

YE-E212



# The X5070

for Machining High Hardened Steel  
for High Speed Cutting & Dry Cutting  
for Mold & Die

*Blue*



**YG-1 CO., LTD.**

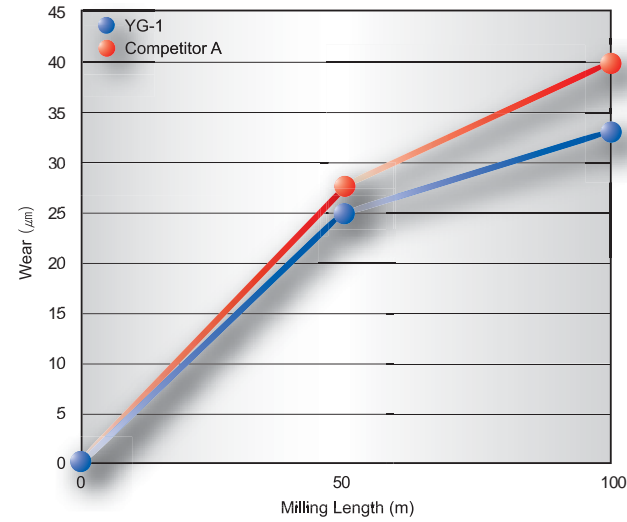
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Tool specifications are subject to change without notice.

YG1E2110530003

**YG-1 CO., LTD.**

● Carbide 6FL. 45° Helix End Mill for Hardened Steel

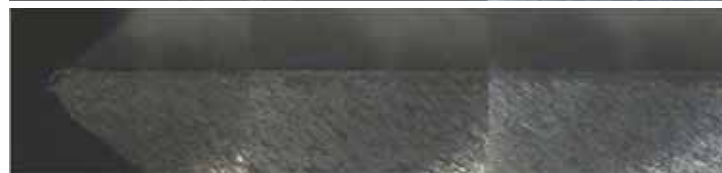


**CUTTING CONDITION**  
**Tools :** 6Flute, X5070 45° Helix  
**Size :** Ø16×Ø16×40×110  
**Work Material :** • JIS:SKD61(HRc50)  
 • DIN:X40CrMoV5-1(1.2344)  
 • AISI:H13  
**Cutting Speed :** 96.5 m/min.  
**R.P.M :** 1,920 rev./min.  
**Feed :** 912 mm/min.  
**Milling Method :** Down & Side Cutting  
**Milling Depth :** Axial : 24 mm  
 Radial : 0.96 mm  
**Coolant :** Dry Cut  
**Overhang :** 52 mm  
**Machine :** Machining Center

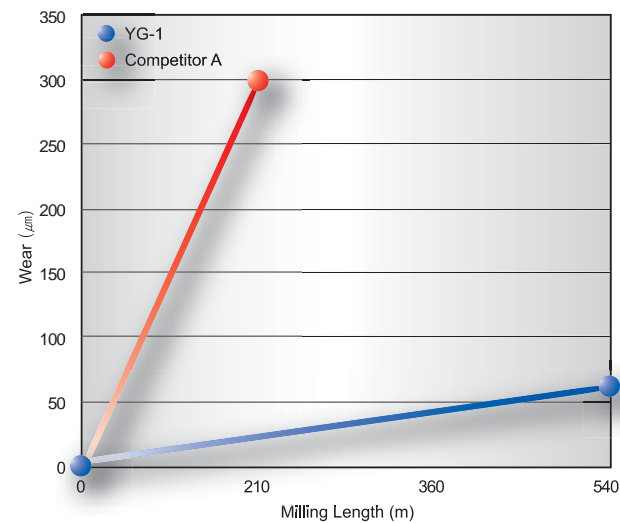
**YG-1**  
(Total Milling Length 100m)



**Competitor A**  
(Total Milling Length 100m)



● Carbide 4FL. Center Match Ball End Mill for Hardened Steel



**CUTTING CONDITION**  
**Tools :** 4Flute, X5070 Ball Nose  
**Size :** Ø10×Ø10×18×100  
**Work Material :** • JIS:SKD11(HRc60)  
 • DIN:X155CrVMo12-1(1.2379)  
 • AISI:D2  
**Cutting Speed :** 210.486 m/min.  
**R.P.M :** 6,700 rev./min.  
**Feed :** 2,800 mm/min.  
**Milling Method :** Side Cutting  
**Milling Depth :** Axial : 0.2 mm  
 Radial : 0.5 mm  
**Coolant :** Oil Mist  
**Overhang :** 32 mm  
**Machine :** Machining Center

**YG-1**  
(Total Milling Length 540m)

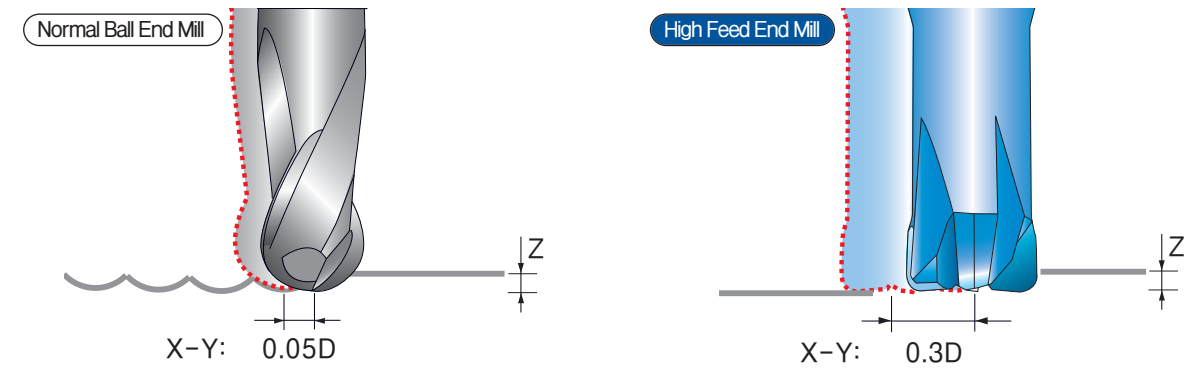


**Competitor A**  
(Total Milling Length 210m)



High Feed End Mill Capabilities :

- ✓ High speed roughing
- ✓ High speed finishing.. Mirror like surface

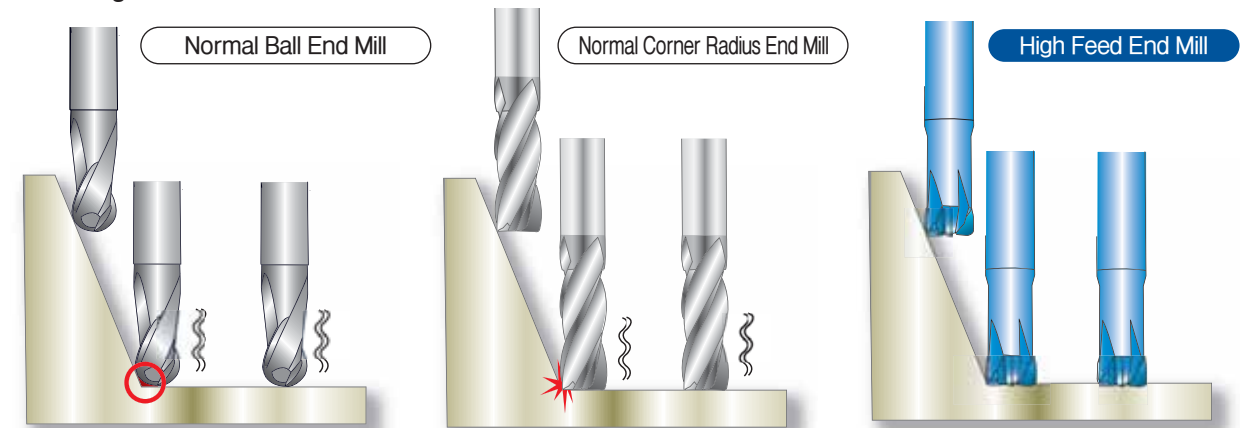


- More number of flutes than normal 2F ball E/M makes high-feed cutting. For X-Y wide cutting pitch, high effective cutting performs in short tool working time.







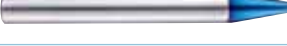
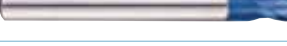
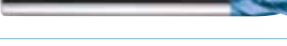













(Example of performance : for the material HRc 50~55)

ITEM	SIZE	RPM	FEED	DEPTH OF CUT	
				Z (mm)	X-Y (mm)
High Feed End Mill	4F Ø 10×R2	5400	11,000	02	30
Normal Ball End Mill	2F Ø 10×R5	7,500	2,500	02	05

- For cutting on slope and corner, the remaining part to be cut is smaller than one which comes from the working with normal ball end mill. It saves the time and cost.



- By using straight flute, the rigidity of corner radius is improved. And it's also possible to get less damage to end teeth and radius than normal radius end mill

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
G8B59		CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS HIGH FEED	D2.0	D12.0	4
G8B54		CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS HIGH FEED	D2.0	D16.0	7
G8A46		CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING	R0.05	R2.0	8
G8A54		CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING	R0.25	R1.0	9
G8A28		CARBIDE, 2 FLUTE BALL NOSE	R0.05	R6.0	10
G8A38		CARBIDE, 2 FLUTE STUB LENGTH BALL NOSE with EXTENDED NECK	R0.5	R12.5	11
G8A53		CARBIDE, 2 FLUTE MINIATURE BALL NOSE	R0.2	R1.0	12
G8A59		CARBIDE, 3 FLUTE BALL NOSE	R1.5	R10.0	13
G8D62		CARBIDE, 4 FLUTE BALL NOSE - Center Match	R1.5	R10.0	16
G8A60		CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING	D0.5	D12.0	17
G8A36		CARBIDE, 2 FLUTE STUB LENGTH CORNER RADIUS with EXTENDED NECK	D0.3	D20.0	18
G8A52		CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING	D0.5	D2.0	19
G8A50		CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS	D0.3	D2.0	20
G8A47		CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK	D3.0	D12.0	21
G8A37		CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS with EXTENDED NECK	D1.0	D20.0	22
G8B08		CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK	D6.0	D12.0	23
G8A39		CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS with EXTENDED NECK	D6.0	D20.0	26
G8A45		CARBIDE, 2 FLUTE for RIB PROCESSING	D0.1	D4.0	27
G8A01		CARBIDE, 2 FLUTE with EXTENDED NECK	D0.1	D20.0	28
G8A02		CARBIDE, 4 FLUTE with EXTENDED NECK	D1.0	D20.0	29
G8D63		CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH	D6.0	D25.0	30
G8D64		CARBIDE, 6&8 FLUTE 45° HELIX EXTRA LONG LENGTH	D6.0	D25.0	
RECOMMENDED CUTTING CONDITIONS					

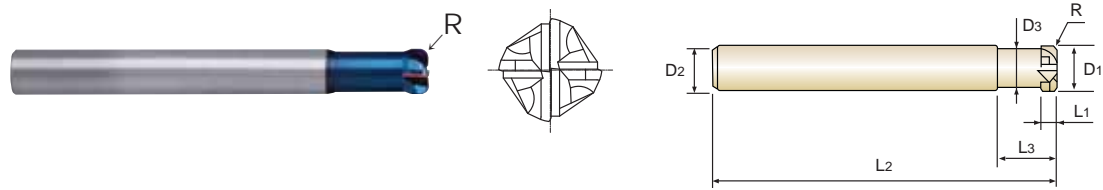
**SELECTION GUIDE**

◎ : Excellent, ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
			-HB225	HB225~325								
			○	○	◎	◎						
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**CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS HIGH FEED**

- ▶ Excellent wear resistance at heavy feed rates on high hardened material.
- ▶ Designed with reduced clearance angles and short flutes for strength.
- ▶ High hardness & heat resistance coating for long life in dry applications.

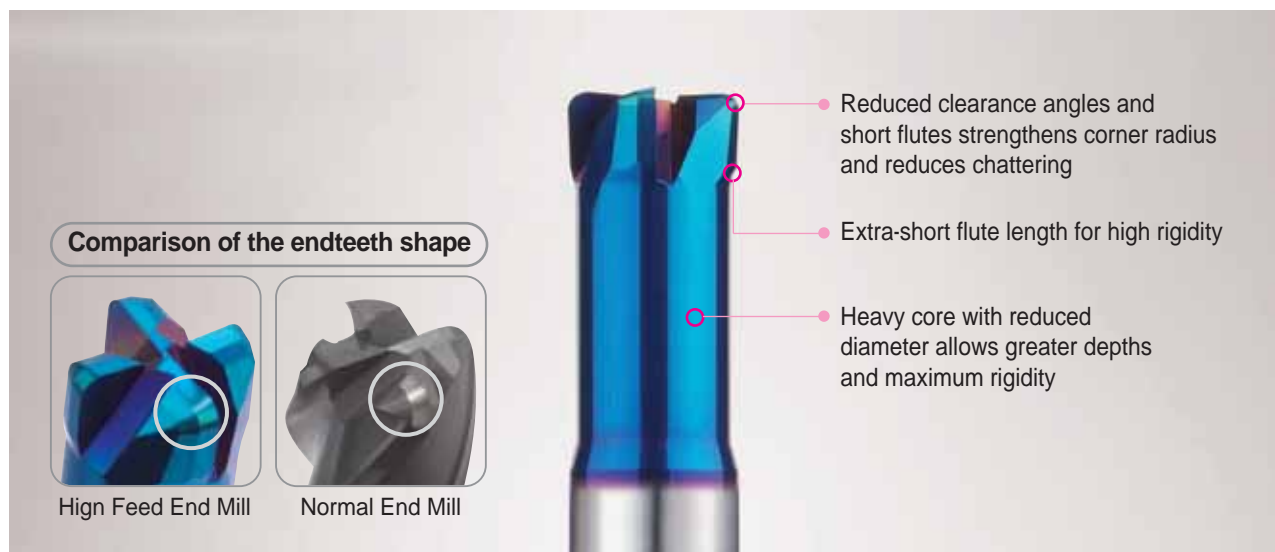


Unit : mm

EDP No.	Corner Radius R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8B5902005	R0.5	2.0	6	1	6	50	1.8
G8B5903005	R0.5	3.0	6	1.2	8	50	2.8
G8B5904005	R0.5	4.0	6	1.5	10	50	3.8
G8B5906005	R0.5	6.0	6	2.5	12	60	5.4
G8B5906010	R1.0	6.0	6	2.5	12	60	5.4
G8B5908010	R1.0	8.0	8	3.5	16	60	7.2
G8B5908020	R2.0	8.0	8	3.5	16	60	7.2
G8B5910010	R1.0	10.0	10	4	20	70	9
G8B5910020	R2.0	10.0	10	4	20	70	9
G8B5912020	R2.0	12.0	12	5	25	80	11
G8B5912030	R3.0	12.0	12	5	25	80	11

