



**CARBIDE, 2 FLUTE SHORT LENGTH CORNER RADIUS**  
**VOLLHARTMETALL, 2 SCHNEIDEN KURZ ECKENRADIUS**

- ▶ 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.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B82020	RO.2	2.0	4	4	50
G9B82901	RO.3	2.0	4	4	50
G9B82902	RO.5	2.0	4	4	50
G9B82025	RO.2	2.5	4	5	50
G9B82903	RO.3	2.5	4	5	50
G9B82904	RO.5	2.5	4	5	50
G9B82030	RO.2	3.0	4	6	50
G9B82905	RO.3	3.0	4	6	50
G9B82906	RO.5	3.0	4	6	50
G9B82907	R1.0	3.0	4	6	50
G9B82040	RO.2	4.0	4	8	50
G9B82908	RO.3	4.0	4	8	50
G9B82909	RO.5	4.0	4	8	50
G9B82910	R1.0	4.0	4	8	50
G9B82050	RO.2	5.0	6	10	50
G9B82911	RO.3	5.0	6	10	50
G9B82912	RO.5	5.0	6	10	50
G9B82913	R1.0	5.0	6	10	50
G9B82060	RO.2	6.0	6	12	50
G9B82914	RO.3	6.0	6	12	50
G9B82915	RO.5	6.0	6	12	50
G9B82916	R1.0	6.0	6	12	50

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							
○	○	○				○		○	○	○	○	○

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P.826

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B82080	R0.5	8.0	8	16	60
G9B82917	R1.0	8.0	8	16	60
G9B82918	R1.5	8.0	8	16	60
G9B82919	R2.0	8.0	8	16	60
G9B82920	R2.5	8.0	8	16	60
G9B82100	R0.5	10.0	10	20	75
G9B82921	R1.0	10.0	10	20	75
G9B82922	R1.5	10.0	10	20	75
G9B82923	R2.0	10.0	10	20	75
G9B82924	R2.5	10.0	10	20	75
G9B82120	R0.5	12.0	12	24	75
G9B82925	R1.0	12.0	12	24	75
G9B82926	R1.5	12.0	12	24	75
G9B82927	R2.0	12.0	12	24	75
G9B82928	R2.5	12.0	12	24	75

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



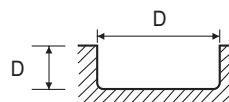
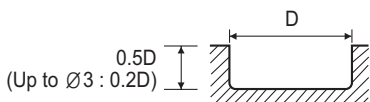
**K-2 CARBIDE END MILLS**

**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 2 FLUTE CORNER RADIUS FINISH SLOTTING  
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS SCHLICHTEN NUTENFRÄSEN**

**G9B82, G9B83 SERIES**

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS, HEAT RESISTANT STEELS		STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		COPPER, BRASS NON-FERROUS METALS		
	HARDNESS ~ HRc 30		HRc 30 ~ HRc 45										
STRENGTH ~1000N/mm <sup>2</sup>		1000~1500N/mm <sup>2</sup>											
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	
1.0	14300	105	8500	65	7150	50	18700	205	44000	330	24700	200	
1.5	9350	150	5550	85	5600	80	12100	205	27500	385	20300	300	
2.0	7850	160	5150	100	4300	80	9350	220	22000	460	16500	340	
3.0	6100	180	3800	120	3150	100	6050	220	15400	460	11000	340	
4.0	5150	255	3150	155	2650	130	4600	220	11000	460	8800	340	
5.0	4300	270	2550	160	2150	135	3650	220	9150	460	6800	340	
6.0	3800	300	2300	190	1950	155	2950	255	7600	485	5700	375	
8.0	2850	325	1700	170	1450	155	2200	275	5700	485	4400	375	
10.0	2200	280	1350	135	1150	135	1850	285	4600	485	3400	375	
12.0	1850	240	1150	110	950	110	1450	295	3750	485	2850	375	



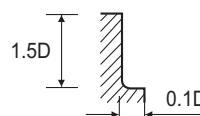
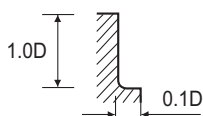
※ The FEED, in long & extra long types, should be reduced by around 50%

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

**CARBIDE, 4 FLUTE CORNER RADIUS FINISH SIDE CUTTING  
VOLLHARTMETALL, 4 SCHNEIDEN ECKENRADIUS SCHLICHTEN SEITENFRÄSEN**

**G9B84, G9B85 SERIES**

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS, HEAT RESISTANT STEELS		STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		COPPER, BRASS NON-FERROUS METALS		
	HARDNESS ~ HRc 30		HRc 30 ~ HRc 45										
STRENGTH ~1000N/mm <sup>2</sup>		1000~1500N/mm <sup>2</sup>											
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	
1.0	17600	150	10250	85	8650	75	18700	620	44000	1050	24700	605	
1.5	11800	215	7050	115	7050	120	12100	620	27500	1160	20300	910	
2.0	9850	240	6450	145	5350	120	9350	640	22000	1320	16500	1035	
3.0	7600	270	4750	170	3950	145	6050	640	15400	1320	11000	1035	
4.0	6450	485	3950	300	3300	240	4600	640	11000	1320	8800	1035	
5.0	5350	510	3200	305	2700	255	3650	640	9150	1320	6800	1035	
6.0	4750	560	2850	350	2400	280	2950	770	7600	1430	5700	1100	
8.0	3550	605	2150	325	1800	300	2200	815	5700	1430	4400	1100	
10.0	2750	520	1700	255	1450	255	1850	860	4600	1430	3400	1100	
12.0	2350	440	1450	215	1150	205	1450	900	3750	1430	2850	1100	



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