

# GT E4FL SERIES

## 4 Flute Square End Mill - Long Shank

### Feeds & Speeds

#### Micrograin Solid Carbide

HRC 55

Helix Angle 35



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Material	SS41, S45C, FC, FCD, SCr, SCM, SNCM, SK, SKD, PDS, YK30	SCr, SCN, SNC, SNCM, SKD, NAK101, PDS5, P20	SCr, SCM, SNC, SNCM, SKD, NAK, P20S, FDAC, SUS	Hardened Steels Titanium Alloys	Hardened Steels Nickle Alloys					
Hardness	~ HRC30		~ HRC30 - 35	~ HRC40 - 45	~ HRC45- 55					
Outside Diameter	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed

#### Slot Milling

4mm	3200	120	1900	56	1700	51	1500	48	630	19
6mm	2650	150	1600	96	1450	83	1250	70	530	30
8mm	2000	150	1200	96	1100	83	950	70	400	30
10mm	1600	150	950	96	850	83	750	70	320	30
12mm	1300	145	800	96	720	83	650	70	270	30

Depth of Cut	ap = 0.10D					ap = 0.05D				

#### Side Milling

4mm	3200	150	1900	70	1700	64	1500	60	630	24
6mm	2650	190	1600	120	1450	104	1250	72	530	38
8mm	2000	190	1200	120	1100	104	950	88	400	38
10mm	1600	190	950	120	850	104	750	88	320	38
12mm	1300	180	800	120	720	104	650	88	270	38

Depth of Cut	ap = 2.5D ae = 0.05D					ap = 2.0D ae = 0.02D				

#### Notes:

Milling parameters shown above are a general guide. Different machines have different rigidities & spindle torques. Please adjust parameters as necessary to suit your machine

RPM: rev/min  
Feed: mm/min