# CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK

## VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

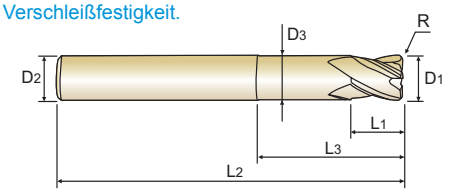
## Fraise carbure, 4 dents, torique, détalonnée

## 4 TAGLIENTI, TORICA, TAGLIENTE CORTO CON SCARICO ESTESO

- 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.

- Geeignet zum Fräsen hochgehärteter Stähle.
- Geeignet zum Trockenfräsen und HSC-Fräsen dank neuentwickeltem Material und Beschichtung.
- Excellente Werkstückoberflächen.
- Abgesetzter Schaft für größere Reichweite.
- Schneidkantenschutz durch definierten Radius.
- Höhere Verschleißfestigkeit.




CARBIDE | 4 | 30° | R ±0.010 | R ±0.015 | PLAIN | BLUE

Ø6 Ø8~Ø12

p.C192

Recommended ToolHolder

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

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 |
|---|---|---|---|---|---|---|---|
| G8B0806005090 | R0.5 | **6.0** | 6 | 9 | 20 | 90 | 5.85 |
| G8B0806010090 | R1.0 | **6.0** | 6 | 9 | 20 | 90 | 5.85 |
| G8B0808005100 | R0.5 | **8.0** | 8 | 12 | 25 | 100 | 7.7 |
| G8B0808010100 | R1.0 | **8.0** | 8 | 12 | 25 | 100 | 7.7 |
| G8B0810005100 | R0.5 | **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 | R0.5 | **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 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.

| Size | Corner Radius Tolerance (mm) | Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|---|---|
| up to Ø6 | ± 0.010 | 0 ~ - 0.012 | h5 |
| over Ø6 | ± 0.015 | 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 | | | | | | | | | | | | | | | | | | ◎ | ◎ | ○ | ◎ |