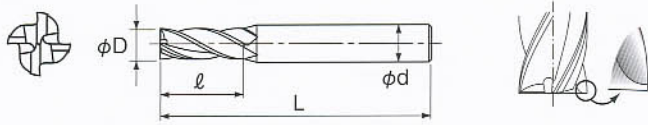


# GSX MILL 4枚刃

## GSX4C-1.5D

GSX MILL 4枚刃 1.5D Four Flutes 1.5D



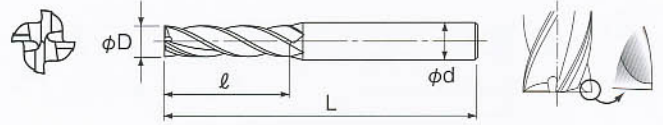
LIST9160 単位(Unit):mm/円

商品記号 CODE	外径 D	刃長 ℓ	全長 L	シャンク径 d	参考価格 Price
GSX40100C-1.5D	1	1.5	40	4	3,800
GSX40150C-1.5D	1.5	2.3	40	4	3,800
GSX40200C-1.5D	2	3	40	4	2,850
GSX40250C-1.5D	2.5	3.8	40	4	2,850
GSX40300C-1.5D	3	4.5	45	6	2,950
GSX40350C-1.5D	3.5	5.3	45	6	5,900
GSX40400C-1.5D	4	6	45	6	3,200
GSX40450C-1.5D	4.5	6.8	50	6	6,280
GSX40500C-1.5D	5	7.5	50	6	3,500
GSX40550C-1.5D	5.5	8.3	50	6	6,980
GSX40600C-1.5D	6	9	50	6	3,800
GSX40700C-1.5D	7	11	60	8	8,900
GSX40800C-1.5D	8	12	60	8	5,900
GSX40900C-1.5D	9	14	70	10	9,980
GSX41000C-1.5D	10	15	70	10	7,800
GSX41200C-1.5D	12	18	75	12	9,800
GSX41400C-1.5D	14	21	90	16	21,200
GSX41500C-1.5D	15	23	90	16	26,900
GSX41600C-1.5D	16	24	90	16	32,000
GSX42000C-1.5D	20	30	100	20	46,800

シャンク径許容差:h6 ねじれ角:30° 外径許容差は3Dと同じ。  
Tolerance of Shank Dia. Helix angle Tolerance of outer diameter is the same as 3D.

## GSX4C-3D

GSX MILL 4枚刃 3D Four Flutes 3D



LIST9162 単位(Unit):mm/円

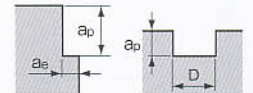
商品記号 CODE	外径 D	刃長 ℓ	全長 L	シャンク径 d	参考価格 Price
GSX40100C-3D	1	3	40	4	3,800
GSX40150C-3D	1.5	4.5	40	4	3,800
GSX40200C-3D	2	6	40	4	2,850
GSX40250C-3D	2.5	7.5	40	4	2,850
GSX40300C-3D	3	9	50	6	2,950
GSX40400C-3D	4	12	50	6	3,200
GSX40500C-3D	5	15	50	6	3,500
GSX40600C-3D	6	18	50	6	3,800
GSX40800C-3D	8	24	70	8	5,900
GSX41000C-3D	10	30	90	10	7,800
GSX41200C-3D	12	36	90	12	9,800
GSX41600C-3D	16	48	110	16	32,000
GSX42000C-3D	20	60	120	20	46,800

外径(mm) D		許容差(mm) Tolerance
を超え Above	以下 Up to	
3	3	0~-0.015
12	12	0~-0.02
		0~-0.03

