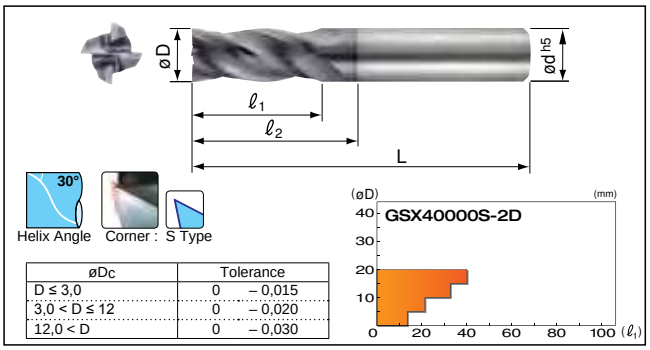
для заказа - sumitomo@sumitomo-tools.ru

GSX 40000S-2D Type

Coated Carbide — Grades
GSX — Coating

Structural 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
GSX 40100S-2D	●	1,0	2,5	3,5	40	4
GSX 40150S-2D	●	1,5	3,8	4,8	40	4
GSX 40200S-2D	●	2,0	5,0	6,0	40	4
GSX 40250S-2D	●	2,5	6,3	7,3	40	4
GSX 40300S-2D	●	3,0	7,5	9,0	45	6
GSX 40350S-2D	●	3,5	8,8	10,0	45	6
GSX 40400S-2D	●	4,0	11,0	14,0	45	6
GSX 40450S-2D	●	4,5	11,3	12,8	50	6
GSX 40500S-2D	●	5,0	13,0	19,6	50	6
GSX 40550S-2D	●	5,5	13,0	19,6	50	6
GSX 40600S-2D	●	6,0	13,0	–	50	6
GSX 40700S-2D	●	7,0	16,0	21,1	60	8
GSX 40800S-2D	●	8,0	19,0	–	60	8
GSX 40900S-2D	●	9,0	19,0	24,1	70	10
GSX 41000S-2D	●	10,0	22,0	–	70	10
GSX 41200S-2D	●	12,0	26,0	–	75	12
GSX 41600S-2D	●	16,0	32,0	–	90	16
GSX 42000S-2D	●	20,0	40,0	–	100	20

■ Endmill Identification (GSX MILL Series)

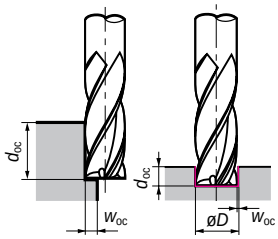
GSX 4 1000 S - 2D

①	②	③	④	⑤
Series Code	No. of Teeth	Diameter	Cutting Edge	Cutting Edge Length

(S: Sharp Edge
C: Gash Land Drilling)

■ 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. 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.
5. This series is not recommended for grooving.
6. 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	22.000	360	22.000	360	22.000	360	19.000	220	13.000	140	9.500	90	11.300	90	9.500	65
2,0	11.500	440	11.500	440	11.500	440	11.000	290	7.500	180	5.400	110	6.500	120	5.400	85
4,0	6.000	560	6.000	560	6.000	560	5.800	370	4.000	230	2.900	150	3.400	160	2.900	100
6,0	4.200	600	4.200	600	4.200	600	4.000	400	2.700	240	2.000	160	2.400	170	2.000	120
8,0	3.000	600	3.000	600	3.000	600	2.800	400	2.000	240	1.450	160	1.800	170	1.450	120
10,0	2.500	600	2.500	600	2.500	600	2.350	400	1.600	240	1.200	160	1.450	170	1.200	120
12,0	2.100	600	2.100	600	2.100	600	2.000	400	1.350	240	1.000	160	1.200	170	1.000	120
16,0	1.500	500	1.500	500	1.500	500	1.450	320	1.000	210	750	130	900	140	750	90
20,0	1.200	460	1.200	460	1.200	460	1.150	290	800	200	600	110	700	120	600	75
Shoulder cutting d_{oc}	2,0 D															
Shoulder cutting w_{oc}	0,03 D										0,01 D					

● Groove Finishing

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	22.000	360	22.000	360	22.000	360	19.000	220	13.000	140	9.500	90	11.300	90	9.500	65
2,0	11.500	440	11.500	440	11.500	440	11.000	290	7.500	180	5.400	110	6.500	120	5.400	85
4,0	6.000	560	6.000	560	6.000	560	5.800	370	4.000	230	2.900	150	3.400	160	2.900	100
6,0	4.200	600	4.200	600	4.200	600	4.000	400	2.700	240	2.000	160	2.400	170	2.000	120
8,0	3.000	600	3.000	600	3.000	600	2.800	400	2.000	240	1.450	160	1.800	170	1.450	120
10,0	2.500	600	2.500	600	2.500	600	2.350	400	1.600	240	1.200	160	1.450	170	1.200	120
12,0	2.100	600	2.100	600	2.100	600	2.000	400	1.350	240	1.000	160	1.200	170	1.000	120
16,0	1.500	500	1.500	500	1.500	500	1.450	320	1.000	210	750	130	900	140	750	90
20,0	1.200	460	1.200	460	1.200	460	1.150	290	800	200	600	110	700	120	600	75
Groove finishing d_{oc}	1,5 D															
Groove finishing w_{oc}	~ 0,02 D															

● = Euro stock

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