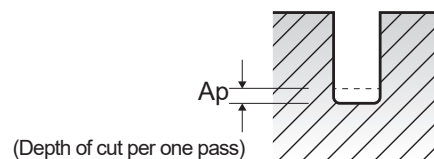


**GM8A1** SERIES 2 FLUTE CORNER RADIUS RIB PROCESSING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)					
				1.0	1.2	1.4	1.5	1.6	1.8
P	1-4	Non-alloy steel	SFM(Vc)	245~305	240~290	240~305	235~300	240~310	255~320
			IPT(fz)	.0002~.0006	.0003~.0008	.0003~.0009	.0004~.0010	.0004~.0010	.0004~.0011
			RPM	23770~29590	19410~23450	16630~21140	15200~19410	14550~18800	13750~17250
			IPM(FEED)	12~34	12~37	12~37	12~37	12~37	12~37
	Ap		0.045~0.090	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	
	5		SFM(Vc)	170~215	170~215	175~210	170~220	175~220	180~225
			IPT(fz)	.0002~.0006	.0003~.0007	.0003~.0009	.0004~.0009	.0004~.0009	.0004~.001
			RPM	16500~20860	13750~17380	12130~14550	11000~14230	10610~13340	9700~12130
		IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25	
	6-7	SFM(Vc)	245~305	240~290	240~305	235~300	240~310	255~320	
		IPT(fz)	.0002~.0006	.0003~.0008	.0003~.0009	.0004~.0010	.0004~.0010	.0004~.0011	
		RPM	23770~29590	19410~23450	16630~21140	15200~19410	14550~18800	13750~17250	
		IPM(FEED)	12~34	12~37	12~37	12~37	12~37	12~37	
	8-9	SFM(Vc)	170~215	170~215	175~210	170~220	175~220	180~225	
		IPT(fz)	.0002~.0006	.0003~.0007	.0003~.0009	.0004~.0009	.0004~.0009	.0004~.001	
		RPM	16500~20860	13750~17380	12130~14550	11000~14230	10610~13340	9700~12130	
		IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25	
	10	SFM(Vc)	245~305	240~290	240~305	235~300	240~310	255~320	
		IPT(fz)	.0002~.0006	.0003~.0008	.0003~.0009	.0004~.0010	.0004~.0010	.0004~.0011	
		RPM	23770~29590	19410~23450	16630~21140	15200~19410	14550~18800	13750~17250	
IPM(FEED)		12~34	12~37	12~37	12~37	12~37	12~37		
11.1 11.2	SFM(Vc)	170~215	170~215	175~210	170~220	175~220	180~225		
	IPT(fz)	.0002~.0006	.0003~.0007	.0003~.0009	.0004~.0009	.0004~.0009	.0004~.001		
	RPM	16500~20860	13750~17380	12130~14550	11000~14230	10610~13340	9700~12130		
	IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25		
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	245~305	240~290	240~305	235~300	240~310	255~320
			IPT(fz)	.0002~.0006	.0003~.0008	.0003~.0009	.0004~.0010	.0004~.0010	.0004~.0011
			RPM	23770~29590	19410~23450	16630~21140	15200~19410	14550~18800	13750~17250
			IPM(FEED)	12~34	12~37	12~37	12~37	12~37	12~37
H	38.1 - 38.2	Hardened steel	SFM(Vc)	110~135	110~135	110~135	110~135	110~140	110~140
			IPT(fz)	.0001~.0002	.0002~.0002	.0002~.0003	.0002~.0003	.0002~.0003	.0002~.0004
			RPM	10670~13100	8890~10920	7620~9360	7120~8730	6670~8490	5930~7550
			IPM(FEED)	3~5	3~5	3~5	3~5	3~5	3~5
	40	Chilled Cast Iron	SFM(Vc)	170~215	170~215	175~210	170~220	175~220	180~225
			IPT(fz)	.0002~.0006	.0003~.0007	.0003~.0009	.0004~.0009	.0004~.0009	.0004~.001
			RPM	16500~20860	13750~17380	12130~14550	11000~14230	10610~13340	9700~12130
			IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25
	41	Hardened Cast Iron	SFM(Vc)	110~135	110~135	110~135	110~135	110~140	110~140
			IPT(fz)	.0001~.0002	.0002~.0002	.0002~.0003	.0002~.0003	.0002~.0003	.0002~.0004
			RPM	10670~13100	8890~10920	7620~9360	7120~8730	6670~8490	5930~7550
			IPM(FEED)	3~5	3~5	3~5	3~5	3~5	3~5

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)

