



MILLING / Solid Carbide End Mills

GM series for general machining

2-flute ball nose end mills with straight shank



Profile



Cavity

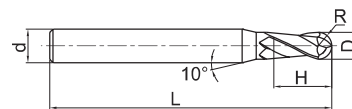


Ball nose slot

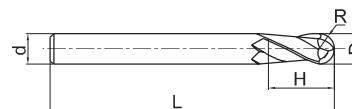
GM-2B



- For profile milling, high speed machining applicable.
- Wide application.



Picture 1



Picture 2

Type	Basic dimension(mm)					Number of teeth Z	Geometry
	D	R	d	H	L		
GM-2B-R0.5S	1.0	0.5	4	2	50	2	Picture 1
GM-2B-R0.5	1.0	0.5	6	2	50	2	Picture 1
GM-2B-R0.75S	1.5	0.75	4	3	50	2	Picture 1
GM-2B-R0.75	1.5	0.75	6	3	50	2	Picture 1
GM-2B-R1.0F	2.0	1.0	3	4	50	2	Picture 1
GM-2B-R1.0S	2.0	1.0	4	4	50	2	Picture 1
GM-2B-R1.0	2.0	1.0	6	4	50	2	Picture 1
GM-2B-R1.25F	2.5	1.25	3	5	50	2	Picture 1
GM-2B-R1.25S	2.5	1.25	4	5	50	2	Picture 1
GM-2B-R1.25	2.5	1.25	6	5	50	2	Picture 1
GM-2B-R1.5F	3.0	1.5	3	6	50	2	Picture 2
GM-2B-R1.5S	3.0	1.5	4	6	50	2	Picture 1
GM-2B-R1.5	3.0	1.5	6	6	50	2	Picture 1
GM-2B-R1.75S	3.5	1.75	4	8	50	2	Picture 1
GM-2B-R1.75	3.5	1.75	6	8	50	2	Picture 1
GM-2B-R2.0S	4.0	2.0	4	8	50	2	Picture 2
GM-2B-R2.0	4.0	2.0	6	8	50	2	Picture 1
GM-2B-R2.5	5.0	2.5	6	10	50	2	Picture 1
GM-2B-R2.75	5.5	2.75	6	12	50	2	Picture 1
GM-2B-R3.0	6.0	3.0	6	12	50	2	Picture 2
GM-2B-R3.5	7.0	3.5	8	14	60	2	Picture 1
GM-2B-R4.0	8.0	4.0	8	16	60	2	Picture 2
GM-2B-R4.5	9.0	4.5	10	18	75	2	Picture 1
GM-2B-R5.0	10.0	5.0	10	20	75	2	Picture 2
GM-2B-R6.0	12.0	6.0	12	24	75	2	Picture 2
GM-2B-R7.0	14.0	7.0	14	28	75	2	Picture 2
GM-2B-R8.0	16.0	8.0	16	32	100	2	Picture 2
GM-2B-R10.0	20.0	10.0	20	40	100	2	Picture 2

➤ Applicable workpiece material table ⊙Very suitable ⊙Suitable

Workpiece material											
Carbon steel	Alloy steel	Pre-hardened steel、Hardened steel				Stainless steel	Cast iron, Nodular cast iron	Copper alloy	Aluminum alloy	Titanium alloy	Heat resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

Code key

B258

Graphics category and identification

B259

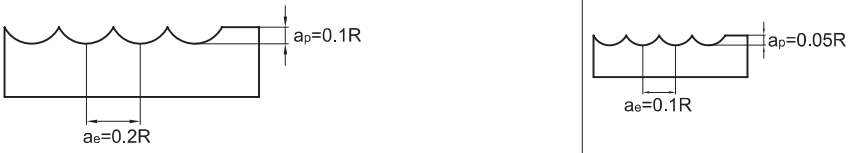
Cutting parameters

B515

Non-standard customization

B570-B571

GM-2B★GM-2BL/M/X★GM-2BFP

Workpiece material	Cast iron, Nodular cast iron		Carbon steel, Alloy steel ~750N/mm ²		Carbon steel, Alloy steel ~30HRC		Pre-hardened steel, quenched and tempered steel ~40HRC		Stainless steel		Pre-hardened steel, quenched and tempered steel ~50HRC	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
R0.5	40000	800	40000	800	38000	700	32000	320	22300	200	25000	275
R1.0	24000	900	24000	900	19000	760	16000	400	11150	230	13000	275
R1.5	15500	950	15500	950	12750	760	10600	450	7400	290	8500	280
R2.0	11500	950	11500	950	9550	760	8000	550	5550	370	6500	370
R2.5	9500	1050	9500	1050	7650	800	6400	550	4450	370	5000	375
R3.0	8000	1050	8000	1050	6400	800	5300	580	3700	390	4200	390
R4.0	6000	1300	6000	1300	4800	950	4000	700	2750	455	3200	440
R5.0	4800	1200	4800	1200	3800	900	3200	650	2200	430	2500	440
R6.0	4000	1100	4000	1100	3200	840	2650	610	1850	430	2100	420
R8.0	3000	1050	3000	1050	2400	800	2000	600	1350	380	1600	375
R10.0	2400	950	2400	950	1900	680	1600	560	1100	370	1250	330
Maximum cutting depth												

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
4. Make overhang of tool as short as possible in conditions of non-interference.

