

GM-6E

Workpiece material	Cast iron, Nodular cast iron		Carbon steel, Alloy steel ~750N/mm ²		Carbon steel, Alloy steel ~30HRC		Pre-hardened steel, quenched and tempered steel ~40HRC		Stainless steel		Pre-hardened steel, quenched and tempered steel ~50HRC	
	Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)
6	7000	890	7000	890	6400	820	5300	680	3700	160	4200	540
8	5200	890	5200	890	4800	820	4000	680	2800	160	3200	550
10	4200	860	4200	860	3800	800	3200	665	2200	160	2500	520
12	3500	860	3500	860	3200	800	2650	665	1850	160	2100	520
14	3000	810	3000	810	2700	750	2300	625	1600	150	1800	490
16	2600	810	2600	810	2400	750	2000	625	1400	150	1600	490
18	2300	800	2300	800	2100	740	1800	615	1250	125	1400	485
20	2050	800	2050	800	1900	740	1600	615	1100	125	1250	485

Maximum cutting depth

The diagram illustrates the maximum cutting depth parameters for the end mill. It shows a cross-section of the tool cutting into a workpiece. The axial cutting depth is labeled as $a_e = 0.05D$, where D is the diameter of the end mill. The radial cutting depth is labeled as $a_p = 1.5D$.

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Down milling is recommended in the case of side milling.
4. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
5. Make overhang of tool as short as possible in conditions of non-interference.



GM-6EL

Workpiece material	Cast iron, Nodular cast iron		Carbon steel, Alloy steel ~750N/mm ²		Carbon steel, Alloy steel ~30HRC		Pre-hardened steel, quenched and tempered steel ~40HRC		Stainless steel		Pre-hardened steel, quenched and tempered steel ~50HRC	
	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
6	5800	750	5800	750	5300	685	4250	545	2650	115	3600	460
8	4400	750	4400	750	4000	685	3180	545	2000	115	2700	465
10	3500	730	3500	730	3200	665	2550	530	1600	115	2150	440
12	2900	730	2900	730	2650	665	2120	530	1350	115	1800	440
14	2500	685	2500	685	2300	625	1820	500	1150	105	1550	415
16	2200	685	2200	685	2000	625	1590	500	1000	105	1350	415
18	1950	675	1950	675	1800	615	1420	490	900	90	1200	410
20	1750	675	1750	675	1600	615	1270	490	800	90	1050	410
Maximum cutting depth	<p>The diagram illustrates the maximum cutting depth parameters for the GM-6EL end mill. It shows a cross-section of the tool cutting into a workpiece. The axial cutting depth is labeled as $a_e = 0.02D$, and the radial cutting depth is labeled as $a_p = 3D$.</p>											

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Down milling is recommended in the case of side milling.
4. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
5. Make overhang of tool as short as possible in conditions of non-interference.