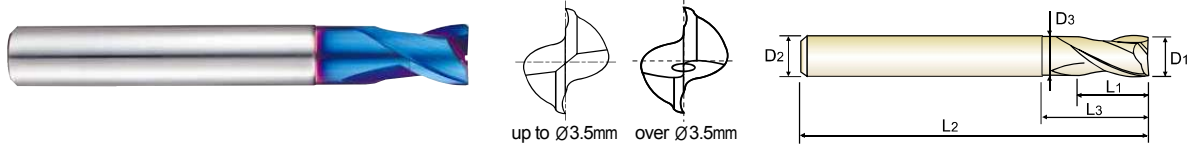


CARBIDE, 2 FLUTE with EXTENDED NECK

- VOLLHARTMETALL, 2 SCHNEIDEN mit ABGESETZTEM SCHAFTTEIL
- ① Fraise carbure, 2 dents, détalonnée
- ② TAGLIANTI CON SCARICO ESTESO

- ▶ 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.
 - ▶ Designed for high precision milling operation.
 - ▶ Higher wear-resistance.
- ▶ Geeignet zum Fräsen hochgehärteter Stähle.
 - ▶ Geeignet zum Trockenfräsen und HSC-Fräsen dank neuentwickeltem Material und Beschichtung.
 - ▶ Excellente Werkstückoberflächen.
 - ▶ Geeignet für hochpräzises Fräsen.
 - ▶ Höhere Verschleißfestigkeit.



CARBIDE 2 BLUE 30° PLAIN P.153-155

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	D1	D2	L1	L3	L2	D3
G8A01001	0.1	4	0.2	-	40	-
G8A01002	0.2	4	0.4	-	40	-
G8A01003	0.3	4	0.6	-	40	-
G8A01004	0.4	4	0.8	-	40	-
G8A01005	0.5	4	1	-	40	-
G8A01006	0.6	4	1.2	-	40	-
G8A01007	0.7	4	1.4	-	40	-
G8A01008	0.8	4	1.6	-	40	-
G8A01009	0.9	4	2	-	40	-
G8A010104S	1.0	4	1.5	3	50	0.95
G8A01010	1.0	6	1.5	3	50	0.95
G8A010154S	1.5	4	1.7	4	50	1.45
G8A01015	1.5	6	1.7	4	50	1.45
G8A010204S	2.0	4	2	5	50	1.95
G8A01020	2.0	6	2	5	50	1.95
G8A010254S	2.5	4	2.5	6	55	2.4
G8A01025	2.5	6	2.5	6	55	2.4
G8A01030	3.0	6	3	8	55	2.85
G8A01035	3.5	6	3.5	9	55	3.35
G8A01040	4.0	6	4	10	55	3.85
G8A01050	5.0	6	5	13	55	4.85
G8A01060	6.0	6	6	15	55	5.85
G8A01080	8.0	8	8	20	65	7.7
G8A01100	10.0	10	10	25	75	9.7
G8A01120	12.0	12	12	28	85	11.7
G8A01160	16.0	16	16	32	90	15.7
G8A01200	20.0	20	20	40	105	19.7

Unit : mm

Due to the characteristics of the blue decoration layer, it might be erased during short term use and the color layer might not be uniformed. However, it doesn't affect the performance of the tool.

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO Material Description	P										M						K																									
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel						Stainless steel			Grey cast iron			Nodular cast iron			Malleable cast iron																
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC																																										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230																						
Recommend					○				○	○																																

ISO Material Description	N										S										H									
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron									
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47			
HRC																														
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550									
Recommend																														

