MOLDINO
The Edge To Innovation

Special Shape Tool Series for High Efficiency Finishing.

GALLEA

GALLEA series

Added corner-connected R insert for GP1LB that is easy to use for 3-axis machining.

MOLDINO Tool Engineering, Ltd.

New Product News | No. H2007A-1 | 2020-10

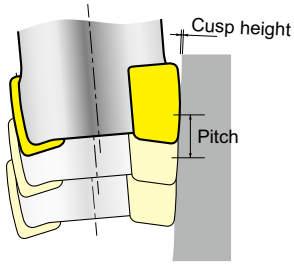
GALLEA Series

Combination of
lens tool and barrel tool

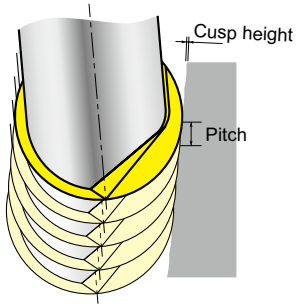
Concept of GALLEA series

Comparison of barrel tool and ball-radius end mill

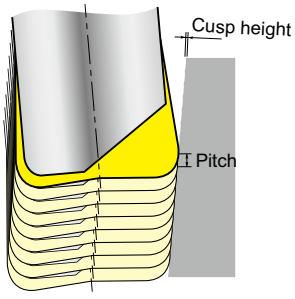
Barrel tool
Tool dia. 20mm Peripheral flute R30



Ball end mill
Tool dia. 20mm R10



Corner radius end mill
Tool dia. 20mm Corner radius R3

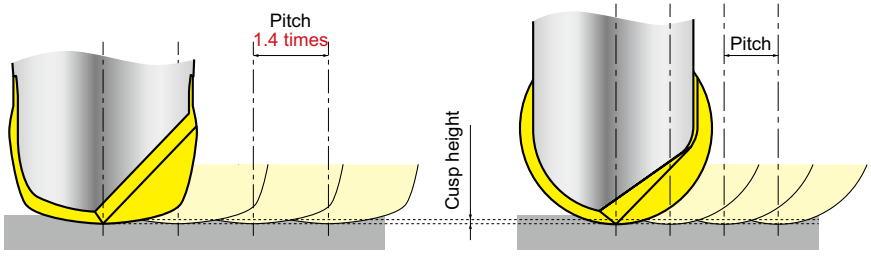


When contour milling with the same theoretical cusp height, the barrel tool can be machined with a pitch of about 1.7 times compared with the ball end mill of the same diameter, and about 3 times as compared with the R3 radius end mill.

Comparison of lens tool and ball end mill

Lens tool
Tool dia. 30mm Lens R 30

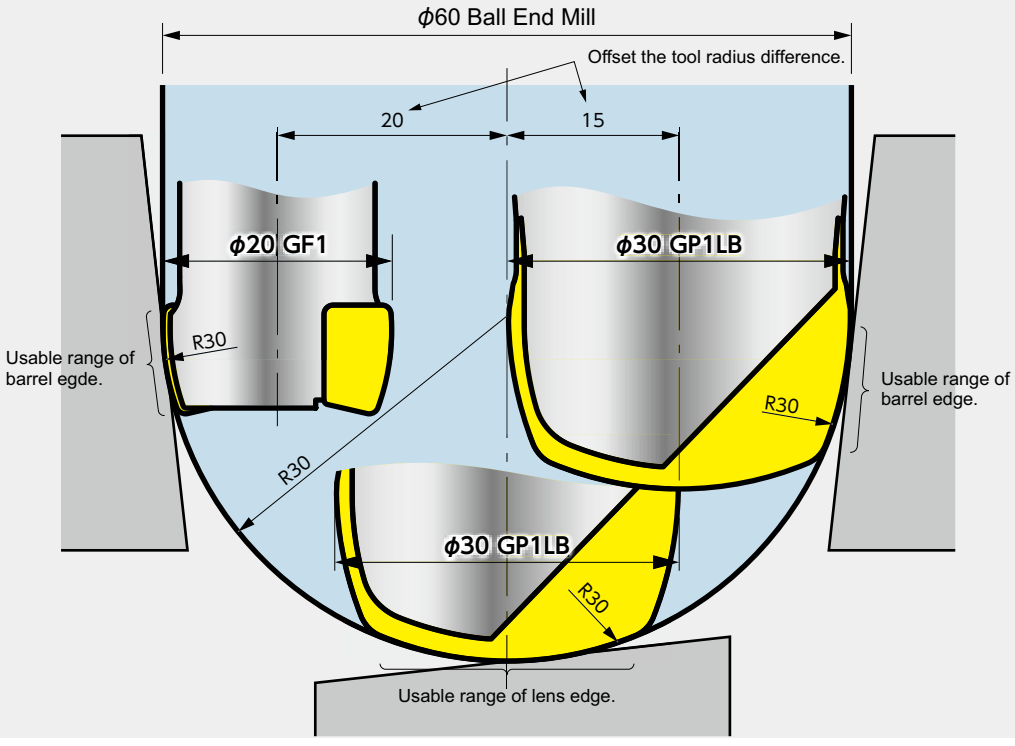
Ball end mill
Tool dia. 30mm R15



Can be machined with pitch of about 1.4 times compared with the ball end mill of same diameter.

Because of the ability to increase the pitch, machining time can be reduced without needing to modify speeds and feeds.

The same R size GALLEA series as ϕ60 ball end mill.



How can finishing time be reduced? **Large pitch! Small cusp!**

Conventional pitch and cusp height

Pitch of GALLEA series

Possible to reduce the polishing time in case of same pitch condition

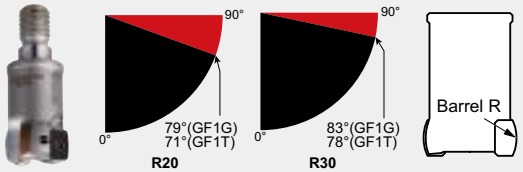
List of GALLEA series

Red In 3-axis machining usable range of Barrel edge

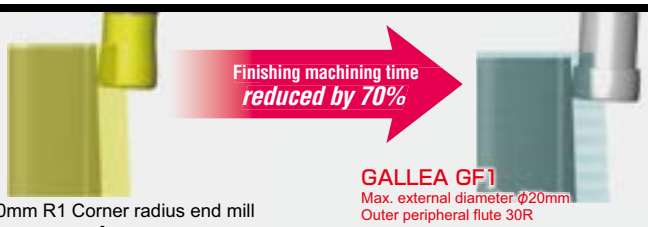
Blue In 3-axis machining usable range of Lens edge / Tip edge

Green In 3-axis machining usable range of corner-connected R

GF1 Barrel P.6



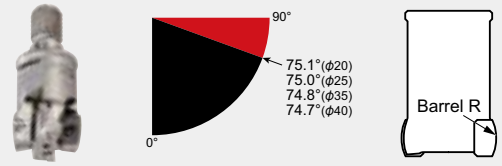
For tilted wall finishing



φ20mm R1 Corner radius end mill
【Cutting conditions】
v_f=2000mm/min n=4500min^{-1} a_p=0.2mm
Machining time simulation = Approx. 150 min.

GALLEA GF1
Max. external diameter φ20mm
Outer peripheral flute 30R
【Cutting conditions】
v_f=2000mm/min n=4500min^{-1} a_p=0.6mm
Cutting time = Approx. 40min.

GF2T Barrel P.8



For tilted wall finishing

High-performance tilted wall finishing!

Enables machining at a larger pitch than ball end mills or radius end mills.

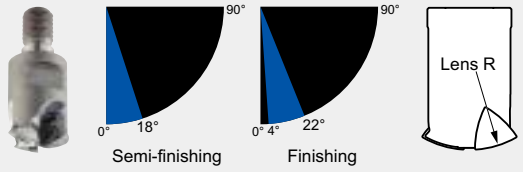
Series expansion toward larger diameters

φ20 φ25 φ35 φ40

Economical 2-corner specification

Unique insert holding surface enables realization of 2-corner specification.

GF3L Lens P.10



For gentle curved surfaces and gentle sloped surfaces

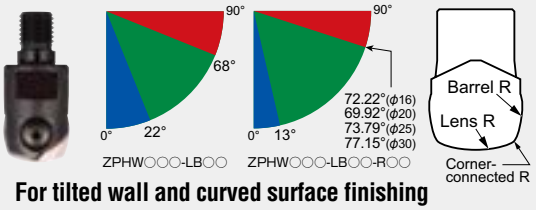
01 Using GALLEA series increases efficiency in both semi-finish and finish process.

02 Good sharp positive design.

03 High efficiency cutting tool with three edge specification

04 Unique insert retaining surface insures strong insert clamping.

GP1LB Barrel, Lens P.12

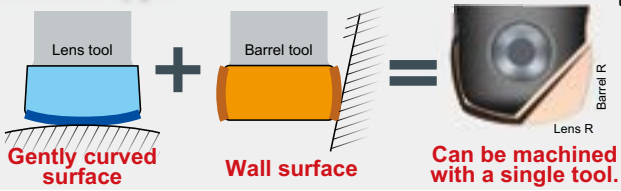


For tilted wall and curved surface finishing

Combination of lens tool and barrel tool.

Precision type

GP1LB type

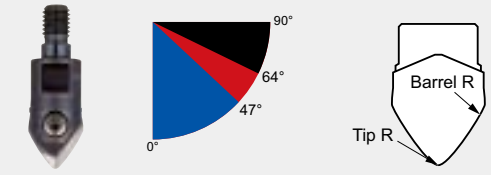


Gently curved surface

Wall surface

Can be machined with a single tool.

GP1T Taper Barrel P.14



For tilted wall, curved surface and corner finishing

Two types of processes are possible with one tool when using a 5-axis machine.

Since it can work for 2 types of machining processes, the machining surface steps can be minimized.

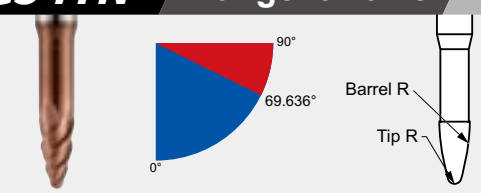
Barrel R

This tool can take a larger pitch with a barrel R which larger than the tool radius.

Tip R

The tip can be used as a ball end mill for corner processing.

GS4TN Tangent Barrel P.18



For tilted wall, curved surface and corner finishing

- Barrel R achieves high-efficiency and high-quality machining for a tilted area on part.
- Tip R can finish curved connecting faces to a high surface quality.
- Employs unique high helix shape that reduces the cutting forces.

