

YGBasiX END MILLS

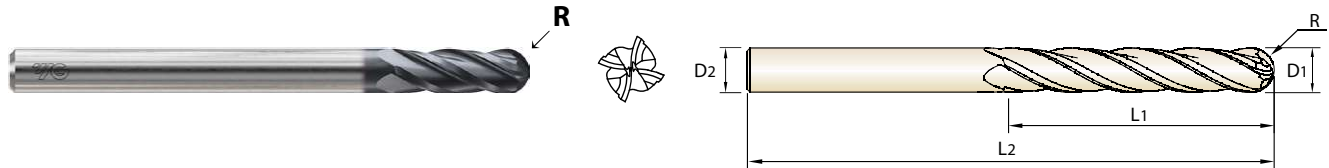


X-Coated **G9109** SERIES

Uncoated **E5109** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE BALL NOSE 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.



P. 152-153

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
G9109008N	E5109008	R1/16	1/8	1/8	1	3
G9109010N	E5109010	R5/64	5/32	3/16	1-1/8	3
G9109012N	E5109012	R3/32	3/16	3/16	1-1/8	3
G9109016N	E5109016	R1/8	1/4	1/4	1	4
G9109901N	E5109901	R1/8	1/4	1/4	1-1/2	4
G9109902N	E5109902	R1/8	1/4	1/4	1-1/2	6
G9109903N	E5109903	R5/32	5/16	5/16	1-1/2	6
G9109020N	E5109020	R5/32	5/16	5/16	1-5/8	4
G9109904N	E5109904	R3/16	3/8	3/8	1-1/2	6
G9109024N	E5109024	R3/16	3/8	3/8	1-3/4	4
G9109028N	E5109028	R7/32	7/16	7/16	3	6
G9109032N	E5109032	R1/4	1/2	1/2	1-1/2	6
G9109905N	E5109905	R1/4	1/2	1/2	3	6
G9109040N	E5109040	R5/16	5/8	5/8	1-1/2	6
G9109906N	E5109906	R5/16	5/8	5/8	3	6
G9109048N	E5109048	R3/8	3/4	3/4	1-1/2	6
G9109907N	E5109907	R3/8	3/4	3/4	3	6
G9109908N	E5109908	R1/2	1	1	1-1/2	6
G9109064N	E5109064	R1/2	1	1	3	6

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

Holemaking

Threading

Milling

Indexable Inserts

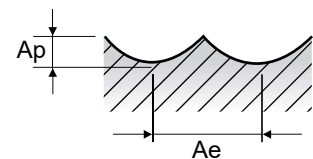
RECOMMENDED CUTTING CONDITIONS

E5H99, E5I01, E5I05, E5I06, E5I08, E5I09

BALL NOSE / 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	1-4	Non-alloy steel	0.7D	0.3D	SFM	100	100	100	100	100	100	100	100	100	100	100
					IPT	.0004	.0005	.0068	.0008	.0010	.0012	.0013	.0013	.0018	.0021	.0028
					RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380
	IPM		5	5	55	5	5	5	4	4	4	4	4			
	IPT		.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017			
	RPM		2600	2080	1730	1300	1040	870	740	650	520	430	320			
	IPM	2	2	3	2	2	3	2	2	2	2	2	2			
	IPT	.0004	.0005	.0068	.0008	.0010	.0012	.0013	.0013	.0018	.0021	.0028				
	RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380				
	IPM	5	5	55	5	5	5	4	4	4	4	4	4			
	IPT	.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017				
	RPM	2600	2080	1730	1300	1040	870	740	650	520	430	320				
	IPM	2	2	3	2	2	3	2	2	2	2	2	2			
	IPT	.0004	.0005	.0068	.0008	.0010	.0012	.0013	.0013	.0018	.0021	.0028				
RPM	3060	2440	2040	1530	1220	1020	870	760	610	510	380					
IPM	5	5	55	5	5	5	4	4	4	4	4	4				
IPT	.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017					
RPM	2600	2080	1730	1300	1040	870	740	650	520	430	320					
IPM	2	2	3	2	2	3	2	2	2	2	2	2				
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	140
					IPT	.0004	.0007	.0011	.0014	.0024	.0030	.0033	.0035	.0047	.0054	.0053
					RPM	4280	3420	2850	2140	1710	1430	1220	1070	860	710	530
					IPM	8	10	12	12	16	17	16	15	16	15	11
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.7D	0.3D	SFM	425	425	425	425	425	425	425	425	425	425	425
					IPT	.0003	.0003	.0005	.0006	.0009	.0012	.0014	.0016	.0019	.0023	.0029
					RPM	12990	10390	8660	6490	5190	4330	3710	3250	2600	2160	1620
					IPM	14	14	17	16	19	20	21	21	19	19	18

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



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