

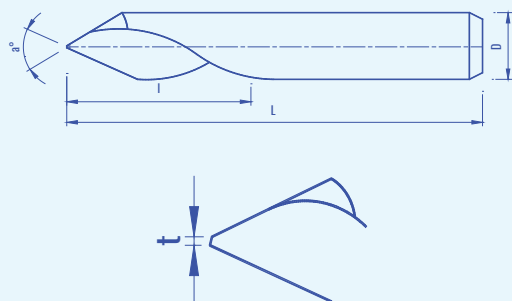
NexGen High Precision Engravers

MMP[®]
TECHNOLOGY
Embedded



HELICAL ENGRAVER G845-SN HELICAL ENGRAVER G845-SN

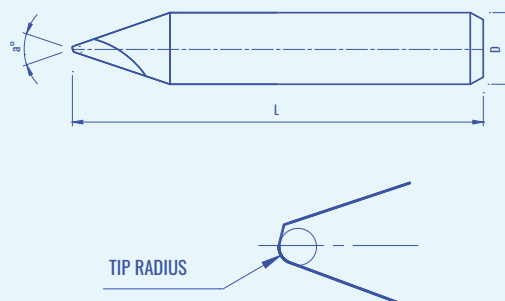
RH
COATED



Tip Dia t	Dia D h6	Angle α	Length L	OAL
* 0.03	3.00	60°	9.0	38
0.05	3.00	60°	9.0	38
0.10	3.00	60°	9.0	38
0.15	4.00	60°	12.0	40

ENGRAVER G851-SN ENGRAVER G851-SN

RH
COATED

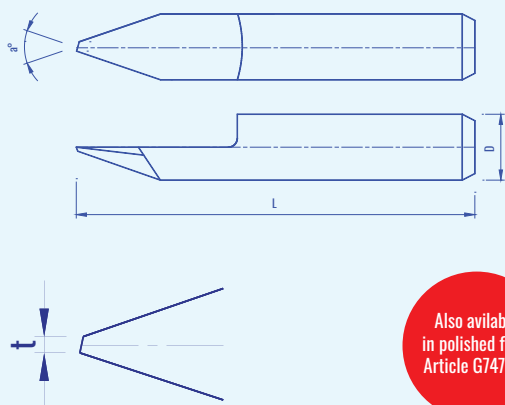


Tip Radius	Dia D h6	Angle α	OAL
* 0.03	3.00	35°	30
0.05	3.00	35°	30
0.10	3.00	35°	30
0.15	3.00	35°	30
0.20	3.00	35°	30

ENGRAVER G847-SN ENGRAVER G847-SN

RH
COATED

Tip Dia t	Dia D h6	Angle α					OAL
* 0.03	3.00	30°	45°	60°	90°	120°	38
0.05	3.00	30°	45°	60°	90°	120°	38
0.10	3.00	30°	45°	60°	90°	120°	38
0.15	3.00	30°	45°	60°	90°	120°	38
0.20	3.00	30°	45°	60°	90°	120°	38
* 0.03	3.175	30°	45°	60°	90°	120°	38
0.05	3.175	30°	45°	60°	90°	120°	38
0.10	3.175	30°	45°	60°	90°	120°	38
0.15	3.175	30°	45°	60°	90°	120°	38
0.20	3.175	30°	45°	60°	90°	120°	38
* 0.03	6.00	30°	45°	60°	90°	120°	50
0.05	6.00	30°	45°	60°	90°	120°	50
0.10	6.00	30°	45°	60°	90°	120°	50
0.15	6.00	30°	45°	60°	90°	120°	50
0.20	6.00	30°	45°	60°	90°	120°	50



This type of Engraver can be modified as per material property with desired angle & tip diameter