Overview of GALLEA series

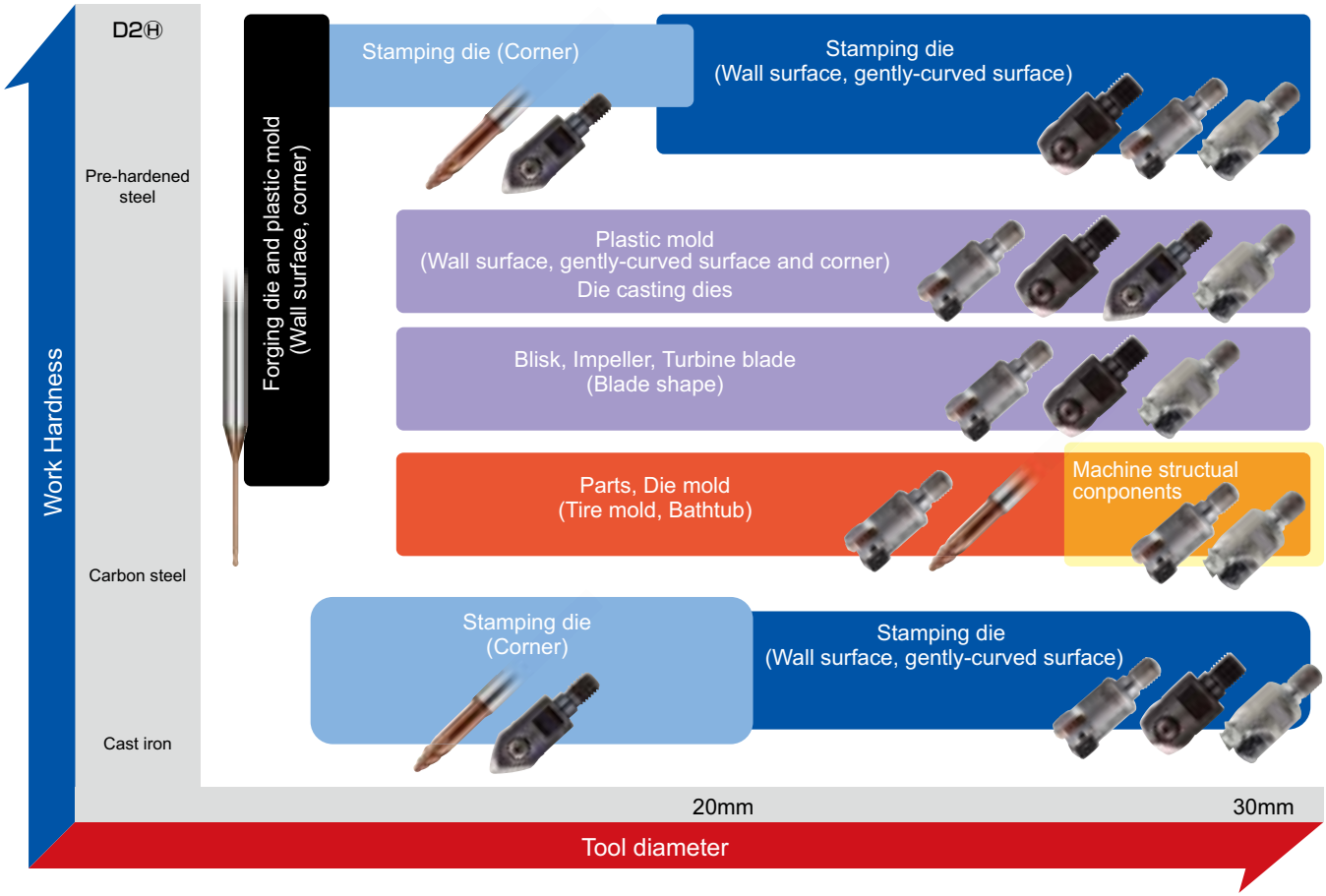


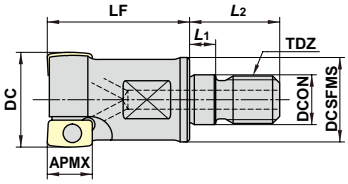
Chart of tool dia. and barrel for GALLEA series

Barrel R (mm) \ Tool dia. (mm)	2.5	3.75	5.0	7.5	10.0	12.0	16.0	20.0	25.0	30.0	35.0	40.0
12.5	GS4TN											
16.0							GP1LB					
18.75		GS4TN										
19.91									GF1T			
19.93									GF1G			
20.0								GF1T/GF1G GP1LB				
20.14							GF1G					
20.18							GF1T					
25.0			GS4TN						GP1LB			
29.78												GF2T
29.81									GF1T			
29.82									GF1G			
29.84											GF2T	
30.0						GP1T		GF1T/GF1G	GF2T	GP1LB		
30.24								GF2T				
30.33							GF1T					
30.38							GF1G					
37.5				GS4TN								
40.0							GP1T					
50.0					GS4TN			GP1T				
62.5									GP1T			
75.0										GP1T		

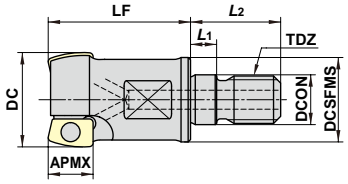
Modular type

GF1□20○○M-○-M○○

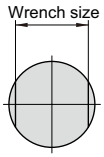
Numeric figure in a circle ○ and Alphabetical character comes in a square □



Basic type



Offset type



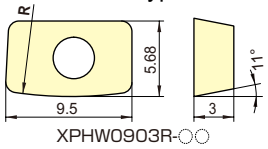
Type	Order No.	Stock	No.of flutes	Size (mm)									Insert
				DC	LF	APMX	DCON	TDZ	DCSFMS	L1	L2	Wrench size	
Basic type	GF1G2016M-2-M8	●	2	16	25	9.5	8.5	M8	14	5.5	17	10	XPHW0903R-20 XPHW0903R-30
	GF1G2020M-3-M10	●	3	20	30	9.5	10.5	M10	17.8	5.5	19	15	
	GF1G2025M-4-M10	★	4	25	30	9.5	10.5	M10	17.8	5.5	19	15	
	GF1G2025M-4-M12	●	4	25	35	9.5	12.5	M12	22.5	5.5	22	17	
Offset type	GF1T2016M-2-M8	●	2	16	25	9.5	8.5	M8	14	5.5	17	10	YPHW0903R-20 YPHW0903R-30
	GF1T2020M-3-M10	●	3	20	30	9.5	10.5	M10	17.8	5.5	19	15	
	GF1T2025M-4-M12	●	4	25	35	9.5	12.5	M12	22.5	5.5	22	17	

【Note】Do not apply lubricants such as grease, etc. to the “contact faces” and “modular screws” of the “modular mill”, “special shanks” and “special arbor”.

※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

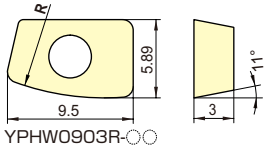
Inserts

Basic type



XPHW0903R-○○

Offset type



YPHW0903R-○○

P	Carbon Steel, Alloy Steel	■	⊔
M	Stainless Steel, etc.	■	
K	Cast Iron・Ductile Cast Iron	⊔	■
H	Hardened Steel		■

■ : General cutting, First recommended
⊔ : General cutting, Second recommended

Type	Order No.	PN215	TH315	Size (mm) R
Basic type	XPHW0903R-20	●	●	20
	XPHW0903R-30	●	●	30
Offset type	YPHW0903R-20	●	●	20
	YPHW0903R-30	●	●	30

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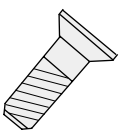
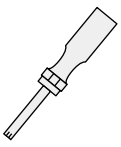
Parts

To reduce environmental loads, drivers and screw anti-seizure agent are sold separately.
We ask for your understanding and cooperation.

Shape / Cutter body	Clamp screw	Fastening torque (N·m)	Not included with product (sold separately) Screw driver	Screw anti-seizure agent
				
GF1□20○○M-○-M○○	250-141	1.1	104-T8	P-37

● : Inventory maintained in US ★ : Inventory maintained in Japan

Recommended cutting conditions

※Red indicates primary recommended grade.

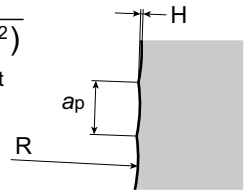
Work material	Recommended grade	Cutting condition	φ16	φ20	φ25
Carbon Steel Alloy Steel (<30HRC)	※ PN215	n (min-1)	11,950	9,560	7,650
		vc (m/min)	600	600	600
		vf (mm/min)	4,780	5,740	6,120
		fz (mm/t)	0.2	0.2	0.2
		ap (mm)	Refer right table		
		ae (mm)	~0.1	~0.1	~0.1
Carbon Steel Alloy Steel (30~45HRC)	PN215 TH315	n (min-1)	7,970	6,370	5,100
		vc (m/min)	400	400	400
		vf (mm/min)	3,190	3,830	4,080
		fz (mm/t)	0.2	0.2	0.2
		ap (mm)	Refer right table		
		ae (mm)	~0.1	~0.1	~0.1
Stainless Steel SUS	PN215	n (min-1)	9,960	7,970	6,370
		vc (m/min)	500	500	500
		vf (mm/min)	3,990	4,790	5,100
		fz (mm/t)	0.2	0.2	0.2
		ap (mm)	Refer right table		
		ae (mm)	~0.1	~0.1	~0.1
Cast Iron Ductile Cast Iron	TH315 PN215	n (min-1)	11,950	9,560	7,650
		vc (m/min)	600	600	600
		vf (mm/min)	5,980	7,170	7,650
		fz (mm/t)	0.25	0.25	0.25
		ap (mm)	Refer right table		
		ae (mm)	~0.1	~0.1	~0.1
Hardened Steel (45~55HRC)	TH315 PN215	n (min-1)	4,980	3,990	3,190
		vc (m/min)	250	250	250
		vf (mm/min)	1,500	1,800	1,920
		fz (mm/t)	0.15	0.15	0.15
		ap (mm)	Refer right table		
		ae (mm)	~0.08	~0.08	~0.08

Determine the a_p value based on the desired cusp height by selecting it from the table below or by calculating it using the equation below.

Insert		Cusp height (mm)					
Order No.	R	0.001	0.002	0.003	0.004	0.005	0.01
XPHW0903R-20	20	0.4	0.57	0.69	0.8	0.89	1.26
XPHW0903R-30	30	0.49	0.69	0.85	0.98	1.1	1.55

$$a_p = 2\sqrt{(R^2-(R-H)^2)}$$

R : Tool R H : Cusp height



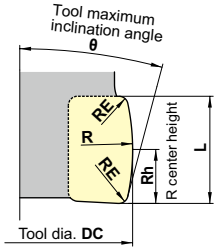
※When overhang length is 3*D*c or greater, adjust the values shown in the table at left according to the table below.

Overhang ratio	vc (m/min)	vf (mm/min)
<3DC	100%	100%
3DC ~ 5DC	70%	70%
5DC ~ 6DC	60%	60%
6DC ~ 7DC	50%	50%
7DC ~	45%	45%

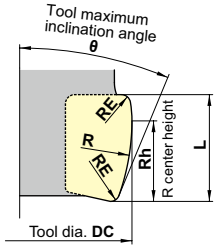
【Note】

①Use the appropriate coolant for the work material and machining shape.
②These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
③To prevent tool breakage due to chips clogging tool flutes, always be sure to use an air blower, etc. to remove chips.
④Ensure to index the insert at the correct time to ensure safety of the tool-body.

Flute tip shape definitions for programing



Basic type



Offset type

Rotation locus shape will be different depending on the combination of insert and tool diameter. Refer to the table below.

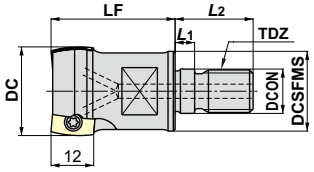
	Basic type						Offset type					
Insert Order No.	XPHW0903R-20			XPHW0903R-30			YPHW0903R-20			YPHW0903R-30		
Tool dia. DC (mm)	φ16	φ20	φ25	φ16	φ20	φ25	φ16	φ20	φ25	φ16	φ20	φ25
R (mm)	20.14	20	19.93	30.38	30	29.82	20.18	20	19.91	30.33	30	29.81
Rh (mm)	4.75	4.75	4.75	4.75	4.75	4.75	7.25	7.25	7.25	7.25	7.25	7.25
RE (mm)	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
L (mm)	9.5	9.5	9.5	9.5	9.5	9.5	9.5	9.5	9.5	9.5	9.5	9.5
θ	11°	11°	11°	7°	7°	7°	19°	19°	19°	12°	12°	12°

【Note】 The numbers after the third decimal point are rounded off. When defining the shape parametrically, check the required dimensions from the DXF data.

