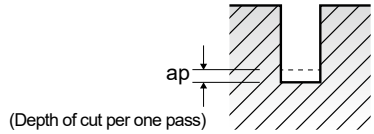
GM8A1

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS for RIB PROCESSING - SLOTTING

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

MATERIAL	P					P				
	NON-ALLOYED STEELS ALLOY STEELS					ALLOY STEELS HEAT RESISTANT STEELS				
HARDNESS	~HRc30					HRc30~HRc45				
STRENGTH	~1000N/mm²					1000 ~ 1500N/mm²				
DIAMETER	RPM	FEED	ap (mm)	Vc	Fz	RPM	FEED	ap (mm)	Vc	Fz
1.0	23630~29400	295~850	0.045~0.090	71~88	0.006~0.014	16490~21000	200~630	0.045~0.090	49~63	0.006~0.015
1.2	19430~23630	295~945	0.055~0.100	70~85	0.008~0.020	13650~17330	200~630	0.055~0.100	49~62	0.007~0.018
1.4	16800~21000	295~945	0.062~0.125	70~88	0.009~0.023	12080~14700	200~630	0.062~0.125	51~62	0.008~0.021
1.5	15230~19430	295~945	0.070~0.135	68~87	0.010~0.024	11030~14180	200~630	0.070~0.135	49~64	0.009~0.022
1.6	14700~18900	295~945	0.075~0.145	70~90	0.010~0.025	10710~13440	200~630	0.075~0.145	51~64	0.009~0.023
1.8	13650~17330	295~945	0.080~0.160	74~93	0.011~0.027	9660~12080	200~630	0.080~0.160	52~65	0.010~0.026
2.0	12600~15230	295~945	0.090~0.180	75~91	0.012~0.031	8720~11030	200~630	0.090~0.180	52~66	0.011~0.029
2.5	9980~12600	295~945	0.112~0.235	75~94	0.015~0.038	7040~8930	200~630	0.112~0.235	53~67	0.014~0.035
3.0	8400~10500	295~945	0.135~0.270	75~94	0.018~0.045	5780~7350	200~630	0.135~0.270	52~66	0.017~0.043
4.0	6300~7880	295~945	0.180~0.360	75~94	0.023~0.060	4310~5570	200~630	0.180~0.360	52~67	0.023~0.057
5.0	5040~6300	295~945	0.225~0.450	75~94	0.029~0.075	3470~4410	200~630	0.225~0.450	52~66	0.029~0.071
6.0	4200~5250	295~945	0.270~0.540	75~94	0.035~0.090	2940~3680	200~630	0.270~0.540	53~66	0.034~0.086



MATERIAL	P					K				
	HARDENED STEELS					CAST IRON				
HARDNESS	HRc45~HRc55									
STRENGTH	1500 ~ 2000N/mm²									
DIAMETER	RPM	FEED	ap (mm)	Vc	Fz	RPM	FEED	ap (mm)	Vc	Fz
1.0	10500~13130	70~135	0.009~0.018	31~39	0.003~0.005	23630~29400	295~850	0.045~0.090	71~88	0.006~0.014
1.2	8720~11030	70~135	0.010~0.022	31~40	0.004~0.006	19430~23630	295~945	0.055~0.100	70~85	0.008~0.020
1.4	7560~9450	70~135	0.012~0.025	32~40	0.005~0.007	16800~21000	295~945	0.062~0.125	70~88	0.009~0.023
1.5	7040~8610	70~135	0.014~0.028	32~39	0.005~0.008	15230~19430	295~945	0.070~0.135	68~87	0.010~0.024
1.6	6720~8400	70~135	0.015~0.030	32~40	0.005~0.008	14700~18900	295~945	0.075~0.145	70~90	0.010~0.025
1.8	5990~7560	70~135	0.016~0.032	32~41	0.006~0.009	13650~17330	295~945	0.080~0.160	74~93	0.011~0.027
2.0	5570~6930	70~135	0.018~0.035	33~41	0.006~0.010	12600~15230	295~945	0.090~0.180	75~91	0.012~0.031
2.5	4520~5570	70~135	0.022~0.045	34~42	0.008~0.012	9980~12600	295~945	0.112~0.235	75~94	0.015~0.038
3.0	3680~4620	70~135	0.028~0.055	33~41	0.009~0.015	8400~10500	295~945	0.135~0.270	75~94	0.018~0.045
4.0	2730~3470	70~135	0.036~0.072	33~41	0.013~0.020	6300~7880	295~945	0.180~0.360	75~94	0.023~0.060
5.0	2210~2730	70~135	0.045~0.090	33~41	0.015~0.025	5040~6300	295~945	0.225~0.450	75~94	0.029~0.075
6.0	1840~2730	70~135	0.054~0.108	33~49	0.019~0.025	4200~5250	295~945	0.270~0.540	75~94	0.035~0.090