X5070 END MILLS

PLAIN SHANK **G8A28** SERIES

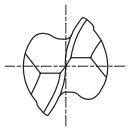
CARBIDE, 2 FLUTE BALL NOSE

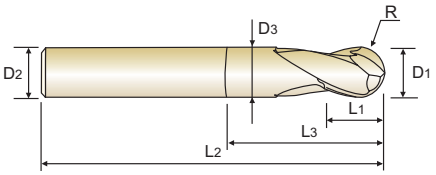
VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS
Fraise carbure, 2 dents, hémisphérique
2 TAGLIENTI, SEMISFERICA

- 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.

- Geeignet zum Fräsen hochgehärteter Stähle.
- Geeignet zum Trockenfräsen und HSC-Fräsen dank neuentwickeltem Material und Beschichtung.
- Excellente Werkstückoberflächen.
- Geeignet für hochpräzises Fräsen.
- Höhere Verschleißfestigkeit.







CARBIDE | 2 | 30° | R ±0.005 (R0.05~R3) | R ±0.010 (R4~R6) | PLAIN | BLUE

p.C184~C185

Recommended ToolHolder
- Plain Shank
- HYDRAULIC CHUCK SHRINK FIT HOLDER
- POWER MILLING CHUCK
- ER COLLET CHUCK SK SLIM CHUCK

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter 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	-
G8A280104S	R0.5	1.0	4	1.5	3	50	0.95
G8A28010	R0.5	1.0	6	1.5	3	50	0.95
G8A280154S	R0.75	1.5	4	2	4	50	1.45
G8A28015	R0.75	1.5	6	2	4	50	1.45
G8A280204S	R1.0	2.0	4	2.5	5	50	1.95
G8A28020	R1.0	2.0	6	2.5	5	50	1.95
G8A280254S	R1.25	2.5	4	3	7	50	2.4
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

Due to the characteristics of the blue decoration layer, it might be erased during short term use and the color layer might not be uniformed. However, it doesn't affect the performance of the tool.

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend					○			○	○		○									

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		◎	◎	○	◎

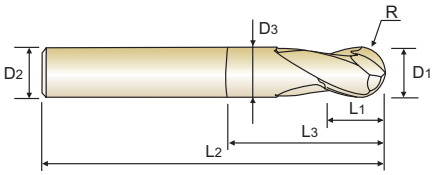
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G8A28055	R2.75	5.5	6	6.5	12	60	5.35
G8A28060	R3.0	6.0	6	7	15	60	5.85
G8A28903	R3.0	6.0	6	9	30	90	5.85
G8A28901	R4.0	8.0	8	9	15	60	7.7
G8A28080	R4.0	8.0	8	9	15	80	7.7
G8A28904	R4.0	8.0	8	12	30	100	7.7
G8A28902	R5.0	10.0	10	11	25	60	9.7
G8A28100	R5.0	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

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