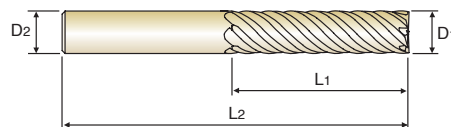
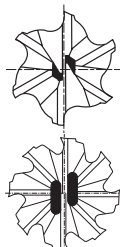




CARBIDE, 6&8 FLUTE 45° HELIX EXTRA LONG LENGTH
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE EXTRA LANG

- ▶ 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

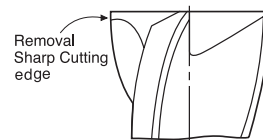


Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
	D1	D2	L1	L2	
G8D64060	6.0	6	26	70	6
G8D64080	8.0	8	36	90	6
G8D64100	10.0	10	46	100	6
G8D64120	12.0	12	56	110	6
G8D64160	16.0	16	66	130	6
G8D64200	20.0	20	76	140	8
G8D64250	25.0	25	92	180	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~-0.03	h6



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									
		○	○	◎	◎									

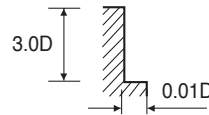


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

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

G8D64 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS							
	HARDNESS DIAMETER	HRc 30 ~ HRc 40				HRc 40 ~ HRc 55				HRc 55 ~ HRc 65			
		RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	3180	770	60	0.040	3180	575	60	0.030	2540	455	50	0.030	
8.0	2390	720	60	0.050	2390	575	60	0.040	1910	455	50	0.040	
10.0	1910	685	60	0.060	1910	575	60	0.050	1520	455	50	0.050	
12.0	1580	660	60	0.070	1580	575	60	0.061	1270	455	50	0.060	
14.0	1370	620	60	0.075	1370	540	60	0.066	1090	430	50	0.066	
16.0	1190	575	60	0.081	1190	505	60	0.071	960	410	50	0.071	
18.0	1070	730	60	0.085	1070	685	60	0.080	850	550	50	0.081	
20.0	960	660	60	0.086	960	695	60	0.090	770	560	50	0.091	
25.0	770	550	60	0.089	770	490	60	0.080	610	395	50	0.081	



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