

YG X5070 END MILLS

PLAIN SHANK

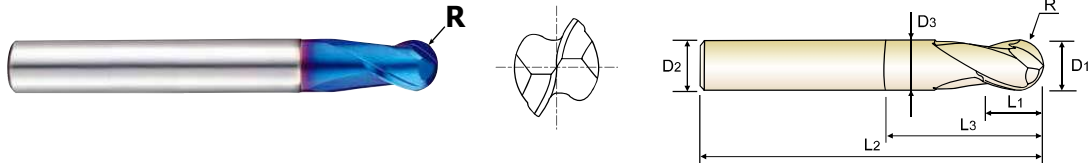
G8A38 SERIES

CARBIDE, 2 FLUTE STUB LENGTH BALL NOSE with EXTENDED NECK

- **VOLLHARTMETALL, 2 SCHNEIDEN EXTRA KURZ STIRNRADIUS mit ABGESETZTEM SCHAFTTEIL**
- **Fraise carbure, 2 dents, hémisphérique, détalonnée, extra-courte**
- **2 TAGLIENTI, SEMISFERICA TAGLIENTE CORTO 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°
R ±0.005
R ±0.010
PLAIN
P.142-143

R0.5-R3 R3.5-R12.5

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8A38010	R0.5	1.0	4	1	2.2	50	0.95
G8A38012	R0.6	1.2	4	1.2	2.6	50	1.15
G8A38015	R0.75	1.5	4	1.5	3	50	1.45
G8A380204S	R1.0	2.0	4	2	4	50	1.95
G8A38020	R1.0	2.0	6	2	4	50	1.95
G8A38030	R1.5	3.0	6	3	6	60	2.85
G8A38040	R2.0	4.0	6	4	8	70	3.85
G8A38050	R2.5	5.0	6	5	10	80	4.85
G8A38060	R3.0	6.0	6	6	12	90	5.85
G8A38070	R3.5	7.0	8	7	14	90	6.7
G8A38080	R4.0	8.0	8	8	16	100	7.7
G8A38090	R4.5	9.0	10	9	18	100	8.7
G8A38100	R5.0	10.0	10	10	20	100	9.7
G8A38120	R6.0	12.0	12	12	24	110	11.7
G8A38140	R7.0	14.0	14	14	28	110	13.7
G8A38160	R8.0	16.0	16	16	32	140	15.7
G8A38180	R9.0	18.0	18	18	36	140	17.7
G8A38200	R10.0	20.0	20	20	40	160	19.7
G8A38250	R12.5	25.0	25	25	50	180	24.7

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	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	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				
HRc	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25							
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			
HRc											15	30	25	38	34			55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550			
Recommend																		◎	◎	○	◎			



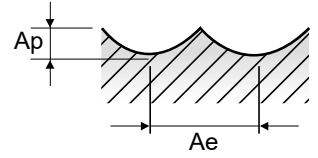
RECOMMENDED CUTTING CONDITIONS
EMPFOLHENE SCHNEIDPARAMETER

G8A28, G8A38, G8A53 SERIES 2 FLUTE BALL NOSE

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	1.0
P	5	Non-alloy steel	0.05D	0.02D	Vc	30	45	65	80	95	125	155
					fz	0.012	0.015	0.019	0.024	0.029	0.039	0.048
					RPM	47746	47746	51725	50930	50399	49736	49338
					FEED	1146	1432	1966	2445	2923	3879	4736
	8-9	Low alloy steel	0.05D	0.02D	Vc	30	45	65	80	95	125	155
					fz	0.012	0.015	0.019	0.024	0.029	0.039	0.048
					RPM	47746	47746	51725	50930	50399	49736	49338
					FEED	1146	1432	1966	2445	2923	3879	4736
	11.1	High alloyed steel, and tool steel	0.05D	0.02D	Vc	30	45	65	80	95	125	155
					fz	0.012	0.015	0.019	0.024	0.029	0.039	0.048
					RPM	47746	47746	51725	50930	50399	49736	49338
					FEED	1146	1432	1966	2445	2923	3879	4736
11.2	High alloyed steel, and tool steel	0.05D	0.02D	Vc	30	45	65	80	95	125	155	
				fz	0.011	0.014	0.017	0.021	0.025	0.033	0.042	
				RPM	47746	47746	51725	50930	50399	49736	49338	
				FEED	1050	1337	1759	2139	2520	3283	4144	
H	38.1	Hardened steel	0.05D	0.02D	Vc	30	45	65	80	95	125	155
					fz	0.011	0.014	0.017	0.021	0.025	0.033	0.042
					RPM	47746	47746	51725	50930	50399	49736	49338
					FEED	1050	1337	1759	2139	2520	3283	4144
	38.2		0.05D	0.02D	Vc	30	40	55	70	85	115	140
					fz	0.011	0.013	0.017	0.021	0.024	0.033	0.042
					RPM	47746	42441	43768	44563	45094	45757	44563
					FEED	1050	1103	1488	1872	2165	3020	3743
	39.1		0.05D	0.02D	Vc	25	40	50	65	75	100	125
					fz	0.01	0.012	0.015	0.019	0.023	0.03	0.038
					RPM	39789	42441	39789	41380	39789	39789	39789
					FEED	796	1019	1194	1572	1830	2387	3024
39.2	0.05D	0.02D	Vc	20	35	45	55	65	90	110		
			fz	0.01	0.012	0.015	0.019	0.023	0.03	0.037		
			RPM	31831	37136	35810	35014	34484	35810	35014		
			FEED	637	891	1074	1331	1586	2149	2591		
39.3	0.05D	0.02D	Vc	20	30	40	50	60	80	110		
			fz	0.009	0.011	0.014	0.017	0.022	0.029	0.033		
			RPM	31831	31831	31831	31831	31831	31831	35014		
			FEED	573	700	891	1082	1401	1846	2311		
40	Chilled Cast Iron	0.05D	0.02D	Vc	30	45	65	80	95	125	155	
				fz	0.011	0.014	0.017	0.021	0.025	0.033	0.042	
				RPM	47746	47746	51725	50930	50399	49736	49338	
				FEED	1050	1337	1759	2139	2520	3283	4144	
41	Hardened Cast Iron	0.05D	0.02D	Vc	30	40	55	70	85	115	140	
				fz	0.011	0.013	0.017	0.021	0.024	0.033	0.042	
				RPM	47746	47746	51725	50930	50399	49736	49338	
				FEED	1050	1337	1759	2139	2520	3283	4144	

