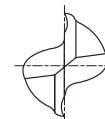


HSSCo8, 2 FLUTE, SHORT LENGTH

GB570 SERIES

FLAT SHANK

- ▶ Excellent at dry cutting
- ▶ Improved wear resistance and edge stability
- ▶ Fine surface finishing



Unit : mm

EDP No.	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
GB570010	1.0	6	2.5	47
GB570015	1.5	6	3	47
GB570020	2.0	6	4	48
GB570030	3.0	6	5	49
GB570035	3.5	6	6	50
GB570040	4.0	6	7	51
GB570045	4.5	6	7	51
GB570050	5.0	6	8	52
GB570055	5.5	6	8	52
GB570060	6.0	6	8	52
GB570070	7.0	10	10	60
GB570080	8.0	10	11	61
GB570090	9.0	10	11	61
GB570100	10.0	10	13	63
GB570120	12.0	12	16	73
GB570140	14.0	12	16	73
GB570160	16.0	16	19	79
GB570180	18.0	16	19	79
GB570200	20.0	20	22	88

Tolerances according to DIN 7160 & 7161

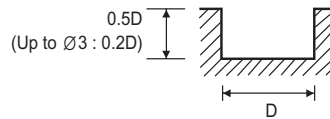
Tolerance range in μm						
Nominal-Diameter in mm						
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
e8	-14 -28	-20 -38	-25 -47	-32 -59	-40 -73	-50 -89
h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16

$\mu\text{m} = 1/1000\text{mm}$

HSSCo8, 2 FLUTE, FINISH SLOTTING

▶▶ GB570, GB571, GB510 SERIES

MATERIAL	CARBON STEELS, ALLOY STEELS, TOOL STEELS								ALUMINUM, ALUMINUM ALLOYS	
	~HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40					
HARDNESS										
STRENGTH	~ 500N/mm ²		500 ~ 800N/mm ²		800 ~ 1000N/mm ²		1000 ~ 1300N/mm ²			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	7850	65	6300	50	5600	48	3100	25	16800	255
3	4900	90	4500	70	3500	64	2250	30	15400	400
4	3900	110	3100	90	2500	72	1550	50	11200	465
5	3100	145	2500	110	2250	96	1250	55	8800	495
6	2500	145	2250	130	1700	96	1100	65	7850	495
8	1950	160	1550	145	1250	112	800	70	5600	625
10	1550	160	1250	145	1100	128	650	70	4350	640
12	1250	175	1100	160	900	128	550	80	3500	610
14	1100	175	1000	145	800	128	500	80	3100	560
16	1000	175	800	145	650	112	400	70	2800	560
18	900	160	700	145	550	112	350	70	2500	560
20	800	160	650	145	550	112	300	70	2250	510



※ The FEED, in long & extra long types, should be reduced by around 50%

RPM = rev./min. Feed = mm/min.