

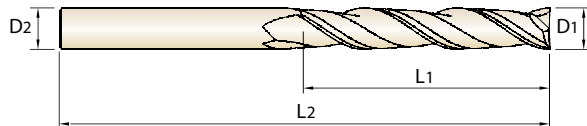
YGBasiX END MILLS



X-Coated **G9H93** SERIES
Uncoated **E5H93** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 2 FLUTE SQUARE 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.134-135

Unit : inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	D1	D2	L1	L2
G9H93008N	E5H93008	1/8	1/8	1	3
G9H93010N	E5H93010	5/32	3/16	1-1/8	3
G9H93901N	E5H93901	3/16	3/16	1	4
G9H93012N	E5H93012	3/16	3/16	1-1/8	3
G9H93016N	E5H93016	1/4	1/4	1-1/2	4
G9H93902N	E5H93902	1/4	1/4	1-1/2	6
G9H93903N	E5H93903	5/16	5/16	1-1/2	6
G9H93020N	E5H93020	5/16	5/16	1-5/8	4
G9H93904N	E5H93904	3/8	3/8	1-1/2	6
G9H93024N	E5H93024	3/8	3/8	1-3/4	4
G9H93028N	E5H93028	7/16	7/16	3	6
G9H93905N	E5H93905	1/2	1/2	1-1/2	6
G9H93032N	E5H93032	1/2	1/2	3	6
G9H93040N	E5H93040	5/8	5/8	3	6
G9H93906N	E5H93906	3/4	3/4	1-1/2	6
G9H93048N	E5H93048	3/4	3/4	3	6
G9H93907N	E5H93907	3/4	3/4	4	7
G9H93064N	E5H93064	1	1	1-1/2	6
G9H93908N	E5H93908	1	1	3	6
G9H93909N	E5H93909	1	1	4	7

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

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

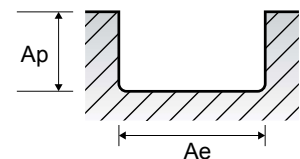
RECOMMENDED CUTTING CONDITIONS

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	
	3-4		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	IPM	5	5	5	5	5	5	5	5	5	5	5	
					SFM	145	145	145	145	145	145	145	145	145	145	145	
					IPT	.0005	.0006	.0008	.0009	.0013	.0016	.0017	.0019	.0024	.0029	.0039	
	5		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	RPM	4430	3540	2950	2220	1770	1480	1270	1110	890	740	550	
					IPM	4	4	4	4	4	5	4	4	4	4	4	
					SFM	120	120	120	120	120	120	120	120	120	120	120	
	6	Low alloy steel	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0018	.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	
7	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		
8-9	1.0D		upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	IPM	5	5	5	5	5	5	5	5	5	5	5		
				SFM	145	145	145	145	145	145	145	145	145	145	145		
				IPT	.0005	.0006	.0008	.0009	.0013	.0016	.0017	.0019	.0024	.0029	.0039		
10	High alloyed steel, and tool steel	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	RPM	4430	3540	2950	2220	1770	1480	1270	1110	890	740	550		
				IPM	4	4	4	4	4	5	4	4	4	4	4		
				SFM	120	120	120	120	120	120	120	120	120	120	120		
11.1		1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	IPT	.0004	.0006	.0007	.0008	.0011	.0014	.0015	.0017	.0018	.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
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	upto Ø1/2 : 0.5D over Ø1/2 : 0.3D	IPM	3	3	3	3	3	3	3	3	4	4	4	
					SFM	195	195	195	195	195	195	195	195	195	195	195	195
					IPT	.0006	.0008	.0011	.0015	.0022	.0027	.0032	.0037	.0051	.0061	.0080	
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	1.0D	1.0D	RPM	5960	4770	3970	2980	2380	1990	1700	1490	1190	990	740	
					IPM	8	8	8	9	11	11	11	11	12	12	12	
					SFM	490	490	490	490	490	490	490	490	490	490	490	490
26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	1.0D	1.0D	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		
26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	1.0D	1.0D	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