



metric

# G0mill™ PRO

SOLID CARBIDE  
END MILLS



**EXPLORE  
G0mill PRO**

# GOmill PRO SOLID CARBIDE END MILLS

Ideal for shops working in the general engineering, transportation, energy and medical industries, GOmill PRO serves as a do-it-all end mill where price, performance and versatility meet for next level operations.

## Your Go-To End Mill for Price, Performance & Versatility

Kennametal's 4-flute GOmill PRO Solid Carbide End Mills are a go-to solution for small and medium sized shops. Designed for side and shoulder milling, helical milling, pocketing, slotting and shallow ramping, GOmill PRO delivers affordability, versatility and high performance for next level machining.



# Features & Benefits

- Asymmetric divided flutes for better vibration control and tool life and smoother cutting
- Variable helix angle for better vibration control and tool life
- Tapered core for better chip evacuation and tool strength
- Multilayer TiN/TiAlN coating for high performance with medium-high cutting on steels, stainless steels and cast iron
- Special relief design for higher edge strength, better vibration control and workpiece material flexibility

## Product

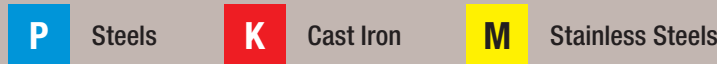
Cutting Diameter	Length of Cut	Grade	End Face Styles	Shank Styles
1,5 – 25mm	1xD – 5xD	KCU20	Square End, Chamfer, Radius, Ball Nose	Weldon® & Cylindrical Shanks

## Applications



## Materials

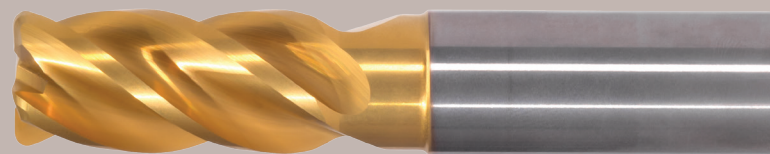
PRIMARY



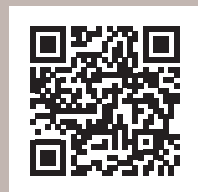
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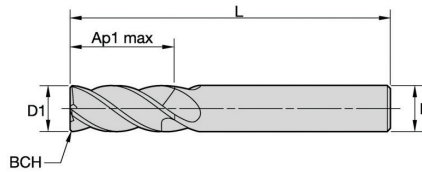


## Industries



EXPLORE  
GOmill PRO





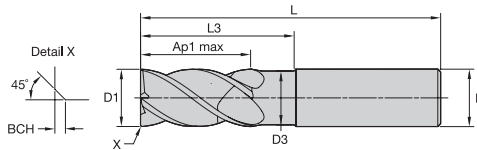
**GOmill PRO • Chamfered • 4 Flutes • Plain Shank**

● Primary  
○ Secondary

**KCU20**

P	●
M	●
K	●
N	●
S	○
H	○

Catalog Number	D1	D	AP1 Max	L	BCH	KCU20
GOPR4CH0300R008HAM	3,00	6,00	8,00	57,00	0,15	7231597
GOPR4CH0400R011HAM	4,00	6,00	11,00	57,00	0,15	7231599
GOPR4CH0500R013HAM	5,00	6,00	13,00	57,00	0,15	7231601
GOPR4CH0600R013HAM	6,00	6,00	13,00	57,00	0,15	7231603
GOPR4CH0600X032HAM	6,00	6,00	32,00	76,00	0,15	7231605
GOPR4CH0700R019HAM	7,00	8,00	19,00	63,00	0,15	7231606
GOPR4CH0800R019HAM	8,00	8,00	19,00	63,00	0,20	7231676
GOPR4CH0800L032HAM	8,00	8,00	32,00	87,00	0,20	7231678
GOPR4CH0900R022HAM	9,00	10,00	22,00	72,00	0,20	7231679
GOPR4CH1000R022HAM	10,00	10,00	22,00	72,00	0,20	7231680
GOPR4CH1000L038HAM	10,00	10,00	38,00	89,00	0,20	7231712
GOPR4CH1200R026HAM	12,00	12,00	26,00	83,00	0,20	7231713
GOPR4CH1200L051HAM	12,00	12,00	51,00	100,00	0,20	7231715
GOPR4CH1400S026HAM	14,00	14,00	26,00	83,00	0,35	7231716
GOPR4CH1600R032HAM	16,00	16,00	32,00	92,00	0,35	7231718
GOPR4CH1600L057HAM	16,00	16,00	57,00	125,00	0,35	7231721
GOPR4CH2000S038HAM	20,00	20,00	38,00	104,00	0,35	7231722
GOPR4CH2000R057HAM	20,00	20,00	57,00	125,00	0,35	7231724
GOPR4CH2500S045HAM	25,00	25,00	45,00	121,00	0,35	7231726



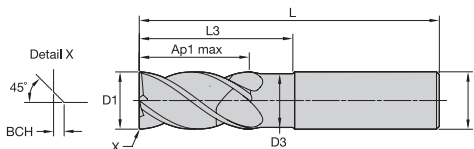
**GOmill PRO • Chamfered • 4 Flutes • Necked • Plain Shank**

● Primary  
○ Secondary

**KCU20**

P	●
M	●
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	Catalog Number	D1	D	D3	AP1 Max	L	L3	BCH	KCU20
<b>NEW</b>	GOPR4CH0150N004HAM	1,50	6,00	1,40	4,00	57,00	8,00	0,15	7378493
<b>NEW</b>	GOPR4CH0150N005HAM	1,50	6,00	1,40	5,00	57,00	11,00	0,15	7378531
<b>NEW</b>	GOPR4CH0200N004HAM	2,00	6,00	1,88	4,00	57,00	8,00	0,15	7378495
<b>NEW</b>	GOPR4CH0200N007HAM	2,00	6,00	1,88	7,00	57,00	11,00	0,15	7378533
<b>NEW</b>	GOPR4CH0300N004HAM	3,00	6,00	2,82	4,00	54,00	11,00	0,15	7378512
<b>NEW</b>	GOPR4CH0300N008HAM	3,00	6,00	2,82	8,00	57,00	15,00	0,15	7378496
<b>NEW</b>	GOPR4CH0300N010HAM	3,00	6,00	2,82	10,00	57,00	16,00	0,15	7378535
<b>NEW</b>	GOPR4CH0400N005HAM	4,00	6,00	3,76	5,00	57,00	15,00	0,15	7378514
<b>NEW</b>	GOPR4CH0400N011HAM	4,00	6,00	3,76	11,00	57,00	16,00	0,15	7378497
<b>NEW</b>	GOPR4CH0400N013HAM	4,00	6,00	3,76	13,00	57,00	17,00	0,15	7378537
<b>NEW</b>	GOPR4CH0500N006HAM	5,00	6,00	4,70	6,00	57,00	17,00	0,15	7378516
<b>NEW</b>	GOPR4CH0500N013HAM	5,00	6,00	4,70	13,00	57,00	18,00	0,15	7378498
<b>NEW</b>	GOPR4CH0500N016HAM	5,00	6,00	4,70	16,00	57,00	20,00	0,15	7378539
<b>NEW</b>	GOPR4CH0600N007HAM	6,00	6,00	5,64	7,00	57,00	19,00	0,15	7378518
<b>NEW</b>	GOPR4CH0600N012HAM	6,00	6,00	5,64	12,00	100,00	42,00	0,15	7378483
<b>NEW</b>	GOPR4CH0600N013HAM	6,00	6,00	5,64	13,00	57,00	21,00	0,15	7378499
<b>NEW</b>	GOPR4CH0600N019HAM	6,00	6,00	5,64	19,00	63,00	27,00	0,15	7378541
<b>NEW</b>	GOPR4CH0800N009HAM	8,00	8,00	7,52	9,00	58,00	20,00	0,20	7378520
<b>NEW</b>	GOPR4CH0800N016HAM	8,00	8,00	7,52	16,00	100,00	62,00	0,20	7378484
<b>NEW</b>	GOPR4CH0800N019HAM	8,00	8,00	7,52	19,00	63,00	27,00	0,20	7378500
<b>NEW</b>	GOPR4CH0800N025HAM	8,00	8,00	7,52	25,00	76,00	34,00	0,20	7378543
<b>NEW</b>	GOPR4CH1000N011HAM	10,00	10,00	9,40	11,00	66,00	24,00	0,20	7378522
<b>NEW</b>	GOPR4CH1000N020HAM	10,00	10,00	9,40	20,00	100,00	60,00	0,20	7378485
<b>NEW</b>	GOPR4CH1000N022HAM	10,00	10,00	9,40	22,00	72,00	32,00	0,20	7378501



