



K-2 CARBIDE END MILLS



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YG1EK071129002

K-2 CARBIDE END MILLS

*Soild Carbide End Mills for General Purpose!!
Vollhartmetallfräser für universellen Einsatz!!*



YG-1 CO., LTD.
<http://www.yg1.co.kr>

K-2 CARBIDE END MILLS

K-2 is micro grain size carbide end mills for general purpose such as slotting, side cutting and profiling.

K-2 ist ein Feinstkorn Vollhartmetallfräser für den universellen Einsatz und einer breiten Spanne von Anwendungen.

K-2 end mills get you increased productivity and decreased tooling cost with satisfaction.

K-2 Fräser erhöhen Ihre Produktivität und senken Ihre Werkzeugkosten.

Improved hot hardness and oxidation resistance will meet your needs in dry milling applications at high temperatures.

Erhöhte Warmfestigkeit und verminderte Oxydierung verbessern die Einsatzbedingungen beim Trockenfräsen bei hohen Temperaturen.



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2 FLUTE, SHORT LENGTH 2 SCHNEIDEN, KURZ

G9424 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



P.31

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 h 10	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9424010	1.0	4	3	40
G9424015	1.5	4	4.5	40
G9424020	2.0	2	8	32
G9424025	2.5	2.5	8	32
G9424030	3.0	3	12	32
G9424035	3.5	3.5	12	32
G9424040	4.0	4	12	40
G9424045	4.5	4.5	14	50
G9424050	5.0	5	14	50
G9424055	5.5	5.5	16	50
G9424060	6.0	6	16	50
G9424070	7.0	7	20	60
G9424080	8.0	8	20	60
G9424090	9.0	9	20	60
G9424100	10.0	10	22	70
G9424120	12.0	12	22	70
G9424140	14.0	14	25	75
G9424160	16.0	16	25	75
G9424200	20.0	20	32	100

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 -0.030	h6

G9448		4 FLUTE, SHORT LENGTH 4 SCHNEIDEN, KURZ	19
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RECOMMENDED CUTTING CONDITIONS			31 ~ 34



2 FLUTE, SHORT LENGTH

2 SCHNEIDEN, KURZ

G9A68 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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 h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9A68010	1.0	3	3	39
G9A68015	1.5	3	5	39
G9A68020	2.0	3	7	39
G9A68025	2.5	3	7	39
G9A68030	3.0	3	9	39
G9A68040	4.0	4	14	51
G9A68050	5.0	5	16	51
G9A68060	6.0	6	19	64
G9A68080	8.0	8	21	64
G9A68100	10.0	10	22	70
G9A68120	12.0	12	25	76
G9A68160	16.0	16	32	89
G9A68200	20.0	20	38	102

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, SHORT LENGTH

2 SCHNEIDEN, KURZ

G9444 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHE



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 h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9444020	2.0	6	3	50
G9444030	3.0	6	4	50
G9444035	3.5	6	4	50
G9444040	4.0	6	5	54
G9444045	4.5	6	5	54
G9444050	5.0	6	6	54
G9444060	6.0	6	7	54
G9444070	7.0	8	8	58
G9444080	8.0	8	9	58
G9444090	9.0	10	10	66
G9444100	10.0	10	11	66
G9444120	12.0	12	12	73
G9444140	14.0	14	14	75
G9444160	16.0	16	16	82
G9444180	18.0	18	18	84
G9444200	20.0	20	20	92

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, LONG LENGTH

2 SCHNEIDEN, LANG

G9527 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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 h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9527035	3.5	3.5	7	50
G9527040	4.0	4	8	50
G9527045	4.5	4.5	8	50
G9527050	5.0	5	10	50
G9527055	5.5	5.5	10	57
G9527060	6.0	6	10	57
G9527065	6.5	6.5	13	60
G9527070	7.0	7	13	60
G9527075	7.5	7.5	16	63
G9527080	8.0	8	16	63
G9527085	8.5	8.5	16	67
G9527090	9.0	9	16	67
G9527095	9.5	9.5	19	72
G9527100	10.0	10	19	72
G9527110	11.0	11	22	83
G9527120	12.0	12	22	83
G9527130	13.0	13	22	83
G9527140	14.0	14	22	83
G9527150	15.0	15	26	92
G9527160	16.0	16	26	92
G9527180	18.0	18	26	92
G9527200	20.0	20	32	104

