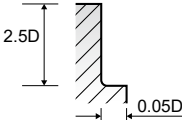
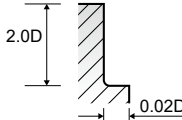
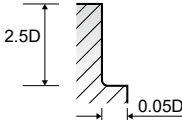


GM819 Y-COATED SOLID CARBIDE END MILLS 4 FLUTE LONG LENGTH CORNER RADIUS - SIDE CUTTING

RPM = rev./min. Vc = m/min.
FEED = mm/min. Fz = mm/tooth

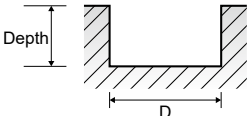
MATERIAL	P												K			
	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				CAST IRON			
HARDNESS	~HRC30				HRC30~HRC45				HRC45~HRC55							
STRENGTH	~1000N/mm ²				1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	7280	185	70	0.006	4710	145	45	0.008	2900	70	25	0.006	7280	185	70	0.006
4.0	5900	230	75	0.010	3750	165	45	0.011	2370	75	30	0.008	5900	230	75	0.010
5.0	5040	235	80	0.012	3190	200	50	0.016	2090	95	35	0.011	5040	235	80	0.012
6.0	4350	235	80	0.014	2770	200	50	0.018	1800	95	35	0.013	4350	235	80	0.014
8.0	3300	255	85	0.019	2090	200	55	0.024	1390	95	35	0.017	3300	255	85	0.019
10.0	2770	255	85	0.023	1800	200	55	0.028	1110	95	35	0.021	2770	255	85	0.023
12.0	2270	200	85	0.022	1530	175	60	0.029	920	75	35	0.020	2270	200	85	0.022
16.0	1910	175	95	0.023	1180	140	60	0.030	740	65	35	0.022	1910	175	95	0.023
20.0	1390	125	85	0.022	900	100	55	0.028	550	50	35	0.023	1390	125	85	0.022

GM810 Y-COATED SOLID CARBIDE END MILLS 2 FLUTE SHORT LENGTH - SLOTTING

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
	HRC30~HRC45				HRC45~HRC55			
STRENGTH	1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
0.4	33000	100	40	0.002	25300	55	30	0.001
0.8	26400	165	65	0.003	19800	70	50	0.002
1	22000	175	70	0.004	16500	85	50	0.003
1.2	17600	175	65	0.005	13200	85	50	0.003
1.5	13200	165	60	0.006	9900	75	45	0.004

D<1
Depth=0.15xD
D≥1
Depth=0.25xD



D<1
Depth=0.02xD
D≥1
Depth=0.05xD

