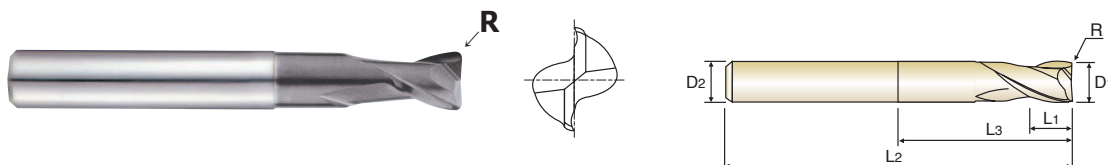


CARBIDE, 2 FLUTE CORNER RADIUS DLC COATING with EXTENDED NECK
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS DLC BESCHICHTUNG mit ABGESETZTEM SCHAFTTETTEL

- ▶ Designed to copper, copper alloys soft graphites, reinforced plastics and the materials affiliated with non-ferrous metals.
- ▶ Suitable for various cutting application like roughing, semi-finishing and finishing thanks to application

- ▶ Entwickelt für die Bearbeitung von Kupfer, Kupferlegierungen, sowie faserverstärkten Kunststoffen, NE- Metallen
- ▶ Ausgelegt für verschiedene Anwendungen, z.B. schrumpfen, schrumpfschichten und zur schlicht Bearbeitung, aufgrund der neuartigen Geometrie



Ø1~Ø6 Ø8~Ø12

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length
	R	D1	D2	L1	L3	L2
SGED290100104	RO.1	1.0	4	1.5	4	45
SGED290100106	RO.1	1.0	4	1.5	6	45
SGED290100108	RO.1	1.0	4	1.5	8	45
SGED290100204	RO.2	1.0	4	1.5	4	45
SGED290100206	RO.2	1.0	4	1.5	6	45
SGED290100208	RO.2	1.0	4	1.5	8	45
SGED290150106	RO.1	1.5	4	2.3	6	45
SGED290150108	RO.1	1.5	4	2.3	8	45
SGED290150110	RO.1	1.5	4	2.3	10	45
SGED290150206	RO.2	1.5	4	2.3	6	45
SGED290150208	RO.2	1.5	4	2.3	8	45
SGED290150210	RO.2	1.5	4	2.3	10	45
SGED290200208	RO.2	2.0	4	3	8	45
SGED290200210	RO.2	2.0	4	3	10	45
SGED290200212	RO.2	2.0	4	3	12	45
SGED290200508	RO.5	2.0	4	3	8	45
SGED290200510	RO.5	2.0	4	3	10	45
SGED290200512	RO.5	2.0	4	3	12	45
SGED290300210	RO.2	3.0	6	4.5	10	50
SGED290300212	RO.2	3.0	6	4.5	12	50
SGED290300216	RO.2	3.0	6	4.5	16	60
SGED290300310	RO.3	3.0	6	4.5	10	50
SGED290300312	RO.3	3.0	6	4.5	12	50
SGED290300316	RO.3	3.0	6	4.5	16	60

◎ : 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	◎			○					



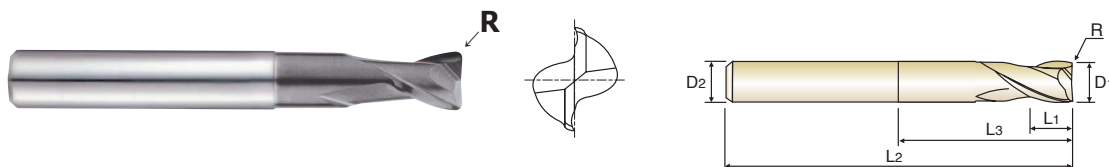
SGED29 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE CORNER RADIUS DLC COATING with EXTENDED NECK
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS DLC BESCHICHTUNG mit ABGESETZTEM SCHAFTTITEL

- ▶ Designed to copper, copper alloys soft graphites, reinforced plastics and the materials affiliated with non-ferrous metals.
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- ▶ Ausgelegt für verschiedene Anwendungen, z.B. schrappen, schrappschichten und zur schlicht Bearbeitung, aufgrund der neuartigen Geometrie