Due to the characteristics of blue decoration layer which might be earased 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)	Corner Radius Tolerance (mm)	Shank Dia. Tolerance
0~-0.02	±0.005	h6



◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

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Unit : mm

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G8B5402005	R0.5	2.0	6	1	6	70	1.8
G8B5403005	R0.5	3.0	6	1.2	8	70	2.8
G8B5404005	R0.5	4.0	6	1.5	10	70	3.8
G8B5405005	R0.5	5.0	6	2	10	70	4.6
G8B5406005	R0.5	6.0	6	2.5	12	90	5.4
G8B5406010	R1.0	6.0	6	2.5	12	90	5.4
G8B5408010	R1.0	8.0	8	3.5	16	100	5.4
G8B5408020	R2.0	8.0	8	3.5	16	100	7.2
G8B5410010	R1.0	10.0	10	4	20	100	7.2
G8B5410020	R2.0	10.0	10	4	20	100	9
G8B5412020	R2.0	12.0	12	5	25	110	9
G8B5412030	R3.0	12.0	12	5	25	110	11
G8B5416030	R3.0	16.0	16	6.5	30	130	11

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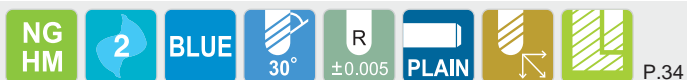
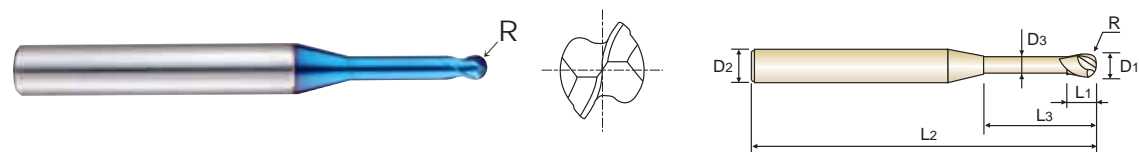
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-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Radius of Ball Nose R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A46805	RO.05	0.1	4	0.1	0.3	45	0.085
G8A46806	RO.05	0.1	4	0.1	0.5	45	0.085
G8A46002	RO.1	0.2	4	0.2	0.5	45	0.17
G8A46977	RO.1	0.2	4	0.2	1	45	0.17
G8A46958	RO.1	0.2	4	0.2	1.5	45	0.17
G8A46003	RO.15	0.3	4	0.3	1	45	0.27
G8A46959	RO.15	0.3	4	0.3	2	45	0.27
G8A46986	RO.15	0.3	4	0.3	3	45	0.27
G8A46004	RO.2	0.4	4	0.4	1	45	0.37
G8A46960	RO.2	0.4	4	0.4	2	45	0.37
G8A46961	RO.2	0.4	4	0.4	3	45	0.37
G8A46981	RO.2	0.4	4	0.4	4	45	0.37
G8A46987	RO.2	0.4	4	0.4	5	45	0.37
G8A46005	RO.25	0.5	4	0.4	2	45	0.45
G8A46804	RO.25	0.5	4	0.4	2.5	45	0.45
G8A46962	RO.25	0.5	4	0.4	4	45	0.45
G8A46963	RO.25	0.5	4	0.4	6	45	0.45
G8A46964	RO.25	0.5	4	0.4	8	45	0.45
G8A46957	RO.3	0.6	4	0.5	2	45	0.55
G8A46988	RO.3	0.6	4	0.5	3	45	0.55
G8A46915	RO.3	0.6	4	0.5	4	45	0.55
G8A46989	RO.3	0.6	4	0.5	5	45	0.55
G8A46916	RO.3	0.6	4	0.5	6	45	0.55
G8A46917	RO.3	0.6	4	0.5	8	45	0.55
G8A46990	RO.3	0.6	4	0.5	10	45	0.55
G8A46918	RO.4	0.8	4	0.6	2	45	0.75
G8A46919	RO.4	0.8	4	0.6	4	45	0.75
G8A46008	RO.4	0.8	4	0.6	6	45	0.75
G8A46901	RO.4	0.8	4	0.6	8	45	0.75

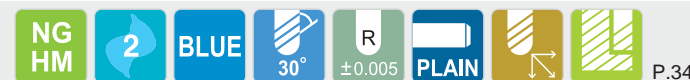
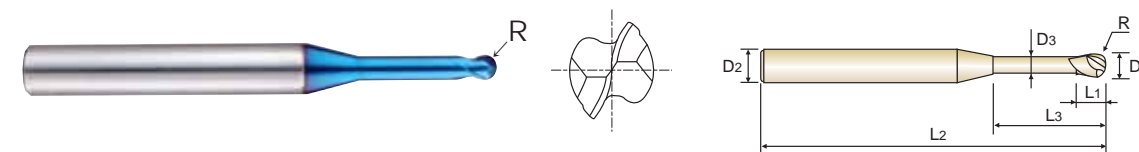
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-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
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Unit : mm

EDP No.	Radius of Ball Nose R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A46965	RO.4	0.8	4	0.6	10	45	0.75
G8A46920	RO.5	1.0	4	0.8	3	45	0.95
G8A46921	RO.5	1.0	4	0.8	4	45	0.95
G8A46923	RO.5	1.0	4	0.8	5	45	0.95
G8A46010	RO.5	1.0	4	0.8	6	45	0.95
G8A46924	RO.5	1.0	4	0.8	7	45	0.95
G8A46902	RO.5	1.0	4	0.8	8	45	0.95
G8A46925	RO.5	1.0	4	0.8	9	45	0.95
G8A46903	RO.5	1.0	4	0.8	10	45	0.95
G8A46904	RO.5	1.0	4	0.8	12	45	0.95
G8A46926	RO.5	1.0	4	0.8	14	50	0.95
G8A46927	RO.5	1.0	4	0.8	16	50	0.95
G8A46966	RO.5	1.0	4	0.8	20	55	0.95
G8A46982	RO.6	1.2	4	1.0	6	45	1.15
G8A46012	RO.6	1.2	4	1.0	8	45	1.15
G8A46983	RO.6	1.2	4	1.0	10	45	1.15
G8A46905	RO.6	1.2	4	1.0	12	45	1.15
G8A46930	RO.75	1.5	4	1.2	6	45	1.45
G8A46015	RO.75	1.5	4	1.2	8	45	1.45
G8A46931	RO.75	1.5	4	1.2	10	45	1.45
G8A46906	RO.75	1.5	4	1.2	12	45	1.45
G8A46992	RO.75	1.5	4	1.2	14	50	1.45
G8A46907	RO.75	1.5	4	1.2	16	50	1.45
G8A46932	RO.75	1.5	4	1.2	20	55	1.45
G8A46939	R1.0	2.0	4	1.6	4	45	1.95
G8A46940	R1.0	2.0	4	1.6	6	45	1.95
G8A46020	R1.0	2.0	4	1.6	8	45	1.95
G8A46941	R1.0	2.0	4	1.6	10	45	1.95
G8A46942	R1.0	2.0	4	1.6	12	50	1.95

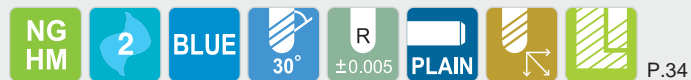
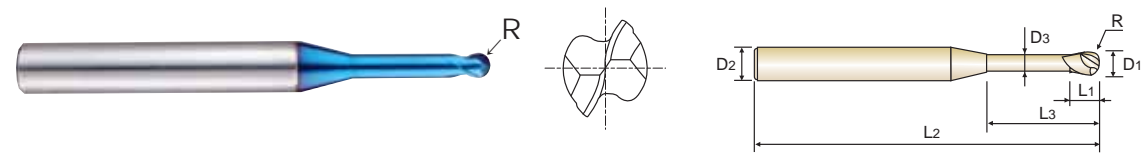
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-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

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Unit : mm

EDP No.	Radius of Ball Nose R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A46943	R1.0	2.0	4	1.6	14	50	1.95
G8A46909	R1.0	2.0	4	1.6	16	50	1.95
G8A46993	R1.0	2.0	4	1.6	18	55	1.95
G8A46910	R1.0	2.0	4	1.6	20	55	1.95
G8A46944	R1.0	2.0	4	1.6	22	60	1.95
G8A46945	R1.0	2.0	4	1.6	25	60	1.95
G8A46967	R1.0	2.0	4	1.6	30	70	1.95
G8A46948	R1.5	3.0	6	2.4	12	50	2.85
G8A46984	R1.5	3.0	6	2.4	14	55	2.85
G8A46030	R1.5	3.0	6	2.4	16	55	2.85
G8A46985	R1.5	3.0	6	2.4	18	60	2.85
G8A46911	R1.5	3.0	6	2.4	20	60	2.85
G8A46968	R1.5	3.0	6	2.4	25	65	2.85
G8A46969	R1.5	3.0	6	2.4	30	70	2.85
G8A46970	R1.5	3.0	6	2.4	35	80	2.85
G8A46950	R2.0	4.0	6	3.2	12	60	3.85
G8A46040	R2.0	4.0	6	3.2	16	60	3.85
G8A46912	R2.0	4.0	6	3.2	20	65	3.85
G8A46913	R2.0	4.0	6	3.2	25	70	3.85
G8A46971	R2.0	4.0	6	3.2	30	70	3.85
G8A46972	R2.0	4.0	6	3.2	35	80	3.85
G8A46973	R2.0	4.0	6	3.2	40	90	3.85
G8A46974	R2.0	4.0	6	3.2	45	90	3.85
G8A46975	R2.0	4.0	6	3.2	50	100	3.85

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

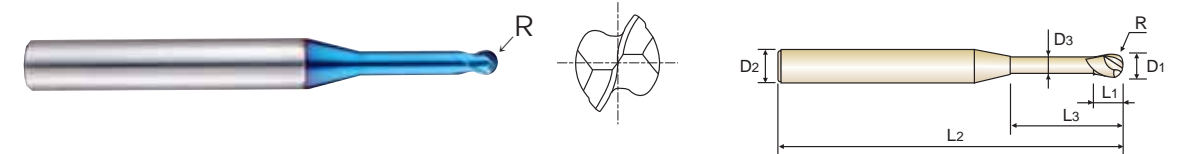
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Radius of Ball Nose R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A54005	R0.25	0.5	6	0.5	1.5	50	0.45
G8A54901	R0.25	0.5	6	0.5	3.3	50	0.45
G8A54006	R0.3	0.6	6	0.6	2	50	0.55
G8A54902	R0.3	0.6	6	0.6	4	50	0.55
G8A54008	R0.4	0.8	6	0.8	2.5	50	0.75
G8A54903	R0.4	0.8	6	0.8	5.5	50	0.75
G8A54010	R0.5	1.0	6	1	3.3	50	0.95
G8A54904	R0.5	1.0	6	1	6.7	50	0.95
G8A54905	R0.5	1.0	6	1	12	50	0.95
G8A54012	R0.6	1.2	6	1.2	4.4	50	1.15
G8A54906	R0.6	1.2	6	1.2	8	50	1.15
G8A54015	R0.75	1.5	6	1.5	5	50	1.45
G8A54907	R0.75	1.5	6	1.5	9.7	50	1.45
G8A54908	R0.75	1.5	6	1.5	15	50	1.45
G8A54020	R1.0	2.0	6	2	6	50	1.95
G8A54909	R1.0	2.0	6	2	13	50	1.95
G8A54910	R1.0	2.0	6	2	20	60	1.95

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

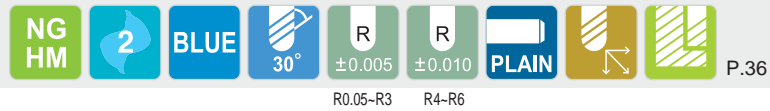
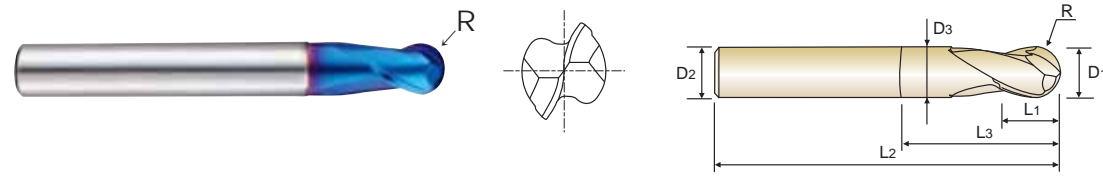
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE BALL NOSE**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8A28001	R0.05	0.1	4	0.2	-	40	-
G8A28002	R0.1	0.2	4	0.3	-	40	-
G8A28003	R0.15	0.3	4	0.5	-	40	-
G8A28004	R0.2	0.4	4	0.6	-	40	-
G8A28005	R0.25	0.5	4	0.7	-	40	-
G8A28006	R0.3	0.6	4	0.9	-	40	-
G8A28007	R0.35	0.7	4	1.1	-	40	-
G8A28008	R0.4	0.8	4	1.2	-	40	-
G8A28009	R0.45	0.9	4	1.4	-	40	-
G8A28010	R0.5	1.0	6	1.5	3	50	0.95
G8A28015	R0.75	1.5	6	2	4	50	1.45
G8A28020	R1.0	2.0	6	2.5	5	50	1.95
G8A28025	R1.25	2.5	6	3	7	50	2.4
G8A28030	R1.5	3.0	6	4	10	60	2.85
G8A28035	R1.75	3.5	6	4.5	10	60	3.35
G8A28040	R2.0	4.0	6	5	10	60	3.85
G8A28045	R2.25	4.5	6	5.5	10	60	4.35
G8A28050	R2.5	5.0	6	6	12	60	4.85
G8A28055	R2.75	5.5	6	6.5	12	60	5.35
G8A28060	R3.0	6.0	6	7	15	60	5.85
G8A28903	R3.0	6.0	6	9	30	90	5.85
G8A28901	R4.0	8.0	8	9	15	60	7.7
G8A28080	R4.0	8.0	8	9	15	80	7.7
G8A28904	R4.0	8.0	8	12	30	100	7.7
G8A28902	R5.0	10.0	10	11	25	60	9.7
G8A28100	R5.0	10.0	10	11	25	80	9.7
G8A28905	R5.0	10.0	10	15	30	100	9.7
G8A28120	R6.0	12.0	12	14	25	80	11.7

