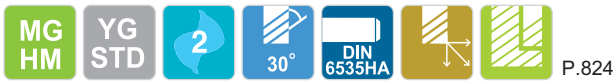
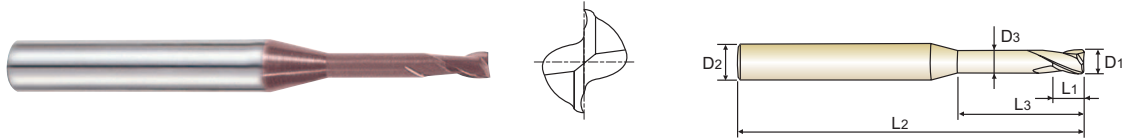


**YG K-2 CARBIDE
END MILLS**

**G9B80 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT**

**CARBIDE, 2 FLUTE RIB PROCESSING
VOLLHARTMETALL, 2 SCHNEIDEN SCHMALE RIPPEN**

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.
- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis.
- ▶ 2 Schneiden zum Nutenfräsen.



Unit : mm

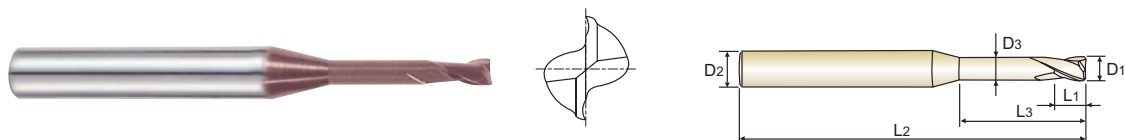
EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
G9B80004	0.4	4	0.7	2	50	0.37
G9B80901	0.4	4	0.7	4	50	0.37
G9B80005	0.5	4	0.75	2	50	0.45
G9B80902	0.5	4	0.75	4	50	0.45
G9B80903	0.5	4	0.75	6	50	0.45
G9B80006	0.6	4	0.9	2	50	0.55
G9B80904	0.6	4	0.9	4	50	0.55
G9B80905	0.6	4	0.9	6	50	0.55
G9B80007	0.7	4	1.1	4	50	0.65
G9B80906	0.7	4	1.1	6	50	0.65
G9B80008	0.8	4	1.2	4	50	0.75
G9B80907	0.8	4	1.2	6	50	0.75
G9B80908	0.8	4	1.2	8	50	0.75
G9B80009	0.9	4	1.4	6	50	0.85
G9B80909	0.9	4	1.4	8	50	0.85
G9B80910	0.9	4	1.4	10	50	0.85
G9B80010	1.0	4	1.5	6	50	0.95
G9B80911	1.0	4	1.5	8	50	0.95
G9B80912	1.0	4	1.5	10	50	0.95
G9B80913	1.0	4	1.5	12	50	0.95
G9B80012	1.2	4	1.8	6	50	1.15
G9B80914	1.2	4	1.8	8	50	1.15
G9B80915	1.2	4	1.8	10	50	1.15
G9B80916	1.2	4	1.8	12	50	1.15
G9B80015	1.5	4	2.3	6	50	1.45
G9B80917	1.5	4	2.3	8	50	1.45
G9B80918	1.5	4	2.3	10	50	1.45
G9B80919	1.5	4	2.3	12	50	1.45
G9B80920	1.5	4	2.3	14	50	1.45
G9B80921	1.5	4	2.3	16	50	1.45

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	○	○				○		○	○	○	○	○

CARBIDE, 2 FLUTE RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN SCHMALE RIPPEN

- ▶ Suitable for dry milling applications at high temperatures.
 - ▶ Excellent high-performance end mills.
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 - ▶ Hervorragendes Preis - Leistungsverhältnis.
 - ▶ 2 Schneiden zum Nutenfräsen.



