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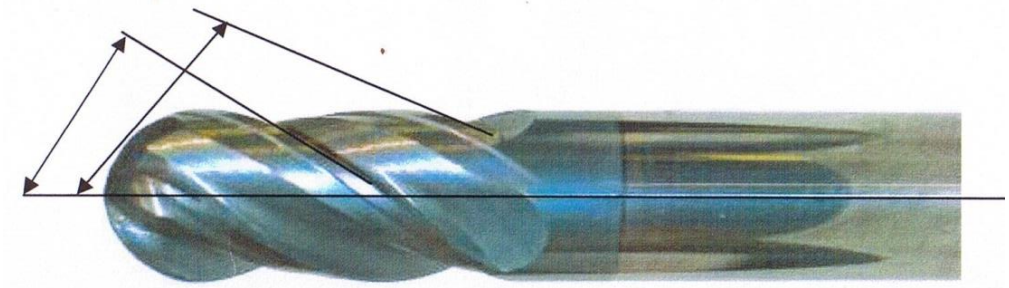
GTV: VARIABLE HELIX CUTTERS



Variable helix cutters allow you to increase the depth of cut and feed rates on materials such as:

Low alloy steels
Medium alloy steels
Tool steels
Stainless steels
Titanium
Heat-resistant alloys

A chatter-resistant design coupled with our “TB5” coating ensures greater tool life and an improved surface finish by reducing vibrations.

Square-ended {3mm-20mm} or Ball-ended {3mm-16mm} are ex-stock.
Corner-Rads stocked to specific sizes.

GTV: 4-flute Variable Helix Cutters

Square-End					
Dia	Shank diameter	Flute length	O/a length	C/rad	Price
3	3	8	57	chamfer	£26.28
4	4	11	57	0.25 / 0.5 / 1.0	£34.16
4	4	11	57	chamfer	£26.28
5	5	13	57	0.25 / 0.5 / 1.0	£37.66
5	5	13	57	chamfer	£26.84
6	6	13	57	0.25 / 0.5 / 1.0	£37.66
6	6	13	57	chamfer	£26.84
8	8	19	63	0.5 / 1.0 / 1.5	£43.20
8	8	19	63	chamfer	£32.38
10	10	22	72	0.5 / 1.0 / 1.5 / 2.0	£54.86
10	10	22	72	chamfer	£44.04
12	12	26	83	0.5 / 1.0 / 1.5 / 2.0	£61.10
12	12	26	83	chamfer	£69.88
16	16	32	92	1.0 / 1.5 / 2.0	£98.22
16	16	32	92	chamfer	£83.52
20	20	38	104	chamfer	£124.24

Ball-Nose				
Dia	Shank diameter	Flute length	O/a length	Price
3	3	8	57	£31.04
4	4	11	57	£31.82
5	5	13	57	£36.62
6	6	13	57	£36.62
8	8	19	63	£39.94
10	10	22	72	£57.10
12	12	26	83	£65.46
16	16	32	92	£92.18

Feeds and speeds are based on the following maximums:
Profiling: Radial width – 0.5 x dia
Axial Depth – 1.5 x dia

Profiling: Axial depth – 1.5 x dia

Slotting: Axial depth – 1 x dia

Material	speed	feed	speed	feed	speed	feed	speed	feed	speed	feed	speed	feed	speed	feed	speed	feed	speed	feed
	3		4		5		6		8		10		12		16		20	
Low carbon steels	16444	335	12333	350	9866	500	8222	580	6166	750	4933	955	4111	960	3083	800	2467	800
Medium alloy steels	13261	230	9946	230	7957	350	6630	400	4970	500	3980	650	3320	660	2490	560	1990	550
Tool & Die steels	5835	110	8434	120	3501	170	2920	200	2190	260	1750	330	1460	340	1090	280	875	280
Stainless 300	9548	175	7160	200	5729	300	4775	350	2860	400	2860	400	2390	400	1790	400	1430	350
Stainless 400	13261	250	10100	300	8080	430	6740	550	5050	630	4040	630	3370	630	2520	630	2020	550
Stainless PH	8060	125	6050	160	4840	250	4030	300	3025	350	2420	350	2020	350	1520	350	1200	300
Titanium alloys	8480	220	6360	220	5090	350	4240	400	3180	450	2550	450	2120	450	1590	450	1275	400
Heat resistant alloys	2546	50	1900	50	1528	75	1273	75	955	100	765	100	640	100	480	100	380	100