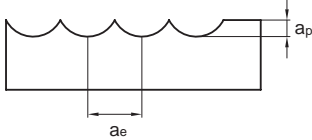


Solid Carbide End Mills **MILLING**

Cutting parameters for GM series end mills

GM-2BP

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)	a _e (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	a _e (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	a _e (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	a _e (mm)
R1.25	8	14000	800	0.10	0.32	14000	750	0.10	0.32	14000	560	0.10	0.32	12500	450	0.10	0.32
	12	13000	630	0.06	0.30	13000	600	0.06	0.30	12000	450	0.06	0.30	10000	270	0.06	0.30
	16	13000	550	0.06	0.24	13000	530	0.06	0.24	12000	400	0.06	0.24	10000	270	0.06	0.24
	20	10000	360	0.06	0.16	10000	330	0.06	0.16	8000	225	0.06	0.16	7000	175	0.06	0.16
R1.5	10	12000	800	0.15	0.40	12000	720	0.15	0.40	9500	600	0.15	0.40	7500	400	0.15	0.40
	12	12000	720	0.15	0.40	12000	650	0.15	0.40	9500	540	0.15	0.40	7500	360	0.15	0.40
	16	10000	600	0.15	0.40	10000	540	0.15	0.40	8500	300	0.15	0.40	6500	250	0.15	0.40
	20	10000	600	0.10	0.32	10000	540	0.10	0.32	8500	300	0.10	0.32	6500	250	0.10	0.32
R2.0	10	9000	800	0.20	0.80	9000	720	0.20	0.80	7500	600	0.20	0.80	6000	400	0.20	0.80
	16	9000	800	0.20	0.60	9000	720	0.20	0.60	7500	600	0.20	0.60	6000	400	0.20	0.60
	20	7000	600	0.20	0.40	7000	540	0.20	0.40	6000	400	0.20	0.40	5000	250	0.20	0.40
	25	7000	600	0.15	0.40	7000	540	0.15	0.40	6000	400	0.15	0.40	5000	250	0.15	0.40
R2.5	16	7000	600	0.25	1.00	7000	540	0.25	1.00	6500	500	0.25	1.00	5000	400	0.25	1.00
	25	6000	500	0.25	1.00	6000	450	0.25	1.00	5000	500	0.25	1.00	4000	250	0.25	1.00
Maximum cutting depth																	

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.

B

Indexable
milling tools

Solid carbide
end mills

Cutting parameters for GM series end mills