シャンク径許容差:h6 ねじれ角:30°  
Tolerance of Shank Dia. Helix angle

### 基準切削条件 Standard Milling Condition

GSX MILL 4枚刃 1.5D GSX MILL Four Flutes 1.5D



被削材 Work Material	切削条件 Milling Conditions	構造用鋼 SS Structural Steels		炭素鋼 S-C, 鋳鉄 FC- Carbon Steels, Cast Irons (150~250HB)		合金鋼、プレハードン鋼 Alloy Steels, Pre-hardened Steels (25~35HRC)		調質鋼、焼入鋼 Hardened Steels (35~45HRC)		焼入鋼 Hardened Steels (45~55HRC)		ステンレス鋼 Stainless Steels (SUS304, 316)		耐熱合金、チタン合金 Nickel Alloys, Titanium Alloys		
		回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Rotation min <sup>-1</sup>	送り速度 Feed mm/min	
側面加工 Side Milling	切削条件 外径 φ	1	24,000	470	24,000	470	21,000	290	14,500	180	10,500	120	12,600	120	10,500	85
		2	12,800	570	12,800	570	12,000	380	8,300	230	6,000	150	7,200	160	6,000	110
		4	6,800	730	6,800	730	6,400	490	4,400	300	3,200	200	3,800	210	3,200	130
		6	4,600	780	4,600	780	4,300	520	3,000	320	2,200	210	2,650	220	2,200	150
		8	3,400	780	3,400	780	3,200	520	2,200	320	1,600	210	2,000	220	1,600	150
		10	2,800	780	2,800	780	2,600	520	1,800	320	1,300	210	1,600	220	1,300	150
		12	2,300	780	2,300	780	2,200	520	1,500	320	1,100	210	1,300	220	1,100	150
		16	1,700	650	1,700	650	1,600	420	1,100	280	800	170	1,000	180	800	120
		20	1,350	600	1,350	600	1,300	380	900	260	650	150	800	160	650	100
		切込み量 Depth of Cut	ap	1.5D				1D				1D				
	ae	0.05D				0.02D				0.02D						
溝加工 Grooving	1	24,000	380	24,000	470	21,000	290	14,500	180	10,500	120	12,600	85	5,200	30	
	2	12,800	460	12,800	570	12,000	380	8,300	230	6,000	150	7,200	110	3,000	40	
	4	6,800	580	6,800	730	6,400	490	4,400	300	3,200	200	3,800	130	1,600	55	
	6	4,600	620	4,600	780	4,300	520	3,000	320	2,200	210	2,650	160	1,100	65	
	8	3,400	620	3,400	780	3,200	520	2,200	320	1,600	210	2,000	160	800	65	
	10	2,800	620	2,800	780	2,600	520	1,800	320	1,300	210	1,600	160	650	65	
	12	2,300	620	2,300	780	2,200	520	1,500	320	1,100	210	1,300	160	550	65	
	16	1,700	520	1,700	650	1,600	420	1,100	280	800	170	1,000	130	400	55	
	20	1,350	480	1,350	600	1,300	380	900	260	650	150	800	110	320	50	
		切込み量 Depth of Cut	ap	0.2D		0.5D		0.2D		0.05D		0.2D				
高速条件 High-Speed Milling	側面加工 Side Milling	1	60,000	1,200	60,000	1,200	60,000	850	60,000	720	48,000	500	32,000	300		
		2	47,800	2,200	47,800	2,200	47,800	1,600	39,800	1,200	31,800	900	15,900	400		
		4	23,900	2,600	23,900	2,600	23,900	1,900	19,900	1,400	15,900	1,100	8,000	490		
		6	16,000	2,700	16,000	2,700	16,000	2,000	13,300	1,500	10,600	1,200	5,300	520		
		8	12,000	2,700	12,000	2,700	12,000	2,000	10,000	1,500	8,000	1,200	4,000	520		
		10	9,600	2,700	9,600	2,700	9,600	2,000	8,000	1,500	6,400	1,200	3,200	520		
		12	8,000	2,700	8,000	2,700	8,000	2,000	6,700	1,500	5,300	1,200	2,700	520		
		16	6,000	2,200	6,000	2,200	6,000	1,600	5,000	1,200	4,000	900	2,000	450		
		20	4,800	2,000	4,800	2,000	4,800	1,400	4,000	1,100	3,200	750	1,600	380		
		切込み量 Depth of Cut	ap	1.5D				1D				1D				
	ae	0.05D				0.02D				0.02D						

右ページ下の注意事項をお読みください。  
Please read the notice which is the right page.

側面加工(高速条件)  
ドライ加工(エアブロー)をおすすめします。ただし、ステンレス鋼には水溶性切削油剤をご使用ください。

Recommend dry milling (air blow). However, use the water-miscible cutting fluid for stainless steels.