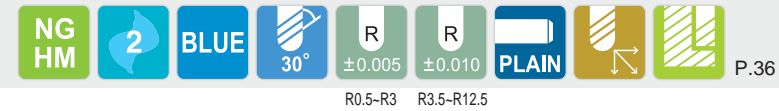
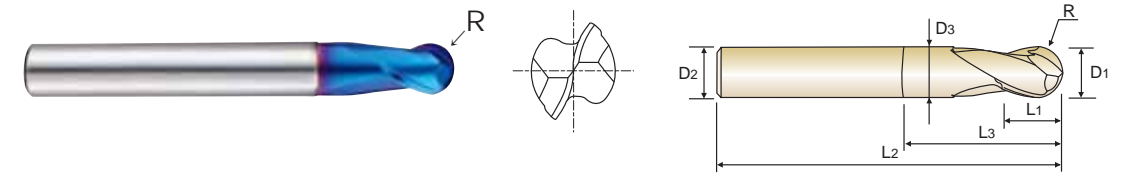
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

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	

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE STUB LENGTH BALL NOSE with EXTENDED NECK**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8A38010	R0.5	1.0	4	1	2.2	50	0.95
G8A38012	R0.6	1.2	4	1.2	2.6	50	1.15
G8A38015	R0.75	1.5	4	1.5	3	50	1.45
G8A38020	R1.0	2.0	6	2	4	50	1.95
G8A38030	R1.5	3.0	6	3	6	60	2.85
G8A38040	R2.0	4.0	6	4	8	70	3.85
G8A38050	R2.5	5.0	6	5	10	80	4.85
G8A38060	R3.0	6.0	6	6	12	90	5.85
G8A38070	R3.5	7.0	8	7	14	90	6.7
G8A38080	R4.0	8.0	8	8	16	100	7.7
G8A38090	R4.5	9.0	10	9	18	100	8.7
G8A38100	R5.0	10.0	10	10	20	100	9.7
G8A38120	R6.0	12.0	12	12	24	110	11.7
G8A38140	R7.0	14.0	14	14	28	110	13.7
G8A38160	R8.0	16.0	16	16	32	140	15.7
G8A38180	R9.0	18.0	18	18	36	140	17.7
G8A38200	R10.0	20.0	20	20	40	160	19.7
G8A38250	R12.5	25.0	25	25	50	180	24.7

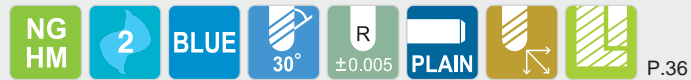
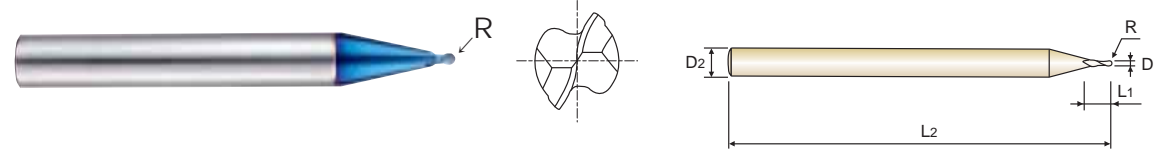
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

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	

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

## CARBIDE, 2 FLUTE MINIATURE BALL NOSE

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Radius of Ball Nose R (±0.005)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
G8A53004	R0.2	0.4	6	0.4	50
G8A53005	R0.25	0.5	6	0.5	50
G8A53006	R0.3	0.6	6	0.6	50
G8A53008	R0.4	0.8	6	0.8	50
G8A53010	R0.5	1.0	6	1.0	50
G8A53012	R0.6	1.2	6	1.2	50
G8A53015	R0.75	1.5	6	1.5	50
G8A53020	R1.0	2.0	6	2.0	50

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn' t effect on performance of tool.

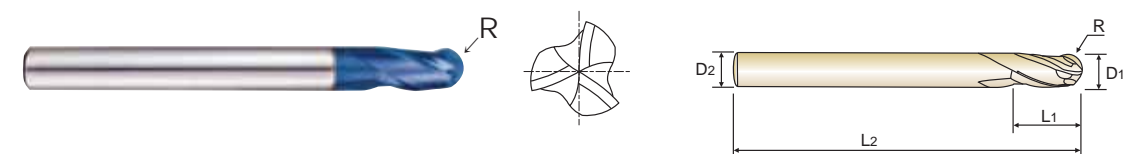
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

## CARBIDE, 3 FLUTE BALL NOSE

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
G8A59030	R1.5	3.0	6	8	60
G8A59040	R2.0	4.0	6	8	70
G8A59050	R2.5	5.0	6	10	80
G8A59060	R3.0	6.0	6	12	90
G8A59080	R4.0	8.0	8	14	100
G8A59100	R5.0	10.0	10	18	100
G8A59120	R6.0	12.0	12	22	110
G8A59160	R8.0	16.0	16	30	140
G8A59200	R10.0	20.0	20	38	160

Due to the characteristics of blue decoration layer which might be earased 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	

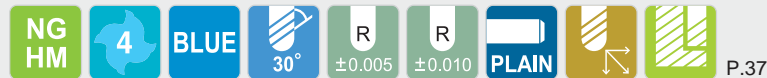
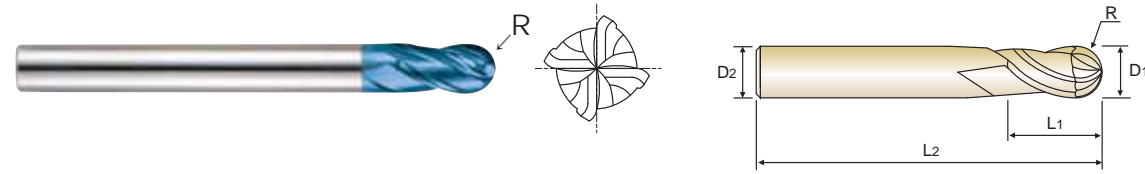
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							



### CARBIDE, 4 FLUTE BALL NOSE - Center Match

- ▶ 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.



R1.5-R3 R4-R10

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length 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 earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

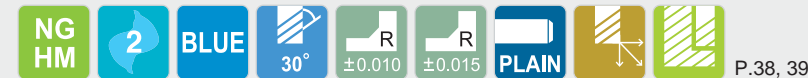
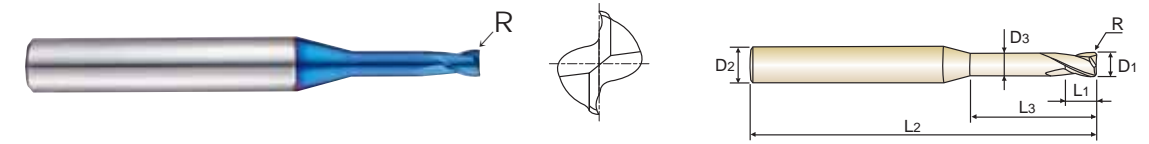
Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	±0.005	0~-0.012	h6
over R3	±0.010	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

### CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING

- ▶ 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.



Ø0.5-Ø6 Ø8-Ø12

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A60936	R0.05	0.5	4	0.7	1.5	45	0.45
G8A60932	R0.05	0.5	4	0.7	2.5	45	0.45
G8A60935	R0.05	0.5	4	0.7	4	45	0.45
G8A60931	R0.05	0.6	4	0.9	2	45	0.55
G8A60933	R0.05	0.6	4	0.9	3	45	0.55
G8A60934	R0.05	0.6	4	0.9	4	45	0.55
G8A600060102	R0.1	0.6	4	0.9	2	45	0.55
G8A600070104	R0.1	0.7	4	1	4	45	0.65
G8A600080102	R0.1	0.8	4	1.2	2	45	0.75
G8A60008	R0.1	0.8	4	1.2	4	45	0.75
G8A60924	R0.1	0.8	4	1.2	6	45	0.75
G8A60925	R0.1	1.0	6	1.5	4	50	0.95
G8A60926	R0.1	1.0	6	1.5	6	50	0.95
G8A60010	R0.2	1.0	6	1.5	4	50	0.95
G8A60910	R0.2	1.0	6	1.5	6	50	0.95
G8A60911	R0.2	1.0	6	1.5	8	50	0.95
G8A60912	R0.3	1.0	6	1.5	4	50	0.95
G8A60930	R0.3	1.0	6	1.5	6	50	0.95
G8A600100308	R0.3	1.0	6	1.5	8	50	0.95
G8A60015	R0.2	1.5	6	2.5	4	50	1.45
G8A600150206	R0.2	1.5	6	2.5	6	50	1.45
G8A600150208	R0.2	1.5	6	2.5	8	50	1.45
G8A60913	R0.2	1.5	6	2.5	10	50	1.45
G8A60914	R0.2	1.5	6	2.5	12	50	1.45
G8A60915	R0.3	1.5	6	2.5	4	50	1.45
G8A600150306	R0.3	1.5	6	2.5	6	50	1.45
G8A600150308	R0.3	1.5	6	2.5	8	50	1.45
G8A60927	R0.2	2.0	6	3	6	50	1.95
G8A600200208	R0.2	2.0	6	3	8	50	1.95

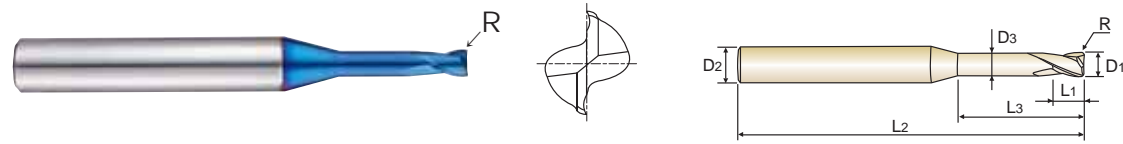
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING**

- ▶ 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.



NG HM 2 BLUE 30° ±0.010 ±0.015 PLAIN P.38, 39

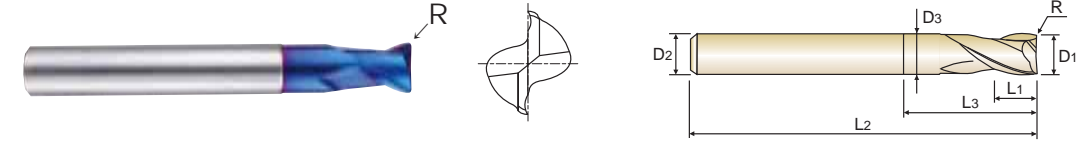
EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
G8A600200210	R0.2	2.0	6	3	10	55	1.95
G8A600200212	R0.2	2.0	6	3	12	55	1.95
G8A60916	R0.3	2.0	6	3	6	50	1.95
G8A600200308	R0.3	2.0	6	3	8	50	1.95
G8A600200310	R0.3	2.0	6	3	10	55	1.95
G8A600200312	R0.3	2.0	6	3	12	55	1.95
G8A600200316	R0.3	2.0	6	3	16	55	1.95
G8A60917	R0.5	2.0	6	3	6	50	1.95
G8A60020	R0.5	2.0	6	3	10	55	1.95
G8A60918	R0.5	2.0	6	3	12	55	1.95
G8A600300208	R0.2	3.0	6	4	8	55	2.85
G8A600300210	R0.2	3.0	6	4	10	55	2.85
G8A600300212	R0.2	3.0	6	4	12	55	2.85
G8A600300216	R0.2	3.0	6	4	16	55	2.85
G8A600300308	R0.3	3.0	6	4	8	55	2.85
G8A60919	R0.3	3.0	6	4	10	55	2.85
G8A600300312	R0.3	3.0	6	4	12	55	2.85
G8A600300316	R0.3	3.0	6	4	16	55	2.85
G8A60030	R0.5	3.0	6	4	10	55	2.85
G8A600300512	R0.5	3.0	6	4	12	55	2.85
G8A60901	R0.5	3.0	6	4	16	55	2.85
G8A60902	R0.5	3.0	6	4	20	55	2.85
G8A600400212	R0.2	4.0	6	5	12	55	3.85
G8A600400216	R0.2	4.0	6	5	16	55	3.85
G8A600400220	R0.2	4.0	6	5	20	55	3.85
G8A600400310	R0.3	4.0	6	5	10	55	3.85
G8A60920	R0.3	4.0	6	5	12	55	3.85
G8A600400316	R0.3	4.0	6	5	16	55	3.85
G8A600400320	R0.3	4.0	6	5	20	55	3.85

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING**

- ▶ 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.



