

NEW**W/G****MILLS**

ULTRA ECONOMICAL HIGH PERFORMANCE VARIABLE HELIX MILLING

- ✓ **Vibration free milling**
- ✓ **High metal removal**
- ✓ **Stub length tools for maximum rigidity**

Free Next Day Delivery

On orders above £59*

Expert Technical Support

Available 5 days a week

Same Day Despatch

Order before 5.45pm

FEATURES & BENEFITS OF EV MILL

✔ **MULTI-MATERIAL CAPABILITY**

Performs efficiently on steel, stainless steel, cast iron, and exotic alloys for both roughing and finishing.

✔ **STABLE CUTTING PERFORMANCE**

Short length and soft geometry ensure smooth, vibration-free machining.

✔ **VARIABLE HELIX DESIGN**

Uneven flute spacing minimises chatter for longer tool life and better surface finish.

✔ **VERSATILE MACHINE USE**

Ideal for both lathes and milling machines, offering flexible operation.

✔ **COST-EFFECTIVE SHORT SHANK**

Reduces deflection and tooling costs while improving stability and accuracy.

ORDER YOUR EV MILL TODAY

Here's a few reasons why Cutwel should be your number 1 choice:

✔ **OVER 100,000 TOOLS AVAILABLE**

Whether milling, drilling, turning, threading or anything else in-between our huge range of tooling solutions have you covered.

✔ **FREE NEXT DAY DELIVERY**

On orders over £59 ex vat you can get the tools you need, when you need them with over £4.5m worth stocked on site.

✔ **EXPERT TECHNICAL ADVICE**

Our tech team are on hand to provide industry leading support on problem solving and recommendations to save you time and money.

✔ **EXCEPTIONAL CUSTOMER SERVICE**

All our team are trained on the entire product range so we can support any requirements you have quickly and accurately.

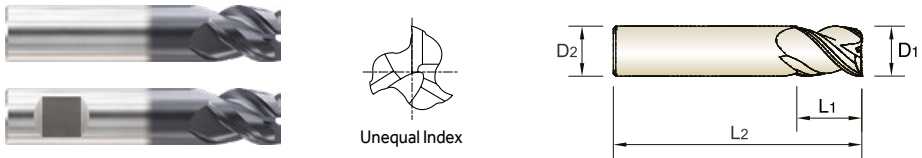
ULTRA ECONOMICAL HIGH PERFORMANCE VARIABLE HELIX MILLING

3 FLUTE SQUARE Y-COATED ULTRAFINE CARBIDE EV MILL

GMK58, GMK59 Series

from
£8.88

- For roughing and finishing applications having one edge to center
- Centre cutting: best performance in pocketing, ramping and plunging operations
- Lower cutting resistance (and reduced vibration) in comparison to 4 flutes
- Variable helix design and unequal flute spacing for vibration elimination
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



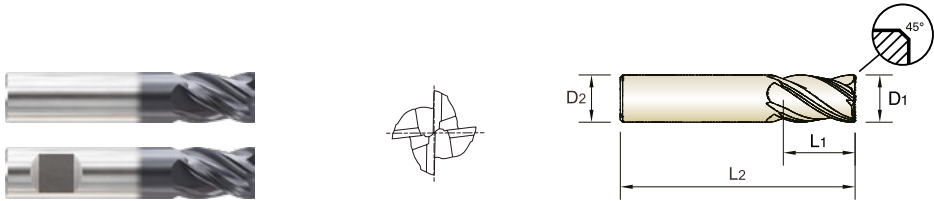
D1	D2	L1	L2	Plain	Order Code	Flat	Price
2	6	4.5	38	GMK58020		GMK59020	£8.88
3	6	5.5	38	GMK58030		GMK59030	£9.86
4	6	7.5	38	GMK58040		GMK59040	£9.86
5	6	9	38	GMK58050		GMK59050	£9.86
6	6	9	38	GMK58060		GMK59060	£9.86
8	8	12	43	GMK58080		GMK59080	£14.38
10	10	14	50	GMK58100		GMK59100	£21.58
12	12	16.5	55	GMK58120		GMK59120	£28.56

4 FLUTE SQUARE Y-COATED ULTRAFINE CARBIDE EV MILL

GMK63, GMK64 Series

from
£9.40

- Extremely stable design due to stub length and smooth cutting action
- High metal removal rates
- Variable helix design and unequal flute spacing for vibration elimination
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