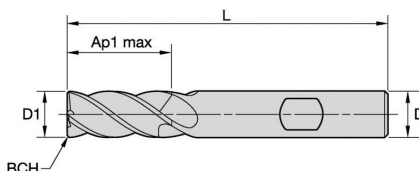
**KCU20**

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**GOmill PRO • Chamfered • 4 Flutes • Necked • Plain Shank • Continued**

- Primary
- Secondary

	Catalog Number	D1	D	D3	AP1 Max	L	L3	BCH	KCU20
NEW	GOPR4CH1000N031HAM	10,00	10,00	9,40	31,00	89,00	45,00	0,20	7378545
NEW	GOPR4CH1200N014HAM	12,00	12,00	11,28	14,00	76,00	30,00	0,20	7378524
NEW	GOPR4CH1200N024HAM	12,00	12,00	11,25	24,00	150,00	73,00	0,20	7378486
NEW	GOPR4CH1200N026HAM	12,00	12,00	11,28	26,00	83,00	38,00	0,20	7378502
NEW	GOPR4CH1200N036HAM	12,00	12,00	11,28	36,00	100,00	48,00	0,20	7378547
NEW	GOPR4CH1600N018HAM	16,00	16,00	15,04	18,00	82,00	34,00	0,35	7378526
NEW	GOPR4CH1600N032HAM	16,00	16,00	15,04	32,00	92,00	44,00	0,35	7378504
NEW	GOPR4CH1600E032HAM	16,00	16,00	15,04	32,00	150,00	100,00	0,35	7378487
NEW	GOPR4CH1600N048HAM	16,00	16,00	15,04	48,00	110,00	60,00	0,35	7378549
NEW	GOPR4CH1800N035HAM	18,00	18,00	16,92	35,00	100,00	53,00	0,35	7378505
NEW	GOPR4CH2000N022HAM	20,00	20,00	18,80	22,00	92,00	40,00	0,35	7378528
NEW	GOPR4CH2000N038HAM	20,00	20,00	18,80	38,00	104,00	53,00	0,35	7378506
NEW	GOPR4CH2000N060HAM	20,00	20,00	18,80	60,00	125,00	75,00	0,35	7378582
NEW	GOPR4CH2500N045HAM	25,00	25,00	23,50	45,00	121,00	65,00	0,35	7378507



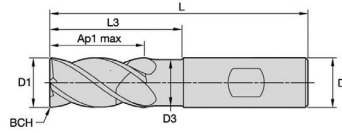
**KCU20**

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**GOmill PRO • Chamfered • 4 Flutes • Weldon Shank**

- Primary
- Secondary

	Catalog Number	D1	D	AP1 Max	L	BCH	KCU20
	GOPR4CH0300R008HBM	3,00	6,00	8,00	57,00	0,15	7231598
	GOPR4CH0400R011HBM	4,00	6,00	11,00	57,00	0,15	7231600
	GOPR4CH0500R013HBM	5,00	6,00	13,00	57,00	0,15	7231602
	GOPR4CH0600R013HBM	6,00	6,00	13,00	57,00	0,15	7231604
	GOPR4CH0800R019HBM	8,00	8,00	19,00	63,00	0,20	7231677
	GOPR4CH1000R022HBM	10,00	10,00	22,00	72,00	0,20	7231711
	GOPR4CH1200R026HBM	12,00	12,00	26,00	83,00	0,20	7231714
	GOPR4CH1400S026HBM	14,00	14,00	26,00	83,00	0,35	7231717
	GOPR4CH1600R032HBM	16,00	16,00	32,00	92,00	0,35	7231719
	GOPR4CH2000S038HBM	20,00	20,00	38,00	104,00	0,35	7231723



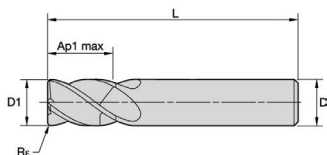
**GOmill PRO • Chamfered • 4 Flutes • Necked • Weldon Shank**

