

# GT E4F SERIES

## 4 Flute Square End Mill

### Feeds & Speeds

#### Micrograin Solid Carbide

HRC 55

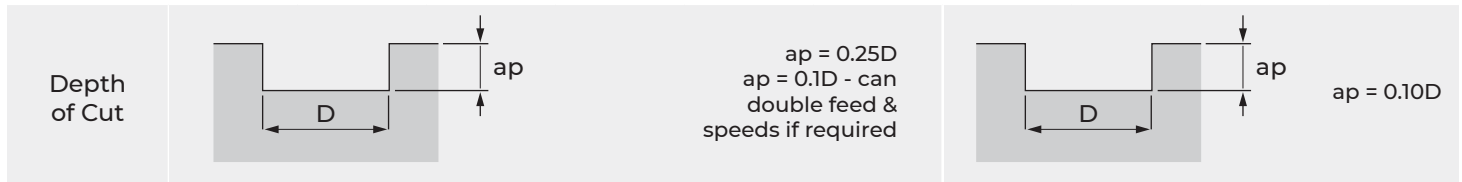
Helix Angle 35



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		~ HRC35 - 40		~ HRC40 - 45		~ HRC45- 55	
Outside Diameter	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed

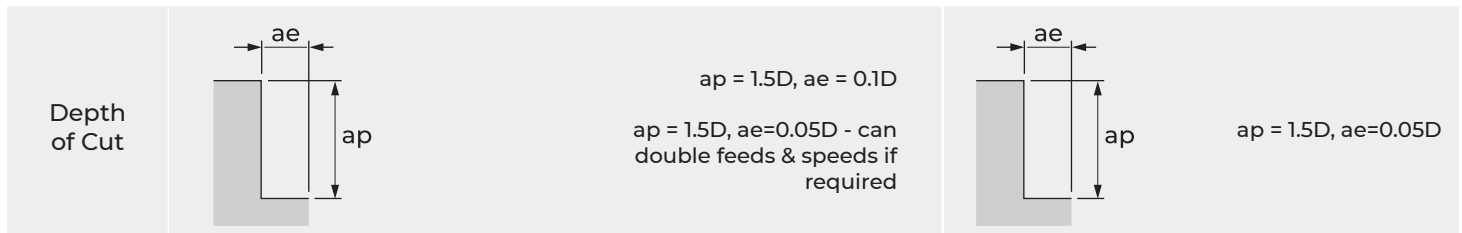
#### Slot Milling

1mm	16000	64	9500	40	8600	38	7600	36	3200	13
2mm	9500	88	5700	56	5100	50	4500	44	1900	19
3mm	7400	176	4500	110	4000	104	3600	90	1500	37
4mm	6400	300	3800	145	3400	130	3000	120	1270	48
5mm	5700	300	3400	180	3000	160	2700	145	1150	60
6mm	5300	380	3200	230	2900	210	2500	180	1060	75
8mm	4000	380	2400	230	2200	210	1900	180	800	75
10mm	3200	380	1900	230	1650	210	1500	180	640	75
12mm	2600	370	1600	230	1450	210	1300	180	530	75



#### Side Milling

1mm	16000	80	9500	50	8600	48	7600	40	3200	16
2mm	9500	100	5700	70	5100	62	4500	55	1900	23
3mm	7400	220	4500	140	4000	130	3600	110	1500	46
4mm	6400	370	3800	180	3400	160	3000	150	1270	60
5mm	5700	370	3400	220	3100	200	2700	180	1150	76
6mm	5300	480	3200	290	2900	260	2500	220	1060	96
8mm	4000	480	2400	290	2200	260	1900	220	800	96
10mm	3200	480	1900	290	1650	260	1500	220	640	96
12mm	2600	460	1600	290	1450	260	1300	220	530	96



#### 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