D1	D2	L1	L2	Chamfer Size	Plain	Order Code	Flat	Price
2	6	4.5	38	0.1	GMK63020		GMK64020	£9.40
3	6	5.5	38	0.1	GMK63030		GMK64030	£10.44
4	6	7.5	38	0.15	GMK63040		GMK64040	£10.44
5	6	9	38	0.15	GMK63050		GMK64050	£10.44
6	6	9	38	0.2	GMK63060		GMK64060	£10.44
8	8	12	43	0.2	GMK63080		GMK64080	£15.24
10	10	14	50	0.3	GMK63100		GMK64100	£22.82
12	12	16.5	55	0.35	GMK63120		GMK64120	£30.24

**FREE CUTWEL PRO BT40/SK40
END MILL HOLDER OR ER
COLLET CHUCK
WHEN YOU ORDER 10+ EV MILLS**



cutwel **PRO**

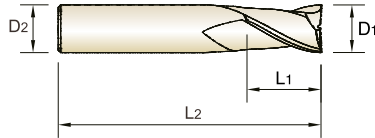
End Mill Holders			ER Collet Chucks		
Size	BT40	SK40	Size	BT40	SK40
6	BT40AD/B-EMH6-50	SK40AD/B-EMH6-50	ER16	BT40-ER16-70	SK40-ER16-70
8	BT40AD/B-EMH8-50	SK40AD/B-EMH8-50	ER20	BT40-ER20-70	SK40-ER20-70
10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
-	-	-	ER40	BT40-ER40-70	SK40-ER40-70

ULTRA ECONOMICAL HIGH PERFORMANCE VARIABLE HELIX MILLING

2 FLUTE Y-COATED ULTRAFINE CARBIDE SLOT DRILL

GMK55, GMK56 Series

- Wide flutes allow for smooth chip evacuation with difficult to machine materials
- Extremely stable design due to stub length and smooth cutting action
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



pg 7

from
£8.88

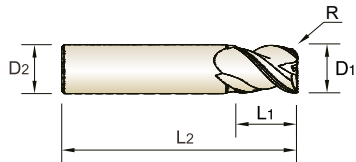


D1	D2	L1	L2	Plain	Order Code	Flat	Price
2	6	4.5	38	GMK55020		GMK56020	£8.88
3	6	5.5	38	GMK55030		GMK56030	£8.88
4	6	7.5	43	GMK55040		GMK56040	£8.88
5	6	9	43	GMK55050		GMK56050	£8.88
6	6	9	43	GMK55060		GMK56060	£8.88
8	8	12	50	GMK55080		GMK56080	£12.94
10	10	14	55	GMK55100		GMK56100	£19.40
12	12	16.5	60	GMK55120		GMK56120	£25.72

3 FLUTE Y-COATED ULTRAFINE CARBIDE KEYWAY MILL

GMK60, GMK61 Series

- Extremely stable design due to stub length and smooth cutting action
- Undersized diameters for keyway milling
- Variable helix design and unequal flute spacing for vibration elimination
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



pg 9

from
£10.34



D1	D2	L1	L2	R	Plain	Order Code	Flat	Price
1.8	6	4.5	38	0.12	GMK60018		GMK61018	£10.34
2.8	6	5.5	38	0.12	GMK60028		GMK61028	£10.34
3.8	6	7.5	38	0.2	GMK60038		GMK61038	£11.50
4.8	6	9	38	0.2	GMK60048		GMK61048	£11.50
5.75	6	9	38	0.2	GMK600575		GMK610575	£11.50
7.75	8	12	43	0.2	GMK600775		GMK610775	£16.76
9.7	10	14	50	0.33	GMK60097		GMK61097	£25.12
11.7	12	16.5	55	0.33	GMK60117		GMK61117	£33.26

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COLLET CHUCK
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cutwel PRO

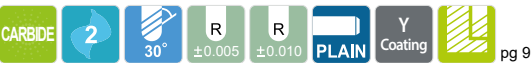
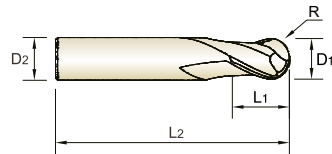
End Mill Holders			ER Collet Chucks		
Size	BT40	SK40	Size	BT40	SK40
6	BT40AD/B-EMH6-50	SK40AD/B-EMH6-50	ER16	BT40-ER16-70	SK40-ER16-70
8	BT40AD/B-EMH8-50	SK40AD/B-EMH8-50	ER20	BT40-ER20-70	SK40-ER20-70
10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
-	-	-	ER40	BT40-ER40-70	SK40-ER40-70