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, LONG LENGTH

2 SCHNEIDEN, LANG

G9445 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHE



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 e8	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9445901	2.0	3	6	38
G9445028	2.8	6	7	57
G9445030	3.0	6	7	57
G9445035	3.5	6	7	57
G9445038	3.8	6	8	57
G9445040	4.0	6	8	57
G9445045	4.5	6	8	57
G9445048	4.8	6	10	57
G9445050	5.0	6	10	57
G9445957	5.75	6	10	57
G9445060	6.0	6	10	57
G9445967	6.75	8	13	63
G9445070	7.0	8	13	63
G9445977	7.75	8	16	63
G9445080	8.0	8	16	63
G9445087	8.7	10	16	72
G9445090	9.0	10	16	72
G9445097	9.7	10	19	72
G9445100	10.0	10	19	72
G9445117	11.7	12	22	83
G9445120	12.0	12	22	83
G9445137	13.7	14	22	83
G9445140	14.0	14	22	83
G9445157	15.7	16	26	92
G9445160	16.0	16	26	92
G9445177	17.7	18	26	92
G9445180	18.0	18	26	92
G9445197	19.7	20	32	104
G9445200	20.0	20	32	104

with plain shank

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, EXTRA LONG LENGTH 2 SCHNEIDEN, EXTRA LANG

G9452 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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 h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9452903	3	3	20	60
G9452904	4	4	20	60
G9452905	5	5	25	75
G9452906	6	6	30	75
G9452908	8	8	30	75
G9452910	10	10	40	100
G9452912	12	12	45	100
G9452914	14	14	45	100
G9452916	16	16	45	100
G9452918	18	18	45	100
G9452920	20	20	45	100

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

3 FLUTE, SHORT LENGTH, THROW AWAY 3 SCHNEIDEN, KURZ, EINWEGFRÄSER

G9553 SERIES

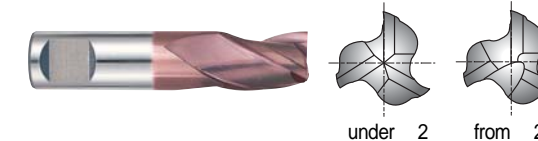
PLAIN SHANK
GLATTE ZYLINDERSCHAFT

G9410 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHE



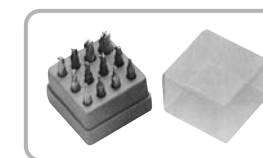
Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
3 flute design possess the advantage of 2 flute and 4 flute end mill.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
3 Schneiden verbinden die Vorteile von 2- und 4- schneidigen Schaffräsern.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9553005	0.5	3	1.5	38
G9553006	0.6	3	1.5	38
G9553008	0.8	3	2	38
G9553010	1.0	3	2	38
G9553012	1.2	3	2	38
G9553015	1.5	3	2	38
G9553018	1.8	3	2	38
G9410020	2.0	6	4	35
G9410025	2.5	6	5	36
G9410030	3.0	6	5	36
G9410035	3.5	6	6	37
G9410040	4.0	6	7	38
G9410045	4.5	6	8	38
G9410050	5.0	6	8	39
G9410055	5.5	6	8	39
G9410957	5.75	6	8	39
G9410060	6.0	6	8	39
G9410967	6.75	8	10	42
G9410070	7.0	8	10	42
G9410977	7.75	8	10	42
G9410080	8.0	8	11	43
G9410087	8.7	10	11	48
G9410090	9.0	10	11	48
G9410097	9.7	10	11	48
G9410100	10.0	10	13	50
G9410120	12.0	12	15	55
G9410140	14.0	14	15	58
G9410160	16.0	16	18	62
G9410180	18.0	18	20	70
G9410200	20.0	20	22	75

with plain shank



SET YG#3 (MINIATURE SET)
* 12PCS. SET
2PCS. OF EACH SIZE
2, 3, 4, 5, 6mm (T3FSQ)
1PC. OF EACH SIZE
8, 10mm (T3FSQ)
* SET ORDERING NO.:SET YG#3

