

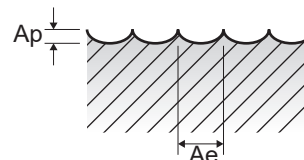
**GM876, GM813** SERIES 2 FLUTE BALL NOSE

**NORMAL SPEED**

ISO	VDI 3323	Material Description	Ae	Parameter	Diameter (Ø)												
					1.0	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-4	Non-alloy steel	0.2D	SFM(Vc)	180	280	330	410	460	490	525	590	655	740	805	885	950
				IPT(fz)	.0003	.0004	.0010	.0010	.0010	.0014	.0018	.0024	.0035	.0047	.0059	.0071	.0079
				RPM	17470	18110	16010	15910	14880	11890	10190	9540	7940	7180	6510	5370	4610
				IPM(FEED)	11	16	33	33	30	33	36	45	56	68	77	76	73
	5	Non-alloy steel	0.2D	SFM(Vc)	150	215	245	310	345	395	425	475	525	590	640	705	755
				IPT(fz)	.0003	.0004	.0009	.0009	.0009	.0013	.0016	.0024	.0031	.0039	.0047	.0055	.0063
				RPM	14550	13910	11890	12030	11160	9580	8250	7680	6370	5730	5180	4280	3660
				IPM(FEED)	9	12	22	22	20	24	26	36	40	45	49	47	46
	6-7	Low alloy steel	0.2D	SFM(Vc)	180	280	330	410	460	490	525	590	655	740	805	885	950
				IPT(fz)	.0003	.0004	.0010	.0010	.0010	.0014	.0018	.0024	.0035	.0047	.0059	.0071	.0079
				RPM	17470	18110	16010	15910	14880	11890	10190	9540	7940	7180	6510	5370	4610
				IPM(FEED)	11	16	33	33	30	33	36	45	56	68	77	76	73
8-9	Low alloy steel	0.2D	SFM(Vc)	150	215	245	310	345	395	425	475	525	590	640	705	755	
			IPT(fz)	.0003	.0004	.0009	.0009	.0009	.0013	.0016	.0024	.0031	.0039	.0047	.0055	.0063	
			RPM	14550	13910	11890	12030	11160	9580	8250	7680	6370	5730	5180	4280	3660	
			IPM(FEED)	9	12	22	22	20	24	26	36	40	45	49	47	46	
10	High alloyed steel, and tool steel	0.2D	SFM(Vc)	180	280	330	410	460	490	525	590	655	740	805	885	950	
			IPT(fz)	.0003	.0004	.0010	.0010	.0010	.0014	.0018	.0024	.0035	.0047	.0059	.0071	.0079	
			RPM	17470	18110	16010	15910	14880	11890	10190	9540	7940	7180	6510	5370	4610	
			IPM(FEED)	11	16	33	33	30	33	36	45	56	68	77	76	73	
11.1 - 11.2	High alloyed steel, and tool steel	0.2D	SFM(Vc)	150	215	245	310	345	395	425	475	525	590	640	705	755	
			IPT(fz)	.0003	.0004	.0009	.0009	.0009	.0013	.0016	.0024	.0031	.0039	.0047	.0055	.0063	
			RPM	14550	13910	11890	12030	11160	9580	8250	7680	6370	5730	5180	4280	3660	
			IPM(FEED)	9	12	22	22	20	24	26	36	40	45	49	47	46	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.2D	SFM(Vc)	180	260	330	410	445	475	525	590	655	720	805	870	950
				IPT(fz)	.0003	.0004	.0010	.0010	.0010	.0014	.0018	.0024	.0035	.0047	.0059	.0071	.0079
				RPM	17470	16820	16010	15910	14390	11520	10190	9540	7940	6990	6510	5280	4610
				IPM(FEED)	11	15	33	33	29	32	36	45	56	66	77	75	73
H	38.1 - 38.2	Hardened steel	0.1D	SFM(Vc)	65	100	115	130	165	195	215	215	230	230	245	245	260
				IPT(fz)	.0003	.0004	.0006	.0006	.0007	.0008	.0009	.0012	.0017	.0022	.0028	.0036	.0045
				RPM	6310	6470	5580	5050	5340	4730	4170	3480	2790	2230	1980	1490	1260
				IPM(FEED)	4	6	7	6	7	8	8	8	10	10	11	11	11
H	40	Chilled Cast Iron	0.2D	SFM(Vc)	150	215	245	310	345	395	425	475	525	590	640	705	755
				IPT(fz)	.0003	.0004	.0009	.0009	.0009	.0013	.0016	.0024	.0031	.0039	.0047	.0055	.0063
				RPM	14550	13910	11890	12030	11160	9580	8250	7680	6370	5730	5180	4280	3660
				IPM(FEED)	9	12	22	22	20	24	26	36	40	45	49	47	46
H	41	Hardened Cast Iron	0.1D	SFM(Vc)	65	100	115	130	165	195	215	215	230	230	245	245	260
				IPT(fz)	.0003	.0004	.0006	.0006	.0007	.0008	.0009	.0012	.0017	.0022	.0028	.0036	.0045
				RPM	6310	6470	5580	5050	5340	4730	4170	3480	2790	2230	1980	1490	1260
				IPM(FEED)	4	6	7	6	7	8	8	8	10	10	11	11	11