NG HM
2
30°
±0.010
±0.015
PLAIN
P.995

Ø1~Ø6 Ø8~Ø12

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length
	R	D1	D2	L1	L3	L2
SGED290400212	RO.2	4.0	6	6	12	50
SGED290400216	RO.2	4.0	6	6	16	60
SGED290400220	RO.2	4.0	6	6	20	60
SGED290400512	RO.5	4.0	6	6	12	50
SGED290400516	RO.5	4.0	6	6	16	60
SGED290400520	RO.5	4.0	6	6	20	60
SGED290600320	RO.3	6.0	6	9	20	60
SGED290600520	RO.5	6.0	6	9	20	60
SGED290601020	R1.0	6.0	6	9	20	60
SGED290800325	RO.3	8.0	8	12	25	65
SGED290800525	RO.5	8.0	8	12	25	65
SGED290801025	R1.0	8.0	8	12	25	65
SGED291000530	RO.5	10.0	10	15	30	70
SGED291001030	R1.0	10.0	10	15	30	70
SGED291200532	RO.5	12.0	12	18	32	80
SGED291201032	R1.0	12.0	12	18	32	80

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	

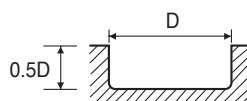
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70									
						◎			○					

CARBIDE, 2 FLUTE CORNER RADIUS DLC COATING with EXTENDED NECK - SLOTING
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS DLC BESCHICHTUNG mit ABGESETZTEM SCHAFTTETL- NUTENFRÄSEN

SGED29 SERIES

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
1.0	50000	1000	155	0.010	50000	1000	155	0.010	50000	700	155	0.007
2.0	50000	1800	315	0.018	50000	1700	315	0.017	50000	1400	315	0.014
3.0	50000	2600	470	0.026	44500	2350	420	0.026	50000	2100	470	0.021
4.0	50000	3680	630	0.037	33400	2100	420	0.031	50000	2600	630	0.026
5.0	50000	4300	785	0.043	27000	2100	425	0.039	50000	3400	785	0.034
6.0	44500	4670	840	0.052	22300	2100	420	0.047	50000	4200	940	0.042
8.0	33400	4560	840	0.068	16700	2100	420	0.063	50000	5700	1255	0.057
10.0	26700	4770	840	0.089	13370	2100	420	0.079	40000	5500	1255	0.069
12.0	22200	4660	835	0.105	11100	2100	420	0.095	33500	5600	1265	0.084

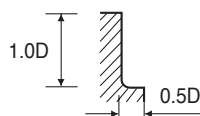


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 2 FLUTE CORNER RADIUS DLC COATING with EXTENDED NECK - SIDE CUTTING
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS DLC BESCHICHTUNG mit ABGESETZTEM SCHAFTTETL- SEITENFRÄSEN

SGED29 SERIES

MATERIAL	WROUGHT ALUMINIUM				UNALLOYED COPPER				THERMOPLASTICS			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
1.0	50000	1400	155	0.014	50000	1200	155	0.012	50000	1200	155	0.012
2.0	50000	2800	315	0.028	50000	2500	315	0.025	50000	2500	315	0.025
3.0	50000	4200	470	0.042	50000	3700	470	0.037	50000	3700	470	0.037
4.0	50000	5300	630	0.053	50000	4700	630	0.047	50000	5000	630	0.050
5.0	50000	6500	785	0.065	40000	4800	630	0.060	50000	6500	785	0.065
6.0	50000	7850	940	0.079	33400	4900	630	0.073	50000	7500	940	0.075
8.0	37500	7850	940	0.105	25000	4700	630	0.094	50000	8400	1255	0.084
10.0	30000	7850	940	0.131	20000	4800	630	0.120	40000	8400	1255	0.105
12.0	25000	7850	940	0.157	16700	4700	630	0.141	33500	8400	1265	0.125



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