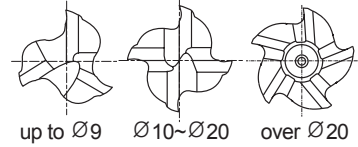


HSSCo8, MULTI FLUTE, ROUGHING, SHORT LENGTH-COARSE PITCH

GB751 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	No. OF FLUTE
GB751060	6.0	6	13	57	3
GB751070	7.0	10	16	66	3
GB751080	8.0	10	19	69	3
GB751090	9.0	10	19	69	3
GB751100	10.0	10	22	72	4
GB751120	12.0	12	26	83	4
GB751140	14.0	12	26	83	4
GB751160	16.0	16	32	92	4
GB751180	18.0	16	32	92	4
GB751200	20.0	20	38	104	4
GB751250	25.0	25	45	121	5

MULTI PURPOSE

Tolerances according to DIN 7160 & 7161

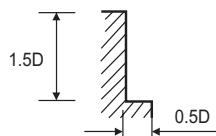
	Tolerance range in μm					
	Nominal-Diameter in mm					
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	$\begin{matrix} 0 \\ -6 \end{matrix}$	$\begin{matrix} 0 \\ -8 \end{matrix}$	$\begin{matrix} 0 \\ -9 \end{matrix}$	$\begin{matrix} 0 \\ -11 \end{matrix}$	$\begin{matrix} 0 \\ -13 \end{matrix}$	$\begin{matrix} 0 \\ -16 \end{matrix}$

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

HSSCo8, MULTI FLUTE, ROUGHING, SIDE CUTTING COARSE PITCH

▶▶ GB751 SERIES

MATERIAL	CARBON STEELS, ALLOY STEELS, TOOL STEELS								ALUMINUM, ALUMINUM ALLOYS	
	~500N/mm ²		500 ~ 800N/mm ²		800 ~ 1000N/mm ²		1000 ~ 1300N/mm ²		RPM	FEED
HARDNESS	~HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40					
STRENGTH										
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	2500	130	2250	95	1700	90	1100	50	6300	320
8	1950	170	1550	120	1250	105	800	55	4350	370
10	1550	240	1250	195	1100	175	650	95	3500	560
12	1260	290	1100	225	900	175	550	110	2800	640
14	1100	290	1000	225	800	175	500	110	2500	670
16	1000	290	800	225	650	175	400	110	2250	720
18	900	290	700	225	550	175	350	110	1950	750
20	800	290	650	225	550	175	300	110	1700	800
25	650	350	550	270	450	225	250	135	1400	720



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