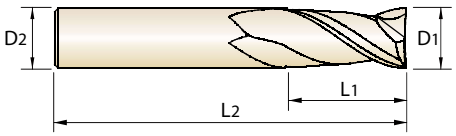
X-Coated **G9H85** SERIES
Uncoated **E5H85** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS
2 FLUTE SQUARE 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.



CARBIDE | 2 | 30° | PLAIN

P.134-135

Unit : inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	D1	D2	L1	L2
G9H85001N	E5H85001	1/64	1/8	3/64	1-1/2
G9H85002N	E5H85002	1/32	1/8	5/64	1-1/2
G9H85901N	E5H85901	1/32	1/8	1/8	1-1/2
G9H85003N	E5H85003	3/64	1/8	7/64	1-1/2
G9H85902N	E5H85902	3/64	1/8	1/8	1-1/2
G9H85004N	E5H85004	1/16	1/8	3/16	1-1/2
G9H85903N	E5H85903	1/16	1/8	1/4	1-1/2
G9H85005N	E5H85005	5/64	1/8	3/16	1-1/2
G9H85905N	E5H85905	5/64	1/8	1/4	1-1/2
G9H85006N	E5H85006	3/32	1/8	3/8	1-1/2
G9H85007N	E5H85007	7/64	1/8	3/8	1-1/2
G9H85008N	E5H85008	1/8	1/8	1/2	1-1/2
G9H85009N	E5H85009	9/64	3/16	1/2	2
G9H85906N	E5H85906	9/64	3/16	9/16	2
G9H85010N	E5H85010	5/32	3/16	9/16	2
G9H85011N	E5H85011	11/64	3/16	9/16	2
G9H85907N	E5H85907	11/64	3/16	5/8	2
G9H85012N	E5H85012	3/16	3/16	5/8	2
G9H85013N	E5H85013	13/64	1/4	5/8	2-1/2
G9H85014N	E5H85014	7/32	1/4	5/8	2-1/2
G9H85015N	E5H85015	15/64	1/4	3/4	2-1/2
G9H85016N	E5H85016	1/4	1/4	3/4	2-1/2
G9H85017N	E5H85017	17/64	5/16	3/4	2-1/2
G9H85018N	E5H85018	9/32	5/16	3/4	2-1/2
G9H85019N	E5H85019	19/64	5/16	13/16	2-1/2
G9H85020N	E5H85020	5/16	5/16	13/16	2-1/2
G9H85021N	E5H85021	21/64	3/8	1	2-1/2
G9H85022N	E5H85022	11/32	3/8	1	2-1/2
G9H85023N	E5H85023	23/64	3/8	1	2-1/2
G9H85024N	E5H85024	3/8	3/8	1	2-1/2
G9H85025N	E5H85025	25/64	7/16	1	2-3/4
G9H85026N	E5H85026	13/32	7/16	1	2-3/4
G9H85027N	E5H85027	27/64	7/16	1	2-3/4
G9H85028N	E5H85028	7/16	7/16	1	2-3/4
G9H85029N	E5H85029	29/64	1/2	1	3
G9H85030N	E5H85030	15/32	1/2	1	3
G9H85031N	E5H85031	31/64	1/2	1	3
G9H85032N	E5H85032	1/2	1/2	1	3
G9H85908N	E5H85908	1/2	1/2	1-1/4	3
G9H85033N	E5H85033	33/64	9/16	1-1/4	3-1/2
G9H85034N	E5H85034	17/32	9/16	1-1/4	3-1/2
G9H85036N	E5H85036	9/16	9/16	1-1/4	3-1/2
G9H85040N	E5H85040	5/8	5/8	1-1/4	3-1/2
G9H85044N	E5H85044	11/16	3/4	1-1/2	4
G9H85048N	E5H85048	3/4	3/4	1-1/2	4
G9H85056N	E5H85056	7/8	7/8	1-1/2	4
G9H85064N	E5H85064	1	1	1-1/2	4

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
+0/-.0012	+0/-.0005

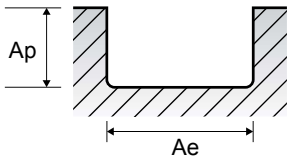
*Only Coated Tools in this series are recommended for stainless steel machining