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	D1	D2	L1	L3	L2	D3
G9B80922	1.5	4	2.3	18	50	1.45
G9B80923	1.5	4	2.3	20	50	1.45
G9B80020	2.0	4	3	6	50	1.95
G9B80924	2.0	4	3	8	50	1.95
G9B80925	2.0	4	3	10	50	1.95
G9B80926	2.0	4	3	12	50	1.95
G9B80927	2.0	4	3	14	50	1.95
G9B80928	2.0	4	3	16	50	1.95
G9B80929	2.0	4	3	18	50	1.95
G9B80930	2.0	4	3	20	50	1.95
G9B80025	2.5	4	3.7	8	50	2.40
G9B80931	2.5	4	3.7	12	50	2.40
G9B80932	2.5	4	3.7	16	50	2.40
G9B80933	2.5	4	3.7	20	50	2.40
G9B80030	3.0	6	4.5	8	50	2.85
G9B80934	3.0	6	4.5	12	50	2.85
G9B80935	3.0	6	4.5	16	60	2.85
G9B80936	3.0	6	4.5	20	60	2.85
G9B80937	3.0	6	4.5	25	75	2.85
G9B80040	4.0	6	6	12	50	3.85
G9B80938	4.0	6	6	16	60	3.85
G9B80939	4.0	6	6	20	75	3.85
G9B80940	4.0	6	6	25	75	3.85
G9B80941	4.0	6	6	30	75	3.85
G9B80942	4.0	6	6	35	75	3.85

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70							
◎	◎	◎				○		○	○	○	○	○

CARBIDE

HSS

CBN END MILLS

i-Xmill END MILLS

X5070 END MILLS

X-POWER END MILLS

JET-POWER END MILLS

V7 Mill INOX END MILLS

V7 Mill STEEL END MILLS

ALU-POWER END MILLS

D-POWER END MILLS

K-2 CARBIDE END MILLS

GENERAL CARBIDE END MILLS

TANK-POWER END MILLS

GENERAL HSS END MILLS

MILLING CUTTERS

TECHNICAL DATA



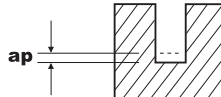
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE for RIB PROCESSING
VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN

G9B80 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS			ALLOY STEELS HEAT RESISTANT STEELS		
	~ HRC30			HRC30 ~ HRC45		
HARDNESS	~ 1000N/mm ²			1000 ~ 1500N/mm ²		
STRENGTH						
DIAMETER	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)
0.4	26500~34000	170~370	0.007~0.018	19000~24000	72~290	0.007~0.018
0.5	26500~34000	170~370	0.009~0.022	19000~24000	72~290	0.009~0.022
0.6	26500~34000	210~485	0.011~0.026	19000~24000	95~365	0.011~0.026
0.7	26500~34000	210~485	0.012~0.031	19000~24000	95~365	0.012~0.031
0.8	23000~30000	240~535	0.014~0.035	16500~21000	100~410	0.014~0.035
0.9	21500~27000	240~610	0.030~0.060	15000~19000	135~460	0.030~0.060
1.0	19000~24000	240~690	0.045~0.090	13500~17000	160~510	0.045~0.090
1.2	15500~19000	240~765	0.055~0.100	11000~14000	160~510	0.055~0.100
1.4	13600~17000	240~765	0.062~0.125	9800~12000	160~510	0.062~0.125
1.5	12500~15500	240~765	0.070~0.135	8950~11500	160~510	0.070~0.135
1.6	12000~15000	240~765	0.075~0.145	8700~10900	160~510	0.075~0.145
1.8	11000~14000	240~765	0.080~0.160	7800~9800	160~510	0.080~0.160
2.0	10000~12500	240~765	0.090~0.180	7000~8950	160~510	0.090~0.180
2.5	8000~10000	240~765	0.112~0.235	5700~7200	160~510	0.112~0.235
3.0	6800~8500	240~765	0.135~0.270	4700~6000	160~510	0.135~0.270
4.0	5100~6500	240~765	0.180~0.360	3500~4500	160~510	0.180~0.360

(Depth of Cut per one pass)



* The FEED, in long & extra long types, should be reduced by around 50%

RPM = rev./min.
FEED = mm/min.