

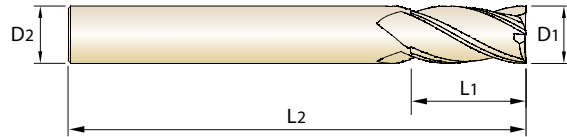
# YGBasiX END MILLS



X-Coated **G9H88** SERIES  
Uncoated **E5H88** SERIES

## X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 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.



Unit : inch

| EDP No.   |          | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|-----------|----------|---------------|----------------|---------------|----------------|
| X-Coated  | Uncoated | D1            | D2             | L1            | L2             |
| G9H88001N | E5H88001 | 1/64          | 1/8            | 3/64          | 1-1/2          |
| G9H88002N | E5H88002 | 1/32          | 1/8            | 5/64          | 1-1/2          |
| G9H88901N | E5H88901 | 1/32          | 1/8            | 1/8           | 1-1/2          |
| G9H88003N | E5H88003 | 3/64          | 1/8            | 1/8           | 1-1/2          |
| G9H88004N | E5H88004 | 1/16          | 1/8            | 3/16          | 1-1/2          |
| G9H88902N | E5H88902 | 1/16          | 1/8            | 1/4           | 1-1/2          |
| G9H88005N | E5H88005 | 5/64          | 1/8            | 3/16          | 1-1/2          |
| G9H88903N | E5H88903 | 5/64          | 1/8            | 1/4           | 1-1/2          |
| G9H88006N | E5H88006 | 3/32          | 1/8            | 3/8           | 1-1/2          |
| G9H88007N | E5H88007 | 7/64          | 1/8            | 3/8           | 1-1/2          |
| G9H88008N | E5H88008 | 1/8           | 1/8            | 1/2           | 1-1/2          |
| G9H88009N | E5H88009 | 9/64          | 3/16           | 1/2           | 2              |
| G9H88904N | E5H88904 | 9/64          | 3/16           | 9/16          | 2              |
| G9H88010N | E5H88010 | 5/32          | 3/16           | 9/16          | 2              |
| G9H88011N | E5H88011 | 11/64         | 3/16           | 9/16          | 2              |
| G9H88905N | E5H88905 | 11/64         | 3/16           | 5/8           | 2              |
| G9H88012N | E5H88012 | 3/16          | 3/16           | 5/8           | 2              |
| G9H88013N | E5H88013 | 13/64         | 1/4            | 5/8           | 2-1/2          |
| G9H88014N | E5H88014 | 7/32          | 1/4            | 5/8           | 2-1/2          |
| G9H88015N | E5H88015 | 15/64         | 1/4            | 3/4           | 2-1/2          |
| G9H88016N | E5H88016 | 1/4           | 1/4            | 3/4           | 2-1/2          |
| G9H88017N | E5H88017 | 17/64         | 5/16           | 3/4           | 2-1/2          |
| G9H88018N | E5H88018 | 9/32          | 5/16           | 3/4           | 2-1/2          |
| G9H88019N | E5H88019 | 19/64         | 5/16           | 13/16         | 2-1/2          |
| G9H88020N | E5H88020 | 5/16          | 5/16           | 13/16         | 2-1/2          |
| G9H88021N | E5H88021 | 21/64         | 3/8            | 1             | 2-1/2          |
| G9H88022N | E5H88022 | 11/32         | 3/8            | 1             | 2-1/2          |
| G9H88023N | E5H88023 | 23/64         | 3/8            | 1             | 2-1/2          |
| G9H88024N | E5H88024 | 3/8           | 3/8            | 1             | 2-1/2          |
| G9H88025N | E5H88025 | 25/64         | 7/16           | 1             | 2-3/4          |
| G9H88026N | E5H88026 | 13/32         | 7/16           | 1             | 2-3/4          |
| G9H88027N | E5H88027 | 27/64         | 7/16           | 1             | 2-3/4          |
| G9H88028N | E5H88028 | 7/16          | 7/16           | 1             | 2-3/4          |
| G9H88029N | E5H88029 | 29/64         | 1/2            | 1             | 3              |
| G9H88030N | E5H88030 | 15/32         | 1/2            | 1             | 3              |
| G9H88031N | E5H88031 | 31/64         | 1/2            | 1             | 3              |
| G9H88032N | E5H88032 | 1/2           | 1/2            | 1             | 3              |
| G9H88906N | E5H88906 | 1/2           | 1/2            | 1-1/4         | 3              |
| G9H88033N | E5H88033 | 33/64         | 9/16           | 1-1/4         | 3-1/2          |
| G9H88034N | E5H88034 | 17/32         | 9/16           | 1-1/4         | 3-1/2          |
| G9H88036N | E5H88036 | 9/16          | 9/16           | 1-1/4         | 3-1/2          |

