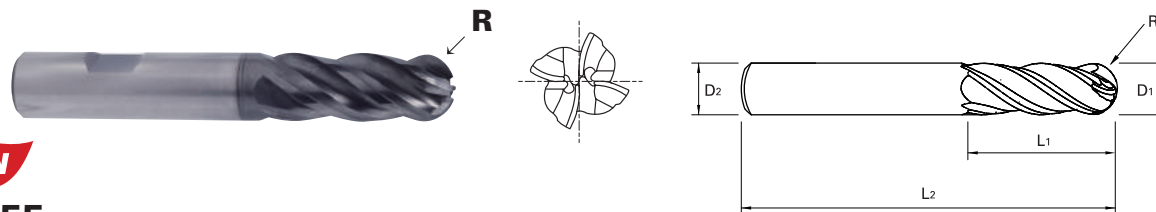


CARBIDE, 4 FLUTE BALL NOSE

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



NEW

GMG55 / PLAIN SHANK

GMG56 / FLAT SHANK



MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~-0.03	h6

Unit : mm

EDP NO.		RADIUS OF BALL NOSE R (±0.02)	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT					
GMG55030	GMG56030	R1.5	3.0	6	8	57
GMG55040	GMG56040	R2.0	4.0	6	11	57
GMG55050	GMG56050	R2.5	5.0	6	13	57
GMG55060	GMG56060	R3.0	6.0	6	13	57
GMG55080	GMG56080	R4.0	8.0	8	19	63
GMG55100	GMG56100	R5.0	10.0	10	22	72
GMG55120	GMG56120	R6.0	12.0	12	26	83
GMG55160	GMG56160	R8.0	16.0	16	32	92
GMG55200	GMG56200	R10.0	20.0	20	38	104
GMG55250	GMG56250	R12.5	25.0	25	38	104










CUTTING CONDITION

GMG55, GMG56 SERIES

Y7 Plus
SOLID CARBIDE END MILLS



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

SPEED AND FEED RECOMMENDATIONS					Diameter (mm)											
Hardness (BRINELL)	Work Materials	Type of cut	Ap x D1	Ae x D1	Parameters	3	4	5	6	8	10	12	16	18	20	25
P < 300	CARBON STEEL 1.1191(C45) 1.0726(35 S 20) 1.0715(9 SMN 28) 1.0718(9 SMNPB 28)		1	0.5	Vc	162 (130-194)										
					RPM	17189	12892	10313	8594	6446	5157	4297	3223	2865	2578	2063
					Fz	0.025	0.027	0.030	0.040	0.060	0.065	0.070	0.075	0.080	0.090	0.099
					FEED	1719	1392	1238	1375	1547	1341	1203	967	917	928	817
P > 300 P < 380	ALLOY STEEL 1.2330(35 CRMO 4) 1.6565(40NICRMO6) 1.7033(34CR4) 1.6523(21 NICRMO2)		1	0.5	Vc	113 (90-136)										
					RPM	11990	8992	7194	5995	4496	3597	2997	2248	1998	1798	1439
					Fz	0.025	0.027	0.030	0.040	0.060	0.065	0.070	0.074	0.079	0.090	0.099
					FEED	1199	971	863	959	1079	935	839	665	631	647	570
P < 380	TOOL STEEL 1.2363(X100 CRMOV 5 1) 1.2379(X155 CRVMO 12 1) 1.2344(X40 CRMOV 5 1) 1.3243(S 6-5-2-5)		1	0.5	Vc	68 (54-82)										
					RPM	7215	5411	4329	3608	2706	2165	1804	1353	1203	1082	866
					Fz	0.017	0.019	0.021	0.028	0.042	0.045	0.049	0.052	0.056	0.063	0.070
					FEED	491	411	364	404	455	390	354	281	269	273	242
K < 260	CAST IRON 0.6020(GG20) 0.8145(GTS-45-06) 0.7060(GGG-60)		1	0.5	Vc	119 (95-143)										
					RPM	12626	9470	7576	6313	4735	3788	3157	2367	2104	1894	1515
					Fz	0.031	0.033	0.037	0.050	0.074	0.081	0.087	0.093	0.099	0.112	0.124
					FEED	1566	1250	1121	1263	1402	1227	1098	881	833	848	752
M	STAINLESS STEELS 300 1.4301(X5 CRNI 18 10) 1.4436(X3 CRNIMO 17 13 3) 1.4306(X2 CRNI 19 11) 1.4435(X2 CRNIMO 18 14 3)		1	0.5	Vc	85 (68-102)										
					RPM	9019	6764	5411	4509	3382	2706	2255	1691	1503	1353	1082
					Fz	0.020	0.020	0.025	0.041	0.045	0.050	0.055	0.060	0.064	0.065	0.068
					FEED	722	541	541	740	609	541	496	406	385	352	294
M	STAINLESS STEELS 400 1.4005(X12 CRS 13) 1.4104(X14 CRMOS 17)		1	0.5	Vc	77 (62-92)										
					RPM	8170	6127	4902	4085	3064	2451	2042	1532	1362	1225	980
					Fz	0.015	0.015	0.025	0.030	0.040	0.045	0.050	0.054	0.059	0.058	0.059
					FEED	490	368	490	490	490	441	408	331	321	284	231
M	STAINLESS STEELS(PH) 1.4594(Z7 CNU 15.05)		1	0.5	Vc	77 (62-92)										
					RPM	8170	6127	4902	4085	3064	2451	2042	1532	1362	1225	980
					Fz	0.020	0.020	0.025	0.041	0.045	0.050	0.055	0.060	0.064	0.065	0.068
					FEED	654	490	490	670	551	490	449	368	349	319	267
M	TITANIUM Ti6AL4V Ti5AL5V5MO Ti7AL4MO		0.3	0.5	Vc	47 (38-56)										
					RPM	4987	3740	2992	2493	1870	1496	1247	935	831	748	598
					Fz	0.018	0.018	0.022	0.037	0.040	0.045	0.049	0.054	0.058	0.058	0.061
					FEED	359	269	263	369	299	269	244	202	193	174	146
S	HIGH TEMPERATURE ALLOY INCONEL HASTELLOY, RENE		0.3	0.2	Vc	21 (17-25)										
					RPM	2228	1671	1337	1114	836	668	557	418	371	334	267
					Fz	0.014	0.014	0.017	0.028	0.031	0.035	0.038	0.042	0.045	0.045	0.048
					FEED	125	94	91	125	104	94	85	70	67	60	51