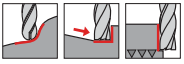


Ball nose end mills G-Mold μ 65 B

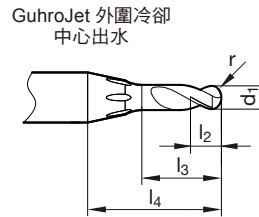
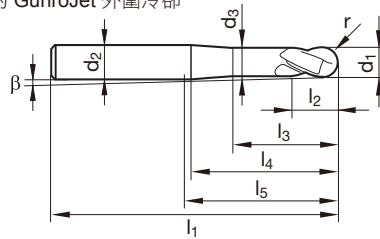


P	○
M	○
K	●
N	○
S	○
H	●

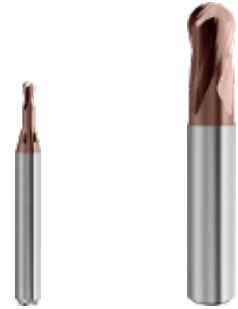
GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- High-precision ball nose end mills for maximum form accuracy
- exact tolerance of the radius contour $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing tolerance $d1$ of $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- with GühroJet peripheral cooling from $\varnothing 0.2\text{-}3 \text{ mm}$
- centre cutting
- neck clearance
- 高精度球型銑刀，確保最高形狀精度
- 半徑輪廓的精確公差 $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing 公差 $d1$ 從 $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- 帶有 $\varnothing 0.2\text{-}3 \text{ mm}$ 的 GühroJet 外圍冷卻
- 端刀過中心可切削
- 頸部縮頸研磨



HRC 65u
2刃球刀



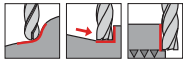
Article no. **6815**

d1 _{-0,005 -0,015}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.20	4.00	0.18	50	0.2	0.50	9.2	22.0	0.10	11.80	2	6815 0.200	1,120
0.30	4.00	0.28	50	0.3	0.75	9.1	22.0	0.15	11.60	2	6815 0.300	1,120
0.40	4.00	0.38	50	0.4	1.00	9.1	22.0	0.20	11.40	2	6815 0.400	1,120
0.50	4.00	0.45	50	0.5	1.25	9.2	22.0	0.25	11.00	2	6815 0.500	1,120
0.60	4.00	0.55	50	0.6	1.50	9.2	22.0	0.30	10.80	2	6815 0.600	1,120
0.80	4.00	0.75	50	0.8	2.00	9.1	22.0	0.40	10.40	2	6815 0.800	1,120
1.00	4.00	0.92	50	1.0	2.50	9.2	22.0	0.50	9.70	2	6815 1.000	1,120
1.20	4.00	1.12	50	1.2	3.00	9.3	22.0	0.60	9.10	2	6815 1.200	1,120
1.50	4.00	1.40	50	1.5	4.00	9.6	22.0	0.75	8.00	2	6815 1.500	1,120
1.80	4.00	1.70	50	1.8	4.50	9.4	22.0	0.90	7.30	2	6815 1.800	1,120
2.00	6.00	1.85	50	2.0	5.00	14.2	14.0	1.00	8.60	2	6815 2.000	1,240
2.50	6.00	2.35	50	2.5	6.50	14.6	15.0	1.25	7.40	2	6815 2.500	1,240
3.00	6.00	2.85	50	3.0	7.50	14.4	14.0	1.50	6.60	2	6815 3.000	1,240
4.00	6.00	3.80	50	4.0	12.50	15.5	14.0	2.00	4.20	2	6815 4.000	1,240
5.00	6.00	4.80	50	5.0	15.00	16.6	14.0	2.50	2.00	2	6815 5.000	1,240
6.00	6.00	5.70	54	6.0	17.00	17.6	18.0	3.00		2	6815 6.000	1,240
8.00	8.00	7.70	58	8.0	22.00	22.6	22.0	4.00		2	6815 8.000	1,480
10.00	10.00	9.50	72	10.0	25.00	25.9	32.0	5.00		2	6815 10.000	2,020
12.00	12.00	11.50	73	12.0	30.00	30.9	28.0	6.00		2	6815 12.000	2,740



Ball nose end mills G-Mold μ 65 B

鑄鐵/ 高硬度短屑材質用

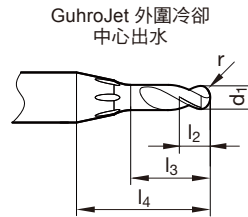
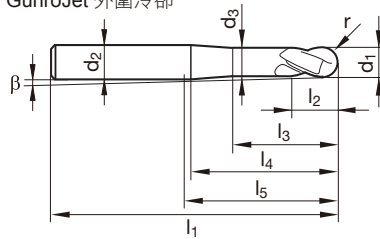


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H	●

GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- High-precision ball nose end mills for maximum form accuracy
- exact tolerance of the radius contour $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing tolerance $d1$ of $\varnothing 0.2\text{-}3 \text{ mm} +0.000\text{-}0.010 \text{ mm}$
- with GühroJet peripheral cooling from $\varnothing 0.2\text{-}3 \text{ mm}$
- centre cutting
- neck clearance
- 高精度球型銑刀，確保最高形狀精度
- 半徑輪廓的精確公差 $r = 0,5 \times d1 \pm 0,005 \text{ mm}$
- \varnothing 公差 $d1$ 從 $\varnothing 0.2\text{-}3 \text{ mm} +0.000\text{-}0.010 \text{ mm}$
- 帶有 $\varnothing 0.2\text{-}3 \text{ mm}$ 的 GühroJet 外圍冷卻
- 端刃過中心可切削
- 頸部縮頸研磨



HRC 65u
2刃球刀

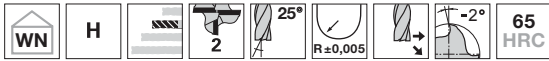


Milling tools

Article no. **6816**

$d1_{-0,015}^{-0,005}$	$d2_{h5}$	$d3$	$l1$	$l2$	$l3$	$l4$	$l5$	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.20	4.00	0.18	50	0.2	0.75	9.5	22.0	0.10	11.40	2	6816 0.200	1,160
0.30	4.00	0.28	50	0.3	1.00	9.4	22.0	0.15	11.30	2	6816 0.300	1,160
0.40	4.00	0.38	50	0.4	1.50	9.6	22.0	0.20	10.80	2	6816 0.400	1,160
0.50	4.00	0.45	50	0.5	1.50	9.5	22.0	0.25	10.70	2	6816 0.500	1,160
0.60	4.00	0.55	50	0.6	2.00	9.7	22.0	0.30	10.20	2	6816 0.600	1,160
0.80	4.00	0.75	50	0.8	3.00	10.1	22.0	0.40	9.30	2	6816 0.800	1,160
1.00	4.00	0.92	50	1.0	3.00	9.7	22.0	0.50	9.20	2	6816 1.000	1,160
1.20	4.00	1.12	50	1.2	4.00	10.3	22.0	0.60	8.20	2	6816 1.200	1,160
1.50	4.00	1.40	50	1.5	6.00	11.6	22.0	0.75	6.50	2	6816 1.500	1,160
1.80	4.00	1.70	50	1.8	6.00	10.9	22.0	0.90	6.20	2	6816 1.800	1,160
2.00	6.00	1.85	50	2.0	6.00	15.2	15.0	1.00	8.00	2	6816 2.000	1,290
2.50	6.00	2.35	50	2.5	8.00	16.1	16.0	1.25	6.70	2	6816 2.500	1,290
3.00	6.00	2.85	57	3.0	10.00	16.9	21.0	1.50	5.50	2	6816 3.000	1,290
4.00	6.00	3.80	57	4.0	14.00	17.0	21.0	2.00	3.80	2	6816 4.000	1,290
5.00	6.00	4.80	57	5.0	18.00	19.6	21.0	2.50	1.60	2	6816 5.000	1,290
6.00	6.00	5.70	57	6.0	20.00	20.6	21.0	3.00		2	6816 6.000	1,290
8.00	8.00	7.70	63	8.0	26.00	26.6	27.0	4.00		2	6816 8.000	1,540
10.00	10.00	9.50	72	10.0	31.00	31.9	32.0	5.00		2	6816 10.000	2,090
12.00	12.00	11.50	83	12.0	37.00	37.9	38.0	6.00		2	6816 12.000	2,830