NG HM 2 BLUE 30° ±0.010 ±0.015 PLAIN P.38, 39

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
G8A60040	R0.5	4.0	6	5	12	55	3.85
G8A60903	R0.5	4.0	6	5	16	55	3.85
G8A60904	R0.5	4.0	6	5	20	55	3.85
G8A600401012	R1.0	4.0	6	5	12	55	3.85
G8A600401016	R1.0	4.0	6	5	16	55	3.85
G8A60921	R0.3	6.0	6	7	20	60	5.85
G8A60060	R0.5	6.0	6	7	20	60	5.85
G8A60905	R1.0	6.0	6	7	20	60	5.85
G8A60906	R1.5	6.0	6	7	20	60	5.85
G8A600602020	R2.0	6.0	6	7	20	60	5.85
G8A60922	R0.3	8.0	8	9	25	60	7.7
G8A60929	R0.5	8.0	8	9	25	60	7.7
G8A60080	R1.0	8.0	8	9	25	60	7.7
G8A60907	R1.5	8.0	8	9	25	60	7.7
G8A600802025	R2.0	8.0	8	9	25	60	7.7
G8A60923	R0.3	10.0	10	11	32	70	9.7
G8A601000532	R0.5	10.0	10	11	32	70	9.7
G8A60100	R1.0	10.0	10	11	32	70	9.7
G8A60908	R1.5	10.0	10	11	32	70	9.7
G8A601002032	R2.0	10.0	10	11	32	70	9.7
G8A601200538	R0.5	12.0	12	12	38	80	11.7
G8A60120	R1.0	12.0	12	12	38	80	11.7
G8A60909	R1.5	12.0	12	12	38	80	11.7
G8A601202038	R2.0	12.0	12	12	38	80	11.7

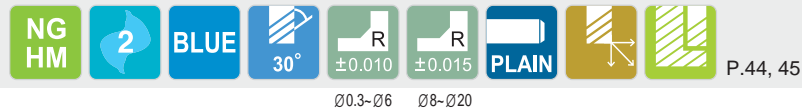
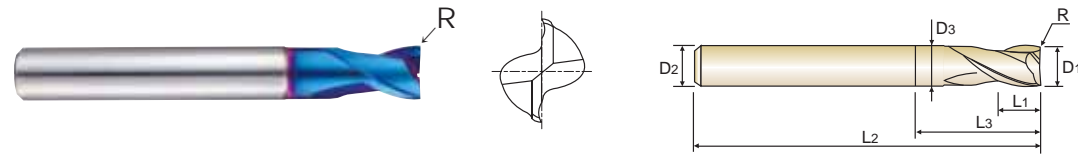
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

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
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE STUB LENGTH CORNER RADIUS with EXTENDED NECK**

- ▶ 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.



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
G8A36003	-	0.3	3	0.45	-	40	-
G8A36004	-	0.4	3	0.6	-	40	-
G8A36005	RO.05	0.5	3	0.7	-	40	-
G8A36907	RO.05	0.5	4	1	-	40	-
G8A36006	RO.05	0.6	3	0.9	-	40	-
G8A36908	RO.05	0.6	4	1.2	-	40	-
G8A36909	RO.05	0.7	4	1.4	-	40	-
G8A36008	RO.05	0.8	3	1.2	-	40	-
G8A36910	RO.05	0.8	4	1.6	-	40	-
G8A36911	RO.05	0.9	4	2	-	40	-
G8A36010	RO.1	1.0	3	1.5	-	40	-
G8A36901	RO.1	1.0	4	1.5	-	40	-
G8A36903	RO.1	1.0	6	1.5	-	40	-
G8A36015	RO.1	1.5	3	2.2	-	40	-
G8A36904	RO.1	1.5	6	2.2	-	40	-
G8A36020	RO.1	2.0	3	3	6	40	1.95
G8A36902	RO.1	2.0	4	3	6	40	1.95
G8A36905	RO.1	2.0	6	3	6	40	1.95
G8A36025	RO.1	2.5	3	4	6	40	2.4
G8A36906	RO.1	2.5	6	4	6	40	2.4
G8A36030	RO.1	3.0	6	4	7	45	2.85
G8A36035	RO.1	3.5	6	5	9	45	3.35
G8A36040	RO.1	4.0	6	5	9	45	3.85
G8A36045	RO.1	4.5	6	6	10	45	4.35
G8A36050	RO.2	5.0	6	6	11	50	4.85
G8A36060	RO.2	6.0	6	7	14	50	5.85
G8A36080	RO.2	8.0	8	9	18	60	7.7
G8A36100	RO.2	10.0	10	12	25	75	9.7
G8A36120	RO.3	12.0	12	15	30	75	11.7
G8A36160	RO.3	16.0	16	18	38	90	15.7
G8A36200	RO.3	20.0	20	24	45	100	19.7

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

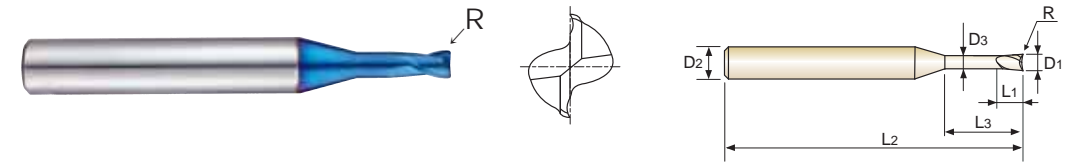
Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.012	h6
over Ø6	±0.015	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING**

- ▶ 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.



EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.010)	D1	D2	L1	L3	L2	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.1	1.0	6	1.5	3.3	50	0.95
G8A52904	RO.1	1.0	6	1.5	6.7	50	0.95
G8A52012	RO.1	1.2	6	1.8	4.4	50	1.15
G8A52905	RO.1	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 earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

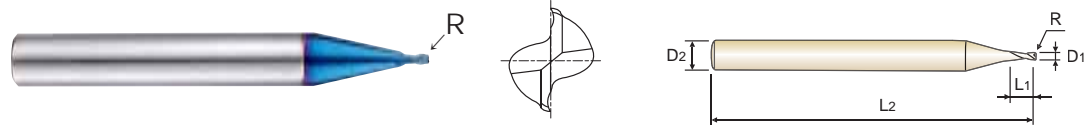
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS**

- ▶ 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.



Unit : mm

EDP No.	Corner Radius R (±0.010)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
G8A50003	-	0.3	6	0.45	50
G8A50004	-	0.4	6	0.6	50
G8A50005	RO.05	0.5	6	0.7	50
G8A50006	RO.05	0.6	6	0.9	50
G8A50008	RO.05	0.8	6	1.2	50
G8A50010	RO.1	1.0	6	1.5	50
G8A50012	RO.1	1.2	6	1.8	50
G8A50015	RO.15	1.5	6	2.2	50
G8A50020	RO.15	2.0	6	2.2	50

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

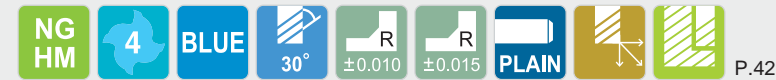
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK**

- ▶ 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.



Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A47916	RO.3	3.0	6	4	12	55	2.85
G8A47917	RO.3	3.0	6	4	16	55	2.85
G8A47918	RO.3	3.0	6	4	20	55	2.85
G8A47030	RO.5	3.0	6	4	10	55	2.85
G8A47901	RO.5	3.0	6	4	16	55	2.85
G8A47902	RO.5	3.0	6	4	20	55	2.85
G8A47919	RO.3	4.0	6	5	12	55	3.85
G8A47920	RO.3	4.0	6	5	16	55	3.85
G8A47921	RO.3	4.0	6	5	20	55	3.85
G8A47040	RO.5	4.0	6	5	12	55	3.85
G8A47903	RO.5	4.0	6	5	16	55	3.85
G8A47904	RO.5	4.0	6	5	20	55	3.85
G8A47922	R1.0	4.0	6	5	12	55	3.85
G8A47060	RO.5	6.0	6	7	20	60	5.85
G8A47905	R1.0	6.0	6	7	20	60	5.85
G8A47906	R1.5	6.0	6	7	20	60	5.85
G8A47910	RO.5	8.0	8	9	25	60	7.7
G8A47080	R1.0	8.0	8	9	25	60	7.7
G8A47907	R1.5	8.0	8	9	25	60	7.7
G8A47913	R2.0	8.0	8	9	25	60	7.7
G8A47911	RO.5	10.0	10	11	32	70	9.7
G8A47100	R1.0	10.0	10	11	32	70	9.7
G8A47908	R1.5	10.0	10	11	32	70	9.7
G8A47914	R2.0	10.0	10	11	32	70	9.7
G8A47912	RO.5	12.0	12	12	38	80	11.7
G8A47120	R1.0	12.0	12	12	38	80	11.7
G8A47909	R1.5	12.0	12	12	38	80	11.7
G8A47915	R2.0	12.0	12	12	38	80	11.7

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

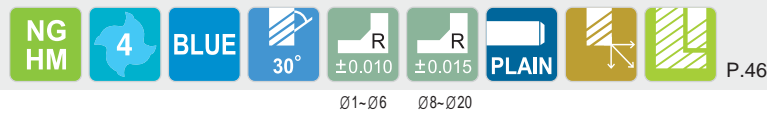
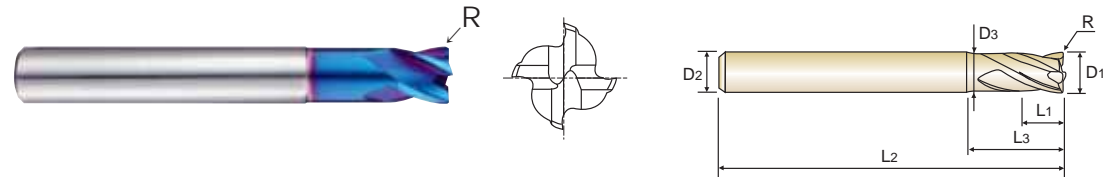
Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.012	h6
over Ø6	±0.015	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS with EXTENDED NECK**

- ▶ 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.



EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A37010	RO.1	1.0	3	1.5	-	40	-
G8A37901	RO.1	1.0	6	1.5	-	40	-
G8A37015	RO.1	1.5	3	2.2	-	40	-
G8A37902	RO.1	1.5	6	2.2	-	40	-
G8A37020	RO.1	2.0	3	3	6	40	1.95
G8A37903	RO.1	2.0	6	3	6	40	1.95
G8A37025	RO.1	2.5	3	4	6	40	2.4
G8A37904	RO.1	2.5	6	4	6	40	2.4
G8A37030	RO.1	3.0	6	4	7	45	2.85
G8A37035	RO.1	3.5	6	5	9	45	3.35
G8A37040	RO.1	4.0	6	5	9	45	3.85
G8A37045	RO.1	4.5	6	6	10	45	4.35
G8A37050	RO.2	5.0	6	6	11	50	4.85
G8A37060	RO.2	6.0	6	7	14	50	5.85
G8A37080	RO.2	8.0	8	9	18	60	7.7
G8A37100	RO.2	10.0	10	12	25	75	9.7
G8A37120	RO.3	12.0	12	15	30	75	11.7
G8A37160	RO.3	16.0	16	18	38	90	15.7
G8A37200	RO.3	20.0	20	24	45	100	19.7

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

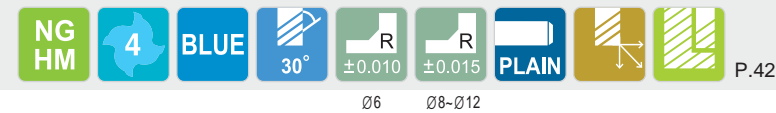
Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.012	h6
over Ø6	±0.015	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK**

- ▶ 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.



EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8B0806005090	RO.5	6.0	6	9	20	90	5.85
G8B0806010090	R1.0	6.0	6	9	20	90	5.85
G8B0808005100	RO.5	8.0	8	12	25	100	7.7
G8B0808010100	R1.0	8.0	8	12	25	100	7.7
G8B0810005100	RO.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	RO.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 earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

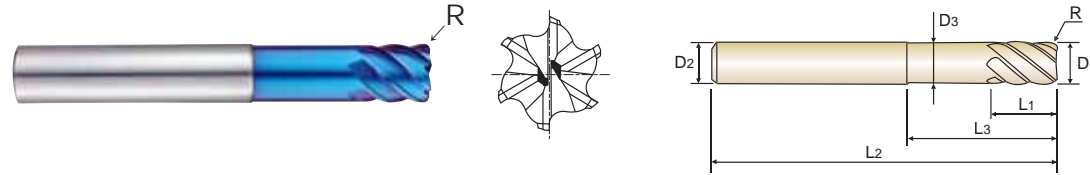
Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.012	h6
over Ø6	±0.015	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS with EXTENDED NECK**

- ▶ 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.



NG HM 6 BLUE 45° ±0.010 ±0.015 PLAIN P.47

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A39916	RO.25	6.0	6	6	14	50	5.85
G8A39060	RO.5	6.0	6	6	14	50	5.85
G8A39901	RO.5	6.0	6	13	-	70	-
G8A39910	RO.5	6.0	* 6	26	-	70	-
G8A39080	RO.5	8.0	8	8	24	60	7.7
G8A39902	RO.5	8.0	8	19	-	90	-
G8A39911	RO.5	8.0	* 8	36	-	90	-
G8A39903	RO.5	10.0	10	22	-	100	-
G8A39100	R1.0	10.0	10	10	30	70	9.7
G8A39904	R1.0	10.0	10	22	-	100	-
G8A39912	R1.0	10.0	* 10	46	-	100	-
G8A39905	RO.5	12.0	12	26	-	110	-
G8A39120	R1.0	12.0	12	12	30	75	11.7
G8A39906	R1.0	12.0	12	26	-	110	-
G8A39913	R1.0	12.0	* 12	56	-	110	-
G8A39160	R1.0	16.0	16	32	-	130	-
G8A39907	R1.5	16.0	16	32	-	130	-
G8A39914	R1.5	16.0	* 16	66	-	130	-
G8A39200	R1.0	20.0	20	38	-	140	-
G8A39908	R1.5	20.0	20	38	-	140	-
G8A39909	R2.0	20.0	20	38	-	140	-
G8A39915	R2.0	20.0	* 20	76	-	140	-

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn' t effect on performance of tool.

