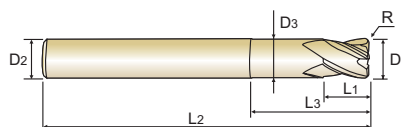


CARBIDE, 4 FLUTE CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS

- ▶ 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.



P.602

Ø3-Ø6 Ø8-Ø12

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
G8A47916	RO.3	3.0	6	4	12	55	2.85
G8A47917	RO.3	3.0	6	4	16	55	2.85
G8A47918	RO.3	3.0	6	4	20	55	2.85
G8A47030	RO.5	3.0	6	4	10	55	2.85
G8A47901	RO.5	3.0	6	4	16	55	2.85
G8A47902	RO.5	3.0	6	4	20	55	2.85
G8A47919	RO.3	4.0	6	5	12	55	3.85
G8A47920	RO.3	4.0	6	5	16	55	3.85
G8A47921	RO.3	4.0	6	5	20	55	3.85
G8A47040	RO.5	4.0	6	5	12	55	3.85
G8A47903	RO.5	4.0	6	5	16	55	3.85
G8A47904	RO.5	4.0	6	5	20	55	3.85
G8A47922	R1.0	4.0	6	5	12	55	3.85
G8A47060	RO.5	6.0	6	7	20	60	5.85
G8A47905	R1.0	6.0	6	7	20	60	5.85
G8A47906	R1.5	6.0	6	7	20	60	5.85
G8A47910	RO.5	8.0	8	9	25	60	7.7
G8A47080	R1.0	8.0	8	9	25	60	7.7
G8A47907	R1.5	8.0	8	9	25	60	7.7
G8A47913	R2.0	8.0	8	9	25	60	7.7
G8A47911	RO.5	10.0	10	11	32	70	9.7
G8A47100	R1.0	10.0	10	11	32	70	9.7
G8A47908	R1.5	10.0	10	11	32	70	9.7
G8A47914	R2.0	10.0	10	11	32	70	9.7
G8A47912	RO.5	12.0	12	12	38	80	11.7
G8A47120	R1.0	12.0	12	12	38	80	11.7
G8A47909	R1.5	12.0	12	12	38	80	11.7
G8A47915	R2.0	12.0	12	12	38	80	11.7

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~-0.012	h6
over Ø6	±0.015	0~-0.015	

◎ : 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							
	○	○	○	◎	◎							



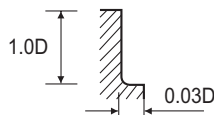
X5070 END MILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS

G8A47, G8B08 SERIES

MATERIAL DIAMETER	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	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1.0	48000	1184	38000	840	25500	568	20500	344	16000	216	12500	140
2.0	33300	1400	26000	1000	17500	672	14500	416	11000	256	9500	184
3.0	21800	1400	17300	1000	11500	672	9500	416	7500	256	6400	184
4.0	16700	1440	13200	1040	8800	704	7200	432	5600	268	4750	192
5.0	15700	1600	12500	1200	8300	800	6400	464	5100	296	4450	216
6.0	13100	1560	10350	1120	6900	760	5300	448	4200	280	3700	208
8.0	9880	1504	7800	1080	5200	720	4000	416	3200	264	2800	192
10.0	7800	1400	6150	1008	4100	672	3200	384	2550	248	2200	176
12.0	6650	1400	5250	1008	3500	672	2650	384	2100	240	1860	176
16.0	4900	1200	3900	880	2600	584	2000	336	1600	216	1400	160
20.0	3900	1040	3100	776	2050	520	1600	304	1300	200	1100	144

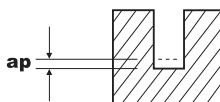


RPM = rev./min.
FEED = mm/min.

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

G8A45 SERIES

MATERIAL DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS			HARDENED STEELS						COPPER		
	HRc 30 ~ HRc 45			HRc 45 ~ HRc 55			HRc 55 ~ HRc 65			RPM	FEED	ap (mm)
	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)			
0.2	50000	300-350	0.006-0.016	50000	265-310	0.005-0.013	50000	225-265	0.005-0.012	50000	455-530	0.010-0.022
0.3	43000-50000	330-420	0.006-0.015	39900-46200	265-310	0.004-0.011	23900-32300	105-185	0.003-0.007	48000-50000	550-640	0.010-0.025
0.4	31400-50000	350-590	0.005-0.028	30500-35200	295-340	0.003-0.020	18300-24600	120-200	0.002-0.012	48000-50000	790-920	0.008-0.048
0.5	25650-33000	370-470	0.006-0.035	23750-26000	285-315	0.004-0.025	14200-18000	115-130	0.003-0.015	44000-50000	800-1150	0.010-0.060
0.6	20900-35200	330-560	0.007-0.030	19900-22000	260-290	0.005-0.021	11900-15500	100-120	0.003-0.013	37500-50000	770-1250	0.011-0.051
0.8	16150-26400	360-590	0.009-0.040	15200-16700	280-310	0.006-0.028	9000-11700	110-125	0.004-0.017	28500-47000	770-1300	0.015-0.068
1.0	12300-18700	350-540	0.011-0.028	10500-11500	250-280	0.008-0.020	6300-8050	100-115	0.005-0.012	22500-34000	810-1300	0.018-0.048
1.2	10450-17600	350-590	0.025-0.070	9100-10000	250-280	0.015-0.042	5400-7000	100-115	0.009-0.026	22500-31500	950-1350	0.036-0.101
1.5	9100-17600	430-830	0.017-0.077	7000-8000	250-280	0.012-0.055	4300-5500	100-115	0.007-0.033	14500-25000	770-1320	0.028-0.132
2.0	6350-10550	340-570	0.021-0.140	6100-6700	270-300	0.015-0.100	3600-4700	100-120	0.009-0.060	11500-18500	770-1250	0.036-0.240
3.0	4300-7050	550-900	0.056-0.210	3990-4600	445-515	0.040-0.150	2400-3200	105-310	0.024-0.090	9000-13000	1400-2110	0.096-0.360
4.0	3200-5300	400-675	0.074-0.280	3000-3400	335-380	0.053-0.200	1800-2400	75-230	0.032-0.120	6750-9750	1050-1575	0.128-0.480



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