

Coated Carbide **GSX**

Structural Steel	Carbon Steel	Alloy Steel	Pre-hardened Steel	Tempered Die Steel	Hardened Steel	Stainless Steel	Ti Alloy / Heat Resistant Alloy	Cast Iron	Al Alloy	Cu Alloy	Graphite
○	○	○	○	○	○	○	○	○	○	○	○

Grades Coating

Helix Angle: 30°
Corner: C Type

øDc	Tolerance
D ≤ 3.0	0 - 0.015
3.0 < D ≤ 12	0 - 0.020
12.0 < D	0 - 0.030

Grade: ACF20

Endmills

Cat. No.	Stock	øD	l ₁	l ₂	L	ød
GSX 20100C-4D	●	1,0	4,0	5,0	40	4
GSX 20150C-4D	●	1,5	6,0	7,0	40	4
GSX 20200C-4D	●	2,0	8,0	9,0	40	4
GSX 20250C-4D	●	2,5	10,0	11,0	50	4
GSX 20300C-4D	●	3,0	12,0	13,5	50	6
GSX 20400C-4D	●	4,0	16,0	17,5	50	6
GSX 20500C-4D	●	5,0	20,0	22,0	60	6
GSX 20600C-4D	●	6,0	24,0	-	60	6
GSX 20800C-4D	●	8,0	32,0	-	80	8
GSX 21000C-4D	●	10,0	40,0	-	90	10
GSX 21200C-4D	●	12,0	48,0	-	100	12
GSX 21600C-4D		16,0	64,0	-	120	16
GSX 22000C-4D		20,0	80,0	-	140	20

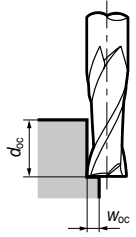
Endmill Identification (GSX MILL Series)

GSX 2 0100 C - 4D

- ① Series Code
 - ② No. of Teeth
 - ③ Diameter
 - ④ Cutting Edge
 - ⑤ Cutting Edge Length
- (S: Sharp Edge
C: Gash Land Drilling)

Recommended cutting conditions

- For stable machining performance use rigid, high-precision machines and holders.
- Use air blowing when dry machining.
- Use wet machining for stainless steel, heat resistant alloy, and titanium alloy applications.
- In rear cases, chattering may occur in early milling stages, dissipating after 2m of cutting.
- If chattering is a problem, reduce the spindle speed and feed rate indicated in the table below by the same ratio, or reduce the depth of cut.
- This series is not recommended for grooving.
- If the machine cannot achieve the recommended spindle speed, please use the max. spindle speed available.



Shoulder Milling

Work Material Cond.	Structural Steel		Carbon Steel (150 to 250HB)		Cast Iron		Alloy Steel (25 to 35HRC)		Tempered Steel, Hardened Steel (35 to 45HRC)		Hardened Steel (45 to 55HRC)		Stainless Steel		Heat Resistant Steel, Titanium Alloy			
	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)	Spindle Speed (rpm)	Feed Rate (mm/min)		
1,0	9.000	130	9.000	130	9.000	130	7.000	95	6.500	50	4.500	30	5.400	40	4.500	25		
2,0	4.500	180	4.500	180	4.500	180	3.500	120	3.200	70	2.300	40	2.700	50	2.300	35		
4,0	2.250	240	2.250	240	2.250	240	1.750	160	1.600	95	1.200	60	1.350	65	1.200	40		
6,0	1.500	300	1.500	300	1.500	300	1.150	170	1.050	110	800	70	900	70	800	50		
8,0	1.100	260	1.100	260	1.100	260	850	170	800	110	600	70	660	70	600	50		
10,0	900	250	900	250	900	250	700	160	650	110	460	70	540	70	460	50		
12,0	750	240	750	240	750	240	580	160	520	110	400	70	450	70	400	50		
16,0	550	200	550	200	550	200	440	140	400	95	300	55	330	60	300	45		
20,0	450	180	450	180	450	180	350	120	320	85	240	45	270	50	240	40		
Shoulder cutting	d _{oc}		3,5 D				0,08 D				3,0 D				0,04 D			

Coated Endmills