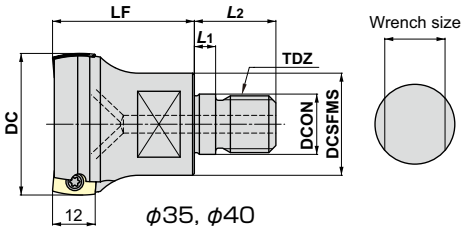
Modular type

GF2T30○○M-○

Numeric figure in a circle ○ and Alphabetical character comes in a square□



ϕ20, ϕ25



ϕ35, ϕ40

Type	Order No.	Stock	No. of flutes	Size (mm) DC	LF	DCON	TDZ	DCSFMS	L1	L2	Wrench size	Insert
Offset type	GF2T3020M-3	★	3	20	30	10.5	M10	17.8	5.5	19	15	YPHW1203R-30
	GF2T3025M-4	★	4	25	35	12.5	M12	22.5	5.5	22	17	
	GF2T3035M-5	★	5	35	40	17	M16	28.8	6	23	22	
	GF2T3040M-6	★	6	40	40	17	M16	28.8	6	23	22	

【Note】Do not apply lubricants such as grease, etc. to the “contact faces” and “modular screws” of the “modular mill”, “special shanks” and “special arbor”.

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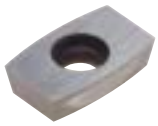
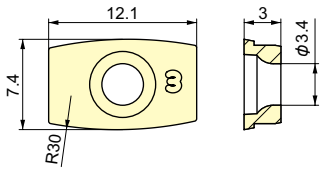
Inserts





		Order No.	Tolerance class	Grade PN215	Grade TH315
P	Carbon Steel, Alloy Steel	YPHW1203R-30	H	★	★
M	Stainless Steel, etc.				
K	Cast Iron・Ductile Cast Iron				
H	Hardened Steel				

■ : General cutting, First recommended

□ : General cutting, Second recommended

Parts

To reduce environmental loads, drivers and screw anti-seizure agent are sold separately.
We ask for your understanding and cooperation.

Shape / Cutter body	Clamp screw	Fastening torque (N·m)	Not included with product (sold separately) Screw driver	Screw anti-seizure agent
GF2T30○○M-○	265-143	2.0	104-T10	P-37

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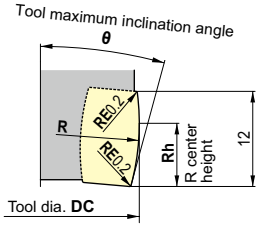
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

Flute tip shape definitions for programing



Offset type

★ : Inventory maintained in Japan

Rotation locus shape will be different depending on the combination of insert and tool diameter.
Refer to the table below.

Insert Order No.	Offset type YPHW1203-R30			
Tool dia. **DC** (mm)	**ϕ20**	**ϕ25**	**ϕ35**	**ϕ40**
R (mm)	30.24	30	29.84	29.78
Rh (mm)	7.92	8	8	8
θ	14.9°	15°	15.2°	15.3°

【Note】The numbers after the third decimal point are rounded off. When defining the shape parametrically, check the required dimensions from the DXF data.

Recommended cutting conditions

※Red indicates primary recommended grade.

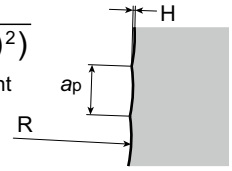
Work material	Recommended grade	Cutting conditions	φ20	φ25	φ35	φ40
Carbon Steel Alloy Steel (<30HRC)	PN215	n (min-1)	9,560	7,650	5,460	4,780
		vc (m/min)	600	600	600	600
		vf (mm/min)	5,740	6,120	5,460	5,740
		fz (mm/t)	0.2	0.2	0.2	0.2
		ap (mm)	Refer to the table at right.			
		ae (mm)	<0.1	<0.1	<0.1	<0.1
Carbon Steel Alloy Steel (30~45HRC)	PN215 TH315	n (min-1)	6,370	5,100	3,640	3,190
		vc (m/min)	400	400	400	400
		vf (mm/min)	3,830	4,080	3,640	3,830
		fz (mm/t)	0.2	0.2	0.2	0.2
		ap (mm)	Refer to the table at right.			
		ae (mm)	<0.1	<0.1	<0.1	<0.1
Stainless Steel	PN215	n (min-1)	7,970	6,370	4,550	3,990
		vc (m/min)	500	500	500	500
		vf (mm/min)	4,790	5,100	4,550	4,790
		fz (mm/t)	0.2	0.2	0.2	0.2
		ap (mm)	Refer to the table at right.			
		ae (mm)	<0.1	<0.1	<0.1	<0.1
Cast Iron Ductile Cast Iron	TH315 PN215	n (min-1)	9,560	7,650	5,460	4,780
		vc (m/min)	600	600	600	600
		vf (mm/min)	7,170	7,650	6,830	7,170
		fz (mm/t)	0.25	0.25	0.25	0.25
		ap (mm)	Refer to the table at right.			
		ae (mm)	<0.1	<0.1	<0.1	<0.1
Hardened Steel (45~55HRC)	TH315 PN215	n (min-1)	3,990	3,190	2,280	2,000
		vc (m/min)	250	250	250	250
		vf (mm/min)	1,800	1,920	1,710	1,800
		fz (mm/t)	0.15	0.15	0.15	0.15
		ap (mm)	Refer to the table at right.			
		ae (mm)	<0.08	<0.08	<0.08	<0.08

Determine the *ap* value based on the desired cusp height by selecting it from the table below or by calculating it using the equation below.

Insert		Cusp height (mm)					
Order No.	R	0.001	0.002	0.003	0.004	0.005	0.01
YPHW1203R-30	30	0.49	0.69	0.85	0.98	1.1	1.55

$$ap = 2\sqrt{(R^2-(R-H)^2)}$$

R : Tool R H : Cusp height



※When overhang length is 3*D*c or greater, adjust the values shown in the table at left according to the table below.

Overhang ratio	vc (m/min)	vf (mm/min)
<3Dc	100%	100%
3Dc ~ 5Dc	70%	70%
5Dc ~ 6Dc	60%	60%
6Dc ~ 7Dc	50%	50%
7Dc ~	45%	45%

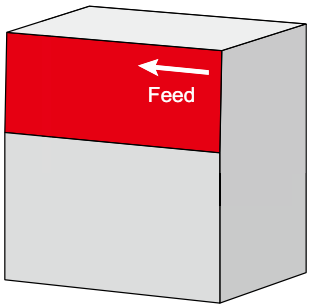
【Note】

①Use the appropriate coolant for the work material and machining shape.
②These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
③To prevent tool breakage due to chips clogging tool flutes, always be sure to use an air blower, etc. to remove chips.
④Ensure to index the insert at the correct time to ensure safety of the tool-body.

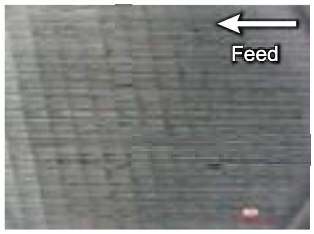
Field Data

Cutting of a 1°incline face

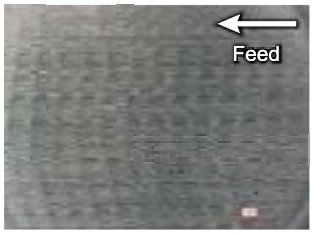
Work material：P21



Achieves same surface roughness at 3 times the pitch of conventional tools.



Conventional radius mill
Ra0.54μm
ap=0.2mm



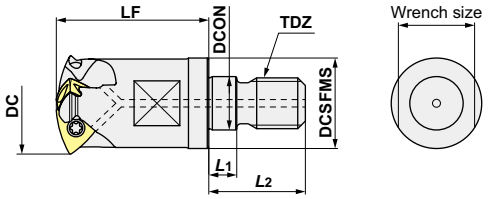
GF2T3040M-6
Ra0.54μm
ap=0.6mm

Tool	Overhang length (mm)	Tool dia. (mm)	Cutting speed (m/min)	Revolution (min-1)	Feed per tooth (mm/t)	Feed rate (mm/min)	ap (mm)	ae (mm)	Coolant
GF2T3040M-6 YPHW1203R-30 PN215	245	40	160	1,273	0.1	765	0.6	0.1	Air blow
Conventional R2 radius mill							0.2		

Modular type

GF3L○○M-3-M○○

Numeric figure in a circle ○

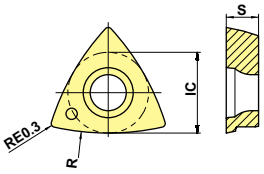


Order No.	Stock	No. of Inserts	Size (mm)								Insert
			DC	LF	DCON	TDZ	DCSFMS	L_1	L_2	Wrench size	
GF3L20M-3-M10	★	3	20	30	10.5	M10	17.8	5.5	19	15	TPHW0902-20
GF3L25M-3-M12	★	3	25	35	12.5	M12	22.5	5.5	22	17	TPHW1303-25
GF3L30M-3-M16	★	3	30	40	17	M16	28.8	6	23	22	TPHW1403-30

【Note】 Do not apply lubricants such as grease, etc. to the “contact faces” and “modular screws” of the “modular mill”, “special shanks” and “special arbor”.

※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

Inserts



P	Carbon Steel, Alloy Steel	■	□
M	Stainless Steel, etc.	■	
K	Cast Iron・Ductile Cast Iron	□	■
H	Hardened Steel		■

■ : General cutting, First recommended
□ : General cutting, Second recommended

Order No.	Tolerance class	Grade		Size(mm)		
		PN215	TH315	IC	S	R
TPHW0902-20	H	★	★	6.5	2.6	20
TPHW1303-25		★	★	8.2	3.0	25
TPHW1403-30		★	★	9.8	3.2	30

※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

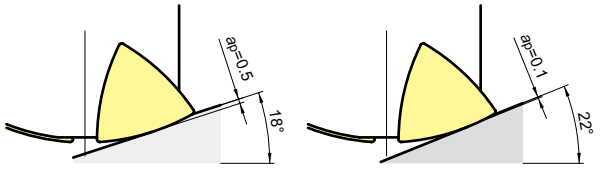
Parts

To reduce environmental loads, drivers and screw anti-seizure agent are sold separately.
We ask for your understanding and cooperation.

Parts / Shape / Cutter body	Clamp screw	Fastening torque (N·m)	Not included with product (sold separately) Wrench	Screw anti-seizure agent
				
GF3L20M-3-M10	251-141	1.1	104-T8	P-37
GF3L25M-3-M12	265-143	2.0	104-T10	
GF3L30M-3-M16	412-141	2.9	104-T15	

Usable range of cutting edge for GF3L type

Semi-finishing | Finishing

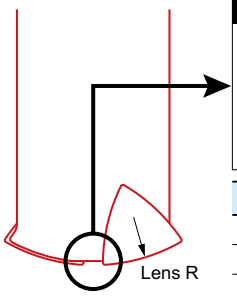


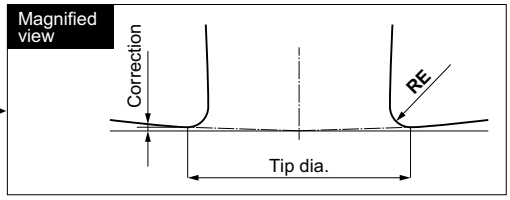
	a_p max finishing allowance	Available cutting range
Semi-finishing	0.5mm	18°
Finishing	0.1mm	22°

Because of GF3L type does not have a peripheral cutting edge, cutting range changes according to cutting depth (a_p).

Correction of tool length measurement value

GF3L type does not have a cutting edge in the tool center.
When creating a toolpath with the lens tool shape, correct the tool length value. If using a CAM that can utilize the exact shape, then no length correction is needed.





	Correction (mm)	Tip dia.(mm)
GF3L20M-3-M10	0.058	3.0
GF3L25M-3-M12	0.056	3.3
GF3L30M-3-M16	0.062	3.9

★ : Inventory maintained in Japan

Recommended cutting conditions

※Red indicates primary recommended grade.

