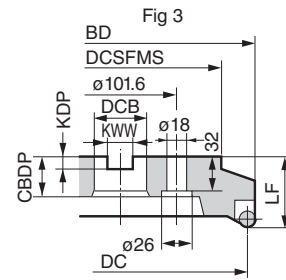
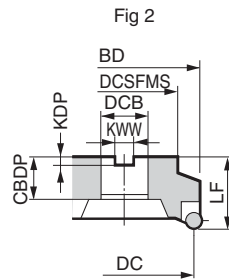
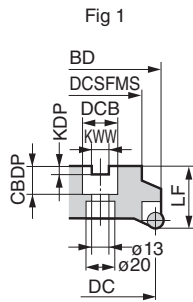
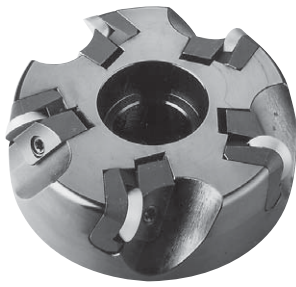


Rake Angle	Radial	+10°
	Axial	+25°



<b>P</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>S</b>	<b>H</b>
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel

## Milling for Stainless Steel, Die Steel & Hard-to-Cut Material



### Body

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)										
				Diameter DC	External Diameter BD	Boss DCSFMS	Height LF	Hole Size DCB	Grooving Width KWW	Grooving Depth KDP	Mounting Depth CBDDP	No. of Teeth	Weight (kg)	Fig
<b>GRC 6080R</b>	●	<b>GRC 6080L</b>		*80	100	60	50	<b>25.4</b>	9.5	6	25	4	2.3	1
<b>6100R</b>	●	<b>6100L</b>		100	119	70	50	<b>31.75</b>	12.7	8	32	5	2.9	2
<b>6125R</b>	●	<b>6125L</b>		125	143	80	63	<b>38.1</b>	15.9	10	38	6	5.1	2
<b>6160R</b>	●	<b>6160L</b>		160	177	100	63	<b>50.8</b>	19.1	11	38	8	7.5	2
<b>6200R</b>		<b>6200L</b>		200	216	130	63	<b>47.625</b>	25.4	14	35	10	11.0	3
<b>6250R</b>		<b>6250L</b>		250	265	130	63	<b>47.625</b>	25.4	14	35	12	16.3	3

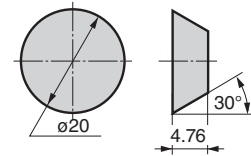


Inserts are not included.  
\*Please use JIS B1176 hexagonal bolt (M12x30 to 35mm) for securing ø80 cutter to the arbor.

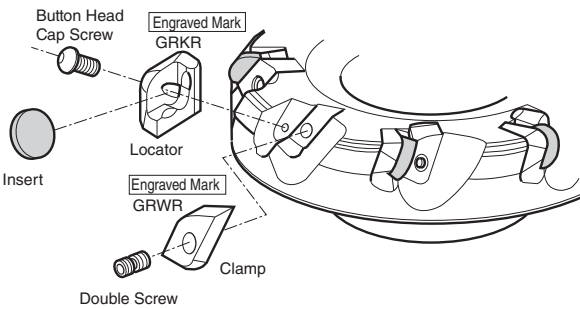
### Insert

**P** Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade		Coated Carbide			Carbide		
	High Speed/Light	General Purpose	P	M	K	N	S	H
High Speed/Light	P				K			
General Purpose		P	P		K		P	
Roughing		P	P		K			
Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	
<b>RGEN 2004SN-S</b>		●	●				●	
<b>2004SN-I</b>						●		
<b>2004SN-T</b>						●		



\* -S: For Stainless Steel, -I: For Inconel, -T: For Titanium Alloys.



### Parts

Applicable Cutters	Locator	Clamp	Double Screw	Locator Screw	Wrench
GRC6080R to GRC6250R	GRKR	GRWR	WB8-22T	BH0410T	TT27 (TT15)
GRC6080L to GRC6250L	GRKL	GRWL	WB8-22T	BH0410T	TT27 (TT15)

Double Screw (Common)	Size		Locator Screw	Size	
	M8	8.0		M4	3.0

Recommended Tightening Torque (N·m)

### Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed $v_c$ (m/min) Min. - Optimum - Max.	Feed Rate $f_z$ (mm/t) Min. - Optimum - Max.	Grade
<b>P</b>	Die Steel	200 to 220HB	80-120-160	0.15-0.23-0.30	ACP200
<b>M</b>	Stainless Steel	—	120-150-180	0.15-0.23-0.30	ACP200
<b>S</b>	Inconel	—	40-45-50	0.10-0.15-0.20	EH20Z
	Titanium Alloy	—	40-60-80	0.10-0.15-0.20	EH20Z

**Note** The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.