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

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**GM876, GM813 SERIES 2 FLUTE BALL NOSE**

**HIGH SPEED**

ISO	VDI 3323	Material Description	Ae	Parameter	Diameter (Ø)													
					1.0	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1-5	Non-alloy steel	0.05D	SFM(Vc)	295	395	490	605	720	970	1215	1460	1540	1625	1690	1770	1835	
				IPT(fz)	.0010	.0012	.0014	.0017	.0019	.0027	.0034	.0037	.0047	.0055	.0063	.0071	.0079	
				RPM	28620	25550	23770	23480	23290	23530	23580	23610	18680	15770	13670	10730	8900	
				IPM(FEED)	59	60	66	78	88	129	160	177	177	172	172	153	140	
	6-9	Low alloy steel	0.05D	SFM(Vc)	295	395	490	605	720	970	1215	1460	1540	1625	1690	1770	1835	
				IPT(fz)	.0010	.0012	.0014	.0017	.0019	.0027	.0034	.0037	.0047	.0055	.0063	.0071	.0079	
				RPM	28620	25550	23770	23480	23290	23530	23580	23610	18680	15770	13670	10730	8900	
				IPM(FEED)	59	60	66	78	88	129	160	177	177	172	172	153	140	
	10 - 11.2	High alloyed steel, and tool steel	0.05D	SFM(Vc)	295	395	490	605	720	970	1215	1460	1540	1625	1690	1770	1835	
				IPT(fz)	.0010	.0012	.0014	.0017	.0019	.0027	.0034	.0037	.0047	.0055	.0063	.0071	.0079	
				RPM	28620	25550	23770	23480	23290	23530	23580	23610	18680	15770	13670	10730	8900	
				IPM(FEED)	59	60	66	78	88	129	160	177	177	172	172	153	140	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	SFM(Vc)	295	395	490	605	720	970	1215	1460	1540	1625	1690	1770	1835	
				IPT(fz)	.0010	.0012	.0014	.0017	.0019	.0027	.0034	.0037	.0047	.0055	.0063	.0071	.0079	
				RPM	28620	25550	23770	23480	23290	23530	23580	23610	18680	15770	13670	10730	8900	
				IPM(FEED)	59	60	66	78	88	129	160	177	177	172	172	153	140	
H	38.1 - 38.2	Hardened steel	0.05D	SFM(Vc)	295	395	490	540	590	625	690	720	770	805	835	885	920	
				IPT(fz)	.0006	.0007	.0009	.0010	.0012	.0016	.0020	.0024	.0030	.0034	.0037	.0041	.0045	
				RPM	28620	25550	23770	20960	19080	15160	13390	11640	9340	7810	6750	5370	4460	
				IPM(FEED)	36	38	41	43	47	50	53	55	55	53	51	44	40	
	40	Chilled Cast Iron	0.05D	SFM(Vc)	295	395	490	605	720	970	1215	1460	1540	1625	1690	1770	1835	
				IPT(fz)	.0010	.0012	.0014	.0017	.0019	.0027	.0034	.0037	.0047	.0055	.0063	.0071	.0079	
				RPM	28620	25550	23770	23480	23290	23530	23580	23610	18680	15770	13670	10730	8900	
				IPM(FEED)	59	60	66	78	88	129	160	177	177	172	172	153	140	
	41	Hardened Cast Iron	0.05D	SFM(Vc)	295	395	490	540	590	625	690	720	770	805	835	885	920	
				IPT(fz)	.0006	.0007	.0009	.0010	.0012	.0016	.0020	.0024	.0030	.0034	.0037	.0041	.0045	
				RPM	28620	25550	23770	20960	19080	15160	13390	11640	9340	7810	6750	5370	4460	
				IPM(FEED)	36	38	41	43	47	50	53	55	55	53	51	44	40	

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

