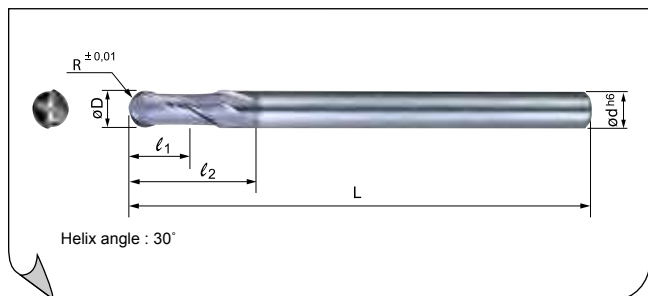


GS MILL Ball Endmills GLB 2000SF Type

Coated carbide grade: **ACZ20W**



Endmills

(mm)

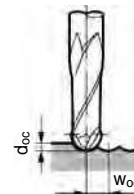
	Cat. No.	Stock	R	øD	ℓ ₁	ℓ ₂	L	ød
2	GLB 2010 SF	▲	0,5	1,0	1,5	2	50	4
	GLB 2015 SF	▲	0,75	1,5	2,5	3	50	4
	GLB 2020 SF	▲	1,0	2,0	3	4	60	6
	GLB 2025 SF	▲	1,25	2,5	4	5	60	6
	GLB 2030 SF	▲	1,5	3,0	4,5	6	60	6
	GLB 2040 SF	▲	2,0	4,0	6	8	70	6
	GLB 2050 SF	▲	2,5	5,0	7,5	10	80	6
	GLB 2060 SF	▲	3,0	6,0	9	-	80	6
	GLB 2080 SF	▲	4,0	8,0	12	-	90	8
	GLB 2100 SF	▲	5,0	10,0	15	-	100	10
	GLB 2120 SF	▲	6,0	12,0	21	-	110	12

Recommended cutting conditions

Conventional Milling Operations

Recommended :

- (1) Cutting performance is enhanced when using a high quality machine and rigid set up.
- (2) In case of chatter check immediately rigidity of set up and the cutting conditions.



GS Mill, 2 teeth ball nose type endmill, GLB 2000SF

Material Cutting data R (mm)	Carbon steel, Cast iron (HB150~250)		Alloy steel, Prehardened steel (HRC25~35)		Heat treated alloy steel, hardened steel (HRC35~45)		Hardened steel (HRC45~55)		Stainless steel		Heat resistant alloys Titanium alloy	
	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)
	R = 1	19.100	770	12.800	370	10.200	270	8.900	190	8.900	210	6.400
R = 2	10.800	1.100	7.200	550	5.700	400	5.000	280	5.000	310	3.600	180
R = 3	7.700	1.300	5.200	660	4.100	480	3.600	330	3.600	380	2.600	210
R = 4	6.000	1.400	4.000	700	3.200	510	2.800	360	2.800	400	2.000	230
R = 5	4.800	1.400	3.200	700	2.600	520	2.300	370	2.300	410	1.600	230
R = 6	4.000	1.400	2.700	710	2.200	530	1.900	370	1.900	410	1.400	240
Depth and width of cut	d _{oc} W _{oc}		0,1D 0,2D		0,05D 0,05D		0,1D 0,2D		0,05D 0,1D			

Coated
Endmills

HSC Machining Centre Operations

GS Mill, HSC operations with 2 teeth ball nose type endmill, GLB 2000SF

Material Cutting data R (mm)	Carbon steel, Cast iron (HB150~250)		Alloy steel, Prehardened steel (HRC25~35)		Heat treated alloy steel, hardened steel (HRC35~45)		Hardened steel (HRC45~55)		Stainless steel	
	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)	Speed (rpm)	Feed (mm/min)
	R = 1	51.000	2.100	39.800	1.300	35.700	960	23.700	640	35.700
R = 2	25.500	2.700	19.900	1.700	17.900	1.300	11.900	830	17.900	1.300
R = 3	17.000	3.000	13.300	1.900	11.900	1.400	7.900	920	11.900	1.400
R = 4	12.800	3.100	10.000	2.000	9.000	1.500	6.000	960	9.000	1.500
R = 5	10.200	3.100	8.000	2.000	7.200	1.500	4.800	960	7.200	1.500
R = 6	8.500	3.100	6.700	2.000	6.000	1.500	4.000	960	6.000	1.500
Depth and wide of cut	d _{oc} W _{oc}		0,05D 0,1D		0,02D 0,05D		0,05D 0,1D			

