

**YG X5070 END MILLS**

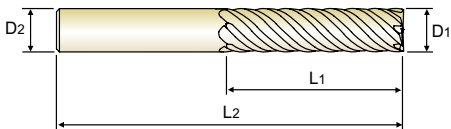
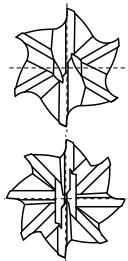
PLAIN SHANK

**G8D64** SERIES

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

- VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE EXTRA LANG**
- Fraise carbure, 6&8 dents, hélice 45°, extra-longue**
- 6&8 TAGLIENTI, ELICA 45°, TAGLIENTE EXTRA LUNGO**

- ▶ Designed to machine high hardened materials.
- ▶ Designed for high abrasion resistance thanks to negative rake angle.
- ▶ Excellent side-cutting of press mold field.
- ▶ Speziell ausgelegt für die Hartbearbeitung
- ▶ Ausgelegt für hohe Abriebfestigkeit dank der negativen Spanwinkel.
- ▶ Hervorragend geeignet für die Seitenbearbeitung im Formenbau



p.C143

| Recommended ToolHolder | Plain Shank       |            |
|------------------------|-------------------|------------|
|                        |                   | Page       |
|                        | HYDRAULIC CHUCK   | D15 - 46   |
|                        | SHRINK FIT HOLDER | D47 - 72   |
| POWER MILLING CHUCK    |                   | D161 - 176 |
| ER COLLET CHUCK        |                   | D73 - 116  |
| SK SLIM CHUCK          |                   | D183 - 201 |

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

| Mill Dia.<br>Tolerance (mm) | Shank Dia.<br>Tolerance |
|-----------------------------|-------------------------|
| 0 ~ - 0.03                  | h5                      |



Enforced Cutting Edge

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