

GM811 SERIES

4 FLUTE - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)										
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1-4	Non-alloy steel	0.05D	1.0D	Vc	80	95	105	110	115	120	115	115	125	120	120
					fz	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.046
					RPM	12732	10080	8356	7003	6101	4775	3661	3050	2487	1910	1528
					FEED	306	363	635	672	732	802	688	573	468	367	281
	5	Non-alloy steel	0.05D	1.0D	Vc	55	60	65	65	70	70	70	70	75	75	75
					fz	0.006	0.009	0.019	0.024	0.031	0.038	0.037	0.037	0.037	0.038	0.039
					RPM	8754	6366	5173	4138	3714	2785	2228	1857	1492	1194	955
					FEED	210	229	393	397	460	423	330	275	221	181	149
	6-7	Low alloy steel	0.05D	1.0D	Vc	80	95	105	110	115	120	115	115	125	120	120
					fz	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.046
					RPM	12732	10080	8356	7003	6101	4775	3661	3050	2487	1910	1528
					FEED	306	363	635	672	732	802	688	573	468	367	281
	8-9	Low alloy steel	0.05D	1.0D	Vc	55	60	65	65	70	70	70	70	75	75	75
					fz	0.006	0.009	0.019	0.024	0.031	0.038	0.037	0.037	0.037	0.038	0.039
					RPM	8754	6366	5173	4138	3714	2785	2228	1857	1492	1194	955
					FEED	210	229	393	397	460	423	330	275	221	181	149
10	High alloyed steel, and tool steel	0.05D	1.0D	Vc	80	95	105	110	115	120	115	115	125	120	120	
				fz	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.046	
				RPM	12732	10080	8356	7003	6101	4775	3661	3050	2487	1910	1528	
				FEED	306	363	635	672	732	802	688	573	468	367	281	
11.1 11.2	High alloyed steel, and tool steel	0.05D	1.0D	Vc	55	60	65	65	70	70	70	70	75	75	75	
				fz	0.006	0.009	0.019	0.024	0.031	0.038	0.037	0.037	0.037	0.038	0.039	
				RPM	8754	6366	5173	4138	3714	2785	2228	1857	1492	1194	955	
				FEED	210	229	393	397	460	423	330	275	221	181	149	
M	14.1	Stainless steel	0.05D	1.0D	Vc	45	50	55	55	60	60	60	55	60	60	60
					fz	0.005	0.009	0.018	0.024	0.029	0.041	0.045	0.044	0.046	0.045	0.044
					RPM	7162	5305	4377	3501	3183	2387	1910	1459	1194	955	764
					FEED	143	191	315	336	369	392	344	257	220	172	134
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1.0D	Vc	80	95	105	110	115	120	115	115	125	120	120
					fz	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.046
					RPM	12732	10080	8356	7003	6101	4775	3661	3050	2487	1910	1528
					FEED	306	363	635	672	732	802	688	573	468	367	281
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	Vc	35	35	40	40	40	45	50	50	50	50	45
					fz	0.002	0.004	0.005	0.008	0.010	0.017	0.016	0.017	0.016	0.015	0.015
					RPM	5570	3714	3183	2546	2122	1790	1592	1326	995	796	573
					FEED	45	59	64	81	85	122	102	90	64	48	34
	40	Chilled Cast Iron	0.05D	1.0D	Vc	55	60	65	65	70	70	70	70	75	75	75
					fz	0.006	0.009	0.019	0.024	0.031	0.038	0.037	0.037	0.037	0.038	0.039
					RPM	8754	6366	5173	4138	3714	2785	2228	1857	1492	1194	955
					FEED	210	229	393	397	460	423	330	275	221	181	149
	41	Hardened Cast Iron	0.05D	1.0D	Vc	35	35	40	40	40	45	50	50	50	50	45
					fz	0.002	0.004	0.005	0.008	0.010	0.017	0.016	0.017	0.016	0.015	0.015
					RPM	5570	3714	3183	2546	2122	1790	1592	1326	995	796	573
					FEED	45	59	64	81	85	122	102	90	64	48	34

