

# GT ER4F SERIES

## 4 Flute Corner Radius

Feeds & Speeds



www.glotek.co.za

### Micrograin Carbide End Mills

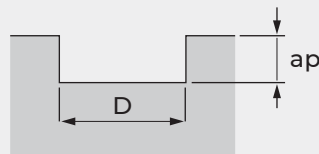
#### HRC 55

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	
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	120	4500	76	4000	68	3600	60	1500	25
4mm	6400	160	3800	96	3400	86	3000	80	1270	32
5mm	5700	200	3400	120	3100	116	2700	96	1150	40
6mm	5300	256	3200	152	2900	136	2500	120	2000	100
8mm	4000	256	2400	152	2200	136	1900	120	1500	100
10mm	3200	256	1900	152	1700	136	1500	120	1200	100
12mm	2600	250	1600	130	1450	120	1300	104	1050	85

Depth of Cut

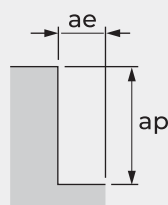


$$ap = 0.25D$$

#### Side Milling

1mm	16000	80	9500	50	8600	48	7600	40	3200	16
2mm	9500	110	5700	70	5100	62	4500	55	1900	23
3mm	7400	150	4500	95	4000	85	3600	75	1500	31
4mm	6400	200	3800	120	3400	107	3000	100	1270	40
5mm	5700	250	3400	150	3100	137	2700	120	1150	51
6mm	5300	320	3200	190	2900	170	2500	150	2000	120
8mm	4000	326	2400	190	2200	170	1900	150	1500	120
10mm	3200	320	1900	190	1700	170	1500	150	1200	120
12mm	2600	310	1600	160	1450	145	1300	130	1050	105

Depth of Cut



$$ap = 1.5D$$

$$ae = 0.05D$$

#### 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