GMK32, GMK55, GMK56 SERIES

2 FLUTE SQUARE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

ISO	VDI 3323	Material Description	Slotting Ae	Slotting Ap	Para-meter	Diameter (Ø) 1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	66	71	81	92	96	102	103	99	100
					fz	0.004	0.008	0.012	0.020	0.025	0.031	0.045	0.051	0.051
					RPM	21010	11300	8590	7320	6110	5410	4100	3150	2650
					FEED	170	180	210	290	310	340	370	320	270
	5		1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	40	47	50	56	57	61	61	61	61
					fz	0.004	0.008	0.013	0.019	0.025	0.033	0.040	0.040	0.039
					RPM	12730	7480	5310	4460	3630	3240	2430	1940	1620
					FEED	100	120	140	170	180	210	190	160	130
	6-7	Low alloy steel	1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	66	71	81	92	96	102	103	99	100
					fz	0.004	0.008	0.012	0.020	0.025	0.031	0.045	0.051	0.051
					RPM	21010	11300	8590	7320	6110	5410	4100	3150	2650
					FEED	170	180	210	290	310	340	370	320	270
	8-9		1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	40	47	50	56	57	61	61	61	61
					fz	0.004	0.008	0.013	0.019	0.025	0.033	0.040	0.040	0.039
					RPM	12730	7480	5310	4460	3630	3240	2430	1940	1620
					FEED	100	120	140	170	180	210	190	160	130
	10	High alloyed steel, and tool steel	1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	66	71	81	92	96	102	103	99	100
					fz	0.004	0.008	0.012	0.020	0.025	0.031	0.045	0.051	0.051
					RPM	21010	11300	8590	7320	6110	5410	4100	3150	2650
					FEED	170	180	210	290	310	340	370	320	270
	11.1 - 11.2		1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	40	47	50	56	57	61	61	61	61
					fz	0.004	0.008	0.013	0.019	0.025	0.033	0.040	0.040	0.039
					RPM	12730	7480	5310	4460	3630	3240	2430	1940	1620
					FEED	100	120	140	170	180	210	190	160	130
M	14.1	Stainless steel	1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	33	39	43	48	49	52	51	51	49
					fz	0.004	0.007	0.013	0.019	0.025	0.032	0.043	0.048	0.048
					RPM	10500	6210	4560	3820	3120	2760	2030	1620	1300
					FEED	80	90	120	150	160	180	170	160	120
K	15 - 20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.5D D≤3 : 0.2D D<1 : 0.15D	Vc	66	71	81	92	96	102	103	99	100
					fz	0.004	0.008	0.012	0.020	0.025	0.031	0.045	0.051	0.051
					RPM	21010	11300	8590	7320	6110	5410	4100	3150	2650
					FEED	170	180	210	290	310	340	370	320	270

