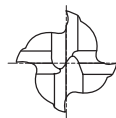


CARBIDE, 4 FLUTE SHORT END MILL



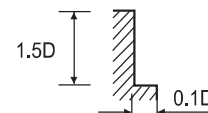
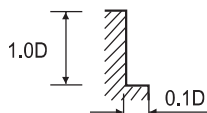
Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9F42010N	1.0	4	3	50
G9F42020N	2.0	4	6	50
G9F42030N	3.0	4	8	50
G9F42040N	4.0	4	11	50
G9F42050N	5.0	6	13	50
G9F42060N	6.0	6	16	50
G9F42080N	8.0	8	20	60
G9F42100N	10.0	10	25	75
G9F42120N	12.0	12	32	75
G9F42140N	14.0	14	32	75
G9F42160N	16.0	16	32	75
G9F42200N	20.0	20	32	100

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 - 0.030	h6

CUTTING CONDITIONS

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALLOY STEELS PRE-HARDENED STEELS				STAINLESS STEELS				CAST IRON			
	~ HRc30				HRc30 ~ HRc50											
HARDNESS	~ 1000N/mm ²				1000 ~ 1500N/mm ²											
STRENGTH	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
1.0	19000	160	60	0.002	11050	90	35	0.002	9350	80	29	0.002	20200	670	63	0.008
2.0	10650	260	67	0.006	6950	155	44	0.006	5800	130	36	0.006	10100	690	63	0.017
3.0	8200	290	77	0.009	5150	185	49	0.009	4250	155	40	0.009	6550	690	62	0.026
4.0	6950	525	87	0.019	4250	325	53	0.019	3550	260	45	0.018	4950	690	62	0.035
5.0	5800	550	91	0.024	3450	330	54	0.024	2900	275	46	0.024	3950	690	62	0.044
6.0	5100	605	96	0.030	3100	380	58	0.031	2600	300	49	0.029	3200	830	60	0.065
8.0	3850	655	97	0.043	2300	350	58	0.038	1950	325	49	0.042	2400	880	60	0.092
10.0	2950	560	93	0.047	1850	275	58	0.037	1500	275	47	0.046	2000	930	63	0.116
12.0	2550	475	96	0.047	1550	230	58	0.037	1250	220	47	0.044	1550	970	58	0.156
14.0	2250	425	99	0.047	1400	210	62	0.038	1150	205	51	0.045	1400	1020	62	0.182
16.0	2000	380	101	0.048	1250	185	63	0.037	1050	185	53	0.044	1200	1050	60	0.219
20.0	1550	290	97	0.047	950	145	60	0.038	750	140	47	0.047	950	1120	60	0.295



RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t