

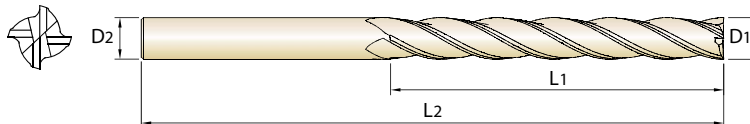
YGBasiX END MILLS



X-Coated **G9H94** SERIES
Uncoated **E5H94** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE SQUARE EXTRA LONG LENGTH

- Suitable for cutting high alloy steels, steel casting, chill casting, malleable cast iron, CrNi-steels, brass, copper, aluminum with a high percentage of silicon and abrasive plastics.



Unit : inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	D1	D2	L1	L2
G9H94008N	E5H94008	1/8	1/8	1	3
G9H94010N	E5H94010	5/32	3/16	1-1/8	3
G9H94901N	E5H94901	3/16	3/16	1	4
G9H94012N	E5H94012	3/16	3/16	1-1/8	3
G9H94016N	E5H94016	1/4	1/4	1	4
G9H94902N	E5H94902	1/4	1/4	1-1/2	4
G9H94903N	E5H94903	1/4	1/4	1-1/2	6
G9H94904N	E5H94904	5/16	5/16	1-1/2	6
G9H94020N	E5H94020	5/16	5/16	1-5/8	4
G9H94024N	E5H94024	3/8	3/8	1	4
G9H94906N	E5H94906	3/8	3/8	1-1/2	6
G9H94905N	E5H94905	3/8	3/8	1-3/4	4
G9H94028N	E5H94028	7/16	7/16	3	6
G9H94032N	E5H94032	1/2	1/2	1-1/2	6
G9H94907N	E5H94907	1/2	1/2	3	6
G9H94908N	E5H94908	1/2	1/2	4	7
G9H94909N	E5H94909	1/2	1/2	5	8
G9H94040N	E5H94040	5/8	5/8	1-1/2	6
G9H94910N	E5H94910	5/8	5/8	3	6
G9H94911N	E5H94911	5/8	5/8	4	7
G9H94912N	E5H94912	5/8	5/8	5	8
G9H94913N	E5H94913	5/8	5/8	6	9
G9H94048N	E5H94048	3/4	3/4	1-1/2	6
G9H94914N	E5H94914	3/4	3/4	3	6
G9H94915N	E5H94915	3/4	3/4	4	7
G9H94916N	E5H94916	3/4	3/4	5	8
G9H94917N	E5H94917	3/4	3/4	6	9
G9H94918N	E5H94918	3/4	3/4	8	12
G9H94064N	E5H94064	1	1	1-1/2	6
G9H94919N	E5H94919	1	1	3	6
G9H94920N	E5H94920	1	1	4	7
G9H94921N	E5H94921	1	1	5	8
G9H94922N	E5H94922	1	1	6	9
G9H94923N	E5H94923	1	1	7	10
G9H94924N	E5H94924	1	1	8	12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
+0/-0.0012	+0/-0.0005

*Uncoated Tools in this series are not recommended for slotting in stainless steel.

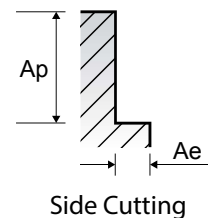
RECOMMENDED CUTTING CONDITIONS

E5H83, E5H84, E5H88, E5H90, E5H92, E5H94, E5H97

SQUARE / CORNER RADIUS / 4 FLUTE / SIDE CUTTING / INCH / Uncoated

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						1/8	5/32	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P	1-2	Non-alloy steel	0.1D	1.5D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					IPT	.0006	.0009	.0011	.0013	.0017	.0022	.0024	.0027	.0038	.0045	.0059	
					RPM	3360	2690	2240	1680	1340	1120	960	840	670	560	420	
	3-4		0.1D	1.5D	IPM	9	9	10	9	9	10	9	9	10	10	10	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					IPT	.0007	.0009	.0011	.0013	.0018	.0023	.0025	.0027	.0038	.0045	.0057	
	5		0.1D	1.5D	RPM	2900	2320	1940	1450	1160	970	830	730	580	480	360	
					IPM	8	8	9	8	8	9	8	8	9	9	8	
					SFM	80	80	80	80	80	80	80	80	80	80	80	
	6	Low alloy steel	0.1D	1.5D	IPT	.0006	.0008	.0010	.0012	.0016	.0020	.0022	.0024	.0039	.0046	.0059	
					RPM	2440	1960	1630	1220	980	810	700	610	490	410	310	
					IPM	6	6	7	6	6	6	6	6	8	7	7	
	7		0.1D	1.5D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					IPT	.0006	.0009	.0011	.0013	.0017	.0022	.0024	.0027	.0038	.0045	.0059	
					RPM	3360	2690	2240	1680	1340	1120	960	840	670	560	420	
	8-9		0.1D	1.5D	IPM	9	9	10	9	9	10	9	9	10	10	10	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					IPT	.0007	.0009	.0011	.0013	.0018	.0023	.0025	.0027	.0038	.0045	.0057	
	10	High alloyed steel, and tool steel	0.1D	1.5D	RPM	2900	2320	1940	1450	1160	970	830	730	580	480	360	
					IPM	8	8	9	8	8	9	8	8	9	9	8	
					SFM	80	80	80	80	80	80	80	80	80	80	80	
	11.1		0.1D	1.5D	IPT	.0006	.0008	.0010	.0012	.0016	.0020	.0022	.0024	.0039	.0046	.0059	
					RPM	2440	1960	1630	1220	980	810	700	610	490	410	310	
					IPM	6	6	7	6	6	6	6	6	8	7	7	
M	14.1		Stainless steel	0.1D	1.5D	SFM	100	100	100	100	100	100	100	100	100	100	
						IPT	.0003	.0004	.0006	.0007	.0009	.0011	.0012	.0014	.0020	.0025	.0033
						RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	IPM	4	4	5	4	4	5	4	4	5	5		
					SFM	125	125	125	125	125	125	125	125	125	125	125	
					IPT	.0010	.0012	.0016	.0023	.0032	.0041	.0048	.0056	.0075	.0092	.0124	
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.1D	1.5D	RPM	3820	3060	2550	1910	1530	1270	1090	950	760	640	480	
					IPM	15	15	16	17	19	21	21	21	23	23	24	
					SFM	315	315	315	315	315	315	315	315	315	315	315	
	26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	IPT	.0008	.0011	.0013	.0017	.0023	.0028	.0032	.0035	.0045	.0053	.0068	
					RPM	9630	7700	6420	4810	3850	3210	2750	2410	1930	1600	1200	
					IPM	30	33	34	33	35	36	35	34	35	34	33	
					SFM	235	235	235	235	235	235	235	235	235	235	235	
					IPT	.0007	.0010	.0012	.0017	.0023	.0029	.0032	.0035	.0046	.0054	.0069	
					RPM	7180	5740	4790	3590	2870	2390	2050	1800	1440	1200	900	
					IPM	20	22	23	25	26	28	26	25	27	26	25	

