



X-POWER PRO END MILLS

RECOMMENDED CUTTING CONDITIONS

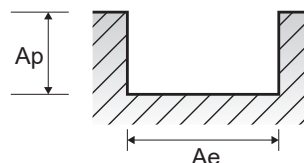
GM895 SERIES

3 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0				
P	1-4	Non-alloy steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395				
					IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012				
	RPM				12610	9540	8370	6990	6060	4550	3640	3030	2400					
	IPM(FEED)				8	8	12	12	14	15	13	11	9					
	SFM(Vc)				165	195	215	215	230	230	230	230	245					
	IPT(fz)				.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009					
	RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490								
	IPM(FEED)	5	6	7	7	9	8	6	5	4								
	5	Low alloy steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395				
					IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012				
	RPM				12610	9540	8370	6990	6060	4550	3640	3030	2400					
	IPM(FEED)				8	8	12	12	14	15	13	11	9					
SFM(Vc)	165				195	215	215	230	230	230	230	245						
IPT(fz)	.0002				.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009						
RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490									
IPM(FEED)	5	6	7	7	9	8	6	5	4									
6-7	High alloyed steel, and tool steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395					
				IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012					
RPM				12610	9540	8370	6990	6060	4550	3640	3030	2400						
IPM(FEED)				8	8	12	12	14	15	13	11	9						
SFM(Vc)				165	195	215	215	230	230	230	230	245						
IPT(fz)				.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009						
RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490									
IPM(FEED)	5	6	7	7	9	8	6	5	4									
8-9	High alloyed steel, and tool steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395					
				IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012					
RPM				12610	9540	8370	6990	6060	4550	3640	3030	2400						
IPM(FEED)				8	8	12	12	14	15	13	11	9						
SFM(Vc)				165	195	215	215	230	230	230	230	245						
IPT(fz)				.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009						
RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490									
IPM(FEED)	5	6	7	7	9	8	6	5	4									
10	High alloyed steel, and tool steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395					
				IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012					
RPM				12610	9540	8370	6990	6060	4550	3640	3030	2400						
IPM(FEED)				8	8	12	12	14	15	13	11	9						
SFM(Vc)				165	195	215	215	230	230	230	230	245						
IPT(fz)				.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009						
RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490									
IPM(FEED)	5	6	7	7	9	8	6	5	4									
11.1 11.2	High alloyed steel, and tool steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	165	195	215	215	230	230	230	230	245					
				IPT(fz)	.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009					
RPM				8010	6310	5220	4170	3720	2790	2230	1860	1490						
IPM(FEED)				5	6	7	7	9	8	6	5	4						
M				14.1	Stainless steel	1.0D	D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	150	165	1805	180	195	195	195	180	195	
								IPT(fz)	.0002	.0003	.0000	.0006	.0008	.0010	.0011	.0011	.0011	
RPM	7280	5340	43780					3490	3150	2370	1890	1460	1180					
IPM(FEED)	3	5	6					6	7	7	7	5	4					
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D					D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	260	295	345	360	375	375	375	375	395
									IPT(fz)	.0002	.0003	.0005	.0006	.0008	.0011	.0012	.0012	.0012
RPM				12610	9540	8370	6990		6060	4550	3640	3030	2400					
IPM(FEED)				8	8	12	12		14	15	13	11	9					
H				38.1 - 38.2	Hardened steel	1.0D	0.05D		SFM(Vc)	115	115	130	130	130	150	150	165	165
									IPT(fz)	.0001	.0002	.0002	.0003	.0003	.0005	.0005	.0005	.0005
RPM	5580	3720	3150					2520	2100	1820	1460	1330	1000					
IPM(FEED)	1	2	2					2	2	3	2	2	2					
H	40	Chilled Cast Iron	1.0D					D≤3 : 0.2D D>3 : 0.5D	SFM(Vc)	165	195	215	215	230	230	230	230	245
									IPT(fz)	.0002	.0003	.0004	.0006	.0008	.0009	.0009	.0009	.0009
RPM				8010	6310	5220	4170		3720	2790	2230	1860	1490					
IPM(FEED)				5	6	7	7		9	8	6	5	4					
H				41	Hardened Cast Iron	1.0D	0.05D		SFM(Vc)	115	115	130	130	130	150	150	165	165
									IPT(fz)	.0001	.0002	.0002	.0003	.0003	.0005	.0005	.0005	.0005
RPM	5580	3720	3150					2520	2100	1820	1460	1330	1000					
IPM(FEED)	1	2	2					2	2	3	2	2	2					