Holemaking

Threading

Milling

Indexable Inserts

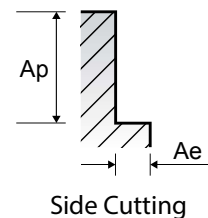
## RECOMMENDED CUTTING CONDITIONS

**G9H83, G9H84, G9H88, G9H90, G9H92, G9H94, G9H97**

**SQUARE / CORNER RADIUS / 4 FLUTE / SIDE CUTTING / 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     |       |       |       |       |
| Holemaking        | P     | 1-2      | Non-alloy steel                    | 0.1D            | 1.5D                                                       | SFM                                                                    | 170                                              | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPT                                                                    | .0006                                            | .0009 | .0011 | .0013 | .0017 | .0022 | .0024 | .0026 | .0038 | .0044 | .0056 |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | RPM                                                                    | 5190                                             | 4160  | 3460  | 2600  | 2080  | 1730  | 1480  | 1300  | 1040  | 870   | 650   |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPM                                                                    | 13                                               | 14    | 15    | 13    | 14    | 15    | 14    | 13    | 16    | 15    | 14    |       |       |       |       |
| SFM               |       | 145      |                                    | 145             | 145                                                        | 145                                                                    | 145                                              | 145   | 145   | 145   | 145   | 145   | 145   | 145   |       |       |       |       |       |       |       |
| IPT               |       | .0007    |                                    | .0009           | .0011                                                      | .0014                                                                  | .0018                                            | .0023 | .0025 | .0027 | .0038 | .0045 | .0060 |       |       |       |       |       |       |       |       |
| RPM               |       | 4430     |                                    | 3540            | 2950                                                       | 2220                                                                   | 1770                                             | 1480  | 1270  | 1110  | 890   | 740   | 550   |       |       |       |       |       |       |       |       |
| IPM               |       | 12       |                                    | 13              | 13                                                         | 12                                                                     | 13                                               | 13    | 13    | 12    | 13    | 13    | 13    |       |       |       |       |       |       |       |       |
| SFM               |       | 120      |                                    | 120             | 120                                                        | 120                                                                    | 120                                              | 120   | 120   | 120   | 120   | 120   | 120   | 120   |       |       |       |       |       |       |       |
| IPT               |       | .0006    |                                    | .0008           | .0010                                                      | .0012                                                                  | .0016                                            | .0020 | .0022 | .0024 | .0040 | .0046 | .0060 |       |       |       |       |       |       |       |       |
| RPM               |       | 3670     |                                    | 2930            | 2440                                                       | 1830                                                                   | 1470                                             | 1220  | 1050  | 920   | 730   | 610   | 460   |       |       |       |       |       |       |       |       |
| IPM               |       | 9        |                                    | 9               | 10                                                         | 9                                                                      | 9                                                | 10    | 9     | 9     | 12    | 11    | 11    |       |       |       |       |       |       |       |       |
| Threading         | P     | 6        | Low alloy steel                    | 0.1D            | 1.5D                                                       | SFM                                                                    | 170                                              | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPT                                                                    | .0006                                            | .0009 | .0011 | .0013 | .0017 | .0022 | .0024 | .0026 | .0038 | .0044 | .0056 |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | RPM                                                                    | 5190                                             | 4160  | 3460  | 2600  | 2080  | 1730  | 1480  | 1300  | 1040  | 870   | 650   |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPM                                                                    | 13                                               | 14    | 15    | 13    | 14    | 15    | 14    | 13    | 16    | 15    | 14    |       |       |       |       |
| SFM               |       | 145      |                                    | 145             | 145                                                        | 145                                                                    | 145                                              | 145   | 145   | 145   | 145   | 145   | 145   | 145   |       |       |       |       |       |       |       |
| IPT               |       | .0007    |                                    | .0009           | .0011                                                      | .0014                                                                  | .0018                                            | .0023 | .0025 | .0027 | .0038 | .0045 | .0060 |       |       |       |       |       |       |       |       |
| RPM               |       | 4430     |                                    | 3540            | 2950                                                       | 2220                                                                   | 1770                                             | 1480  | 1270  | 1110  | 890   | 740   | 550   |       |       |       |       |       |       |       |       |
| IPM               |       | 12       |                                    | 13              | 13                                                         | 12                                                                     | 13                                               | 13    | 13    | 12    | 13    | 13    | 13    |       |       |       |       |       |       |       |       |
| SFM               |       | 120      |                                    | 120             | 120                                                        | 120                                                                    | 120                                              | 120   | 120   | 120   | 120   | 120   | 120   | 120   |       |       |       |       |       |       |       |
| IPT               |       | .0006    |                                    | .0008           | .0010                                                      | .0012                                                                  | .0016                                            | .0020 | .0022 | .0024 | .0040 | .0046 | .0060 |       |       |       |       |       |       |       |       |
| RPM               |       | 3670     |                                    | 2930            | 2440                                                       | 1830                                                                   | 1470                                             | 1220  | 1050  | 920   | 730   | 610   | 460   |       |       |       |       |       |       |       |       |
| IPM               |       | 9        |                                    | 9               | 10                                                         | 9                                                                      | 9                                                | 10    | 9     | 9     | 12    | 11    | 11    |       |       |       |       |       |       |       |       |
