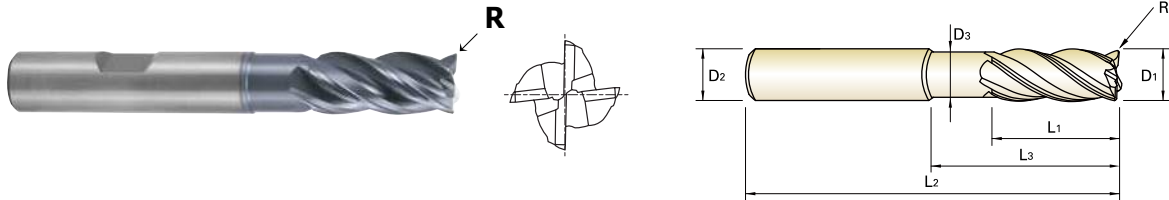


CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK

- VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM HALS
- CARBURE, 4 DENTS, DÉTALONNÉE, RAYONNÉE
- MD, 4 TAGLIENTI CON SCARICO ESTESO TORICA

▶ Special flute geometry and multiple helix eliminate vibrations
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 Low/Medium hardness materials under HRC40

▶ Die spezielle Schneidengeometrie und der ungleiche Drall verhindern Vibrationen
 ▶ Exzellente Leistung in Edelstählen, Baustählen, Guss und Stählen unter 40HRC



EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D1	D2	L1	L3	L2	D3
GMF62030	GMF63030	R0.3	3.0	6	7	12	54	2.7
GMF62901	GMF63901	R0.5	3.0	6	7	12	54	2.7
GMF62902	GMF63902	R0.3	3.0	6	7	17	57	2.7
GMF62903	GMF63903	R0.5	3.0	6	7	17	57	2.7
GMF62040	GMF63040	R0.3	4.0	6	8	15	57	3.7
GMF62904	GMF63904	R0.5	4.0	6	8	15	57	3.7
GMF62905	GMF63905	R0.3	4.0	6	8	22	63	3.7
GMF62906	GMF63906	R0.5	4.0	6	8	22	63	3.7
GMF62050	GMF63050	R0.3	5.0	6	10	17	57	4.7
GMF62907	GMF63907	R0.5	5.0	6	10	17	57	4.7
GMF62908	GMF63908	R0.3	5.0	6	10	27	67	4.7
GMF62909	GMF63909	R0.5	5.0	6	10	27	67	4.7
GMF62060	GMF63060	R0.3	6.0	6	10	15	57	5.5
GMF62910	GMF63910	R0.5	6.0	6	10	15	57	5.5
GMF62911	GMF63911	R1.0	6.0	6	10	15	57	5.5
GMF62912	GMF63912	R0.3	6.0	6	10	20	62	5.5
GMF62913	GMF63913	R0.5	6.0	6	10	20	62	5.5
GMF62914	GMF63914	R1.0	6.0	6	10	20	62	5.5
GMF62915	GMF63915	R0.3	6.0	6	10	32	74	5.5
GMF62916	GMF63916	R0.5	6.0	6	10	32	74	5.5
GMF62917	GMF63917	R1.0	6.0	6	10	32	74	5.5
GMF62080	GMF63080	R0.5	8.0	8	12	20	63	7.5
GMF62918	GMF63918	R1.0	8.0	8	12	20	63	7.5
GMF62919	GMF63919	R0.5	8.0	8	12	30	73	7.5

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
Up to Ø12	0 ~ - 0.02
Over Ø12	0 ~ - 0.03
h5	
* Shank Dia. ≥ Ø12 : h6	

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	42	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	130	230		
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

ISO Material Description	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron					
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100	200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



PLAIN SHANK

GMF62 SERIES

FLAT SHANK

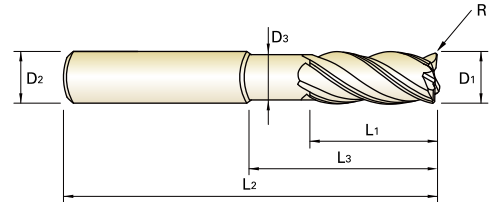
GMF63 SERIES

CARBIDE, 4 FLUTE CORNER RADIUS with EXTENDED NECK

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▶Exzellente Leistung in Edelmetallen, Baustählen, Guss und Stählen unter 40HRC



Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D1	D2	L1	L3	L2	D3
GMF62920	GMF63920	R1.0	8.0	8	12	30	73	7.5
GMF62921	GMF63921	R0.5	8.0	8	12	46	90	7.5
GMF62922	GMF63922	R1.0	8.0	8	12	46	90	7.5
GMF62100	GMF63100	R0.5	10.0	10	14	25	72	9.2
GMF62923	GMF63923	R1.0	10.0	10	14	25	72	9.2
GMF62924	GMF63924	R0.5	10.0	10	14	35	82	9.2
GMF62925	GMF63925	R1.0	10.0	10	14	35	82	9.2
GMF62926	GMF63926	R0.5	10.0	10	14	55	102	9.2
GMF62927	GMF63927	R1.0	10.0	10	14	55	102	9.2
GMF62120	GMF63120	R0.5	12.0	12	16	30	83	11.0
GMF62928	GMF63928	R1.0	12.0	12	16	30	83	11.0
GMF62929	GMF63929	R2.0	12.0	12	16	30	83	11.0
GMF62930	GMF63930	R0.5	12.0	12	16	40	93	11.0
GMF62931	GMF63931	R1.0	12.0	12	16	40	93	11.0
GMF62932	GMF63932	R2.0	12.0	12	16	40	93	11.0
GMF62933	GMF63933	R0.5	12.0	12	16	64	117	11.0
GMF62934	GMF63934	R1.0	12.0	12	16	64	117	11.0
GMF62935	GMF63935	R2.0	12.0	12	16	64	117	11.0
GMF62160	GMF63160	R1.0	16.0	16	22	38	92	15.0
GMF62936	GMF63936	R2.0	16.0	16	22	38	92	15.0
GMF62937	GMF63937	R3.0	16.0	16	22	38	92	15.0
GMF62938	GMF63938	R1.0	16.0	16	22	55	109	15.0
GMF62939	GMF63939	R2.0	16.0	16	22	55	109	15.0
GMF62940	GMF63940	R3.0	16.0	16	22	55	109	15.0

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
Up to Ø12	0 ~ - 0.02
Over Ø12	0 ~ - 0.03
h5	
* Shank Dia. ≥ Ø12 : h6	

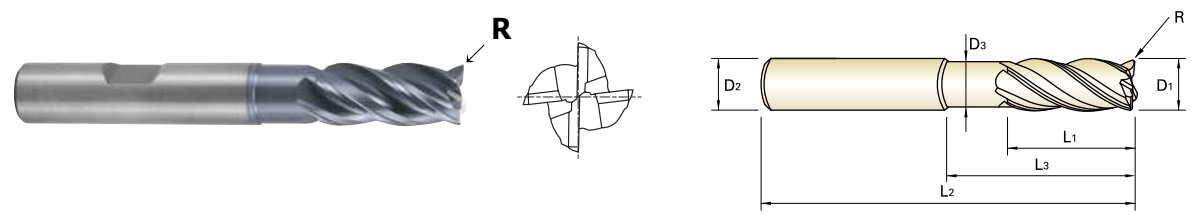
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◎ : Excellent ○ : Good

ISO Material Description	P											M				K					
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
ISO Material Description	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend											○	○	○	○	○	○	○				

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CARBIDE 4 35°/37° PLAIN FLAT P.459

Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D1	D2	L1	L3	L2	D3
GMF62941	GMF63941	R1.0	16.0	16	22	87	141	15.0
GMF62942	GMF63942	R2.0	16.0	16	22	87	141	15.0
GMF62943	GMF63943	R3.0	16.0	16	22	87	141	15.0
GMF62200	GMF63200	R1.0	20.0	20	26	50	104	19.0
GMF62944	GMF63944	R2.0	20.0	20	26	50	104	19.0
GMF62945	GMF63945	R3.0	20.0	20	26	50	104	19.0
GMF62946	GMF63946	R1.0	20.0	20	26	70	124	19.0
GMF62947	GMF63947	R2.0	20.0	20	26	70	124	19.0
GMF62948	GMF63948	R3.0	20.0	20	26	70	124	19.0
GMF62949	GMF63949	R1.0	20.0	20	26	110	164	19.0
GMF62950	GMF63950	R2.0	20.0	20	26	110	164	19.0
GMF62951	GMF63951	R3.0	20.0	20	26	110	164	19.0

