



RECOMMENDED CUTTING CONDITIONS

**GM218** SERIES

**6&8FLUTE SQUARE - 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	1-9	Non-alloy steel Low alloy steel	0.01D	3.0D	SFM(Vc)	150	140	135	150	140	135	145	
					IPT(fz)	.0014	.0018	.0021	.0024	.0026	.0020	.0022	
					RPM	2290	1710	1380	1150	860	690	550	
						IPM(FEED)	19	18	17	16	13	11	10
	10-11.1	High alloyed steel, and tool steel	0.05D	3.0D	SFM(Vc)	150	140	135	150	140	135	145	
					IPT(fz)	.0014	.0018	.0021	.0024	.0026	.0020	.0022	
					RPM	2290	1710	1380	1150	860	690	550	
						IPM(FEED)	19	18	17	16	13	11	10
	11.2	High alloyed steel, and tool steel	0.01D	3.0D	SFM(Vc)	110	105	100	115	105	100	105	
IPT(fz)					.0014	.0017	.0020	.0021	.0024	.0020	.0021		
RPM					1680	1280	1020	880	640	510	400		
					IPM(FEED)	14	13	12	11	9	8	7	
H	38.1	Hardened steel	0.01D	3.0D	SFM(Vc)	110	105	100	115	105	100	105	
					IPT(fz)	.0014	.0017	.0020	.0021	.0024	.0020	.0021	
					RPM	1680	1280	1020	880	640	510	400	
						IPM(FEED)	14	13	12	11	9	8	7
	38.2	Hardened steel	0.05D	3.0D	SFM(Vc)	95	90	85	90	90	85	90	
					IPT(fz)	.0012	.0015	.0018	.0021	.0020	.0018	.0019	
					RPM	1450	1100	870	690	550	430	340	
						IPM(FEED)	10	10	9	9	7	6	5
	40	Chilled Cast Iron	0.01D	3.0D	SFM(Vc)	110	105	100	115	105	100	105	
					IPT(fz)	.0014	.0017	.0020	.0021	.0024	.0020	.0021	
					RPM	1680	1280	1020	880	640	510	400	
						IPM(FEED)	14	13	12	11	9	8	7
41	Hardened Cast Iron	0.05D	3.0D	SFM(Vc)	95	90	85	90	90	85	90		
				IPT(fz)	.0012	.0015	.0018	.0021	.0020	.0018	.0019		
				RPM	1450	1100	870	690	550	430	340		
					IPM(FEED)	10	10	9	9	7	6	5	

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