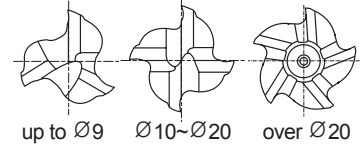


HSSCo8, MULTI FLUTE, ROUGHING, SHORT LENGTH-FINE PITCH

GB753 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
GB753060	6.0	6	13	57	3
GB753070	7.0	10	16	66	3
GB753080	8.0	10	19	69	3
GB753090	9.0	10	19	69	3
GB753100	10.0	10	22	72	4
GB753120	12.0	12	26	83	4
GB753140	14.0	12	26	83	4
GB753160	16.0	16	32	92	4
GB753180	18.0	16	32	92	4
GB753200	20.0	20	38	104	4
GB753250	25.0	25	45	121	5

MULTI PURPOSE

Tolerances according to DIN 7160 & 7161

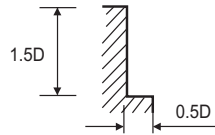
Tolerance range in μm						
Nominal-Diameter in mm						
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	$\begin{matrix} 0 \\ -6 \end{matrix}$	$\begin{matrix} 0 \\ -8 \end{matrix}$	$\begin{matrix} 0 \\ -9 \end{matrix}$	$\begin{matrix}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

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

HSSCo8, MULTI FLUTE, ROUGHING, SIDE CUTTING FINE PITCH

▶▶ GB753 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	~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
6	2500	130	2250	95	1800	90	1100	50	6300	320
8	1950	170	1550	120	1350	105	800	55	4350	370
10	1550	240	1250	195	1200	175	650	95	3500	560
12	1250	290	1100	225	950	175	550	110	2800	640
14	1100	290	1000	225	850	175	500	110	2500	670
16	1000	290	800	225	700	175	400	110	2250	720
18	900	290	700	225	600	175	350	110	1950	750
20	800	290	650	225	600	175	300	110	1700	800
25	650	350	550	270	450	225	250	135	1400	720



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