Mill Dia. Tolerance (mm)		Shank Dia. Tolerance
Up to Ø12	0 ~ - 0.02	h5
Over Ø12	0 ~ - 0.03	* Shank Dia. ≥ Ø12 : h6

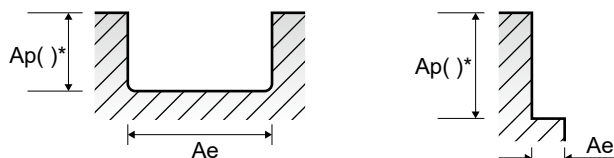
◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	10	29	32	38	35	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

ISO Material Description	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron					
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	15	30	25	38	34						15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend											○	○	○	○	○	○	○				

GMF52		GMF54		GMF56		GMF58		GMF60		GMF62		Vc = m/min. fz = mm/tooth RPM = rev./min. FEED = mm/min.	4 FLUTE - SIDE & SLOTTING													
GMF53		GMF55		GMF57		GMF59		GMF61		GMF63			Diameter (Ø)													
ISO	VDI 3323	Material Description		Ae		Ap		Parameter	3.0	4.0	5.0		6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0					
		Side	Slotting	Side	Slotting	Side	Slotting																			
P	1-4	Non-alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	152	152	152	152	152	168	168	168	168	168	168	168	168	168					
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064							
							RPM	16128	12096	9677	8064	6048	5348	4456	3820	3342	2971	2674	2139							
							FEED	323	387	426	516	653	813	838	749	709	701	695	548							
							Vc	107	107	107	107	107	117	117	117	117	117	117	117							
	5	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064							
							RPM	11353	8515	6812	5677	4257	3724	3104	2660	2328	2069	1862	1490							
							FEED	227	272	300	363	460	566	583	521	493	488	484	381							
							Vc	152	152	152	152	152	168	168	168	168	168	168	168							
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064							
	6-7	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	RPM	16128	12096	9677	8064	6048	5348	4456	3820	3342	2971	2674	2139							
							FEED	323	387	426	516	653	813	838	749	709	701	695	548							
							Vc	107	107	107	107	107	117	117	117	117	117	117	117							
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064							
							RPM	11353	8515	6812	5677	4257	3724	3104	2660	2328	2069	1862	1490							
	8-9	Low alloy steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	FEED	227	272	300	363	460	566	583	521	493	488	484	381							
							Vc	152	152	152	152	152	168	168	168	168	168	168	168							
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.049	0.053	0.059	0.065	0.064							
							RPM	11353	8515	6812	5677	4257	3724	3104	2660	2328	2069	1862	1490							
							FEED	227	272	300	363	460	566	583	521	493	488	484	381							
10-11.1	High alloyed steel, and tool steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	64	64	64	64	64	70	70	70	70	70	70	70	70							
						fz	0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.034	0.037	0.041	0.045	0.045								
						RPM	6791	5093	4074	3395	2546	2228	1857	1592	1393	1238	1114	891								
						FEED	81	122	130	149	194	241	238	216	206	203	201	160								
						Vc	148	148	148	148	148	148	148	148	148	148	148	148								
M	12-13	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	fz	0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.042	0.045	0.05	0.055	0.055							
							RPM	15703	11777	9422	7852	5889	4711	3926	3365	2944	2617	2355	1884							
							FEED	251	283	339	408	518	641	612	565	530	523	518	415							
	14.1	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	Vc	106	106	106	106	106	106	106	106	106	106	106	106							
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.059	0.062	0.07	0.077	0.077							
							RPM	11247	8435	6748	5623	4218	3374	2812	2410	2109	1874	1687	1350							
	14.2	Stainless steel	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	FEED	225	270	351	405	472	648	619	569	523	525	520	416							
							Vc	95	95	95	95	95	95	95	95	95	95	95	95							
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.059	0.062	0.069	0.076	0.076							
	15-20	Grey cast iron	0.5D	1.0D	1.5D (1.2D)	1.0D (0.8D)	RPM	10080	7560	6048	5040	3780	3024	2520	2160	1890	1680	1512	1210							
							FEED	202	242	314	363	423	581	554	510	469	464	460	368							
							Vc	112	112	112	112	112	123	123	123	123	123	123	123							
31-35	Heat Resistant Super Alloys	0.25D	1.0D	1.0D	0.5D	fz	0.005	0.007	0.008	0.012	0.019	0.033	0.038	0.04	0.043	0.048	0.054	0.052								
						RPM	2759	2069	1655	1379	1035	828	690	591	517	460	414	331								
						FEED	55	58	53	66	79	109	105	95	89	88	89	69								
36-37	Titanium Alloys	0.4D	1.0D	1.0D	0.5D	Vc	58	58	58	58	58	58	58	58	58	58	58	58	58							
						fz	0.004	0.007	0.011	0.016	0.025	0.042	0.05	0.053	0.055	0.062	0.068	0.069								
						RPM	6154	4615	3692	3077	2308	1846	1538	1319	1154	1026	923	738								
FEED	98	129	162	197	231	310	308	280	254	254	251	204														