● Primary  
○ Secondary

**KCU20**

P	●
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N	●
S	○
H	○

	Catalog Number	D1	D	D3	AP1 Max	L	L3	BCH	KCU20
NEW	GOPR4CH0150N004HBM	1,50	6,00	1,40	4,00	57,00	8,00	0,15	7378494
NEW	GOPR4CH0150N005HBM	1,50	6,00	1,40	5,00	57,00	11,00	0,15	7378532
	GOPR4CH0200N006HBM	2,00	6,00	1,88	4,00	57,00	8,00	0,15	7230995
NEW	GOPR4CH0200N007HBM	2,00	6,00	1,88	7,00	57,00	11,00	0,15	7378534
NEW	GOPR4CH0200N008HBM	2,00	6,00	1,88	8,00	63,00	16,00	0,15	7378832
NEW	GOPR4CH0200N010HBM	2,00	6,00	1,88	10,00	63,00	18,00	0,15	7378630
NEW	GOPR4CH0300N004HBM	3,00	6,00	2,82	4,00	54,00	11,00	0,15	7378513
	GOPR4CH0300N008HBM	3,00	6,00	2,82	8,00	57,00	15,00	0,15	7231184
NEW	GOPR4CH0300N010HBM	3,00	6,00	2,82	10,00	57,00	16,00	0,15	7378536
NEW	GOPR4CH0300N012HBM	3,00	6,00	2,82	12,00	63,00	18,00	0,15	7378833
NEW	GOPR4CH0300N015HBM	3,00	6,00	2,82	15,00	63,00	21,00	0,15	7378851
	GOPR4CH0400N011HBM	4,00	6,00	3,76	11,00	57,00	16,00	0,15	7231185
NEW	GOPR4CH0400N005HBM	4,00	6,00	3,76	5,00	57,00	15,00	0,15	7378515
NEW	GOPR4CH0400N013HBM	4,00	6,00	3,76	13,00	57,00	17,00	0,15	7378538
NEW	GOPR4CH0400N016HBM	4,00	6,00	3,76	16,00	63,00	21,00	0,15	7378834
NEW	GOPR4CH0400N020HBM	4,00	6,00	3,76	20,00	63,00	24,00	0,15	7378852
NEW	GOPR4CH0500N006HBM	5,00	6,00	4,70	6,00	57,00	17,00	0,15	7378517
	GOPR4CH0500N013HBM	5,00	6,00	4,70	13,00	57,00	18,00	0,15	7231186
NEW	GOPR4CH0500N016HBM	5,00	6,00	4,70	16,00	57,00	20,00	0,15	7378540
NEW	GOPR4CH0500N020HBM	5,00	6,00	4,70	20,00	63,00	25,00	0,15	7378835
NEW	GOPR4CH0500N025HBM	5,00	6,00	4,70	25,00	76,00	35,00	0,15	7378853
NEW	GOPR4CH0600N007HBM	6,00	6,00	5,64	7,00	57,00	19,00	0,15	7378519
	GOPR4CH0600N013HBM	6,00	6,00	5,64	13,00	57,00	21,00	0,15	7231187
NEW	GOPR4CH0600N019HBM	6,00	6,00	5,64	19,00	63,00	27,00	0,15	7378542
NEW	GOPR4CH0600N024HBM	6,00	6,00	5,64	24,00	76,00	30,00	0,15	7378836
NEW	GOPR4CH0600N030HBM	6,00	6,00	5,64	30,00	76,00	38,00	0,15	7378854
NEW	GOPR4CH0800N009HBM	8,00	8,00	7,52	9,00	58,00	20,00	0,20	7378521
	GOPR4CH0800N019HBM	8,00	8,00	7,52	19,00	63,00	27,00	0,20	7231188
NEW	GOPR4CH0800N025HBM	8,00	8,00	7,52	25,00	76,00	34,00	0,20	7378544
NEW	GOPR4CH0800N032HBM	8,00	8,00	7,52	32,00	76,00	40,00	0,20	7378837
NEW	GOPR4CH0800N040HBM	8,00	8,00	7,52	40,00	87,00	48,00	0,20	7378855
NEW	GOPR4CH1000N011HBM	10,00	10,00	9,40	11,00	66,00	24,00	0,20	7378523
	GOPR4CH1000N022HBM	10,00	10,00	9,40	22,00	72,00	32,00	0,20	7231189
NEW	GOPR4CH1000N031HBM	10,00	10,00	9,40	31,00	89,00	45,00	0,20	7378546
NEW	GOPR4CH1000N040HBM	10,00	10,00	9,40	40,00	89,00	50,00	0,20	7378838
NEW	GOPR4CH1000N050HBM	10,00	10,00	9,40	50,00	100,00	60,00	0,20	7378856
NEW	GOPR4CH1200N014HBM	12,00	12,00	11,28	14,00	76,00	30,00	0,20	7378525
	GOPR4CH1200N026HBM	12,00	12,00	11,28	26,00	83,00	38,00	0,20	7231190
NEW	GOPR4CH1200N036HBM	12,00	12,00	11,28	36,00	100,00	48,00	0,20	7378548
NEW	GOPR4CH1200N048HBM	12,00	12,00	11,28	48,00	100,00	55,00	0,20	7378839
NEW	GOPR4CH1200N060HBM	12,00	12,00	11,28	60,00	150,00	72,00	0,20	7378857
NEW	GOPR4CH1600N018HBM	16,00	16,00	15,04	18,00	82,00	34,00	0,35	7378527
NEW	GOPR4CH1600N022HBM	16,00	16,00	15,04	22,00	82,00	34,00	0,35	7378503
	GOPR4CH1600N032HBM	16,00	16,00	15,04	32,00	92,00	44,00	0,35	7231191
NEW	GOPR4CH1600N048HBM	16,00	16,00	15,04	48,00	110,00	60,00	0,35	7378550
NEW	GOPR4CH1600N064HBM	16,00	16,00	15,04	64,00	125,00	76,00	0,35	7378840
NEW	GOPR4CH1600N080HBM	16,00	16,00	15,04	80,00	141,00	92,00	0,35	7378858
NEW	GOPR4CH2000N022HBM	20,00	20,00	18,80	22,00	92,00	40,00	0,35	7378529
	GOPR4CH2000N038HBM	20,00	20,00	18,80	38,00	104,00	53,00	0,35	7231192
NEW	GOPR4CH2000N060HBM	20,00	20,00	18,80	60,00	125,00	75,00	0,35	7378583
NEW	GOPR4CH2000N080HBM	20,00	20,00	18,80	80,00	150,00	100,00	0,35	7378841
	GOPR4CH2500N045HBM	25,00	25,00	23,50	45,00	121,00	65,00	0,35	7231725



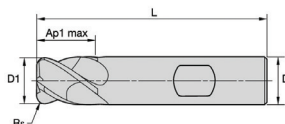
KCU20

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**GOmill PRO • Radiused • 4 Flutes • Plain Shank**

- Primary
- Secondary

	Catalog Number	D1	D	AP1 Max	L	Re	KCU20
NEW	GOPR4RA0300S004HAR020M	3,00	6,00	4,00	50,00	0,20	7378690
NEW	GOPR4RA0400S005HAR020M	4,00	6,00	5,00	50,00	0,20	7378932
NEW	GOPR4RA0500S006HAR040M	5,00	6,00	6,00	50,00	0,40	7378934
	GOPR4RA0600S007HAR040M	6,00	6,00	7,00	50,00	0,40	7231579
	GOPR4RA0800S010HAR040M	8,00	8,00	10,00	50,00	0,40	7231641
	GOPR4RA1000S012HAR040M	10,00	10,00	12,00	66,00	0,40	7231643
	GOPR4RA1200S015HAR050M	12,00	12,00	15,00	73,00	0,50	7231646
	GOPR4RA1600S020HAR050M	16,00	16,00	20,00	82,00	0,50	7231664
	GOPR4RA1600R035HAR050M	16,00	16,00	35,00	92,00	0,50	7231662
	GOPR4RA2000S025HAR050M	20,00	20,00	25,00	92,00	0,50	7231670
	GOPR4RA2000R042HAR050M	20,00	20,00	42,00	104,00	0,50	7231668
	GOPR4RA2500R052HAR050M	25,00	25,00	52,00	121,00	0,50	7231674



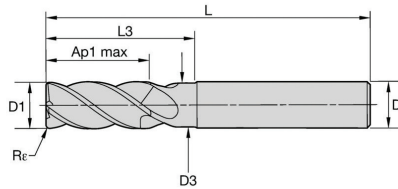
KCU20

P	●
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S	○
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**GOmill PRO • Radiused • 4 Flutes • Weldon Shank**

