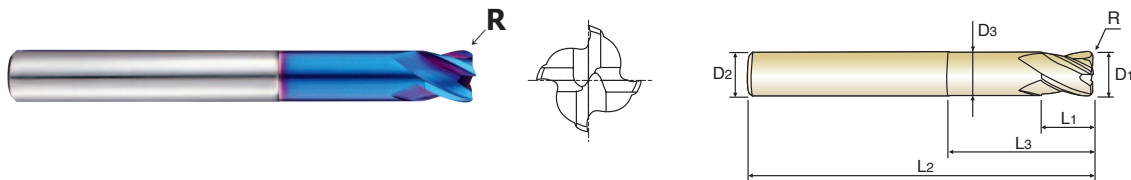




**CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK**  
**VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETTEL**

- ▶ 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.



NG HM
4
BLUE
30°
R ±0.010
R ±0.015
PLAIN
P.695

Ø6 Ø8-Ø12

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8B0806005090	R0.5	6.0	6	9	20	90	5.85
G8B0806010090	R1.0	6.0	6	9	20	90	5.85
G8B0808005100	R0.5	8.0	8	12	25	100	7.7
G8B0808010100	R1.0	8.0	8	12	25	100	7.7
G8B0810005100	R0.5	10.0	10	15	32	100	9.7
G8B0810010100	R1.0	10.0	10	15	32	100	9.7
G8B0810020100	R2.0	10.0	10	15	32	100	9.7
G8B0812005110	R0.5	12.0	12	18	38	110	11.7
G8B0812010110	R1.0	12.0	12	18	38	110	11.7
G8B0812020110	R2.0	12.0	12	18	38	110	11.7

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.

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.012	h6
over Ø6	±0.015	0~-0.015	

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									
		○	○	◎	◎									

◎ : Excellent ○ : Good



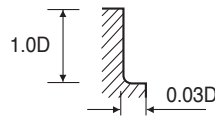
**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE CORNER RADIUS  
VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS**

**G8A47, G8B08 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				HRc 50 ~ HRc 55			
	HARDNESS DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc
1.0	48000	1184	150	0.006	38000	840	120	0.006	25500	568	80	0.006
2.0	33300	1400	210	0.011	26000	1000	165	0.010	17500	672	110	0.010
3.0	21800	1400	205	0.016	17300	1000	165	0.014	11500	672	110	0.015
4.0	16700	1440	210	0.022	13200	1040	165	0.020	8800	704	110	0.020
5.0	15700	1600	245	0.025	12500	1200	195	0.024	8300	800	130	0.024
6.0	13100	1560	245	0.030	10350	1120	195	0.027	6900	760	130	0.028
8.0	9880	1504	250	0.038	7800	1080	195	0.035	5200	720	130	0.035
10.0	7800	1400	245	0.045	6150	1008	195	0.041	4100	672	130	0.041
12.0	6650	1400	250	0.053	5250	1008	200	0.048	3500	672	130	0.048
16.0	4900	1200	245	0.061	3900	880	195	0.056	2600	584	130	0.056
20.0	3900	1040	245	0.067	3100	776	195	0.063	2050	520	130	0.063

MATERIAL	HARDENED STEELS											
	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65				HRc 65 ~ HRc 70			
	HARDNESS DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc
1.0	20500	344	65	0.004	16000	216	50	0.003	12500	140	40	0.700
2.0	14500	416	90	0.007	11000	256	70	0.006	9500	184	60	0.657
3.0	9500	416	90	0.011	7500	256	70	0.009	6400	184	60	0.657
4.0	7200	432	90	0.015	5600	268	70	0.012	4750	192	60	0.686
5.0	6400	464	100	0.018	5100	296	80	0.015	4450	216	70	0.675
6.0	5300	448	100	0.021	4200	280	80	0.017	3700	208	70	0.650
8.0	4000	416	100	0.026	3200	264	80	0.021	2800	192	70	0.600
10.0	3200	384	100	0.030	2550	248	80	0.024	2200	176	70	0.550
12.0	2650	384	100	0.036	2100	240	80	0.029	1860	176	70	0.550
16.0	2000	336	100	0.042	1600	216	80	0.034	1400	160	70	0.500
20.0	1600	304	100	0.048	1300	200	80	0.038	1100	144	70	0.450



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

- HSS
- CBN END MILLS
- i-Xmill END MILLS
- i-HS mill END MILLS
- X5070 END MILLS
- 4G MILL END MILLS
- X-SPEED ROUGHER END MILLS
- X-POWER END MILLS
- JET-POWER END MILLS
- TN MILL END MILLS
- V7 Mill END MILLS
- ALU-POWER END MILLS
- CRX S END MILLS
- D-POWER GRAPHITE END MILLS
- D-POWER CFRP END MILLS
- ROUTERS
- K-2 CARBIDE END MILLS
- GENERAL CARBIDE END MILLS
- TANK-POWER END MILLS
- GENERAL HSS END MILLS
- MILLING CUTTERS
- TECHNICAL DATA