

# GH-K Programming and Changing Blades

HTC021/V1.0

COFA | COFA-C | SNAP | VEX-S | VEX-P | COMBI | DEFA

GH-K

BSF | SOLO | GH-Z/E

## Cutting Data

Material	Hardness BHN	Feed (per blade)  IPR mm/rev	HSS-E	Carbide
			Coated SFM MPM	Coated SFM MPM
Carbon Steels	100-250	.001-.002	15-80	60-120*
		.0025-.05	5-24	18-36
Free Machining Alloy	125-340	.001-.002	30-80	80-150*
		0.025-.05	9-24	24-45
High Alloy Steel	250-350	.001-.002	15-80	60-120*
		.0025-.05	5-24	18-36
Stainless Steel	140-250	.001-.002	20-50	40-90*
		.0025-.05	6-15	12-26
Ductile/Grey Cast Iron	150-330	.001-.002	30-100	100-250
		.0025-.05	9-30	30-75
Aluminum	30-180	.001-.002	80-230	200-600
		.0025-.05	24-70	60-220
Titanium		.001-.002	15-45	20-80
		.0025-.05	5-13	6-24
Copper Alloy	80-200	.001-.002	80-200	130-320
		.0025-.05	24-60	40-100

\*Optional geometry available on request; HSS-E is recommended.

**IMPORTANT:** Power feed control is recommended to prevent over-feeding, which can damage the blades. Shims can be added behind the cutting blades to increase front clearance, which will change the cutting geometry to .005 thickness and enable you to tune the tool to different materials. Shims must be placed between blade and tool body. Use the single-blade design only with the power feed, along with a stable spindle and rigid set-up.

**NOTE:** All listed cutting data are standard values only. In case of hard-to-machine materials or uneven surfaces, we recommend applying cutting speeds that are at the lower end of the range.

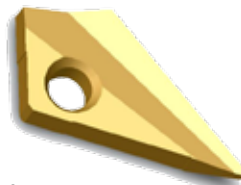
## Replacing GH-K Blades



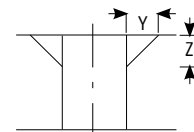
1. Unscrew the screw for each blade that attaches it to the tool body.
2. Place the new blade on the tool body and insert the screw. Repeat for each blade.

**NOTE:** Be sure to replace the entire set of blades and not just one single blade as they come in sets.

## Calculation Reference



See blade order numbers on pages 176-177



	Z	Y
60°	1	.577
82°	1	.869
90°	1	1.00
100°	1	1.191