

GM819 SERIES

4 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-4	Non-alloy steel	0.05D	2.5D	SFM(Vc)	230	245	260	260	280	280	280	310	280
					IPT(fz)	.0002	.0004	.0005	.0006	.0007	.0009	.0009	.0009	.0009
					RPM	7440	5940	5050	4210	3400	2720	2260	1880	1360
	IPM(FEED)				7	9	10	9	10	10	8	7	5	
	SFM(Vc)				150	150	165	165	180	180	195	195	180	
	IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011	
	RPM	4850	3640	3200	2670	2180	1750	1580	1180	870				
	IPM(FEED)	6	6	8	8	8	8	7	6	4				
	5	Low alloy steel	0.05D	2.5D	SFM(Vc)	230	245	260	260	280	280	280	310	280
					IPT(fz)	.0002	.0004	.0005	.0006	.0007	.0009	.0009	.0009	.0009
					RPM	7440	5940	5050	4210	3400	2720	2260	1880	1360
	IPM(FEED)				7	9	10	9	10	10	8	7	5	
SFM(Vc)	150				150	165	165	180	180	195	195	180		
IPT(fz)	.0003				.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
6-7	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	230	245	260	260	280	280	280	310	280	
				IPT(fz)	.0002	.0004	.0005	.0006	.0007	.0009	.0009	.0009	.0009	
				RPM	7440	5940	5050	4210	3400	2720	2260	1880	1360	
IPM(FEED)				7	9	10	9	10	10	8	7	5		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
8-9	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	230	245	260	260	280	280	280	310	280	
				IPT(fz)	.0002	.0004	.0005	.0006	.0007	.0009	.0009	.0009	.0009	
				RPM	7440	5940	5050	4210	3400	2720	2260	1880	1360	
IPM(FEED)				7	9	10	9	10	10	8	7	5		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
10	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	SFM(Vc)	80	100	115	115	115	115	115	115	115	
				IPT(fz)	.0002	.0003	.0004	.0005	.0007	.0008	.0008	.0009	.0009	
				RPM	2590	2430	2230	1860	1400	1120	930	700	560	
IPM(FEED)				3	3	4	4	4	4	3	2	2		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
11.1 11.2	Hardened steel	0.02D	2.0D	SFM(Vc)	80	100	115	115	115	115	115	115	115	
				IPT(fz)	.0002	.0003	.0004	.0005	.0007	.0008	.0008	.0009	.0009	
				RPM	2590	2430	2230	1860	1400	1120	930	700	560	
IPM(FEED)				3	3	4	4	4	4	3	2	2		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
15-20	Chilled Cast Iron	0.05D	2.5D	SFM(Vc)	80	100	115	115	115	115	115	115	115	
				IPT(fz)	.0002	.0003	.0004	.0005	.0007	.0008	.0008	.0009	.0009	
				RPM	2590	2430	2230	1860	1400	1120	930	700	560	
IPM(FEED)				3	3	4	4	4	4	3	2	2		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					
38.1 38.2	Hardened Cast Iron	0.02D	2.0D	SFM(Vc)	80	100	115	115	115	115	115	115	115	
				IPT(fz)	.0002	.0003	.0004	.0005	.0007	.0008	.0008	.0009	.0009	
				RPM	2590	2430	2230	1860	1400	1120	930	700	560	
IPM(FEED)				3	3	4	4	4	4	3	2	2		
SFM(Vc)				150	150	165	165	180	180	195	195	180		
IPT(fz)				.0003	.0004	.0006	.0007	.0010	.0011	.0012	.0012	.0011		
RPM	4850	3640	3200	2670	2180	1750	1580	1180	870					
IPM(FEED)	6	6	8	8	8	8	7	6	4					

SFM = Surface Feet per Minute
 RPM = Revolutions Per Minute
 IPT = Inches Per Tooth
 IPM = Inches Per Minute
 Ap : Inch (Axial Depth of Cut)
 Ae : Inch (Radial Depth of Cut)