Ball nose end mills G-Mold μ 65 B

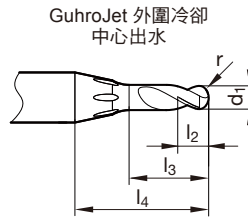
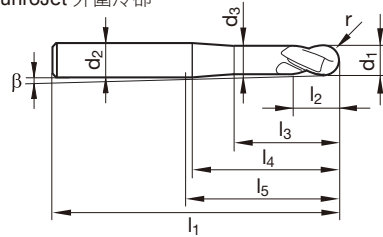


P	○
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K	●
N	○
S	○
H	●

GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- High-precision ball nose end mills for maximum form accuracy
- exact tolerance of the radius contour $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing tolerance $d1$ of $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- with GühroJet peripheral cooling from $\varnothing 0.2\text{-}3 \text{ mm}$
- centre cutting
- neck clearance
- 高精度球型銑刀，確保最高形狀精度
- 半徑輪廓的精確公差 $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing 公差 $d1$ 從 $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- 帶有 $\varnothing 0.2\text{-}3 \text{ mm}$ 的 GühroJet 外圍冷卻
- 端刀過中心可切削
- 頸部縮頸研磨



HRC 65u
2刃球刀



Article no.

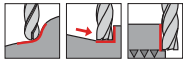
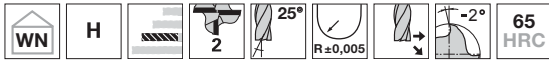
6817

$d1_{-0.005/-0.015}$	$d2 \text{ h5}$	$d3$	$l1$	$l2$	$l3$	$l4$	$l5$	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.20	4.00	0.18	50	0.2	1.0	9.7	22.0	0.10	11.20	2	6817 0.200	1,200
0.30	4.00	0.28	50	0.3	1.5	9.9	22.0	0.15	10.70	2	6817 0.300	1,200
0.40	4.00	0.38	50	0.4	2.0	10.1	22.0	0.20	10.30	2	6817 0.400	1,200
0.50	4.00	0.45	50	0.5	2.5	10.5	22.0	0.25	9.60	2	6817 0.500	1,200
0.60	4.00	0.55	50	0.6	3.0	10.7	22.0	0.30	9.20	2	6817 0.600	1,200
0.80	4.00	0.75	50	0.8	4.0	11.1	22.0	0.40	8.50	2	6817 0.800	1,200
1.00	4.00	0.92	50	1.0	5.0	11.7	22.0	0.50	7.60	2	6817 1.000	1,200
1.20	4.00	1.12	50	1.2	6.0	12.3	22.0	0.60	6.80	2	6817 1.200	1,200
1.50	4.00	1.40	50	1.5	8.0	13.6	22.0	0.75	5.50	2	6817 1.500	1,200
1.80	4.00	1.70	50	1.8	9.0	13.9	22.0	0.90	4.80	2	6817 1.800	1,200
2.00	6.00	1.85	50	2.0	10.0	19.2	19.0	1.00	6.20	2	6817 2.000	1,330
2.50	6.00	2.35	50	2.5	12.5	20.6	21.0	1.25	5.10	2	6817 2.500	1,330
3.00	6.00	2.85	65	3.0	15.0	21.9	29.0	1.50	4.20	2	6817 3.000	1,330
4.00	6.00	3.80	65	4.0	20.0	23.0	29.0	2.00	2.70	2	6817 4.000	1,330
5.00	6.00	4.80	65	5.0	25.0	26.6	29.0	2.50	1.10	2	6817 5.000	1,330
6.00	6.00	5.70	65	6.0	25.0	25.6	29.0	3.00		2	6817 6.000	1,330
8.00	8.00	7.70	75	8.0	30.0	30.6	39.0	4.00		2	6817 8.000	1,590
10.00	10.00	9.50	90	10.0	40.0	40.9	50.0	5.00		2	6817 10.000	2,160
12.00	12.00	11.50	100	12.0	40.0	40.9	55.0	6.00		2	6817 12.000	2,930



Ball nose end mills G-Mold μ 65 B

鑄鐵/ 高硬度短屑材質用

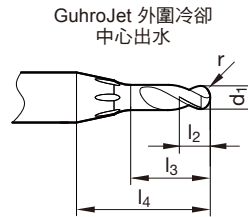
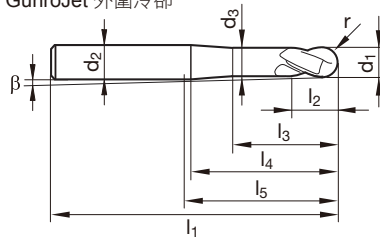


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N	
S	
H	●

GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- High-precision ball nose end mills for maximum form accuracy
- exact tolerance of the radius contour $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing tolerance $d1$ of $\varnothing 0.2\text{-}3 \text{ mm} +0.000\text{-}0.010 \text{ mm}$
- with GühroJet peripheral cooling from $\varnothing 0.2\text{-}3 \text{ mm}$
- centre cutting
- neck clearance
- 高精度球型銑刀，確保最高形狀精度
- 半徑輪廓的精確公差 $r = 0,5 \times d1 \pm 0,005 \text{ mm}$
- \varnothing 公差 $d1$ 從 $\varnothing 0.2\text{-}3 \text{ mm} +0.000\text{-}0.010 \text{ mm}$
- 帶有 $\varnothing 0.2\text{-}3 \text{ mm}$ 的 GühroJet 外圍冷卻
- 端刃過中心可切削
- 頸部縮頸研磨