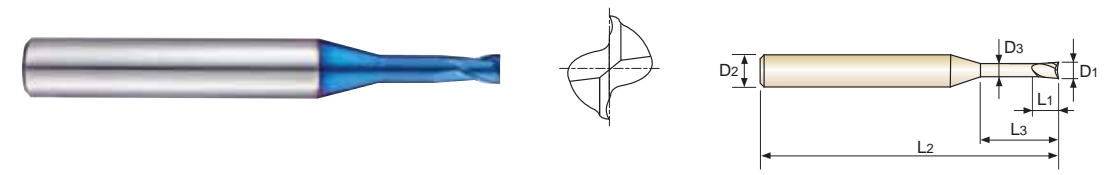
Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	±0.010	0~-0.02	h6
over Ø6	±0.015	(*Extra Long Type: 0~-0.03)	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE for RIB PROCESSING**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



NG HM 2 BLUE 30° PLAIN P.43

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A45863	0.1	4	0.15	0.3	45	0.085
G8A45864	0.1	4	0.15	0.5	45	0.085
G8A45002	0.2	4	0.3	0.5	45	0.17
G8A45815	0.2	4	0.3	1	45	0.17
G8A45816	0.2	4	0.3	1.5	45	0.17
G8A45003	0.3	4	0.45	1	45	0.27
G8A45844	0.3	4	0.45	1.5	45	0.27
G8A45817	0.3	4	0.45	2	45	0.27
G8A45818	0.3	4	0.45	3	45	0.27
G8A45842	0.3	4	0.45	4	45	0.27
G8A45843	0.4	4	0.6	1	45	0.37
G8A45004	0.4	4	0.6	2	45	0.37
G8A45984	0.4	4	0.6	3	45	0.37
G8A45985	0.4	4	0.6	4	45	0.37
G8A45986	0.4	4	0.6	5	45	0.37
G8A45005	0.5	4	0.7	2	45	0.45
G8A45861	0.5	4	0.7	2.5	45	0.45
G8A45988	0.5	4	0.7	4	45	0.45
G8A45989	0.5	4	0.7	6	45	0.45
G8A45990	0.5	4	0.7	8	45	0.45
G8A45006	0.6	4	0.9	2	45	0.55
G8A45860	0.6	4	0.9	3	45	0.55
G8A45991	0.6	4	0.9	4	45	0.55
G8A45992	0.6	4	0.9	6	45	0.55
G8A45993	0.6	4	0.9	8	45	0.55
G8A45819	0.6	4	0.9	10	45	0.55
G8A45862	0.8	4	1.2	2	45	0.75
G8A45008	0.8	4	1.2	4	45	0.75
G8A45908	0.8	4	1.2	6	45	0.75

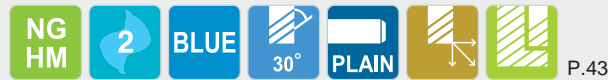
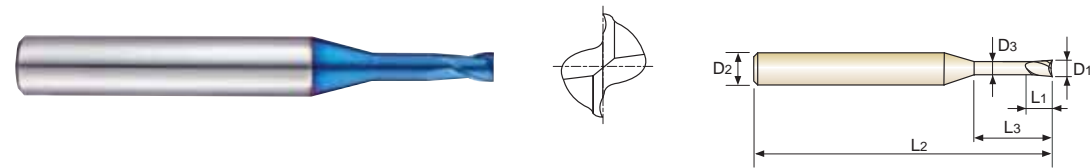
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn' t effect on performance of tool.

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE for RIB PROCESSING**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A45909	0.8	4	1.2	8	45	0.75
G8A45994	0.8	4	1.2	10	45	0.75
G8A45995	0.8	4	1.2	12	45	0.75
G8A45996	1.0	4	1.5	4	45	0.95
G8A45010	1.0	4	1.5	6	45	0.95
G8A45912	1.0	4	1.5	8	45	0.95
G8A45913	1.0	4	1.5	10	45	0.95
G8A45914	1.0	4	1.5	12	45	0.95
G8A45997	1.0	4	1.5	16	50	0.95
G8A45998	1.0	4	1.5	20	55	0.95
G8A45012	1.2	4	1.8	6	45	1.15
G8A45915	1.2	4	1.8	8	45	1.15
G8A45916	1.2	4	1.8	10	45	1.15
G8A45917	1.2	4	1.8	12	45	1.15
G8A45999	1.2	4	1.8	16	50	1.15
G8A45015	1.5	4	2.3	6	45	1.45
G8A45923	1.5	4	2.3	8	45	1.45
G8A45924	1.5	4	2.3	10	45	1.45
G8A45925	1.5	4	2.3	12	45	1.45
G8A45926	1.5	4	2.3	14	50	1.45
G8A45927	1.5	4	2.3	16	50	1.45
G8A45928	1.5	4	2.3	18	55	1.45
G8A45810	1.5	4	2.3	20	55	1.45
G8A45958	2.0	4	3.0	6	45	1.95
G8A45020	2.0	4	3.0	8	45	1.95
G8A45959	2.0	4	3.0	10	45	1.95
G8A45960	2.0	4	3.0	12	45	1.95
G8A45961	2.0	4	3.0	14	50	1.95
G8A45962	2.0	4	3.0	16	50	1.95

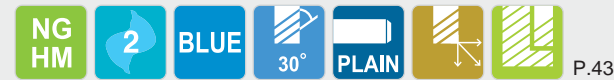
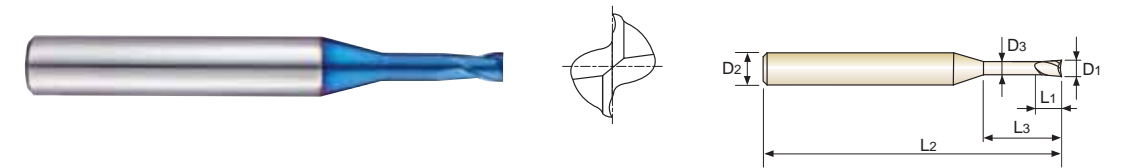
Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE for RIB PROCESSING**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A45963	2.0	4	3.0	18	55	1.95
G8A45964	2.0	4	3.0	20	55	1.95
G8A45966	2.0	4	3.0	25	60	1.95
G8A45814	2.0	4	3.0	30	70	1.95
G8A45975	3.0	6	4.5	10	45	2.85
G8A45976	3.0	6	4.5	12	45	2.85
G8A45977	3.0	6	4.5	14	50	2.85
G8A45978	3.0	6	4.5	16	55	2.85
G8A45979	3.0	6	4.5	18	55	2.85
G8A45980	3.0	6	4.5	20	60	2.85
G8A45981	3.0	6	4.5	25	65	2.85
G8A45832	3.0	6	4.5	30	70	2.85
G8A45833	3.0	6	4.5	35	80	2.85
G8A45983	3.0	6	4.5	40	90	2.85
G8A45040	4.0	6	6	12	50	3.85
G8A45801	4.0	6	6	16	60	3.85
G8A45802	4.0	6	6	20	60	3.85
G8A45803	4.0	6	6	25	70	3.85
G8A45834	4.0	6	6	30	70	3.85
G8A45835	4.0	6	6	35	80	3.85
G8A45836	4.0	6	6	40	90	3.85
G8A45837	4.0	6	6	45	90	3.85
G8A45838	4.0	6	6	50	100	3.85

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

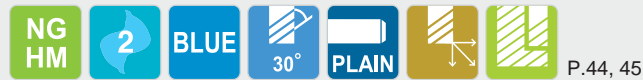
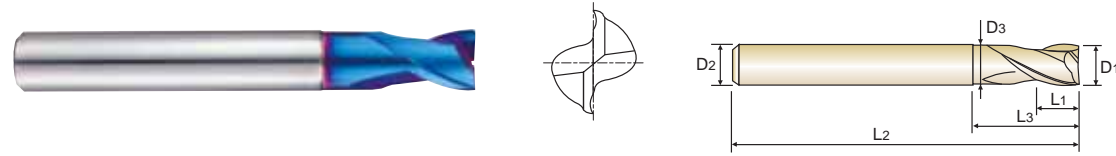
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.012	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 2 FLUTE with EXTENDED NECK**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



P.44, 45

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A01001	0.1	4	0.2	-	40	-
G8A01002	0.2	4	0.4	-	40	-
G8A01003	0.3	4	0.6	-	40	-
G8A01004	0.4	4	0.8	-	40	-
G8A01005	0.5	4	1	-	40	-
G8A01006	0.6	4	1.2	-	40	-
G8A01007	0.7	4	1.4	-	40	-
G8A01008	0.8	4	1.6	-	40	-
G8A01009	0.9	4	2	-	40	-
G8A01010	1.0	6	1.5	3	50	0.95
G8A01015	1.5	6	1.7	4	50	1.45
G8A01020	2.0	6	2	5	50	1.95
G8A01025	2.5	6	2.5	6	55	2.4
G8A01030	3.0	6	3	8	55	2.85
G8A01035	3.5	6	3.5	9	55	3.35
G8A01040	4.0	6	4	10	55	3.85
G8A01050	5.0	6	5	13	55	4.85
G8A01060	6.0	6	6	15	55	5.85
G8A01080	8.0	8	8	20	65	7.7
G8A01100	10.0	10	10	25	75	9.7
G8A01120	12.0	12	12	28	85	11.7
G8A01160	16.0	16	16	32	90	15.7
G8A01200	20.0	20	20	40	105	19.7

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

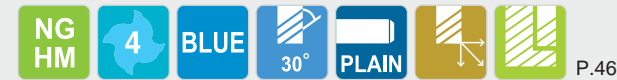
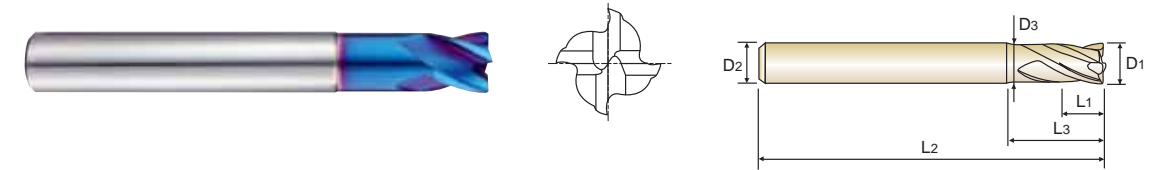
Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0~-0.012	h6
over Ø6	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							

**CARBIDE, 4 FLUTE with EXTENDED NECK**

- ▶ 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.
- ▶ Designed for high precision milling operation.
- ▶ Higher wear-resistance.



P.46

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G8A02010	1.0	6	1.5	3	50	0.95
G8A02020	2.0	6	2	5	50	1.95
G8A02030	3.0	6	3	8	55	2.85
G8A02040	4.0	6	4	10	55	3.85
G8A02050	5.0	6	5	13	55	4.85
G8A02060	6.0	6	6	15	55	5.85
G8A02080	8.0	8	8	20	65	7.7
G8A02100	10.0	10	10	25	75	9.7
G8A02120	12.0	12	12	28	85	11.7
G8A02160	16.0	16	16	32	90	15.7
G8A02200	20.0	20	20	40	105	19.7

Due to the characteristics of blue decoration layer which might be earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

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

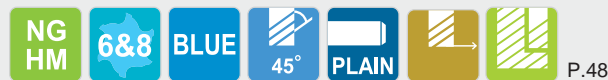
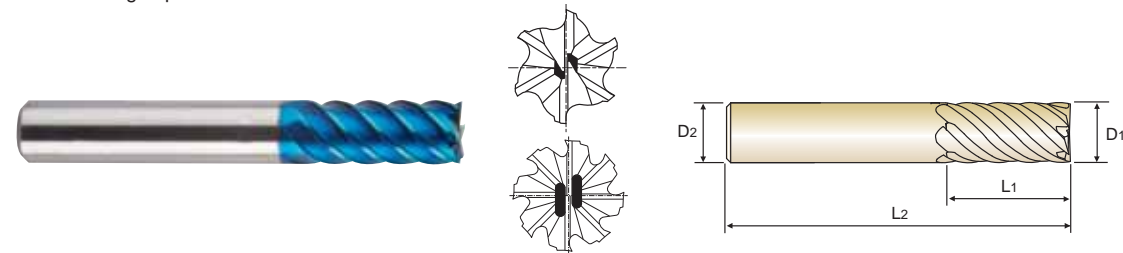
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70							
		○	○	◎							



**CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH**

- ▶ Designed to machine high hardened materials.
- ▶ Designed for high abrasion resistance thanks to negative rake angle.
- ▶ Excellent side-cutting of press mold field.



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
	D1	D2	L1	L2	
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 earased during short term using, the color layer might not be uniform moreover. However, it doesn't effect on performance of tool.

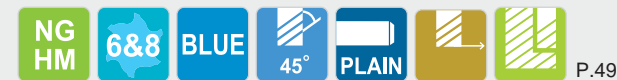
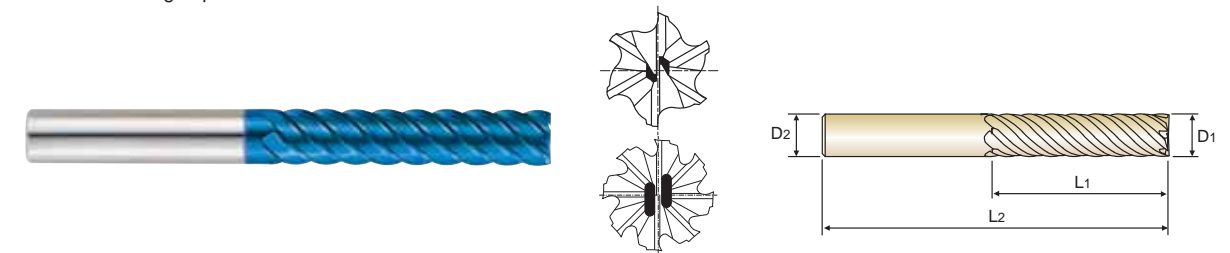
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.02	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70								
		○	○	◎	◎								

**CARBIDE, 6&8 FLUTE 45° HELIX EXTRA LONG LENGTH**

- ▶ Designed to machine high hardened materials.
- ▶ Designed for high abrasion resistance thanks to negative rake angle.
- ▶ Excellent side-cutting of press mold field.