*(): Short length & Neck type



SELECTION GUIDE

HSS

CBN

END MILLS

i-Xmill

END MILLS

i-SMART

MODULAR

END MILLS

X5070

END MILLS

4G MILL

END MILLS

X-POWER

PRO

END MILLS

TitaNox-

POWER

END MILLS

JET-POWER

END MILLS

V7 PLUS

END MILLS

ALU-POWER

HPC

END MILLS

ALU-

POWER

END MILLS

D-POWER

GRAPHITE

END MILLS

D-POWER

CFRP

END MILLS

ROUTERS

CRX S

END MILLS

K-2

END MILLS

ONLY ONE

COATED PM60

END MILLS

TANK-

POWER

END MILLS

GENERAL

HSS

END MILLS

MILLING

CUTTERS

TECHNICAL

DATA



SERIES	GMG55 GMG56	GMF54 GMF55	GMF58 GMF59
FLUTE	4	4	4
HELIX ANGLE	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)
CUTTING EDGE SHAPE	BALL NOSE	CORNER RADIUS	CORNER RADIUS
SIZE MIN	R1.5	D3.0	D3.0
SIZE MAX	R12.5	D20.0	D25.0
PAGE	442	443	444

SOLID CARBIDE V7 PLUS END MILLS

High performance carbide end mills for Steels, Cast Iron and Stainless Steels



Please visit globalyg1.com/mat for material search

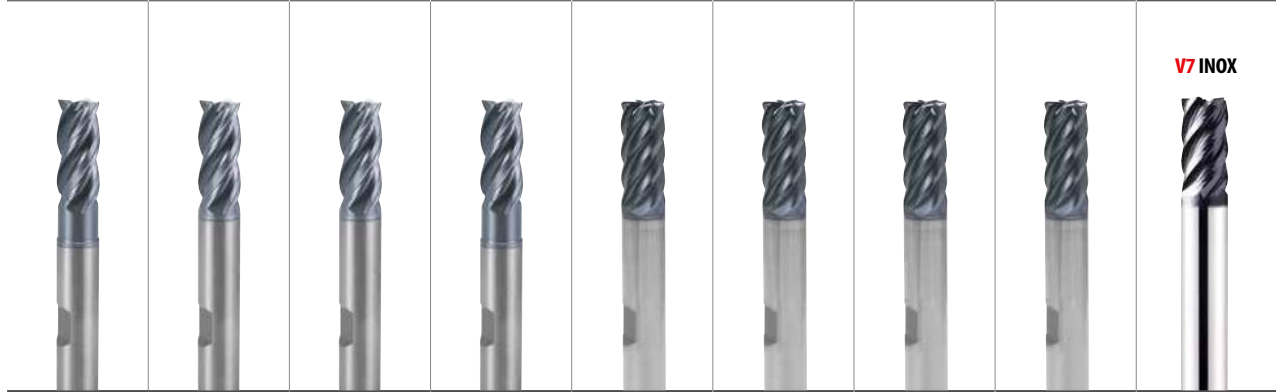
◎ : Excellent ○ : Good

Recommended cutting conditions : P 458

	LONG LENGTH	SHORT LENGTH	LONG LENGTH
	Y-Coating	Y-Coating	Y-Coating
P	◎	◎	◎
M	◎	◎	◎
K	◎	◎	◎
N			
S	○	○	○
H			

