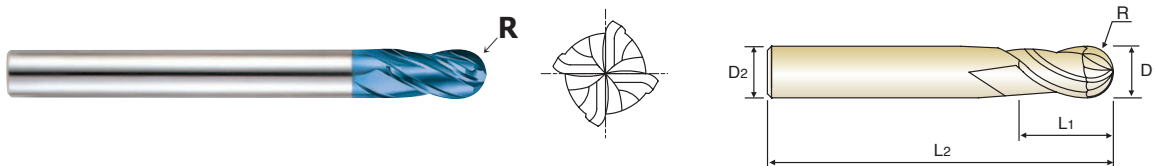




PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE BALL NOSE - Center Match VOLLHARTMETALL, 3 SCHNEIDEN STIRNRADIUS - Schneiden Mittelpunkt

- ▶ Applied center match type & special new design on ball center shape.
- ▶ Excellent high wear resistance and high performance.
- ▶ Applied for high speed and feed.
- ▶ Increased the surface roughness.
- ▶ Neues Design der Kugelschneidengeometrie
- ▶ Hohe Verschleißfestigkeit, hohe Leistung.
- ▶ Geeignet für hohe Schnittgeschwindigkeiten und hohe Vorschübe
- ▶ verbessert deutlich die Oberflächenrauigkeit



NG HM
4
BLUE
30°
R ±0.005
R ±0.010
PLAIN
P.690

R1.5-R3 R4-R10

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R	D1	D2	L1	L2
G8D62030	R1.5	3.0	6	8	60
G8D62040	R2.0	4.0	6	8	70
G8D62050	R2.5	5.0	6	10	80
G8D62060	R3.0	6.0	6	12	90
G8D62080	R4.0	8.0	8	14	100
G8D62100	R5.0	10.0	10	18	100
G8D62120	R6.0	12.0	12	22	110
G8D62160	R8.0	16.0	16	30	140
G8D62200	R10.0	20.0	20	38	160

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	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	±0.005	0~-0.012	h6
over R3	±0.010	0~-0.015	

◎ : 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									
		○	○	◎	◎									



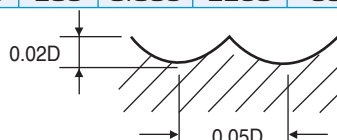
**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE BALL NOSE - Center Match
VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS - Schneiden Mittelpunkt**

G8D62 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS								HARDENED STEELS					
	HRc 30 ~ HRc 45				HRc 45 ~ HRc 55				HRc 55 ~ HRc 60					
	HARDNESS DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	
R1.5 × 3.0	36100	10200	340	0.071	30250	7300	285	0.060	24440	4880	230	0.050		
R2.0 × 4.0	27050	8700	340	0.080	22650	6350	285	0.070	18300	4400	230	0.060		
R2.5 × 5.0	21600	7800	340	0.090	17820	5750	280	0.081	14650	4150	230	0.071		
R3.0 × 6.0	18040	7320	340	0.101	15180	5560	285	0.092	12210	4020	230	0.082		
R4.0 × 8.0	13530	6270	340	0.116	11330	4680	285	0.103	9190	3520	230	0.096		
R5.0 × 10.0	10840	5560	340	0.128	9130	4070	285	0.111	7370	3080	230	0.104		
R6.0 × 12.0	9020	5230	340	0.145	7590	3800	285	0.125	6110	2810	230	0.115		
R8.0 × 16.0	6770	3910	340	0.144	5670	2920	285	0.129	4620	2200	230	0.119		
R10.0 × 20.0	5450	3140	340	0.144	4570	2310	285	0.126	3690	1760	230	0.119		

MATERIAL	HARDENED STEELS							
	HRc 60 ~ HRc 65				HRc 65 ~ HRc 70			
	HARDNESS DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc
R1.5 × 3.0	22280	4010	210	0.045	15170	2430	145	0.040
R2.0 × 4.0	16710	3680	210	0.055	11380	2280	145	0.050
R2.5 × 5.0	13370	3590	210	0.067	9100	2260	145	0.062
R3.0 × 6.0	11110	3410	210	0.077	7590	2200	145	0.072
R4.0 × 8.0	8310	2970	210	0.089	5670	1870	145	0.082
R5.0 × 10.0	6660	2530	210	0.095	4570	1760	145	0.096
R6.0 × 12.0	5560	2150	210	0.097	3800	1430	145	0.094
R8.0 × 16.0	4180	1600	210	0.096	2860	1100	145	0.096
R10.0 × 20.0	3300	1270	205	0.096	2260	880	140	0.097



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