

YGBasiX END MILLS

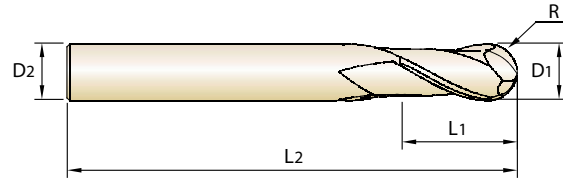


X-Coated **G9102** SERIES

Uncoated **E5102** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 2 FLUTE BALL NOSE REGULAR 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.



P. 148-149

Unit : inch

EDP No.		Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	R	D1	D2	L1	L2
G9102001N	E5102001	R.0078	1/64	1/8	3/64	1-1/2
G9102002N	E5102002	R1/64	1/32	1/8	1/8	1-1/2
G9102003N	E5102003	R.0234	3/64	1/8	1/8	1-1/2
G9102004N	E5102004	R1/32	1/16	1/8	1/8	1-1/2
G9102901N	E5102901	R1/32	1/16	1/8	1/4	1-1/2
G9102005N	E5102005	R.0391	5/64	1/8	1/4	1-1/2
G9102006N	E5102006	R3/64	3/32	1/8	3/8	1-1/2
G9102007N	E5102007	R.0547	7/64	1/8	3/8	1-1/2
G9102008N	E5102008	R1/16	1/8	1/8	1/2	1-1/2
G9102009N	E5102009	R.0703	9/64	3/16	9/16	2
G9102010N	E5102010	R5/64	5/32	3/16	9/16	2
G9102011N	E5102011	R.0859	11/64	3/16	9/16	2
G9102012N	E5102012	R3/32	3/16	3/16	5/8	2
G9102013N	E5102013	R.1016	13/64	1/4	5/8	2-1/2
G9102014N	E5102014	R7/64	7/32	1/4	5/8	2-1/2
G9102015N	E5102015	R.1172	15/64	1/4	3/4	2-1/2
G9102016N	E5102016	R1/8	1/4	1/4	3/4	2-1/2
G9102017N	E5102017	R.1328	17/64	5/16	3/4	2-1/2
G9102018N	E5102018	R9/64	9/32	5/16	3/4	2-1/2
G9102019N	E5102019	R.1484	19/64	5/16	13/16	2-1/2
G9102020N	E5102020	R5/32	5/16	5/16	13/16	2-1/2
G9102021N	E5102021	R.1641	21/64	3/8	1	2-1/2
G9102022N	E5102022	R11/64	11/32	3/8	1	2-1/2
G9102023N	E5102023	R.1797	23/64	3/8	1	2-1/2
G9102024N	E5102024	R3/16	3/8	3/8	1	2-1/2
G9102025N	E5102025	R.1953	25/64	7/16	1	2-3/4
G9102026N	E5102026	R13/64	13/32	7/16	1	2-3/4
G9102027N	E5102027	R.2109	27/64	7/16	1	2-3/4
G9102028N	E5102028	R7/32	7/16	7/16	1	2-3/4
G9102029N	E5102029	R.2266	29/64	1/2	1	3
G9102030N	E5102030	R15/64	15/32	1/2	1	3
G9102031N	E5102031	R.2422	31/64	1/2	1	3
G9102032N	E5102032	R1/4	1/2	1/2	1	3
G9102036N	E5102036	R9/32	9/16	9/16	1-1/4	3-1/2
G9102040N	E5102040	R5/16	5/8	5/8	1-1/4	3-1/2
G9102044N	E5102044	R11/32	11/16	3/4	1-1/2	4
G9102048N	E5102048	R3/8	3/4	3/4	1-1/2	4
G9102056N	E5102056	R7/16	7/8	7/8	1-1/2	4
G9102064N	E5102064	R1/2	1	1	1-1/2	4

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

RECOMMENDED CUTTING CONDITIONS

E5H98, E5I02, E5I04, E5I07

BALL NOSE / 2 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	1-4	Non-alloy steel	0.7D	0.3D	SFM	100	100	100	100	100	100	100	100	100	100	100
					IPT	.0005	.0007	.0009	.0010	.0013	.0017	.0017	.0018	.0024	.0029	.0037
					RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380
	IPM		3	3	4	3	3	3	3	3	3	3	3			
	5		0.7D	0.3D	SFM	85	85	85	85	85	85	85	85	85	85	85
					IPT	.0003	.0004	.0005	.0006	.0007	.0009	.0010	.0011	.0015	.0018	.0022
		RPM			2600	2080	1730	1300	1040	870	740	650	520	430	320	
	IPM	1	2	2	1	2	2	2	1	2	2	1				
	6-7	Low alloy steel	0.7D	0.3D	SFM	100	100	100	100	100	100	100	100	100	100	100
					IPT	.0005	.0007	.0009	.0010	.0013	.0017	.0017	.0018	.0024	.0029	.0037
					RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380
	IPM		3	3	4	3	3	3	3	3	3	3	3			
	8-9		0.7D	0.3D	SFM	85	85	85	85	85	85	85	85	85	85	85
					IPT	.0003	.0004	.0005	.0006	.0007	.0009	.0010	.0011	.0015	.0018	.0022
RPM		2600			2080	1730	1300	1040	870	740	650	520	430	320		
IPM	1	2	2	1	2	2	2	1	2	2	1					
10	High alloyed steel, and tool steel	0.7D	0.3D	SFM	100	100	100	100	100	100	100	100	100	100	100	
				IPT	.0005	.0007	.0009	.0010	.0013	.0017	.0017	.0018	.0024	.0029	.0037	
				RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380	
IPM		3	3	4	3	3	3	3	3	3	3	3				
11.1		0.7D	0.3D	SFM	85	85	85	85	85	85	85	85	85	85	85	
				IPT	.0003	.0004	.0005	.0006	.0007	.0009	.0010	.0011	.0015	.0018	.0022	
	RPM			2600	2080	1730	1300	1040	870	740	650	520	430	320		
IPM	1	2	2	1	2	2	2	1	2	2	1					
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.7D	0.3D	SFM	140	140	140	140	140	140	140	140	140	140	
					IPT	.0006	.0010	.0014	.0019	.0032	.0040	.0044	.0047	.0063	.0071	.0069
					RPM	4280	3420	2850	2140	1710	1430	1220	1070	860	710	530
					IPM	5	7	8	8	11	11	11	10	11	10	7
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.7D	0.3D	SFM	425	425	425	425	425	425	425	425	425	425	
					IPT	.0004	.0005	.0007	.0008	.0012	.0016	.0019	.0022	.0025	.0030	.0038
					RPM	12990	10390	8660	6490	5190	4330	3710	3250	2600	2160	1620
					IPM	9	9	11	11	13	14	14	14	13	13	12

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

