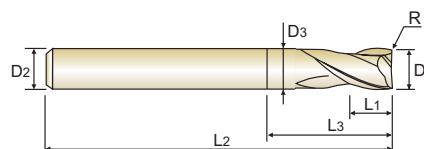


## CARBIDE, 2 FLUTE STUB LENGTH CORNER RADIUS with EXTENDED NECK VOLLHARTMETALL, 2 SCHNEIDEN EXTRA KURZ EXKENRADIUS mit ABGESETZTEM SCHAFTTEIL

- ▶ 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.



P.603

Ø0.3-Ø6 Ø8-Ø20

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8A36003	-	0.3	3	0.45	-	40	-
G8A36004	-	0.4	3	0.6	-	40	-
G8A36005	RO.05	0.5	3	0.7	-	40	-
G8A36907	RO.05	0.5	4	1	-	40	-
G8A36006	RO.05	0.6	3	0.9	-	40	-
G8A36908	RO.05	0.6	4	1.2	-	40	-
G8A36909	RO.05	0.7	4	1.4	-	40	-
G8A36008	RO.05	0.8	3	1.2	-	40	-
G8A36910	RO.05	0.8	4	1.6	-	40	-
G8A36911	RO.05	0.9	4	2	-	40	-
G8A36010	RO.1	1.0	3	1.5	-	40	-
G8A36901	RO.1	1.0	4	1.5	-	40	-
G8A36903	RO.1	1.0	6	1.5	-	40	-
G8A36015	RO.1	1.5	3	2.2	-	40	-
G8A36904	RO.1	1.5	6	2.2	-	40	-
G8A36020	RO.1	2.0	3	3	6	40	1.95
G8A36902	RO.1	2.0	4	3	6	40	1.95
G8A36905	RO.1	2.0	6	3	6	40	1.95
G8A36025	RO.1	2.5	3	4	6	40	2.4
G8A36906	RO.1	2.5	6	4	6	40	2.4
G8A36030	RO.1	3.0	6	4	7	45	2.85
G8A36035	RO.1	3.5	6	5	9	45	3.35
G8A36040	RO.1	4.0	6	5	9	45	3.85
G8A36045	RO.1	4.5	6	6	10	45	4.35

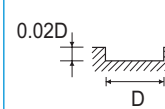
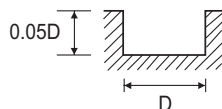
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover.  
However, it doesn't effect on performance of tool.

◎ : 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							
	○	○	○	◎	◎							

**CARBIDE, 2 FLUTE - SLOTTING  
VOLLHARTMETALL, 2 SCHNEIDEN - NUTENFRÄSEN**
**G8A01, G8A36 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
0.2	50000	130	45000	115	40000	95	33000	60	33000	45	26400	30
0.3	50000	190	45000	140	40000	115	33000	70	25000	50	20000	35
0.4	50000	235	45000	180	40000	140	33000	90	25000	55	20000	40
0.5	50000	370	45000	280	40000	220	33000	140	25000	85	20000	60
0.6	50000	470	45000	360	40000	285	30000	160	25000	105	20000	75
0.8	50000	600	40000	440	30000	295	25000	185	19000	110	15200	80
0.9	49000	655	39000	520	27800	330	22700	205	17500	125	14000	90
1.0	48000	750	38000	570	25500	360	20500	215	16000	135	12500	85
2.0	33300	850	26000	680	17500	420	14500	260	11000	160	9500	115
3.0	21800	850	17300	680	11500	420	9500	260	7500	160	6400	115
4.0	16700	880	13200	700	8800	440	7200	270	5600	170	4750	118
5.0	15700	1000	12500	805	8300	500	6400	285	5100	180	4450	132
6.0	13100	950	10350	770	6900	480	5300	280	4200	180	3700	130
8.0	9880	930	7800	720	5200	445	4000	255	3200	165	2800	120
10.0	7800	850	6150	680	4100	415	3200	240	2550	155	2200	112
12.0	6650	850	5250	680	3500	415	2650	240	2100	155	1860	112
16.0	4900	730	3900	580	2600	365	2000	210	1600	135	1400	95
20.0	3900	660	3100	525	2050	335	1600	195	1300	125	1100	85



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

**CARBIDE, 2 FLUTE - SIDE CUTTING  
VOLLHARTMETALL, 2 SCHNEIDEN - SEITENFRÄSEN**
**G8A01, G8A36 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	1050	38000	820	25500	510	20500	310	16000	190	12500	125
2.0	33300	1200	26000	970	17500	600	14500	370	11000	230	9500	165
3.0	21800	1200	17300	970	11500	600	9500	370	7500	230	6400	165
4.0	16700	1250	13200	1000	8800	625	7200	385	5600	240	4750	170
5.0	15700	1450	12500	1150	8300	710	6400	410	5100	260	4450	190
6.0	13100	1350	10350	1100	6900	690	5300	400	4200	255	3700	185
8.0	9880	1320	7800	1030	5200	635	4000	365	3200	235	2800	170
10.0	7800	1200	6150	970	4100	590	3200	340	2550	220	2200	160
12.0	6650	1200	5250	970	3500	590	2650	340	2100	220	1860	160
16.0	4900	1050	3900	840	2600	520	2000	300	1600	190	1400	140
20.0	3900	950	3100	750	2050	475	1600	275	1300	175	1100	125


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