- Primary
- Secondary

	Catalog Number	D1	D	AP1 Max	L	Re	KCU20
NEW	GOPR4RA0300S004HBR020M	3,00	6,00	4,00	50,00	0,20	7378931
NEW	GOPR4RA0400S005HBR020M	4,00	6,00	5,00	50,00	0,20	7378933
NEW	GOPR4RA0500S006HBR040M	5,00	6,00	6,00	50,00	0,40	7378935
	GOPR4RA0600S007HBR040M	6,00	6,00	7,00	50,00	0,40	7231580
	GOPR4RA0800S010HBR040M	8,00	8,00	10,00	50,00	0,40	7231642
	GOPR4RA1000S012HBR040M	10,00	10,00	12,00	66,00	0,40	7231644
	GOPR4RA1200S015HBR050M	12,00	12,00	15,00	73,00	0,50	7231647
	GOPR4RA1600S020HBR050M	16,00	16,00	20,00	82,00	0,50	7231665
	GOPR4RA1600R035HBR050M	16,00	16,00	35,00	92,00	0,50	7231663
	GOPR4RA2000S025HBR050M	20,00	20,00	25,00	92,00	0,50	7231671
	GOPR4RA2000R042HBR050M	20,00	20,00	42,00	104,00	0,50	7231669
	GOPR4RA2500R052HBR050M	25,00	25,00	52,00	121,00	0,50	7231675



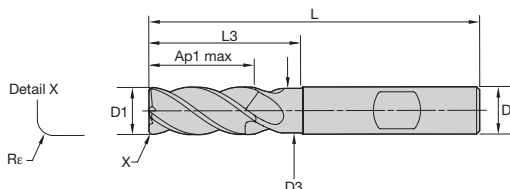
**G0mill PRO • Radiused • 4 Flutes • Necked • Plain Shank**

- Primary
- Secondary

**KCU20**

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	Catalog Number	D1	D	D3	AP1 Max	L	L3	Rε	KCU20
NEW	GOPR4RA0300N004HAR020M	3,00	6,00	2,82	4,00	50,00	7,00	0,20	7378942
	GOPR4RA0300N008HAR020M	3,00	6,00	2,82	8,00	57,00	15,00	0,20	7231153
NEW	GOPR4RA0400N005HAR020M	4,00	6,00	3,76	5,00	50,00	8,00	0,20	7378944
	GOPR4RA0400N011HAR020M	4,00	6,00	3,76	11,00	57,00	16,00	0,20	7231154
	GOPR4RA0400N011HAR050M	4,00	6,00	3,76	11,00	57,00	16,00	0,50	7231155
NEW	GOPR4RA0500N006HAR040M	5,00	6,00	4,70	6,00	57,00	18,00	0,40	7378946
	GOPR4RA0500N013HAR020M	5,00	6,00	4,70	13,00	57,00	18,00	0,20	7231156
	GOPR4RA0500N013HAR050M	5,00	6,00	4,70	13,00	57,00	18,00	0,50	7231157
	GOPR4RA0500N013HAR100M	5,00	6,00	4,70	13,00	57,00	18,00	1,00	7231158
NEW	GOPR4RA0600N007HAR040M	6,00	6,00	5,64	7,00	57,00	18,00	0,40	7378949
	GOPR4RA0600N013HAR050M	6,00	6,00	5,64	13,00	57,00	21,00	0,50	7231159
	GOPR4RA0600N013HAR100M	6,00	6,00	5,64	13,00	57,00	21,00	1,00	7231160
	GOPR4RA0600N013HAR150M	6,00	6,00	5,64	13,00	57,00	21,00	1,50	7231161
NEW	GOPR4RA0600N030HAR050M	6,00	6,00	5,64	30,00	76,00	36,00	0,50	7378873
NEW	GOPR4RA0600N030HAR100M	6,00	6,00	5,64	30,00	76,00	36,00	1,00	7378874
NEW	GOPR4RA0800N010HAR040M	8,00	8,00	7,52	10,00	63,00	24,00	0,40	7378951
	GOPR4RA0800N019HAR050M	8,00	8,00	7,52	19,00	63,00	27,00	0,50	7231163
	GOPR4RA0800N019HAR100M	8,00	8,00	7,52	19,00	63,00	27,00	1,00	7231164
	GOPR4RA0800N019HAR150M	8,00	8,00	7,52	19,00	63,00	27,00	1,50	7231165
	GOPR4RA0800N019HAR200M	8,00	8,00	7,52	19,00	63,00	27,00	2,00	7231166
NEW	GOPR4RA0800N032HAR050M	8,00	8,00	7,52	32,00	76,00	40,00	0,50	7378879
NEW	GOPR4RA0800N032HAR100M	8,00	8,00	7,52	32,00	76,00	40,00	1,00	7378880
NEW	GOPR4RA1000N012HAR040M	10,00	10,00	9,40	12,00	72,00	30,00	0,40	7378954
	GOPR4RA1000N022HAR050M	10,00	10,00	9,40	22,00	72,00	32,00	0,50	7231167
	GOPR4RA1000N022HAR100M	10,00	10,00	9,40	22,00	72,00	32,00	1,00	7231168
	GOPR4RA1000N022HAR150M	10,00	10,00	9,40	22,00	72,00	32,00	1,50	7231169
	GOPR4RA1000N022HAR200M	10,00	10,00	9,40	22,00	72,00	32,00	2,00	7231170
	GOPR4RA1000N022HAR250M	10,00	10,00	9,40	22,00	72,00	32,00	2,50	7231645
NEW	GOPR4RA1000N038HAR050M	10,00	10,00	9,40	38,00	89,00	44,00	0,50	7378886
NEW	GOPR4RA1000N038HAR100M	10,00	10,00	9,40	38,00	89,00	44,00	1,00	7378887
NEW	GOPR4RA1200N015HAR050M	12,00	12,00	11,28	15,00	83,00	36,00	0,50	7378956
	GOPR4RA1200N026HAR050M	12,00	12,00	11,28	26,00	83,00	38,00	0,50	7231171
	GOPR4RA1200N026HAR100M	12,00	12,00	11,28	26,00	83,00	38,00	1,00	7231172
	GOPR4RA1200N026HAR150M	12,00	12,00	11,28	26,00	83,00	38,00	1,50	7231173
	GOPR4RA1200N026HAR200M	12,00	12,00	11,28	26,00	83,00	38,00	2,00	7231174
	GOPR4RA1200N026HAR250M	12,00	12,00	11,28	26,00	83,00	38,00	2,50	7231648
	GOPR4RA1200N026HAR300M	12,00	12,00	11,28	26,00	83,00	38,00	3,00	7231649
	GOPR4RA1200N026HAR400M	12,00	12,00	11,28	26,00	83,00	38,00	4,00	7231175
NEW	GOPR4RA1200N050HAR050M	12,00	12,00	11,28	50,00	100,00	60,00	0,50	7378905
NEW	GOPR4RA1200N050HAR100M	12,00	12,00	11,28	50,00	100,00	60,00	1,00	7378906
	GOPR4RA1400N026HAR050M	14,00	14,00	13,16	26,00	89,00	40,00	0,50	7231650
	GOPR4RA1400N026HAR100M	14,00	14,00	13,16	26,00	89,00	40,00	1,00	7231661
NEW	GOPR4RA1600N020HAR050M	16,00	16,00	15,04	20,00	92,00	44,00	0,50	7378958
	GOPR4RA1600N032HAR050M	16,00	16,00	15,04	32,00	92,00	44,00	0,50	7231666
	GOPR4RA1600N032HAR100M	16,00	16,00	15,04	32,00	92,00	44,00	1,00	7231176
	GOPR4RA1600N032HAR200M	16,00	16,00	15,04	32,00	92,00	44,00	2,00	7231177
	GOPR4RA1600N032HAR250M	16,00	16,00	15,04	32,00	92,00	44,00	2,50	7231667
	GOPR4RA1600N032HAR300M	16,00	16,00	15,04	32,00	92,00	44,00	3,00	7231178
	GOPR4RA1600N032HAR400M	16,00	16,00	15,04	32,00	92,00	44,00	4,00	7231179
NEW	GOPR4RA1600N057HAR100M	16,00	16,00	15,04	57,00	125,00	69,00	1,00	7378915
NEW	GOPR4RA1600N057HAR200M	16,00	16,00	15,04	57,00	125,00	69,00	2,00	7378916
NEW	GOPR4RA2000N025HAR050M	20,00	20,00	18,80	25,00	125,00	60,00	0,50	7378960
	GOPR4RA2000N038HAR050M	20,00	20,00	18,80	38,00	104,00	53,00	0,50	7231672
	GOPR4RA2000N038HAR100M	20,00	20,00	18,80	38,00	104,00	53,00	1,00	7231180
	GOPR4RA2000N038HAR200M	20,00	20,00	18,80	38,00	104,00	53,00	2,00	7231181
	GOPR4RA2000N038HAR250M	20,00	20,00	18,80	38,00	104,00	53,00	2,50	7231673
	GOPR4RA2000N038HAR300M	20,00	20,00	18,80	38,00	104,00	53,00	3,00	7231182
	GOPR4RA2000N038HAR400M	20,00	20,00	18,80	38,00	104,00	53,00	4,00	7231183
NEW	GOPR4RA2000N057HAR100M	20,00	20,00	18,80	57,00	125,00	73,00	1,00	7378923
NEW	GOPR4RA2000N057HAR200M	20,00	20,00	18,80	57,00	125,00	73,00	2,00	7378924