ULTRA ECONOMICAL HIGH PERFORMANCE VARIABLE HELIX MILLING

2 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE

GMK57 Series

- For precision finishing applications providing higher accuracy than 3 & 4 Flute Ball Nose tools
- Wide flutes allow for smooth chip evacuation
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



pg 9

from
£11.44

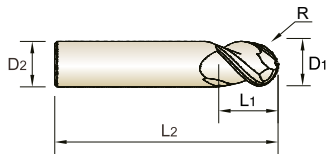


D1	D2	L1	L2	R	Order Code	Price
2	6	4.5	38	1	GMK57020	£11.44
3	6	5.5	38	1.5	GMK57030	£11.44
4	6	7.5	43	2	GMK57040	£11.44
5	6	9	43	2.5	GMK57050	£11.44
6	6	9	43	3	GMK57060	£11.44
8	8	12	50	4	GMK57080	£16.68
10	10	14	55	5	GMK57100	£25.02
12	12	16.5	60	6	GMK57120	£33.12

3 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE

GMK62 Series

- For roughing and semi-finishing applications having one edge to centre
- Smooth cutting action, unequal flute geometry and variable multiple helix eliminate vibrations
- Suitable for steel <HRC40, stainless steel, exotics and cast iron



pg 10

from
£11.44



D1	D2	L1	L2	R	Order Code	Price
2	6	4.5	38	1	GMK62020	£11.44
3	6	5.5	38	1.5	GMK62030	£12.72
4	6	7.5	38	2	GMK62040	£12.72
5	6	9	38	2.5	GMK62050	£12.72
6	6	9	38	3	GMK62060	£12.72
8	8	12	43	4	GMK62080	£18.54
10	10	14	50	5	GMK62100	£27.80
12	12	16.5	55	6	GMK62120	£36.80

FREE CUTWEL PRO BT40/SK40
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COLLET CHUCK
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End Mill Holders			ER Collet Chucks		
Size	BT40	SK40	Size	BT40	SK40
6	BT40AD/B-EMH6-50	SK40AD/B-EMH6-50	ER16	BT40-ER16-70	SK40-ER16-70
8	BT40AD/B-EMH8-50	SK40AD/B-EMH8-50	ER20	BT40-ER20-70	SK40-ER20-70
10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
-	-	-	ER40	BT40-ER40-70	SK40-ER40-70

ULTRA ECONOMICAL HIGH PERFORMANCE VARIABLE HELIX MILLING

4 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE

GMK65 Series

For roughing and finishing applications having two edges to centre

Smooth cutting action, unequal flute geometry and variable multiple helix eliminate vibrations

Suitable for steel <HRC40, stainless steel, exotics and cast iron

CARBIDE

4

35°/37°

±0.020

PLAIN

Y Coating

pg 11

D1

D2

L1

L2

R

Order Code

Price

2

6

4.5

38

1

GMK65020

£11.44

3

6

5.5

38

1.5

GMK65030

£12.72

4

6

7.5

38

2

GMK65040

£12.72

5

6

9

38

2.5

GMK65050

£12.72

6

6

9

38

3

GMK65060

£12.72

8

8

12

43

4

GMK65080

£18.54

10

10

14

50

5

GMK65100

£27.80

12

12

16.5

55

6

GMK65120

£36.80

from

£11.44

FREE CUTWEL PRO BT40/SK40
END MILL HOLDER OR ER
COLLET CHUCK
WHEN YOU ORDER 10+ EV MILLS

cutwel

PRO

End Mill Holders			ER Collet Chucks		
Size	BT40	SK40	Size	BT40	SK40
6	BT40AD/B-EMH6-50	SK40AD/B-EMH6-50	ER16	BT40-ER16-70	SK40-ER16-70
8	BT40AD/B-EMH8-50	SK40AD/B-EMH8-50	ER20	BT40-ER20-70	SK40-ER20-70
10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
-	-	-	ER40	BT40-ER40-70	SK40-ER40-70

CUTTING DATA

3 FLUTE SQUARE Y-COATED ULTRAFINE CARBIDE EV MILL CUTTING DATA

GMK58, GMK59 Series

Speed & Feed Recommendations

Diameter (mm)

Hardness (Brinell)