Work material	Recommended grade	Cutting condition	Finishing			Semi-finishing		
			ϕ20	ϕ25	ϕ30	ϕ20	ϕ25	ϕ30
Carbon Steel Alloy Steel (<30HRC)	PN215	*n* (min^{-1})	11,470	9,180	7,650	4,780	3,830	3,190
		vc (m/min)	720	720	720	300	300	300
		vf (mm/min)	6,890	5,510	4,590	7,170	5,750	4,790
		fz (mm/t)	0.2	0.2	0.2	0.5	0.5	0.5
		ap (mm)	0.1	0.1	0.1	0.5	0.5	0.5
		ae (mm)	Refer below table			Refer below table		
Carbon Steel Alloy Steel (30~45HRC)	PN215 TH315	*n* (min^{-1})	8,290	6,630	5,530	3,190	2,550	2,130
		vc (m/min)	520	520	520	200	200	200
		vf (mm/min)	4,980	3,980	3,320	4,790	3,830	3,200
		fz (mm/t)	0.2	0.2	0.2	0.5	0.5	0.5
		ap (mm)	0.1	0.1	0.1	0.5	0.5	0.5
		ae (mm)	Refer below table			Refer below table		
Stainless Steel	PN215	*n* (min^{-1})	7,970	6,370	5,310	4,780	3,830	3,190
		vc (m/min)	500	500	500	300	300	300
		vf (mm/min)	4,790	3,830	3,190	7,170	5,750	4,790
		fz (mm/t)	0.2	0.2	0.2	0.5	0.5	0.5
		ap (mm)	0.1	0.1	0.1	0.5	0.5	0.5
		ae (mm)	Refer below table			Refer below table		
Cast Iron Ductile Cast Iron	TH315 PN215	*n* (min^{-1})	10,360	8,290	6,910	6,370	5,100	4,250
		vc (m/min)	650	650	650	400	400	400
		vf (mm/min)	9,330	7,470	6,220	9,560	7,650	6,380
		fz (mm/t)	0.3	0.3	0.3	0.5	0.5	0.5
		ap (mm)	0.1	0.1	0.1	0.5	0.5	0.5
		ae (mm)	Refer below table			Refer below table		
Hardened Steel (45~55HRC)	TH315	*n* (min^{-1})	3,990	3,190	2,660	1,920	1,530	1,280
		vc (m/min)	250	250	250	120	120	120
		vf (mm/min)	2,400	1,920	1,600	580	460	390
		fz (mm/t)	0.2	0.2	0.2	0.15	0.15	0.15
		ap (mm)	0.08	0.08	0.08	0.2	0.2	0.2
		ae (mm)	Refer below table			Refer below table		

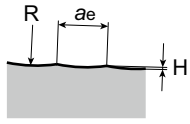
How to calculate "*ae*"

Determine the *ae* value based on the desired cusp height by selecting it from the table below or by calculating it using the equation below.

Insert	R	Cusp height (mm)						
		0.001	0.002	0.003	0.004	0.005	0.01	0.02
TPHW0902-20	20	0.4	0.57	0.69	0.8	0.89	1.26	1.79
TPHW1303-25	25	0.45	0.63	0.77	0.89	1	1.41	2
TPHW1403-30	30	0.49	0.69	0.85	0.98	1.1	1.55	2.19

$$ae = 2\sqrt{(R^2-(R-H)^2)}$$

R : Tool R H : Cusp height



【Note】
①Use the appropriate coolant for the work material and machining shape.
②These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
③To prevent tool breakage due to chips clogging tool flutes, always be sure to use an air blower, etc. to remove chips.
④Ensure to index the insert at the correct time to ensure safety of the tool-body.

Ajustment ratio of cutting conditions by overhang length.

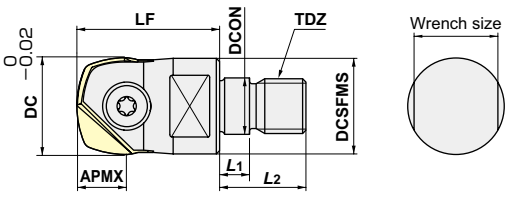
When overhang length is 3*D*c or more, please adjust the values in the above cutting condition table referring to the right table.

Overhang ratio	*Vc* (m/min)	*Vf* (mm/min)
<3DC	100%	100%
3DC ~ 5DC	70%	70%
5DC ~ 6DC	60%	60%
6DC ~ 7DC	50%	50%
7DC ~	45%	45%

Modular type

GP1LB ○○M-M○○

Numeric figure in a circle ○ and Alphabetical character comes in a square □

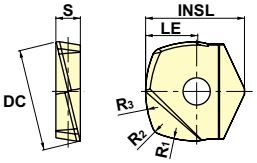


Order No.	Stock	No. of Inserts	Size (mm)									Insert
			DC	LF	APMX	DCON	TDZ	DCSFMS	L_1	L_2	Wrench size	
GP1LB16M-M8	●	1	16	32	8	8.5	M8	12.8	5.5	17	10	ZPHW160-LB16
GP1LB20M-M10	●	1	20	38	10	10.5	M10	17.8	5.5	19	15	ZPHW200-LB20
GP1LB25M-M12	●	1	25	38	12.5	12.5	M12	20.8	5.5	22	17	ZPHW250-LB25
GP1LB30M-M16	★	1	30	43	15	17	M16	28.8	6	23	22	ZPHW300-LB30

【Note】Do not apply lubricants such as grease, etc. to the “contact faces” and “modular screws” of the “modular mill”, “special shanks” and “special arbor”.

※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

Inserts



P	Carbon Steel, Alloy Steel	■	⊏
M	Stainless Steel, etc.	■	
K	Cast Iron・Ductile Cast Iron	⊏	■
H	Hardened Steel		■

■ : General cutting, First recommended

⊏ : General cutting, Second recommended

Order No.	Tolerance class	Grade		Size (mm)						
		PN215	TH308	R_1	R_2	R_3	LE	INSL	DC	S
ZPHW160-LB16	H	●	●	16	1.5	16	8	16.6	16	4.2
ZPHW160-LB16-R5		●	●	16	5	16	8	16.6	16	4.2
ZPHW200-LB20		●	●	20	1.9	20	10	20.3	20	5.2
ZPHW200-LB20-R6		●	●	20	6	20	10	20.3	20	5.2
ZPHW250-LB25		●	●	25	2.38	25	12.5	24.1	25	6.2
ZPHW250-LB25-R8		●	●	25	8	25	12.5	24.1	25	6.2
ZPHW300-LB30		★	★	30	2.85	30	15	29.1	30	7.2
ZPHW300-LB30-R10		★	★	30	10	30	15	29.1	30	7.2

【Note】The numbers after the third decimal point are rounded off. When defining the shape parametrically, check the required dimensions from the DXF data.

Parts

To reduce environmental loads, drivers and screw anti-seizure agent are sold separately.
We ask for your understanding and cooperation.

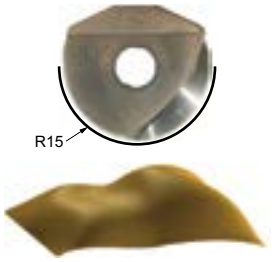
Parts	Clamp screw		Not included with product (sold separately)	
			Wrench	Screw anti-seizure agent
Shape / Cutter body		Fastening torque (N·m)		
GP1LB16M-M8	581-144	4.9	105-T20	P-37
GP1LB20M-M10	581-145	6.9	101-T25S	
GP1LB25M-M12	581-146	9.8	105-T30A	
GP1LB30M-M16	581-147	9.8		

※The insert can be attached to Ball Precision F (ABPF type) holders.
※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

How to select GP1LB inserts

Comparison of cutting efficiency of 3-axis machining with φ30 tool. ※Set the cusp-height of each edge of barrel R, lens R and corner-connected R same as ball end mill

Ball end mill (φ30)

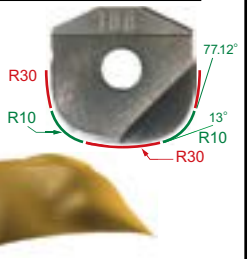


Ball end mill is recommended
for shapes with large undulations

GP1LB ZPHW300-LB30-R10

1.4 times cutting efficiency than ball end mill

Cutting efficiency Compared with the ball end mill 0.8 times



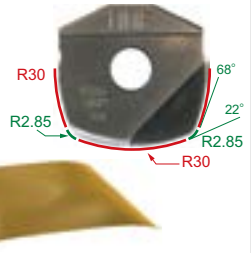
High efficiency machining on undulating curved surface.

If the barrel R and lens R can be used more than 47% of the whole machining, more efficient than ball end mill of same diameter.

GP1LB ZPHW300-LB30

1.4 times cutting efficiency than ball end mill

Cutting efficiency Compared with the ball end mill 0.4 times



High efficiency machining with gentle curved surface with less undulation.

If the barrel R and lens R can be used more than 84% of the whole machining, more efficient than ball end mill of same diameter.

※Checking the usage rate of barrel R edge and lens R edge in model shape to be processed and choosing an insert, possible more efficient machining.

● : Inventory maintained in US ★ : Inventory maintained in Japan

Recommended cutting conditions

※Red indicates primary recommended grade.

Work material	Recommended grade	Cutting condition	Lens part				Barrel part			
			φ16	φ20	φ25	φ30	φ16	φ20	φ25	φ30
Carbon Steel Alloy Steel (<30HRC)	PN215	*n* (min^{-1})	14,340	11,470	9,180	7,650	11,950	9,560	7,650	6,370
		vc (m/min)	720	720	720	720	600	600	600	600
		vf (mm/min)	7,170	5,740	4,590	3,830	4780	3,830	3,060	2,550
		fz (mm/t)	0.25	0.25	0.25	0.25	0.2	0.2	0.2	0.2
		ap (mm)	0.1	0.1	0.1	0.1	Refer below table			
		ae (mm)	Refer below table				0.1	0.1	0.1	0.1
Carbon Steel Alloy Steel (30～45HRC)	PN215 TH308	*n* (min^{-1})	10,360	8,290	6,630	5,530	7,970	6,370	5,100	4,250
		vc (m/min)	520	520	520	520	400	400	400	400
		vf (mm/min)	5,180	4,150	3,320	2,770	3,190	2,550	2,040	1,700
		fz (mm/t)	0.25	0.25	0.25	0.25	0.2	0.2	0.2	0.2
		ap (mm)	0.1	0.1	0.1	0.1	Refer below table			
		ae (mm)	Refer below table				0.1	0.1	0.1	0.1
Stainless Steel	PN215	*n* (min^{-1})	12,940	10,360	8,290	6,910	9,960	7,970	6,370	5,310
		vc (m/min)	650	650	650	650	500	500	500	500
		vf (mm/min)	6,470	5,180	4,150	3,460	3,990	3,190	2,550	2,130
		fz (mm/t)	0.25	0.25	0.25	0.25	0.2	0.2	0.2	0.2
		ap (mm)	0.1	0.1	0.1	0.1	Refer below table			
		ae (mm)	Refer below table				0.1	0.1	0.1	0.1
Cast iron Ductile Cast Iron	TH308 PN215	*n* (min^{-1})	14,340	11,470	9,180	7,650	11,950	9,560	7,650	6,370
		vc (m/min)	720	720	720	720	600	600	600	600
		vf (mm/min)	11,480	9,180	7,350	6,120	5,980	4,780	3,830	3,190
		fz (mm/t)	0.4	0.4	0.4	0.4	0.25	0.25	0.25	0.25
		ap (mm)	0.1	0.1	0.1	0.1	Refer below table			
		ae (mm)	Refer below table				0.1	0.1	0.1	0.1
Hardened Steel (45～55HRC)	TH308	*n* (min^{-1})	6,370	5,100	4,080	3,400	4,980	3,990	3,190	2,660
		vc (m/min)	320	320	320	320	250	250	250	250
		vf (mm/min)	2,550	2,040	1,640	1,360	1,500	1,200	960	800
		fz (mm/t)	0.20	0.20	0.20	0.20	0.15	0.15	0.15	0.15
		ap (mm)	0.08	0.08	0.08	0.08	Refer below table			
		ae (mm)	Refer below table				0.08	0.08	0.08	0.08
Hardened steels (55～62HRC)	TH308	*n* (min^{-1})	5,580	4,460	3,570	2,980	4,380	3,510	2,810	2,340
		vc (m/min)	280	280	280	280	220	220	220	220
		vf (mm/min)	2,240	1,790	1,430	1,200	1,320	1,060	850	710
		fz (mm/t)	0.20	0.20	0.20	0.20	0.15	0.15	0.15	0.15
		ap (mm)	0.05	0.05	0.05	0.05	Refer below table			
		ae (mm)	Refer below table				0.05	0.05	0.05	0.05

- For machining shapes that make heavy use of lens R, refer to the "Lens part cutting conditions" in the above table.
- For machining shapes that make heavy use of barrel R, refer to the "Barrel part cutting conditions" in the above table.
- For machining shapes that use both lens R and barrel R equally, refer to the conditions with the higher usage ratio.

