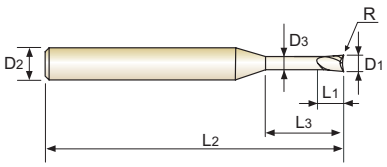
X5070 END MILLS

G8A52 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS für SCHMALE RIPPEN

- Designed to machine high hardened materials.
- Suitable for dry cutting, high speed cutting thanks to newly developed raw-material and new coating.
- Excellent workpiece finish.
- Deep slotting is possible by reduced neck.
- Corner radius for preventing the chipping in high speed machining.
- Higher wear-resistance.

- Geeignet zum Fräsen hochgehärteter Stähle.
- Geeignet zum Trockenfräsen und HSC-Fräsen dank neuentwickeltem Material und Beschichtung.
- Excellente Werkstückoberflächen.
- Abgesetzter Schaft für größere Reichweite.
- Schneidkantenschutz durch definierten Radius.
- Höhere Verschleißfestigkeit.



NG HM | 2 | BLUE | 30° | R ±0.010 | PLAIN

P.601

Unit : mm

EDP No.	Corner Radius R (±0.010)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A52005	R0.05	0.5	6	0.7	1.5	50	0.45
G8A52901	R0.05	0.5	6	0.7	3.3	50	0.45
G8A52006	R0.05	0.6	6	0.9	2	50	0.55
G8A52902	R0.05	0.6	6	0.9	4	50	0.55
G8A52008	R0.05	0.8	6	1.2	2.5	50	0.75
G8A52903	R0.05	0.8	6	1.2	5.5	50	0.75
G8A52010	R0.10	1.0	6	1.5	3.3	50	0.95
G8A52904	R0.10	1.0	6	1.5	6.7	50	0.95
G8A52012	R0.10	1.2	6	1.8	4.4	50	1.15
G8A52905	R0.10	1.2	6	1.8	8	50	1.15
G8A52015	R0.15	1.5	6	2.2	5	50	1.45
G8A52906	R0.15	1.5	6	2.2	9.7	50	1.45
G8A52020	R0.15	2.0	6	2.2	6	50	1.95
G8A52907	R0.15	2.0	6	2.2	13	50	1.95

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover.
However, it doesn't effect on performance of tool.

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~−0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
	○	○	○	◎	◎							

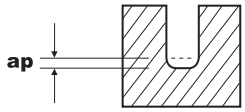
X5070 END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS für SCHMALE RIPPEN

G8A52 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS			HARDENED STEELS					
HARDNESS	HRc 30 ~ HRc 45			HRc 45 ~ HRc 55			HRc 55 ~ HRc 60		
DIAMETER	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)
0.5	25650~33000	370~470	0.0056~0.0350	23750~26000	285~315	0.0040~0.0250	14200~18000	115~130	0.0024~0.0150
0.6	20900~35200	330~560	0.0063~0.0294	19900~22000	260~290	0.0450~0.0210	11900~15500	100~120	0.0027~0.0126
0.8	16150~26400	360~590	0.0084~0.0392	15200~16700	280~310	0.0060~0.0280	9000~11700	110~125	0.0036~0.0168
1.0	12300~18700	350~540	0.0105~0.0280	10500~11500	250~280	0.0075~0.0200	6300~8050	100~115	0.0045~0.0120
1.2	10450~17600	350~590	0.0245~0.0700	9100~10000	250~280	0.0150~0.0420	5400~7000	100~115	0.0090~0.0252
1.5	9100~17600	430~830	0.0161~0.0770	7000~8000	250~280	0.0115~0.0550	4300~5500	100~115	0.0069~0.0330
2.0	6350~10550	340~570	0.0210~0.1400	6100~6700	270~300	0.0150~0.1000	3600~4700	100~120	0.0090~0.0600

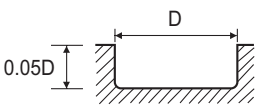


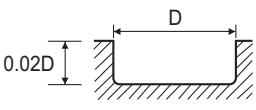
RPM = rev./min.
FEED = mm/min.

CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN MINI ECKENRADIUS - NUTENFRÄSEN

G8A50 SERIES

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS							
HARDNESS	HRc 30 ~ HRc 40		HRc 40 ~ HRc 50		HRc 50 ~ HRc 55		HRc 55 ~ HRc 60		HRc 60 ~ HRc 65	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
0.3	50000	190	45000	140	40000	115	33000	70	25000	40
0.4	50000	235	45000	180	40000	140	33000	90	25000	55
0.5	50000	370	45000	280	40000	220	33000	140	25000	85
0.6	50000	470	45000	360	40000	285	30000	160	25000	105
0.8	50000	600	40000	440	30000	295	25000	185	19000	110
1.0	48000	750	38000	570	25500	360	20500	215	16000	135
1.2	42000	790	34000	640	22500	380	20000	250	14500	145
1.5	37000	800	30500	670	21000	410	17000	250	13000	155
2.0	33300	850	26000	680	17500	420	14500	260	11000	160





RPM = rev./min.
FEED = mm/min.