HRC 65u
2刃球刀

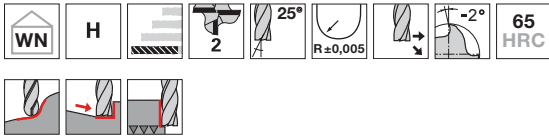


Milling tools

Article no. **6818**

d1 ^{-0,005} _{-0,015}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.20	4.00	0.18	50	0.2	1.25	10.0	22.0	0.10	10.80	2	6818 0.200	1,410
0.30	4.00	0.28	50	0.3	2.00	10.4	22.0	0.15	10.20	2	6818 0.300	1,410
0.40	4.00	0.38	50	0.4	3.00	11.1	22.0	0.20	9.30	2	6818 0.400	1,410
0.50	4.00	0.45	50	0.5	3.00	11.0	22.0	0.25	9.20	2	6818 0.500	1,410
0.60	4.00	0.55	50	0.6	4.00	11.7	22.0	0.30	8.40	2	6818 0.600	1,410
0.80	4.00	0.75	50	0.8	5.00	12.1	22.0	0.40	7.70	2	6818 0.800	1,410
1.00	4.00	0.92	50	1.0	7.00	13.7	22.0	0.50	6.40	2	6818 1.000	1,410
1.20	4.00	1.12	50	1.2	8.00	14.3	22.0	0.60	5.80	2	6818 1.200	1,410
1.50	4.00	1.40	50	1.5	10.00	15.6	22.0	0.75	4.80	2	6818 1.500	1,410
1.80	4.00	1.70	55	1.8	12.00	16.9	27.0	0.90	3.90	2	6818 1.800	1,410
2.00	6.00	1.85	57	2.0	12.00	21.2	21.0	1.00	5.60	2	6818 2.000	1,560
2.50	6.00	2.35	57	2.5	15.00	23.1	23.0	1.25	4.50	2	6818 2.500	1,560
3.00	6.00	2.85	65	3.0	18.00	24.9	29.0	1.50	3.60	2	6818 3.000	1,560
4.00	6.00	3.80	65	4.0	24.00	27.0	29.0	2.00	2.30	2	6818 4.000	1,560
5.00	6.00	4.80	80	5.0	30.00	31.6	44.0	2.50	0.90	2	6818 5.000	1,560
6.00	6.00	5.70	80	6.0	30.00	30.6	44.0	3.00		2	6818 6.000	1,560
8.00	8.00	7.70	90	8.0	40.00	40.6	54.0	4.00		2	6818 8.000	1,860
10.00	10.00	9.50	100	10.0	50.00	50.9	60.0	5.00		2	6818 10.000	2,530
12.00	12.00	11.50	120	12.0	60.00	60.9	75.0	6.00		2	6818 12.000	3,430

Ball nose end mills G-Mold μ 65 B

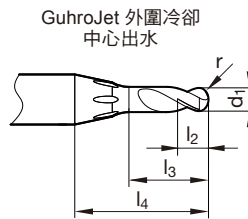
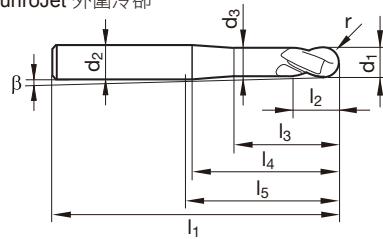


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K	●
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H	●

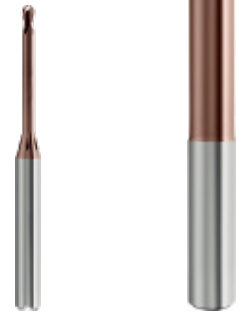
GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- High-precision ball nose end mills for maximum form accuracy
- exact tolerance of the radius contour $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing tolerance $d1$ of $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- with GühroJet peripheral cooling from $\varnothing 0.2\text{-}3 \text{ mm}$
- centre cutting
- neck clearance
- 高精度球型銑刀，確保最高形狀精度
- 半徑輪廓的精確公差 $r = 0.5 \times d1 \pm 0.005 \text{ mm}$
- \varnothing 公差 $d1$ 從 $\varnothing 0.2\text{-}3 \text{ mm} +0.000/-0.010 \text{ mm}$
- 帶有 $\varnothing 0.2\text{-}3 \text{ mm}$ 的 GühroJet 外圍冷卻
- 端刀過中心可切削
- 頸部縮頸研磨



HRC 65u
2刃球刀



Tool material	Solid carbide
Surface	X
Type	H
Shank form	HA

Article no.

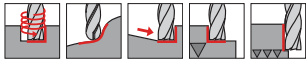
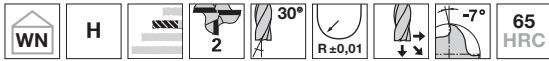
6819

d1 _{-0.005} 0.015	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.20	4.00	0.18	50	0.2	1.5	10.2	22.0	0.10	10.60	2	6819 0.200	1,450
0.30	4.00	0.28	50	0.3	3.0	11.4	22.0	0.15	9.30	2	6819 0.300	1,450
0.40	4.00	0.38	50	0.4	4.0	12.1	22.0	0.20	8.60	2	6819 0.400	1,450
0.50	4.00	0.45	50	0.5	5.0	13.0	22.0	0.25	7.80	2	6819 0.500	1,450
0.60	4.00	0.55	50	0.6	6.0	13.7	22.0	0.30	7.20	2	6819 0.600	1,450
0.80	4.00	0.75	50	0.8	8.0	15.1	22.0	0.40	6.20	2	6819 0.800	1,450
1.00	4.00	0.92	50	1.0	10.0	16.7	22.0	0.50	5.30	2	6819 1.000	1,450
1.20	4.00	1.12	55	1.2	12.0	18.3	27.0	0.60	4.50	2	6819 1.200	1,450
1.50	4.00	1.40	55	1.5	16.0	21.6	27.0	0.75	3.40	2	6819 1.500	1,450
1.80	4.00	1.70	63	1.8	20.0	24.9	35.0	0.90	2.60	2	6819 1.800	1,450
2.00	6.00	1.85	65	2.0	20.0	29.2	29.0	1.00	4.00	2	6819 2.000	1,610
2.50	6.00	2.35	65	2.5	20.0	28.1	29.0	1.25	3.70	2	6819 2.500	1,610
3.00	6.00	2.85	70	3.0	25.0	31.9	34.0	1.50	2.80	2	6819 3.000	1,610
4.00	6.00	3.80	75	4.0	32.0	35.0	39.0	2.00	1.70	2	6819 4.000	1,610
5.00	6.00	4.80	80	5.0	42.0	43.6	44.0	2.50	0.70	2	6819 5.000	1,610
6.00	6.00	5.70	100	6.0	40.0	40.6	64.0	3.00		2	6819 6.000	1,610
8.00	8.00	7.70	100	8.0	40.0	40.6	64.0	4.00		2	6819 8.000	1,920



Ball nose end mills G-Mold 65 B

鑄鐵/ 高硬度短屑材質用



P	○
M	
K	●
N	
S	
H	●

GÜHRING NAVIGATOR

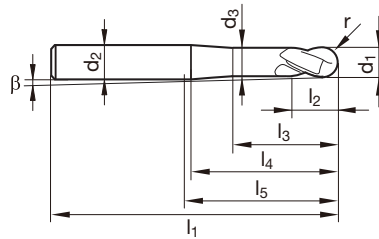
Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	H
Shank form	HA



HRC 65
2刃球刀



Article no.