Work Materials

Side Cutting Ae X D

Slotting

2

3

4

5

6

8

10

12

< 300hb

Non-Alloy Steel
Carbon Steel

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

152
0.003
24192
218

152
0.005
16128
242

152
0.008
12096
290

152
0.011
9677
319

152
0.016
8064
387

152
0.027
6048
490

168
0.038
5348
610

168
0.047
4456
628

300-350hb

Low Alloy Steel
Cast Steel

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

107
0.003
17030
153

107
0.005
11353
170

107
0.008
8515
204

107
0.011
6812
225

107
0.016
5677
272

107
0.027
4257
345

117
0.038
3724
425

117
0.047
3104
438

< 380hb

Tool Steel
High Alloy Steel

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

64
0.001
10186
31

64
0.003
6791
61

64
0.006
5093
92

64
0.008
4074
98

64
0.011
3395
112

64
0.019
2546
145

70
0.027
2228
180

70
0.032
1857
178

<240hb

Stainless Steels
400 Series
Ferretic / Martensitic

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

148
0.002
23555
141

148
0.004
15703
188

148
0.006
11777
212

148
0.009
9422
254

148
0.013
7852
306

148
0.022
5889
389

148
0.034
4711
481

148
0.039
3926
459

<180hb

Stainless Steels
300 Series
Austenitic

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

106
0.003
16870
152

106
0.005
11247
169

106
0.008
8435
202

106
0.013
6748
263

106
0.018
5623
304

106
0.028
4218
354

106
0.048
3374
486

106
0.055
2812
464

<180hb

Ph & Duplex
Stainless Steels

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

95
0.003
15120
136

95
0.005
10080
151

95
0.008
7560
181

95
0.013
6048
236

95
0.018
5040
272

95
0.028
3780
318

95
0.048
3024
435

95
0.055
2520
416

-

High Temperature
Alloy
Inconel, Hastelloy, Stellite

0.25d

1d

1d

0.5d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

26
0.003
4138
37

26
0.005
2759
41

26
0.007
2069
43

26
0.008
1655
40

26
0.012
1379
50

26
0.019
1035
59

26
0.033
828
82

26
0.038
690
79

-

Titanium & Ti-Alloys

0.25d

1d

1d

0.5d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

58
0.002
9231
55

58
0.004
6154
74

58
0.007
4615
97

58
0.011
3692
122

58
0.016
3077
148

58
0.025
2308
173

58
0.042
1846
233

58
0.050
1538
231

< 260hb

Cast Iron

0.5d

1d

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

112
0.004
17825
214

112
0.006
11884
214

112
0.01
8913
267

112
0.014
7130
299

112
0.02
5942
357

112
0.034
4456
455

123
0.048
3915
564

123
0.058
3263
568

2 FLUTE Y-COATED ULTRAFINE CARBIDE SLOT DRILL CUTTING DATA

GMK55, GMK56 Series

Speed & Feed Recommendations

Diameter (mm)

Hardness (Brinell)

Work Materials

Slotting

2

3

4

5

6

8

10

12

< 300hb

Non-Alloy Steel
Carbon Steel

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

71
0.008
11300
180

81
0.012
8590
210

92
0.020
7320
290

96
0.025
6110
310

102
0.031
5410
340

103
0.045
4100
370

99
0.051
3150
320

100
0.051
2650
270

300-350hb

Low Alloy Steel
Cast Steel

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

71
0.008
11300
180

81
0.012
8590
210

92
0.020
7320
290

96
0.025
6110
310

102
0.031
5410
340

103
0.045
4100
370

99
0.051
3150
320

100
0.051
2650
270

< 380hb

Tool Steel
High Alloy Steel

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

47
0.008
7480
120

50
0.013
5310
140

56
0.019
4460
170

57
0.025
3630
180

61
0.033
3240
210

61
0.040
2430
190

61
0.040
1940
160

61
0.039
1620
130

<180hb

Stainless Steels
300 Series
Austenitic

1d

0.8d

Vc (M/Min)
Fz (mm/tooth)
RPM
Feed (mm/min)

39
0.007
6210
90

43
0.013
4560
120

48
0.019
3820
150

49
0.025
3120
160

52
0.032
2760
180

51
0.043
2030
170

49
0.048
1620
160

49
0.048
1300
120

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Technical
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8:30am to 4:30pm

Friday

8am to 4:15pm

Speak to us

01924 869615

6

ALL ENQUIRES: 03330 389849 OR EMAIL SALES@CUTWEL.NET

Rated Excellent

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C

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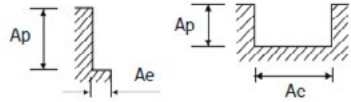
ORDER ONLINE WWW.CUTWEL.CO.UK - FREE NEXT DAY DELIVERY ON ORDERS ABOVE £59*

