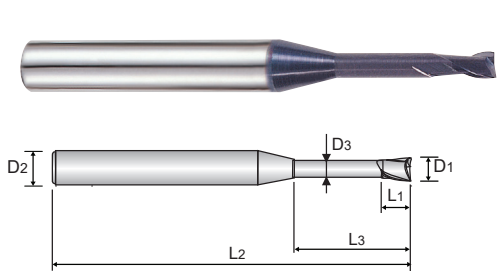
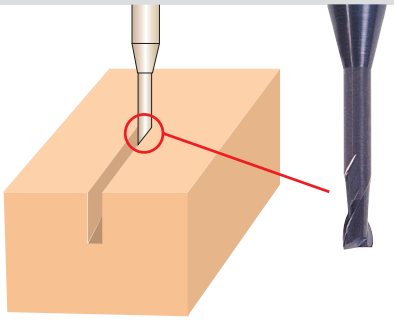
# CARBIDE, 2 FLUTE for RIB PROCESSING

## VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN
## Fraise carbure, 2 dents pour usinage de rainure
## 2 TAGLIENTI, SCARICATA PER NERVATURE



CARBIDE | 2 | 30° | PLAIN | Y Coating

p.C426~C427

Recommended ToolHolder

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

Unit : mm

| EDP No. | Mill Diameter | Shank Diameter | Length of Cut | Length Below Shank | Overall Length | Neck Diameter |
|---|---|---|---|---|---|---|
| | D1 | D2 | L1 | L3 | L2 | D3 |
| GM883004 | 0.4 | 4 | 0.6 | 2 | 45 | 0.37 |
| GM883005 | 0.5 | 4 | 0.7 | 2 | 45 | 0.45 |
| GM883988 | 0.5 | 4 | 0.7 | 4 | 45 | 0.45 |
| GM883820 | 0.7 | 4 | 1 | 3 | 45 | 0.65 |
| GM883008 | 0.8 | 4 | 1.2 | 4 | 45 | 0.75 |
| GM883908 | 0.8 | 4 | 1.2 | 6 | 45 | 0.75 |
| GM883996 | 1.0 | 4 | 1.5 | 4 | 45 | 0.95 |
| GM883010 | 1.0 | 4 | 1.5 | 6 | 45 | 0.95 |
| GM883912 | 1.0 | 4 | 1.5 | 8 | 45 | 0.95 |
| GM883913 | 1.0 | 4 | 1.5 | 10 | 45 | 0.95 |
| GM883914 | 1.0 | 4 | 1.5 | 12 | 45 | 0.95 |
| GM883997 | 1.0 | 4 | 1.5 | 16 | 50 | 0.95 |
| GM883998 | 1.0 | 4 | 1.5 | 20 | 55 | 0.95 |
| GM883012 | 1.2 | 4 | 1.8 | 6 | 45 | 1.15 |
| GM883015 | 1.5 | 4 | 2.3 | 6 | 45 | 1.45 |
| GM883923 | 1.5 | 4 | 2.3 | 8 | 45 | 1.45 |
| GM883924 | 1.5 | 4 | 2.3 | 10 | 45 | 1.45 |
| GM883925 | 1.5 | 4 | 2.3 | 12 | 45 | 1.45 |
| GM883927 | 1.5 | 4 | 2.3 | 16 | 50 | 1.45 |
| GM883810 | 1.5 | 4 | 2.3 | 20 | 55 | 1.45 |

▶ NEXT PAGE

| Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.015 | h5 |

◎ : 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 | ○ | ○ | ○ | ◎ | ◎ | ○ | ◎ | ◎ | ◎ | ○ | ◎ | | | | ○ | ○ | ○ | ○ | ○ | ○ |

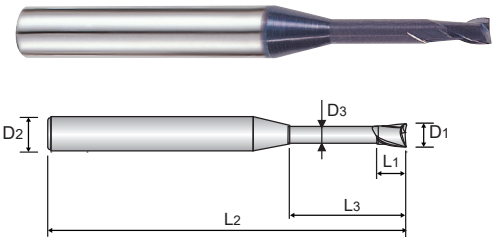
| ISO | N | | | | | | | | | | S | | | | | | | H | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Aluminum-wrought alloy | | Aluminum-cast, alloyed | | | Copper and Copper Alloys (Bronze / Brass) | | | Non Metallic Materials | | 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 | | | | | | | | | | | | | | | | | | ○ | | ◎ | ○ |

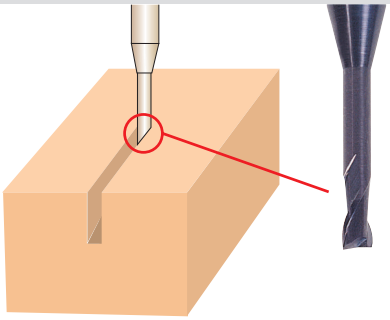
# X-POWER PRO END MILLS

PLAIN SHANK **GM883 SERIES**

## CARBIDE, 2 FLUTE for RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN
Fraise carbure, 2 dents pour usinage de rainure
2 TAGLIENTI, SCARICATA PER NERVATURE