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



3 FLUTE, SHORT LENGTH

3 SCHNEIDEN, KURZ

G9425 SERIES **PLAIN SHANK**
GLATTE ZYLINDERSCHAFT

MG HM YG STD N 30_s 3 DIN 6535HA P.32

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
3 flute design possess the advantage of 2 flute and 4 flute end mill.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
3 Schneiden verbinden die Vorteile von 2 - und 4 - schneidigen Schaftfräsern.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9425010	1.0	4	3	40
G9425015	1.5	4	4.5	40
G9425020	2.0	2	8	32
G9425025	2.5	2.5	8	32
G9425030	3.0	3	12	32
G9425035	3.5	3.5	12	32
G9425040	4.0	4	12	40
G9425045	4.5	4.5	14	50
G9425050	5.0	5	14	50
G9425055	5.5	5.5	16	50
G9425060	6.0	6	16	50
G9425070	7.0	7	20	60
G9425080	8.0	8	20	60
G9425090	9.0	9	20	60
G9425100	10.0	10	22	70
G9425120	12.0	12	22	70
G9425140	14.0	14	25	75
G9425160	16.0	16	25	75
G9425200	20.0	20	32	100

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



3 FLUTE, SHORT LENGTH

3 SCHNEIDEN, KURZ

G9439 SERIES **FLAT SHANK**
GLATTE ZYLINDERSCHAFT

MG HM DIN 6527 N 30_s 3 DIN 6535HB P.32

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
3 flute design possess the advantage of 2 flute and 4 flute end mill.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
3 Schneiden verbinden die Vorteile von 2 - und 4 - schneidigen Schaftfräsern.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9439020	2.0	6	3	50
G9439030	3.0	6	4	50
G9439035	3.5	6	4	50
G9439040	4.0	6	5	54
G9439045	4.5	6	5	54
G9439050	5.0	6	6	54
G9439060	6.0	6	7	54
G9439070	7.0	8	8	58
G9439080	8.0	8	9	58
G9439090	9.0	10	10	66
G9439100	10.0	10	11	66
G9439120	12.0	12	12	73
G9439140	14.0	14	14	75
G9439160	16.0	16	16	82
G9439180	18.0	18	18	84
G9439200	20.0	20	20	92

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

3 FLUTE, LONG LENGTH

3 SCHNEIDEN, LANG

G9528 SERIES **PLAIN SHANK**
GLATTE ZYLINDERSCHAFT

MG HM DIN 6528 N 3

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
3 flute design possess the advantage of 2 flute and 4 flute end mill.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
3 Schneiden verbinden die Vorteile von 2 - und 4 - schneidigen Schaftfräsern.



Unit : mm

EDP No.	MILL DIAMETER h 10	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9528035	3.5	3.5	7	50
G9528040	4.0	4	8	50
G9528045	4.5	4.5	8	50
G9528050	5.0	5	10	50
G9528055	5.5	5.5	10	57
G9528060	6.0	6	10	57
G9528065	6.5	6.5	13	60
G9528070	7.0	7	13	60
G9528075	7.5	7.5	16	63
G9528080	8.0	8	16	63
G9528085	8.5	8.5	16	67
G9528090	9.0	9	16	67
G9528095	9.5	9.5	19	72
G9528100	10.0	10	19	72
G9528110	11.0	11	22	83
G9528120	12.0	12	22	83
G9528130	13.0	13	22	83
G9528140	14.0	14	22	83
G9528150	15.0	15	26	92
G9528160	16.0	16	26	92
G9528180	18.0	18	26	92
G9528200	20.0	20	32	104

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

3 FLUTE, LONG LENGTH

3 SCHNEIDEN, LANG

G9433 SERIES **FLAT SHANK**
GLATTE ZYLINDERSCHAFT

MG HM DIN 6527 N 3

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
3 flute design possess the advantage of 2 flute and 4 flute end mill.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
3 Schneiden verbinden die Vorteile von 2 - und 4 - schneidigen Schaftfräsern.



Unit : mm

EDP No.	MILL DIAMETER h 10	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9433030	3.0	6	7	57
G9433040	4.0	6	8	57
G9433050	5.0	6	10	57
G9433060	6.0	6	10	57
G9433080	8.0	8	16	63
G9433090	9.0	10	16	72
G9433100	10.0	10	19	72
G9433120	12.0	12	22	83
G9433140	14.0	14	22	83
G9433160	16.0	16	26	92
G9433180	18.0	18	26	92
G9433200	20.0	20	32	104

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



3 FLUTE, 45° HELIX, LONG LENGTH 3 SCHNEIDEN, 45° RECHTSSPIRALE, LANG

G9447 SERIES

FLAT SHANK
GLATTE ZYLINDERSCHAFT



Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9447030	3.0	6	7	57
G9447035	3.5	6	7	57
G9447040	4.0	6	8	57
G9447045	4.5	6	8	57
G9447050	5.0	6	10	57
G9447060	6.0	6	10	57
G9447070	7.0	8	13	63
G9447080	8.0	8	16	63
G9447090	9.0	10	16	72
G9447100	10.0	10	19	72
G9447120	12.0	12	22	83
G9447140	14.0	14	22	83
G9447160	16.0	16	26	92
G9447180	18.0	18	26	92
G9447200	20.0	20	32	104

