



**X-POWER PRO
END MILLS**

RECOMMENDED CUTTING CONDITIONS

GM902 SERIES

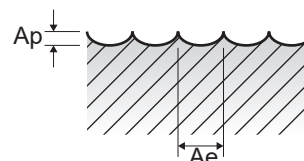
2 FLUTE BALL NOSE with TAPER NECK

NORMAL SPEED

ISO	VDI 3323	Material Description	Ae	Parameter	Diameter (Ø)						
					1.0	2.0	3.0	4.0	5.0	6.0	8.0
H	5	Non-alloy steel	0.2D	SFM(Vc)	115	195	260	295	310	360	395
				IPT(fz)	.0003	.0006	.0009	.0012	.0016	.0024	.0031
				RPM	11160	9460	8410	7160	6020	5820	4790
				IPM(FEED)	7	11	15	18	19	28	30
	8-9	Low alloy steel	0.2D	SFM(Vc)	115	195	260	295	310	360	395
				IPT(fz)	.0003	.0006	.0009	.0012	.0016	.0024	.0031
				RPM	11160	9460	8410	7160	6020	5820	4790
				IPM(FEED)	7	11	15	18	19	28	30
	11.1	High alloyed steel, and tool steel	0.2D	SFM(Vc)	115	195	260	295	310	360	395
				IPT(fz)	.0003	.0006	.0009	.0012	.0016	.0024	.0031
				RPM	11160	9460	8410	7160	6020	5820	4790
				IPM(FEED)	7	11	15	18	19	28	30
11.2	High alloyed steel, and tool steel	0.1D	SFM(Vc)	180	245	330	360	410	445	490	
			IPT(fz)	.0005	.0011	.0017	.0020	.0023	.0026	.0030	
			RPM	17470	11890	10670	8730	7960	7200	5940	
			IPM(FEED)	17	26	36	36	37	38	35	
H	38.1	Hardened steel	0.1D	SFM(Vc)	180	245	330	360	410	445	490
				IPT(fz)	.0005	.0011	.0017	.0020	.0023	.0026	.0030
				RPM	17470	11890	10670	8730	7960	7200	5940
				IPM(FEED)	17	26	36	36	37	38	35
	38.2	Hardened steel	0.1D	SFM(Vc)	180	245	310	360	410	425	460
				IPT(fz)	.0005	.0010	.0017	.0020	.0023	.0027	.0029
				RPM	17470	11890	10030	8730	7960	6870	5580
				IPM(FEED)	17	24	34	36	37	37	33
	40	Chilled Cast Iron	0.1D	SFM(Vc)	180	245	330	360	410	445	490
				IPT(fz)	.0005	.0011	.0017	.0020	.0023	.0026	.0030
				RPM	17470	11890	10670	8730	7960	7200	5940
				IPM(FEED)	17	26	36	36	37	38	35
41	Hardened Cast Iron	0.1D	SFM(Vc)	180	245	310	360	410	425	460	
			IPT(fz)	.0005	.0010	.0017	.0020	.0023	.0027	.0029	
			RPM	17470	11890	10030	8730	7960	6870	5580	
			IPM(FEED)	17	24	34	36	37	37	33	

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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YG X-POWER PRO END MILLS

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

GM902 SERIES 2 FLUTE BALL NOSE with TAPER NECK

HIGH SPEED

ISO	VDI 3323	Material Description	Ae	Parameter	Diameter (Ø)							
					1.0	2.0	3.0	4.0	5.0	6.0	8.0	
P	1-5	Non-alloy steel	0.05D	SFM(Vc)	215	360	540	720	900	1100	1165	
				IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047	
				RPM	20860	17470	17470	17470	17470	17790	14130	
				IPM(FEED)	42	50	66	97	119	133	132	
				Ap	0.2	0.2	0.2	0.2	0.2	0.2	0.3	
				SFM(Vc)	215	360	540	720	900	1100	1165	
	6-9	Low alloy steel	0.05D	IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047	
				RPM	20860	17470	17470	17470	17470	17790	14130	
				IPM(FEED)	42	50	66	97	119	133	132	
				Ap	0.2	0.2	0.2	0.2	0.2	0.2	0.3	
				SFM(Vc)	215	360	540	720	900	1100	1165	
				IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047	
10 - 11.2	High alloyed steel, and tool steel	0.05D	RPM	20860	17470	17470	17470	17470	17790	14130		
			IPM(FEED)	42	50	66	97	119	133	132		
			Ap	0.2	0.2	0.2	0.2	0.2	0.2	0.3		
			SFM(Vc)	215	360	540	720	900	1100	1165		
			IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047		
			RPM	20860	17470	17470	17470	17470	17790	14130		
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	IPM(FEED)	42	50	66	97	119	133	132	
				Ap	0.2	0.2	0.2	0.2	0.2	0.2	0.3	
				SFM(Vc)	215	360	540	720	900	1100	1165	
				IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047	
				RPM	20860	17470	17470	17470	17470	17790	14130	
				SFM(Vc)	180	245	330	360	410	445	490	
	H	38	Hardened steel	0.05D	IPT(fz)	.0008	.0015	.0027	.0032	.0035	.0040	.0044
					RPM	17470	11890	10670	8730	7960	7200	5940
					IPM(FEED)	26	35	58	55	55	57	53
					Ap	0.05	0.10	0.15	0.20	0.25	0.25	0.25
					SFM(Vc)	180	245	310	360	395	425	460
					IPT(fz)	.0007	.0017	.0026	.0031	.0034	.0040	.0043
38.2		Hardened steel	0.05D	RPM	17470	11890	10030	8730	7670	6870	5580	
				IPM(FEED)	23	40	52	54	52	55	48	
				Ap	0.05	0.10	0.15	0.20	0.25	0.25	0.25	
				SFM(Vc)	215	360	540	720	900	1100	1165	
				IPT(fz)	.0010	.0014	.0019	.0028	.0034	.0037	.0047	
				RPM	20860	17470	17470	17470	17470	17790	14130	
H	40	Chilled Cast Iron	0.05D	IPM(FEED)	42	50	66	97	119	133	132	
				Ap	0.2	0.2	0.2	0.2	0.2	0.2	0.3	
				SFM(Vc)	180	245	310	360	395	425	460	
				IPT(fz)	.0007	.0017	.0026	.0031	.0034	.0040	.0043	
				RPM	17470	11890	10030	8730	7670	6870	5580	
				IPM(FEED)	23	40	52	54	52	55	48	
	41	Hardened Cast Iron	0.05D	Ap	0.05	0.10	0.15	0.20	0.25	0.25	0.25	

SFM = Surface Feet per Minute
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 Ap : mm (Axial Depth of Cut)
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