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Vc = m/min.
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G8A28, G8A38, G8A53 SERIES **2 FLUTE BALL NOSE**

VDI 3323	Parameter	Diameter (Ø)											
		1.2	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
5	Vc	190	235	310	310	315	290	260	280	290	260	280	280
	fz	0.051	0.054	0.057	0.091	0.12	0.156	0.174	0.189	0.199	0.212	0.238	0.264
	RPM	50399	49869	49338	32892	25067	18462	13793	11141	9231	6897	5570	4456
8-9	FEED	5141	5386	5625	5986	6016	5760	4800	4211	3674	2924	2652	2353
	Vc	190	235	310	310	315	290	260	280	290	260	280	280
	fz	0.051	0.054	0.057	0.091	0.12	0.156	0.174	0.189	0.199	0.212	0.238	0.264
111	RPM	50399	49869	49338	32892	25067	18462	13793	11141	9231	6897	5570	4456
	FEED	5141	5386	5625	5986	6016	5760	4800	4211	3674	2924	2652	2353
	Vc	190	235	310	310	315	290	260	280	290	260	280	280
112	fz	0.051	0.054	0.057	0.091	0.12	0.156	0.174	0.189	0.199	0.212	0.238	0.264
	RPM	50399	49869	49338	32892	25067	18462	13793	11141	9231	6897	5570	4456
	FEED	5141	5386	5625	5986	6016	5760	4800	4211	3674	2924	2652	2353
38.1	Vc	180	225	300	300	300	280	255	270	280	250	270	270
	fz	0.045	0.047	0.05	0.083	0.111	0.138	0.153	0.164	0.174	0.187	0.206	0.227
	RPM	47746	47746	47746	31831	23873	17825	13528	10743	8913	6631	5371	4297
38.2	FEED	4297	4488	4775	5284	5300	4920	4140	3524	3102	2480	2213	1951
	Vc	160	205	250	250	250	235	205	225	235	210	225	225
	fz	0.045	0.047	0.05	0.075	0.1	0.125	0.141	0.15	0.16	0.17	0.189	0.208
39.1	RPM	42441	43502	39789	26526	19894	14961	10876	8952	7480	5570	4476	3581
	FEED	3820	4089	3979	3979	3979	3740	3067	2686	2394	1894	1692	1490
	Vc	145	175	220	220	220	210	190	200	205	190	200	200
39.2	fz	0.039	0.042	0.045	0.067	0.09	0.113	0.125	0.134	0.144	0.155	0.169	0.188
	RPM	38462	37136	35014	23343	17507	13369	10080	7958	6525	5040	3979	3183
	FEED	3000	3119	3151	3128	3151	3021	2520	2133	1879	1562	1345	1197
39.3	Vc	130	155	200	200	200	180	165	175	180	165	175	175
	fz	0.04	0.041	0.044	0.067	0.088	0.111	0.122	0.132	0.142	0.142	0.143	0.143
	RPM	34484	32892	31831	21221	15915	11459	8754	6963	5730	4377	3482	2785
40	FEED	2759	2697	2801	2844	2801	2544	2136	1838	1627	1243	996	797
	Vc	115	140	180	180	180	165	150	165	165	150	160	160
	fz	0.038	0.039	0.04	0.061	0.079	0.1	0.109	0.119	0.13	0.131	0.133	0.129
41	RPM	30505	29709	28648	19099	14324	10504	7958	6565	5252	3979	3183	2546
	FEED	2318	2317	2292	2330	2263	2101	1735	1562	1366	1042	847	657
	Vc	180	225	300	300	300	280	255	270	280	250	270	270
41	fz	0.045	0.047	0.05	0.083	0.111	0.138	0.153	0.164	0.174	0.187	0.206	0.227
	RPM	47746	47746	47746	31831	23873	17825	13528	10743	8913	6631	5371	4297
	FEED	4297	4488	4775	5284	5300	4920	4140	3524	3102	2480	2213	1951
41	Vc	160	205	250	250	250	235	205	225	235	210	225	225
	fz	0.045	0.047	0.05	0.075	0.1	0.125	0.141	0.15	0.16	0.17	0.189	0.208
	RPM	47746	47746	47746	31831	23873	17825	13528	10743	8913	6631	5371	4297
41	FEED	4297	4488	4775	5284	5300	4920	4140	3524	3102	2480	2213	1951