SFM = ft./min.
IPT = In./tooth
RPM = rev./min.
IPM = In./min.



Holemaking

Threading

Milling

Indexable Inserts

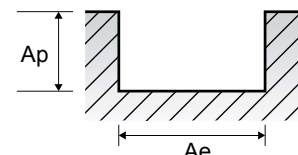
RECOMMENDED CUTTING CONDITIONS

E5H83, E5H84, E5H88, E5H90, E5H92, E5H94, E5H97

SQUARE / CORNER RADIUS / 4 FLUTE / SLOTTING / INCH / Uncoated

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						1/8	5/32	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P	1-2	Non-alloy steel	1.0D	0.3D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					IPT	.0004	.0006	.0007	.0009	.0011	.0014	.0016	.0018	.0025	.0030	.0039	
					RPM	3360	2690	2240	1680	1340	1120	960	840	670	560	420	
	3-4		1.0D	0.3D	IPM	6	6	6	6	6	6	6	6	7	7	7	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					IPT	.0005	.0006	.0008	.0009	.0012	.0015	.0017	.0018	.0026	.0030	.0038	
	5		1.0D	0.3D	RPM	2900	2320	1940	1450	1160	970	830	730	580	480	360	
					IPM	5	6	6	5	6	6	6	5	6	6	6	
					SFM	80	80	80	80	80	80	80	80	80	80	80	
	6		1.0D	0.3D	IPT	.0004	.0005	.0007	.0008	.0011	.0014	.0015	.0016	.0027	.0032	.0041	
		RPM			2440	1960	1630	1220	980	810	700	610	490	410	310		
		IPM			4	4	4	4	4	4	4	4	5	5	5		
	7	Low alloy steel	1.0D	0.3D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					IPT	.0004	.0006	.0007	.0009	.0011	.0014	.0016	.0018	.0025	.0030	.0039	
					RPM	3360	2690	2240	1680	1340	1120	960	840	670	560	420	
	8-9		1.0D	0.3D	IPM	6	6	6	6	6	6	6	6	7	7	7	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					IPT	.0005	.0006	.0008	.0009	.0012	.0015	.0017	.0018	.0026	.0030	.0038	
	10		High alloyed steel, and tool steel	1.0D	0.3D	RPM	2900	2320	1940	1450	1160	970	830	730	580	480	360
						IPM	5	6	6	5	6	6	6	5	6	6	6
						SFM	80	80	80	80	80	80	80	80	80	80	80
	11.1	1.0D		0.3D	IPT	.0004	.0005	.0007	.0008	.0011	.0014	.0015	.0016	.0027	.0032	.0041	
					RPM	2440	1960	1630	1220	980	810	700	610	490	410	310	
					IPM	4	4	4	4	4	4	4	4	5	5	5	
	K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.3D	SFM	125	125	125	125	125	125	125	125	125	125	
IPT						.0006	.0008	.0011	.0015	.0021	.0027	.0032	.0037	.0050	.0061	.0084	
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	1.0D	0.5D	RPM	3820	3060	2550	1910	1530	1270	1090	950	760	640	480	
					IPM	10	10	11	12	13	14	14	14	15	16	16	
					SFM	315	315	315	315	315	315	315	315	315	315	315	
	26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	1.0D	0.5D	IPT	.0005	.0007	.0009	.0012	.0015	.0019	.0021	.0023	.0030	.0035	.0045	
					RPM	9630	7700	6420	4810	3850	3210	2750	2410	1930	1600	1200	
					IPM	20	22	23	22	23	24	23	22	23	23	22	
					SFM	235	235	235	235	235	235	235	235	235	235	235	
					IPT	.0005	.0007	.0009	.0012	.0015	.0019	.0021	.0023	.0031	.0036	.0046	
					RPM	7180	5740	4790	3590	2870	2390	2050	1800	1440	1200	900	
					IPM	15	16	17	17	18	18	17	17	18	17	17	

SFM = ft./min.
IPT = In./tooth
RPM = rev./min.
IPM = In./min.



Slotting

Holemaking

Threading

Milling

Indexable Inserts