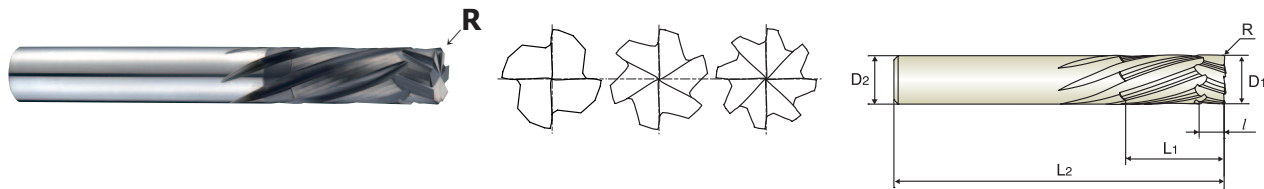




**CARBIDE, MULTI FLUTE DUAL HELIX**  
**VOLLHARTMETALL, MULTI SCHNEIDEN DOPPEL HELIX**

- ▶ 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 ausgezeichneter Abriebfestigkeit.



Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1(l)	Overall Length L2	No. of Flute
<b>GUF40060</b>	RO.5	<b>6.0</b>	6	12(3)	65	4
<b>GUF40080</b>	RO.5	<b>8.0</b>	8	16(4)	70	6
<b>GUF40100</b>	RO.5	<b>10.0</b>	10	20(5)	80	6
<b>GUF40120</b>	RO.5	<b>12.0</b>	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									
							○							◎

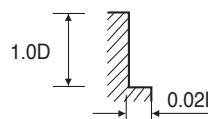
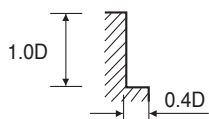
**YG D-POWER CFRP END MILLS**

**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
<b>6.0</b>	7950	1115	150	0.035	4240	425	80	0.025	10610	1995	200	0.047	5300	740	100	0.035
<b>8.0</b>	5960	1610	150	0.045	3180	590	80	0.031	7950	2955	200	0.062	3970	955	100	0.040
<b>10.0</b>	4770	1575	150	0.055	2540	565	80	0.037	6360	2940	200	0.077	3180	860	100	0.045
<b>12.0</b>	3970	2065	150	0.065	2120	730	80	0.043	5300	3900	200	0.092	2650	1060	100	0.050

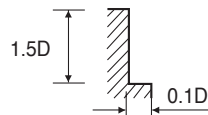
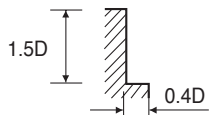


RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t

**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
<b>6.0</b>	10610	1485	200	0.035	5300	530	100	0.025	10610	1190	200	0.028	5300	530	100	0.025
<b>8.0</b>	7950	1430	200	0.045	3970	490	100	0.031	7950	1145	200	0.036	3970	445	100	0.028
<b>10.0</b>	6360	1400	200	0.055	3180	470	100	0.037	6360	1120	200	0.044	3180	405	100	0.032
<b>12.0</b>	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