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc	
P	1	Non-alloy steel	About 0.15% C Annealed	125		
	2		About 0.45% C Annealed	190	13	
	3		About 0.45% C Quenched & Tempered	250	25	
	4		About 0.75% C Annealed	270	28	
	5		About 0.75% C Quenched & Tempered	300	32	
	6	Low alloy steel	Annealed	180	10	
	7		Quenched & Tempered	275	29	
	8		Quenched & Tempered	300	32	
	9		Quenched & Tempered	350	38	
	10		High alloyed steel, and tool steel	Annealed	200	15
	11			Quenched & Tempered	325	35
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15	
	13		Martensitic Quenched & Tempered	240	23	
	14		Austenitic	180	10	
K	15	Grey cast iron	Pearlitic / ferritic	180	10	
	16		Pearlitic (Martensitic)	260	26	
	17	Nodular cast iron	Ferritic	160	3	
	18		Pearlitic	250	25	
	19	Malleable cast iron	Ferritic	130		
	20		Pearlitic	230	21	
N	21	Aluminum-wrought alloy	Not Curable	60		
	22		Curable Hardened	100		
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		
	24		≤ 12% Si, Curable Hardened	90		
	25		> 12% Si, Not Curable	130		
	26		Cutting Alloys, PB>1%	110		
	27	Copper and Copper Alloys	CuZn, CuSnZn (Brass)	90		
	28		CuSn, lead-free copper and electrolytic copper	100		
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic			
	30		Rubber, Wood, etc.			
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15	
	32		Cured	280	30	
	33		Annealed	250	25	
	34		Ni or Co Based Cured	350	38	
	35		Cast	320	34	
	36	Titanium Alloys	Pure Titanium	400 Rm		
	37		Alpha + Beta Alloys Hardened	1050 Rm		
H	38	Hardened steel	Hardened	550	55	
	39		Hardened	630	60	
	40	Chilled Cast Iron	Cast	400	42	
	41	Hardened Cast Iron	Hardened	550	55	

GMF62 GMF63	GMF52 GMF53	GMF56 GMF57	GMF60 GMF61	GMG16 GMG17	GMG18 GMG19	GMG12 GMG13	GMG14 GMG15	EMB72 EMB73
4	4	4	4	6	6	6	6	5
35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	45°	45°	45°	45°	41°~45°
CORNER RADIUS	SQUARE	SQUARE	SQUARE	CORNER RADIUS	CORNER RADIUS	SQUARE	SQUARE	SQUARE
D3.0	D3.0	D3.0	D3.0	D6.0	D6.0	D6.0	D6.0	D6.0
D20.0	D20.0	D25.0	D20.0	D25.0	D25.0	D25.0	D25.0	D25.0
445	448	449	450	452	453	455	456	457
LONG LENGTH with NECK	SHORT LENGTH	LONG LENGTH	LONG LENGTH with NECK	LONG LENGTH	EXTRA LONG LENGTH	LONG LENGTH	EXTRA LONG LENGTH	LONG LENGTH
Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	AlTiN



⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	1
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⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	3
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	4
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	5
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	6 P
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	7
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⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	10
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	11
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	12
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	13 M
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⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	15
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	16
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⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	18
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	19
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HSS

CBN
END MILLS

i-Xmill
END MILLS

i-SMART
MODULAR
END MILLS

X5070
END MILLS

4G MILL
END MILLS

X-POWER
PRO
END MILLS

TitaNox-
POWER
END MILLS

JET-POWER
END MILLS

V7 PLUS
END MILLS

ALU-POWER
HPC
END MILLS

ALU-
POWER
END MILLS

D-POWER
GRAPHITE
END MILLS

D-POWER
CFRP
END MILLS

ROUTERS

CRX S
END MILLS

K-2
END MILLS

ONLY ONE
COATED PM60
END MILLS

TANK-
POWER
END MILLS

GENERAL
HSS
END MILLS

MILLING
CUTTERS

TECHNICAL
DATA