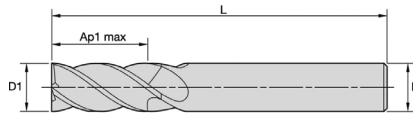
**KCU20**

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● Primary  
○ Secondary

**GOmill PRO • Radiused • 4 Flutes • Necked • Weldon Shank**

	Catalog Number	D1	D	D3	AP1 Max	L	L3	Rε	KCU20
NEW	GOPR4RA0300N004HBR020M	3,00	6,00	2,82	4,00	50,00	7,00	0,20	7378943
NEW	GOPR4RA0300N008HBR020M	3,00	6,00	2,82	8,00	57,00	15,00	0,20	7378793
NEW	GOPR4RA0400N005HBR020M	4,00	6,00	3,76	5,00	50,00	8,00	0,20	7378945
NEW	GOPR4RA0400N011HBR020M	4,00	6,00	3,76	11,00	57,00	16,00	0,20	7378794
NEW	GOPR4RA0400N011HBR050M	4,00	6,00	3,76	11,00	57,00	16,00	0,50	7378795
NEW	GOPR4RA0400N011HBR100M	4,00	6,00	3,76	11,00	57,00	21,00	1,00	7378796
NEW	GOPR4RA0500N006HBR040M	5,00	6,00	4,70	6,00	57,00	18,00	0,40	7378948
NEW	GOPR4RA0500N013HBR020M	5,00	6,00	4,70	13,00	57,00	18,00	0,20	7378797
NEW	GOPR4RA0500N013HBR050M	5,00	6,00	4,70	13,00	57,00	18,00	0,50	7378798
NEW	GOPR4RA0500N013HBR100M	5,00	6,00	4,70	13,00	57,00	18,00	1,00	7378799
NEW	GOPR4RA0600N007HBR040M	6,00	6,00	5,64	7,00	57,00	18,00	0,40	7378950
NEW	GOPR4RA0600N013HBR050M	6,00	6,00	5,64	13,00	57,00	21,00	0,50	7378800
NEW	GOPR4RA0600N013HBR100M	6,00	6,00	5,64	13,00	57,00	21,00	1,00	7378871
NEW	GOPR4RA0600N013HBR150M	6,00	6,00	5,64	13,00	57,00	21,00	1,50	7378872
NEW	GOPR4RA0800N010HBR040M	8,00	8,00	7,52	10,00	63,00	24,00	0,40	7378952
NEW	GOPR4RA0800N019HBR050M	8,00	8,00	7,52	19,00	63,00	27,00	0,50	7378875
NEW	GOPR4RA0800N019HBR100M	8,00	8,00	7,52	19,00	63,00	27,00	1,00	7378876
NEW	GOPR4RA0800N019HBR150M	8,00	8,00	7,52	19,00	63,00	27,00	1,50	7378877
NEW	GOPR4RA0800N019HBR200M	8,00	8,00	7,52	19,00	63,00	27,00	2,00	7378878
NEW	GOPR4RA1000N012HBR040M	10,00	10,00	9,40	12,00	72,00	30,00	0,40	7378955
NEW	GOPR4RA1000N022HBR050M	10,00	10,00	9,40	22,00	72,00	32,00	0,50	7378881
NEW	GOPR4RA1000N022HBR100M	10,00	10,00	9,40	22,00	72,00	32,00	1,00	7378882
NEW	GOPR4RA1000N022HBR150M	10,00	10,00	9,40	22,00	72,00	32,00	1,50	7378883
NEW	GOPR4RA1000N022HBR200M	10,00	10,00	9,40	22,00	72,00	32,00	2,00	7378884
NEW	GOPR4RA1000N022HBR250M	10,00	10,00	9,40	22,00	72,00	32,00	2,50	7378885
NEW	GOPR4RA1200N015HBR050M	12,00	12,00	11,28	15,00	83,00	36,00	0,50	7378957
NEW	GOPR4RA1200N026HBR050M	12,00	12,00	11,28	26,00	83,00	38,00	0,50	7378888
NEW	GOPR4RA1200N026HBR100M	12,00	12,00	11,28	26,00	83,00	38,00	1,00	7378889
NEW	GOPR4RA1200N026HBR150M	12,00	12,00	11,28	26,00	83,00	38,00	1,50	7378890
NEW	GOPR4RA1200N026HBR200M	12,00	12,00	11,28	26,00	83,00	38,00	2,00	7378901
NEW	GOPR4RA1200N026HBR250M	12,00	12,00	11,28	26,00	83,00	38,00	2,50	7378903
NEW	GOPR4RA1200N026HBR300M	12,00	12,00	11,28	26,00	83,00	38,00	3,00	7378904
NEW	GOPR4RA1200N026HBR400M	12,00	12,00	11,28	26,00	83,00	38,00	4,00	7378902
NEW	GOPR4RA1400N026HBR050M	14,00	14,00	13,16	26,00	89,00	40,00	0,50	7378907
NEW	GOPR4RA1400N026HBR100M	14,00	14,00	13,16	26,00	89,00	40,00	1,00	7378908
NEW	GOPR4RA1600N020HBR050M	16,00	16,00	15,04	20,00	92,00	44,00	0,50	7378959
NEW	GOPR4RA1600N032HBR050M	16,00	16,00	15,04	32,00	92,00	44,00	0,50	7378913
NEW	GOPR4RA1600N032HBR100M	16,00	16,00	15,04	32,00	92,00	44,00	1,00	7378909
NEW	GOPR4RA1600N032HBR200M	16,00	16,00	15,04	32,00	92,00	44,00	2,00	7378910
NEW	GOPR4RA1600N032HBR250M	16,00	16,00	15,04	32,00	92,00	44,00	2,50	7378914
NEW	GOPR4RA1600N032HBR300M	16,00	16,00	15,04	32,00	92,00	44,00	3,00	7378911
NEW	GOPR4RA1600N032HBR400M	16,00	16,00	15,04	32,00	92,00	44,00	4,00	7378912
NEW	GOPR4RA2000N025HBR050M	20,00	20,00	18,80	25,00	125,00	60,00	0,50	7378961
NEW	GOPR4RA2000N038HBR050M	20,00	20,00	18,80	38,00	104,00	53,00	0,50	7378921
NEW	GOPR4RA2000N038HBR100M	20,00	20,00	18,80	38,00	104,00	53,00	1,00	7378917
NEW	GOPR4RA2000N038HBR200M	20,00	20,00	18,80	38,00	104,00	53,00	2,00	7378918
NEW	GOPR4RA2000N038HBR250M	20,00	20,00	18,80	38,00	104,00	53,00	2,50	7378922
NEW	GOPR4RA2000N038HBR300M	20,00	20,00	18,80	38,00	104,00	53,00	3,00	7378919
NEW	GOPR4RA2000N038HBR400M	20,00	20,00	18,80	38,00	104,00	53,00	4,00	7378920