| Milling           | P     | 8-9      | High alloyed steel, and tool steel | 0.1D            | 1.5D                                                       | SFM                                                                    | 170                                              | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPT                                                                    | .0006                                            | .0009 | .0011 | .0013 | .0017 | .0022 | .0024 | .0026 | .0038 | .0044 | .0056 |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | RPM                                                                    | 5190                                             | 4160  | 3460  | 2600  | 2080  | 1730  | 1480  | 1300  | 1040  | 870   | 650   |       |       |       |       |
|                   |       |          |                                    |                 |                                                            | IPM                                                                    | 13                                               | 14    | 15    | 13    | 14    | 15    | 14    | 13    | 16    | 15    | 14    |       |       |       |       |
| SFM               |       | 120      |                                    | 120             | 120                                                        | 120                                                                    | 120                                              | 120   | 120   | 120   | 120   | 120   | 120   | 120   |       |       |       |       |       |       |       |
| IPT               |       | .0006    |                                    | .0008           | .0010                                                      | .0012                                                                  | .0016                                            | .0020 | .0022 | .0024 | .0040 | .0046 | .0060 |       |       |       |       |       |       |       |       |
| RPM               |       | 3670     |                                    | 2930            | 2440                                                       | 1830                                                                   | 1470                                             | 1220  | 1050  | 920   | 730   | 610   | 460   |       |       |       |       |       |       |       |       |
| IPM               |       | 9        |                                    | 9               | 10                                                         | 9                                                                      | 9                                                | 10    | 9     | 9     | 12    | 11    | 11    |       |       |       |       |       |       |       |       |
| Indexable Inserts |       | P        |                                    | 10              | High alloyed steel, and tool steel                         | 0.1D                                                                   | 1.5D                                             | SFM   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   | 170   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPT   | .0006 | .0009 | .0011 | .0013 | .0017 | .0022 | .0024 | .0026 | .0038 | .0044 | .0056 |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | RPM   | 5190  | 4160  | 3460  | 2600  | 2080  | 1730  | 1480  | 1300  | 1040  | 870   | 650   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPM   | 13    | 14    | 15    | 13    | 14    | 15    | 14    | 13    | 16    | 15    | 14    |       |       |
| SFM               | 120   |          | 120                                | 120             |                                                            | 120                                                                    | 120                                              | 120   | 120   | 120   | 120   | 120   | 120   | 120   |       |       |       |       |       |       |       |
| IPT               | .0006 |          | .0008                              | .0010           |                                                            | .0012                                                                  | .0016                                            | .0020 | .0022 | .0024 | .0040 | .0046 | .0060 |       |       |       |       |       |       |       |       |
| RPM               | 3670  |          | 2930                               | 2440            |                                                            | 1830                                                                   | 1470                                             | 1220  | 1050  | 920   | 730   | 610   | 460   |       |       |       |       |       |       |       |       |
| IPM               | 9     |          | 9                                  | 10              |                                                            | 9                                                                      | 9                                                | 10    | 9     | 9     | 12    | 11    | 11    |       |       |       |       |       |       |       |       |
| Indexable Inserts | M     |          | 14.1                               | Stainless steel |                                                            | 0.1D                                                                   | 1.5D                                             | SFM   | 160   | 160   | 160   | 160   | 160   | 160   | 160   | 160   | 160   | 160   | 160   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPT   | .0003 | .0004 | .0006 | .0007 | .0009 | .0012 | .0013 | .0014 | .0020 | .0025 | .0035 |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | RPM   | 4890  | 3910  | 3260  | 2440  | 1960  | 1630  | 1400  | 1220  | 980   | 810   | 610   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPM   | 7     | 7     | 7     | 7     | 7     | 8     | 7     | 7     | 8     | 8     | 9     |       |       |
| Indexable Inserts |       | K        | 15-20                              |                 | Grey cast iron<br>Nodular cast iron<br>Malleable cast iron | 0.1D                                                                   | 1.5D                                             | SFM   | 195   | 195   | 195   | 195   | 195   | 195   | 195   | 195   | 195   | 195   | 195   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPT   | .0009 | .0012 | .0016 | .0023 | .0033 | .0041 | .0048 | .0056 | .0078 | .0081 | .0088 |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | RPM   | 5960  | 4770  | 3970  | 2980  | 2380  | 1990  | 1700  | 1490  | 1190  | 990   | 740   |       |       |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  | IPM   | 22    | 23    | 25    | 27    | 31    | 32    | 33    | 33    | 37    | 32    | 26    |       |       |
| Indexable Inserts |       |          | N                                  |                 |                                                            | 21-25                                                                  | Aluminum-wrought alloy<br>Aluminum-cast, alloyed | 0.1D  | 1.5D  | SFM   | 490   | 490   | 490   | 490   | 490   | 490   | 490   | 490   | 490   | 490   | 490   |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | IPT   | .0008 | .0011 | .0013 | .0017 | .0022 | .0027 | .0031 | .0034 | .0044 | .0053 | .0071 |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | RPM   | 14970 | 11980 | 9980  | 7490  | 5990  | 4990  | 4280  | 3740  | 2990  | 2500  | 1870  |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | IPM   | 45    | 51    | 51    | 50    | 53    | 55    | 52    | 51    | 53    | 53    | 53    |
| Indexable Inserts | N     |          |                                    | 26-29.1         |                                                            | Copper and Copper Alloys<br>(Bronze / Brass)<br>Non Metallic Materials |                                                  | 0.1D  | 1.5D  | SFM   | 370   | 370   | 370   | 370   | 370   | 370   | 370   | 370   | 370   | 370   | 370   |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | IPT   | .0008 | .0010 | .0013 | .0017 | .0022 | .0029 | .0031 | .0034 | .0044 | .0053 | .0069 |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | RPM   | 11310 | 9050  | 7540  | 5650  | 4520  | 3770  | 3230  | 2830  | 2260  | 1880  | 1410  |
|                   |       |          |                                    |                 |                                                            |                                                                        |                                                  |       |       | IPM   | 38    | 38    | 40    | 38    | 40    | 43    | 40    | 38    | 40    | 40    | 39    |