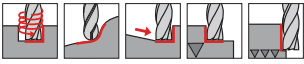
6832

d1 ^{-0,01 -0,03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	45	0.5	2.5	9.1	17.0	0.25	10.80	2	6832 0.500	660
0.80	4.00	0.75	45	0.8	3.2	9.3	17.0	0.40	9.70	2	6832 0.800	660
1.00	4.00	0.92	45	1.0	4.0	9.7	17.0	0.50	8.70	2	6832 1.000	660
1.50	4.00	1.40	45	1.5	6.0	10.9	17.0	0.75	6.50	2	6832 1.500	660
2.00	6.00	1.85	54	2.0	8.0	13.7	18.0	1.00	8.30	2	6832 2.000	730
3.00	6.00	2.85	54	3.0	12.0	16.3	18.0	1.50	5.20	2	6832 3.000	730
4.00	6.00	3.80	57	4.0	14.0	17.0	21.0	2.00	3.30	2	6832 4.000	730
5.00	6.00	4.80	57	5.0	17.0	18.6	21.0	2.50	1.50	2	6832 5.000	730
6.00	6.00	5.70	57	6.0	20.0	20.6	21.0	3.00		2	6832 6.000	730
8.00	8.00	7.70	63	8.0	26.0	26.6	27.0	4.00		2	6832 8.000	870
10.00	10.00	9.50	72	10.0	31.0	31.9	32.0	5.00		2	6832 10.000	1,180
12.00	12.00	11.50	83	12.0	37.0	37.9	38.0	6.00		2	6832 12.000	1,600

Milling tools

Ball nose end mills G-Mold 65 B

鑄鐵/ 高硬度短屑材質用



P	○
M	○
K	●
N	○
S	○
H	●

GÜHRING NAVIGATOR

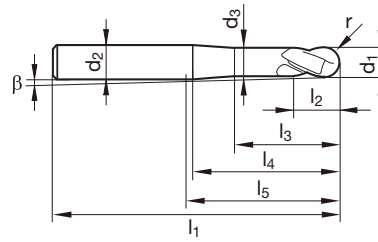
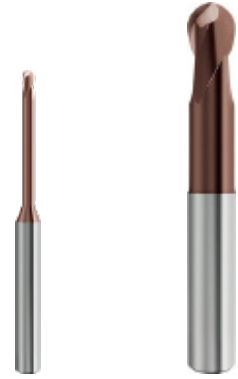
Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刀過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	H
Shank form	HA



HRC 65
2刃球刀



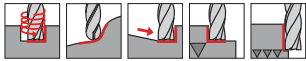
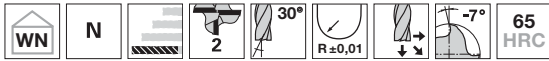
Article no. **6833**

d1 ^{-0.01} / _{-0.03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	50	0.5	3.6	10.2	22.0	0.25	9.70	2	6833 0.500	750
0.80	4.00	0.75	50	0.8	5.0	11.1	22.0	0.40	8.20	2	6833 0.800	750
1.00	4.00	0.92	50	1.0	6.5	12.2	22.0	0.50	7.00	2	6833 1.000	750
1.50	4.00	1.40	50	1.5	10.0	14.9	22.0	0.75	4.80	2	6833 1.500	750
2.00	6.00	1.85	57	2.0	13.0	18.7	21.0	1.00	6.10	2	6833 2.000	840
3.00	6.00	2.85	65	3.0	20.0	24.3	29.0	1.50	3.50	2	6833 3.000	840
4.00	6.00	3.80	75	4.0	25.0	28.0	39.0	2.00	2.00	2	6833 4.000	840
5.00	6.00	4.80	75	5.0	31.0	32.6	39.0	2.50	0.80	2	6833 5.000	840
6.00	6.00	5.70	75	6.0	38.0	38.6	39.0	3.00		2	6833 6.000	840
8.00	8.00	7.70	90	8.0	53.0	53.6	54.0	4.00		2	6833 8.000	1,000
10.00	10.00	9.50	100	10.0	59.0	59.9	60.0	5.00		2	6833 10.000	1,360
12.00	12.00	11.50	120	12.0	74.0	74.9	75.0	6.00		2	6833 12.000	1,840



Ball nose end mills G-Mold 65 B

鑄鐵/ 高硬度短屑材質用

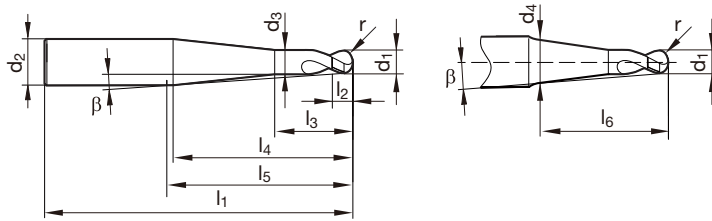


P	○
M	
K	●
N	
S	
H	●

GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刃過中心可切削
- 頸部縮頸研磨



Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 65
2刃球刀



Milling tools

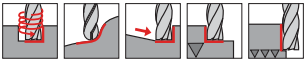
Article no.

6834

d1 ^{-0,01} _{-0,03}	d2 h5	d3	d4	l1	l2	l3	l4	l5	l6	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	1.47	50	0.5	1.3	14.7	22.0	10.0	0.25	3.00	2	6834 0.500	820
0.80	4.00	0.75	2.38	50	0.8	2.0	19.0	22.0	16.0	0.40	3.00	2	6834 0.800	820
1.00	4.00	0.92	2.99	63	1.0	2.5	21.9	35.0	20.0	0.50	3.00	2	6834 1.000	820
1.50	4.00	1.40		63	1.5	3.8	25.6	35.0		0.75	3.00	2	6834 1.500	820
2.00	6.00	1.85		80	2.0	5.0	40.1	44.0		1.00	3.00	2	6834 2.000	910
3.00	6.00	2.85		80	3.0	7.5	31.1	44.0		1.50	3.00	2	6834 3.000	910
4.00	6.00	3.80		80	4.0	10.0	22.0	44.0		2.00	3.00	2	6834 4.000	910
5.00	8.00	4.80		90	5.0	12.5	32.1	54.0		2.50	3.00	2	6834 5.000	1,090
6.00	8.00	5.70		90	6.0	15.0	43.1	54.0		3.00	1.50	2	6834 6.000	1,090
8.00	10.00	7.70		100	8.0	20.0	44.1	60.0		4.00	1.50	2	6834 8.000	1,470
10.00	12.00	9.50		120	10.0	25.0	45.1	75.0		5.00	1.50	2	6834 10.000	2,000

Ball nose end mills G-Mold 65 B

鑄鐵/ 高硬度短屑材質用



P	○
M	○
K	●
N	○
S	○
H	●

GÜHRING NAVIGATOR

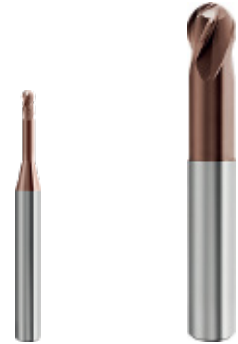
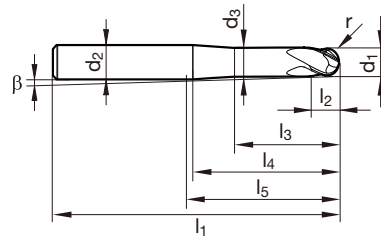
Cutting data page 55-58 切削參數請參閱 55-58頁

- 4 face cutting edges up to the centre
- neck clearance
- centre cutting
- 4 切削刃到中心
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	H
Shank form	HA