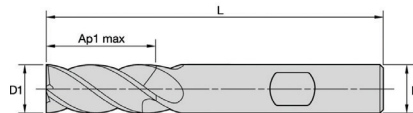
**KCU20**

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● Primary  
○ Secondary

**GOmill PRO • Square End • 4 Flutes • Plain Shank**

	Catalog Number	D1	D	AP1 Max	L	KCU20
<b>NEW</b>	GOPR4SE0150R006HAM	1,50	6,00	6,00	57,00	7378469
	GOPR4SE0200R006HAM	2,00	6,00	6,00	57,00	7230994
	GOPR4SE0300R008HAM	3,00	6,00	8,00	57,00	7231062
	GOPR4SE0400R011HAM	4,00	6,00	11,00	57,00	7231064
	GOPR4SE0500R013HAM	5,00	6,00	13,00	57,00	7231066
	GOPR4SE0600R013HAM	6,00	6,00	13,00	57,00	7231068
	GOPR4SE0800R019HAM	8,00	8,00	19,00	63,00	7231070
	GOPR4SE1000R022HAM	10,00	10,00	22,00	72,00	7231132
	GOPR4SE1000R025HAM	10,00	10,00	25,00	72,00	7231133
	GOPR4SE1200R026HAM	12,00	12,00	26,00	83,00	7231135
	GOPR4SE1200R030HAM	12,00	12,00	30,00	83,00	7231137
	GOPR4SE1400S026HAM	14,00	14,00	26,00	83,00	7231578
	GOPR4SE1600R032HAM	16,00	16,00	32,00	92,00	7231139
	GOPR4SE2000S038HAM	20,00	20,00	38,00	104,00	7231151



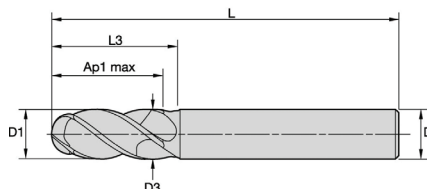
**KCU20**

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● Primary  
○ Secondary

**GOmill PRO • Square End • 4 Flutes • Weldon Shank**

	Catalog Number	D1	D	AP1 Max	L	KCU20
	GOPR4SE0300R008HBM	3,00	6,00	8,00	57,00	7231063
	GOPR4SE0400R011HBM	4,00	6,00	11,00	57,00	7231065
	GOPR4SE0500R013HBM	5,00	6,00	13,00	57,00	7231067
	GOPR4SE0600R013HBM	6,00	6,00	13,00	57,00	7231069
	GOPR4SE0800R019HBM	8,00	8,00	19,00	63,00	7231131
	GOPR4SE1000R022HBM	10,00	10,00	22,00	72,00	7231134
<b>NEW</b>	GOPR4SE1000R025HBM	10,00	10,00	25,00	72,00	7378470
	GOPR4SE1200R026HBM	12,00	12,00	26,00	83,00	7231136
<b>NEW</b>	GOPR4SE1200R030HBM	12,00	12,00	30,00	83,00	7378491
<b>NEW</b>	GOPR4SE1400R026HBM	14,00	14,00	26,00	83,00	7378492
	GOPR4SE1600R032HBM	16,00	16,00	32,00	92,00	7231140
	GOPR4SE2000S038HBM	20,00	20,00	38,00	104,00	7231152

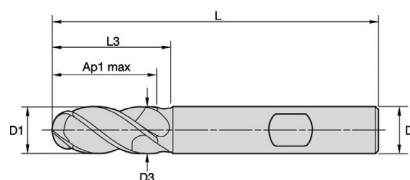


**GOmill PRO • Ball Nose • 4 Flutes • Necked • Plain Shank**

● Primary  
○ Secondary

KCU20	P	●
	M	●
	K	●
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Catalog Number	D1	D	D3	AP1 Max	L	L3	KCU20
GOPR4BN0500R013HAM	5,00	6,00	4,70	13,00	57,00	18,00	7231264
GOPR4BN0600R013HAM	6,00	6,00	5,64	13,00	57,00	21,00	7231266
GOPR4BN0800R019HAM	8,00	8,00	7,52	19,00	63,00	27,00	7231268
GOPR4BN1000R022HAM	10,00	10,00	9,40	22,00	72,00	32,00	7231270
GOPR4BN1200R026HAM	12,00	12,00	11,28	26,00	83,00	30,00	7231272
GOPR4BN1600R032HAM	16,00	16,00	15,04	32,00	92,00	38,00	7231274
GOPR4BN2000S038HAM	20,00	20,00	18,80	38,00	104,00	50,00	7231276



