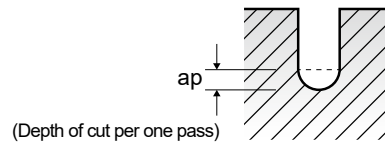


GM886 Y-COATED SOLID CARBIDE END MILLS 2 FLUTE BALL NOSE for RIB PROCESSING

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

MATERIAL	P									
	NON-ALLOYED STEELS ALLOY STEELS					ALLOY STEELS HEAT RESISTANT STEELS				
HARDNESS	~HRC30					HRC30~HRC45				
STRENGTH	~1000N/mm ²					1000 ~ 1500N/mm ²				
DIAMETER	RPM	FEED	ap (mm)	Vc	Fz	RPM	FEED	ap (mm)	Vc	Fz
0.5	32550~42000	185~515	0.023~0.045	49~63	0.003~0.006	23630~29930	90~285	0.023~0.045	35~45	0.002~0.005
0.6	32550~42000	235~660	0.027~0.054	58~75	0.004~0.008	23630~29930	115~370	0.027~0.054	42~54	0.002~0.006
0.8	32550~42000	235~660	0.036~0.072	78~101	0.004~0.008	23630~29930	115~370	0.036~0.072	57~72	0.002~0.006
1.0	30450~38330	265~735	0.045~0.090	91~115	0.004~0.010	21530~27300	130~410	0.045~0.090	64~82	0.003~0.008
1.2	25200~32030	265~820	0.055~0.100	90~115	0.005~0.013	17850~22580	130~410	0.055~0.100	64~81	0.004~0.009
1.4	22050~27300	265~820	0.062~0.125	92~114	0.006~0.015	15750~18900	130~410	0.062~0.125	66~79	0.004~0.011
1.5	19950~25200	265~820	0.070~0.135	90~113	0.007~0.016	14180~18380	130~410	0.070~0.135	64~82	0.005~0.011
1.6	18900~24680	265~820	0.075~0.145	90~118	0.007~0.017	13860~17330	130~410	0.075~0.145	66~83	0.005~0.012
1.8	17850~22580	265~820	0.080~0.160	96~122	0.007~0.018	12600~15750	130~410	0.080~0.160	68~85	0.005~0.013
2.0	16280~19950	265~820	0.090~0.180	97~119	0.008~0.021	11550~14180	130~410	0.090~0.180	69~85	0.006~0.014
3.0	11030~13650	265~820	0.135~0.270	99~123	0.012~0.030	7350~9450	130~410	0.135~0.270	66~85	0.009~0.022
4.0	8930~11550	265~820	0.180~0.360	107~138	0.015~0.035	6090~8190	130~410	0.180~0.360	73~98	0.011~0.025
5.0	7140~9240	265~820	0.225~0.450	107~138	0.018~0.044	4830~6510	130~410	0.225~0.450	72~97	0.014~0.031
6.0	5990~7670	265~820	0.270~0.540	107~138	0.022~0.053	4100~5460	130~410	0.270~0.540	74~98	0.016~0.038



MATERIAL	P					K				
	HARDENED STEELS					CAST IRON				
HARDNESS	HRC45~HRC55									
STRENGTH	1500 ~ 2000N/mm ²									
DIAMETER	RPM	FEED	ap (mm)	Vc	Fz	RPM	FEED	ap (mm)	Vc	Fz
0.5	15020~18900	90~185	0.005~0.009	22~28	0.003~0.005	32550~42000	185~515	0.023~0.045	49~63	0.003~0.006
0.6	15020~18900	115~235	0.005~0.011	27~34	0.004~0.006	32550~42000	235~660	0.027~0.054	58~75	0.004~0.008
0.8	15020~18900	115~235	0.007~0.014	36~45	0.004~0.006	32550~42000	235~660	0.036~0.072	78~101	0.004~0.008
1.0	13650~17120	130~265	0.009~0.018	41~51	0.005~0.008	30450~38330	265~735	0.045~0.090	91~115	0.004~0.010
1.2	11340~14390	130~265	0.010~0.022	41~52	0.006~0.009	25200~32030	265~820	0.055~0.100	90~115	0.005~0.013
1.4	9870~12290	130~265	0.012~0.025	41~51	0.007~0.011	22050~27300	265~820	0.062~0.125	92~114	0.006~0.015
1.5	9140~11240	130~265	0.014~0.028	41~50	0.007~0.012	19950~25200	265~820	0.070~0.135	90~113	0.007~0.016
1.6	8720~10920	130~265	0.015~0.030	42~52	0.008~0.012	18900~24680	265~820	0.075~0.145	90~118	0.007~0.017
1.8	7770~9870	130~265	0.016~0.032	42~53	0.008~0.013	17850~22580	265~820	0.080~0.160	96~122	0.007~0.018
2.0	7250~9030	130~265	0.018~0.035	43~54	0.009~0.015	16280~19950	265~820	0.090~0.180	97~119	0.008~0.021
3.0	4830~5990	130~265	0.028~0.055	43~54	0.014~0.022	11030~13650	265~820	0.135~0.270	99~123	0.012~0.030
4.0	4100~5150	130~265	0.035~0.070	49~62	0.016~0.026	8930~11550	265~820	0.180~0.360	107~138	0.015~0.035
5.0	3260~4100	130~265	0.044~0.088	49~61	0.020~0.032	7140~9240	265~820	0.225~0.450	107~138	0.018~0.044
6.0	2730~3470	130~265	0.053~0.105	49~62	0.024~0.038	5990~7670	265~820	0.270~0.540	107~138	0.022~0.053