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)

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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

GM895 SERIES 3 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	
P	1-4	Non-alloy steel	0.05D	1.0D	SFM(Vc)	260	295	345	360	375	375	375	375	395	
					IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0017	.0019	.0019	.0019	
					RPM	12610	9540	8370	6990	6060	4550	3640	3030	2400	
					IPM(FEED)	9	10	19	20	22	23	20	17	13	
	5	Non-alloy steel	0.05D	1.0D	SFM(Vc)	165	195	215	215	230	230	230	230	245	
					IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0015	.0015	.0015	.0015	
					RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490	
					IPM(FEED)	6	7	12	12	14	13	10	8	7	
	6-7	Low alloy steel	0.05D	1.0D	SFM(Vc)	260	295	345	360	375	375	375	375	395	
					IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0017	.0019	.0019	.0019	
					RPM	12610	9540	8370	6990	6060	4550	3640	3030	2400	
					IPM(FEED)	9	10	19	20	22	23	20	17	13	
8-9	Low alloy steel	0.05D	1.0D	SFM(Vc)	165	195	215	215	230	230	230	230	245		
				IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0015	.0015	.0015	.0015		
				RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490		
				IPM(FEED)	6	7	12	12	14	13	10	8	7		
10	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	260	295	345	360	375	375	375	375	395		
				IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0017	.0019	.0019	.0019		
				RPM	12610	9540	8370	6990	6060	4550	3640	3030	2400		
				IPM(FEED)	9	10	19	20	22	23	20	17	13		
11.1 11.2	High alloyed steel, and tool steel	0.05D	1.0D	SFM(Vc)	165	195	215	215	230	230	230	230	245		
				IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0015	.0015	.0015	.0015		
				RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490		
				IPM(FEED)	6	7	12	12	14	13	10	8	7		
M	14.1	Stainless steel	0.05D	1.0D	SFM(Vc)	150	165	180	180	195	195	195	180	195	
					IPT(fz)	.0002	.0003	.0007	.0009	.0012	.0017	.0018	.0017	.0019	
					RPM	7280	5340	4370	3490	3150	2370	1890	1460	1180	
					IPM(FEED)	5	6	9	10	11	12	10	8	7	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1.0D	SFM(Vc)	260	295	345	360	375	375	375	375	395	
					IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0017	.0019	.0019	.0019	
					RPM	12610	9540	8370	6990	6060	4550	3640	3030	2400	
					IPM(FEED)	9	10	19	20	22	23	20	17	13	
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	SFM(Vc)	115	115	130	130	130	150	150	165	165	
					IPT(fz)	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0007	.0007	
					RPM	5580	3720	3150	2520	2100	1820	1460	1330	1000	
					IPM(FEED)	1	2	2	2	3	3	3	3	2	
	40	Chilled Cast Iron	0.05D	1.0D	SFM(Vc)	165	195	215	215	230	230	230	230	245	
					IPT(fz)	.0002	.0004	.0007	.0009	.0012	.0015	.0015	.0015	.0015	
					RPM	8010	6310	5220	4170	3720	2790	2230	1860	1490	
					IPM(FEED)	6	7	12	12	14	13	10	8	7	
	41	Hardened Cast Iron	0.05D	1.0D	SFM(Vc)	115	115	130	130	130	150	150	165	165	
					IPT(fz)	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0007	.0007	
					RPM	5580	3720	3150	2520	2100	1820	1460	1330	1000	
					IPM(FEED)	1	2	2	2	3	3	3	3	2	

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)

