

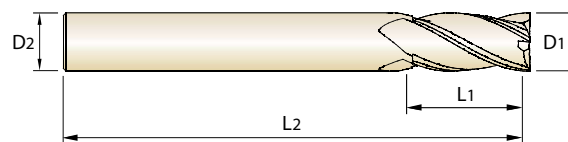
YGBasiX END MILLS



X-Coated **G9H92** SERIES
Uncoated **E5H92** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE SQUARE 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
G9H92008N	E5H92008	1/8	1/8	3/4	2-1/4
G9H92010N	E5H92010	5/32	3/16	3/4	2-1/2
G9H92012N	E5H92012	3/16	3/16	3/4	2-1/2
G9H92016N	E5H92016	1/4	1/4	1-1/8	3
G9H92020N	E5H92020	5/16	5/16	1-1/8	3
G9H92024N	E5H92024	3/8	3/8	1-1/8	3
G9H92028N	E5H92028	7/16	7/16	2	4
G9H92032N	E5H92032	1/2	1/2	1	4
G9H92901N	E5H92901	1/2	1/2	1-1/2	4
G9H92902N	E5H92902	1/2	1/2	2	4
G9H92040N	E5H92040	5/8	5/8	2-1/4	5
G9H92048N	E5H92048	3/4	3/4	2-1/4	5
G9H92064N	E5H92064	1	1	2-1/4	5

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.

Holemaking

Threading

Milling

Indexable Inserts

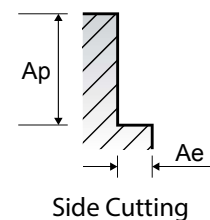
RECOMMENDED CUTTING CONDITIONS

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	
3-4		0.1D		1.5D	SFM	145	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		
5		0.1D		1.5D	SFM	120	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		
6	0.1D	1.5D	SFM	170	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				
7	0.1D	1.5D	SFM	145	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				
8-9	0.1D	1.5D	SFM	120	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				
10	0.1D	1.5D	SFM	170	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				
11.1	0.1D	1.5D	SFM	120	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	
	K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	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	8	9	
Indexable Inserts	N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	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	
	26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	RPM	5960	4770	3970	2980	2380	1990	1700	1490	1190	990	740		
					IPM	22	23	25	27	31	32	33	33	37	32	26		
					SFM	490	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		
					SFM	370	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.



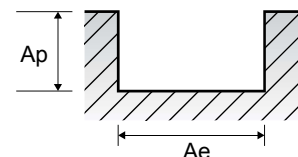
RECOMMENDED CUTTING CONDITIONS

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	8	9	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 Nodular cast iron 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 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 (Bronze / Brass) 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