HRC 65
4刃球刀



Article no. **6835**

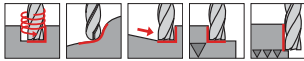
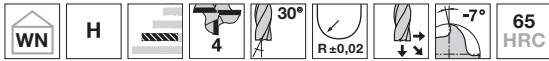
d1 ^{-0.01} _{-0.03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z
mm	mm	mm	mm	mm	mm	mm	mm	mm	°	
1.00	4.00	0.92	45	1.0	4.0	9.7	17.0	0.50	8.70	4
1.50	4.00	1.40	45	1.5	6.0	10.9	17.0	0.75	6.50	4
2.00	6.00	1.85	54	2.0	8.0	13.7	18.0	1.00	8.30	4
3.00	6.00	2.85	54	3.0	12.0	16.3	18.0	1.50	5.20	4
4.00	6.00	3.80	57	4.0	14.0	17.0	21.0	2.00	3.30	4
5.00	6.00	4.80	57	5.0	17.0	18.6	21.0	2.50	1.50	4
6.00	6.00	5.70	57	6.0	20.0	20.6	21.0	3.00		4
8.00	8.00	7.70	63	8.0	26.0	26.6	27.0	4.00		4
10.00	10.00	9.50	72	10.0	31.0	31.9	32.0	5.00		4
12.00	12.00	11.50	83	12.0	37.0	37.9	38.0	6.00		4

Order no.	價格
6835 1.000	750
6835 1.500	750
6835 2.000	840
6835 3.000	840
6835 4.000	840
6835 5.000	840
6835 6.000	840
6835 8.000	1,000
6835 10.000	1,360
6835 12.000	1,840



Ball nose end mills G-Mold 65 B

鑄鐵/ 高硬度短屑材質用



P	○
M	
K	●
N	
S	
H	●

GÜHRING NAVIGATOR

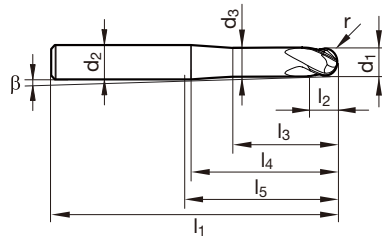
Cutting data page 55-58 切削參數請參閱 55-58頁

- 4 face cutting edges up to the centre
- neck clearance
- centre cutting
- 4 切削刃到中心
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	H
Shank form	HA



HRC 65
4刃球刀



Article no. **6836**

$d1_{-0,03}^{+0,01}$	$d2_{h5}$	$d3$	$l1$	$l2$	$l3$	$l4$	$l5$	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
1.00	4.00	0.92	50	1.0	6.5	12.2	25.0	0.50	7.00	4	6836 1.000	850
1.50	4.00	1.40	50	1.5	10.0	14.9	25.5	0.75	4.80	4	6836 1.500	850
2.00	6.00	1.85	57	2.0	13.0	18.7	29.5	1.00	6.10	4	6836 2.000	950
3.00	6.00	2.85	65	3.0	20.0	24.3	34.5	1.50	3.50	4	6836 3.000	950
4.00	6.00	3.80	75	4.0	25.0	28.0	40.6	2.00	2.00	4	6836 4.000	950
5.00	6.00	4.80	75	5.0	31.0	32.6	41.6	2.50	0.80	4	6836 5.000	950
6.00	6.00	5.70	75	6.0	38.0	38.6	39.0	3.00		4	6836 6.000	950
8.00	8.00	7.70	90	8.0	53.0	53.6	54.0	4.00		4	6836 8.000	1,130
10.00	10.00	9.50	100	10.0	59.0	59.9	60.0	5.00		4	6836 10.000	1,530
12.00	12.00	11.50	120	12.0	74.0	74.9	75.0	6.00		4	6836 12.000	2,080

Milling tools



Solid carbide milling cutters

短柄型 G-Mold 55B 球刀

Ball nose end mills G-Mold 55 B short shank

Article no. **6166**

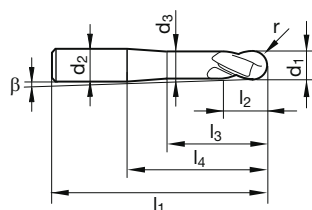


You can find cutting data in our online navigator at <https://webnavigator.guehring.de>.



neck clearance • centre cutting

P	M	K	N	S	H
•	•	•	○	•	•



加工長

編號 : **6166**

d1 h10 mm	d2 h5 mm	d3 mm	l1 mm	l2 mm	l3 mm	l4 mm	r mm	β °	Z	Price
0.50	4.00	0.45	33	0.5	2.5	9.1	0.25	11.10	2	2,500
0.80	4.00	0.75	33	0.8	3.2	9.3	0.40	10.20	2	2,500
1.00	4.00	0.92	33	1.0	4.0	9.7	0.50	9.20	2	2,500
1.50	4.00	1.40	33	1.5	6.0	10.9	0.75	7.00	2	2,500
2.00	6.00	1.85	38	2.0	8.0	13.7	1.00	8.90	2	2,700
3.00	6.00	2.85	38	3.0	12.0	16.3	1.50	5.70	2	2,700

短柄型 G-Mold 55B 球刀 頸部加長型

Ball nose end mills G-Mold 55 B short shank

Article no. **6167**

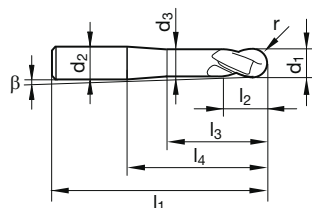


You can find cutting data in our online navigator at <https://webnavigator.guehring.de>.



neck clearance • centre cutting

P	M	K	N	S	H
•	•	•	○	•	•



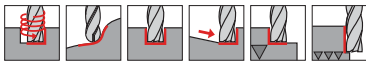
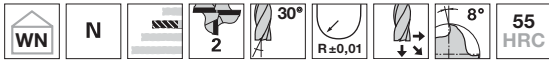
加工長

編號 : **6167**

d1 h10 mm	d2 h5 mm	d3 mm	l1 mm	l2 mm	l3 mm	l4 mm	r mm	β °	Z	Price
0.50	4.00	0.45	33	0.5	3.6	10.2	0.25	9.90	2	2,800
0.80	4.00	0.75	33	0.8	5.0	11.1	0.40	8.50	2	2,800
1.00	4.00	0.92	36	1.0	6.5	12.2	0.50	7.30	2	2,800
1.50	4.00	1.40	38	1.5	10.0	14.9	0.75	5.00	2	2,800
2.00	6.00	1.85	43	2.0	13.0	18.7	1.00	6.40	2	3,200
3.00	6.00	2.85	48	3.0	20.0	24.3	1.50	3.70	2	3,200

Ball nose end mills G-Mold 55 B

泛用型



- P** •
- M** •
- K** •
- N** ○
- S** •
- H** •

GÜHRING NAVIGATOR

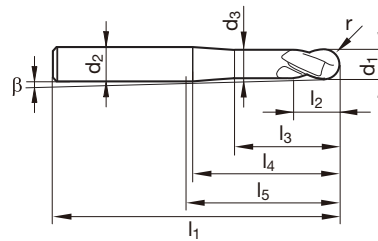
Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刀過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 55
2刃球刀



