


**D-POWER CFRP
END MILLS**
GUF40 SERIES

 PLAIN SHANK
GLATTER ZYLINDERSCHAFT

HSS

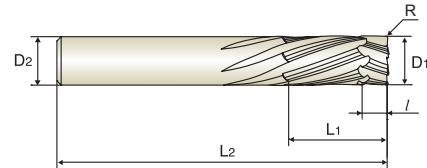
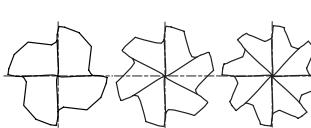
CBN
END MILLSi-Xmill
END MILLSi-HS mill
END MILLSX5070
END MILLS4G MILL
END MILLSX-SPEED
ROUGHER
END MILLSX-POWER
END MILLSJET-POWER
END MILLSTN MILL
END MILLSV7 MILL
END MILLSALU-POWER
END MILLSCRX S
END MILLSD-POWER
GRAPHITE
END MILLSD-POWER
CFRP
END MILLS

ROUTERS

K-2 CARBIDE
END MILLSGENERAL
CARBIDE
END MILLSTANK-POWER
END MILLSGENERAL
HSS
END MILLSMILLING
CUTTERSTECHNICAL
DATA
**CARBIDE, MULTI FLUTE DUAL HELIX
VOLLHARTMETALL, MULTI SCHNEIDEN DOPPEL HELIX**

- For composite materials - CFRP, GFRP.
- Reduce delamination and burrs.
- Diamond coating with excellent abrasion resistance

- Für verbund materialien - CFK und GFK
- Verringert Ablösungen (Delamination) und Gratbildung
- Diamant-Beschichtung mit ausgezeichnetner Abriebfestigkeit.

MG
HM

4·8

20°/20°

PLAIN



P.1022

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D ₁	Shank Diameter D ₂	Length of Cut L ₁ (l)	Overall Length L ₂	No. of Flute
GUF40060	R0.5	6.0	6	12(3)	65	4
GUF40080	R0.5	8.0	8	16(4)	70	6
GUF40100	R0.5	10.0	10	20(5)	80	6
GUF40120	R0.5	12.0	12	24(6)	90	8

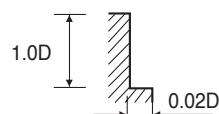
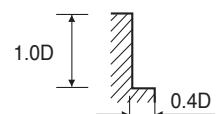
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : 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								
						○							○


**D-POWER CFRP
END MILLS**
**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**
**CARBIDE, MULTI FLUTE DUAL HELIX
VOLLHARTMETALL, MULTI SCHNEIDEN DOPPEL HELIX**
GUF40 SERIES

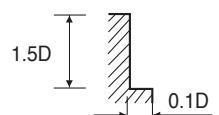
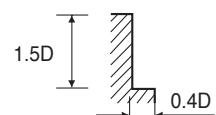
MATERIAL	CFRP				GFRP				CFRP				GFRP				
	DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
X5070 END MILLS	6.0	7950	1115	150	0.035	4240	425	80	0.025	10610	1995	200	0.047	5300	740	100	0.035
	8.0	5960	1610	150	0.045	3180	590	80	0.031	7950	2955	200	0.062	3970	955	100	0.040
	10.0	4770	1575	150	0.055	2540	565	80	0.037	6360	2940	200	0.077	3180	860	100	0.045
	12.0	3970	2065	150	0.065	2120	730	80	0.043	5300	3900	200	0.092	2650	1060	100	0.050



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

**CARBIDE, 4 FLUTE
VOLLHARTMETALL, 4 SCHNEIDEN**
GUF39 SERIES

MATERIAL	CFRP				GFRP				CFRP				GFRP				
	DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
D-POWER GRAPHITE END MILLS	6.0	10610	1485	200	0.035	5300	530	100	0.025	10610	1190	200	0.028	5300	530	100	0.025
	8.0	7950	1430	200	0.045	3970	490	100	0.031	7950	1145	200	0.036	3970	445	100	0.028
	10.0	6360	1400	200	0.055	3180	470	100	0.037	6360	1120	200	0.044	3180	405	100	0.032
	12.0	5300	1380	200	0.065	2650	455	100	0.043	5300	1100	200	0.052	2650	370	100	0.035



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