



**X-POWER PRO  
END MILLS**

**RECOMMENDED CUTTING CONDITIONS**

**GM668** SERIES

**6&8FLUTE CORNER RADIUS - SIDE CUTTING**

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						1/4	5/16	3/8	1/2	5/8	3/4
P	1-11.2	Non-alloy steel Low alloy steel High alloyed steel, and tool steel	0.05D	1.5D	SFM(Vc)	1120	1050	1000	1120	1050	1000
					IPT(fz)	.0024	.0032	.0039	.0040	.0040	.0030
					RPM	17110	12840	10190	8560	6420	5090
					IPM(FEED)	245	245	240	204	153	122
H	38.1	Hardened steel	0.05D	1.5D	SFM(Vc)	1120	1050	1000	1120	1050	1000
					IPT(fz)	.0024	.0032	.0039	.0040	.0040	.0030
					RPM	17110	12840	10190	8560	6420	5090
					IPM(FEED)	245	245	240	204	153	122
	38.2	Hardened steel	0.05D	1.5D	SFM(Vc)	560	525	500	560	525	500
					IPT(fz)	.0024	.0032	.0040	.0040	.0040	.0029
					RPM	8560	6420	5090	4280	3210	2550
					IPM(FEED)	122	122	122	102	77	59
	40	Chilled Cast Iron	0.05D	1.5D	SFM(Vc)	1120	1050	1000	1120	1050	1000
					IPT(fz)	.0024	.0032	.0039	.0040	.0040	.0030
					RPM	17110	12840	10190	8560	6420	5090
					IPM(FEED)	245	245	240	204	153	122
41	Hardened Cast Iron	0.05D	1.5D	SFM(Vc)	560	525	500	560	525	500	
				IPT(fz)	.0024	.0032	.0040	.0040	.0040	.0029	
				RPM	8560	6420	5090	4280	3210	2550	
				IPM(FEED)	122	122	122	102	77	59	

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)