

GMF52, GMF54, GMF56, GMF58, GMF60, GMF62, GMF53, GMF55, GMF57, GMF59, GMF61, GMF63 SERIES

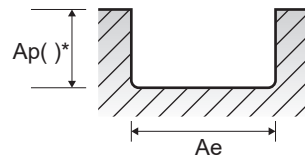
4 FLUTE - SIDE & SLOTTING

Vc = m/min.
RPM = rev./min.

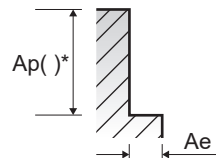
fz = mm/tooth
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae		Ap		Parameter	Diameter (Ø)											
			Side	Slotting	Side	Slotting		3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0
P	1-4	Non-alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	152	152	152	152	152	168	168	168	168	168	168	168
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064
							RPM	16128	12096	9677	8064	6048	5348	4456	3820	3342	2971	2674	2139
	5	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	FEED	323	387	426	516	653	813	838	749	709	701	695	548
							Vc	107	107	107	107	107	117	117	117	117	117	117	117
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064
	6-7	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	RPM	11353	8515	6812	5677	4257	3724	3104	2660	2328	2069	1862	1490
							FEED	227	272	300	363	460	566	583	521	493	488	484	381
	8-9	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	152	152	152	152	152	168	168	168	168	168	168	168
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064
							RPM	16128	12096	9677	8064	6048	5348	4456	3820	3342	2971	2674	2139
M	12-13	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	FEED	323	387	426	516	653	813	838	749	709	701	695	548
							Vc	107	107	107	107	107	117	117	117	117	117	117	117
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064
	14.1	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	RPM	11353	8515	6812	5677	4257	3724	3104	2660	2328	2069	1862	1490
							FEED	227	272	300	363	460	566	583	521	493	488	484	381
							Vc	64	64	64	64	64	70	70	70	70	70	70	70
	14.2	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	fz	0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.034	0.037	0.041	0.045	0.045
							RPM	6791	5093	4074	3395	2546	2228	1857	1592	1393	1238	1114	891
							FEED	81	122	130	149	194	241	238	216	206	203	201	160
	15-20	Grey cast iron	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	148	148	148	148	148	148	148	148	148	148	148	148
							fz	0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.042	0.045	0.05	0.055	0.055
							RPM	15703	11777	9422	7852	5889	4711	3926	3365	2944	2617	2355	1884
S	31-35	Heat Resistant Super Alloys	0.25D	1.0D	1.0D	0.5D	FEED	251	283	339	408	518	641	612	565	530	523	518	415
							Vc	106	106	106	106	106	106	106	106	106	106	106	106
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.059	0.062	0.069	0.076	0.076
	36-37	Titanium Alloys	0.4D	1.0D	1.0D	0.5D	RPM	11247	8435	6748	5623	4218	3374	2812	2410	2109	1874	1687	1350
							FEED	225	270	351	405	472	648	619	569	523	525	520	416
							Vc	95	95	95	95	95	95	95	95	95	95	95	95
	15-20	Grey cast iron	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.059	0.062	0.069	0.076	0.076
							RPM	10080	7560	6048	5040	3780	3024	2520	2160	1890	1680	1512	1210
							FEED	202	242	314	363	423	581	554	510	469	464	460	368
	31-35	Heat Resistant Super Alloys	0.25D	1.0D	1.0D	0.5D	Vc	112	112	112	112	112	123	123	123	123	123	123	123
							fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.061	0.065	0.073	0.081	0.079
							RPM	11884	8913	7130	5942	4456	3915	3263	2797	2447	2175	1958	1566
S	36-37	Titanium Alloys	0.4D	1.0D	1.0D	0.5D	FEED	285	357	399	475	606	752	757	682	636	635	634	495
							Vc	26	26	26	26	26	26	26	26	26	26	26	26
							fz	0.005	0.007	0.008	0.012	0.019	0.033	0.038	0.04	0.043	0.048	0.054	0.052
	31-35	Heat Resistant Super Alloys	0.25D	1.0D	1.0D	0.5D	RPM	2759	2069	1655	1379	1035	828	690	591	517	460	414	331
							FEED	55	58	53	66	79	109	105	95	89	88	89	69
							Vc	58	58	58	58	58	58	58	58	58	58	58	58
	15-20	Grey cast iron	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	fz	0.004	0.007	0.011	0.016	0.025	0.042	0.05	0.053	0.055	0.062	0.068	0.069
							RPM	6154	4615	3692	3077	2308	1846	1538	1319	1154	1026	923	738
							FEED	98	129	162	197	231	310	308	280	254	254	251	204

*() : Short length & Neck type



Slotting



Side Cutting