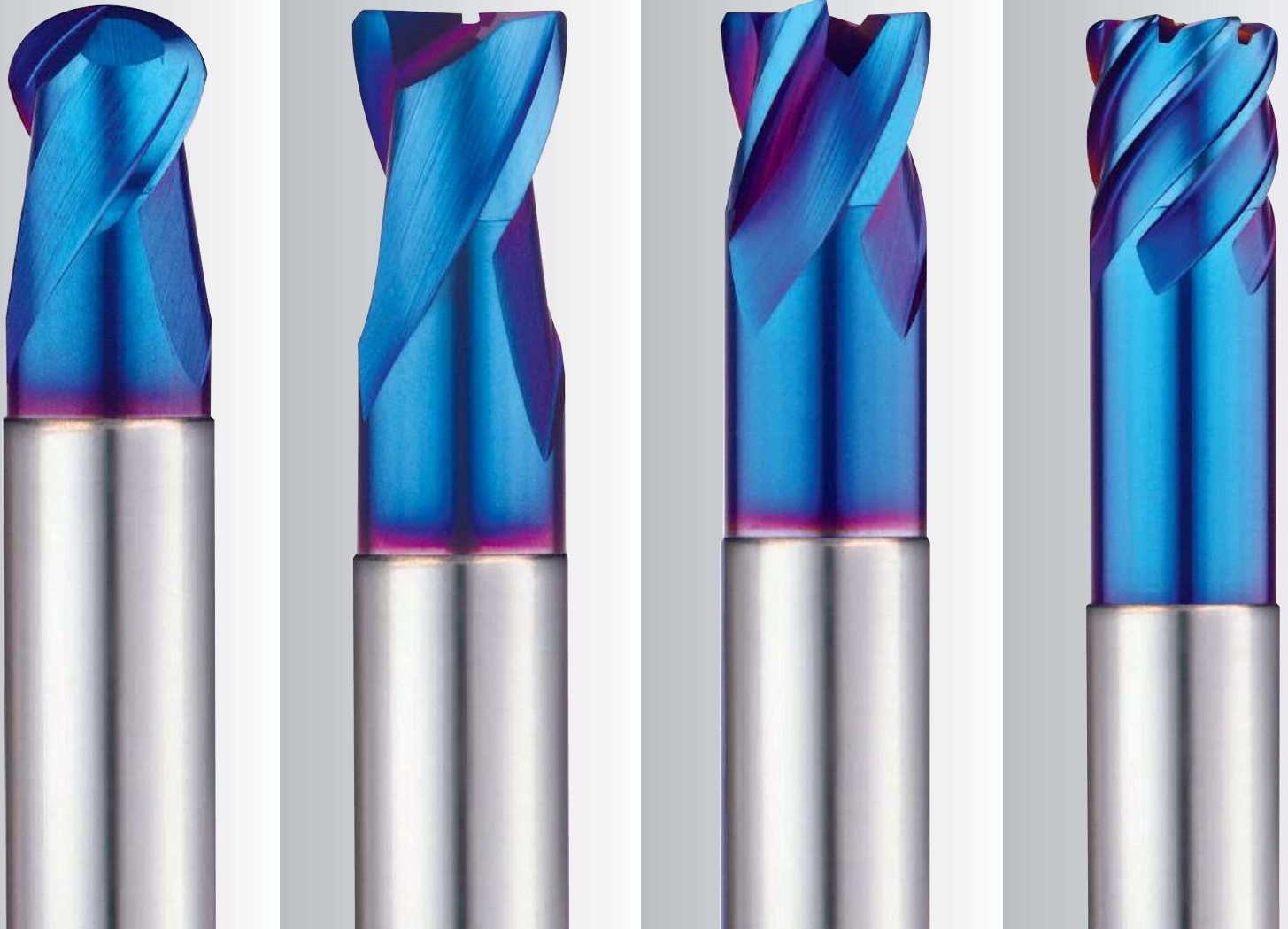




CARBIDE

Being the best through innovation

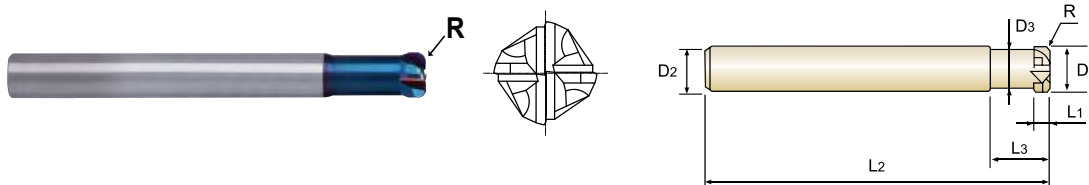


X5070 END MILLS

- High Hardened Steels HRc45 to HRc70, High Speed Machining, Dry Cutting

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.