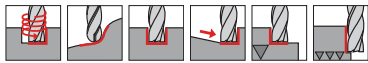
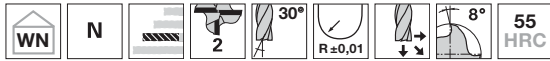
Article no. **6844**

d1 ^{-0,01} / _{-0,03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	45	0.5	2.5	9.1	17.0	0.25	10.80	2	6844 0.500	660
0.80	4.00	0.75	45	0.8	3.2	9.3	17.0	0.40	9.70	2	6844 0.800	660
1.00	4.00	0.92	45	1.0	4.0	9.7	17.0	0.50	8.70	2	6844 1.000	660
1.50	4.00	1.40	45	1.5	6.0	10.9	17.0	0.75	6.50	2	6844 1.500	660
2.00	6.00	1.85	54	2.0	8.0	13.7	18.0	1.00	8.30	2	6844 2.000	730
3.00	6.00	2.85	54	3.0	12.0	16.3	18.0	1.50	5.20	2	6844 3.000	730
4.00	6.00	3.80	57	4.0	14.0	17.0	21.0	2.00	3.30	2	6844 4.000	730
5.00	6.00	4.80	57	5.0	17.0	18.6	21.0	2.50	1.50	2	6844 5.000	730
6.00	6.00	5.70	57	6.0	20.0	20.6	21.0	3.00		2	6844 6.000	730
8.00	8.00	7.70	63	8.0	26.0	26.6	27.0	4.00		2	6844 8.000	870
10.00	10.00	9.50	72	10.0	31.0	31.9	32.0	5.00		2	6844 10.000	1,180
12.00	12.00	11.50	83	12.0	37.0	37.9	38.0	6.00		2	6844 12.000	1,600



Ball nose end mills G-Mold 55 B

泛用型



- P** •
- M** •
- K** •
- N** ○
- S** •
- H** •

GÜHRING NAVIGATOR

Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material **Solid carbide**

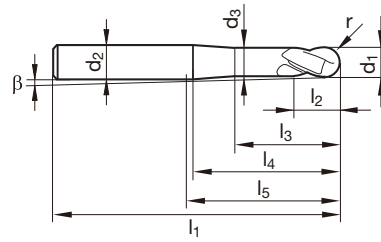
Surface

Type **N**

Shank form **HA**



HRC 55
2刃球刀



Article no.

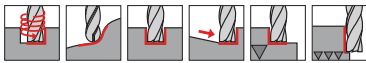
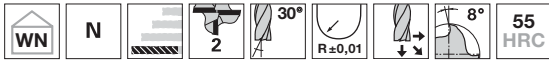
6845

d1 ^{-0,01} _{-0,03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	50	0.5	3.6	10.2	22.0	0.25	9.70	2	6845 0.500	750
0.80	4.00	0.75	50	0.8	5.0	11.1	22.0	0.40	8.20	2	6845 0.800	750
1.00	4.00	0.92	50	1.0	6.5	12.2	22.0	0.50	7.00	2	6845 1.000	750
1.50	4.00	1.40	50	1.5	10.0	14.9	22.0	0.75	4.80	2	6845 1.500	750
2.00	6.00	1.85	57	2.0	13.0	18.7	21.0	1.00	6.10	2	6845 2.000	840
3.00	6.00	2.85	65	3.0	20.0	24.3	29.0	1.50	3.50	2	6845 3.000	840
4.00	6.00	3.80	75	4.0	25.0	28.0	39.0	2.00	2.00	2	6845 4.000	840
5.00	6.00	4.80	75	5.0	31.0	32.6	39.0	2.50	0.80	2	6845 5.000	840
6.00	6.00	5.70	75	6.0	38.0	38.6	39.0	3.00		2	6845 6.000	840
8.00	8.00	7.70	90	8.0	53.0	53.6	54.0	4.00		2	6845 8.000	1,000
10.00	10.00	9.50	100	10.0	59.0	59.9	60.0	5.00		2	6845 10.000	1,360
12.00	12.00	11.50	120	12.0	74.0	74.9	75.0	6.00		2	6845 12.000	1,840

Milling tools

泛用型

Ball nose end mills G-Mold 55 B



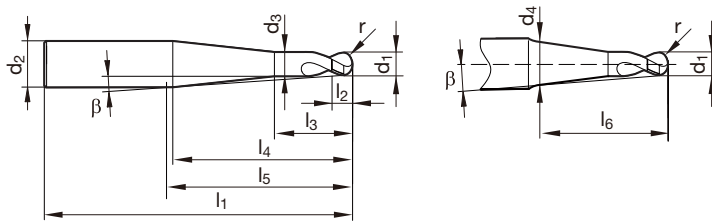
P • **GÜHRING NAVIGATOR**
M • Cutting data page 55-58 切削參數請參閱 55-58頁

- K** •
- N** ○
- S** •
- H** •
 - neck clearance
 - centre cutting
 - 端刀過中心可切削
 - 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 55
2刃球刀



Article no. **6846**

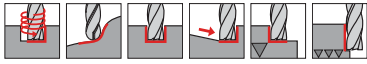
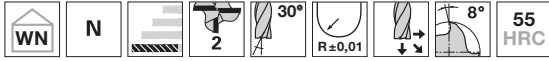
d1 _{-0.03^{0.01}}	d2 h5	d3	d4	l1	l2	l3	l4	l5	l6	r	β	Z
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	°	
0.50	4.00	0.45	0.96	50	0.5	1.3	15.7	22.0	10.0	0.25	1.50	2
0.80	4.00	0.75	1.56	50	0.8	2.0	20.5	22.0	16.0	0.40	1.50	2
1.00	4.00	0.92	1.97	63	1.0	2.5	23.8	35.0	20.0	0.50	1.50	2
1.50	4.00	1.40	2.98	63	1.5	3.8	31.9	35.0	30.0	0.75	1.50	2
2.00	6.00	1.85	3.99	80	2.0	5.0	43.7	44.0	40.0	1.00	1.50	2
3.00	6.00	2.85	4.96	80	3.0	7.5	41.9	44.0	40.0	1.50	1.50	2
4.00	6.00	3.80		80	4.0	10.0	42.1	44.0		2.00	1.50	2
5.00	8.00	4.80	6.91	90	5.0	12.5	42.0	54.0	40.0	2.50	1.50	2
6.00	8.00	5.70		90	6.0	15.0	43.1	54.0		3.00	1.50	2
8.00	10.00	7.70		100	8.0	20.0	44.1	60.0		4.00	1.50	2
10.00	12.00	9.50		120	10.0	25.0	45.1	75.0		5.00	1.50	2

Order no.	價格
6846 0.500	820
6846 0.800	820
6846 1.000	820
6846 1.500	820
6846 2.000	910
6846 3.000	910
6846 4.000	910
6846 5.000	1,090
6846 6.000	1,090
6846 8.000	1,470
6846 10.000	2,000



Ball nose end mills G-Mold 55 B

泛用型



- P •
- M •
- K •
- N ○
- S •
- H •

GÜHRING NAVIGATOR

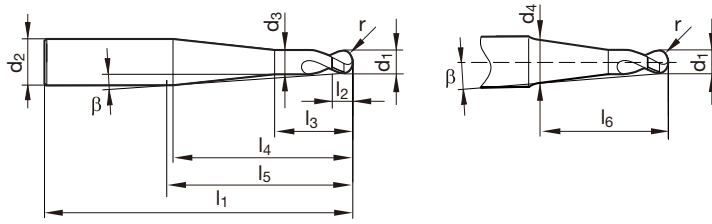
Cutting data page 55-58 切削參數請參閱 55-58頁

- neck clearance
- centre cutting
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 55
2刃球刀



Article no.