When overhang length is 3*Dc* or greater, adjust the values shown in the below table according to the above table.

Overhang ratio	*Vc* (m/min)	*Vf* (mm/min)
<3DC	100%	100%
3DC ～ 5DC	70%	70%
5DC ～ 6DC	60%	60%
6DC ～ 7DC	50%	50%
7DC ～	45%	45%

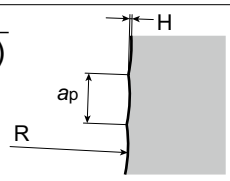
Determine the *ap* or *ae* value based on the desired cusp height by selecting it from the table below or by calculating it using the equation below.

Insert		Cusp height (mm)					
Item code	R	**0.001**	**0.002**	**0.003**	**0.004**	**0.005**	**0.01**
ZPHW160-LB16	16	0.36	0.51	0.62	0.72	0.8	1.13
ZPHW200-LB20	20	0.4	0.57	0.69	0.8	0.89	1.26
ZPHW250-LB25	25	0.45	0.63	0.77	0.89	1	1.41
ZPHW300-LB30	30	0.49	0.69	0.85	0.98	1.1	1.55

$$a_p = 2\sqrt{(R^2-(R-H)^2)}$$

(a_e)

R : Tool R　H : Cusp height



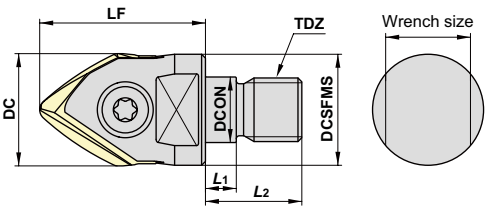
【Note】
①Use the appropriate coolant for the work material and machining shape.
②These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
③To prevent tool breakage due to chips clogging tool flutes, always be sure to use an air blower, etc. to remove chips.
④Ensure to index the insert at the correct time to ensure safety of the tool-body.

Refer page 15 for set-up procedures of inserts.

Modular type

GP1T ○○M-M○○

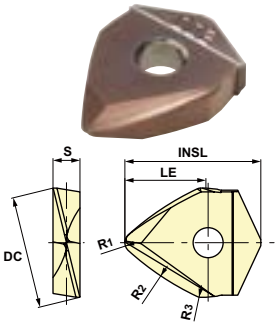
Numeric figure in a circle ○ and Alphabetical character comes in a square □



Order No.	Stock	No. of flutes	Size (mm)								Insert
			DC	LF	DCON	TDZ	DCSFMS	L_1	L_2	Wrench size	
GP1T12M-M6	★	1	12	26	6.5	M6	9.8	5.5	14.5	7	ZDHW120-T43R1.2-30
GP1T16M-M8	★	1	16	32	8.5	M8	12.8	5.5	17	10	ZDHW160-T43R1.6-40
GP1T20M-M10	★	1	20	38	10.5	M10	17.8	5.5	19	15	ZDHW200-T43R2-50
GP1T25M-M12	★	1	25	38	12.5	M12	20.8	5.5	22	17	ZDHW250-T43R2.5-62.5
GP1T30M-M16	★	1	30	43	17	M16	28.8	6	23	22	ZDHW300-T43R3-75

【Note】Do not apply lubricants such as grease, etc. to the “contact faces” and “modular screws” of the “modular mill”, “special shanks” and “special arbor”.
※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

Inserts



R accuracy：±0.01(Insert itself)

P	Carbon Steel, Alloy Steel	■	⊔
M	Stainless Steel, etc.	■	
K	Cast Iron・Ductile Cast Iron	⊔	■
H	Hardened Steel		■

■ : General cutting, First recommended
⊔ : General cutting, Second recommended

Order No.	Tolerance class	Grade		Size(mm)						
		PN215	TH308	R_1	R_2	R_3	LE	INSL	DC	S
ZDHW120-T43R1.2-30	H	★	★	1.2	30	0.98	8.6	17.6	12	3.2
ZDHW160-T43R1.6-40		★	★	1.6	40	1.3	11.3	20.6	16	4.2
ZDHW200-T43R2-50		★	★	2.0	50	1.63	14.3	25.4	20	5.2
ZDHW250-T43R2.5-62.5		★	★	2.5	62.5	2.04	17.9	30.1	25	6.2
ZDHW300-T43R3-75		★	★	3.0	75	2.45	21.6	36.3	30	7.2

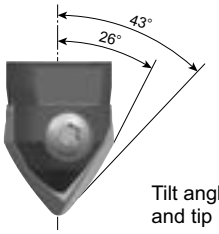
・The insert can be set with "ABPF-type" cutter body ・Use solid barrel end mill, "GS4TN-type" for smaller diameter in size
【Note】The numbers after the third decimal point are rounded off. When defining the shape parametrically, check the required dimensions from the DXF data.
※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

Parts

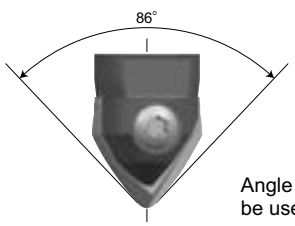
To reduce environmental loads, drivers and screw anti-seizure agent are sold separately.
We ask for your understanding and cooperation.

Parts	Clamp screw		Not included with product (sold separately)	
			Wrench	Screw anti-seizure agent
Shape / Cutter body		Fastening torque (N･m)		
GP1T12M-M6	581-143	4.9	105-T20	P-37
GP1T16M-M8	581-144	4.9		
GP1T20M-M10	581-145	6.9	101-T25S	
GP1T25M-M12	581-146	9.8	105-T30A	
GP1T30M-M16	581-147	9.8		

Angle range of barrel R and tip R



Tilt angle range of barrel R and tip R



Angle range of tip R that can be used as a ball end mill

★ : Inventory maintained in Japan

Recommended cutting conditions

※Red indicates primary recommended grade.

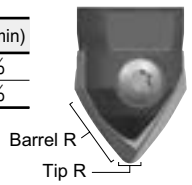
Work material	Recommended grade	Cutting conditions	Tip R					Barrel R				
			φ12(R1.2)	φ16(R1.6)	φ20(R2)	φ25(R2.5)	φ30(R3)	φ12	φ16	φ20	φ25	φ30
Carbon Steel Alloy Steel (<30HRC)	PN215	n (min-1)	19,910	14,930	11,950	9,560	7,970	19,110	14,340	11,470	9,180	7,650
		vc (m/min)	750(150)	750(150)	750(150)	750(150)	750(150)	720	720	720	720	720
		vf (mm/min)	1,600	1,500	1,440	1,340	1,280	5,740	4,310	3,450	2,760	2,300
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.15	0.15	0.15	0.15	0.15
		ap (mm)	0.1	0.1	0.1	0.1	0.1	Refer to the below table				
		ae (mm)	Refer to the below table					0.1	0.1	0.1	0.1	0.1
Carbon Steel Alloy Steel (30~45HRC)	PN215 TH308	n (min-1)	18,580	13,940	11,150	8,920	7,440	13,810	10,360	8,290	6,630	5,530
		vc (m/min)	700(140)	700(140)	700(140)	700(140)	700(140)	520	520	520	520	520
		vf (mm/min)	1,490	1,400	1,340	1,250	1,200	4,150	3,110	2,490	1,990	1,660
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.15	0.15	0.15	0.15	0.15
		ap (mm)	0.1	0.1	0.1	0.1	0.1	Refer to the below table				
		ae (mm)	Refer to the below table					0.1	0.1	0.1	0.1	0.1
Stainless Steel	PN215	n (min-1)	19,910	14,930	11,950	9,560	7,970	17,260	12,940	10,360	8,290	6,910
		vc (m/min)	750(150)	750(150)	750(150)	750(150)	750(150)	650	650	650	650	650
		vf (mm/min)	1,600	1,500	1,440	1,340	1,280	5,180	3,890	3,110	2,490	2,080
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.15	0.15	0.15	0.15	0.15
		ap (mm)	0.1	0.1	0.1	0.1	0.1	Refer to the below table				
		ae (mm)	Refer to the below table					0.1	0.1	0.1	0.1	0.1
Cast Iron Ductile Cast Iron	TH308 PN215	n (min-1)	19,910	14,930	11,950	9,560	7,970	19,110	14,340	11,470	9,180	7,650
		vc (m/min)	750(150)	750(150)	750(150)	750(150)	750(150)	720	720	720	720	720
		vf (mm/min)	1,600	1,500	1,440	1,340	1,280	7,650	5,740	4,590	3,680	3,060
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.2	0.2	0.2	0.2	0.2
		ap (mm)	0.1	0.1	0.1	0.1	0.1	Refer to the below table				
		ae (mm)	Refer to the below table					0.1	0.1	0.1	0.1	0.1
Hardened Steel (45~55HRC)	TH308	n (min-1)	13,270	9,960	7,970	6,370	5,310	8,500	6,370	5,100	4,080	3,400
		vc (m/min)	500(100)	500(100)	500(100)	500(100)	500(100)	320	320	320	320	320
		vf (mm/min)	1,070	1,000	960	900	850	1,700	1,280	1,020	820	680
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.1	0.1	0.1	0.1	0.1
		ap (mm)	0.08	0.08	0.08	0.08	0.08	Refer to the below table				
		ae (mm)	Refer to the below table					0.08	0.08	0.08	0.08	0.08
Hardened Steel (55~62HRC)	TH308	n (min-1)	11,950	8,960	7,170	5,740	4,780	7,440	5,580	4,460	3,570	2,980
		vc (m/min)	450(90)	450(90)	450(90)	450(90)	450(90)	280	280	280	280	280
		vf (mm/min)	960	900	870	810	770	1,490	1,120	900	720	600
		fz (mm/t)	0.04	0.05	0.06	0.07	0.08	0.1	0.1	0.1	0.1	0.1
		ap (mm)	0.05	0.05	0.05	0.05	0.05	Refer to the below table				
		ae (mm)	Refer to the below table					0.05	0.05	0.05	0.05	0.05

※The ( ) values of vc indicate the cutting speed of the tip R part.

When overhang length is 3DC or greater, adjust the values shown in the table at right according to the above table.

Overhang ratio	Vc (m/min)	Vf (mm/min)
<3DC	100%	100%
3DC ~ 5DC	70%	70%
5DC ~ 6DC	60%	60%

Overhang ratio	Vc (m/min)	Vf (mm/min)
6DC ~ 7DC	50%	50%
7DC ~	45%	45%

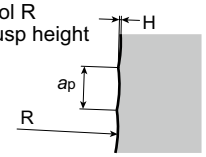


Determine the ap or ae value based on the desired cusp height by selecting it from the table below or by calculating it using the equation below.

