

CARBIDE, 3&4 FLUTE 20° HELIX LONG LENGTH ROUGHING - FINE

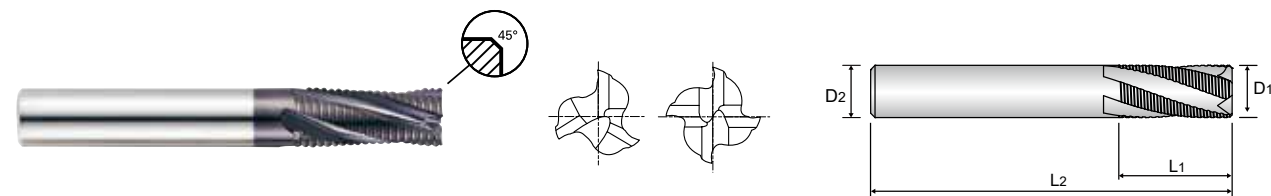
 VOLLHARTMETALL, 3&4 SCHNEIDEN 20° RECHTSSPIRALE LANG SCHRUPPFRÄSER - FEIN

 Fraise carbure, 3&4-dents ébauche, hélice 20°, pas fin, longue

 3 - 4 TAGLIENTI, BOMBATO FINE PER SGROSSATURA, ELICA 20° SERIE LUNGA

- Designed to machine tool steels, alloy steels, mold steels and other hardened materials.
- High velocity milling of hardened steels.
- For dry and wet milling.
- Fast chip ejection.

- Zur Bearbeitung von Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- Hochgeschwindigkeitsfräsen von gehärteten Stählen.
- Für Trocken - und Nassfräsen.
- Schnelle Spanabfuhr.



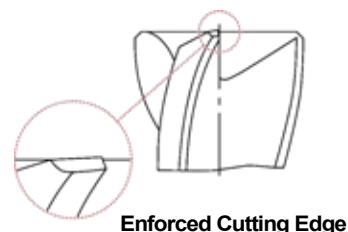
Plain Shank	Page
HYDRAULIC CHUCK	D15 - 46
SHRINK FIT HOLDER	D47 - 72
POWER MILLING CHUCK	D161 - 176
ER COLLET CHUCK	D73 - 116
SK SLIM CHUCK	D183 - 201

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute	Chamfer
	D1	D2	L1	L2		
GM814060	6.0	6	16	57	3	0.38
GM814080	8.0	8	16	63	3	0.38
GM814100	10.0	10	22	72	4	0.60
GM814120	12.0	12	26	83	4	0.60
GM814160	16.0	16	32	92	4	0.60
GM814200	20.0	20	38	104	4	0.60

Tolerances according to DIN 7160 & 7161

Tolerance range in µm					
Nominal-Diameter in mm					
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h5	0 - 4	0 - 5	0 - 6	0 - 8	0 - 9



Enforced Cutting Edge

		P										M					K				
		Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
ISO	Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	HRC	125	130	135	140	145	150	155	160	165	170	175	180	185	190	195	200	205	210	215	220
HB		125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
		N										S					H				
		Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
ISO	Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	HRC	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HB		60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	550	630	400
Recommend																					

© : Excellent ○ : Good