

YG K-2 CARBIDE END MILLS

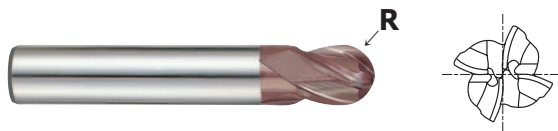
G9634 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

**CARBIDE, 4 FLUTE SHORT LENGTH BALL NOSE
VOLLHARTMETALL, 4 SCHNEIDEN KURZ STIRNRADIUS**

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 4 flute allows for better work piece finishes.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.

- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis.
- ▶ 4 Schneiden erzeugen eine bessere Oberflächengüte des Werkstücks.
- ▶ Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



MG HM YG STD 4 30° R ±0.02 DIN 6535HA P.823

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9634020	R 1.0	2.0	6	4	48
G9634030	R 1.5	3.0	6	4	48
G9634040	R 2.0	4.0	6	6	50
G9634050	R 2.5	5.0	6	7	51
G9634060	R 3.0	6.0	6	7	51
G9634080	R 4.0	8.0	8	9	59
G9634100	R 5.0	10.0	10	10	60
G9634120	R 6.0	12.0	12	14	71
G9634140	R 7.0	14.0	14	14	71
G9634160	R 8.0	16.0	16	16	76
G9634180	R 9.0	18.0	18	18	76
G9634200	R 10.0	20.0	20	20	82

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							
◎	◎	◎	○	○		○		○	○	○	○	○



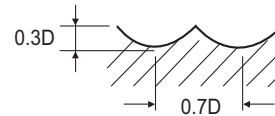
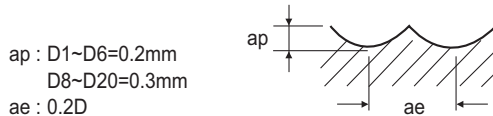
K-2 CARBIDE END MILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE BALL NOSE VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS

G9624, G9A70, G9437, G9438, G9454, G9455 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		HARDENED STEELS		CAST IRON		ALUMINUM ALLOYS	
HARDNESS	~ HRc 30		HRc 30 ~ HRc 45		HRc 45 ~ HRc 50					
STRENGTH	~1000N/mm ²		1000~1500N/mm ²		1500N/mm ² ~					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	12350	640	9150	415	4000	125	10500	220	30800	395
3.0	11400	575	8550	390	3800	125	7050	230	20500	395
4.0	8950	630	7150	450	3600	150	5150	285	15400	395
5.0	7800	700	6200	490	3100	150	4150	330	12100	470
6.0	7250	870	5900	705	2700	160	3400	360	10300	470
8.0	6100	1090	4900	785	2050	190	2500	460	7900	540
10.0	5450	1330	4350	870	1750	190	2050	460	6150	540
12.0	4990	1500	3950	950	1500	210	1750	460	5150	630
14.0	4530	1495	3600	925	1300	210	1400	460	4300	630
16.0	4085	1470	3200	905	1150	210	1300	460	3850	540
18.0	3800	1425	3000	890	1050	210	1100	460	3400	540
20.0	3550	1425	2800	885	950	210	1050	420	2950	540



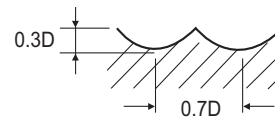
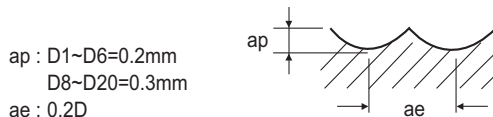
※ The FEED, in long & extra long types, should be reduced by around 50%

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

CARBIDE, 4 FLUTE BALL NOSE VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS

G9634 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		HARDENED STEELS		CAST IRON		ALUMINUM ALLOYS	
HARDNESS	~ HRc 30		HRc 30 ~ HRc 45		HRc 45 ~ HRc 50					
STRENGTH	~1000N/mm ²		1000~1500N/mm ²		1500N/mm ² ~					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	13300	680	10000	405	4100	135	10500	330	30800	605
3.0	11500	870	8550	585	3850	190	7050	340	20500	605
4.0	8950	950	7150	680	3600	230	5150	430	15400	605
5.0	7800	1045	6200	745	3100	230	4150	495	12100	715
6.0	7250	1330	5900	1090	2700	235	3400	540	10300	715
8.0	6100	1660	4900	1185	2100	285	2500	680	7900	820
10.0	5450	1950	4350	1330	1750	290	2050	680	6150	820
12.0	4985	2230	4000	1425	1500	320	1750	680	5150	945
14.0	4500	2230	3600	1425	1300	320	1400	700	4300	945
16.0	4085	2230	3200	1380	1100	320	1300	700	3850	820
18.0	3800	2135	3000	1330	1050	320	1100	700	3400	820
20.0	3550	2135	2800	1330	950	320	1050	630	2950	820



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

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