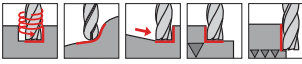
6847

d1 ^{-0,01} _{-0,03}	d2 h5	d3	d4	l1	l2	l3	l4	l5	l6	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
0.50	4.00	0.45	0.79	50	0.5	1.3	16.0	22.0	10.0	0.25	1.00	2	6847 0.500	820
0.80	4.00	0.75	1.29	50	0.8	2.0	21.0	22.0	16.0	0.40	1.00	2	6847 0.800	820
1.00	4.00	0.92	1.63	63	1.0	2.5	24.4	35.0	20.0	0.50	1.00	2	6847 1.000	820
1.50	4.00	1.40	2.47	63	1.5	3.8	32.8	35.0	30.0	0.75	1.00	2	6847 1.500	820
2.00	6.00	1.85	3.31	80	2.0	5.0	45.0	44.0	40.0	1.00	1.00	2	6847 2.000	910
3.00	6.00	2.85	4.29	80	3.0	7.5	43.2	44.0	40.0	1.50	1.00	2	6847 3.000	910
4.00	6.00	3.80	5.28	80	4.0	10.0	41.3	44.0	40.0	2.00	1.00	2	6847 4.000	910
5.00	8.00	4.80	6.61	90	5.0	12.5	52.6	54.0	50.0	2.50	1.00	2	6847 5.000	1,090
6.00	8.00	5.70	7.59	90	6.0	15.0	50.8	54.0	50.0	3.00	1.00	2	6847 6.000	1,090
8.00	10.00	7.70		100	8.0	20.0	64.2	60.0		4.00	1.00	2	6847 8.000	1,470

Milling tools

Ball nose end mills G-Mold 55 B

泛用型



- P** •
- M** •
- K** •
- N** ○
- S** •
- H** •

GÜHRING NAVIGATOR

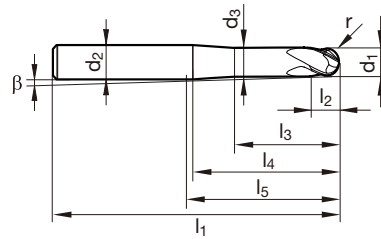
Cutting data page 55-58 切削參數請參閱 55-58頁

- 4 face cutting edges up to the centre
- neck clearance
- centre cutting
- 4 切削刃到中心
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 55
4刃球刀



Article no. **6848**

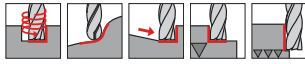
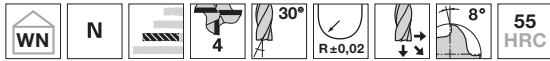
d1 ^{-0,01} _{-0,03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z
mm	mm	mm	mm	mm	mm	mm	mm	mm	°	
1.00	4.00	0.92	45	1.0	4.0	9.7	17.0	0.50	8.70	4
1.50	4.00	1.40	45	1.5	6.0	10.9	17.0	0.75	6.50	4
2.00	6.00	1.85	54	2.0	8.0	13.7	18.0	1.00	8.30	4
3.00	6.00	2.85	54	3.0	12.0	16.3	18.0	1.50	5.20	4
4.00	6.00	3.80	57	4.0	14.0	17.0	21.0	2.00	3.30	4
5.00	6.00	4.80	57	5.0	17.0	18.6	21.0	2.50	1.50	4
6.00	6.00	5.70	57	6.0	20.0	20.6	21.0	3.00		4
8.00	8.00	7.70	63	8.0	26.0	26.6	27.0	4.00		4
10.00	10.00	9.50	72	10.0	31.0	31.9	32.0	5.00		4
12.00	12.00	11.50	83	12.0	37.0	37.9	38.0	6.00		4

Order no.	價格
6848 1.000	750
6848 1.500	750
6848 2.000	840
6848 3.000	840
6848 4.000	840
6848 5.000	840
6848 6.000	840
6848 8.000	1,000
6848 10.000	1,360
6848 12.000	1,840



Ball nose end mills G-Mold 55 B

泛用型



- P •
- M •
- K •
- N ○
- S •
- H •

GÜHRING NAVIGATOR

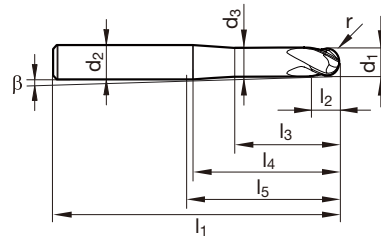
Cutting data page 55-58 切削參數請參閱 55-58頁

- 4 face cutting edges up to the centre
- neck clearance
- centre cutting
- 4 切刃到中心
- 端刃過中心可切削
- 頸部縮頸研磨

Tool material	Solid carbide
Surface	
Type	N
Shank form	HA



HRC 55
4刃球刀






Article no.

6849




d1 ^{-0,01} _{-0,03}	d2 h5	d3	l1	l2	l3	l4	l5	r	β	Z	Order no.	價格
mm	mm	mm	mm	mm	mm	mm	mm	mm	°			
1.00	4.00	0.92	50	1.0	6.5	12.2	25.0	0.50	7.00	4	6849 1.000	850
1.50	4.00	1.40	50	1.5	10.0	14.9	25.5	0.75	4.80	4	6849 1.500	850
2.00	6.00	1.85	57	2.0	13.0	18.7	29.5	1.00	6.10	4	6849 2.000	950
3.00	6.00	2.85	65	3.0	20.0	24.3	34.5	1.50	3.50	4	6849 3.000	950
4.00	6.00	3.80	75	4.0	25.0	28.0	40.5	2.00	2.00	4	6849 4.000	950
5.00	6.00	4.80	75	5.0	31.0	32.6	41.5	2.50	0.80	4	6849 5.000	950
6.00	6.00	5.70	75	6.0	38.0	38.6	39.0	3.00		4	6849 6.000	950
8.00	8.00	7.70	90	8.0	53.0	53.6	54.0	4.00		4	6849 8.000	1,130
10.00	10.00	9.50	100	10.0	59.0	59.9	60.0	5.00		4	6849 10.000	1,530
12.00	12.00	11.50	120	12.0	74.0	74.9	75.0	6.00		4	6849 12.000	2,080

Milling tools

Milling conditions:

	適合低切深 高切削速度與高進給 stable machining conditions low cutting depth, high cutting values
	短刀型刀具 short tools
	長刀型刀具 long tools

Correction factors:

	中等長度 medium length tools	切削速度/ 進給 調整 v_c -25% f_z -25%
	加長型 extra length tools	切削速度/ 進給 調整 v_c -50% f_z -50%
	中等長度 uncoated tools	切削速度/ 進給 調整 v_c -60% f_z -25%



