



ENDMILLS

PLUNGE-MILL

For material P, M, K, N application (≤ 45 HRC)

Index - PLUNGE-MILL, For ≤ 45 HRC

 Suitable for Material Groups
  Adapté pour les matériaux
  适用于材料
 Geeignet für die Materialgruppen
  Adatto per il materiale

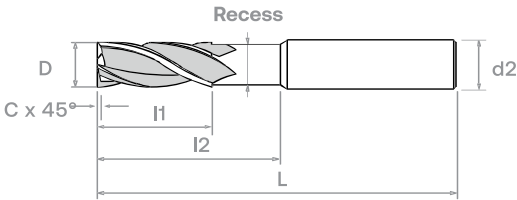
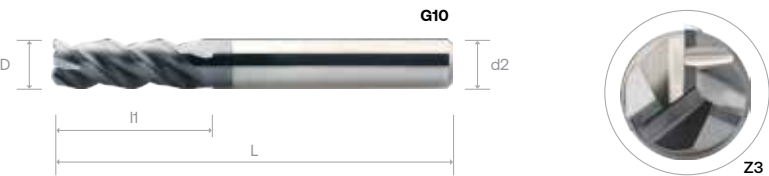
P
K

EDP Number	Type	No. Z	Helix Angle	Coating	Performance	Page Number
G10 	PLUNGE-MILL	4	45°	G610	G	349
G12 	PLUNGE-MILL, Recess	4	45°	G610	G	349

G - General P - Performance

PLUNGE-MILL, FOR PLUNGING + SLOTTING + MILLING / RECESS, 3 FLUTES

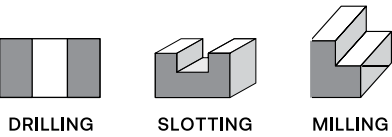
- VHM Schaftfräser, 3 Zähne, zum Bohren, Nuten- und Umfangsfräsen
- Frese per lavorazioni a tuffo, dal pieno e contornature, 3 taglienti
- Fraises Plongée, 3 dents, pour usinages en plongée, rainurage
- 整体硬质合金 Plunge-mill 系列.立铣刀3刃,适用于开槽.侧铣.插铣



Order Number	Dimension (mm)						G6110
	D	I1	I2	L	d2 (h6)	C	
G10 0100 050 04	1	1.5		50	4	0.1	•
G10 0150 050 04	1.5	2.3		50	4	0.1	•
G10 0200 050 04	2	3		50	4	0.1	•
G10 0250 050 04	2.5	3.8		50	4	0.1	•
G10 0300 050 06 *	3	6		50	6	0.2	•
G10 0400 050 06 *	4	8		50	6	0.2	•
G10 0500 050 06 *	5	10		50	6	0.25	•
G10 0600 050	6	13		50	6	0.25	•
G10 0800	8	20		64	8	0.3	•
G10 1000	10	22		75	10	0.3	•
G10 1200	12	25		75	12	0.3	•
G10 1600	16	32		90	16	0.3	•

Order Number	Dimension (mm)						G6110
	D	I1	I2	L	d2 (h6)	C	
G12 0100 050 04	1	1.5	5	50	4	0.1	◦
G12 0150 050 04	1.5	2.3	7.5	50	4	0.1	•
G12 0200 050 04	2	3	10	50	4	0.1	◦
G12 0250 050 04	2.5	3.8	12.5	50	4	0.1	◦
G12 0300 050 06	3	6	15	50	6	0.2	•
G12 0400 050 06	4	8	20	50	6	0.2	•
G12 0500 050 06	5	10	20	50	6	0.25	•
G12 0600 050	6	13	20	50	6	0.25	◦
G12 0800	8	20	30	64	8	0.3	◦
G12 1000	10	22	32	75	10	0.3	•
G12 1200	12	25	37	75	12	0.3	•
G12 1600	16	32	46	90	16	0.3	◦

* - DIN 6535



CNC Repeatability
Ø1 - Ø3 within 10µm
Ø4 - Ø8 within 15µm
≥ Ø10 within 20µm

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	350
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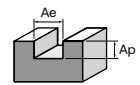
Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

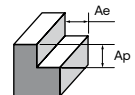


Plunge-Mill Endmills, 3 Flutes - G10, G12



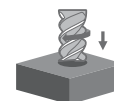
Slotting	K		P					
Working Material	Grey Cast Iron		Carbon steel		Alloy steel		Prehardened steel	
Properties	-		-		520 < Rm < 1200		35 ≤ HRC < 45	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		0.80 × D	
Cutting Width, ae	1.00 × D		1.00 × D		0.30 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	170	0.003	200	0.003	160	0.003	150	0.003
2		0.007		0.007		0.007		0.007
3		0.010		0.010		0.010		0.010
4		0.013		0.013		0.013		0.013
5		0.018		0.018		0.018		0.018
6		0.021		0.021		0.021		0.021
8		0.029		0.029		0.029		0.029
10		0.037		0.036		0.037		0.036
12		0.045		0.045		0.045		0.045
16		0.060		0.059		0.059		0.059

Plunge-Mill Endmills, 3 Flutes - G10, G12



Side Milling	K		P					
Working Material	Grey Cast Iron		Carbon steel		Alloy steel		Prehardened steel	
Properties	-		-		520 < Rm < 1200		35 ≤ HRC < 45	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.25 × D		0.25 × D		0.25 × D		0.18 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	250	0.008	280	0.006	230	0.007	190	0.006
2		0.011		0.010		0.010		0.010
3		0.018		0.019		0.015		0.015
4		0.024		0.025		0.022		0.021
5		0.032		0.033		0.028		0.026
6		0.040		0.040		0.034		0.034
8		0.054		0.054		0.047		0.046
10		0.069		0.068		0.062		0.062
12		0.082		0.082		0.077		0.077
16		0.094		0.103		0.096		0.088

Plunge-Mill Endmills, 3 Flutes - G10, G12



Plunging	K		P			
Working Material	Grey Cast Iron		Carbon steel		Alloy steel	
Properties	-		-		520 < Rm < 1200	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	-		-		-	
D	Vc	Fz	Vc	Fz	Vc	Fz
1	150	0.008	150	0.010	130	0.008
2		0.016		0.018		0.016
3		0.025		0.028		0.024
4		0.035		0.038		0.033
5		0.044		0.048		0.042
6		0.054		0.059		0.052
8		0.074		0.080		0.070
10		0.094		0.101		0.090
12		0.118		0.126		0.113
16		0.151		0.144		0.144