10000	98	87	79	71
11000	108	95	87	78
12000	118	104	94	85
13000	128	113	102	92
14000	138	121	110	99
15000	148	130	118	106
16000	157	139	126	113
17000	167	147	134	120
18000	177	156	142	128
19000	187	165	150	135
20000	197	173	157	142
21000	207	182	165	149
22000	217	191	173	156
23000	226	199	181	163
24000	236	208	189	170
25000	246	217	197	177
26000	256	225	205	184
27000	266	234	213	191
28000	276	243	220	198

CHAMFERING ONLY

	0.236"	0.283"	0.315"
59	52	47	
69	61	55	
79	69	63	
89	78	71	
98	87	79	
108	95	87	
118	104	94	
128	113	102	
138	121	110	
148	130	118	
157	139	126	
167	147	134	
177	156	142	
187	165	150	
197	173	157	
207	182	165	
217	191	173	
226	199	181	
236	208	189	
246	217	197	
256	225	205	
266	234	213	
276	243	220	

mm/min

CUTTING & QUAD CHAMFERING

Material thickness (mm)	0-2	2-3	3-4.6	4.6-5.6
Rotation speed RPM				
6000	1500	1320	1200	1080
7000	1750	1540	1400	1260
8000	2000	1760	1600	1440
9000	2250	1980	1800	1620
10000	2500	2200	2000	1800
11000	2750	2420	2200	1980
12000	3000	2640	2400	2160
13000	3250	2860	2600	2340
14000	3500	3080	2800	2520
15000	3750	3300	3000	2700
16000	4000	3520	3200	2880
17000	4250	3740	3400	3060
18000	4500	3960	3600	3240
19000	4750	4180	3800	3420
20000	5000	4400	4000	3600
21000	5250	4620	4200	3780
22000	5500	4840	4400	3960
23000	5750	5060	4600	4140
24000	6000	5280	4800	4320
25000	6250	5500	5000	4500
26000	6500	5720	5200	4680
27000	6750	5940	5400	4860
28000	7000	6160	5600	5040

CHAMFERING ONLY

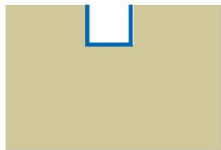
	5.6-6	6-7.2	7.2-8
1500	1320	1200	
1750	1540	1400	
2000	1760	1600	
2250	1980	1800	
2500	2200	2000	
2750	2420	2200	
3000	2640	2400	
3250	2860	2600	
3500	3080	2800	
3750	3300	3000	
4000	3520	3200	
4250	3740	3400	
4500	3960	3600	
4750	4180	3800	
5000	4400	4000	
5250	4620	4200	
5500	4840	4400	
5750	5060	4600	
6000	5280	4800	
6250	5500	5000	
6500	5720	5200	
6750	5940	5400	
7000	6160	5600	

Straight & Core Box

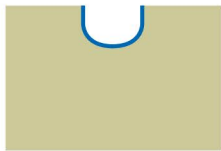
RPM & Feed Rate Chart



G1853X04 G1853X08



Straight
4 Sizes Available



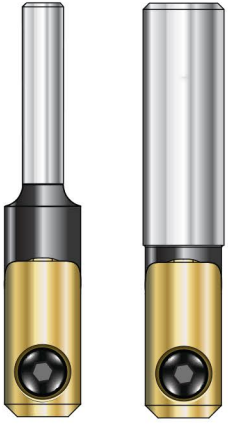
Core Box
4 Sizes Available

inch/min

Cutting depth up to	1/8"	3/16"	1/4"	5/16"
Rotation speed RPM				
6000	24	31	35	43
7000	28	36	41	50
8000	31	41	47	57
9000	35	46	53	64
10000	39	51	59	71
11000	43	56	65	78
12000	47	61	71	85
13000	51	67	77	92
14000	55	72	83	99
15000	59	77	89	106
16000	63	82	94	113
17000	67	87	100	120
18000	71	92	106	128
19000	75	97	112	135
20000	79	102	118	142
21000	83	107	124	149
22000	87	113	130	156
23000	91	118	136	163
24000	94	123	142	170
25000	98	128	148	177
26000	102	133	154	184
27000	106	138	159	191
28000	110	143	165	198

mm/min

Cutting depth up to	3.2mm	4.76mm	6.35mm	7.93mm
Rotation speed RPM				
6000	600	780	900	1080
7000	700	910	1050	1260
8000	800	1040	1200	1440
9000	900	1170	1350	1620
10000	1000	1300	1500	1800
11000	1100	1430	1650	1980
12000	1200	1560	1800	2160
13000	1300	1690	1950	2340
14000	1400	1820	2100	2520
15000	1500	1950	2250	2700
16000	1600	2080	2400	2880
17000	1700	2210	2550	3060
18000	1800	2340	2700	3240
19000	1900	2470	2850	3420
20000	2000	2600	3000	3600
21000	2100	2730	3150	3780
22000	2200	2860	3300	3960
23000	2300	2990	3450	4140
24000	2400	3120	3600	4320
25000	2500	3250	3750	4500
26000	2600	3380	3900	4680
27000	2700	3510	4050	4860
28000	2800	3640	4200	5040

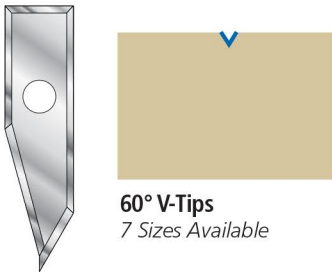


G1853X04 G1853X08

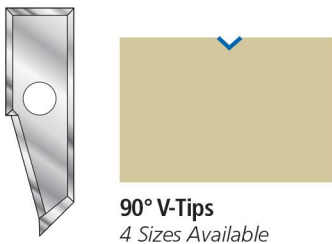
inch/min	Feed variations RPM (inch/min)						
cutting diameter (Inch)	0.004	0.010	0.020	0.030	0.039	0.059	0.089
rotation speed (RPM)							
6000	19	47	94	142	NO LIMIT		
7000	22	55	110				
8000	25	63	126				
9000	28	71	142				
10000	31	79	157				
11000	35	87					
12000	38	94					
13000	41	102					
14000	44	110					
15000	47	118					
16000	50	126					
17000	54	134					
18000	57	142					
19000	60	150					
20000	63						
21000	66						
22000	69						
23000	72						
24000	76						
25000	79						
26000	82						
27000	85						
28000	88						



30° V-Tips
7 Sizes Available



60° V-Tips
7 Sizes Available



90° V-Tips
4 Sizes Available

mm/min	Feed variations RPM (mm/min)						
cutting diameter (mm)	0.1	0.25	0.5	0.75	1	1.5	2.25
rotation speed (RPM)							
6000	480	1200	2400	3600	NO LIMIT		
7000	560	1400	2800				
8000	640	1600	3200				
9000	720	1800	3600				
10000	800	2000	4000				
11000	880	2200					
12000	960	2400					
13000	1040	2600					
14000	1120	2800					
15000	1200	3000					
16000	1280	3200					
17000	1360	3400					
18000	1440	3600					
19000	1520	3800					
20000	1600						
21000	1680						
22000	1760						
23000	1840						
24000	1920						
25000	2000						
26000	2080						
27000	2160						
28000	2240						