



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

GM967 SERIES

2FLUTE BALL NOSE - PROFILE

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)					
				1/32	3/64	1/16	5/64	3/32	1/8
P	1-4	Non-alloy steel	SFM(Vc)	230~300	240~305	240~310	260~310	245~310	275~345
			IPT(fz)	.0001~.0002	.0002~.0005	.0003~.0007	.0003~.0008	.0004~.0010	.0005~.0012
			RPM	28120~36670	19560~24860	14670~18950	12710~15160	9980~12630	8400~10540
			IPM(FEED)	8~17	8~25	8~25	8~25	8~25	8~25
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
	5	Non-alloy steel	SFM(Vc)	170~210	165~215	175~220	180~225	175~220	190~240
			IPT(fz)	.0001~.0002	.0002~.0004	.0002~.0005	.0002~.0006	.0003~.0007	.0003~.0009
			RPM	20780~25670	13450~17520	10700~13450	8800~11000	7130~8960	5810~7330
			IPM(FEED)	3~10	4~12	4~12	4~12	4~12	4~124
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
	6-7	Low alloy steel	SFM(Vc)	230~300	240~305	240~310	260~310	245~310	275~345
			IPT(fz)	.0001~.0002	.0002~.0005	.0003~.0007	.0003~.0008	.0004~.0010	.0005~.0012
			RPM	28120~36670	19560~24860	14670~18950	12710~15160	9980~12630	8400~10540
			IPM(FEED)	8~17	8~25	8~25	8~25	8~25	8~25
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
	8-9	Low alloy steel	SFM(Vc)	170~210	165~215	175~220	180~225	175~220	190~240
			IPT(fz)	.0001~.0002	.0002~.0004	.0002~.0005	.0002~.0006	.0003~.0007	.0003~.0009
			RPM	20780~25670	13450~17520	10700~13450	8800~11000	7130~8960	5810~7330
			IPM(FEED)	3~10	4~12	4~12	4~12	4~12	4~124
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
10	High alloyed steel, and tool steel	SFM(Vc)	230~300	240~305	240~310	260~310	245~310	275~345	
		IPT(fz)	.0001~.0002	.0002~.0005	.0003~.0007	.0003~.0008	.0004~.0010	.0005~.0012	
		RPM	28120~36670	19560~24860	14670~18950	12710~15160	9980~12630	8400~10540	
		IPM(FEED)	8~17	8~25	8~25	8~25	8~25	8~25	
		Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106	
		Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106	
11.1-11.2	High alloyed steel, and tool steel	SFM(Vc)	170~210	165~215	175~220	180~225	175~220	190~240	
		IPT(fz)	.0001~.0002	.0002~.0004	.0002~.0005	.0002~.0006	.0003~.0007	.0003~.0009	
		RPM	20780~25670	13450~17520	10700~13450	8800~11000	7130~8960	5810~7330	
		IPM(FEED)	3~10	4~12	4~12	4~12	4~12	4~124	
		Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106	
		Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106	
H	38.1-38.2	Hardened steel	SFM(Vc)	105~125	105~135	110~135	115~140	110~135	120~150
			IPT(fz)	.00006~.00013	.0001~.0002	.0002~.0003	.0002~.0003	.0002~.0004	.0003~.0005
			RPM	12840~15280	8560~11000	6720~8250	5620~6850	4480~5500	3670~4580
			IPM(FEED)	2~4	2~4	2~4	2~4	2~4	2~4
			Ap	.0003~.0006	.0004~.0009	.0006~.0012	.0007~.0014	.0009~.0018	.0011~.0022
			Ap	.0003~.0006	.0004~.0009	.0006~.0012	.0007~.0014	.0009~.0018	.0011~.0022
	40	Chilled Cast Iron	SFM(Vc)	170~210	165~215	175~220	180~225	175~220	190~240
			IPT(fz)	.0001~.0002	.0002~.0004	.0002~.0005	.0002~.0006	.0003~.0007	.0003~.0009
			RPM	20780~25670	13450~17520	10700~13450	8800~11000	7130~8960	5810~7330
			IPM(FEED)	3~10	4~12	4~12	4~12	4~12	4~124
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
			Ap	.0006~.0014	.0022~.0039	.0030~.0057	.0035~.0071	.0044~.0093	.0053~.0106
	41	Hardened Cast Iron	SFM(Vc)	105~125	105~135	110~135	115~140	110~135	120~150
			IPT(fz)	.00006~.00013	.0001~.0002	.0002~.0003	.0002~.0003	.0002~.0004	.0003~.0005
			RPM	12840~15280	8560~11000	6720~8250	5620~6850	4480~5500	3670~4580
			IPM(FEED)	2~4	2~4	2~4	2~4	2~4	2~4
			Ap	.0003~.0006	.0004~.0009	.0006~.0012	.0007~.0014	.0009~.0018	.0011~.0022
			Ap	.0003~.0006	.0004~.0009	.0006~.0012	.0007~.0014	.0009~.0018	.0011~.0022

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)