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 earased 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

◎ : Excellent ○ : Good

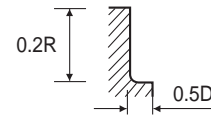
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
-HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70								
		○	○	◎	◎								

**CARBIDE, 4FLUTE CORNER RADIUS HIGH FEED**

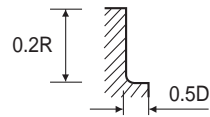
G8B59, G8B54 SERIES

**■ NORMAL SPEED**

MATERIAL	HARDENED STEELS											
	~ Hrc 40				Hrc 40 - Hrc 50				Hrc 50 - Hrc 55			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
2.0 × R0.5	13500	6500	85	0.120	9550	3800	60	0.099	5500	2200	35	0.100
3.0 × R0.5	9550	6500	90	0.170	6900	4150	65	0.150	4550	2750	45	0.151
4.0 × R0.5	7950	7000	100	0.220	5750	4600	70	0.200	4000	3200	50	0.200
5.0 × R0.5	6500	7300	100	0.281	4800	4800	75	0.250	3400	3200	55	0.235
6.0 × R0.5	5800	7650	110	0.330	4100	4900	75	0.299	2900	3500	55	0.302
6.0 × R1.0	5800	7650	110	0.330	4100	4900	75	0.299	2900	3500	55	0.302
8.0 × R1.0	4350	7650	110	0.440	3050	4900	75	0.402	2200	3500	55	0.398
8.0 × R2.0	4350	7650	110	0.440	3050	4900	75	0.402	2200	3500	55	0.398
10.0 × R1.0	3500	7650	110	0.546	2450	4900	75	0.500	1750	3500	55	0.500
10.0 × R2.0	3500	7650	110	0.546	2450	4900	75	0.500	1750	3500	55	0.500
12.0 × R2.0	2900	7650	110	0.659	2050	4900	75	0.598	1450	3500	55	0.603
12.0 × R3.0	2900	7650	110	0.659	2050	4900	75	0.598	1450	3500	55	0.603
16.0 × R3.0	2200	7650	110	0.869	1550	4900	80	0.790	1100	3500	55	0.795



MATERIAL	HARDENED STEELS							
	Hrc 55 - Hrc 60				Hrc 60 - Hrc 65			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc
2.0 × R0.5	3200	1000	20	0.078	2200	550	15	0.063
3.0 × R0.5	2850	1150	25	0.101	1900	610	20	0.080
4.0 × R0.5	2550	1350	30	0.132	1750	700	20	0.100
5.0 × R0.5	2200	1600	35	0.182	1500	700	25	0.117
6.0 × R0.5	1850	1850	35	0.250	1350	795	25	0.147
6.0 × R1.0	1850	1850	35	0.250	1350	795	25	0.147
8.0 × R1.0	1400	1850	35	0.330	995	795	25	0.200
8.0 × R2.0	1400	1850	35	0.330	995	795	25	0.200
10.0 × R1.0	1100	1850	35	0.420	795	795	25	0.250
10.0 × R2.0	1100	1850	35	0.420	795	795	25	0.250
12.0 × R2.0	925	1850	35	0.500	665	795	25	0.299
12.0 × R3.0	925	1850	35	0.500	665	795	25	0.299
16.0 × R3.0	700	1850	35	0.661	500	795	25	0.398



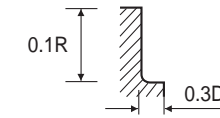
RPM = rev./min.  
FEED = mm/min.

**CARBIDE, 4FLUTE CORNER RADIUS HIGH FEED**

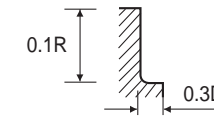
G8B59, G8B54 SERIES

**■ HIGH SPEED**

MATERIAL	HARDENED STEELS											
	~ Hrc 40				Hrc 40 - Hrc 50				Hrc 50 - Hrc 55			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
2.0 × R0.5	29000	15000	180	0.129	22000	9800	140	0.111	15000	7850	95	0.131
3.0 × R0.5	22000	16000	205	0.182	17000	10000	160	0.147	12500	8000	200	0.160
4.0 × R0.5	17000	17500	215	0.257	13000	12000	165	0.231	11000	9200	140	0.209
5.0 × R0.5	15000	18000	235	0.300	11000	12500	175	0.284	10000	10000	155	0.250
6.0 × R0.5	13500	18500	255	0.343	10500	13800	200	0.329	9000	11000	170	0.306
6.0 × R1.0	13500	18500	255	0.343	10500	13800	200	0.329	9000	11000	170	0.306
8.0 × R1.0	10000	18500	250	0.463	8000	14000	200	0.438	6800	11000	170	0.404
8.0 × R2.0	10000	18500	250	0.463	8000	14000	200	0.438	6800	11000	170	0.404
10.0 × R1.0	8000	18500	250	0.578	6400	14000	200	0.547	5400	11000	170	0.509
10.0 × R2.0	8000	18500	250	0.578	6400	14000	200	0.547	5400	11000	170	0.509
12.0 × R2.0	6600	18500	250	0.701	5300	14000	200	0.660	4500	11000	170	0.611
12.0 × R3.0	6600	18500	250	0.701	5300	14000	200	0.660	4500	11000	170	0.611
16.0 × R3.0	5000	18500	250	0.925	3900	14000	195	0.897	3300	11000	165	0.833



MATERIAL	HARDENED STEELS							
	Hrc 55 - Hrc 60				Hrc 60 - Hrc 65			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc
2.0 × R0.5	11000	4450	70	0.101	8700	2450	55	0.070
3.0 × R0.5	9500	4600	90	0.121	6900	2500	65	0.091
4.0 × R0.5	8000	5500	100	0.172	5600	2900	70	0.129
5.0 × R0.5	7000	6000	110	0.214	4900	3100	75	0.158
6.0 × R0.5	6400	6400	120	0.250	4500	3600	85	0.200
6.0 × R1.0	6400	6400	120	0.250	4500	3600	85	0.200
8.0 × R1.0	4800	6700	120	0.349	3400	4100	85	0.301
8.0 × R2.0	4800	6700	120	0.349	3400	4100	85	0.301
10.0 × R1.0	3800	6800	120	0.447	2700	3800	85	0.352
10.0 × R2.0	3800	6800	120	0.447	2700	3800	85	0.352
12.0 × R2.0	3200	7000	120	0.547	2250	3600	85	0.400
12.0 × R3.0	3200	7000	120	0.547	2250	3600	85	0.400
16.0 × R3.0	2400	7000	120	0.729	1650	3300	85	0.500

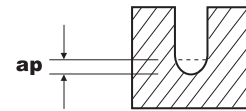


RPM = rev./min.  
FEED = mm/min.

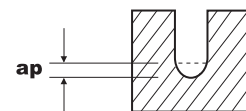
**CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING**

**G8A46, G8A54 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
	HRc 30 - HRc 45					HRc 45 - HRc 55				
	DIAMETER	RPM	FEED	ap(mm)	Fz	RPM	FEED	ap(mm)	Vc	Fz
R0.1 × 0.2	50000	300-350	0.006-0.016	31	0.012-0.014	50000	265-310	0.005-0.013	31	0.011-0.012
R0.15 × 0.3	48000-50000	480-520	0.010-0.017	45-47	0.020-0.021	48000-50000	440-460	0.008-0.014	45-47	0.018-0.018
R0.2 × 0.4	48000-50000	720-790	0.013-0.032	60-63	0.030-0.032	48000-50000	450-550	0.011-0.026	60-63	0.019-0.022
R0.25 × 0.5	34100-49500	600-870	0.007-0.028	54-78	0.035-0.035	31900-35200	490-540	0.005-0.023	50-55	0.031-0.031
R0.3 × 0.6	28600-40700	590-850	0.007-0.034	54-77	0.041-0.042	26400-29700	480-540	0.006-0.028	50-56	0.036-0.036
R0.4 × 0.8	22000-30800	640-890	0.016-0.064	55-77	0.058-0.058	19800-22000	490-550	0.013-0.052	50-55	0.049-0.05
R0.5 × 1.0	17600-24200	600-850	0.008-0.080	55-76	0.068-0.070	15400-17600	470-540	0.007-0.065	48-55	0.061-0.061
R0.6 × 1.2	14300-18700	590-780	0.024-0.032	54-70	0.083-0.083	12000-14000	480-540	0.020-0.026	45-53	0.080-0.077
R0.75 × 1.5	11000-14300	580-760	0.031-0.048	52-67	0.105-0.106	10000-11500	480-540	0.025-0.039	47-54	0.096-0.094
R1.0 × 2.0	8500-11000	590-800	0.024-0.160	53-69	0.139-0.145	7900-8800	470-530	0.020-0.130	50-55	0.119-0.12
R1.5 × 3.0	5700-8200	730-1000	0.064-0.240	54-77	0.256-0.244	5300-5800	590-650	0.052-0.195	50-55	0.223-0.224
R2.0 × 4.0	4300-6200	680-990	0.080-0.320	54-78	0.316-0.319	3950-4400	550-620	0.065-0.026	50-55	0.299-0.282



MATERIAL	HARDENED STEELS					COPPER				
	HRc 55 - HRc 65									
	DIAMETER	RPM	FEED	ap(mm)	Fz	RPM	FEED	ap(mm)	Vc	Fz
R0.1 × 0.2	50000	225-265	0.005-0.012	31-31	0.009-0.011	50000	455-530	0.010-0.022	31-31	0.018-0.021
R0.15 × 0.3	46000-50000	390-420	0.007-0.013	43-47	0.017-0.017	48000-50000	690-790	0.002-0.023	45-47	0.029-0.032
R0.2 × 0.4	46000-50000	400-460	0.010-0.024	58-63	0.017-0.018	48000-50000	1000-1150	0.019-0.048	60-63	0.042-0.046
R0.25 × 0.5	31900-35200	440-480	0.005-0.021	50-55	0.028-0.027	49000-50000	1100-1400	0.010-0.042	77-79	0.045-0.056
R0.3 × 0.6	26400-29700	400-480	0.006-0.025	50-56	0.030-0.032	42000-50000	1100-1700	0.011-0.050	79-94	0.052-0.068
R0.4 × 0.8	19800-22000	440-500	0.012-0.048	50-55	0.044-0.045	31000-50000	1100-2250	0.024-0.096	78-126	0.071-0.090
R0.5 × 1.0	15400-17600	440-500	0.006-0.060	48-55	0.057-0.057	24000-49500	1100-2200	0.012-0.120	75-156	0.092-0.089
R0.6 × 1.2	12000-14000	420-480	0.018-0.024	45-53	0.070-0.069	28500-38500	1480-1950	0.036-0.048	107-145	0.104-0.101
R0.75 × 1.5	10000-11500	420-480	0.023-0.036	47-54	0.084-0.083	17000-28500	1100-1950	0.046-0.072	80-134	0.129-0.137
R1.0 × 2.0	7900-8800	440-480	0.018-0.120	50-55	0.111-0.109	12600-24000	1100-2150	0.036-0.240	79-151	0.175-0.179
R1.5 × 3.0	5300-5800	550-620	0.048-0.120	50-55	0.208-0.214	11900-17000	1850-2700	0.096-0.360	112-160	0.311-0.318
R2.0 × 4.0	3850-4400	530-570	0.060-0.240	48-55	0.275-0.259	6600-12500	1260-2500	0.120-0.480	83-157	0.382-0.400

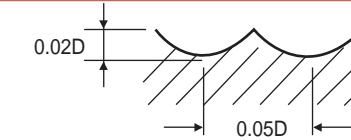


RPM = rev./min.  
FEED = mm/min.

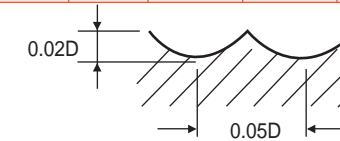
**CARBIDE, 3 FLUTE BALL NOSE**

**G8A59 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 45				HRc 45 - HRc 55				HRc 55 - HRc 60			
	DIAMETER	RPM	FEED	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
R1.5 × 3.0	32000	8600	300	0.090	26840	5800	255	0.072	19840	4280	185	0.072
R2.0 × 4.0	24080	7700	305	0.107	20130	5430	255	0.090	14880	3880	185	0.087
R2.5 × 5.0	20000	7250	315	0.121	16780	5430	265	0.108	12400	3690	195	0.099
R3.0 × 6.0	18000	8570	340	0.159	15200	6220	285	0.136	12200	4500	230	0.123
R4.0 × 8.0	13500	7350	340	0.181	11300	5250	285	0.155	9200	3980	230	0.144
R5.0 × 10.0	10800	6530	340	0.202	9100	4590	285	0.168	7350	3450	230	0.156
R6.0 × 12.0	9050	6100	340	0.225	7590	4260	285	0.187	6130	3190	230	0.173
R8.0 × 16.0	6700	4600	335	0.229	5690	3250	285	0.190	4600	2480	230	0.180
R10.0 × 20.0	5400	3600	340	0.222	4550	2620	285	0.192	3670	1980	230	0.180



MATERIAL	HARDENED STEELS							
	HRc 60 - HRc 65				HRc 65 - HRc 70			
	DIAMETER	RPM	FEED	Fz	RPM	FEED	Vc	Fz
R1.5 × 3.0	18680	4040	175	0.072	12780	2760	120	0.072
R2.0 × 4.0	14220	3650	180	0.086	9580	2500	120	0.087
R2.5 × 5.0	11670	3470	185	0.099	8000	2370	125	0.099
R3.0 × 6.0	11100	3830	210	0.115	7590	2460	145	0.108
R4.0 × 8.0	8320	3350	210	0.134	5690	2130	145	0.125
R5.0 × 10.0	6660	2870	210	0.144	4550	1960	145	0.144
R6.0 × 12.0	5530	2400	210	0.145	3800	1640	145	0.144
R8.0 × 16.0	4160	1800	210	0.144	2850	1230	145	0.144
R10.0 × 20.0	3300	1440	205	0.145	2280	980	145	0.143

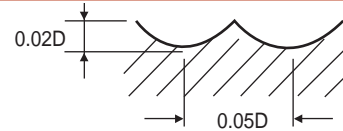


RPM = rev./min.  
FEED = mm/min.

