



RECOMMENDED CUTTING CONDITIONS

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

GM666 SERIES 3-5FLUTE Roughing - Side Cutting

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	0.3D	1.5D	SFM(Vc)	1105	1025	975	1130	1060	1105	1355
					IPT(fz)	.0019	.0026	.0033	.0030	.0039	.0044	.0036
					RPM	16880	12530	9930	8630	6480	5630	5180
					IPM(FEED)	99	99	99	102	102	99	92
	5	Non-alloy steel	0.3D	1.5D	SFM(Vc)	875	815	805	850	850	935	1020
					IPT(fz)	.0009	.0012	.0015	.0013	.0016	.0016	.0012
					RPM	13370	9960	8200	6490	5200	4760	3900
					IPM(FEED)	36	36	36	34	32	31	24
	6-7	Low alloy steel	0.3D	1.5D	SFM(Vc)	1105	1025	975	1130	1060	1105	1355
					IPT(fz)	.0019	.0026	.0033	.0030	.0039	.0044	.0036
					RPM	16880	12530	9930	8630	6480	5630	5180
					IPM(FEED)	99	99	99	102	102	99	92
8-9	Low alloy steel	0.3D	1.5D	SFM(Vc)	875	815	805	850	850	935	1020	
				IPT(fz)	.0009	.0012	.0015	.0013	.0016	.0016	.0012	
				RPM	13370	9960	8200	6490	5200	4760	3900	
				IPM(FEED)	36	36	36	34	32	31	24	
10	High alloyed steel, and tool steel	0.3D	1.5D	SFM(Vc)	1105	1025	975	1130	1060	1105	1355	
				IPT(fz)	.0019	.0026	.0033	.0030	.0039	.0044	.0036	
				RPM	16880	12530	9930	8630	6480	5630	5180	
				IPM(FEED)	99	99	99	102	102	99	92	
11.1	High alloyed steel, and tool steel	0.3D	1.5D	SFM(Vc)	875	815	805	850	850	935	1020	
				IPT(fz)	.0009	.0012	.0015	.0013	.0016	.0016	.0012	
				RPM	13370	9960	8200	6490	5200	4760	3900	
				IPM(FEED)	36	36	36	34	32	31	24	
11.2	High alloyed steel, and tool steel	0.3D	1.5D	SFM(Vc)	595	555	540	595	580	575	680	
				IPT(fz)	.0009	.0012	.0015	.0013	.0015	.0015	.0012	
				RPM	9090	6780	5500	4550	3550	2930	2600	
				IPM(FEED)	24	24	24	24	22	18	15	
K	38.1-38.2	Hardened steel	0.05D	1.0D	SFM(Vc)	240	210	210	235	215	235	285
					IPT(fz)	.0010	.0013	.0019	.0015	.0013	.0013	.0012
					RPM	3670	2570	2140	1800	1310	1200	1090
					IPM(FEED)	11	10	12	11	7	6	6
	40	Chilled Cast Iron	0.3D	1.5D	SFM(Vc)	595	555	540	595	580	575	680
					IPT(fz)	.0009	.0012	.0015	.0013	.0015	.0015	.0012
					RPM	9090	6780	5500	4550	3550	2930	2600
					IPM(FEED)	24	24	24	24	22	18	15
	41	Hardened Cast Iron	0.05D	1.0D	SFM(Vc)	240	210	210	235	215	235	285
					IPT(fz)	.0010	.0013	.0019	.0015	.0013	.0013	.0012
					RPM	3670	2570	2140	1800	1310	1200	1090
					IPM(FEED)	11	10	12	11	7	6	6

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)