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 -0.030	h6

4 FLUTE, SHORT LENGTH 4 SCHNEIDEN, KURZ

G9432 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9432010	1.0	4	3	40
G9432015	1.5	4	4.5	40
G9432020	2.0	2	8	32
G9432025	2.5	2.5	8	32
G9432030	3.0	3	12	32
G9432035	3.5	3.5	12	32
G9432040	4.0	4	12	40
G9432045	4.5	4.5	14	50
G9432050	5.0	5	14	50
G9432055	5.5	5.5	16	50
G9432060	6.0	6	16	50
G9432070	7.0	7	20	60
G9432080	8.0	8	20	60
G9432090	9.0	9	20	60
G9432100	10.0	10	22	70
G9432120	12.0	12	22	70
G9432140	14.0	14	25	75
G9432160	16.0	16	25	75
G9432200	20.0	20	32	100

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 -0.030	h6

4 FLUTE, SHORT LENGTH

4 SCHNEIDEN, KURZ

G9A69 SERIES **PLAIN SHANK**
GLATTE ZYLINDERSCHAFT

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.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9A69010	1.0	3	3	39
G9A69015	1.5	3	5	39
G9A69020	2.0	3	7	39
G9A69025	2.5	3	7	39
G9A69030	3.0	3	10	39
G9A69040	4.0	4	14	51
G9A69050	5.0	5	16	51
G9A69060	6.0	6	19	64
G9A69080	8.0	8	21	64
G9A69100	10.0	10	22	70
G9A69120	12.0	12	25	76
G9A69160	16.0	16	32	89
G9A69200	20.0	20	38	102

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

4 FLUTE, SHORT LENGTH

4 SCHNEIDEN, KURZ

G9448 SERIES **FLAT SHANK**
SEITLICHE MITNAHMEFLÄCHE

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.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9448020	2.0	6	4	50
G9448025	2.5	6	4	50
G9448030	3.0	6	5	50
G9448035	3.5	6	6	50
G9448040	4.0	6	8	54
G9448045	4.5	6	8	54
G9448050	5.0	6	9	54
G9448060	6.0	6	10	54
G9448070	7.0	8	11	58
G9448080	8.0	8	12	58
G9448090	9.0	10	13	66
G9448100	10.0	10	14	66
G9448120	12.0	12	16	73
G9448140	14.0	14	18	75
G9448160	16.0	16	22	82
G9448180	18.0	18	24	84
G9448200	20.0	20	26	92

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

4 FLUTE, LONG LENGTH

4 SCHNEIDEN, LANG

G9540 SERIES **PLAIN SHANK**
GLATTE ZYLINDERSCHAFT

MG HM DIN 6528 N

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.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9540035	3.5	3.5	10	50
G9540040	4.0	4	11	50
G9540045	4.5	4.5	11	50
G9540050	5.0	5	13	50
G9540055	5.5	5.5	13	57
G9540060	6.0	6	13	57
G9540065	6.5	6.5	16	60
G9540070	7.0	7	16	60
G9540075	7.5	7.5	19	63
G9540080	8.0	8	19	63
G9540085	8.5	8.5	19	67
G9540090	9.0	9	19	67
G9540095	9.5	9.5	22	72
G9540100	10.0	10	22	72
G9540110	11.0	11	26	83
G9540120	12.0	12	26	83
G9540130	13.0	13	26	83
G9540140	14.0	14	26	83
G9540150	15.0	15	32	92
G9540160	16.0	16	32	92
G9540180	18.0	18	32	92
G9540200	20.0	20	38	104

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

4 FLUTE, LONG LENGTH

4 SCHNEIDEN, LANG

G9449 SERIES **FLAT SHANK**
SEITLICHE MITNAHMEFLÄCHE

MG HM DIN 6527 N

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.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
G9449901	2.0	3	7	38
G9449030	3.0	6	8	57
G9449035	3.5	6	10	57
G9449040	4.0	6	11	57
G9449045	4.5	6	11	57
G9449050	5.0	6	13	57
G9449060	6.0	6	13	57
G9449070	7.0	8	16	63
G9449080	8.0	8	19	63
G9449090	9.0	10	19	72
G9449100	10.0	10	22	72
G9449120	12.0	12	26	83
G9449140	14.0	14	26	83
G9449160	16.0	16	32	92
G9449180	18.0	18	32	92
G9449200	20.0	20	38	104

with plain shank

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

4 FLUTE, EXTRA LONG LENGTH 4 SCHNEIDEN, EXTRA LANG

G9453 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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.



