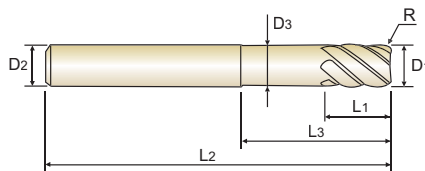




CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS

- ▶ 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
6
BLUE
45°
R ±0.010
R ±0.015
PLAIN
P.604

Ø6 Ø8-Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A39916	R0.25	6.0	6	6	14	50	5.85
G8A39060	R0.5	6.0	6	6	14	50	5.85
G8A39901	R0.5	6.0	6	13	-	70	-
G8A39910	R0.5	6.0	* 6	26	-	70	-
G8A39080	R0.5	8.0	8	8	24	60	7.7
G8A39902	R0.5	8.0	8	19	-	90	-
G8A39911	R0.5	8.0	* 8	36	-	90	-
G8A39903	R0.5	10.0	10	22	-	100	-
G8A39100	R1.0	10.0	10	10	30	70	9.7
G8A39904	R1.0	10.0	10	22	-	100	-
G8A39912	R1.0	10.0	* 10	46	-	100	-
G8A39905	R0.5	12.0	12	26	-	110	-
G8A39120	R1.0	12.0	12	12	30	75	11.7
G8A39906	R1.0	12.0	12	26	-	110	-
G8A39913	R1.0	12.0	* 12	56	-	110	-
G8A39160	R1.0	16.0	16	32	-	130	-
G8A39907	R1.5	16.0	16	32	-	130	-
G8A39914	R1.5	16.0	* 16	66	-	130	-
G8A39200	R1.0	20.0	20	38	-	140	-
G8A39908	R1.5	20.0	20	38	-	140	-
G8A39909	R2.0	20.0	20	38	-	140	-
G8A39915	R2.0	20.0	* 20	76	-	140	-

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.

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~0.02	h6
over Ø6	±0.015	(*Extra Long Type: 0~0.03)	

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							
	○	○	○	◎	◎							

◎ : Excellent ○ : Good

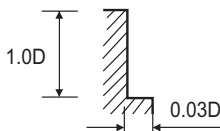


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN - SEITENFRÄSEN

G8A02, G8A37 SERIES

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS									
	HRc 30 ~ HRc 40		HRc 40 ~ HRc 50		HRc 50 ~ HRc 55		HRc 55 ~ HRc 60		HRc 60 ~ HRc 65		HRc 65 ~ HRc 70	
HARDNESS DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1.0	48000	1480	38000	1050	25500	710	20500	430	16000	270	12500	175
2.0	33300	1750	26000	1250	17500	840	14500	520	11000	320	9500	230
3.0	21800	1750	17300	1250	11500	840	9500	520	7500	320	6400	230
4.0	16700	1800	13200	1300	8800	880	7200	540	5600	335	4750	240
5.0	15700	2000	12500	1500	8300	1000	6400	580	5100	370	4450	270
6.0	13100	1950	10350	1400	6900	950	5300	560	4200	350	3700	260
8.0	9880	1880	7800	1350	5200	900	4000	520	3200	330	2800	240
10.0	7800	1750	6150	1260	4100	840	3200	480	2550	310	2200	220
12.0	6650	1750	5250	1260	3500	840	2650	480	2100	300	1860	220
16.0	4900	1500	3900	1100	2600	730	2000	420	1600	270	1400	200
20.0	3900	1300	3100	970	2050	650	1600	380	1300	250	1100	180

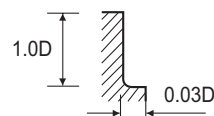
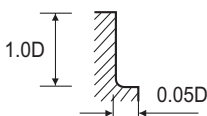


RPM = rev./min.
FEED = mm/min.

CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE, ECKENRADIUS

G8A39 SERIES

MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS									
	HRc 30 ~ HRc 40		HRc 40 ~ HRc 50		HRc 50 ~ HRc 55		HRc 55 ~ HRc 60		HRc 60 ~ HRc 65		HRc 65 ~ HRc 70	
HARDNESS DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	24800	5350	23500	4900	16000	4900	13500	3300	10500	2100	8000	1450
8.0	20000	5500	19000	5000	12000	4600	10000	3100	8000	2000	6000	1400
10.0	16000	4900	15500	4500	9500	4100	8000	2900	6400	1800	4800	1300
12.0	13000	4500	12500	4100	8000	3800	6600	2500	5300	1600	4000	1150
16.0	10000	4000	9700	3700	6000	3400	5000	2300	4000	1250	3000	870
20.0	8000	3350	7800	3400	4800	3200	4000	2100	3200	1020	2400	690



※ The Feed, in long & extra long types, should be reduced by around 50%.

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