* Dia 0.030mm available on request

ALSO AVAILABLE

- Other Shank Diameter
- With Special Angles
- With Special Dimensions

- Left Hand Cutting
- Shank Diameter h4 on request

All dimensions are in mm

PACKING

- Dia = 3.175 mm : 10 Tools / Pack
- Dia > 3.175 mm : 1 Tool / Pack

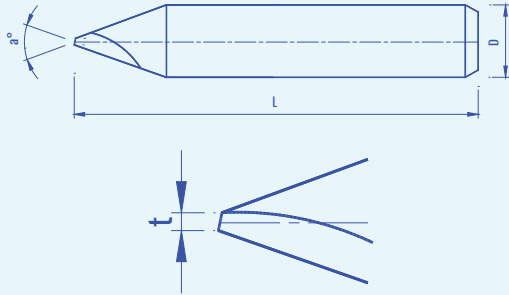
Sharp Cutting Edge

High Precision

Polished Flutes

REINFORCED ENGRAVER G647-SN REINFORCED ENGRAVER G647-SN

RH
COATED



Tip Dia t	Dia D h6	Angle α		OAL
* 0.03	3.00	35°	40°	30
0.05	3.00	35°	40°	30
0.10	3.00	35°	40°	30
0.15	3.00	35°	40°	30
0.20	3.00	35°	40°	30

ENGRAVER APPLICATION

Material	G845-SN	G851-SN	G647-SN	G847-SN
Unalloyed / Low Alloyed Steel <600 N/mm	✗	○	○	✓
Unalloyed / Low Alloyed Steel 600 - 1500N/mm	✗	✓	✓	○
High Alloyed Steel 700 - 1500N/mm	✗	✓	✓	○
Grey Cast Iron <250HB	✓	○	○	✓
Grey Cast Iron >250HB	✓	○	○	✓
Heat Resisting Stainless Steel	✗	○	○	○
Titanium Alloy	✗	✓	✓	○
Copper Alloy (easy to machine)	✓	○	○	✓
Copper Alloy (difficult to machine)	✗	✓	✓	○
Aluminium Alloy (Si < 8%)	✓	○	○	✓
Aluminium Alloy (Si > 8%)	✓	○	○	✓
Plastic	✗	○	○	○
Gold, Silver	✓	○	○	✓
Legends	Perfect ✓	Partly ○	No ✗	

RECOMMENDED CUTTING PARAMETERS

Material	G847-SN / G847-SN Coated				G647-SN/ G647-SN Coated / G851-SN/ G851-SN-Coated			
	RPM Uncoated	RPM Coated	Vf (mm/min)	ap (mm)	RPM Uncoated	RPM Coated	Vf (mm/min)	ap (mm)
Unalloyed / Low Alloyed Steel <600 N/mm	25K - 40K	---	75 - 240	0.05 - 0.20	20K - 35K	---	50 - 200	0.05 - 0.15
Unalloyed / Low Alloyed Steel 600 - 1500N/mm	25K - 35K	25K - 35K	60 - 200	0.05 - 0.20	---	20K - 30K	50 - 150	0.05 - 0.10
High Alloyed Steel 700 - 1500N/mm	---	15K - 20K	50 - 160	0.05 - 0.10	15K - 28K	15K - 28K	50 - 150	0.05 - 0.10
Grey Cast Iron <250HB	25K - 35K	---	75 - 240	0.05 - 0.20	25K - 35K	25K - 35K	75 - 240	0.05 - 0.15
Grey Cast Iron >250HB	15K - 20K	15K - 20K	50 - 180	0.05 - 0.15	20K - 30K	20K - 30K	50 - 200	0.05 - 0.10
Heat Resisting Stainless Steel	10K - 15K	10K - 15K	30 - 80	0.05 - 0.10	---	---	---	---
Titanium Alloy	20K - 30K	---	75 - 200	0.05 - 0.20	20K - 35K	---	60 - 200	0.05 - 0.15
Copper Alloy (easy to machine)	30K - 40K	---	75 - 240	0.05 - 0.20	25K - 35K	20K - 30K	50 - 300	0.05 - 0.20
Copper Alloy (difficult to machine)	20K - 30K	---	50 - 200	0.05 - 0.15	20K - 30K	20K - 30K	50 - 150	0.05 - 0.10
Aluminium Alloy (Si < 8%)	25K - 30K	---	75 - 240	0.05 - 0.20	20K - 35K	---	50 - 300	0.05 - 0.20
Aluminium Alloy (Si > 8%)	20K - 30K	---	75 - 240	0.05 - 0.20	20K - 30K	---	75 - 240	0.05 - 0.15
Plastic	30K - 40K	---	100 - 240	0.05 - 0.30	20K - 35K	---	50 - 300	0.05 - 0.20
Gold, Silver	25K - 40K	---	75 - 240	0.05 - 0.20	20K - 35K	---	50 - 300	0.05 - 0.20

NexGen High Precision Engravers



Axis
Tools for mICRO mACHINING



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