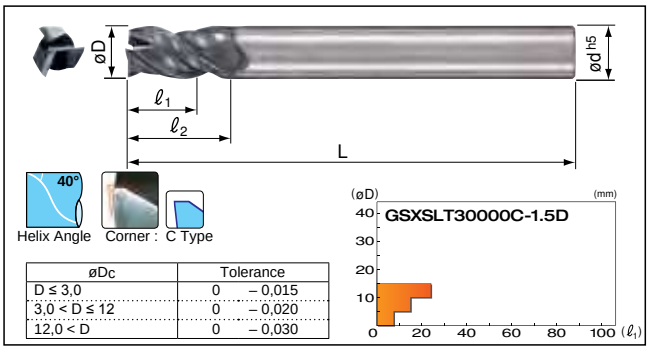
для заказа - sumitomo@sumitomo-tools.ru

GSXSLT 30000C-1.5D Type

3 Slotted Short Endmills (3 Flutes)

For Compound Endmilling

Coated Carbide (Grades)	GSX (Coating)	Structual Steel	Carbon Steel	Alloy Steel	Pre-hardened Steel	Tempered Die Steel	Hardened Steel 45~55 HRC	Hardened Steel 55~60 HRC	Hardened Steel 60~65 HRC	Stainless Steel	Ti Alloy / Heat Resistant Alloy	Cast iron	Al Alloy	Cu Alloy	Graphite
		○	◎	◎	◎	◎	◎			◎	○	○			



øDc	Tolerance
D ≤ 3,0	0 – 0,015
3,0 < D ≤ 12	0 – 0,020
12,0 < D	0 – 0,030

Grade: ACF20

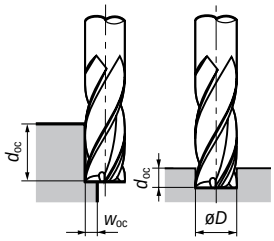
■ Endmills

(mm)

Cat. No.	Stock	øD	ℓ_1	ℓ_2	L	ød
GSXSLT 30100C-1.5D	●	1,0	1,5	2,5	40	4
GSXSLT 30150C-1.5D	●	1,5	2,3	3,3	40	4
GSXSLT 30200C-1.5D	●	2,0	3,0	4,0	40	4
GSXSLT 30250C-1.5D	●	2,5	3,8	4,8	40	4
GSXSLT 30300C-1.5D	●	3,0	4,5	6,0	45	6
GSXSLT 30400C-1.5D	●	4,0	6,0	7,5	45	6
GSXSLT 30500C-1.5D	●	5,0	7,5	9,5	50	6
GSXSLT 30600C-1.5D	●	6,0	9,0	–	50	6
GSXSLT 30700C-1.5D	●	7,0	11,0	13,0	60	8
GSXSLT 30800C-1.5D	●	8,0	12,0	–	60	8
GSXSLT 30900C-1.5D	●	9,0	14,0	16,0	70	10
GSXSLT 31000C-1.5D	●	10,0	15,0	–	70	10
GSXSLT 31200C-1.5D	●	12,0	18,0	–	75	12
GSXSLT 31600C-1.5D		16,0	24,0	–	90	16

■ Recommended cutting conditions

1. For stable machining performance use rigid, high-precision machines and holders.
2. Use air blowing when dry machining.
3. Use wet machining for stainless steel, heat resistant alloy, and titanium alloy applications.
4. Use step machining of 0.1Dc when drilling stainless steel, heat resistant alloy, and titanium alloy.
5. If the machine cannot achieve the recommended spindle speed, please use the max. spindle speed available.



● Shoulder Milling

Work Material / Cond. / øD (mm)	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 Resistive 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	19.600	300	19.600	300	19.600	300	18.300	210	12.700	130	9.000	80	11.000	90	9.000	65
2,0	11.200	410	11.200	410	11.200	410	10.500	280	7.300	170	5.300	100	6.400	120	5.300	90
4,0	6.400	550	6.400	550	6.400	550	6.000	370	4.200	230	3.000	140	3.600	150	3.000	120
6,0	4.600	670	4.600	670	4.600	670	4.300	460	3.000	270	2.200	170	2.700	180	2.200	130
8,0	3.400	670	3.400	670	3.400	670	3.200	460	2.200	270	1.600	170	2.000	180	1.600	130
10,0	2.800	670	2.800	670	2.800	670	2.600	460	1.800	270	1.300	170	1.600	180	1.300	130
12,0	2.300	670	2.300	670	2.300	670	2.200	460	1.500	270	1.100	170	1.300	180	1.100	130
16,0	1.700	550	1.700	550	1.700	550	1.600	370	1.100	230	800	140	1.000	150	800	100
Shoulder cutting d_{oc}	1.5 *D*										1.0 *D*					
Shoulder cutting w_{oc}	0.05 *D*										0.02 *D*					

● Grooving

Work Material / Cond. / øD (mm)	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 Resistive 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	19.600	240	19.600	300	19.600	300	18.300	210	12.700	130	9.000	80	11.000	65	4.500	25
2,0	11.200	320	11.200	410	11.200	410	10.500	280	7.300	170	5.300	100	6.400	85	2.650	35
4,0	6.400	450	6.400	550	6.400	550	6.000	370	4.200	230	3.000	140	3.600	100	1.500	50
6,0	4.600	540	4.600	670	4.600	670	4.300	460	3.000	270	2.200	170	2.650	130	1.150	55
8,0	3.400	540	3.400	670	3.400	670	3.200	460	2.200	270	1.600	170	2.000	130	800	55
10,0	2.800	540	2.800	670	2.800	670	2.600	460	1.800	270	1.300	170	1.600	130	650	55
12,0	2.300	540	2.300	670	2.300	670	2.200	460	1.500	270	1.100	170	1.300	130	500	55
16,0	1.700	440	1.700	550	1.700	550	1.600	370	1.100	230	800	140	1.000	110	400	45
Grooving d_{oc}	0,2 *D*		0,5 *D*						0,2 *D*		0,05 *D*		0,2 *D*			

● Drilling

Work Material / Cond. / øD (mm)	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 Resistive 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	19.600	70	19.600	90	19.600	90	18.300	60	12.700	40	9.000	25	11.000	20	4.500	10
2,0	11.200	90	11.200	120	11.200	120	10.500	80	7.300	50	5.300	30	6.400	25	2.650	15
4,0	6.400	130	6.400	160	6.400	160	6.000	110	4.200	70	3.000	40	3.600	30	1.500	20
6,0	4.600	160	4.600	200	4.600	200	4.300	130	3.000	80	2.200	50	2.650	40	1.150	20
8,0	3.400	160	3.400	200	3.400	200	3.200	130	2.200	80	1.600	50	2.000	40	800	20
10,0	2.800	160	2.800	200	2.800	200	2.600	130	1.800	80	1.300	50	1.600	40	650	20
12,0	2.300	160	2.300	200	2.300	200	2.200	130	1.500	80	1.100	50	1.300	40	500	20
16,0	1.700	130	1.700	160	1.700	160	1.600	110	1.100	70	800	40	1.000	35	400	15

● = Euro stock

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