▶ NEXT PAGE





**GM8A1** SERIES

**2 FLUTE CORNER RADIUS RIB PROCESSING**

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)					
				2.0	2.5	3.0	4.0	5.0	6.0
P	1-4	Non-alloy steel	SFM(Vc)	260~315	255~325	260~325	260~325	260~325	260~325
			IPT(fz)	.0005~.0012	.0006~.0015	.0007~.0018	.0009~.0024	.0011~.0029	.0014~.0035
			RPM	12610~15280	9900~12610	8410~10510	6310~7880	5050~6310	4210~5260
			IPM(FEED)	12~37	12~37	12~37	12~37	12~37	12~37
			Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			SFM(Vc)	180~225	180~230	180~225	180~230	180~225	180~230
	5	Non-alloy steel	IPT(fz)	.0005~.0011	.0006~.0014	.0007~.0017	.0009~.0022	.0011~.0028	.0014~.0033
			RPM	8730~10920	6990~8930	5820~7280	4370~5580	3490~4370	2910~3720
			IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25
			Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			SFM(Vc)	260~315	255~325	260~325	260~325	260~325	260~325
			IPT(fz)	.0005~.0012	.0006~.0015	.0007~.0018	.0009~.0024	.0011~.0029	.0014~.0035
6-7	Low alloy steel	RPM	12610~15280	9900~12610	8410~10510	6310~7880	5050~6310	4210~5260	
		IPM(FEED)	12~37	12~37	12~37	12~37	12~37	12~37	
		Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		SFM(Vc)	180~225	180~230	180~225	180~230	180~225	180~230	
		IPT(fz)	.0005~.0011	.0006~.0014	.0007~.0017	.0009~.0022	.0011~.0028	.0014~.0033	
		RPM	8730~10920	6990~8930	5820~7280	4370~5580	3490~4370	2910~3720	
8-9	Low alloy steel	IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25	
		Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		SFM(Vc)	260~315	255~325	260~325	260~325	260~325	260~325	
		IPT(fz)	.0005~.0012	.0006~.0015	.0007~.0018	.0009~.0024	.0011~.0029	.0014~.0035	
		RPM	12610~15280	9900~12610	8410~10510	6310~7880	5050~6310	4210~5260	
		IPM(FEED)	12~37	12~37	12~37	12~37	12~37	12~37	
10	High alloyed steel, and tool steel	Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		SFM(Vc)	180~225	180~230	180~225	180~230	180~225	180~230	
		IPT(fz)	.0005~.0011	.0006~.0014	.0007~.0017	.0009~.0022	.0011~.0028	.0014~.0033	
		RPM	8730~10920	6990~8930	5820~7280	4370~5580	3490~4370	2910~3720	
		IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25	
		Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
11.1 - 11.2	High alloyed steel, and tool steel	SFM(Vc)	260~315	255~325	260~325	260~325	260~325	260~325	
		IPT(fz)	.0005~.0012	.0006~.0015	.0007~.0018	.0009~.0024	.0011~.0029	.0014~.0035	
		RPM	12610~15280	9900~12610	8410~10510	6310~7880	5050~6310	4210~5260	
		IPM(FEED)	12~37	12~37	12~37	12~37	12~37	12~37	
		Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		SFM(Vc)	180~225	180~230	180~225	180~230	180~225	180~230	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	IPT(fz)	.0005~.0011	.0006~.0014	.0007~.0017	.0009~.0022	.0011~.0028	.0014~.0033
			RPM	8730~10920	6990~8930	5820~7280	4370~5580	3490~4370	2910~3720
			IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25
			Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			SFM(Vc)	260~315	255~325	260~325	260~325	260~325	260~325
			IPT(fz)	.0005~.0012	.0006~.0015	.0007~.0018	.0009~.0024	.0011~.0029	.0014~.0035
H	38.1 - 38.2	Hardened steel	RPM	12610~15280	9900~12610	8410~10510	6310~7880	5050~6310	4210~5260
			IPM(FEED)	12~37	12~37	12~37	12~37	12~37	12~37
			Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540
			SFM(Vc)	115~145	115~145	115~145	115~145	115~140	115~170
			IPT(fz)	.0003~.0004	.0003~.0005	.0004~.0006	.0005~.0008	.0006~.001	.0008~.001
			RPM	5580~7040	4460~5630	3720~4690	2790~3520	2230~2720	1860~2750
	40	Chilled Cast Iron	IPM(FEED)	3~5	3~5	3~5	3~5	3~5	3~5
			Ap	0.018~0.035	0.022~0.045	0.028~0.055	0.036~0.072	0.045~0.090	0.054~0.108
			SFM(Vc)	180~225	180~230	180~225	180~230	180~225	180~230
			IPT(fz)	.0005~.0011	.0006~.0014	.0007~.0017	.0009~.0022	.0011~.0028	.0014~.0033
			RPM	8730~10920	6990~8930	5820~7280	4370~5580	3490~4370	2910~3720
			IPM(FEED)	8~25	8~25	8~25	8~25	8~25	8~25
41	Hardened Cast Iron	Ap	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360	0.225~0.450	0.270~0.540	
		SFM(Vc)	115~145	115~145	115~145	115~145	115~140	115~170	
		IPT(fz)	.0003~.0004	.0003~.0005	.0004~.0006	.0005~.0008	.0006~.001	.0008~.001	
		RPM	5580~7040	4460~5630	3720~4690	2790~3520	2230~2720	1860~2750	
		IPM(FEED)	3~5	3~5	3~5	3~5	3~5	3~5	
		Ap	0.018~0.035	0.022~0.045	0.028~0.055	0.036~0.072	0.045~0.090	0.054~0.108	

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
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