**GOmill PRO • Ball Nose • 4 Flutes • Necked • Weldon Shank**

● Primary  
○ Secondary

KCU20	P	●
	M	●
	K	●
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Catalog Number	D1	D	D3	AP1 Max	L	L3	KCU20
GOPR4BN0500R013HBM	5,00	6,00	4,70	13,00	57,00	18,00	7231265
GOPR4BN0600R013HBM	6,00	6,00	5,64	13,00	57,00	21,00	7231267
GOPR4BN0800R019HBM	8,00	8,00	7,52	19,00	63,00	27,00	7231269
GOPR4BN1000R022HBM	10,00	10,00	9,40	22,00	72,00	32,00	7231271
GOPR4BN1200R026HBM	12,00	12,00	11,28	26,00	83,00	30,00	7231273
GOPR4BN1600R032HBM	16,00	16,00	15,04	32,00	92,00	38,00	7231275
GOPR4BN2000S038HBM	20,00	20,00	18,80	38,00	104,00	50,00	7231277



## GOmill PRO Application Data • Regular

Material Group		Side Milling	Slotting	KCU20 Cutting Speed Vc m/min		Recommended Feed per Tooth (Fz=mm/th) is for Side Milling (A), For Slotting (B) Reduce Fz by 20%.															
				Min	Max	mm	D1 - Diameter														
							2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0		
P	P0	Ap1Max	0,4xD	1xD	150	200	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	P1	Ap1Max	0,4xD	1xD	150	200	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	P2	Ap1Max	0,4xD	1xD	140	190	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	P3	Ap1Max	0,4xD	1xD	120	160	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	P4	Ap1Max	0,4xD	0,75xD	90	150	Fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098	
	P5	Ap1Max	0,4xD	1xD	60	100	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091	
M	M1	Ap1Max	0,4xD	1xD	90	115	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	M2	Ap1Max	0,4xD	1xD	60	80	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091	
K	M3	Ap1Max	0,4xD	1xD	60	70	Fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071	
	K1	Ap1Max	0,4xD	1xD	120	150	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	K2	Ap1Max	0,4xD	1xD	110	140	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
S	K3	Ap1Max	0,4xD	1xD	110	130	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091	
	S1	Ap1Max	0,4xD	0,3xD	50	90	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	S2	Ap1Max	0,4xD	0,3xD	25	50	Fz	0,006	0,009	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061	
	S3	Ap1Max	0,4xD	1xD	25	40	Fz	0,006	0,009	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061	
H	S4	Ap1Max	0,4xD	1xD	50	60	Fz	0,007	0,011	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084	
	H1	Ap1Max	0,4xD	0,75xD	80	140	Fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098	
	H2	Ap1Max	0,4xD	0,5xD	70	120	Fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071	

**NOTE:**

These guidelines may require variations to achieve optimum results.  
 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 greater than 12mm.  
 For better surface finish reduce feed per tooth.  
 Side milling applications - for longest reach (L3) tools, reduce Ae by 30%.  
 Slot milling applications - for longest reach (L3) tools, reduce Ae by 30%.  
 Sharp corner tools are not recommended for slotting applications.

## GOmill PRO Application Data • Adjustment Factor Table for Feed and Speed Calculation

	Ae/D	2%	4%	5%	8%	10%	12%	20%	30%	40%
<b>Speed Factor</b>	Kv	2-3,3	1,45- 2,73	1,45-2,27	1,45	1,27	1,25	1,18	1,09	1,00
<b>Feed Factor</b>	KFz	3,51	2,51	2,25	1,80	1,64	1,51	1,23	1,07	1,00
<b>phi [°]</b>		<b>16,26</b>	<b>23,07</b>	<b>25,84</b>	<b>32,86</b>	<b>36,87</b>	<b>40,54</b>	<b>53,13</b>	<b>66,42</b>	<b>78,46</b>

**NOTE:**

These calculations are for roughing/semi-finishing cuts when used with the recommended base fz.  
 For light finishing cuts requiring improved surface quality it is recommended to reduce the base fz approximately 50% and then apply these factors.  
 For an Ae/D ratio of 5% or less there is range given for speed factor Kv, which allows the user to either be more conservative at the lower value or more aggressive with the higher value.  
 This can also be considered based on machinability of the material, from difficult to free cutting.

To calculate application specific cutting data, please use above Kv coefficient for adaptation of cutting speed and KFz for feed respectively.

Vc new=Vc\*Kv  
 Fz new=Fz\*KFz

**Calculation Example:**

Application:	D1=	14,0mm
	Material Group	P5
	Ae=	20% of D
Cutting data recommendation:	Vc=	80 m/min
	Fz=	0,063 mm/th
Adjustment coefficient:	Kv=	1,18
	KFz=	1,23

**Final cutting data recommendation:**

Vc new= 80 \* 1.18 = 94,40 m/min  
 Fz new= 0,063 \* 1.23 = 0,078 mm/th



## GOmill PRO Application Data • Ramping

Material Group	Helical Interpolation / Ramping 0°- 5°	Recommended feed per tooth (fz = mm/z) for Helical Interpolation and Ramping - Zef=2																		
		KCU20		D1 - Diameter																
		Cutting Speed Vc		mm	2,0	3,0	4,0	5,0	6,0	7,0	8,0	9,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0	
		m/min	2,3-4,3		3,5-6,5	4,6-7,6	5,8-9,5	6,9-11,4	8,1-13,3	9,2-15,2	9,2-15,2	11,5-19,0	13,8-22,8	16,1-26,6	18,4-30,4	20,7-34,2	23,0-38,0	28,8-47,5		
Max Depth	Min	Max																		
P	P0	1,25 x D1	150	200	Fz	0,015	0,023	0,031	0,040	0,048	0,057	0,066	0,073	0,079	0,091	0,102	0,111	0,119	0,125	0,136
	P1	1,25 x D1	150	200	Fz	0,015	0,023	0,031	0,040	0,048	0,057	0,066	0,073	0,079	0,091	0,102	0,111	0,119	0,125	0,136
	P2	1,25 x D1	140	190	Fz	0,015	0,023	0,031	0,040	0,048	0,057	0,066	0,073	0,079	0,091	0,102	0,111	0,119	0,125	0,136
	P3	1,25 x D1	120	160	Fz	0,012	0,019	0,026	0,033	0,040	0,047	0,055	0,061	0,067	0,077	0,087	0,096	0,104	0,111	0,125
	P4	1,25 x D1	90	150	Fz	0,012	0,017	0,024	0,030	0,036	0,043	0,049	0,054	0,059	0,069	0,077	0,084	0,091	0,097	0,107
	P5	1,25 x D1	60	100	Fz	0,010	0,016	0,021	0,027	0,032	0,038	0,044	0,049	0,053	0,062	0,070	0,077	0,083	0,089	0,100
P6	1,25 x D1	50	75	Fz	0,009	0,013	0,018	0,022	0,027	0,032	0,037	0,041	0,044	0,051	0,057	0,063	0,067	0,071	0,078	
M	M1	1,25 x D1	90	115	Fz	0,012	0,019	0,026	0,033	0,040	0,047	0,055	0,061	0,067	0,077	0,087	0,096	0,104	0,111	0,125
	M2	1,25 x D1	60	80	Fz	0,010	0,016	0,021	0,027	0,032	0,038	0,044	0,049	0,053	0,062	0,070	0,077	0,083	0,089	0,100
	M3	1,0 x D1	60	70	Fz	0,009	0,013	0,018	0,022	0,027	0,032	0,037	0,041	0,044	0,051	0,057	0,063	0,067	0,071	0,078
K	K1	1,0 x D1	120	150	Fz	0,015	0,023	0,031	0,040	0,048	0,057	0,066	0,073	0,079	0,091	0,102	0,111	0,119	0,125	0,136
	K2	1,0 x D1	110	140	Fz	0,012	0,019	0,026	0,033	0,040	0,047	0,055	0,061	0,067	0,077	0,087	0,096	0,104	0,111	0,125
	K3	1,0 x D1	110	130	Fz	0,010	0,016	0,021	0,027	0,032	0,038	0,044	0,049	0,053	0,062	0,070	0,077	0,083	0,089	0,100
S	S1	0,75 x D1	50	90	Fz	0,012	0,019	0,026	0,033	0,040	0,047	0,055	0,061	0,067	0,077	0,087	0,096	0,104	0,111	0,125
	S2	0,75 x D1	25	50	Fz	0,007	0,010	0,014	0,018	0,021	0,025	0,029	0,032	0,035	0,041	0,046	0,051	0,055	0,059	0,067
	S3	0,5 x D1	25	40	Fz	0,007	0,010	0,014	0,018	0,021	0,025	0,029	0,032	0,035	0,041	0,046	0,051	0,055	0,059	0,067
	S4	1,25 x D1	50	60	Fz	0,008	0,013	0,017	0,023	0,028	0,034	0,040	0,045	0,049	0,057	0,064	0,071	0,076	0,082	0,092
H	H1	1,0 x D1	80	140	Fz	0,012	0,017	0,024	0,030	0,036	0,043	0,049	0,054	0,059	0,069	0,077	0,084	0,091	0,097	0,107
	H2	1,0 x D1	70	120	Fz	0,009	0,013	0,018	0,022	0,027	0,032	0,037	0,041	0,044	0,051	0,057	0,063	0,067	0,071	0,078