7

CUTTING DATA

4 FLUTE SQUARE Y-COATED ULTRAFINE CARBIDE EV MILL CUTTING DATA

GMK63, GMK64 Series



Speed & Feed Recommendations						Diameter (mm)								
Hardness (Brinell)	Work Materials	Side Cutting Ae X D		Slotting			2	3	4	5	6	8	10	12
		Ae	Ap	Ae	Ap									
< 300hb	Non-Alloy Steel Carbon Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	152	152	152	152	152	152	168	168
						Fz (mm/tooth)	0.003	0.005	0.008	0.011	0.016	0.027	0.038	0.047
						RPM	24192	16128	12096	9677	8064	6048	5348	4456
						Feed (mm/min)	290	323	387	426	516	653	813	838
300-350hb	Low Alloy Steel Cast Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	107	107	107	107	107	107	117	117
						Fz (mm/tooth)	0.003	0.005	0.008	0.011	0.016	0.027	0.038	0.047
						RPM	17030	11353	8515	6812	5677	4257	3724	3104
						Feed (mm/min)	204	227	272	300	363	460	566	583
< 380hb	Tool Steel High Alloy Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	64	64	64	64	64	64	70	70
						Fz (mm/tooth)	0.001	0.003	0.006	0.008	0.011	0.019	0.027	0.032
						RPM	10186	6791	5093	4074	3395	2546	2228	1857
						Feed (mm/min)	41	81	122	130	149	194	241	238
<240hb	Stainless Steels 400 Series Ferretic / Martensitic	0.5d	1d	1d	0.8d	Vc (M/Min)	148	148	148	148	148	148	148	148
						Fz (mm/tooth)	0.002	0.004	0.006	0.009	0.013	0.022	0.034	0.039
						RPM	23555	15703	11777	9422	7852	5889	4711	3926
						Feed (mm/min)	188	251	283	339	408	518	641	612
<180hb	Stainless Steels 300 Series Austenitic	0.5d	1d	1d	0.8d	Vc (M/Min)	106	106	106	106	106	106	106	106
						Fz (mm/tooth)	0.003	0.005	0.008	0.013	0.018	0.028	0.048	0.055
						RPM	16870	11247	8435	6748	5623	4218	3374	2812
						Feed (mm/min)	202	225	270	351	405	472	648	619
<180hb	Ph & Duplex Stainless Steels	0.5d	1d	1d	0.8d	Vc (M/Min)	95	95	95	95	95	95	95	95
						Fz (mm/tooth)	0.003	0.005	0.008	0.013	0.018	0.028	0.048	0.055
						RPM	15120	10080	7560	6048	5040	3780	3024	2520
						Feed (mm/min)	181	202	242	314	363	423	581	554
-	High Temperature Alloy Inconel, Hastelloy, Stellite	0.25d	1d	1d	0.5d	Vc (M/Min)	26	26	26	26	26	26	26	26
						Fz (mm/tooth)	0.003	0.005	0.007	0.008	0.012	0.019	0.033	0.038
						RPM	4138	2759	2069	1655	1379	1035	828	690
						Feed (mm/min)	50	55	58	53	66	79	109	105
-	Titanium & Ti-Alloys	0.25d	1d	1d	0.5d	Vc (M/Min)	58	58	58	58	58	58	58	58
						Fz (mm/tooth)	0.002	0.004	0.007	0.011	0.016	0.025	0.042	0.050
						RPM	9231	6154	4615	3692	3077	2308	1846	1538
						Feed (mm/min)	74	98	129	162	197	231	310	308
< 260hb	Cast Iron	0.5d	1d	1d	0.8d	Vc (M/Min)	112	112	112	112	112	112	123	123
						Fz (mm/tooth)	0.004	0.006	0.01	0.014	0.02	0.034	0.048	0.058
						RPM	17825	11884	8913	7130	5942	4456	3915	3263
						Feed (mm/min)	285	285	357	399	475	606	752	757