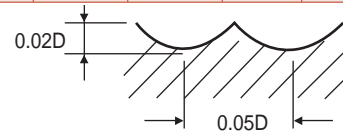
**CARBIDE, 2 FLUTE BALL NOSE**

**G8A28, G8A38, G8A53 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRC 30 - HRC 40				HRC 40 - HRC 50				HRC 50 - HRC 55			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
R0.1 × 0.2	50000	1200	30	0.012	50000	1050	30	0.011	45000	960	30	0.011
R0.15 × 0.3	50000	1500	45	0.015	50000	1350	45	0.014	45000	1200	40	0.013
R0.2 × 0.4	50000	1900	65	0.019	50000	1700	65	0.017	45000	1500	55	0.017
R0.25 × 0.5	50000	2400	80	0.024	50000	2100	80	0.021	45000	1900	70	0.021
R0.3 × 0.6	50000	2900	95	0.029	50000	2500	95	0.025	45000	2200	85	0.024
R0.4 × 0.8	50000	3900	125	0.039	50000	3300	125	0.033	45000	3000	115	0.033
R0.5 × 1.0	50000	4800	155	0.048	50000	4200	155	0.042	45000	3800	140	0.042
R0.6 × 1.2	50000	5100	190	0.051	48000	4300	180	0.045	43000	3850	160	0.045
R0.75 × 1.5	50000	5400	235	0.054	48000	4500	225	0.047	43000	4000	205	0.047
R1.0 × 2.0	49700	5700	310	0.057	47800	4800	300	0.050	40000	4000	250	0.050
R1.5 × 3.0	33100	6000	310	0.091	31800	5300	300	0.083	26500	4000	250	0.075
R2.0 × 4.0	24900	6000	315	0.120	23900	5300	300	0.111	20000	4000	250	0.100
R2.5 × 5.0	18600	5800	290	0.156	17800	4900	280	0.138	15000	3750	235	0.125
R3.0 × 6.0	13900	4850	260	0.174	13400	4100	255	0.153	11000	3100	205	0.141
R4.0 × 8.0	11100	4200	280	0.189	10700	3500	270	0.164	9000	2700	225	0.150
R5.0 × 10.0	9300	3700	290	0.199	8900	3100	280	0.174	7500	2400	235	0.160
R6.0 × 12.0	6950	2950	260	0.212	6680	2500	250	0.187	5600	1900	210	0.170
R8.0 × 16.0	5570	2650	280	0.238	5350	2200	270	0.206	4500	1700	225	0.189
R10.0 × 20.0	4450	2350	280	0.264	4300	1950	270	0.227	3600	1500	225	0.208



MATERIAL	HARDENED STEELS											
	HRC 55 - HRC 60				HRC 60 - HRC 65				HRC 65 - HRC 70			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
R0.1 × 0.2	40000	770	25	0.010	35000	674	20	0.010	31500	570	20	0.009
R0.15 × 0.3	40000	965	40	0.012	35000	840	35	0.012	31500	700	30	0.011
R0.2 × 0.4	40000	1200	50	0.015	35000	1050	45	0.015	31500	890	40	0.014
R0.25 × 0.5	40000	1500	65	0.019	35000	1300	55	0.019	31500	1100	50	0.017
R0.3 × 0.6	40000	1800	75	0.023	35000	1600	65	0.023	31500	1400	60	0.022
R0.4 × 0.8	40000	2400	100	0.030	35000	2100	90	0.030	31500	1800	80	0.029
R0.5 × 1.0	40000	3000	125	0.038	35000	2600	110	0.037	35000	2300	110	0.033
R0.6 × 1.2	38000	3000	145	0.039	34000	2700	130	0.040	30600	2300	115	0.038
R0.75 × 1.5	37000	3100	175	0.042	33000	2700	155	0.041	29700	2300	140	0.039
R1.0 × 2.0	35000	3150	220	0.045	32000	2800	200	0.044	28500	2300	180	0.040
R1.5 × 3.0	23500	3150	220	0.067	21000	2800	200	0.067	19000	2300	180	0.061
R2.0 × 4.0	17500	3150	220	0.090	16000	2800	200	0.088	14500	2300	180	0.079
R2.5 × 5.0	13500	3050	210	0.113	11500	2550	180	0.111	10500	2100	165	0.100
R3.0 × 6.0	10000	2500	190	0.125	8800	2150	165	0.122	8000	1750	150	0.109
R4.0 × 8.0	8000	2150	200	0.134	7000	1850	175	0.132	6500	1550	165	0.119
R5.0 × 10.0	6600	1900	205	0.144	5800	1650	180	0.142	5300	1380	165	0.130
R6.0 × 12.0	5000	1550	190	0.155	4400	1250	165	0.142	4000	1050	150	0.131
R8.0 × 16.0	4000	1350	200	0.169	3500	1000	175	0.143	3200	850	160	0.133
R10.0 × 20.0	3200	1200	200	0.188	2800	800	175	0.143	2550	660	160	0.129

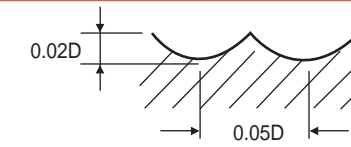


RPM = rev./min.  
FEED = mm/min.

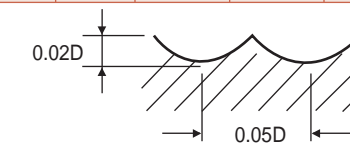
**CARBIDE, 4 FLUTE BALL NOSE**

**G8D62 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRC 30 - HRC 45				HRC 45 - HRC 55				HRC 55 - HRC 60			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
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	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

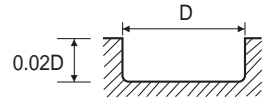


RPM = rev./min.  
FEED = mm/min.

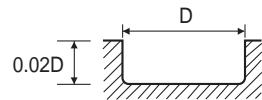
**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING - SLOTTING**

G8A60 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
0.5	50000	144	80	0.001	45000	110	70	0.001	40000	85	65	0.001
0.6	50000	185	95	0.002	45000	140	85	0.002	40000	110	75	0.001
0.8	50000	235	125	0.002	40000	170	100	0.002	30000	115	75	0.002
1.0	48000	590	150	0.006	38000	460	120	0.006	25500	285	80	0.006
2.0	33300	670	210	0.010	26000	540	165	0.010	17500	335	110	0.010
3.0	21800	670	205	0.015	17300	540	165	0.016	11500	335	110	0.015
4.0	16700	700	210	0.021	13200	560	165	0.021	8800	350	110	0.020
5.0	15700	810	245	0.026	12500	645	195	0.026	8300	395	130	0.024
6.0	13100	755	245	0.029	10350	615	195	0.030	6900	385	130	0.028
8.0	9880	740	250	0.037	7800	575	195	0.037	5200	355	130	0.034
10.0	7800	670	245	0.043	6150	540	195	0.044	4100	330	130	0.040
12.0	6650	672	250	0.051	5250	540	200	0.051	3500	330	130	0.047



MATERIAL	HARDENED STEELS											
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
0.5	33000	55	50	0.001	25000	30	40	0.001	20000	20	30	0.250
0.6	30000	65	55	0.001	25000	40	45	0.001	20000	25	40	0.278
0.8	25000	70	65	0.001	19000	45	50	0.001	16000	28	40	0.280
1.0	20500	170	65	0.004	16000	105	50	0.003	12500	70	40	0.700
2.0	14500	205	90	0.007	11000	130	70	0.006	9500	90	60	0.643
3.0	9500	205	90	0.011	7500	130	70	0.009	6400	90	60	0.643
4.0	7200	215	90	0.015	5600	135	70	0.012	4750	95	60	0.679
5.0	6400	230	100	0.018	5100	145	80	0.014	4450	105	70	0.656
6.0	5300	225	100	0.021	4200	140	80	0.017	3700	100	70	0.625
8.0	4000	205	100	0.026	3200	130	80	0.020	2800	95	70	0.594
10.0	3200	190	100	0.030	2550	120	80	0.024	2200	90	70	0.563
12.0	2650	190	100	0.036	2100	120	80	0.029	1860	90	70	0.563

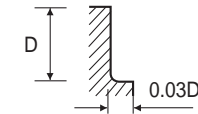


RPM = rev./min.  
FEED = mm/min.

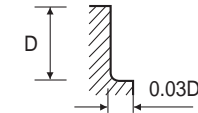
**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING - SIDE CUTTING**

G8A60 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
0.5	50000	205	80	0.002	45000	160	70	0.002	40000	125	65	0.002
0.6	50000	265	95	0.003	45000	200	85	0.002	40000	160	75	0.002
0.8	50000	335	125	0.003	40000	245	100	0.003	30000	165	75	0.003
1.0	48000	840	150	0.009	38000	656	120	0.009	25500	408	80	0.008
2.0	33300	960	210	0.014	26000	776	165	0.015	17500	480	110	0.014
3.0	21800	960	205	0.022	17300	776	165	0.022	11500	480	110	0.021
4.0	16700	1000	210	0.030	13200	800	165	0.030	8800	500	110	0.028
5.0	15700	1160	245	0.037	12500	920	195	0.037	8300	568	130	0.034
6.0	13100	1080	245	0.041	10350	880	195	0.043	6900	552	130	0.040
8.0	9880	1056	250	0.053	7800	824	195	0.053	5200	508	130	0.049
10.0	7800	960	245	0.062	6150	776	195	0.063	4100	472	130	0.058
12.0	6650	960	250	0.072	5250	776	200	0.074	3500	472	130	0.067



MATERIAL	HARDENED STEELS											
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	HARDNESS	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
0.5	33000	80	50	0.001	25000	45	40	0.001	20000	30	30	0.001
0.6	30000	90	55	0.002	25000	60	45	0.001	20000	35	40	0.001
0.8	25000	100	65	0.002	19000	65	50	0.002	16000	40	40	0.001
1.0	20500	248	65	0.006	16000	152	50	0.005	12500	100	40	0.004
2.0	14500	296	90	0.010	11000	184	70	0.008	9500	132	60	0.007
3.0	9500	296	90	0.016	7500	184	70	0.012	6400	132	60	0.010
4.0	7200	308	90	0.021	5600	192	70	0.017	4750	136	60	0.014
5.0	6400	328	100	0.026	5100	208	80	0.020	4450	152	70	0.017
6.0	5300	320	100	0.030	4200	204	80	0.024	3700	148	70	0.020
8.0	4000	292	100	0.037	3200	188	80	0.029	2800	136	70	0.024
10.0	3200	272	100	0.043	2550	176	80	0.035	2200	128	70	0.029
12.0	2650	272	100	0.051	2100	176	80	0.042	1860	128	70	0.034

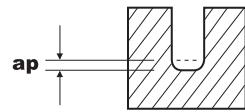


RPM = rev./min.  
FEED = mm/min.

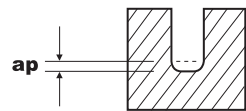
**CARBIDE, 2 FLUTE CORNER RADIUS for RIB PROCESSING**

**G8A52 SERIES**

MATERIAL HARDNESS DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
	HRc 30 ~ HRc 45					HRc 45 ~ HRc 55				
	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 HARDNESS DIAMETER	HARDENED STEELS				
	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

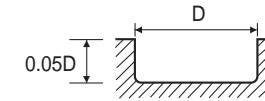


RPM = rev./min.  
FEED = mm/min.

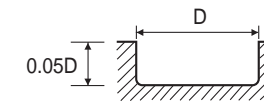
**CARBIDE, 2 FLUTE MINIATURE CORNER RADIUS - SLOTTING**

**G8A50 SERIES**

MATERIAL HARDNESS DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 50				HRc 50 ~ HRc 55			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
0.3	50000	190	45	0.002	45000	140	40	0.002	40000	115	40	0.001
0.4	50000	235	65	0.002	45000	180	55	0.002	40000	140	50	0.002
0.5	50000	370	80	0.004	45000	280	70	0.003	40000	220	65	0.003
0.6	50000	470	95	0.005	45000	360	85	0.004	40000	285	75	0.004
0.8	50000	600	125	0.006	40000	440	100	0.006	30000	295	75	0.005
1.0	48000	750	150	0.008	38000	570	120	0.008	25500	360	80	0.007
1.2	42000	790	160	0.009	34000	640	130	0.009	22500	380	85	0.008
1.5	37000	800	175	0.011	30500	670	145	0.011	21000	410	100	0.010
2.0	33300	850	210	0.013	26000	680	165	0.013	17500	420	110	0.012



MATERIAL HARDNESS DIAMETER	HARDENED STEELS							
	HRc 55 ~ HRc 60				HRc 60 ~ HRc 65			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
0.3	33000	70	30	0.001	25000	40	25	0.001
0.4	33000	90	40	0.001	25000	55	30	0.001
0.5	33000	140	50	0.002	25000	85	40	0.002
0.6	30000	160	55	0.003	25000	105	45	0.002
0.8	25000	185	65	0.004	19000	110	50	0.003
1.0	20500	215	65	0.005	16000	135	50	0.004
1.2	20000	250	75	0.006	14500	145	55	0.005
1.5	17000	250	80	0.007	13000	155	60	0.006
2.0	14500	260	90	0.009	11000	160	70	0.007

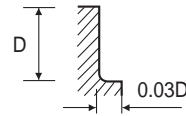


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FEED = mm/min.

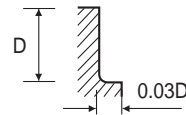
**CARBIDE, 4 FLUTE CORNER RADIUS**

**G8A47, G8B08 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	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			
	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

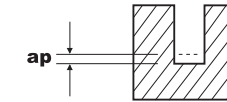


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FEED = mm/min.

