

GT ER4FL SERIES

4 Flute Corner Radius - Long Shank

Feeds & Speeds



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Micrograin Carbide End Mills HRC 55

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	
	~ HRC30		~ HRC30 - 35		~ HRC35 - 40		~ HRC40 - 45		~ HRC45- 55	
Outside Diameter	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed
Slot Milling										
4mm	6400	570	5100	460	4100	370	3200	290	1600	145
6mm	6400	570	5100	460	4100	370	3200	290	1600	145
8mm	4800	570	3800	460	3100	370	2400	290	1200	145
10mm	3800	570	3000	460	2400	370	2000	290	1000	145
12mm	3200	480	2600	380	2100	310	1600	240	800	120
Depth of Cut	<p>$ap = 0.25D$ $ap = 0.10D$ - can double feeds & speeds if required</p>				<p>$ap = 0.10D$</p>					
Side Milling										
4mm	8000	950	6400	760	5100	600	4000	490	2000	240
6mm	8000	950	6400	760	5100	600	4000	490	2000	240
8mm	6000	950	4800	760	3850	600	3000	490	1500	240
10mm	4800	950	3800	760	3000	600	2400	490	1200	240
12mm	4000	800	3200	640	2600	500	2000	410	1000	200
Depth of Cut	<p>$ap = 1.5D$, $ae = 0.1D$ $ap = 1.5D$ under, $0.05D$ - can double feeds & speeds if required</p>									

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