Unit : mm

EDP No.	MILL DIAMETER h 10	SHANK DIAMETER h 6	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 - 0.030	h6

2 FLUTE, BALL NOSE, SHORT LENGTH 2 SCHNEIDEN, STIRNRADIUS, KURZ

G9624 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.
[Für die Trockenbearbeitung.](#)
Hervorragendes Preis - Leistungsverhältnis.
Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9624020	R 1.0	2.0	6	4	48
G9624025	R 1.25	2.5	6	4	48
G9624030	R 1.5	3.0	6	4	48
G9624040	R 2.0	4.0	6	6	50
G9624901	R 2.0	4.0	4	12	40
G9624050	R 2.5	5.0	6	7	51
G9624902	R 2.5	5.0	5	14	50
G9624060	R 3.0	6.0	6	7	51
G9624080	R 4.0	8.0	8	9	59
G9624100	R 5.0	10.0	10	10	60
G9624120	R 6.0	12.0	12	14	71
G9624140	R 7.0	14.0	14	14	71
G9624160	R 8.0	16.0	16	16	76
G9624180	R 9.0	18.0	18	18	76
G9624200	R 10.0	20.0	20	20	82

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, BALL NOSE, SHORT LENGTH

2 SCHNEIDEN, STIRNRADIUS, KURZ

G9A70 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.

Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9A70010	R 0.5	1.0	3.0	3	39
G9A70015	R 0.75	1.5	3.0	5	39
G9A70020	R 1.0	2.0	3.0	7	39
G9A70025	R 1.25	2.5	3.0	7	39
G9A70030	R 1.5	3.0	3.0	9	39
G9A70040	R 2.0	4.0	4.0	14	51
G9A70050	R 2.5	5.0	5.0	16	51
G9A70060	R 3.0	6.0	6.0	19	64
G9A70080	R 4.0	8.0	8.0	21	64
G9A70100	R 5.0	10	10	22	70
G9A70110	R 5.5	11	11	25	70
G9A70120	R 6.0	12	12	25	76
G9A70160	R 8.0	16	16	32	89
G9A70200	R 10.0	20	20	38	102

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6



2 FLUTE, BALL NOSE, SHORT LENGTH

2 SCHNEIDEN, STIRNRADIUS, KURZ

G9437 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHE



Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.

Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9437020	R 1.0	2.0	6	3	50
G9437030	R 1.5	3.0	6	4	50
G9437040	R 2.0	4.0	6	5	54
G9437050	R 2.5	5.0	6	6	54
G9437060	R 3.0	6.0	6	7	54
G9437080	R 4.0	8.0	8	9	58
G9437100	R 5.0	10.0	10	11	66
G9437120	R 6.0	12.0	12	12	73
G9437140	R 7.0	14.0	14	14	75
G9437180	R 9.0	18.0	18	18	84
G9437200	R 10.0	20.0	20	20	92

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

2 FLUTE, BALL NOSE, LONG LENGTH

2 SCHNEIDEN, STIRNRADIUS, LANG

G9438 SERIES **FLAT SHANK**
SEITLICHE MITNAHMEFLÄCHE

MG HM DIN 6527 N 30 2 DIN 6535HB P.34

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9438020	R 1.0	2.0	3	6	38
G9438030	R 1.5	3.0	6	7	57
G9438040	R 2.0	4.0	6	8	57
G9438050	R 2.5	5.0	6	10	57
G9438060	R 3.0	6.0	6	10	57
G9438080	R 4.0	8.0	8	16	63
G9438100	R 5.0	10.0	10	19	72
G9438120	R 6.0	12.0	12	22	83
G9438140	R 7.0	14.0	14	22	83
G9438160	R 8.0	16.0	16	26	92
G9438180	R 9.0	18.0	18	26	92
G9438200	R 10.0	20.0	20	32	104

with plain shank

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

2 FLUTE, BALL NOSE, LONG REACH

2 SCHNEIDEN, STIRNRADIUS, GROSSE REICHWEITE

G9454 SERIES **PLAIN SHANK**
GLATTE ZYLINDERSCHAFT

MG HM YG STD N 30 2 DIN 6535HA P.34

Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9454030	R 1.5	3.0	3	5	75
G9454040	R 2.0	4.0	4	8	75
G9454050	R 2.5	5.0	5	9	75
G9454060	R 3.0	6.0	6	10	100
G9454080	R 4.0	8.0	8	12	100
G9454100	R 5.0	10.0	10	14	100
G9454120	R 6.0	12.0	12	16	100
G9454140	R 7.0	14.0	14	18	100
G9454160	R 8.0	16.0	16	22	150
G9454200	R 10.0	20.0	20	26	150