CUTTING DATA

3 FLUTE Y-COATED ULTRAFINE CARBIDE KEYWAY MILL CUTTING DATA

GMK60, GMK61 Series



Speed & Feed Recommendations						Diameter (mm)								
Hardness (Brinell)	Work Materials	Side Cutting Ae X D		Slotting			1.8	2.8	3.8	4.8	5.75	7.75	9.7	11.7
		Ae	Ap	Ae	Ap									
< 300hb	Non-Alloy Steel Carbon Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	152	152	152	152	152	152	168	168
						Fz (mm/tooth)	0.003	0.005	0.008	0.011	0.016	0.027	0.038	0.047
						RPM	26880	17280	12732	10080	8414	6243	5513	4571
						Feed (mm/min)	242	259	306	333	404	506	628	645
300-350hb	Low Alloy Steel Cast Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	107	107	107	107	107	107	117	117
						Fz (mm/tooth)	0.003	0.005	0.008	0.011	0.016	0.027	0.038	0.047
						RPM	18922	12164	8963	7096	5923	4395	3839	3183
						Feed (mm/min)	170	182	215	234	284	356	438	449
< 380hb	Tool Steel High Alloy Steel	0.5d	1d	1d	0.8d	Vc (M/Min)	64	64	64	64	64	64	70	70
						Fz (mm/tooth)	0.001	0.003	0.006	0.008	0.011	0.019	0.027	0.032
						RPM	11318	7276	5361	4244	3543	2629	2297	1904
						Feed (mm/min)	34	65	96	102	117	150	186	183
<240hb	Stainless Steels 400 Series Ferretic / Martensitic	0.5d	1d	1d	0.8d	Vc (M/Min)	148	148	148	148	148	148	148	148
						Fz (mm/tooth)	0.002	0.004	0.006	0.009	0.013	0.022	0.034	0.039
						RPM	26172	16825	12397	9815	8193	6079	4857	4026
						Feed (mm/min)	157	202	223	265	320	401	495	471
<180hb	Stainless Steels 300 Series Austenitic	0.5d	1d	1d	0.8d	Vc (M/Min)	106	106	106	106	106	106	106	106
						Fz (mm/tooth)	0.003	0.005	0.008	0.013	0.018	0.028	0.048	0.055
						RPM	18745	12050	8879	7029	5868	4354	3478	2884
						Feed (mm/min)	169	181	213	274	317	366	501	476
<180hb	Ph & Duplex Stainless Steels	0.5d	1d	1d	0.8d	Vc (M/Min)	95	95	95	95	95	95	95	95
						Fz (mm/tooth)	0.003	0.005	0.008	0.013	0.018	0.028	0.048	0.055
						RPM	16800	10800	7958	6300	5259	3902	3117	2585
						Feed (mm/min)	151	162	191	246	284	328	449	427
-	High Temperature Alloy Inconel, Hastelloy, Stellite	0.25d	1d	1d	0.5d	Vc (M/Min)	26	26	26	26	26	26	26	26
						Fz (mm/tooth)	0.003	0.005	0.008	0.013	0.018	0.028	0.048	0.055
						RPM	4598	2956	2178	1724	1439	1068	853	707
						Feed (mm/min)	41	44	46	41	52	61	84	81
-	Titanium & Ti-Alloys	0.25d	1d	1d	0.5d	Vc (M/Min)	58	58	58	58	58	58	58	58
						Fz (mm/tooth)	0.002	0.004	0.007	0.011	0.016	0.025	0.042	0.050
						RPM	10257	6594	4858	3846	3211	2382	1903	1578
						Feed (mm/min)	62	79	102	127	154	179	240	237
< 260hb	Cast Iron	0.5d	1d	1d	0.8d	Vc (M/Min)	112	112	112	112	112	112	123	123
						Fz (mm/tooth)	0.004	0.006	0.01	0.014	0.02	0.034	0.048	0.058
						RPM	19806	12732	9382	7427	6200	4600	4039	3346
						Feed (mm/min)	214	214	267	299	357	455	564	568

2 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE CUTTING DATA

GMK57 Series



Speed & Feed Recommendations					Diameter (mm)							
Hardness (Brinell)	Work Materials	Ae	Ap		2	3	4	5	6	8	10	12
< 300hb	Non-Alloy Steel Carbon Steel	1d	0.8d	Vc (M/Min)	87	119	128	140	155	175	194	213
				Fz (mm/tooth)	0.026	0.026	0.035	0.045	0.060	0.090	0.120	0.150
				RPM	13850	12630	10190	8910	8220	6960	6180	5650
				Feed (mm/min)	720	660	710	800	990	1250	1480	1700
300-350hb	Low Alloy Steel Cast Steel	1d	0.8d	Vc (M/Min)	65	91	103	112	126	141	155	170
				Fz (mm/tooth)	0.026	0.026	0.035	0.045	0.060	0.090	0.120	0.150
				RPM	10350	9660	8200	7130	6680	5610	4930	4510
				Feed (mm/min)	540	500	570	640	800	1010	1180	1350
< 380hb	Tool Steel High Alloy Steel	1d	0.8d	Vc (M/Min)	28	42	51	56	58	60	62	64
				Fz (mm/tooth)	0.026	0.026	0.035	0.045	0.060	0.090	0.120	0.150
				RPM	4460	4460	4060	3570	3080	2390	1970	1700
				Feed (mm/min)	230	230	280	320	370	430	470	510