G9H80, G9H81, G9H85, G9H87, G9H91, G9H93, G9H96

SQUARE / CORNER RADIUS / 2 Flute / SLOTTING / INCH / **X-Coated**

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	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	170	170	170	170	170	170	170	170	170	170	170
					IPT	.0005	.0006	.0008	.0009	.0012	.0015	.0017	.0018	.0025	.0029	.0037
					RPM	5190	4160	3460	2600	2080	1730	1480	1300	1040	870	650
					IPM	5	5	5	5	5	5	5	5	5	5	5
	3-4		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	145	145	145	145	145	145	145	145	145	145	145
					IPT	.0005	.0006	.0008	.0009	.0013	.0016	.0017	.0019	.0024	.0029	.0039
					RPM	4430	3540	2950	2220	1770	1480	1270	1110	890	740	550
					IPM	4	4	4	4	4	5	4	4	4	4	4
	5		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	120	120	120	120	120	120	120	120	120	120	120
					IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0027	.0032	.0041
					RPM	3670	2930	2440	1830	1470	1220	1050	920	730	610	460
					IPM	3	3	3	3	3	3	3	3	4	4	4
	6	Low alloy steel	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	170	170	170	170	170	170	170	170	170	170	170
					IPT	.0005	.0006	.0008	.0009	.0012	.0015	.0017	.0018	.0025	.0029	.0037
					RPM	5190	4160	3460	2600	2080	1730	1480	1300	1040	870	650
					IPM	5	5	5	5	5	5	5	5	5	5	5
	7		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	145	145	145	145	145	145	145	145	145	145	145
					IPT	.0005	.0006	.0008	.0009	.0013	.0016	.0017	.0019	.0024	.0029	.0039
					RPM	4430	3540	2950	2220	1770	1480	1270	1110	890	740	550
					IPM	4	4	4	4	4	5	4	4	4	4	4
	8-9		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	120	120	120	120	120	120	120	120	120	120	120
					IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0027	.0032	.0041
					RPM	3670	2930	2440	1830	1470	1220	1050	920	730	610	460
					IPM	3	3	3	3	3	3	3	3	4	4	4
	10	High alloyed steel, and tool steel	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	170	170	170	170	170	170	170	170	170	170	170
					IPT	.0005	.0006	.0008	.0009	.0012	.0015	.0017	.0018	.0025	.0029	.0037
					RPM	5190	4160	3460	2600	2080	1730	1480	1300	1040	870	650
					IPM	5	5	5	5	5	5	5	5	5	5	5
	11.1		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	120	120	120	120	120	120	120	120	120	120	120
					IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0027	.0032	.0041
					RPM	3670	2930	2440	1830	1470	1220	1050	920	730	610	460
					IPM	3	3	3	3	3	3	3	3	4	4	4
M	14.1	Stainless steel	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	120	120	120	120	120	120	120	120	120	120	120
					IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0027	.0032	.0041
					RPM	3670	2930	2440	1830	1470	1220	1050	920	730	610	460
					IPM	3	3	3	3	3	3	3	3	4	4	4
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	SFM	195	195	195	195	195	195	195	195	195	195	195
					IPT	.0006	.0008	.0011	.0015	.0022	.0027	.0032	.0037	.0051	.0061	.0080
					RPM	5960	4770	3970	2980	2380	1990	1700	1490	1190	990	740
					IPM	8	8	8	9	11	11	11	11	12	12	12
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	1.0D	1.0D	SFM	490	490	490	490	490	490	490	490	490	490	490
					IPT	.0005	.0008	.0009	.0011	.0015	.0019	.0021	.0023	.0030	.0036	.0048
					RPM	14970	11980	9980	7490	5990	4990	4280	3740	2990	2500	1870
					IPM	16	18	18	17	18	19	18	17	18	18	18
	26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	1.0D	1.0D	SFM	370	370	370	370	370	370	370	370	370	370	370
					IPT	.0006	.0007	.0009	.0012	.0015	.0020	.0021	.0023	.0030	.0036	.0047
					RPM	11310	9050	7540	5650	4520	3770	3230	2830	2260	1880	1410
					IPM	12	12	13	13	14	15	14	13	14	14	13

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



Slotting