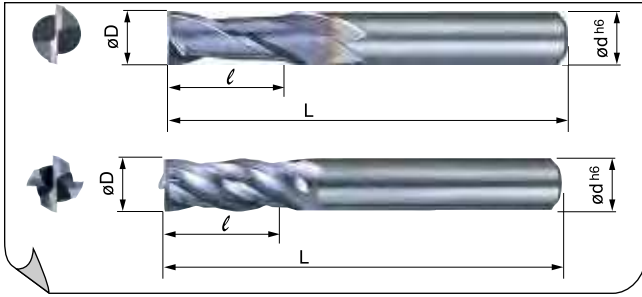


GS MILL Series GLM 2000/4000 SF Type

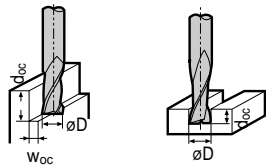
Coated carbide grade: ACZ20W



Endmills (mm)

No. of teeth	Cat. No.	Stock	øD	l	L	ød
2	GLM 2005 SF	▲	0,5	1,25	38	3
	GLM 2010 SF	▲	1,0	2,5	38	3
	GLM 2015 SF	▲	1,5	3,75	38	3
	GLM 2020 SF	▲	2,0	5,0	38	3
	GLM 2025 SF	▲	2,5	6,25	38	3
	GLM 2030 SF	▲	3,0	7,5	38	3
	GLM 2040 SF	▲	4,0	11,0	45	4
	GLM 2050 SF	▲	5,0	13,0	50	6
	GLM 2060 SF	▲	6,0	13,0	50	6
	GLM 2080 SF	▲	8,0	19,0	60	8
	GLM 2100 SF	▲	10,0	22,0	70	10
	GLM 2120 SF	▲	12,0	26,0	75	12

4	GLM 4010 SF	▲	1,0	2,5	38	3
	GLM 4020 SF	▲	2,0	5,0	38	3
	GLM 4030 SF	▲	3,0	7,5	38	3
	GLM 4040 SF	▲	4,0	11,0	45	4
	GLM 4050 SF	▲	5,0	13,0	50	6
	GLM 4060 SF	▲	6,0	13,0	50	6
	GLM 4080 SF	▲	8,0	19,0	60	8
	GLM 4100 SF	▲	10,0	22,0	70	10
	GLM 4120 SF	▲	12,0	26,0	75	12



Recommended cutting conditions

● GS Mill, 2 teeth square type endmill, GLM 2000SF

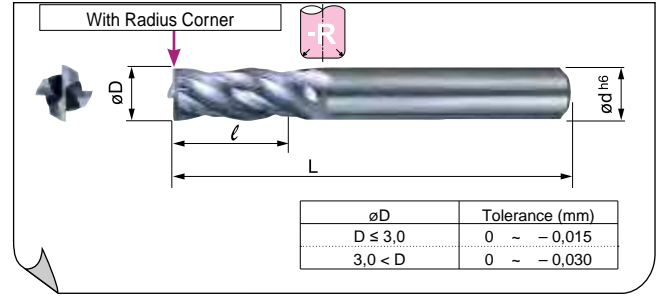
Material Cutting data Tool Dia. (mm)	Carbon steel, Cast iron (HB150~250)		Alloy steel, Prehardened steel (HRC25~35)		Heat treated alloy steel, hardened steel (HRC35~45)		Hardened steel (HRC45~55)		Stainless steel		Heat resistant alloys Titanium alloy	
	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)
	2	11.200	340	10.500	240	7.300	130	5.300	80	5.300	90	3.300
4	6.400	460	6.000	320	4.200	180	3.000	110	3.000	130	1.900	70
6	4.600	550	4.300	390	3.000	210	2.200	130	2.200	150	1.400	80
8	3.400	550	3.200	390	2.200	210	1.600	130	1.600	150	1.000	80
10	2.800	560	2.600	390	1.800	210	1.300	130	1.300	150	800	80
12	2.300	560	2.200	400	1.500	210	1.100	130	1.100	150	700	80
Shoulder cutting	d _{oc}		1,5D		0,05D		1,0D		1,5D		1,0D	
Slotting	d _{oc}		0,5D		0,2D		0,05D		0,3D		0,05D	

● GS Mill, 4 teeth square type endmill, GLM 4000SF

Material Cutting data Tool Dia. (mm)	Carbon steel, Cast iron (HB150~250)		Alloy steel, Prehardened steel (HRC25~35)		Heat treated alloy steel, hardened steel (HRC35~45)		Hardened steel (HRC45~55)		Stainless steel		Heat resistant alloys Titanium alloy	
	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)
	2	12.800	570	12.000	380	8.300	230	6.000	150	6.000	130	3.700
4	6.800	730	6.400	490	4.400	300	3.200	200	3.200	170	2.000	90
6	4.600	770	4.300	520	3.000	320	2.200	210	2.200	180	1.400	100
8	3.400	770	3.200	520	2.200	320	1.600	210	1.600	180	1.000	100
10	2.800	780	2.600	520	1.800	320	1.300	210	1.300	180	800	100
12	2.300	780	2.200	530	1.500	320	1.100	210	1.100	180	700	100
Shoulder cutting	d _{oc}		1,5D		0,05D		1,0D		1,5D		1,0D	
Slotting	d _{oc}		0,5D		0,2D		0,05D		0,3D		0,05D	

GS MILL Series GLM 4000SF-R Type

Coated carbide grade: ACZ20W



Endmills (mm)

No. of teeth	Cat. No.	Stock	øD	R	l	L	ød
4	GLM 4030 SF-R02	▲	3,0	0,2	7,5	38	3
	GLM 4030 SF-R05	▲	3,0	0,5	7,5	38	3
	GLM 4040 SF-R02	▲	4,0	0,2	11	45	4
	GLM 4040 SF-R05	▲	4,0	0,5	11	45	4
	GLM 4040 SF-R10	▲	4,0	1,0	11	45	4
	GLM 4050 SF-R02	▲	5,0	0,2	13	50	6
	GLM 4050 SF-R05	▲	5,0	0,5	13	50	6
	GLM 4050 SF-R10	▲	5,0	1,0	13	50	6
	GLM 4060 SF-R02	▲	6,0	0,2	13	50	6
	GLM 4060 SF-R05	▲	6,0	0,5	13	50	6
	GLM 4060 SF-R10	▲	6,0	1,0	13	50	6
	GLM 4060 SF-R15	▲	6,0	1,5	13	50	6
	GLM 4080 SF-R02	▲	8,0	0,2	19	60	8
	GLM 4080 SF-R05	▲	8,0	0,5	19	60	8
	GLM 4080 SF-R10	▲	8,0	1,0	19	60	8
	GLM 4080 SF-R15	▲	8,0	1,5	19	60	8
	GLM 4100 SF-R02	▲	10,0	0,2	22	70	10
	GLM 4100 SF-R05	▲	10,0	0,5	22	70	10
	GLM 4100 SF-R10	▲	10,0	1,0	22	70	10
	GLM 4100 SF-R15	▲	10,0	1,5	22	70	10
	GLM 4100 SF-R20	▲	10,0	2,0	22	70	10
	GLM 4120 SF-R02	▲	12,0	0,2	26	75	12
	GLM 4120 SF-R05	▲	12,0	0,5	26	75	12
	GLM 4120 SF-R10	▲	12,0	1,0	26	75	12
GLM 4120 SF-R15	▲	12,0	1,5	26	75	12	
GLM 4120 SF-R20	▲	12,0	2,0	26	75	12	