CUTTING DATA

3 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE CUTTING DATA												
GMK62 Series												
Speed & Feed Recommendations				Diameter (mm)								
Hardness (Brinell)	Work Materials	Ae	Ap		2	3	4	5	6	8	10	12
< 300hb	Non-Alloy Steel Carbon Steel	0.5d	1d	Vc (M/Min)	162	162	162	162	162	162	162	162
				Fz (mm/tooth)	0.022	0.025	0.027	0.030	0.040	0.060	0.065	0.070
				RPM	25783	17189	12892	10313	8594	6446	5157	4297
				Feed (mm/min)	1702	1289	1044	928	1031	1160	1006	902
300-350hb	Low Alloy Steel Cast Steel	0.5d	1d	Vc (M/Min)	113	113	113	113	113	113	113	113
				Fz (mm/tooth)	0.022	0.025	0.027	0.030	0.040	0.060	0.065	0.070
				RPM	17985	11990	8992	7194	5995	4496	3597	2997
				Feed (mm/min)	1187	899	728	647	719	809	701	629
< 380hb	Tool Steel High Alloy Steel	0.5d	1d	Vc (M/Min)	68	68	68	68	68	68	68	68
				Fz (mm/tooth)	0.014	0.017	0.019	0.021	0.028	0.042	0.045	0.049
				RPM	10823	7215	5411	4329	3608	2706	2165	1804
				Feed (mm/min)	455	368	308	273	303	341	292	265
<240hb	Stainless Steels 400 Series Ferretic / Martensitic	0.5d	1d	Vc (M/Min)	85	85	85	85	85	85	85	85
				Fz (mm/tooth)	0.015	0.02	0.02	0.025	0.041	0.045	0.05	0.055
				RPM	13528	9019	6764	5411	4509	3382	2706	2255
				Feed (mm/min)	609	541	406	406	555	457	406	372
<180hb	Stainless Steels 300 Series Austenitic	0.5d	1d	Vc (M/Min)	77	77	77	77	77	77	77	77
				Fz (mm/tooth)	0.015	0.02	0.02	0.025	0.041	0.045	0.05	0.055
				RPM	12255	8170	6127	4902	4085	3064	2451	2042
				Feed (mm/min)	551	490	368	368	502	414	368	337
<180hb	Ph & Duplex Stainless Steels	0.5d	1d	Vc (M/Min)	77	77	77	77	77	77	77	77
				Fz (mm/tooth)	0.015	0.02	0.02	0.025	0.041	0.045	0.05	0.055
				RPM	12255	8170	6127	4902	4085	3064	2451	2042
				Feed (mm/min)	551	490	368	368	502	414	368	337
-	High Temperature Alloy Inconel, Hastelloy, Stellite	0.25d	1d	Vc (M/Min)	21	21	21	21	21	21	21	21
				Fz (mm/tooth)	0.01	0.014	0.014	0.017	0.028	0.031	0.035	0.038
				RPM	3342	2228	1671	1337	1114	836	668	557
				Feed (mm/min)	100	94	70	68	94	78	70	63
-	Titanium & Ti-Alloys	0.25d	1d	Vc (M/Min)	47	47	47	47	47	47	47	47
				Fz (mm/tooth)	0.014	0.018	0.018	0.022	0.037	0.040	0.045	0.049
				RPM	7480	4987	3740	2992	2493	1870	1496	1247
				Feed (mm/min)	314	269	202	197	277	224	202	183
< 260hb	Cast Iron	0.5d	1d	Vc (M/Min)	119	119	119	119	119	119	119	119
				Fz (mm/tooth)	0.028	0.031	0.033	0.037	0.05	0.074	0.081	0.087
				RPM	18939	12626	9470	7576	6313	4735	3788	3157
				Feed (mm/min)	1591	1174	938	841	947	1051	920	824