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

2 FLUTE, BALL NOSE, EXTRA LONG LENGTH

2 SCHNEIDEN, STIRNRADIUS, EXTRA LANG

G9455 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Designed for milling of radius bottom slots, fillets and special contours.

Für die Trockenbearbeitung.

Hervorragendes Preis - Leistungsverhältnis.

Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	LENGTH OF CUT	OVERALL LENGTH
G9455903	R 1.5	3.0	3	20	60
G9455904	R 2.0	4.0	4	20	60
G9455905	R 2.5	5.0	5	25	75
G9455906	R 3.0	6.0	6	30	75
G9455908	R 4.0	8.0	8	30	75
G9455910	R 5.0	10.0	10	40	100
G9455912	R 6.0	12.0	12	45	100
G9455914	R 7.0	14.0	14	45	100
G9455916	R 8.0	16.0	16	45	100
G9455918	R 9.0	18.0	18	45	100
G9455920	R 10.0	20.0	20	45	100

MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

4 FLUTE, BALL NOSE, SHORT LENGTH

4 SCHNEIDEN, STIRNRADIUS, KURZ

G9634 SERIES

PLAIN SHANK
GLATTE ZYLINDERSCHAFT



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.



Unit : mm

EDP No.	R i 0.02	MILL DIAMETER	SHANK DIAMETER h 6	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 - 0.030	h6

MULTI FLUTE, COARSE PITCH ROUGHING, LONG LENGTH

MEHRSCHEIDEN - SCHRUPPFÄRER, LANG

2 FLUTE, FINISH, SLOTTING

2 SCHNEIDEN, SCHLICHTEN, NUTENFRÄSEN

G9A42 SERIES **FLAT SHANK**
SEITLICHE MITNAHMEFLÄCHE

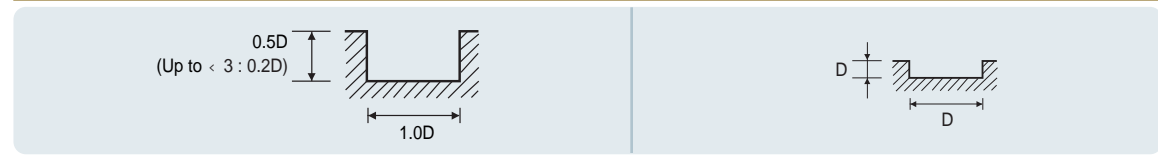
Suitable for dry milling applications at high temperatures.
Excellent high-performance end mills.
Fast chip ejection.
Für die Trockenbearbeitung.
Hervorragendes Preis - Leistungsverhältnis.
Guter Spanauswurf.



Unit : mm

EDP No.	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH	No. OF FLUTE
G9A42060	6.0	6	16	57	3
G9A42080	8.0	8	16	63	3
G9A42100	10.0	10	22	72	4
G9A42120	12.0	12	26	83	4
G9A42140	14.0	14	26	83	4
G9A42160	16.0	16	32	92	4
G9A42180	18.0	18	32	92	4
G9A42200	20.0	20	38	104	4
G9A42250	25.0	25	45	121	5

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	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	7850	160	5150	100	4300	80	9350	220	22000	460	16500	340
3	6100	180	3800	120	3150	100	6050	220	15400	460	11000	340
4	5150	255	3150	155	2650	130	4600	220	11000	460	8800	340
5	4300	270	2550	160	2150	135	3650	220	9150	460	6800	340
6	3800	300	2300	190	1950	155	2950	255	7600	485	5700	375
8	2850	325	1700	170	1450	155	2200	275	5700	485	4400	375
10	2200	280	1350	135	1150	135	1850	285	4600	485	3400	375
12	1850	240	1150	110	950	110	1450	295	3750	485	2850	375
14	1700	215	1050	100	850	100	1300	310	3300	485	2400	375
16	1500	185	950	95	700	95	1100	320	2850	485	2200	375
20	1150	145	700	70	550	70	900	340	2200	485	1700	375



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

RPM = rev./min. Feed = mm/min.

