

# TuffCut® GP-GX

## Recommended Cutting Data - Inch

TuffCut® GP-GX																	
Workpiece Material Group	ISO	Coolant			Application	Depth of Cut Per Application		vc - SFM	End Mill Diameter (inch)								
		• Preferred ○ Possible x Not Possible				Radial (Ae)	Axial (Ap)		.062	.078	.093	.125	.156	.187	.250	.375	.500
		Max.	Air	MMS					fz - in/tooth by Cutter Diameter								
Aluminum > 10% Si	N	•	X	○	Slotting	-	≤ .25 x D	800	.0003	.0004	.0005	.0006	.0008	.0009	.0013	.0019	.0025
					Profiling	.2 x D	Max.	1200	.0006	.0008	.0009	.0013	.0016	.0019	.0025	.0038	.0050
Graphite	N	○	•	○	Slotting	-	≤ 1.5 x D	1200	.0006	.0008	.0009	.0013	.0016	.0019	.0025	.0038	.0050
					Profiling	.5 x D	Max.	1500	.0010	.0012	.0015	.0020	.0025	.0030	.0040	.0060	.0080
Composites	N	○	•	○	Slotting	-	≤ 1 x D	600	.0003	.0004	.0005	.0006	.0008	.0009	.0013	.0019	.0025
					Profiling	.2 x D	Max.	800	.0005	.0006	.0007	.0010	.0012	.0015	.0020	.0030	.0040

**Note:**

- Cutting data is for tools with a flute length that is ≤ 3xD, and for tools with a neck length that is ≤ 5xD.
- Cutting conditions may need to be reduced for tools that exceed these limits.

**Safety Note**

Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.



**For More Information Contact:**

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Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula: (Calculated Feed x Spindle Maximum)/Calculated Speed. Above 20,000 RPM, tool balancing required.

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.