CUTTING DATA

4 FLUTE Y-COATED ULTRAFINE CARBIDE BALL NOSE CUTTING DATA												
GMK65 Series												
Speed & Feed Recommendations				Diameter (mm)								
Hardness (Brinell)	Work Materials	Ae	Ap		2	3	4	5	6	8	10	12
< 300hb	Non-Alloy Steel Carbon Steel	0.5d	1d	Vc (M/Min)	162	162	162	162	162	162	162	162
				Fz (mm/tooth)	0.022	0.025	0.027	0.030	0.040	0.060	0.065	0.070
				RPM	25783	17189	12892	10313	8594	6446	5157	4297
				Feed (mm/min)	2269	1719	1392	1238	1375	1547	1341	1203
300-350hb	Low Alloy Steel Cast Steel	0.5d	1d	Vc (M/Min)	113	113	113	113	113	113	113	113
				Fz (mm/tooth)	0.022	0.025	0.027	0.030	0.040	0.060	0.065	0.070
				RPM	17985	11990	8992	7194	5995	4496	3597	2997
				Feed (mm/min)	1583	1199	971	863	959	1079	935	839
< 380hb	Tool Steel High Alloy Steel	0.5d	1d	Vc (M/Min)	68	68	68	68	68	68	68	68
				Fz (mm/tooth)	0.014	0.017	0.019	0.021	0.028	0.042	0.045	0.049
				RPM	10823	7215	5411	4329	3608	2706	2165	1804
				Feed (mm/min)	606	491	411	364	404	455	390	354
<240hb	Stainless Steels 400 Series Ferretic / Martensitic	0.5d	1d	Vc (M/Min)	85	85	85	85	85	85	85	85
				Fz (mm/tooth)	0.015	0.02	0.02	0.025	0.041	0.045	0.05	0.055
				RPM	13528	9019	6764	5411	4509	3382	2706	2255
				Feed (mm/min)	812	722	541	541	740	609	541	496
<180hb	Stainless Steels 300 Series Austenitic	0.5d	1d	Vc (M/Min)	77	77	77	77	77	77	77	77
				Fz (mm/tooth)	0.013	0.015	0.015	0.025	0.03	0.04	0.045	0.05
				RPM	12255	8170	6127	4902	4085	3064	2451	2042
				Feed (mm/min)	637	490	368	490	490	490	441	408
<180hb	Ph & Duplex Stainless Steels	0.5d	1d	Vc (M/Min)	77	77	77	77	77	77	77	77
				Fz (mm/tooth)	0.013	0.015	0.015	0.025	0.03	0.04	0.045	0.05
				RPM	12255	8170	6127	4902	4085	3064	2451	2042
				Feed (mm/min)	637	490	368	490	490	490	441	408
-	High Temperature Alloy Inconel, Hastelloy, Stellite	0.25d	1d	Vc (M/Min)	21	21	21	21	21	21	21	21
				Fz (mm/tooth)	0.010	0.014	0.014	0.017	0.028	0.031	0.035	0.038
				RPM	3342	2228	1671	1337	1114	836	668	557
				Feed (mm/min)	134	125	94	91	125	104	94	85
-	Titanium & Ti-Alloys	0.25d	1d	Vc (M/Min)	47	47	47	47	47	47	47	47
				Fz (mm/tooth)	0.014	0.018	0.018	0.022	0.037	0.040	0.045	0.049
				RPM	7480	4987	3740	2992	2493	1870	1496	1247
				Feed (mm/min)	419	359	269	263	369	299	269	244
< 260hb	Cast Iron	0.5d	1d	Vc (M/Min)	119	119	119	119	119	119	119	119
				Fz (mm/tooth)	0.028	0.031	0.033	0.037	0.05	0.074	0.081	0.087
				RPM	18939	12626	9470	7576	6313	4735	3788	3157
				Feed (mm/min)	2121	1566	1250	1121	1263	1402	1227	1098

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10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
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8	BT40AD/B-EMH8-50	SK40AD/B-EMH8-50	ER20	BT40-ER20-70	SK40-ER20-70
10	BT40AD/B-EMH10-63	SK40AD/B-EMH10-50	ER25	BT40-ER25-70	SK40-ER25-70
12	BT40AD/B-EMH12-63	SK40AD/B-EMH12-50	ER32	BT40-ER32-70	SK40-ER32-70
-	-	-	ER40	BT40-ER40-70	SK40-ER40-70

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