Tolerances according to DIN 7160 & 7161

Toleranzen nach DIN 7160 & 7161

Toleranzwerte in μm / Tolerance range in μm					
Nennmaßbereich in mm / Nominal-Diameter in mm					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
h10	0 -40	0 -48	0 -58	0 -70	0 -84
h6	0 -6	0 -8	0 -9	0 -11	0 -13

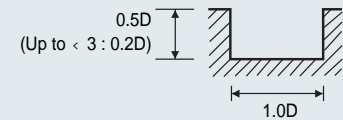
$\mu\text{m} = 1/1000\text{mm}$



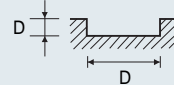
3 FLUTE, FINISH, SLOTTING

3 SCHNEIDEN, SCHLICHTEN, NUTENFRÄSEN

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	14300	75	8500	45	7150	35	18700	185	44000	300	24700	180
1.5	12750	105	5550	60	5600	55	12100	185	27500	345	20300	270
2	7850	110	5150	70	4300	55	9350	200	22000	420	16500	310
3	6100	125	3800	85	3150	70	6050	200	15400	430	11000	310
4	5150	180	3150	110	2650	90	4600	185	11000	420	8800	310
5	4300	190	2550	110	2150	95	3650	200	9150	420	6800	310
6	3800	210	2300	135	1950	110	2950	230	7600	440	5700	340
8	2850	230	1700	120	1450	110	2200	240	5700	440	4400	330
10	2200	195	1350	95	1150	95	1850	255	4600	440	3400	330
12	1850	170	1150	75	950	75	1450	275	3750	430	2850	330
14	1700	150	1050	70	850	70	1300	285	3300	430	2400	330
16	1500	130	950	65	700	65	1100	285	2850	430	2200	330
20	1150	100	700	50	550	50	900	310	2200	430	1700	330



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

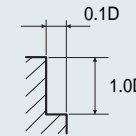


RPM = rev./min. Feed = mm/min.

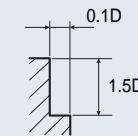
4 FLUTE, FINISH, SIDE CUTTING

4 SCHNEIDEN, SCHLICHTEN, SEITENFRÄSEN

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	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	9850	240	6450	145	5350	120	9350	640	22000	1320	16500	1035
3	7600	270	4750	170	3950	145	6050	640	15400	1320	11000	1035
4	6450	485	3950	300	3300	240	4600	640	11000	1320	8800	1035
5	5350	510	3200	305	2700	255	3650	640	9150	1320	6800	1035
6	4750	560	2850	350	2400	280	2950	770	7600	1430	5700	1100
8	3550	605	2150	325	1800	300	2200	815	5700	1430	4400	1100
10	2750	520	1700	255	1450	255	1850	860	4600	1430	3400	1100
12	2350	440	1450	215	1150	205	1450	900	3750	1430	2850	1100
14	2100	395	1300	195	1050	190	1300	945	3300	1430	2400	1100
16	1850	350	1150	170	950	170	1100	970	2850	1430	2200	1100
20	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%

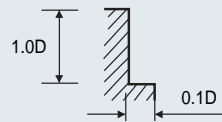


RPM = rev./min. Feed = mm/min.

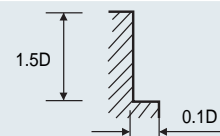
3 FLUTE, FINISH, SIDE CUTTING

3 SCHNEIDEN, SCHLICHTEN, SEITENFRÄSEN

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	17600	110	10250	65	8650	55	18700	460	44000	750	24700	450
1.5	11800	160	7050	85	7050	90	12100	460	27500	860	20300	675
2	9850	180	6450	120	5350	100	9350	475	22000	1035	16500	770
3	7600	205	4750	130	3950	105	6050	475	15400	990	11000	760
4	6450	365	3950	220	3300	180	4600	485	11000	1035	8800	770
5	5350	385	3200	230	2700	195	3650	485	9150	1010	6800	760
6	4750	425	2850	265	2400	215	2950	570	7600	1100	5700	825
8	3550	450	2150	245	1800	225	2200	615	5700	1100	4400	825
10	2750	390	1700	195	1450	195	1850	640	4600	1100	3400	825
12	2350	330	1450	160	1150	155	1450	670	3750	1100	2850	825
14	2100	465	1300	145	1050	140	1300	705	3300	1100	2400	825
16	1850	265	1150	130	900	130	1100	725	2850	1100	2200	825
20	1450	205	900	100	700	100	900	770	2200	1100	1700	825



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

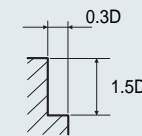


RPM = rev./min. Feed = mm/min.

