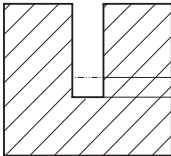


GM-2EP

Workpiece material		Cast iron, Carbon steel, Alloy steel ~750N/mm ²			Carbon steel, Alloy steel ~30HRC			Pre-hardened steel, quenched and tempered steel ~40HRC			Stainless steel		
Diameter (mm)	Effective length (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)
0.5	4	28000	500	0.023	28000	400	0.021	28000	250	0.018	25000	200	0.014
	6	22000	400	0.007	22000	350	0.06	22000	150	0.005	20000	150	0.004
	8	18000	300	0.005	18000	300	0.005	18000	150	0.004	20000	150	0.003
0.8	4	32000	900	0.057	32000	600	0.053	32000	600	0.044	25000	400	0.035
	6	26000	700	0.036	26000	450	0.034	26000	400	0.028	21000	300	0.022
	8	22000	500	0.026	22000	350	0.024	22000	300	0.02	18000	200	0.016
	10	22000	500	0.01	22000	350	0.01	22000	300	0.008	18000	200	0.006
1.0	4	2900	1300	0.08	27000	1000	0.08	26000	900	0.07	20000	600	0.05
	6	29000	1300	0.07	27000	1000	0.07	26000	900	0.06	20000	600	0.04
	8	24000	900	0.05	23000	800	0.04	22000	700	0.04	18000	400	0.03
	10	20000	700	0.03	19000	600	0.03	18000	500	0.03	15000	300	0.02
	12	20000	700	0.02	19000	600	0.02	18000	500	0.02	15000	300	0.01
	14	18000	500	0.015	15000	400	0.01	15000	360	0.01	12000	200	0.008
1.2	6	25000	1100	0.09	23000	1000	0.08	22000	900	0.07	17000	600	0.05
	8	21000	900	0.07	20000	700	0.07	19000	700	0.05	14000	400	0.04
	10	21000	900	0.06	20000	700	0.05	19000	700	0.04	14000	400	0.03
	12	18000	700	0.04	17000	600	0.04	16000	500	0.03	11000	300	0.02
1.5	6	20000	1200	0.15	18000	1000	0.14	18000	900	0.11	14000	600	0.09
	8	19000	900	0.11	16000	800	0.1	15000	700	0.08	12000	400	0.07
	10	19000	900	0.09	16000	800	0.08	15000	700	0.06	12000	400	0.05
	12	19000	900	0.07	16000	800	0.06	15000	700	0.05	12000	400	0.04
	14	19000	700	0.06	16000	650	0.05	15000	630	0.04	12000	360	0.03
2.0	6	16000	1300	0.34	15000	1100	0.31	14000	1000	0.26	11000	700	0.21
	8	16000	1300	0.29	15000	1100	0.26	14000	1000	0.22	11000	700	0.18
	10	14000	900	0.26	13000	800	0.24	12000	700	0.20	9000	500	0.16
	12	14000	900	0.14	13000	800	0.13	12000	700	0.11	9000	500	0.09
	14	14000	900	0.10	13000	800	0.11	12000	700	0.09	9000	500	0.07
	16	14000	900	0.08	13000	800	0.08	12000	700	0.07	9000	500	0.06

Maximum cutting depth



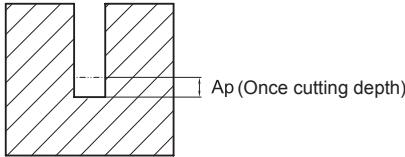
Ap (Once cutting depth)

Indexable milling tools

Solid carbide end mills

Cutting parameters for GM series end mills

GM-2EP

Workpiece material		Cast iron, Carbon steel, Alloy steel ~750N/mm ²			Carbon steel, Alloy steel ~30HRC			Pre-hardened steel, quenched and tempered steel ~40HRC			Stainless steel		
Diameter (mm)	Effective length (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)
2.5	8	13000	1300	0.42	12000	1100	0.39	11000	1000	0.33	9000	700	0.26
	10	13000	1300	0.36	12000	1100	0.33	11000	1000	0.28	9000	700	0.22
	12	13000	1300	0.24	12000	1100	0.23	11000	1000	0.19	9000	700	0.15
	14	12000	900	0.18	10000	800	0.17	9000	700	0.14	7000	500	0.11
	16	12000	900	0.13	10000	800	0.12	9000	700	0.09	7000	500	0.08
	18	12000	800	0.11	10000	720	0.10	9000	630	0.07	7000	450	0.07
	20	12000	800	0.09	10000	720	0.08	9000	630	0.05	7000	450	0.05
3.0	6	11000	1300	0.42	10000	1100	0.39	10000	1000	0.32	8000	700	0.27
	8	11000	1300	0.39	10000	1100	0.36	10000	1000	0.30	8000	700	0.24
	10	11000	1300	0.31	10000	1100	0.29	10000	1000	0.24	8000	700	0.19
	12	11000	1100	0.29	10000	1000	0.27	10000	900	0.22	8000	650	0.16
	14	11000	1100	0.27	10000	1000	0.25	10000	900	0.20	8000	650	0.15
	16	10000	850	0.22	10000	750	0.20	9000	650	0.17	6000	450	0.13
	18	10000	850	0.16	10000	750	0.14	9000	650	0.12	6000	450	0.10
4.0	20	10000	850	0.12	10000	750	0.10	9000	650	0.08	6000	450	0.07
	12	8000	1300	0.42	7000	1100	0.38	7000	1000	0.32	6000	700	0.26
	16	8000	1100	0.39	7000	1000	0.35	7000	900	0.30	6000	650	0.24
	20	7000	900	0.34	7000	800	0.30	6000	700	0.27	5000	500	0.20
5.0	25	7000	900	0.30	7000	800	0.27	6000	700	0.24	5000	500	0.15
	16	6000	1200	0.49	6000	1000	0.45	5000	1000	0.38	5000	600	0.30
	25	5000	800	0.45	5000	720	0.42	5000	700	0.35	5000	600	0.25
Maximum cutting depth													

Indexable
milling toolsSolid carbide
end mills

Cutting parameters for GM series end mills

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Make overhang of tool as short as possible in conditions of non-interference.
4. Reduce feed speed correspondingly when rotating speed is low.