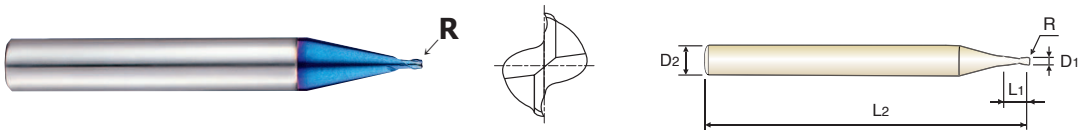
X5070 END MILLS

G8A50 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS
VOLLHARTMETALL, 2 SCHNEIDEN MINI ECKENRADIUS

- Designed to machine high hardened materials.
- Suitable for dry cutting, high speed cutting thanks to newly developed raw-material and new coating.
- Excellent workpiece finish.
- Deep slotting is possible by reduced neck.
- Corner radius for preventing the chipping in high speed machining.
- Higher wear-resistance.

- Geeignet zum Fräsen hochgehärteter Stähle.
- Geeignet zum Trockenfrasen und HSC-Frasen dank neuentwickeltem Material und Beschichtung.
- Excellente Werkstückoberflächen.
- Abgesetzter Schaft für größere Reichweite.
- Schneidkantenschutz durch definierten Radius.
- Höhere Verschleißfestigkeit.



NG HM | 2 | BLUE | 30° | R ±0.010 | PLAIN

P.694

Unit : mm

EDP No.	Corner Radius R (±0.010)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
G8A50003	-	0.3	6	0.45	50
G8A50004	-	0.4	6	0.6	50
G8A50005	R0.05	0.5	6	0.7	50
G8A50006	R0.05	0.6	6	0.9	50
G8A50008	R0.05	0.8	6	1.2	50
G8A50010	R0.10	1.0	6	1.5	50
G8A50012	R0.10	1.2	6	1.8	50
G8A50015	R0.15	1.5	6	2.2	50
G8A50020	R0.15	2.0	6	2.2	50

Due to the characteristics of blue decoration layer which might be erased during short term using, the color layer might not be uniform moreover.
However, it doesn' t effect on performance of tool.

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~−0.012	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									
		○	○	◎	◎									

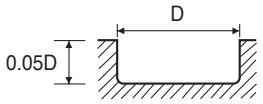
X5070 END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

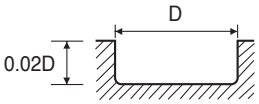
CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN MINI ECKENRADIUS - NUTENFRÄSEN

G8A50 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
HARDNESS	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				HRc 50 ~ HRc 55			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
0.3	50000	190	45	0.002	45000	140	40	0.002	40000	115	40	0.001
0.4	50000	235	65	0.002	45000	180	55	0.002	40000	140	50	0.002
0.5	50000	370	80	0.004	45000	280	70	0.003	40000	220	65	0.003
0.6	50000	470	95	0.005	45000	360	85	0.004	40000	285	75	0.004
0.8	50000	600	125	0.006	40000	440	100	0.006	30000	295	75	0.005
1.0	48000	750	150	0.008	38000	570	120	0.008	25500	360	80	0.007
1.2	42000	790	160	0.009	34000	640	130	0.009	22500	380	85	0.008
1.5	37000	800	175	0.011	30500	670	145	0.011	21000	410	100	0.010
2.0	33300	850	210	0.013	26000	680	165	0.013	17500	420	110	0.012



MATERIAL	HARDENED STEELS							
HARDNESS	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
0.3	33000	70	30	0.001	25000	40	25	0.001
0.4	33000	90	40	0.001	25000	55	30	0.001
0.5	33000	140	50	0.002	25000	85	40	0.002
0.6	30000	160	55	0.003	25000	105	45	0.002
0.8	25000	185	65	0.004	19000	110	50	0.003
1.0	20500	215	65	0.005	16000	135	50	0.004
1.2	20000	250	75	0.006	14500	145	55	0.005
1.5	17000	250	80	0.007	13000	155	60	0.006
2.0	14500	260	90	0.009	11000	160	70	0.007



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