

GSXB 20000 Type



2
Flutes

GSX
Coating

R

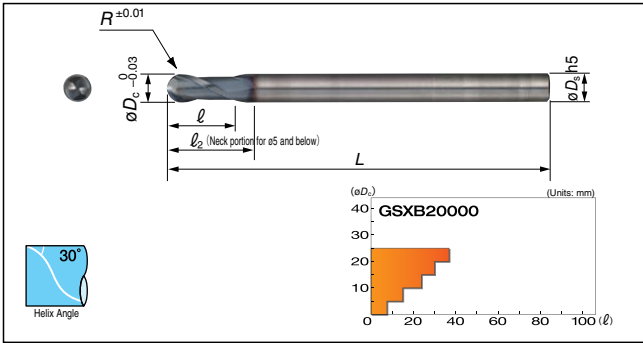
Side Milling

Face Milling

R

Profile Milling

Coated Carbide	Carbon Steel	Alloy Steel	Prehardened Steel	High Speed Steel	Hardened Steel				Stainless Steel	Ti Alloy	Cast Iron	Al Alloy	Copper Alloy	Graphite	CFRP
○	○	○	○	○	45 to 55 HRC	55 to 60 HRC	60 to 65 HRC	○	○	○	○	○	○	○	○



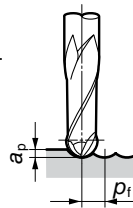
Body

Cat. No.	Stock	Dimensions (mm)					
		R	øD _c	ℓ	ℓ ₂	L	øD _s
GSXB 20020	●	0.20	0.4	0.6	0.8	50	4
20030	●	0.30	0.6	0.9	1.2	50	4
20050	●	0.50	1.0	1.5	2.0	50	4
20075	●	0.75	1.5	2.5	3.0	50	4
20100	●	1.00	2.0	3.0	4.0	60	6
GSXB 20125	●	1.25	2.5	4.0	5.0	60	6
20150	●	1.50	3.0	4.5	6.0	60	6
20200	●	2.00	4.0	6.0	8.0	70	6
20250	●	2.50	5.0	7.5	10.0	80	6
20300	●	3.00	6.0	9.0	—	80	6
GSXB 20350	●	3.50	7.0	11.0	20.0	90	8
20400	●	4.00	8.0	12.0	—	90	8
20500	●	5.00	10.0	15.0	—	100	10
20600	●	6.00	12.0	18.0	—	110	12
20700	●	7.00	14.0	21.0	38.0	110	16
GSXB 20800	●	8.00	16.0	24.0	—	140	16
20900	●	9.00	18.0	27.0	50.0	140	20
21000	●	10.00	20.0	30.0	—	160	20
21250	●	12.50	25.0	38.0	—	180	25

Grade: ACB20

Recommended Cutting Conditions

1. If cutting noise and vibration are present, please change the cutting conditions accordingly.
2. If the machine is not designed to achieve the recommended spindle speed, please use the max. spindle speed available.



Radius Milling

Work Material	Carbon Steel, Alloy Steel (Below 25HRC)		Carbon Steel, Alloy Steel (Below 50HRC)		Cast Iron Special Cast Iron		Stainless Steel Titanium Alloy		
	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	
Ballnose	50,000	2,100	35,000	1,150	50,000	2,100	50,000	1,750	
DLC	0.30	50,000	2,500	35,000	1,350	50,000	2,500	50,000	
	0.50	50,000	3,000	35,000	1,600	50,000	3,000	50,000	
SUMIDIA Coat	0.75	35,000	3,000	24,000	1,650	35,000	3,200	34,000	
	1.00	27,500	3,000	19,000	1,700	35,000	3,900	26,000	
Long Neck	1.25	22,500	3,000	15,500	1,700	28,000	3,900	21,000	
	1.50	19,000	3,000	13,000	1,700	24,000	3,900	17,500	
Uncoated	2.00	17,000	3,800	12,000	2,100	20,000	4,100	15,000	
	2.50	15,500	4,300	11,000	2,200	18,000	4,600	12,000	
CBN PCD	3.00	14,000	4,700	10,500	2,500	16,500	5,300	10,500	
	3.50	12,500	4,200	9,000	2,100	14,000	4,500	9,000	
	4.00	11,000	3,500	7,900	1,900	12,500	4,000	7,800	
	5.00	9,000	2,800	6,300	1,500	10,500	3,300	6,300	
	6.00	7,500	2,400	5,200	1,250	8,700	2,800	5,200	
	7.00	6,400	2,100	4,500	1,100	7,400	2,400	4,500	
	8.00	5,600	1,800	3,900	950	6,500	2,100	3,900	
	9.00	5,000	1,600	3,500	850	5,800	1,900	3,500	
	10.00	4,500	1,450	3,100	750	5,200	1,700	3,150	
	12.50	3,600	1,150	2,500	600	4,200	1,350	2,500	
Standard Depth-of-cut	a_p	0.02D _c		0.02D _c		0.02D _c		0.02D _c	
	p_f	0.05D _c		0.05D _c		0.05D _c		0.05D _c	