Insert Order No.	Cutting depth using barrel R ap(mm)								Cutting depth using tip R ae(mm)							
	Barrel R	Cusp height (mm)							Tip R	Cusp height (mm)						
		0.0005	0.001	0.002	0.003	0.004	0.005	0.01		0.0005	0.001	0.002	0.003	0.004	0.005	0.01
ZDHW120-T43R1.2-30	30	0.35	0.49	0.69	0.85	0.98	1.1	1.55	1.2	0.07	0.1	0.14	0.17	0.2	0.22	0.31
ZDHW160-T43R1.6-40	40	0.4	0.57	0.8	0.98	1.13	1.26	1.79	1.6	0.08	0.11	0.16	0.2	0.23	0.25	0.36
ZDHW200-T43R2-50	50	0.45	0.63	0.89	1.1	1.26	1.41	2	2	0.09	0.13	0.18	0.22	0.25	0.28	0.4
ZDHW250-T43R2.5-62.5	62.5	0.5	0.71	1	1.22	1.41	1.58	2.24	2.5	0.1	0.14	0.2	0.24	0.28	0.32	0.45
ZDHW300-T43R3-75	75	0.55	0.77	1.1	1.34	1.55	1.73	2.45	3	0.11	0.15	0.22	0.27	0.31	0.35	0.49

$$ap = 2\sqrt{(R^2-(R-H)^2)}\ (ae)$$

R: Tool R
H: Cusp height



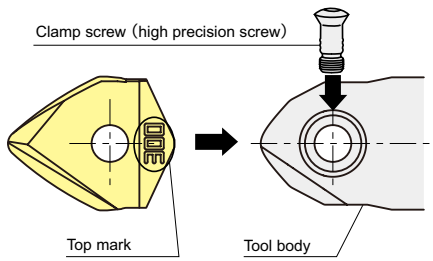
【Note】
①Use the appropriate coolant for the work material and machining shape.
②These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
③To prevent tool breakage due to chips clogging tool flutes, always be sure to use an air blower, etc. to remove chips.
④Ensure to index the insert at the correct time to ensure safety of the tool-body.

Set-up Procedures of Inserts

1. Clean the insert seat: Using air-blow or alike, clean the seat.
2. Put in the insert with its top positioned to the screw-tightening side of the tool body.
3. Tighten the clamp screw with the special wrench. Please do not press down the insert during this tightening process.
4. This is the end of insert set-up.

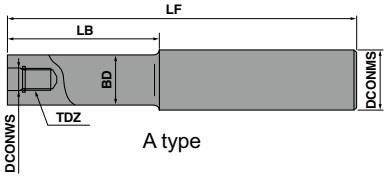
Attention Never tighten the clamp screw without putting the insert. The tool body may be deformed, resulting in improper insert mounting or deterioration of mounting accuracy.

Do not tighten the screw without putting insert

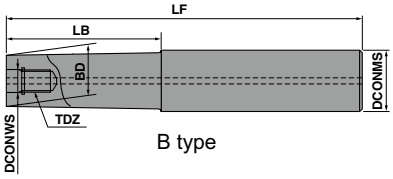


Carbide Shank

Inch



A type



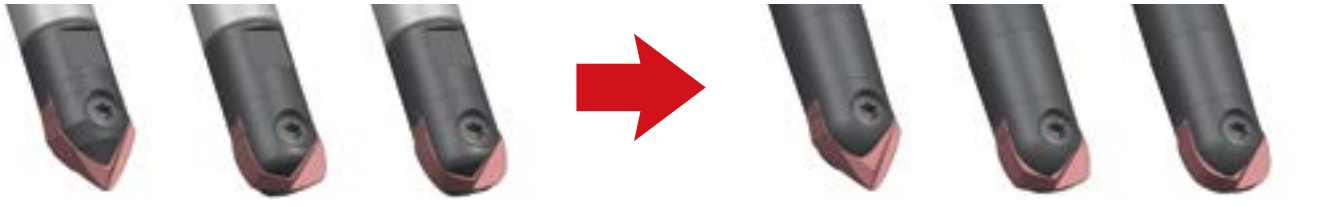
B type

Order No.	Stock	Dimensions (Inch)						Type	Cutter body	Coolant hole
		DCONWS	TDZ	LF	LB	BD	DCONMS			
IASC0.375-M6-3-1	●	6.5mm	M6	3	1	.3661	.375	A	ϕ12mm *1(exc. IASC0.375-M6-3-1)	—
IASC0.5-M6-4-2	●		M6	4	2	.453	.5	A		—
IASC0.5-M6-6-3	●		M6	6	3	.453	.5	A		—
IASC0.625-M8-4-2	●	8.5mm	M8	4	2	.571	.625	B	ϕ16mm	○
IASC0.625-M8-6-3	●		M8	6	3	.571	.625	B		○
IASC0.75-M10-5-2.5Z	●	10.5mm	M10	5	2.5	.689	.75	B	ϕ20mm	○
IASC0.75-M10-8-4Z	●		M10	8	4	.689	.75	B		○
IASC1-M12-6-3Z	●	12.5mm	M12	6	3	.906	1	B	ϕ25mm*1	○
IASC1-M12-8-4Z	●		M12	8	4	.906	1	B		○

●= Inventory Maintained in US ○= Tool with coolant hole

*1 Cutter Dia. is the same or smaller than the shank dia. This can cause interference between part and shank.

GP1LB and GP1T inserts can be set in corresponding metric ABPF cutter body.

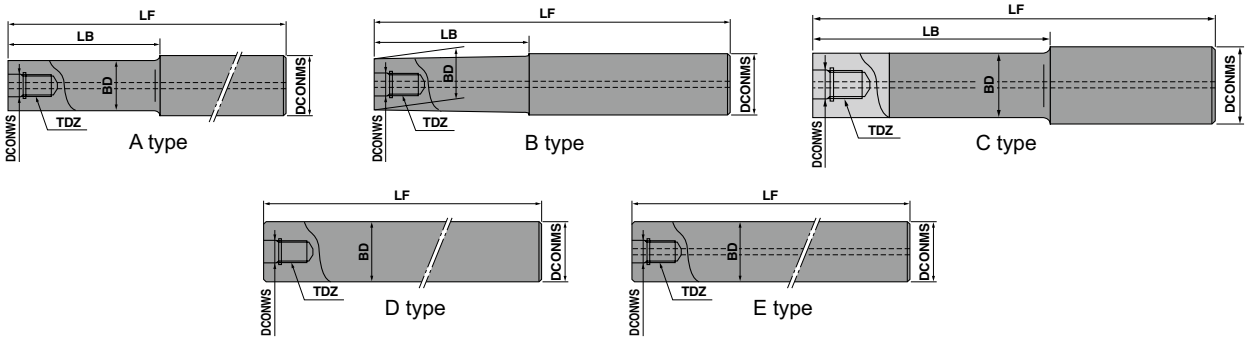


Set to original cutter body

Can be set in ABPF cutter body

The insert of GP1LB and GP1T are able to set in ABPF cutter body.

Metric

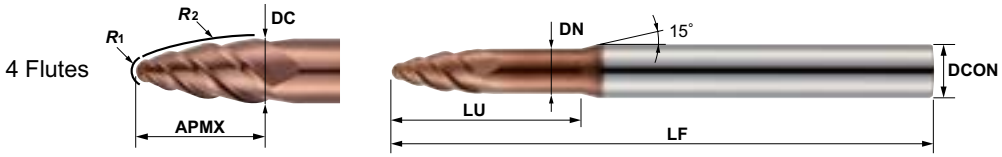


Order No.	Stock	Dimensions (mm)						Type	Cutter body	Coolant hole
		DCONWS	TDZ	LF	LB	BD	DCONMS			
ASC10-6.5-74-24Z	●	6.5	M6	74	24	9.3	10	A	ϕ12 *1 (exc. ASC10 Series)	○
ASC10-6.5-84-34Z	●			84	34			A		○
ASC10-6.5-114-49Z	★			114	49			A		○
ASC10-6.5-114-24Z	★				24			A		○
ASC12-6.5-74-24Z	●	6.5	M6	74	24	11	12	B		○
ASC12-6.5-94-44Z	●			94	44			B		○
ASC12-M6-100-0	●			100	-	12		D		—
ASC12-6.5-129-64Z	★			129	64	11		B		○
ASC12-6.5-129-24Z	★				24			B		○
ASC16-8.5-95-30Z	●	8.5	M8	95	30	14.5	16	B	ϕ16※1	○
ASC16-8.5-120-55Z	●			120	55					
ASC16-8.5-140-75Z	●			140	75					
ASC16-8.5-160-95Z	★			160	95					
ASC16-8.5-160-30Z	★			160	30					
ASC18-M10-125-0Z	●	10.5	M10	125	-	18	18	E	ϕ20※1 *1 (exc. ASC18-M10-125-0Z) ϕ25 (GF1G2025M-4-M10)	○
ASC20-10.5-120-50Z	★			120	50	18.5	20	B		○
ASC20-10.5-170-90Z	●			170	90					
ASC20-10.5-220-120Z	●			220	120					
ASC20-10.5-270-150Z	★			270	150					
ASC20-10.5-220-50Z	★	10.5	M10	220	50	18.5	20	B		○
ASC20-10.5-270-50Z	★			270						
ASC25-12.5-145-65	★	12.5	M12	145	65	23	25	C	ϕ25※1	○
ASC25-M12-150-0Z	●			150	-	25		E		
ASC25-12.5-215-115	●			215	115	23		C		
ASC25-12.5-265-145	●			265	145					
ASC25-12.5-315-195	★			315	195					
ASC25-12.5-265-65	★	12.5	M12	265	65	23	25	C		○
ASC25-12.5-315-65	★			315						
ASC32-17-160-80	★	17	M16	160	80	28	32	C	ϕ30※1 ϕ35 ϕ40	○
ASC32-17-210-110	●			210	110					
ASC32-17-260-140	●			260	140					
ASC32-17-310-190	★			310	190					
ASC32-17-360-240	★			360	240					
ASC32-17-260-80	★	17	M16	260	80	28	32	C		○
ASC32-17-310-80	★			310						
ASC32-17-360-80	★			360						

●= Inventory Maintained in US ★= Inventory Maintained in Japan ○= Tool with coolant hole

*1 Cutter Dia. is the same or smaller than the shank dia. This can cause interference between part and shank.

Solid type



GS4TN○○.○○-○○.○○R-TH3

Carbide | TH3 Coated | 72 HRC | Helix 45 | h5

Form tolerance：±0.01

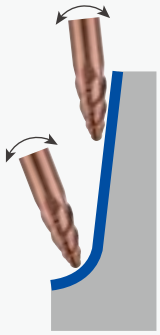
Order No.	Stock	Size (mm)							
		Tip R **R_1**	Barrel R **R_2**	Tool dia. **DC**	Flute length **APMX**	Under neck length **LU**	Neck dia. **DN**	Overall length **LF**	Shank dia. **DCON**
GS4TN2.5-12.5R-TH3	●	0.5	12.5	2.5	4.68	10	2.4	50	4
GS4TN3.75-18.75R-TH3	●	0.75	18.75	3.75	7.01	15	3.65	50	4
GS4TN5-25R-TH3	●	1	25	5	9.35	20	4.8	60	6
GS4TN7.5-37.5R-TH3	●	1.5	37.5	7.5	14.03	30	7.3	75	8
GS4TN10-50R-TH3	●	2	50	10	18.70	40	9.5	100	12

・There is no regrinding compatibility for this tool. ・For the large diameter in size, use the indexable end mill "GP1T".

※For information on the detailed tool shape, download the DXF data from the MOLDINO Tool Engineering home page.
(MOLDINO Tool Engineering tool selection database TOOL SEARCH: http://data.moldino.com/toolsearch/?lang=en)

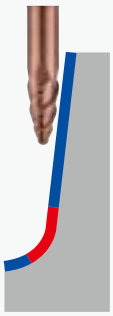
Machining method of GS4TN

When using with 5-axis machine



By using the barrel R with tilted tool axis, tilted section can be cut with large pitch.
Furthermore, it is possible to cut with less machining steps by using the tip R.

When using with 3-axis machine



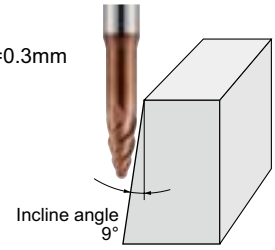
Barrel R enables to cut steep face with large pitch.
However, it is necessary to process the bottom corner section with a separate tool.

