

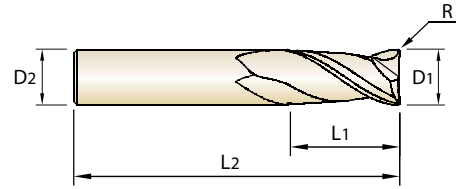
YGBasiX END MILLS



X-Coated **G9H96** SERIES
Uncoated **E5H96** SERIES

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



P. 134-135

Unit : inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	R	D1	D2	L1	L2
G9H96008N	E5H96008	R.010	1/8	1/8	1/2	1-1/2
G9H96901N	E5H96901	R.015	1/8	1/8	1/2	1-1/2
G9H96902N	E5H96902	R.020	1/8	1/8	1/2	1-1/2
G9H96903N	E5H96903	R.030	1/8	1/8	1/2	1-1/2
G9H96012N	E5H96012	R.010	3/16	3/16	5/8	2
G9H96904N	E5H96904	R.015	3/16	3/16	5/8	2
G9H96905N	E5H96905	R.020	3/16	3/16	5/8	2
G9H96906N	E5H96906	R.025	3/16	3/16	5/8	2
G9H96907N	E5H96907	R.045	3/16	3/16	5/8	2
G9H96908N	E5H96908	R.060	3/16	3/16	5/8	2
G9H96016N	E5H96016	R.015	1/4	1/4	3/4	2-1/2
G9H96909N	E5H96909	R.020	1/4	1/4	3/4	2-1/2
G9H96910N	E5H96910	R.025	1/4	1/4	3/4	2-1/2
G9H96911N	E5H96911	R.030	1/4	1/4	3/4	2-1/2
G9H96912N	E5H96912	R.045	1/4	1/4	3/4	2-1/2
G9H96913N	E5H96913	R.060	1/4	1/4	3/4	2-1/2
G9H96914N	E5H96914	R.090	1/4	1/4	3/4	2-1/2
G9H96020N	E5H96020	R.015	5/16	5/16	13/16	2-1/2
G9H96915N	E5H96915	R.020	5/16	5/16	13/16	2-1/2
G9H96916N	E5H96916	R.025	5/16	5/16	13/16	2-1/2
G9H96917N	E5H96917	R.030	5/16	5/16	13/16	2-1/2
G9H96918N	E5H96918	R.045	5/16	5/16	13/16	2-1/2
G9H96919N	E5H96919	R.060	5/16	5/16	13/16	2-1/2
G9H96920N	E5H96920	R.090	5/16	5/16	13/16	2-1/2
G9H96024N	E5H96024	R.015	3/8	3/8	1	2-1/2
G9H96921N	E5H96921	R.020	3/8	3/8	1	2-1/2
G9H96922N	E5H96922	R.025	3/8	3/8	1	2-1/2
G9H96923N	E5H96923	R.030	3/8	3/8	1	2-1/2
G9H96924N	E5H96924	R.045	3/8	3/8	1	2-1/2
G9H96925N	E5H96925	R.060	3/8	3/8	1	2-1/2
G9H96926N	E5H96926	R.090	3/8	3/8	1	2-1/2
G9H96028N	E5H96028	R.015	7/16	7/16	1	2-3/4
G9H96927N	E5H96927	R.020	7/16	7/16	1	2-3/4
G9H96928N	E5H96928	R.025	7/16	7/16	1	2-3/4
G9H96929N	E5H96929	R.030	7/16	7/16	1	2-3/4
G9H96930N	E5H96930	R.045	7/16	7/16	1	2-3/4
G9H96931N	E5H96931	R.060	7/16	7/16	1	2-3/4
G9H96932N	E5H96932	R.090	7/16	7/16	1	2-3/4
G9H96032N	E5H96032	R.015	1/2	1/2	1	3
G9H96933N	E5H96933	R.020	1/2	1/2	1	3
G9H96934N	E5H96934	R.025	1/2	1/2	1	3
G9H96935N	E5H96935	R.030	1/2	1/2	1	3
G9H96936N	E5H96936	R.045	1/2	1/2	1	3
G9H96937N	E5H96937	R.060	1/2	1/2	1	3
G9H96938N	E5H96938	R.090	1/2	1/2	1	3
G9H96939N	E5H96939	R.125	1/2	1/2	1	3

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Unit : inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	R	D1	D2	L1	L2
G9H96040N	E5H96040	R.015	5/8	5/8	1-1/4	3-1/2
G9H96940N	E5H96940	R.020	5/8	5/8	1-1/4	3-1/2
G9H96941N	E5H96941	R.025	5/8	5/8	1-1/4	3-1/2
G9H96942N	E5H96942	R.030	5/8	5/8	1-1/4	3-1/2
G9H96943N	E5H96943	R.045	5/8	5/8	1-1/4	3-1/2
G9H96944N	E5H96944	R.060	5/8	5/8	1-1/4	3-1/2
G9H96945N	E5H96945	R.090	5/8	5/8	1-1/4	3-1/2
G9H96946N	E5H96946	R.125	5/8	5/8	1-1/4	3-1/2
G9H96947N	E5H96947	R.250	5/8	5/8	1-1/4	3-1/2
G9H96048N	E5H96048	R.015	3/4	3/4	1-1/2	4
G9H96948N	E5H96948	R.020	3/4	3/4	1-1/2	4
G9H96949N	E5H96949	R.025	3/4	3/4	1-1/2	4
G9H96950N	E5H96950	R.030	3/4	3/4	1-1/2	4
G9H96951N	E5H96951	R.045	3/4	3/4	1-1/2	4
G9H96952N	E5H96952	R.060	3/4	3/4	1-1/2	4
G9H96953N	E5H96953	R.090	3/4	3/4	1-1/2	4
G9H96954N	E5H96954	R.125	3/4	3/4	1-1/2	4
G9H96955N	E5H96955	R.190	3/4	3/4	1-1/2	4
G9H96956N	E5H96956	R.250	3/4	3/4	1-1/2	4

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

Holemaking

Threading

Milling

Indexable Inserts

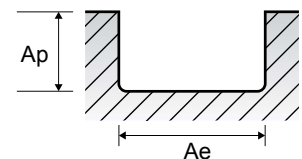
RECOMMENDED CUTTING CONDITIONS

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	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	5
					SFM	145	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	4
					SFM	120	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	.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	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	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	5	
				SFM	145	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	4	
				SFM	120	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	.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	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	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	18	
30-35	Aluminum-cast, wrought alloy Aluminum-cast, wrought alloy Aluminum-cast, wrought alloy	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		
36-40	Aluminum-cast, wrought alloy Aluminum-cast, wrought alloy Aluminum-cast, wrought alloy	1.0D	1.0D	IPM	12	12	13	13	14	15	14	13	14	14	13		
				SFM	490	490	490	490	490	490	490	490	490	490	490	490	
				IPT	.0005	.0008	.0009	.0011	.0015	.0019	.0021	.0023	.0030	.0036	.0048		

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



Slotting