

■ GOmill • 3SE..IS-IR • 3 Flute • Short • Regular

Material Group					Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.																
	Side Milling (A) and Slotting (B)		KC633M		D1 – Diameter																
	A		B		Cutting Speed – vc SFM			frac.	1/32	1/16	5/64	3/32	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
	ap	ae	ap	min		max	dec.	.0031	.0625	.0781	.0938	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000	
P	0	2.0 x D	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	1	2.0 x D	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	0.5 x D	460	–	620	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	3	2.0 x D	0.1 x D	0.5 x D	390	–	520	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	2.0 x D	0.1 x D	0.5 x D	300	–	490	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0014	.0017	.0020	.0026	.0030	.0034	.0039
M	1	2.0 x D	0.1 x D	0.5 x D	300	–	380	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	2.0 x D	0.1 x D	0.5 x D	200	–	260	IPT	.0002	.0003	.0004	.0005	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	2.0 x D	0.1 x D	0.5 x D	390	–	490	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	0.5 x D	360	–	460	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0007	.0008	.0010	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.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 diameters >1/2".

■ GOmill • 3SE..IL • 3 Flute • Long

Material Group					Recommended feed per tooth (IPT = inch/th) for side milling (A).														
	Side Milling (A)		KC633M		D1 – Diameter														
	A		Cutting Speed – vc SFM			frac.	1/8	5/32	1/4	5/16	3/8	1/2	5/8	3/4	1				
	ap	ae	min		max	dec.	.1250	.1563	.2500	.3125	.3750	.5000	.6250	.7500	1.0000				
P	0	2.0 x D	0.1 x D	490	–	660	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049			
	1	2.0 x D	0.1 x D	490	–	660	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049			
	2	2.0 x D	0.1 x D	460	–	620	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049			
	3	2.0 x D	0.1 x D	390	–	520	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045			
	4	2.0 x D	0.1 x D	300	–	490	IPT	.0007	.0008	.0014	.0017	.0020	.0026	.0030	.0034	.0039			
M	1	2.0 x D	0.1 x D	300	–	380	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045			
	2	2.0 x D	0.1 x D	200	–	260	IPT	.0006	.0007	.0012	.0016	.0018	.0023	.0027	.0031	.0036			
K	1	2.0 x D	0.1 x D	390	–	490	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049			
	2	2.0 x D	0.1 x D	360	–	460	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045			
N	1	2.0 x D	0.1 x D	820	–	3250	IPT	.0013	.0016	.0025	.0031	.0038	.0050	.0063	.0075	.0100			
	2	2.0 x D	0.1 x D	820	–	2450	IPT	.0010	.0013	.0020	.0025	.0030	.0040	.0050	.0060	.0080			
	4	2.0 x D	0.1 x D	820	–	2450	IPT	.0011	.0014	.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 diameters >1/2".

