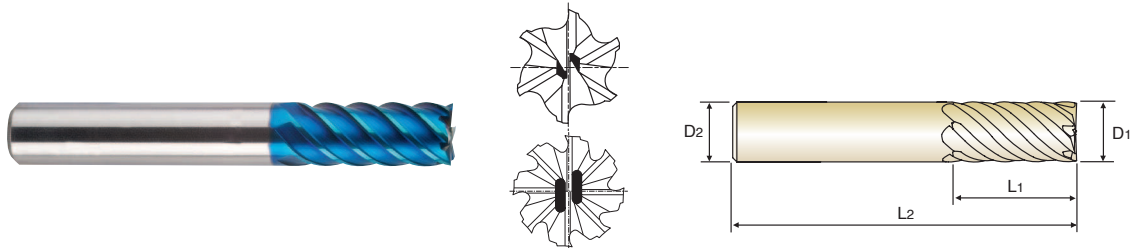




CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG

- ▶ Designed to machine high hardened materials.
- ▶ Designed for high abrasion resistance thanks to negative rake angle.
- ▶ Excellent side-cutting of press mold field.
- ▶ Speziell ausgelegt für die Hartbearbeitung
- ▶ Ausgelegt für hohe Abriebfestigkeit dank der negativen Spanwinkel.
- ▶ hervorragend geeignet für die Seitenbearbeitung im Formenbau

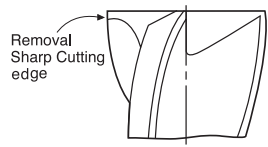


Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	No. of Flute
G8D63060	6.0	6	13	57	6
G8D63080	8.0	8	19	63	6
G8D63100	10.0	10	22	72	6
G8D63120	12.0	12	26	83	6
G8D63140	14.0	14	26	83	6
G8D63160	16.0	16	32	92	6
G8D63180	18.0	18	32	92	8
G8D63200	20.0	20	38	104	8
G8D63250	25.0	25	44	104	8

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~-0.02	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									
		○	○	◎	◎									

- 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



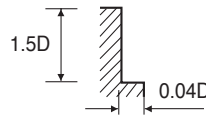
**RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 6&8 FLUTE 45° HELIX LONG - SIDE CUTTING
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG - SEITENFRÄSEN**

G8D63 SERIES

MATERIAL HARDNESS DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 55			
	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	6360	1500	120	0.039	5040	1045	95	0.035
8.0	4800	1510	120	0.052	3840	1070	95	0.046
10.0	3840	1450	120	0.063	3000	995	95	0.055
12.0	3240	1355	120	0.070	2520	935	95	0.062
14.0	2730	1320	120	0.081	2180	920	95	0.070
16.0	2400	1300	120	0.090	1920	910	95	0.079
18.0	2120	1610	120	0.095	1700	1090	95	0.080
20.0	1920	1210	120	0.079	1560	1130	100	0.091
25.0	1560	1370	125	0.110	1200	925	95	0.096

MATERIAL HARDNESS DIAMETER	HARDENED STEELS							
	HRc 55 ~ HRc 65				HRc 65 ~ HRc 70			
	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	3840	720	70	0.031	2520	430	50	0.028
8.0	2880	720	70	0.042	1920	430	50	0.037
10.0	2280	685	70	0.050	1560	420	50	0.045
12.0	1920	650	70	0.056	1320	395	50	0.050
14.0	1600	630	70	0.066	1070	325	45	0.051
16.0	1440	625	70	0.072	960	370	50	0.064
18.0	1280	750	70	0.073	850	450	50	0.066
20.0	1200	660	75	0.069	720	410	45	0.071
25.0	960	670	75	0.087	610	385	50	0.079



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

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