## GOmill PRO Application Data • Long

Material Group	KCU20		Recommended Feed per Tooth (Fz=mm/th) is for Side Milling (A). No Slotting operations recommended.																			
	Cutting Speed Vc		D1 - Diameter																			
	m/min		mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	18,0	20,0	25,0							
Side Milling		ap		ae	Min	Max																
P	P0	Ap1Max	0,2xD	150	200	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,108	0,114	0,124				
	P1	Ap1Max	0,2xD	150	200	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,108	0,114	0,124				
	P2	Ap1Max	0,2xD	140	190	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,108	0,114	0,124				
	P3	Ap1Max	0,2xD	120	160	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,095	0,101	0,114				
	P4	Ap1Max	0,2xD	90	150	Fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,083	0,088	0,098				
	P5	Ap1Max	0,2xD	60	100	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,076	0,081	0,091				
P6	Ap1Max	0,15xD	50	75	Fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,061	0,065	0,071					
M	M1	Ap1Max	0,2xD	90	115	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,095	0,101	0,114				
	M2	Ap1Max	0,2xD	60	80	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,076	0,081	0,091				
	M3	Ap1Max	0,2xD	60	70	Fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,061	0,065	0,071				
K	K1	Ap1Max	0,2xD	120	150	Fz	0,014	0,021	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,108	0,114	0,124				
	K2	Ap1Max	0,2xD	110	140	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,095	0,101	0,114				
	K3	Ap1Max	0,2xD	110	130	Fz	0,009	0,014	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,076	0,081	0,091				
S	S1	Ap1Max	0,1xD	50	90	Fz	0,011	0,017	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,095	0,101	0,114				
	S2	Ap1Max	0,1xD	25	50	Fz	0,006	0,009	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,050	0,054	0,061				
	S3	Ap1Max	0,1xD	25	40	Fz	0,006	0,009	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,050	0,054	0,061				
	S4	Ap1Max	0,15xD	50	60	Fz	0,007	0,011	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,069	0,074	0,084				
H	H1	Ap1Max	0,15xD	80	140	Fz	0,010	0,016	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,083	0,088	0,098				
	H2	Ap1Max	0,15xD	70	120	Fz	0,008	0,012	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,061	0,065	0,071				

NOTE:

These guidelines may require variations to achieve optimum results.

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.

For better surface finish reduce feed per tooth.

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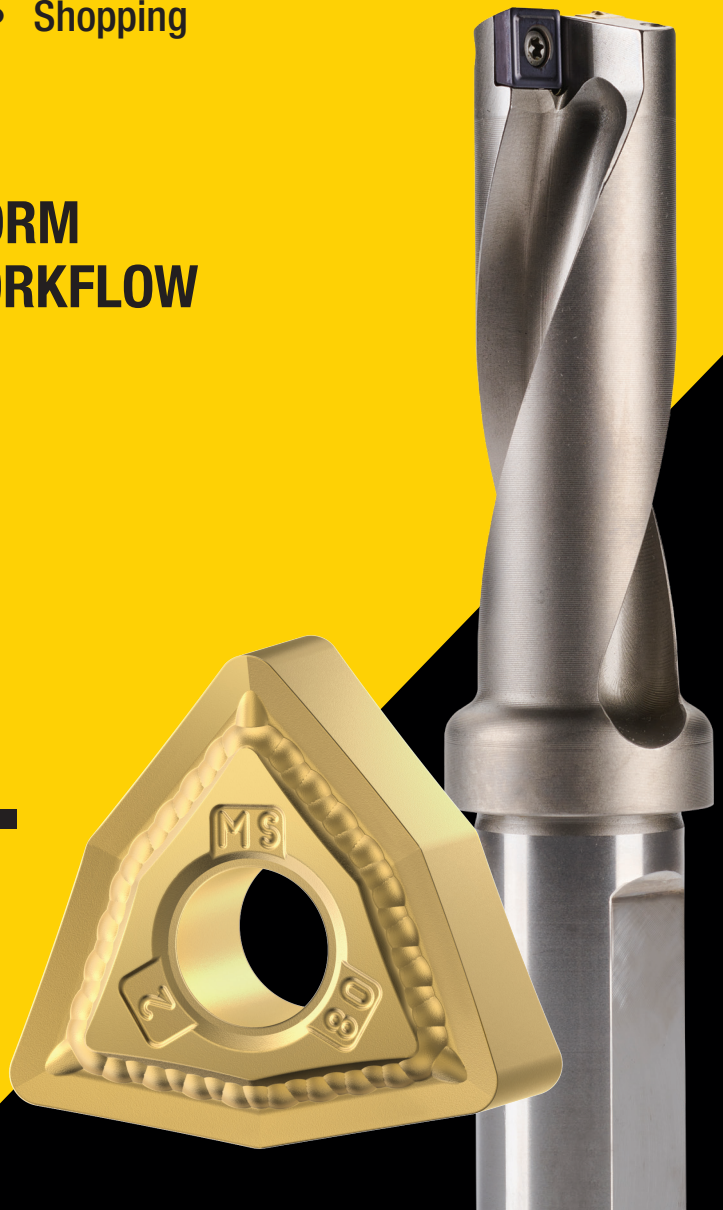
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