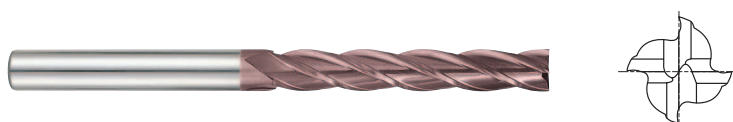


CARBIDE, 4 FLUTE EXTRA LONG LENGTH
VOLLHARTMETALL, 4 SCHNEIDEN EXTRA LANG

- ▶ Suitable for dry milling applications at high temperatures.
 - ▶ Excellent high-performance end mills.
 - ▶ 4 flute allows for better work piece finishes.
- ▶ Für die Trockenbearbeitung.
 - ▶ Hervorragendes Preis - Leistungsverhältnis.
 - ▶ 4 Schneiden erzeugen eine bessere Oberflächengüte des Werkstücks.



MG HM
YG STD
4
30°
DIN 6535HA
P.822

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9453903	3.0	3	20	60
G9453904	4.0	4	20	60
G9453905	5.0	5	25	75
G9453906	6.0	6	30	75
G9453908	8.0	8	30	75
G9453910	10.0	10	40	100
G9453912	12.0	12	45	100
G9453914	14.0	14	45	100
G9453916	16.0	16	45	100
G9453918	18.0	18	45	100
G9453920	20.0	20	45	100

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							
◎	◎	◎				○		○	○	○	○	○

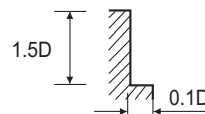
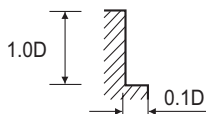
YG K-2 CARBIDE END MILLS

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

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

G9432, G9A69, G9448, G9540, G9449, G9453 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 ²		1000~1500N/mm ²									
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
14.0	2100	395	1300	195	1050	190	1300	945	3300	1430	2400	1100
16.0	1850	350	1150	170	950	170	1100	970	2850	1430	2200	1100
20.0	1450	270	900	135	700	130	900	1035	2200	1430	1700	1100



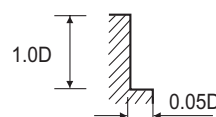
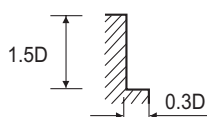
* The FEED, in long & extra long types, should be reduced by around 50%

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

**CARBIDE, MULTI FLUTE ROUGHING SIDE CUTTING
VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFÄSER SEITENFRÄSEN**

G9A42 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS STEELS		INCONEL	
HARDNESS	~ HRc30		HRc30 ~ HRc38		HRc38 ~ HRc45			
STRENGTH	1000N/mm ²		1000 ~ 1200N/mm ²		1200 ~ 1400N/mm ²			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	13250	1970	10550	710	7150	480	2050	160
8.0	9850	1970	7800	710	5350	480	1550	150
10.0	7800	1970	6450	710	4350	480	1100	160
12.0	6800	2040	5100	680	3550	480	1000	160
14.0	5800	2040	4400	710	3050	480	750	110
16.0	5100	2040	4100	650	2800	430	700	90
18.0	4400	1970	3750	610	2300	360	600	90
20.0	4100	1840	3050	480	2050	310	550	90
25.0	3650	1830	2700	530	1850	350	500	90



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

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