High Feed End Mill

◇ Call for Availability

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
		Metric	Inch					
G854020	R0.5	2.0	.0787	6	1	6	70	1.8
G854030	R0.5	3.0	.1181	6	1.2	8	70	2.8
G854040	R0.5	4.0	.1575	6	1.5	10	70	3.8
G854050	R1.0	5.0	.1969	6	2	10	70	4.6
G854060	R0.5	6.0	.2362	6	2.5	12	90	5.4
G854061	R1.0	6.0	.2362	6	2.5	12	90	5.4
G854062	R1.5	6.0	.2362	6	2.5	12	90	5.4
G854081	R1.0	8.0	.3150	8	3.5	16	100	7.2
G854082	R2.0	8.0	.3150	8	3.5	16	100	7.2
G854101	R1.0	10.0	.3937	10	4	20	100	9
G854102	R2.0	10.0	.3937	10	4	20	100	9
G854122	R2.0	12.0	.4724	12	5	25	110	11
G854123	R3.0	12.0	.4724	12	5	25	110	11
G854163	R3.0	16.0	.6299	16	6.5	30	130	15

The original bright blue color may discolor during use, however, the performance will not be negatively affected

Mill Dia. Tolerance (inch)	Corner Radius Tolerance (inch)	Shank Dia. Tolerance
0 ~ -.0008	±.0002	h6

◎ : Excellent ○ : Good

P				H		M	K	N					S		
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels		Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70										
		○	○	◎	◎										



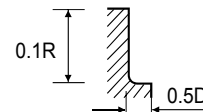
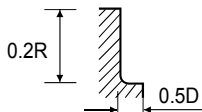
CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS HIGH FEED

G859, G854 SERIES

■ NORMAL SPEED

MATERIAL	P						H			
	HARDENED STEELS						HIGH HARDENED STEELS			
	HARDNESS DIAMETER	~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0 × R0.5	13500	255.9	9550	149.6	5500	86.6	3200	39.4	2200	21.7
3.0 × R0.5	9550	255.9	6900	163.4	4550	108.3	2850	45.3	1900	24.0
4.0 × R0.5	7950	275.6	5750	181.1	4000	126.0	2550	53.2	1750	27.6
5.0 × R0.5	6500	287.4	4800	189.0	3400	126.0	2200	63.0	1500	27.6
6.0 × R0.5	5800	301.2	4100	192.9	2900	137.8	1850	72.8	1350	31.3
6.0 × R1.0	5800	301.2	4100	192.9	2900	137.8	1850	72.8	1350	31.3
8.0 × R1.0	4350	301.2	3050	192.9	2200	137.8	1400	72.8	995	31.3
8.0 × R2.0	4350	301.2	3050	192.9	2200	137.8	1400	72.8	995	31.3
10.0 × R1.0	3500	301.2	2450	192.9	1750	137.8	1100	72.8	795	31.3
10.0 × R2.0	3500	301.2	2450	192.9	1750	137.8	1100	72.8	795	31.3
12.0 × R2.0	2900	301.2	2050	192.9	1450	137.8	925	72.8	665	31.3
12.0 × R3.0	2900	301.2	2050	192.9	1450	137.8	925	72.8	665	31.3
16.0 × R3.0	2200	301.2	1550	192.9	1100	137.8	700	72.8	500	31.3

RPM = rev./min.
FEED = inch/min.



■ HIGH SPEED

MATERIAL	P						H			
	HARDENED STEELS						HIGH HARDENED STEELS			
	HARDNESS DIAMETER	~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0 × R0.5	29000	590.6	22000	385.8	15000	309.1	11000	175.2	8700	96.5
3.0 × R0.5	22000	629.9	17000	393.7	12500	315.0	9500	181.1	6900	98.4
4.0 × R0.5	17000	689.0	13000	472.4	11000	362.2	8000	216.5	5600	114.2
5.0 × R0.5	15000	708.7	11000	192.1	10000	393.7	7000	236.2	4900	122.1
6.0 × R0.5	13500	728.4	10500	543.3	9000	433.1	6400	252.0	4500	141.7
6.0 × R1.0	13500	728.4	10500	543.3	9000	433.1	6400	252.0	4500	141.7
8.0 × R1.0	10000	728.4	8000	551.2	6800	433.1	4800	263.8	3400	161.4
8.0 × R2.0	10000	728.4	8000	551.2	6800	433.1	4800	263.8	3400	161.4
10.0 × R1.0	8000	728.4	6400	551.2	5400	433.1	3800	267.7	2700	149.6
10.0 × R2.0	8000	728.4	6400	551.2	5400	433.1	3800	267.7	2700	149.6
12.0 × R2.0	6600	728.4	5300	551.2	4500	433.1	3200	275.6	2250	141.7
12.0 × R3.0	6600	728.4	5300	551.2	4500	433.1	3200	275.6	2250	141.7
16.0 × R3.0	5000	728.4	3900	551.2	3300	433.1	2400	275.6	1650	129.9

RPM = rev./min.
FEED = inch/min.

