

# **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

### **GM834** SERIES 6 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						6.0	8.0	10.0	12.0	16.0	20.0	25.0
<b>P</b>	1-4	Non-alloy steel	0.01D	3.0D	SFM(Vc)	150	150	150	150	150	150	150
					IPT(fz)	.0014	.0017	.0021	.0023	.0025	.0027	.0029
					RPM	2430	1820	1460	1210	910	730	580
					IPM(FEED)	20	19	19	17	14	12	10
	5	Non-alloy steel	0.01D	3.0D	SFM(Vc)	100	100	100	100	100	100	100
					IPT(fz)	.0014	.0017	.0019	.0021	.0024	.0026	.0027
					RPM	1620	1210	970	810	610	490	390
					IPM(FEED)	13	12	11	10	9	8	6
	6-7	Low alloy steel	0.01D	3.0D	SFM(Vc)	150	150	150	150	150	150	150
					IPT(fz)	.0014	.0017	.0021	.0023	.0025	.0027	.0029
					RPM	2430	1820	1460	1210	910	730	580
					IPM(FEED)	20	19	19	17	14	12	10
8-9	Low alloy steel	0.01D	3.0D	SFM(Vc)	100	100	100	100	100	100	100	
				IPT(fz)	.0014	.0017	.0019	.0021	.0024	.0026	.0027	
				RPM	1620	1210	970	810	610	490	390	
				IPM(FEED)	13	12	11	10	9	8	6	
10	High alloyed steel, and tool steel	0.01D	3.0D	SFM(Vc)	150	150	150	150	150	150	150	
				IPT(fz)	.0014	.0017	.0021	.0023	.0025	.0027	.0029	
				RPM	2430	1820	1460	1210	910	730	580	
				IPM(FEED)	20	19	19	17	14	12	10	
11.1 11.2	High alloyed steel, and tool steel	0.01D	3.0D	SFM(Vc)	100	100	100	100	100	100	100	
				IPT(fz)	.0014	.0017	.0019	.0021	.0024	.0026	.0027	
				RPM	1620	1210	970	810	610	490	390	
				IPM(FEED)	13	12	11	10	9	8	6	
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.01D	3.0D	SFM(Vc)	150	150	150	150	150	150	150
					IPT(fz)	.0014	.0017	.0021	.0023	.0025	.0027	.0029
					RPM	2430	1820	1460	1210	910	730	580
					IPM(FEED)	20	19	19	17	14	12	10
<b>H</b>	38.1 - 38.2	Hardened steel	0.05D	3.0D	SFM(Vc)	80	80	80	80	80	80	80
					IPT(fz)	.0012	.0015	.0019	.0021	.0022	.0024	.0026
					RPM	1290	970	780	650	490	390	310
					IPM(FEED)	9	9	9	8	6	6	5
	40	Chilled Cast Iron	0.01D	3.0D	SFM(Vc)	100	100	100	100	100	100	100
					IPT(fz)	.0014	.0017	.0019	.0021	.0024	.0026	.0027
					RPM	1620	1210	970	810	610	490	390
					IPM(FEED)	13	12	11	10	9	8	6
	41	Hardened Cast Iron	0.05D	3.0D	SFM(Vc)	80	80	80	80	80	80	80
					IPT(fz)	.0012	.0015	.0019	.0021	.0022	.0024	.0026
					RPM	1290	970	780	650	490	390	310
					IPM(FEED)	9	9	9	8	6	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)

