■ GOmill GP • 2SE..IS-IR • 2 Flute • Short • Regular

Material Group		Side Milling (A) and Slotting (B)			KC633M Cutting Speed — vc SFM			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.														
		A		B				D1 — Diameter															
		ap	ae	ap	min		max	inch	1/64 .0156	1/32 .0313	1/16 .0625	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	460	–	620	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	0.5 x D	390	–	520	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	0.5 x D	300	–	490	IPT	.0001	.0002	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0001	.0002	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	360	–	460	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	0.5 x D	820	–	3250	IPT	.0002	.0003	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0001	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0001	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

■ GOmill GP • 2SE..IL • 2 Flute • Long

Material Group		Side Milling (A)		KC633M Cutting Speed — vc SFM			Recommended feed per tooth (IPT = inch/th) for side milling (A).														
		A						D1 — Diameter													
		ap	ae	min		max	inch	1/16 .0156	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	490	–	660	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	490	–	660	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	460	–	620	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	390	–	520	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	300	–	490	IPT	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	300	–	380	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	200	–	260	IPT	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	390	–	490	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	360	–	460	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	820	–	3250	IPT	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	820	–	2450	IPT	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	820	–	2450	IPT	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.