CARBIDE | 2 | 30° | PLAIN | Y Coating

p.C426~C427

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

Unit : mm

| EDP No. | Mill Diameter | Shank Diameter | Length of Cut | Length Below Shank | Overall Length | Neck Diameter |
|---|---|---|---|---|---|---|
| | D1 | D2 | L1 | L3 | L2 | D3 |
| GM883946 | 1.8 | 4 | 2.7 | 12 | 45 | 1.75 |
| GM883958 | 2.0 | 4 | 3 | 6 | 45 | 1.95 |
| GM883020 | 2.0 | 4 | 3 | 8 | 45 | 1.95 |
| GM883959 | 2.0 | 4 | 3 | 10 | 45 | 1.95 |
| GM883960 | 2.0 | 4 | 3 | 12 | 45 | 1.95 |
| GM883961 | 2.0 | 4 | 3 | 14 | 50 | 1.95 |
| GM883962 | 2.0 | 4 | 3 | 16 | 50 | 1.95 |
| GM883964 | 2.0 | 4 | 3 | 20 | 55 | 1.95 |
| GM883966 | 2.0 | 4 | 3 | 25 | 60 | 1.95 |
| GM883814 | 2.0 | 4 | 3 | 30 | 70 | 1.95 |
| GM883970 | 2.5 | 4 | 3.7 | 16 | 55 | 2.40 |
| GM883975 | 3.0 | 6 | 4.5 | 10 | 45 | 2.85 |
| GM883976 | 3.0 | 6 | 4.5 | 12 | 45 | 2.85 |
| GM883978 | 3.0 | 6 | 4.5 | 16 | 55 | 2.85 |
| GM883979 | 3.0 | 6 | 4.5 | 18 | 55 | 2.85 |
| GM883980 | 3.0 | 6 | 4.5 | 20 | 60 | 2.85 |
| GM883981 | 3.0 | 6 | 4.5 | 25 | 65 | 2.85 |
| GM883832 | 3.0 | 6 | 4.5 | 30 | 70 | 2.85 |
| GM883983 | 3.0 | 6 | 4.5 | 40 | 90 | 2.85 |

▶ NEXT PAGE

| Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.015 | h5 |

◎ : 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 | | | | | | | | | | | | | | | | | | ○ | | ◎ | ○ |

# X-POWER PRO END MILLS

PLAIN SHANK **GM883 SERIES**

## CARBIDE, 2 FLUTE for RIB PROCESSING

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Fraise carbure, 2 dents pour usinage de rainure
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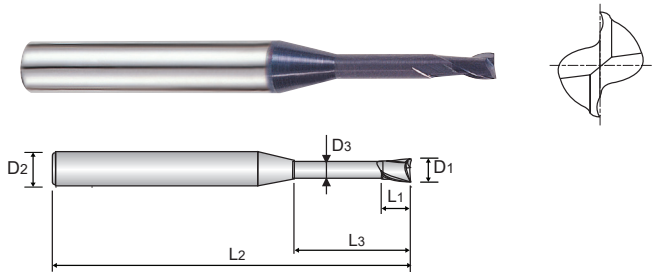


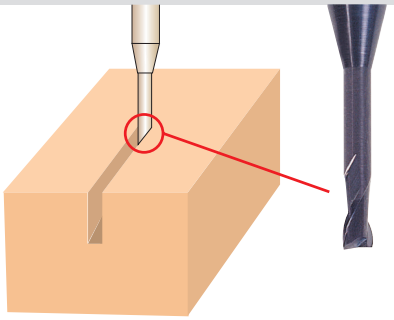

CARBIDE | 2 | 30° | PLAIN | Y Coating

p.C426~C427

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

Unit : mm

| EDP No. | Mill Diameter | Shank Diameter | Length of Cut | Length Below Shank | Overall Length | Neck Diameter |
|---|---|---|---|---|---|---|
| | $D_1$ | $D_2$ | $L_1$ | $L_3$ | $L_2$ | $D_3$ |
| GM883801 | 4.0 | 6 | 6 | 16 | 60 | 3.85 |
| GM883802 | 4.0 | 6 | 6 | 20 | 60 | 3.85 |
| GM883803 | 4.0 | 6 | 6 | 25 | 70 | 3.85 |
| GM883834 | 4.0 | 6 | 6 | 30 | 70 | 3.85 |
| GM883836 | 4.0 | 6 | 6 | 40 | 90 | 3.85 |
| GM883838 | 4.0 | 6 | 6 | 50 | 100 | 3.85 |
| GM883807 | 6.0 | 6 | 9 | 30 | 90 | 5.85 |
| GM883809 | 6.0 | 6 | 9 | 50 | 110 | 5.85 |

| Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.015 | h5 |

◎ : 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 | | | | | | | | | | | | | | | | | | ○ | | ◎ | ○ |