

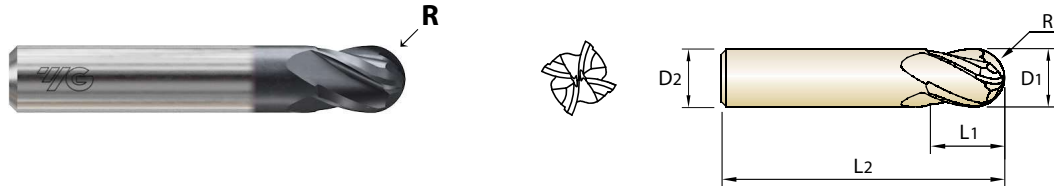
YGBasiX END MILLS



X-Coated **G9H99** SERIES
Uncoated **E5H99** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE BALL NOSE STUB 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. 152-153

Unit : inch

EDP No.		Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
X-Coated	Uncoated	R	D1	D2	L1	L2
G9H99002N	E5H99002	R1/64	1/32	1/8	1/16	1-1/2
G9H99003N	E5H99003	R.0234	3/64	1/8	3/32	1-1/2
G9H99004N	E5H99004	R1/32	1/16	1/8	1/8	1-1/2
G9H99005N	E5H99005	R.0391	5/64	1/8	1/8	1-1/2
G9H99901N	E5H99901	R.0391	5/64	1/8	5/32	1-1/2
G9H99006N	E5H99006	R3/64	3/32	1/8	3/16	1-1/2
G9H99007N	E5H99007	R.0547	7/64	1/8	3/16	1-1/2
G9H99902N	E5H99902	R.0547	7/64	1/8	7/32	1-1/2
G9H99008N	E5H99008	R1/16	1/8	1/8	1/4	1-1/2
G9H99009N	E5H99009	R.0703	9/64	3/16	9/32	2
G9H99903N	E5H99903	R.0703	9/64	3/16	5/16	2
G9H99010N	E5H99010	R5/64	5/32	3/16	5/16	2
G9H99011N	E5H99011	R.0859	11/64	3/16	5/16	2
G9H99012N	E5H99012	R3/32	3/16	3/16	3/8	2
G9H99013N	E5H99013	R.1016	13/64	1/4	3/8	2
G9H99904N	E5H99904	R.1016	13/64	1/4	1/2	2-1/2
G9H99014N	E5H99014	R7/64	7/32	1/4	7/16	2
G9H99906N	E5H99906	R7/64	7/32	1/4	1/2	2-1/2
G9H99015N	E5H99015	R.1172	15/64	1/4	7/16	2
G9H99905N	E5H99905	R.1172	15/64	1/4	1/2	2-1/2
G9H99016N	E5H99016	R1/8	1/4	1/4	1/2	2
G9H99907N	E5H99907	R1/8	1/4	1/4	1/2	2-1/2
G9H99017N	E5H99017	R.1328	17/64	5/16	1/2	2-1/2
G9H99018N	E5H99018	R9/64	9/32	5/16	1/2	2
G9H99019N	E5H99019	R.1484	19/64	5/16	1/2	2-1/2
G9H99020N	E5H99020	R5/32	5/16	5/16	1/2	2
G9H99908N	E5H99908	R5/32	5/16	5/16	1/2	2-1/2
G9H99022N	E5H99022	R11/64	11/32	3/8	9/16	2-1/2
G9H99024N	E5H99024	R3/16	3/8	3/8	5/8	2
G9H99909N	E5H99909	R3/16	3/8	3/8	9/16	2-1/2
G9H99028N	E5H99028	R7/32	7/16	7/16	5/8	2-1/2
G9H99910N	E5H99910	R7/32	7/16	7/16	9/16	2-3/4
G9H99032N	E5H99032	R1/4	1/2	1/2	5/8	2-1/2
G9H99911N	E5H99911	R1/4	1/2	1/2	5/8	3
G9H99040N	E5H99040	R5/16	5/8	5/8	3/4	3
G9H99048N	E5H99048	R3/8	3/4	3/4	1	3

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

RECOMMENDED CUTTING CONDITIONS

G9H99, G9I01, G9I05, G9I06, G9I08, G9I09

BALL NOSE / 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		
P	1-4	Non-alloy steel	0.7D	0.3D	SFM	160	160	160	160	160	160	160	160	160	160	160		
					IPT	.0004	.0005	.0007	.0008	.0010	.0012	.0013	.0014	.0018	.0022	.0028		
					RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610		
	5		Non-alloy steel	0.7D	0.3D	IPM	8	8	9	8	8	8	7	7	7	7	7	
						SFM	130	130	130	130	130	130	130	130	130	130	130	130
						IPT	.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017	
	6-7	Low alloy steel	0.7D	0.3D	RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500		
					IPM	3	4	4	3	4	4	4	3	4	4	3		
					SFM	160	160	160	160	160	160	160	160	160	160	160	160	
	8-9		Low alloy steel	0.7D	0.3D	IPT	.0004	.0005	.0007	.0008	.0010	.0012	.0013	.0014	.0018	.0022	.0028	
						RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610	7
						IPM	8	8	9	8	8	8	7	7	7	7	7	7
10	High alloyed steel, and tool steel	0.7D	0.3D	SFM	130	130	130	130	130	130	130	130	130	130	130	130		
				IPT	.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017			
				RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500			
11.1		High alloyed steel, and tool steel	0.7D	0.3D	IPM	3	4	4	3	4	4	4	3	4	4	3		
					SFM	160	160	160	160	160	160	160	160	160	160	160	160	
					IPT	.0004	.0005	.0007	.0008	.0010	.0012	.0013	.0014	.0018	.0022	.0028		
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.7D	0.3D	RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610		
					IPM	8	8	9	8	8	8	7	7	7	7	7	7	
					SFM	130	130	130	130	130	130	130	130	130	130	130	130	
					IPT	.0002	.0003	.0004	.0004	.0006	.0007	.0008	.0009	.0012	.0014	.0017		
					RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500		
					IPM	3	4	4	3	4	4	4	3	4	4	3		
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.7D	0.3D	SFM	220	220	220	220	220	220	220	220	220	220	220		
					IPT	.0004	.0007	.0011	.0014	.0024	.0029	.0032	.0034	.0047	.0055	.0048		
					RPM	6720	5380	4480	3360	2690	2240	1920	1680	1340	1120	840		
					IPM	12	16	19	19	26	26	24	23	25	25	16		
					SFM	660	660	660	660	660	660	660	660	660	660	660	660	
					IPT	.0003	.0004	.0005	.0006	.0009	.0012	.0014	.0016	.0019	.0023	.0029		
					RPM	20170	16130	13450	10080	8070	6720	5760	5040	4030	3360	2520		
					IPM	21	22	28	25	29	32	32	33	30	31	29		

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