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



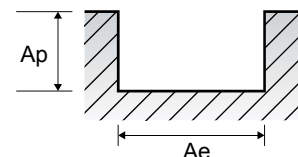
## RECOMMENDED CUTTING CONDITIONS

**G9H83, G9H84, G9H88, G9H90, G9H92, G9H94, G9H97**

**SQUARE / CORNER RADIUS / 4 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 | 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       | 9            | 10    | 10    | 9     | 10    | 11    | 10    | 9     | 11    | 10    | 10    |
|      | 3-4                                |                                                                        | 1.0D | 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       | 8            | 9     | 9     | 8     | 9     | 9     | 9     | 8     | 9     | 9     | 9     |
|      | 5                                  |                                                                        | 1.0D | 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       | 6            | 6     | 7     | 6     | 6     | 7     | 6     | 6     | 8     | 8     | 8     |
|      | 6                                  | Low alloy steel                                                        | 1.0D | 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       | 9            | 10    | 10    | 9     | 10    | 11    | 10    | 9     | 11    | 10    | 10    |
|      | 7                                  |                                                                        | 1.0D | 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       | 8            | 9     | 9     | 8     | 9     | 9     | 9     | 8     | 9     | 9     | 9     |
|      | 8-9                                |                                                                        | 1.0D | 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       | 6            | 6     | 7     | 6     | 6     | 7     | 6     | 6     | 8     | 8     | 8     |
| 10   | High alloyed steel, and tool steel | 1.0D                                                                   | 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  | 9         | 10           | 10    | 9     | 10    | 11    | 10    | 9     | 11    | 10    | 10    |       |
| 11.1 |                                    | 1.0D                                                                   | 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  | 6         | 6            | 7     | 6     | 6     | 7     | 6     | 6     | 8     | 8     | 8     |       |
| M    | 14.1                               | Stainless steel                                                        | 1.0D | 0.3D | SFM       | 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       | 6            | 6     | 7     | 6     | 6     | 7     | 6     | 6     | 8     | 8     | 8     |
| K    | 15-20                              | Grey cast iron<br>Nodular cast iron<br>Malleable cast iron             | 1.0D | 0.3D | SFM       | 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       | 15           | 16    | 17    | 18    | 21    | 22    | 22    | 22    | 24    | 24    | 24    |
| N    | 21-25                              | Aluminum-wrought alloy<br>Aluminum-cast, alloyed                       | 1.0D | 0.5D | SFM       | 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       | 32           | 36    | 36    | 34    | 36    | 37    | 36    | 34    | 36    | 36    | 36    |
|      | 26-29.1                            | Copper and Copper Alloys<br>(Bronze / Brass)<br>Non Metallic Materials | 1.0D | 0.5D | SFM       | 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       | 25           | 25    | 27    | 26    | 27    | 29    | 28    | 26    | 27    | 27    | 27    |

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



Slotting