Processable with GS4TN　Needs separate tool

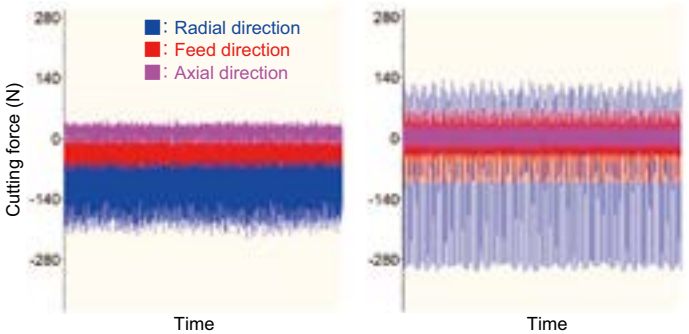
High helix shape realized low cutting force

Cutting conditions

Work material：Matrix HSS (58HRC)
Tool：GS4TN10-50R-TH3
　　2 flutes Ball End Mill
Shape：See the figure right
Condition：　n=4780min^{-1}
　　v_f=956mm/min
　　(Ball：v_f=478)
　　a_p=0.5mm　a_e=0.3mm
　　Contouring
　　Down cut



GS4TN　2 flutes Ball End mill



High helix shape reduces cutting force,
4 flutes improve efficiency

●：Inventory maintained in US

Recommended cutting conditions

●Barrel R　cutting condition

Work material		Carbon Steel, Alloy Steel (<35HRC)				Pre-hardened Steel (35～45HRC)				Hardened Steel (45～55HRC)				Hardened Steel (55～65HRC)				Hardened Steel (65～72HRC)			
Tip R R_1 (mm)	Barrel R R_2 (mm)	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm
0.5	12.5	23,550	3,060	0.22	0.05～0.1	19,100	2,480	0.22	0.05～0.1	17,830	1,960	0.22	0.05～0.1	16,550	1,820	0.22	0.01～0.05	12,730	1,400	0.22	0.01～0.05
0.75	18.75	15,700	2,670	0.27	0.05～0.1	13,840	2,460	0.27	0.05～0.1	11,880	1,780	0.27	0.05～0.1	11,370	1,640	0.27	0.01～0.05	8,570	1,230	0.27	0.01～0.05
1	25	11,780	2,540	0.32	0.05～0.1	10,500	2,260	0.32	0.05～0.1	9,130	1,670	0.32	0.05～0.1	7,040	1,440	0.32	0.01～0.05	6,490	1,100	0.32	0.01～0.05
1.5	37.5	7,850	1,990	0.39	0.05～0.1	6,930	1,780	0.39	0.05～0.1	6,190	1,390	0.39	0.05～0.1	4,460	1,230	0.39	0.01～0.05	4,290	920	0.39	0.01～0.05
2	50	5,890	1,680	0.45	0.05～0.1	5,100	1,460	0.45	0.05～0.1	4,510	1,130	0.45	0.05～0.1	3,520	1,000	0.45	0.01～0.05	3,190	770	0.45	0.01～0.05

●Tip R　cutting condition

Work material		Carbon Steel, Alloy Steel (<35HRC)				Pre-hardened Steel (35～45HRC)				Hardened Steel (45～55HRC)				Hardened Steel (55～65HRC)				Hardened Steel (65～72HRC)			
Tip R R_1 (mm)	Barrel R R_2 (mm)	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm	Revolution n min^{-1}	Feed rate vf mm/min	ap mm	ae mm
0.5	12.5	34,320	2,580	0.09	0.29	28,600	2,060	0.08	0.24	26,000	1,870	0.06	0.18	24,700	1,600	0.06	0.18	20,800	1,120	0.05	0.15
0.75	18.75	25,680	2,890	0.10	0.31	21,400	2,310	0.09	0.26	19,500	2,110	0.07	0.21	18,500	1,800	0.07	0.21	15,600	1,260	0.06	0.18
1	25	22,080	3,310	0.19	0.58	18,400	2,650	0.16	0.48	16,700	2,400	0.13	0.39	15,900	2,060	0.12	0.36	13,400	1,450	0.10	0.30
1.5	37.5	20,400	3,280	0.28	0.86	17,000	2,620	0.24	0.72	15,400	1,850	0.20	0.60	14,300	1,720	0.19	0.57	11,000	1,320	0.15	0.45
2	50	15,600	3,040	0.38	1.15	13,000	2,430	0.32	0.96	11,000	1,760	0.27	0.81	10,560	1,580	0.25	0.75	7,920	1,190	0.20	0.60

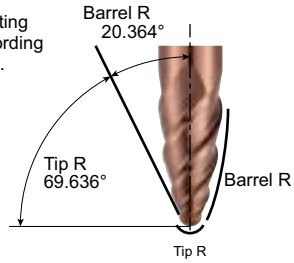
●Cutting condition for using both barrel R and tip R

Work material		Carbon Steel, Alloy Steel (<35HRC)		Pre-hardened Steel (35～45HRC)		Hardened Steel (45～55HRC)		Hardened Steel (55～65HRC)		Hardened Steel (65～72HRC)	
Tip R R_1 (mm)	Barrel R R_2 (mm)	Revolution n min^{-1}	Feed rate vf mm/min	Revolution n min^{-1}	Feed rate vf mm/min	Revolution n min^{-1}	Feed rate vf mm/min	Revolution n min^{-1}	Feed rate vf mm/min	Revolution n min^{-1}	Feed rate vf mm/min
0.5	12.5	28,940	2,820	23,850	2,270	21,920	1,920	20,630	1,710	16,770	1,260
0.75	18.75	20,690	2,780	17,620	2,390	15,690	1,950	14,940	1,720	12,090	1,250
1	25	16,930	2,930	14,450	2,460	12,920	2,040	11,470	1,750	9,950	1,280
1.5	37.5	14,130	2,640	11,970	2,200	10,800	1,620	9,380	1,480	7,650	1,120
2	50	10,750	2,360	9,050	1,950	7,760	1,450	7,040	1,290	5,560	980

※For cutting depth (ap, ae), refer to the above conditions for each section.

■Angle range of barrel R and tip R

Depending on the cutting shape, the contact section is divided into barrel R and tip R. Check the contact section and select the appropriate cutting conditions according to each section.

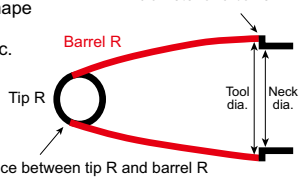


Determine the *ap* value based on the desired cusp height by selecting it from the table below.

Tool		Cusp height (mm)					
Order No.	Barrel R	0.0001	0.0003	0.0005	0.001	0.003	0.005
GS4TN2.5-12.5R-TH3	12.5	0.10	0.17	0.22	0.32	0.55	0.71
GS4TN3.75-18.75R-TH3	18.75	0.12	0.21	0.27	0.39	0.67	0.87
GS4TN5-25R-TH3	25	0.14	0.24	0.32	0.45	0.77	1.00
GS4TN7.5-37.5R-TH3	37.5	0.17	0.30	0.39	0.55	0.95	1.22
GS4TN10-50R-TH3	50	0.20	0.35	0.45	0.63	1.10	1.41

■ About tool shape

"Barrel R" of GS4TN has a shape that connects "tip R" and "tool diameter" with double arc. See the figure on the right.



【Note】

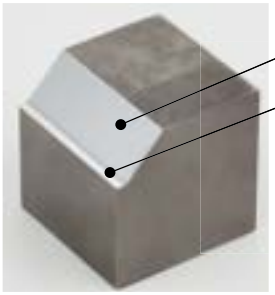
①Use the appropriate coolant for the work material and machining shape.
②Use a machine having as high rigidity and high accuracy as possible.
③These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
④If the rpm of the machine is low, lower the feed rate also to put the rpm and feed rate in the same ratio.

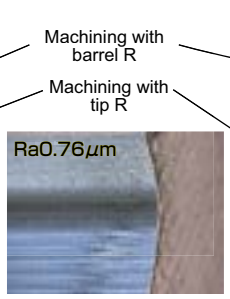
Field data

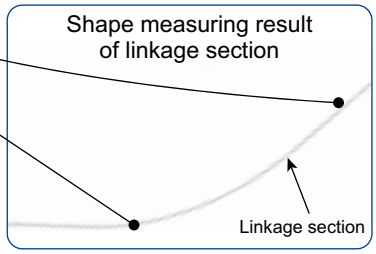
In 3-axis machining evaluation test of machining surface step between barrel R and tip R — GP1T

Cutting conditions

Work material：H13 (52HRC)
GP1Tϕ20-TH308
OH=88mm
n=7,970min^{-1}
v_f=960mm/min
Cusp height setting value：0.001mm
Air-blow, Down cut







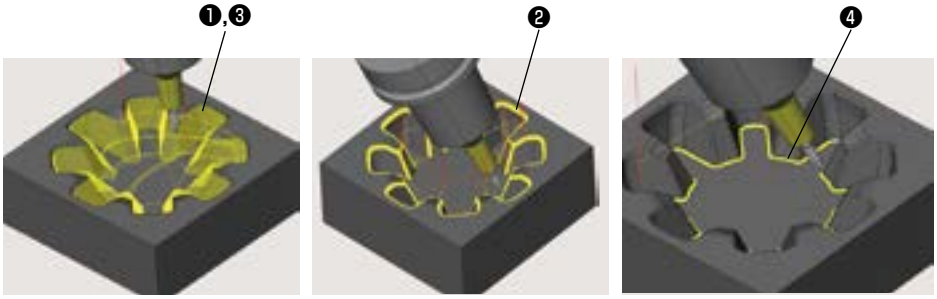
Good machined surface without machining step.

Model machining of Matrix HSS with 5-axis machine Hi-Pre² — GS4TN

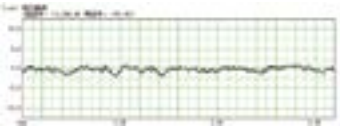
Tool：GS4TN10-50R-TH3　Machine：5-axis machine,　Air blow　Work material：Matrix HSS (58HRC)　Machining depth：30mm
Work size：About 90mm　Finishing time：**About 2 hours.**　CAD/CAM：hyperMILL

Process	Tool	Working area	Flute shape	Revolution n (min^{-1})	Cutting speed v_c (m/min)	Feed rate v_f (mm/min)	Feed per tooth f_z (mm/t)	Depth of cut a_p (mm)	Depth of cut a_e (mm)	Cutting time (min)
Roughing	HGOF4100-20-TH		Radius	2,200	69.1	1,760	0.2	0.4	3	92
Finishing	ETM4060-15-H		Radius	3,700	69.7	1,780	0.12	0.24	3	13
Semi-finishing	GS4TN5-25R-TH3 (O/H:30mm)	❶	Barrel edge	10,560	165.8	1,440	0.034	0.6	0	46
								0.2	0	
		❷	Tip edge	15,900	249.6	2,060	0.032	0	0.15	
Finishing	GS4TN3.75-18.75R-TH3 (O/H:25mm)	❸	Barrel edge	11,370	127.5	1,640	0.036	0.5	0	92
								0.5	0	
		❹	Tip edge	18,500	207.4	1,800	0.024	0	0.7	

Possible to finish tilted section and fillet section (connection surface) with one tool.
Good machined surface without machining steps which caused by tool change.



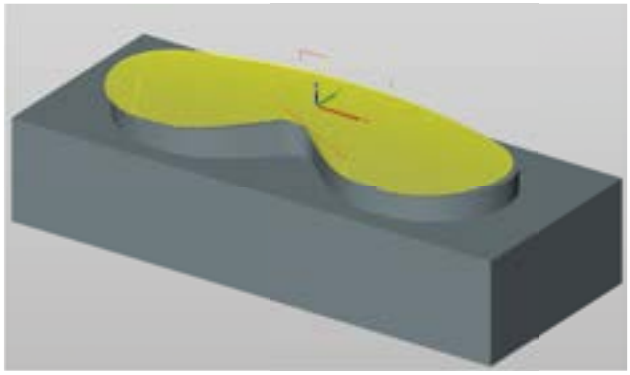
The same tool could finish even fillet section.