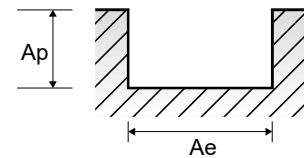
G8A01, G8A36 SERIES

2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						0.2	0.3	0.4	0.5	0.6	0.8	0.9	1.0	2.0	
P	5	Non-alloy steel	1.0D	0.05D	Vc	30	45	65	80	95	125	140	150	210	
					fz	0.001	0.002	0.002	0.004	0.005	0.006	0.007	0.01	0.013	
					RPM	47746	47746	51725	50930	50399	49736	49515	47746	33423	
					FEED	95	191	207	407	504	597	693	955	869	
	8-9	Low alloy steel	1.0D	0.05D	Vc	30	45	65	80	95	125	140	150	210	
					fz	0.001	0.002	0.002	0.004	0.005	0.006	0.007	0.01	0.013	
					RPM	47746	47746	51725	50930	50399	49736	49515	47746	33423	
					FEED	95	191	207	407	504	597	693	955	869	
	11.1	High alloyed steel, and tool steel	1.0D	0.05D	Vc	30	45	65	80	95	125	140	150	210	
					fz	0.001	0.002	0.002	0.004	0.005	0.006	0.007	0.01	0.013	
					RPM	47746	47746	51725	50930	50399	49736	49515	47746	33423	
					FEED	95	191	207	407	504	597	693	955	869	
11.2	High alloyed steel, and tool steel	1.0D	0.05D	Vc	30	40	55	70	85	100	110	120	165		
				fz	0.001	0.002	0.002	0.003	0.004	0.006	0.007	0.008	0.013		
				RPM	47746	42441	43768	44563	45094	39789	38905	38197	26261		
				FEED	95	170	175	267	361	477	545	611	683		
H	38.1	Hardened steel	1.0D	0.05D	Vc	30	40	55	70	85	100	110	120	165	
					fz	0.001	0.002	0.002	0.003	0.004	0.006	0.007	0.008	0.013	
					RPM	47746	42441	43768	44563	45094	39789	38905	38197	26261	
					FEED	95	170	175	267	361	477	545	611	683	
	38.2	Hardened steel	1.0D	0.05D	Vc	25	40	50	65	75	75	80	80	110	
					fz	0.001	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.012	
					RPM	39789	42441	39789	41380	39789	29842	28294	25465	17507	
					FEED	80	85	159	248	318	298	340	357	420	
	39.1	Hardened steel	1.0D	0.05D	Vc	20	30	40	50	55	65	65	65	90	
					fz	0.001	0.001	0.001	0.002	0.003	0.004	0.005	0.005	0.009	
					RPM	31831	31831	31831	31831	29178	25863	22989	20690	14324	
					FEED	64	64	64	127	175	207	230	207	258	
	39.2	Hardened steel	1.0D	0.05D	Vc	20	25	30	40	45	50	50	50	70	
					fz	0.001	0.001	0.001	0.002	0.002	0.003	0.004	0.004	0.007	
					RPM	31831	26526	23873	25465	23873	19894	17684	15915	11141	
					FEED	64	53	48	102	95	119	141	127	156	
	39.3	Hardened steel	1.0D	0.02D	Vc	15	20	25	30	40	40	40	40	60	
					fz	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.003	0.006	
					RPM	23873	21221	19894	19099	21221	15915	14147	12732	9549	
					FEED	29	38	40	57	81	83	91	87	116	
	40	Chilled Cast Iron	1.0D	0.05D	Vc	30	40	55	70	85	100	110	120	165	
					fz	0.001	0.002	0.002	0.003	0.004	0.006	0.007	0.008	0.013	
					RPM	47746	42441	43768	44563	45094	39789	38905	38197	26261	
					FEED	95	170	175	267	361	477	545	611	683	
41	Hardened Cast Iron	1.0D	0.05D	Vc	25	40	50	65	75	75	80	80	110		
				fz	0.001	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.012		
				RPM	39789	42441	39789	41380	39789	29842	28294	25465	17507		
				FEED	80	85	159	248	318	298	340	357	420		

▶ NEXT PAGE





RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

G8A01, G8A36 SERIES 2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	5	Non-alloy steel	1.0D	0.05D	Vc	205	210	245	245	250	245	250	245	245	
					fz	0.019	0.026	0.032	0.036	0.047	0.054	0.064	0.074	0.085	
					RPM	21751	16711	15597	12998	9947	7799	6631	4874	3899	
	8-9	Low alloy steel	1.0D	0.05D	Vc	205	210	245	245	250	245	250	245	245	
					fz	0.019	0.026	0.032	0.036	0.047	0.054	0.064	0.074	0.085	
					RPM	21751	16711	15597	12998	9947	7799	6631	4874	3899	
	11.1	High alloyed steel, and tool steel	1.0D	0.05D	Vc	205	210	245	245	250	245	250	245	245	
					fz	0.019	0.026	0.032	0.036	0.047	0.054	0.064	0.074	0.085	
					RPM	21751	16711	15597	12998	9947	7799	6631	4874	3899	
	11.2	High alloyed steel, and tool steel	1.0D	0.05D	Vc	165	165	195	195	195	195	200	195	195	
					fz	0.02	0.027	0.032	0.037	0.046	0.055	0.065	0.074	0.085	
					RPM	17507	13130	12414	10345	7759	6207	5305	3879	3104	
H	38.1	Hardened steel	1.0D	0.05D	Vc	165	165	195	195	195	195	200	195	195	
					fz	0.02	0.027	0.032	0.037	0.046	0.055	0.065	0.074	0.085	
					RPM	17507	13130	12414	10345	7759	6207	5305	3879	3104	
	38.2	Hardened steel	1.0D	0.05D	Vc	110	110	130	130	130	130	130	130	130	
					fz	0.018	0.025	0.03	0.035	0.043	0.051	0.059	0.07	0.082	
					RPM	11671	8754	8276	6897	5173	4138	3448	2586	2069	
	39.1	Hardened steel	1.0D	0.05D	Vc	90	90	100	100	100	100	100	100	100	
					fz	0.014	0.019	0.022	0.026	0.032	0.038	0.045	0.053	0.061	
					RPM	9549	7162	6366	5305	3979	3183	2653	1989	1592	
	39.2	Hardened steel	1.0D	0.05D	Vc	70	70	80	80	80	80	80	80	80	
					fz	0.011	0.015	0.018	0.021	0.026	0.03	0.037	0.042	0.048	
					RPM	7427	5570	5093	4244	3183	2546	2122	1592	1273	
39.3	Hardened steel	1.0D	0.02D	Vc	60	60	70	70	70	70	70	70	70		
				fz	0.009	0.012	0.015	0.018	0.021	0.026	0.03	0.034	0.039		
				RPM	6366	4775	4456	3714	2785	2228	1857	1393	1114		
40	Chilled Cast Iron	1.0D	0.05D	Vc	165	165	195	195	195	195	200	195	195		
				fz	0.02	0.027	0.032	0.037	0.046	0.055	0.065	0.074	0.085		
				RPM	17507	13130	12414	10345	7759	6207	5305	3879	3104		
41	Hardened Cast Iron	1.0D	0.05D	Vc	110	110	130	130	130	130	130	130	130		
				fz	0.018	0.025	0.03	0.035	0.043	0.051	0.059	0.07	0.082		
				RPM	11671	8754	8276	6897	5173	4138	3448	2586	2069		