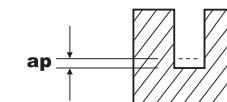
**CARBIDE, 2 FLUTE for RIB PROCESSING**

**G8A45 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
	HRc 30 - HRc 45					HRc 45 - HRc 55				
	DIAMETER	RPM	FEED	ap(mm)	Vc	Fz	RPM	FEED	ap(mm)	Vc
0.2	50000	300-350	0.006-0.016	31	0.003-0.004	50000	265-310	0.005-0.013	31	0.003-0.003
0.3	43000-50000	330-420	0.006-0.015	41-47	0.004-0.004	39900-46200	265-310	0.004-0.011	38-44	0.003-0.003
0.4	31400-50000	350-590	0.005-0.028	39-63	0.006-0.006	30500-35200	295-340	0.003-0.020	38-44	0.005-0.005
0.5	25650-33000	370-470	0.006-0.035	40-52	0.007-0.007	23750-26000	285-315	0.004-0.025	37-41	0.006-0.006
0.6	20900-35200	330-560	0.007-0.030	39-66	0.008-0.008	19900-22000	260-290	0.005-0.021	38-41	0.007-0.007
0.8	16150-26400	360-590	0.009-0.040	41-66	0.011-0.011	15200-16700	280-310	0.006-0.028	38-42	0.009-0.009
1.0	12300-18700	350-540	0.011-0.028	39-59	0.014-0.014	10500-11500	250-280	0.008-0.020	33-36	0.012-0.012
1.2	10450-17600	350-590	0.025-0.070	39-66	0.017-0.017	9100-10000	250-280	0.015-0.042	34-38	0.014-0.014
1.5	9100-17600	430-830	0.017-0.077	43-83	0.024-0.024	7000-8000	250-280	0.012-0.055	33-38	0.018-0.018
2.0	6350-10550	340-570	0.021-0.140	40-66	0.027-0.027	6100-6700	270-300	0.015-0.100	38-42	0.022-0.022
3.0	4300-7050	550-900	0.056-0.210	41-66	0.064-0.064	3990-4600	445-515	0.040-0.150	38-43	0.056-0.056
4.0	3200-5300	400-675	0.074-0.280	40-67	0.063-0.064	3000-3400	335-380	0.053-0.200	38-43	0.056-0.056



MATERIAL	HARDENED STEELS					COPPER				
	HRc 55 - HRc 65									
	DIAMETER	RPM	FEED	ap(mm)	Vc	Fz	RPM	FEED	ap(mm)	Vc
0.2	50000	225-265	0.005-0.012	31	0.002-0.003	50000	455-530	0.010-0.022	31	0.005-0.005
0.3	23900-32300	105-185	0.003-0.007	23-30	0.002-0.003	48000-50000	550-640	0.010-0.025	45-47	0.006-0.006
0.4	18300-24600	120-200	0.002-0.012	23-31	0.003-0.004	48000-50000	790-920	0.008-0.048	60-63	0.008-0.009
0.5	14200-18000	115-130	0.003-0.015	22-28	0.004-0.004	44000-50000	800-1150	0.010-0.060	69-79	0.009-0.012
0.6	11900-15500	100-120	0.003-0.013	22-29	0.004-0.004	37500-50000	770-1250	0.011-0.051	71-94	0.01-0.013
0.8	9000-11700	110-125	0.004-0.017	23-29	0.006-0.005	28500-47000	770-1300	0.015-0.068	72-118	0.014-0.014
1.0	6300-8050	100-115	0.005-0.012	20-25	0.008-0.007	22500-34000	810-1300	0.018-0.048	71-107	0.018-0.019
1.2	5400-7000	100-115	0.009-0.026	20-26	0.009-0.008	22500-31500	950-1350	0.036-0.101	85-119	0.021-0.021
1.5	4300-5500	100-115	0.007-0.033	20-26	0.012-0.01	14500-25000	770-1320	0.028-0.132	68-118	0.027-0.026
2.0	3600-4700	100-120	0.009-0.060	23-30	0.014-0.013	11500-18500	770-1250	0.036-0.240	72-116	0.033-0.034
3.0	2400-3200	105-310	0.024-0.090	23-30	0.022-0.048	9000-13000	1400-2110	0.096-0.360	85-123	0.078-0.081
4.0	1800-2400	75-230	0.032-0.120	23-30	0.021-0.048	6750-9750	1050-1575	0.128-0.480	85-123	0.078-0.081

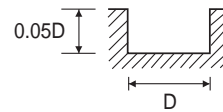


RPM = rev./min.  
FEED = mm/min.

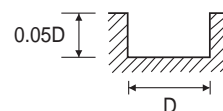
**CARBIDE, 2 FLUTE - SLOTTING**

G8A01, G8A36 SERIES

MATERIAL HARDNESS DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
0.2	50000	130	30	0.001	45000	115	30	0.001	40000	95	25	0.001
0.3	50000	190	45	0.002	45000	140	40	0.002	40000	115	40	0.001
0.4	50000	235	65	0.002	45000	180	55	0.002	40000	140	50	0.002
0.5	50000	370	80	0.004	45000	280	70	0.003	40000	220	65	0.003
0.6	50000	470	95	0.005	45000	360	85	0.004	40000	285	75	0.004
0.8	50000	600	125	0.006	40000	440	100	0.006	30000	295	75	0.005
0.9	49000	655	140	0.007	39000	520	110	0.007	27800	330	80	0.006
1.0	48000	750	150	0.008	38000	570	120	0.008	25500	360	80	0.007
2.0	33300	850	210	0.013	26000	680	165	0.013	17500	420	110	0.012
3.0	21800	850	205	0.019	17300	680	165	0.020	11500	420	110	0.018
4.0	16700	880	210	0.026	13200	700	165	0.027	8800	440	110	0.025
5.0	15700	1000	245	0.032	12500	805	195	0.032	8300	500	130	0.030
6.0	13100	950	245	0.036	10350	770	195	0.037	6900	480	130	0.035
8.0	9880	930	250	0.047	7800	720	195	0.046	5200	445	130	0.043
10.0	7800	850	245	0.054	6150	680	195	0.055	4100	415	130	0.051
12.0	6650	850	250	0.064	5250	680	200	0.065	3500	415	130	0.059
16.0	4900	730	245	0.074	3900	580	195	0.074	2600	365	130	0.070
20.0	3900	660	245	0.085	3100	525	195	0.085	2050	335	130	0.082



MATERIAL HARDNESS DIAMETER	HARDENED STEELS											
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
0.2	33000	60	20	0.001	33000	45	20	0.001	26400	30	15	0.750
0.3	33000	70	30	0.001	25000	50	25	0.001	20000	35	20	0.700
0.4	33000	90	40	0.001	25000	55	30	0.001	20000	40	25	0.667
0.5	33000	140	50	0.002	25000	85	40	0.002	20000	60	30	0.750
0.6	30000	160	55	0.003	25000	105	45	0.002	20000	75	40	0.833
0.8	25000	185	65	0.004	19000	110	50	0.003	15200	80	40	0.800
0.9	22700	205	65	0.005	17500	125	50	0.004	14000	90	40	0.900
1.0	20500	215	65	0.005	16000	135	50	0.004	12500	85	40	0.850
2.0	14500	260	90	0.009	11000	160	70	0.007	9500	115	60	0.821
3.0	9500	260	90	0.014	7500	160	70	0.011	6400	115	60	0.821
4.0	7200	270	90	0.019	5600	170	70	0.015	4750	118	60	0.843
5.0	6400	285	100	0.022	5100	180	80	0.018	4450	132	70	0.825
6.0	5300	280	100	0.026	4200	180	80	0.021	3700	130	70	0.813
8.0	4000	255	100	0.032	3200	165	80	0.026	2800	120	70	0.750
10.0	3200	240	100	0.038	2550	155	80	0.030	2200	112	70	0.700
12.0	2650	240	100	0.045	2100	155	80	0.037	1860	112	70	0.700
16.0	2000	210	100	0.053	1600	135	80	0.042	1400	95	70	0.594
20.0	1600	195	100	0.061	1300	125	80	0.048	1100	85	70	0.531

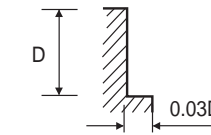


RPM = rev./min.  
FEED = mm/min.

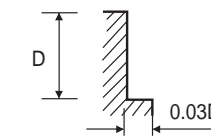
**CARBIDE, 2 FLUTE - SIDE CUTTING**

G8A01, G8A36 SERIES

MATERIAL HARDNESS DIAMETER	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
1.0	48000	1050	150	0.011	38000	820	120	0.011	25500	510	80	0.010
2.0	33300	1200	210	0.018	26000	970	165	0.019	17500	600	110	0.017
3.0	21800	1200	205	0.028	17300	970	165	0.028	11500	600	110	0.026
4.0	16700	1250	210	0.037	13200	1000	165	0.038	8800	625	110	0.036
5.0	15700	1450	245	0.046	12500	1150	195	0.046	8300	710	130	0.043
6.0	13100	1350	245	0.052	10350	1100	195	0.053	6900	690	130	0.050
8.0	9880	1320	250	0.067	7800	1030	195	0.066	5200	635	130	0.061
10.0	7800	1200	245	0.077	6150	970	195	0.079	4100	590	130	0.072
12.0	6650	1200	250	0.090	5250	970	200	0.092	3500	590	130	0.084
16.0	4900	1050	245	0.107	3900	840	195	0.108	2600	520	130	0.100
20.0	3900	950	245	0.122	3100	750	195	0.121	2050	475	130	0.116



MATERIAL HARDNESS DIAMETER	HARDENED STEELS											
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
1.0	20500	310	65	0.008	16000	190	50	0.006	12500	125	40	1.250
2.0	14500	370	90	0.013	11000	230	70	0.010	9500	165	60	1.179
3.0	9500	370	90	0.019	7500	230	70	0.015	6400	165	60	1.179
4.0	7200	385	90	0.027	5600	240	70	0.021	4750	170	60	1.214
5.0	6400	410	100	0.032	5100	260	80	0.025	4450	190	70	1.188
6.0	5300	400	100	0.038	4200	255	80	0.030	3700	185	70	1.156
8.0	4000	365	100	0.046	3200	235	80	0.037	2800	170	70	1.063
10.0	3200	340	100	0.053	2550	220	80	0.043	2200	160	70	1.000
12.0	2650	340	100	0.064	2100	220	80	0.052	1860	160	70	1.000
16.0	2000	300	100	0.075	1600	190	80	0.059	1400	140	70	0.875
20.0	1600	275	100	0.086	1300	175	80	0.067	1100	125	70	0.781



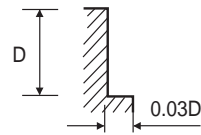
RPM = rev./min.  
FEED = mm/min.



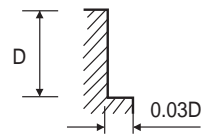
**CARBIDE, 4 FLUTE - SIDE CUTTING**

**G8A02, G8A37 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
1.0	48000	1480	150	0.008	38000	1050	120	0.007	25500	710	80	0.007
2.0	33300	1750	210	0.013	26000	1250	165	0.012	17500	840	110	0.012
3.0	21800	1750	205	0.020	17300	1250	165	0.018	11500	840	110	0.018
4.0	16700	1800	210	0.027	13200	1300	165	0.025	8800	880	110	0.025
5.0	15700	2000	245	0.032	12500	1500	195	0.030	8300	1000	130	0.030
6.0	13100	1950	245	0.037	10350	1400	195	0.034	6900	950	130	0.034
8.0	9880	1880	250	0.048	7800	1350	195	0.043	5200	900	130	0.043
10.0	7800	1750	245	0.056	6150	1260	195	0.051	4100	840	130	0.051
12.0	6650	1750	250	0.066	5250	1260	200	0.060	3500	840	130	0.060
16.0	4900	1500	245	0.077	3900	1100	195	0.071	2600	730	130	0.070
20.0	3900	1300	245	0.083	3100	970	195	0.078	2050	650	130	0.079



MATERIAL	HARDENED STEELS											
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
1.0	20500	430	65	0.005	16000	270	50	0.004	12500	175	40	0.875
2.0	14500	520	90	0.009	11000	320	70	0.007	9500	230	60	0.821
3.0	9500	520	90	0.014	7500	320	70	0.011	6400	230	60	0.821
4.0	7200	540	90	0.019	5600	335	70	0.015	4750	240	60	0.857
5.0	6400	580	100	0.023	5100	370	80	0.018	4450	270	70	0.844
6.0	5300	560	100	0.026	4200	350	80	0.021	3700	260	70	0.813
8.0	4000	520	100	0.033	3200	330	80	0.026	2800	240	70	0.750
10.0	3200	480	100	0.038	2550	310	80	0.030	2200	220	70	0.688
12.0	2650	480	100	0.045	2100	300	80	0.036	1860	220	70	0.688
16.0	2000	420	100	0.053	1600	270	80	0.042	1400	200	70	0.625
20.0	1600	380	100	0.059	1300	250	80	0.048	1100	180	70	0.563

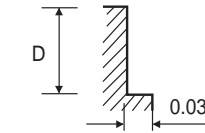


RPM = rev./min.  
FEED = mm/min.

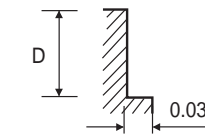
**CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS**

**G8A39 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 - HRc 40				HRc 40 - HRc 50				HRc 50 - HRc 55			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
6.0	24800	5350	465	0.036	23500	4900	445	0.035	16000	4900	300	0.051
8.0	20000	5500	505	0.046	19000	5000	480	0.044	12000	4600	300	0.064
10.0	16000	4900	505	0.051	15500	4500	485	0.048	9500	4100	300	0.072
12.0	13000	4500	490	0.058	12500	4100	470	0.055	8000	3800	300	0.079
16.0	10000	4000	505	0.067	9700	3700	490	0.064	6000	3400	300	0.094
20.0	8000	3350	505	0.070	7800	3400	490	0.073	4800	3200	300	0.111



MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 55 - HRc 60				HRc 60 - HRc 65				HRc 65 - HRc 70			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
6.0	13500	3300	255	0.041	10500	2100	200	0.033	8000	1450	150	1.208
8.0	10000	3100	250	0.052	8000	2000	200	0.042	6000	1400	150	1.167
10.0	8000	2900	250	0.060	6400	1800	200	0.047	4800	1300	150	1.083
12.0	6600	2500	250	0.063	5300	1600	200	0.050	4000	1150	150	0.958
16.0	5000	2300	250	0.077	4000	1250	200	0.052	3000	870	150	0.725
20.0	4000	2100	250	0.088	3200	1020	200	0.053	2400	690	150	0.575



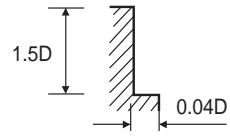
\* The Feed, in long & extra long types, should be reduced by around 50%.

RPM = rev./min.  
FEED = mm/min.

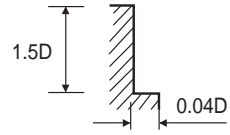
**CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH**

**G8D63 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 55			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc
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	HARDENED STEELS							
	HRc 55 ~ HRc 65				HRc 65 ~ HRc 70			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc
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

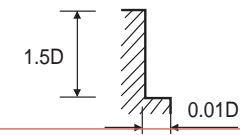


RPM = rev./min.  
FEED = mm/min.

**CARBIDE, 6&8 FLUTE 45° HELIX EXTRA LONG LENGTH**

**G8D64 SERIES**

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS							
	HRc 30 ~ HRc 40				HRc 40 ~ HRc 55				HRc 55 ~ HRc 65			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc
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.