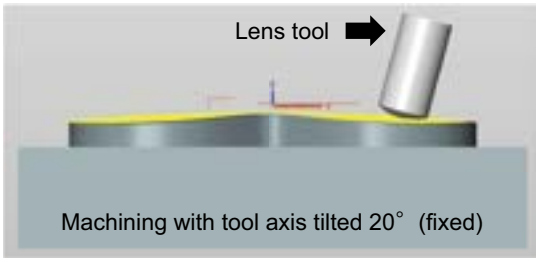
Surface roughness is good even when cutting with large pitch

Ra:0.515μm Rz:2.574μm

Curved surface finishing of eyeglass shape — GF3L



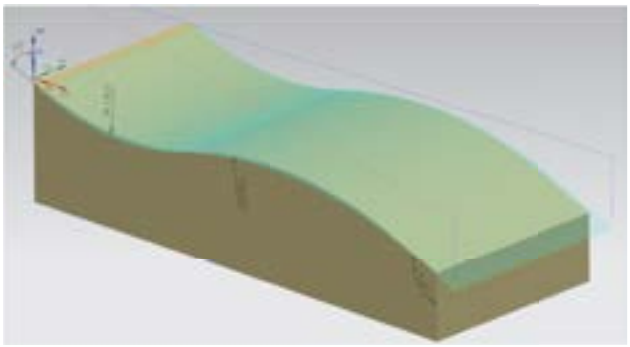
Work material : STAVAX (420 Stainless Steel)
Machine : 5 axis M/C (HSK-A63)



v_c=392m/min、f_z=0.17mm/t、a_p=0.1mm、
Cusp height =0.003mm、wet、DC=25mm, 3NT

Cutting efficiency about doubled with the similar surface roughness as ball end mill.

Semi-finishing of gentle sloped surface. (3 axis M/C) — GF3L



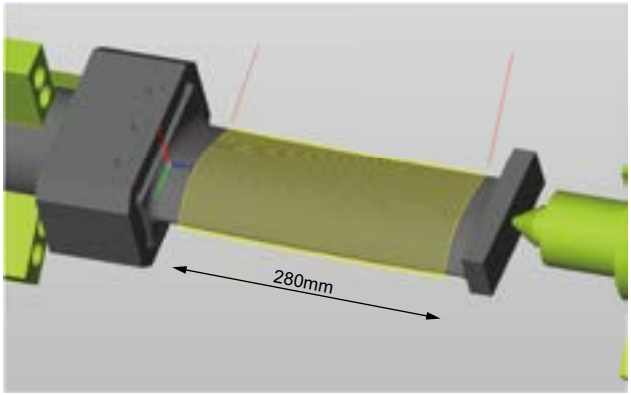
By utilizing GF3L type for semi-finishing process after contour roughing, it is possible to double the efficiency of a standard ball mill.

Using the GALLEA series (GF3L, GP1LB) it is possible to process from semi-finishing to finishing with high efficiency

Work material : P20　Machine : 3 axis vertical M/C (HSK-A63)

Process	Tool	Grade	Cutting conditions									Cutting time
			v_c (m/min)	n (mm^{-1})	v_f (mm/min)	f_z (mm/t)	a_p (mm)	a_e (mm)	Cusp height (mm)	Removal stock (mm)	Method	
Roughing	RD16B4032S32	GX2160	200	2000	2400	0.4	0.8	10	–	0.6	Contouring	27' 28"
Semi-roughing	GF3L25M-3-M12	PN215	200	2546	3820	0.5	0.5	(2)	0.02	0.1	Surface machining	3' 57"
Finishing	GP1LB25M-M12	PN215	720	9180	4590	0.25	0.1	–	0.003	0	Surface machining	6' 30"

Turbine blade finishing — GF3L



Work material : 420 Stainless Steel
Machine : Multi-function machine (HSK-A63)

Surface roughness

Ra=0.71μm
Rz=3.52μm

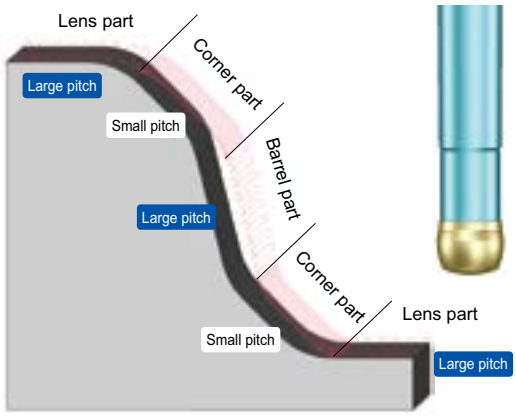
Ra=9.74μm
Rz=34.6μm

v_c=500m/min、f_z=0.4mm/t、v_f=7,640mm/min、
a_p=0.5mm、Cusp height=0.02mm、wet、
DC=25mm、Simultaneous 5-axis machining
Heal angle：10° Fixed
GF3L25M-3-M12／TPHW1303-25 PN215

High efficiency finishing possible by using GF3L type.

Field data

Three-axis machining of auto mobile C pillar outer plate model GP1LB



Combining high efficiency and high quality machining

Work material : H13 (43HRC) Machine : BT50 class
CAD/CAM : tebis

Roughing①: About 4 hours.

- ϕ42mm High feed tool TD4N type

Roughing②: About 50 min.

- ϕ20mm Ball end mill BCF type

Semi-finishing・finishing : About 8 hours.

- ϕ20mm Ball end mill ABPF type
- ϕ20mm GALLEA GP1LB type ZPHW200-LB PN215
- ϕ16mm Ball end mill ABPF type
- ϕ10mm Ball end mill EMBE
- ϕ6mm Ball end mill EMBE

Total cutting time : About 13 hours

After roughing

Unequal part after roughing process can be machined at 1.4 times the rate of a conventional ball end mill.

Surface roughness improved by 40% with the same processing time as conventional ball end mill.

After finishing

Three-axis machining of automobile door panel model GP1LB

By separately using the GALLEA series and conventional tool, you can process the rest of fillets speedy and with high quality.
For high hardened steel, GP1LB can process the part at 1.4 times the rate of a conventional ball end mill of the same diameter.

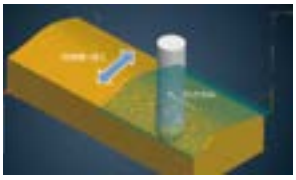
Work material : D2 Modified (60HRC) Machine : BT40 class
CAD/CAM : WorkNC

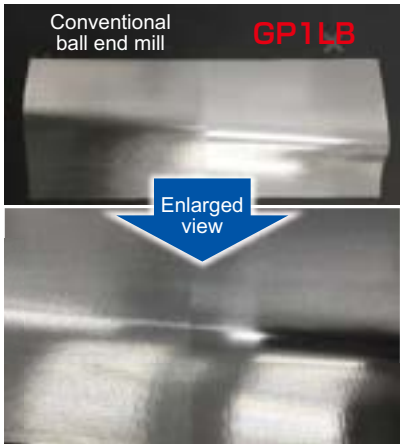
Process		Tool	Cutting speed *vc* (m/min)	Revolution *n* (min^{-1})	Feed per tooth *fz* (mm/t)	Feed rate *vf* (mm/min)	Depth of cut *ap* (mm)	Depth of cut *ae* (mm)	Cusp height (μm)	Removal stock (mm)	Coolant
Roughing		RH2P1016S-4 EPHW0402TN-2 JP4105	65	1,290	0.3	1,540	0.1	6.5	–	0.2	Air-blow
Semi-finishing	All	GP1LB20M-M10 ZPHW200-LB20 TH308	200	3,183	0.2	1,273	0.05	1.0	6	0.1	Air-blow
	Corner etc.	EHHB4080-ATH	136	5,400	0.09	1,905	0.3	0.6	11	0.1	Air-blow
	Corner etc.	EHHB4050-ATH	135	8,600	0.05	1,840	0.2	0.4	8	0.1	Air-blow
Finishing	All	GP1LB20M-M10 ZPHW200-LB20 TH308	200	3,183	0.2	1,273	0.05	0.57	2	0	Air-blow
	Corner etc.	EHHB4080-ATH	161	6,400	0.08	2,050	0.05	0.25	2	0	Air-blow
	Corner etc.	EHHB4050-ATH	160	10,200	0.05	1,980	0.05	0.20	2	0	Air-blow

Total cutting time : About 4 hours

Comparison of machined surface with the same pick. GP1LB

Work material：Ductile Cast Iron
Tool：GP1LB30M-M16　ZPHW300-LB TH308
Conventional ball end mill φ30mm
n=6,000min^{-1} v_c=565m/min
v_f=6,000mm/min
Pitch =0.6mm　Removal stock =0.1mm





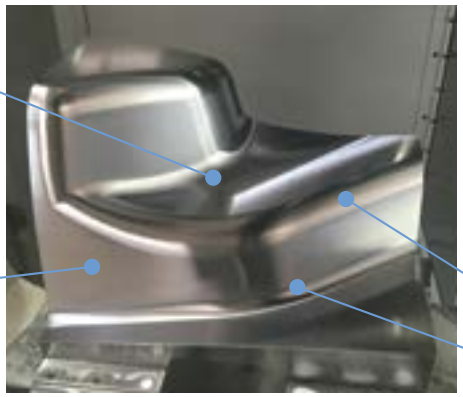
Conventional ball end mill	GP1LB
Ra:0.8μm　Rz:4.66μm	Ra:0.36μm　Rz:2.42μm

Surface roughness is about 1/2 of the ball end mill.

Part of door-inner model for automobile (3-Axis) GP1LB

Gentle sloped surface
Using lens R
Ra0.234μm

Steep sloped surface
Using barrel R
Ra0.279μm



POINT

Combination of lens tool and barrel tool steep-slope and gentle-slope can be finished with single tool

About 1.3 times as compared with conventional ball end mill

Work material：P21 (42HRC)
Machine：BT40 class　CAD/CAM：FF CAM

For fillet processing, use connection-R edge.

Corner R was processed using ball end mill.
Processing is completed. there is no connecting step on the surface.

Process		Tool	Tool dia.	Cutting conditions						
				v_c (m/min)	n (mm^{-1})	v_f (mm/min)	f_z (mm/t)	Pitch (mm)	Cutting amount (mm/t)	Coolant
Semi-finishing	Gentle sloped surface	GP1LB16M-M8 ZPHW160-LB16 PN215 (Lens R:16, Barrel R:16)	16	231	4,600	1,840	0.2	1.6	0.15	Mist
	Steep sloped surface		16	181	3,600	1,440	0.2	1.6	0.15	Mist
Finishing	Gentle sloped surface		16	231	4,600	1,840	0.2	0.25	0.05	Mist
	Steep sloped surface		16	181	3,600	1,440	0.2	0.25	0.05	Mist

Safety Considerations

1. Handling
(1) When removing tool from packaging, be careful not to drop the tool on your foot or fingers.
(2) When actually setting the inserts, be careful not to touch the cutting flute directly with your bare hands.

2. Mounting
(1) When preparing to use, be sure that the insert is firmly screwed in the pocket and cutter is properly mounted on the tool holder.
(2) If abnormal chattering occurs during use, stop the machine immediately, identify the cause of the chatter and take corrective action.

3. Usage
(1) Before use confirm all dimensions, verify work material and programmed tool rotation.
(2) The numerical values in the standard cutting conditions table should be used as criteria when starting new work. The cutting conditions should be adjusted as appropriate when the cutting depth is large, the rigidity of the machine being used is low, or according to the conditions of the work material.
(3) Inserts are made of hard material and may break and be expelled from cutter at high speeds. Since there is a danger of injury to workers from chip evacuation, insert breakage or fire safety precautions must be observed at all times. Including, but not limited to: safety glasses, machine enclosures or other means to create a safe environment for work. If you have questions on safety, contact your supervisor.
・Do not use where there is a risk of fire or explosion.
・Do not use non-water-soluble cutting oils. Such oils may result in fire.
(4) Do not use the tool for any purpose other than that for which it is intended, and do not modify it.

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