



**X-POWER PRO
END MILLS**

RECOMMENDED CUTTING CONDITIONS

GM960 SERIES

2FLUTE BALL NOSE - PROFILE

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)				
				.024	.031	.040	.047	.062
P	5, 8-9, 11.1-11.2	Non-alloy steel Low alloy steel High alloyed steel, and tool steela	SFM(Vc)	200	230	275	310	390
			IPT(fz)	.0004	.0005	.0005	.0005	.0006
			RPM	31830	28340	26260	25200	24030
			IPM(FEED)	25	27	27	28	29
H	38.1-38.2	Hardened steel	SFM(Vc)	200	230	275	310	390
			IPT(fz)	.0002	.0003	.0003	.0003	.0004
			RPM	31830	28340	26260	25200	24030
			IPM(FEED)	12	16	17	17	18
	40	Chilled Cast Iron	SFM(Vc)	200	230	275	310	390
			IPT(fz)	.0004	.0005	.0005	.0005	.0006
			RPM	31830	28340	26260	25200	24030
			IPM(FEED)	25	27	27	28	29
	41	Hardened Cast Iron	SFM(Vc)	200	230	275	310	390
			IPT(fz)	.0002	.0003	.0003	.0003	.0004
			RPM	31830	28340	26260	25200	24030
			IPM(FEED)	12	16	17	17	18

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)

HRc30~HRc45		HRc45~HRc55	
D < .040	D ≥ .040	D < .040	D ≥ .040
Ae = 0.15xD	Ae = 0.15xD	Ae = 0.1xD	Ae = 0.15xD
Ap = 0.05xD	Ap = 0.75xD	Ap = 0.05xD	Ap = 0.05xD