



SGED28 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE BALL NOSE DLC COATING
VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS DLC BESCHICHTUNG

- ▶ Designed to copper, copper alloys soft graphites, reinforced plastics and the materials affiliated with non-ferrous metals.
- ▶ Tight radius tolerance is applied ($\pm 0.005\text{mm}$ tolerance under R3).
- ▶ Excellent surface roughness thanks to Mirror Face of cutting edges
- ▶ Entwickelt für die Bearbeitung von Kupfer, Kupferlegierungen, sowie faserverstärkten Kunststoffen, NE- Metallen
- ▶ Hochgenaue Raduistoleranz ($\pm 0.005\text{mm}$ Toleranz unter R3mm)
- ▶ Sehr gute Oberflächenrauigkeit wird durch die besonders behandelte Schneide erreicht



Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R (± 0.005)				
SGED28010	R0.5	1.0	6	2.5	50
SGED28015	R0.75	1.5	6	4	50
SGED28020	R1.0	2.0	6	5	50
SGED28030	R1.5	3.0	6	8	60
SGED28040	R2.0	4.0	6	8	70
SGED28050	R2.5	5.0	6	12	90
SGED28060	R3.0	6.0	6	12	90
SGED28080	R4.0	8.0	8	16	100
SGED28100	R5.0	10.0	10	20	100
SGED28120	R6.0	12.0	12	25	110

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0~-0.012	h6
over R3		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	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70	◎			○					

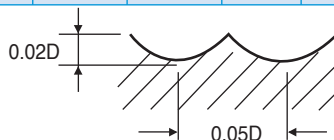


RECOMMENDED CUTTING CONDITIONS
EMPFOLGENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE BALL NOSE DLC COATING with EXTENDED NECK
VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS DLC BESCHICHTUNG mit ABGESETZTEM SCHAFTTETL

SGED27 SERIES

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
R0.25 × 0.5	50000	500	80	0.005	50000	500	80	0.005	50000	380	80	0.004
R0.3 × 0.6	50000	700	95	0.007	50000	650	95	0.007	50000	450	95	0.005
R0.4 × 0.8	50000	850	125	0.009	44000	770	110	0.009	50000	600	125	0.006
R0.5 × 1.0	50000	1000	155	0.010	35000	770	110	0.011	50000	630	155	0.006
R1.0 × 2.0	39600	1716	250	0.022	19800	780	125	0.020	50000	1250	315	0.013
R1.5 × 3.0	26000	1584	245	0.030	13000	720	125	0.028	39000	1512	370	0.019
R2.0 × 4.0	19000	1606	240	0.042	9500	730	120	0.038	28500	1533	360	0.027
R2.5 × 5.0	15400	1606	240	0.052	7700	730	120	0.047	23100	1533	365	0.033
R3.0 × 6.0	13000	1584	245	0.061	6500	720	125	0.055	19500	1512	370	0.039
R4.0 × 8.0	10000	1584	250	0.079	5000	720	125	0.072	15000	1512	375	0.050
R5.0 × 10.0	8000	1606	250	0.100	4000	730	125	0.091	12000	1533	375	0.064
R6.0 × 12.0	6600	1606	250	0.122	3300	730	125	0.111	9900	1533	375	0.077

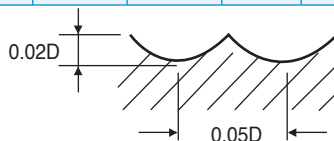


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

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SGED28 SERIES

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
R0.5 × 1.0	50000	1000	155	0.010	42000	930	130	0.011	50000	750	155	0.008
R1.0 × 2.0	47520	2068	300	0.022	24000	940	150	0.020	50000	1500	315	0.015
R1.5 × 3.0	31200	1914	295	0.031	15800	870	150	0.028	47400	1800	445	0.019
R2.0 × 4.0	22800	1936	285	0.042	11500	880	145	0.038	34500	1825	435	0.026
R2.5 × 5.0	18500	1936	290	0.052	9300	880	145	0.047	28000	1825	440	0.033
R3.0 × 6.0	15600	1892	295	0.061	7800	860	145	0.055	23500	1800	445	0.038
R4.0 × 8.0	12000	1892	300	0.079	6000	860	150	0.072	18000	1800	450	0.050
R5.0 × 10.0	9600	1936	300	0.101	4800	880	150	0.092	14500	1825	455	0.063
R6.0 × 12.0	8000	1914	300	0.120	4000	870	150	0.109	12000	1825	450	0.076



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