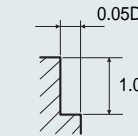
MULTI. FLUTE, ROUGHING, SIDE CUTTING

MULTI. SCHNEIDEN, SCHRUPPFRÄSER, SEITENFRÄSEN

MATERIAL	NON-ALLOYED STEELS, ALLOY STEELS, TOOL STEELS		ALLOY STEELS, HEAT RESISTANT STEELS		STAINLESS STEELS		INCONEL	
HARDNESS	~ HRC 30		HRC 30 ~ HRC 38		HRC 38 ~ HRC 45			
STRENGTH	~ 1000N/mm ²		1000 ~ 1200N/mm ²		1200 ~ 1400N/mm ²			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	13250	1970	10550	710	7150	480	2050	160
8	9850	1970	7800	710	5350	480	1550	150
10	7800	1970	6450	710	4350	480	1100	160
12	6800	2040	5100	680	3550	480	1000	160
14	5800	2040	4400	710	3050	480	750	110
16	5100	2040	4100	650	2800	430	700	90
18	4400	1970	3750	610	2300	360	600	90
20	4100	1840	3050	480	2050	310	550	90
25	3650	1830	2700	530	1850	350	500	90



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



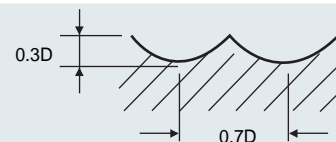
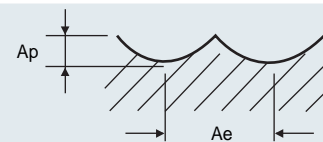
RPM = rev./min. Feed = mm/min.

2 FLUTE, BALL NOSE

2 SCHNEIDEN, STIRNRADIUS

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	12350	640	9150	415	4000	125	10500	220	30800	395
3	11400	575	8550	390	3800	125	7050	230	20500	395
4	8950	630	7150	450	3600	150	5150	285	15400	395
5	7800	700	6200	490	3100	150	4150	330	12100	470
6	7250	870	5900	705	2700	160	3400	360	10300	470
8	6100	1090	4900	785	2050	190	2500	460	7900	540
10	5450	1330	4350	870	1750	190	2050	460	6150	540
12	4990	1500	3950	950	1500	210	1750	460	5150	630
14	4530	1495	3600	925	1300	210	1400	460	4300	630
16	4085	1470	3200	905	1150	210	1300	460	3850	540
18	3800	1425	3000	890	1050	210	1100	460	3400	540
20	3550	1425	2800	885	950	210	1050	420	2950	540

Ap : D1~D6=0.2mm
D8~D20=0.3mm
Ae : 0.2D



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

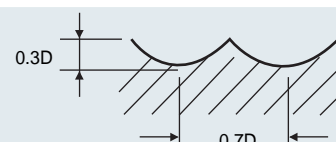
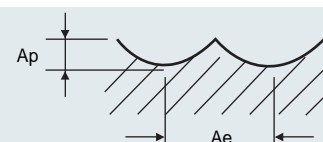
RPM = rev./min. Feed = mm/min.

4 FLUTE, BALL NOSE

4 SCHNEIDEN, STIRNRADIUS

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	13300	680	10000	405	4100	135	10500	330	30800	605
3	11500	870	8550	585	3850	190	7050	340	20500	605
4	8950	950	7150	680	3600	230	5150	430	15400	605
5	7800	1045	6200	745	3100	230	4150	495	12100	715
6	7250	1330	5900	1090	2700	235	3400	540	10300	715
8	6100	1660	4900	1185	2100	285	2500	680	7900	820
10	5450	1950	4350	1330	1750	290	2050	680	6150	820
12	4985	2230	4000	1425	1500	320	1750	680	5150	945
14	4500	2230	3600	1425	1300	320	1400	700	4300	945
16	4085	2230	3200	1380	1100	320	1300	700	3850	820
18	3800	2135	3000	1330	1050	320	1100	700	3400	820
20	3550	2135	2800	1330	950	320	1050	630	2950	820

Ap : D1~D6=0.2mm
D8~D20=0.3mm
Ae : 0.2D



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

RPM = rev./min. Feed = mm/min.



K-2 CARBIDE END MILLS