Material	Hardness	Type	Application	a _p max.	a _e max.	v _c	f _z (mm/tooth) with nom. Ø											
							1	2	3	4	5	6	8	10	12			
Struct./free-cutting steels, unall. heat-treat/case hard. steels 1.0035 S185, 1.0486 P275N, 1.0345 P235GH, 1.0050, 1.0070, 1.8937 1.0718 11SMnPB30, 1.0736 11SMn37 1.0402 C22, 1.1178 C30E 1.0503 C45, 1.1191 C30E 1.0301 C10, 1.1121 C10E 1.1750 C75W, 1.2076 102Cr6, 1.2307 29CrMoV9	≤ 850 N/mm ²	G-Mold 55	Roughing	0.10xD	0.30xD	240	0.015	0.030	0.045	0.060	0.075	0.090	0.120	0.150	0.180			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	340	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	360	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
Free-cutting steels, unall. case hard. steels, nitr. steels 1.0727 46 S20, 1.0728 60 S20, 1.0757 46SPb20 1.0601 C60, 1.1221 C60E 1.7043 38Cr4 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5 1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	850-1,200 N/mm ²	G-Mold 55	Roughing	0.10xD	0.30xD	220	0.015	0.030	0.045	0.060	0.075	0.090	0.120	0.150	0.180			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	310	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	330	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
Alloyed heat-treatable. tool and high speed steels 1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2379 X155CrVMo12-1 1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3 Spring steel = 1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4	850-1,400 N/mm ²	G-Mold 55	Roughing	0.10xD	0.30xD	200	0.012	0.024	0.036	0.048	0.060	0.072	0.096	0.120	0.144			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	280	0.008	0.017	0.025	0.034	0.042	0.050	0.067	0.084	0.101			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	300	0.008	0.017	0.025	0.034	0.042	0.050	0.067	0.084	0.101			
Hardened steel Tool steel. heat-treatable steel. spring steel. high-speed steel. case hardened steel. etc. e.g.: 1.2344 X40CrMoV5-1; 1.2767 X45NiCrMo4; 1.2379 X155CrVMo12-1; 1.2080 X210Cr12; 1.3343 S 6-5-2	≤ 55 HRC	G-Mold 55	Roughing	0.06xD	0.20xD	140	0.013	0.025	0.038	0.051	0.064	0.076	0.102	0.127	0.152			
		G-Mold 55	(Pre-)Finishing	0.02xD	0.05xD	220	0.009	0.018	0.027	0.036	0.044	0.053	0.071	0.089	0.107			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	220	0.009	0.018	0.027	0.036	0.044	0.053	0.071	0.089	0.107			
	55-65 HRC	G-Mold 65	Roughing	0.06xD	0.20xD	100	0.010	0.020	0.030	0.040	0.050	0.060	0.080	0.100	0.120			
		G-Mold 65	(Pre-)Finishing	0.02xD	0.05xD	170	0.007	0.014	0.021	0.028	0.035	0.042	0.056	0.070	0.084			
		G-Mold 65	Fine finishing	0.01xD	0.02xD	170	0.007	0.013	0.020	0.026	0.033	0.039	0.052	0.065	0.078			
Stainless steel 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X10CrNiS18-9 USA = 303, 410, 420F, 430, 430F	≤ 750 N/mm ²	G-Mold 55	Roughing	0.10xD	0.30xD	160	0.013	0.026	0.039	0.052	0.065	0.078	0.104	0.130	0.156			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	230	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	240	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
Stainless steel 1.4301X5CrNi18-10, 1.4303 X5CrNi18-12 1.4310 XCrNi18-8 USA = 304, 304L, 420	750-850 N/mm ²	G-Mold 55	Roughing	0.06xD	0.20xD	110	0.012	0.024	0.036	0.048	0.060	0.072	0.096	0.120	0.144			
		G-Mold 55	(Pre-)Finishing	0.02xD	0.05xD	160	0.008	0.017	0.025	0.034	0.042	0.050	0.067	0.084	0.101			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	170	0.008	0.016	0.023	0.031	0.039	0.047	0.062	0.078	0.094			
Stainless steel 1.4438 X2CrNiMo18-15-4, 1.4404 X2CrNiMo17-12-2, 1.4571 X6CrNiTi18-10 USA = 310, 316, 316B, 316L, 317	≥ 850 N/mm ²	G-Mold 55	Roughing	0.06xD	0.20xD	80	0.010	0.020	0.030	0.040	0.050	0.060	0.080	0.100	0.120			
		G-Mold 55	(Pre-)Finishing	0.02xD	0.05xD	120	0.007	0.014	0.021	0.028	0.035	0.042	0.056	0.070	0.084			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	130	0.007	0.013	0.020	0.026	0.033	0.039	0.052	0.065	0.078			
Special alloys (nickel based "Ni") Nimonic, Inconel, Monel, Hastelloy	≤ 1,300 N/mm ²	G-Mold 55	Roughing	0.06xD	0.20xD	45	0.012	0.024	0.036	0.048	0.061	0.073	0.097	0.121	0.145			
		G-Mold 55	(Pre-)Finishing	0.02xD	0.05xD	60	0.008	0.017	0.025	0.034	0.042	0.051	0.068	0.085	0.102			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	80	0.008	0.016	0.024	0.031	0.039	0.047	0.063	0.079	0.094			
Titanium alloys ("Ti") 3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7164 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5	≤ 1,300 N/mm ²	G-Mold 55	Roughing	0.06xD	0.20xD	90	0.013	0.026	0.039	0.052	0.065	0.078	0.104	0.130	0.156			
		G-Mold 55	(Pre-)Finishing	0.02xD	0.05xD	130	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	140	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
Cast/grey cast iron, spher.graphite/mall, cast iron 0.6010 EN-GL100 (GG10), 0.6020 EN-GJL-200 (GG20), 0.7050 EN-GJS-500-7 (GGG50), 0.8535 EN-GJMW-350-4 (GTW35)	≤ 240 HB	G-Mold 55	Roughing	0.10xD	0.30xD	220	0.015	0.030	0.045	0.060	0.075	0.090	0.120	0.150	0.180			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	310	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	330	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
Cast/grey cast iron, spher.graphite/mall, cast iron 0.6025 EN-GL250 (GG25), 0.6035 EN-GJL-350 (GG35), 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)	≥ 240 HB	G-Mold 55	Roughing	0.10xD	0.30xD	155	0.012	0.023	0.035	0.047	0.059	0.070	0.094	0.117	0.140			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	210	0.008	0.016	0.025	0.033	0.041	0.049	0.066	0.082	0.098			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	240	0.008	0.016	0.025	0.033	0.041	0.049	0.066	0.082	0.098			
Aluminium, Al-wrought alloys, Al-alloys 3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1 3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1.5	≤ 7% Si	G-Mold 55	Roughing	0.10xD	0.30xD	600	0.016	0.032	0.048	0.064	0.080	0.096	0.128	0.160	0.192			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	800	0.011	0.022	0.034	0.045	0.056	0.067	0.090	0.112	0.134			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	900	0.011	0.022	0.034	0.045	0.056	0.067	0.090	0.112	0.134			
Aluminium-cast alloys 3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≥ 7% Si	G-Mold 55	Roughing	0.10xD	0.30xD	300	0.015	0.030	0.045	0.060	0.075	0.090	0.120	0.150	0.180			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	400	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	500	0.011	0.021	0.032	0.042	0.053	0.063	0.084	0.105	0.126			
Magnesium-alloys MgMn2, G-MgAl8Zn1, G-MgAl6Zn3	-	G-Mold 55	Roughing	0.10xD	0.30xD	180	0.013	0.026	0.039	0.052	0.065	0.078	0.104	0.130	0.156			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	260	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	270	0.009	0.018	0.027	0.036	0.046	0.055	0.073	0.091	0.109			
Non-ferr. met. (copper, short-/long-chipp., brass/bronze) 2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPB 2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 ... 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5 2.1090 CuSn7ZnPB, 2.1170 CuPb5Sn5, 2.1176 ... 2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤ 850 N/mm ²	G-Mold 55	Roughing	0.10xD	0.30xD	200	0.016	0.032	0.048	0.064	0.080	0.096	0.128	0.160	0.192			
		G-Mold 55	(Pre-)Finishing	0.05xD	0.10xD	280	0.011	0.022	0.034	0.045	0.056	0.067	0.090	0.112	0.134			
		G-Mold 55	Fine finishing	0.01xD	0.02xD	300	0.011	0.022	0.034	0.045	0.056	0.067	0.090	0.112	0.134			