



RECOMMENDED CUTTING CONDITIONS

GM153 SERIES

4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	0.05D	1.0D	SFM(Vc)	210	320	340	400	380	350	395	395	365	395
					IPT(fz)	.0002	.0004	.0009	.0012	.0017	.0019	.0019	.0018	.0019	.0018
					RPM	12840	9780	6930	6110	4650	3570	3020	2410	1860	1510
					IPM(FEED)	12	14	26	29	31	26	23	18	14	11
	5	Non-alloy steel	0.05D	1.0D	SFM(Vc)	135	200	205	240	225	215	240	245	230	240
					IPT(fz)	.0002	.0004	.0009	.0012	.0015	.0015	.0015	.0015	.0015	.0015
					RPM	8250	6110	4180	3670	2750	2190	1830	1500	1170	920
					IPM(FEED)	7	9	16	18	17	13	11	9	7	6
	6-7	Low alloy steel	0.05D	1.0D	SFM(Vc)	210	320	340	400	380	350	395	395	365	395
					IPT(fz)	.0002	.0004	.0009	.0012	.0017	.0019	.0019	.0018	.0019	.0018
					RPM	12840	9780	6930	6110	4650	3570	3020	2410	1860	1510
					IPM(FEED)	12	14	26	29	31	26	23	18	14	11
8-9	Low alloy steel	0.05D	1.0D	SFM(Vc)	135	200	205	240	225	215	240	245	230	240	
				IPT(fz)	.0002	.0004	.0009	.0012	.0015	.0015	.0015	.0015	.0015	.0015	
				RPM	8250	6110	4180	3670	2750	2190	1830	1500	1170	920	
				IPM(FEED)	7	9	16	18	17	13	11	9	7	6	
10	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	210	320	340	400	380	350	395	395	365	395	
				IPT(fz)	.0002	.0004	.0009	.0012	.0017	.0019	.0019	.0018	.0019	.0018	
				RPM	12840	9780	6930	6110	4650	3570	3020	2410	1860	1510	
				IPM(FEED)	12	14	26	29	31	26	23	18	14	11	
11.1-11.2	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	135	200	205	240	225	215	240	245	230	240	
				IPT(fz)	.0002	.0004	.0009	.0012	.0015	.0015	.0015	.0015	.0015	.0015	
				RPM	8250	6110	4180	3670	2750	2190	1830	1500	1170	920	
				IPM(FEED)	7	9	16	18	17	13	11	9	7	6	
M	12-14.2	Stainless steel	0.05D	1.0D	SFM(Vc)	115	165	170	205	190	180	195	190	180	195
					IPT(fz)	.0002	.0004	.0009	.0011	.0016	.0018	.0018	.0019	.0018	.0017
					RPM	7030	5040	3460	3130	2320	1830	1490	1160	920	750
					IPM(FEED)	6	7	13	14	15	13	11	9	7	5
H	38.1-38.2	Hardened steel	0.05D	1.0D	SFM(Vc)	90	120	125	145	150	145	170	160	145	155
					IPT(fz)	.0001	.0002	.0003	.0004	.0006	.0007	.0007	.0007	.0006	.0005
					RPM	5500	3670	2550	2220	1830	1480	1300	980	740	590
					IPM(FEED)	2	3	3	4	5	4	4	3	2	1
	40	Chilled Cast Iron	0.05D	1.0D	SFM(Vc)	135	200	205	240	225	215	240	245	230	240
					IPT(fz)	.0002	.0004	.0009	.0012	.0015	.0015	.0015	.0015	.0015	.0015
					RPM	8250	6110	4180	3670	2750	2190	1830	1500	1170	920
					IPM(FEED)	7	9	16	18	17	13	11	9	7	6
	41	Hardened Cast Iron	0.05D	1.0D	SFM(Vc)	90	120	125	145	150	145	170	160	145	155
					IPT(fz)	.0001	.0002	.0003	.0004	.0006	.0007	.0007	.0007	.0006	.0005
					RPM	5500	3670	2550	2220	1830	1480	1300	980	740	590
					IPM(FEED)	2	3	3	4	5	4	4	3	2	1

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)

HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA