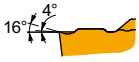
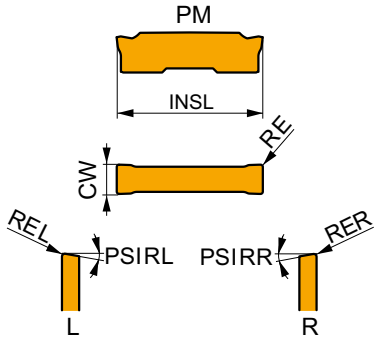
Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

Product		RE	P						M						K						N						S						H					
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap	
		[mm]	[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]	
																																						
			MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.																																			
GL3-D300MM0-MM	**G8330**	1.5	■	210	0.20	1.2	■	125	0.18	1.2	■	195	0.20	1.2	–	–	–	◪	50	0.14	1.0	–	–	–
	T7325	1.5	◪	240	0.20	1.2	■	185	0.18	1.2		–	–	–	–	–	–	◪	75	0.14	1.0	–	–	–
GL4-D400MM0-MM	**G8330**	2.0	■	220	0.20	1.2	■	130	0.18	1.2	■	205	0.20	1.2	–	–	–	◪	55	0.14	1.0	–	–	–
	T7325	2.0	◪	250	0.20	1.2	■	195	0.18	1.2		–	–	–	–	–	–	◪	80	0.14	1.0	–	–	–
GL5-D500MM0-MM	**G8330**	2.5	■	205	0.25	1.2	■	120	0.23	1.2	■	190	0.25	1.2	–	–	–	◪	50	0.18	1.0	–	–	–
	T7325	2.5	◪	235	0.25	1.2	■	180	0.23	1.2		–	–	–	–	–	–	◪	75	0.18	1.0	–	–	–
GL6-D600MM0-MM	**G8330**	3.0	■	195	0.30	1.2	■	115	0.27	1.2	■	185	0.30	1.2	–	–	–	◪	45	0.21	1.0	–	–	–
	T7325	3.0	◪	220	0.30	1.2	■	170	0.27	1.2		–	–	–	–	–	–	◪	70	0.21	1.0	–	–	–

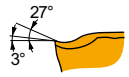
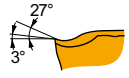
GL. D - PM

PRAMET

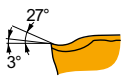
	CW	CWTOLL	CWTOLU	INSL
	[mm]	[mm]	[mm]	[mm]
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			PSIRR	PSIRL
			vc		f	vc		f	vc		f	vc		f	vc		f	vc		f		
		[mm]	[m/min]		[mm/rev]	[m/min]		[mm/rev]	[m/min]		[mm/rev]	[m/min]		[mm/rev]	[m/min]		[mm/rev]	[m/min]		[mm/rev]	[°]	[°]
																						
			PM geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.																			
GL2-D200M02-PM	**G8330**	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	–	–	◪	30	0.06	–	–		–	–
	T7325	0.2	◪	150	0.08	■	115	0.07		–	–	–	–	◪	45	0.06	–	–		–	–
GL3-D250G02-PM	**G8330**	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	–	–	◪	30	0.07	–	–		–	–
GL3-D300M02-PM	**G8330**	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	–	–	◪	30	0.07	–	–		–	–
	T7325	0.2	◪	150	0.10	■	115	0.09		–	–	–	–	◪	45	0.07	–	–		–	–
GL4-D400M02-PM	**G8330**	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	–	–	◪	30	0.10	–	–		–	–
	T7325	0.2	◪	150	0.12	■	115	0.11		–	–	–	–	◪	45	0.10	–	–		–	–
GL5-D500M03-PM	**G8330**	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	–	–	◪	30	0.12	–	–		–	–
GL6-D600M03-PM	**G8330**	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	–	–	◪	30	0.12	–	–		–	–
																						
			R-PM right-handed geometry, first choice for parting-off, and continuous to slightly interrupted cuts.																			
GL2-D200G02R06-PM	**G8330**	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	–	–	◪	30	0.06	–	–		6	–
	T7325	0.2	◪	150	0.08	■	115	0.07		–	–	–	–	◪	45	0.06	–	–		6	–
GL2-D200G02R12-PM	**G8330**	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	–	–	◪	30	0.06	–	–		12	–
GL3-D300G02R06-PM	**G8330**	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	–	–	◪	30	0.07	–	–		6	–
	T7325	0.2	◪	150	0.10	■	115	0.09		–	–	–	–	◪	45	0.07	–	–		6	–
GL3-D300G02R12-PM	**G8330**	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	–	–	◪	30	0.07	–	–		12	–
GL4-D400G02R06-PM	**G8330**	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	–	–	◪	30	0.10	–	–		6	–
	T7325	0.2	◪	150	0.12	■	115	0.11		–	–	–	–	◪	45	0.10	–	–		6	–
GL4-D400G02R12-PM	**G8330**	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	–	–	◪	30	0.10	–	–		12	–

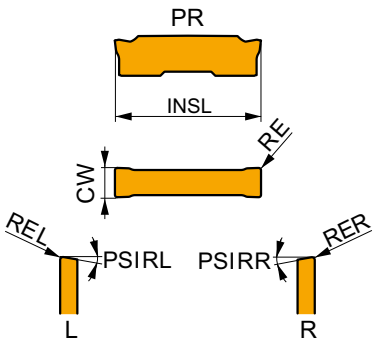
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P				M				K				N				S				H				PSIRR	PSIRL
			vc		f		vc		f		vc		f		vc		f		vc		f		vc		f			
		[mm]	[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[°]	[°]
																												
L-PM left-handed geometry, first choice for parting-off and continuous to slightly interrupted cuts.																												
GL2-D200G02L06-PM	**G8330**	0.2	130		0.08		75		0.07		120		0.08		–		–		30		0.06		–		–		–	6
	T7325	0.2	150		0.08		115		0.07		–		–		–		–		45		0.06		–		–		–	6
GL2-D200G02L12-PM	**G8330**	0.2	130		0.08		75		0.07		120		0.08		–		–		30		0.06		–		–		–	12
GL3-D300G02L06-PM	**G8330**	0.2	130		0.10		75		0.09		120		0.10		–		–		30		0.07		–		–		–	6
	T7325	0.2	150		0.10		115		0.09		–		–		–		–		45		0.07		–		–		–	6
GL3-D300G02L12-PM	**G8330**	0.2	130		0.10		75		0.09		120		0.10		–		–		30		0.07		–		–		–	12
GL4-D400G02L06-PM	**G8330**	0.2	130		0.12		75		0.11		120		0.12		–		–		30		0.10		–		–		–	6
	T7325	0.2	150		0.12		115		0.11		–		–		–		–		45		0.10		–		–		–	6
GL4-D400G02L12-PM	**G8330**	0.2	130		0.12		75		0.11		120		0.12		–		–		30		0.10		–		–		–	12

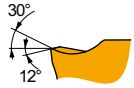
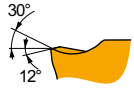
GL. D - PR

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	[mm]	[mm]	[mm]	[mm]
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P				M				K				N				S				H				PSIRR	PSIRL
			vc		f		vc		f		vc		f		vc		f		vc		f		vc		f			
		[mm]	[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[m/min]		[mm/rev]		[°]	[°]
																												
PR geometry, first choice for parting-off and grooving, and continuous to interrupted cuts.																												
GL2-D200M02-PR	**G8330**	0.2	130		0.10		75		0.09		120		0.10		–		–		–		–		–		–		–	–
	T7325	0.2	150		0.10		115		0.09		–		–		–		–		–		–		–		–		–	–
GL3-D300M02-PR	**G8330**	0.2	130		0.12		75		0.11		120		0.12		–		–		–		–		–		–		–	–
	T7325	0.2	150		0.12		115		0.11		–		–		–		–		–		–		–		–		–	–
GL4-D400M02-PR	**G8330**	0.2	130		0.15		75		0.14		120		0.15		–		–		–		–		–		–		–	–
	T7325	0.2	150		0.15		115		0.14		–		–		–		–		–		–		–		–		–	–
GL5-D500M04-PR	**G8330**	0.4	130		0.18		75		0.16		120		0.18		–		–		–		–		–		–		–	–
GL6-D600M04-PR	**G8330**	0.4	130		0.18		75		0.16		120		0.18		–		–		–		–		–		–		–	–
																												
R-PR right-handed geometry, first choice for parting-off, and continuous to interrupted cuts.																												
GL2-D200G02R06-PR	**G8330**	0.2	130		0.10		75		0.09		120		0.10		–		–		–		–		–		–		6	–
GL2-D200G02R12-PR	**G8330**	0.2	130		0.10		75		0.09		120		0.10		–		–		–		–		–		–		12	–
GL3-D300G02R06-PR	**G8330**	0.2	130		0.12		75		0.11		120		0.12		–		–		–		–		–		–		6	–
GL3-D300G02R12-PR	**G8330**	0.2	130		0.12		75		0.11		120		0.12		–		–		–		–		–		–		12	–
GL4-D400G02R06-PR	**G8330**	0.2	130		0.15		75		0.14		120		0.15		–		–		–		–		–		–		6	–
GL4-D400G02R12-PR	**G8330**	0.2	130		0.15		75		0.14		120		0.15		–		–		–		–		–		–		12	–