


**X5070
END MILLS**
G8A52 SERIES
**PLAIN SHANK
GLATTER ZYLINDERSCHAFT**

CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS für SCHMALE RIPPEN

- ▶ 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 Trockenfräsen und HSC-Fräsen dank neuentwickeltem Material und Beschichtung.
- ▶ Excellente Werkstückoberflächen.
- ▶ Abgesetzter Schaft für größere Reichweite.
- ▶ Schneidkantenschutz durch definierten Radius.
- ▶ Höhere Verschleißfestigkeit.



P.693

Unit : mm

EDP No.	Corner Radius R (±0.010)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A52005	RO.05	0.5	6	0.7	1.5	50	0.45
G8A52901	RO.05	0.5	6	0.7	3.3	50	0.45
G8A52006	RO.05	0.6	6	0.9	2	50	0.55
G8A52902	RO.05	0.6	6	0.9	4	50	0.55
G8A52008	RO.05	0.8	6	1.2	2.5	50	0.75
G8A52903	RO.05	0.8	6	1.2	5.5	50	0.75
G8A52010	RO.10	1.0	6	1.5	3.3	50	0.95
G8A52904	RO.10	1.0	6	1.5	6.7	50	0.95
G8A52012	RO.10	1.2	6	1.8	4.4	50	1.15
G8A52905	RO.10	1.2	6	1.8	8	50	1.15
G8A52015	RO.15	1.5	6	2.2	5	50	1.45
G8A52906	RO.15	1.5	6	2.2	9.7	50	1.45
G8A52020	RO.15	2.0	6	2.2	6	50	1.95
G8A52907	RO.15	2.0	6	2.2	13	50	1.95



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

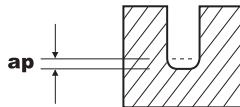
◎ : Excellent ○ : Good

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								
		○	○	◎	◎								

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VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS für SCHMALE RIPPEN
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MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
HARDNESS	HRc 30 ~ HRc 45					HRc 45 ~ HRc 55				
DIAMETER	RPM	FEED	ap(mm)	Vc	fz	RPM	FEED	ap(mm)	Vc	fz
0.5	25650~33000	370~470	0.0056~0.0350	40~52	0.029~0.028	23750~26000	285~315	0.0040~0.0250	37~41	0.024~0.024
0.6	20900~35200	330~560	0.0063~0.0294	39~66	0.032~0.032	19900~22000	260~290	0.0450~0.0210	38~41	0.026~0.026
0.8	16150~26400	360~590	0.0084~0.0392	41~66	0.045~0.045	15200~16700	280~310	0.0060~0.0280	38~42	0.037~0.037
1.0	12300~18700	350~540	0.0105~0.0280	39~59	0.057~0.058	10500~11500	250~280	0.0075~0.0200	33~36	0.048~0.049
1.2	10450~17600	350~590	0.0245~0.0700	39~66	0.067~0.067	9100~10000	250~280	0.0150~0.0420	34~38	0.055~0.056
1.5	9100~17600	430~830	0.0161~0.0770	43~83	0.095~0.094	7000~8000	250~280	0.0115~0.0550	33~38	0.071~0.070
2.0	6350~10550	340~570	0.0210~0.1400	40~66	0.107~0.108	6100~6700	270~300	0.0150~0.1000	38~42	0.089~0.090

MATERIAL	HARDENED STEELS				
HARDNESS	HRc 55 ~ HRc 60				
DIAMETER	RPM	FEED	ap(mm)	Vc	fz
0.5	14200~18000	115~130	0.0024~0.0150	22~28	0.016~0.014
0.6	11900~15500	100~120	0.0027~0.0126	22~29	0.017~0.015
0.8	9000~11700	110~125	0.0036~0.0168	23~29	0.024~0.021
1.0	6300~8050	100~115	0.0045~0.0120	20~25	0.032~0.029
1.2	5400~7000	100~115	0.0090~0.0252	20~26	0.037~0.033
1.5	4300~5500	100~115	0.0069~0.0330	20~26	0.047~0.042
2.0	3600~4700	100~120	0.0090~0.0600	23~30	0.056~0.051



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

HSS

CBN
END MILLSi-Xmill
END MILLSi-HS mill
END MILLSX5070
END MILLS4G MILL
END MILLSX-SPEED
ROUGHER
END MILLSX-POWER
END MILLSJET-POWER
END MILLSTN MILL
END MILLSV7 Mill
END MILLSALU-POWER
END MILLSCRX S
END MILLSD-POWER
GRAPHITE
END MILLSD-POWER
CFRP
END MILLS

ROUTERS

K-2 CARBIDE
END MILLSGENERAL
CARBIDE
END MILLSTANK-POWER
END MILLSGENERAL
HSS
END MILLSMILLING
CUTTERSTECHNICAL
DATA