

YGBasiX END MILLS

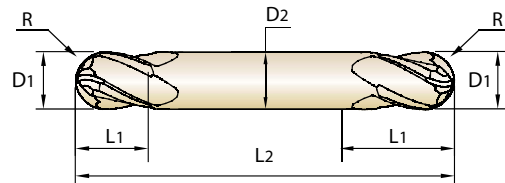


X-Coated **G9I01** SERIES

Uncoated **E5I01** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE BALL NOSE STUB LENGTH DOUBLE

- 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.
- Same construction features as single end mill in a more economical version



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
G9I01002N	E5I01002	R1/64	1/32	1/8	1/16	1-1/2
G9I01003N	E5I01003	R.0234	3/64	1/8	3/32	1-1/2
G9I01004N	E5I01004	R1/32	1/16	1/8	1/8	1-1/2
G9I01005N	E5I01005	R.0391	5/64	1/8	1/8	1-1/2
G9I01901N	E5I01901	R.0391	5/64	1/8	5/32	1-1/2
G9I01006N	E5I01006	R3/64	3/32	1/8	3/16	1-1/2
G9I01007N	E5I01007	R.0547	7/64	1/8	3/16	1-1/2
G9I01902N	E5I01902	R.0547	7/64	1/8	7/32	1-1/2
G9I01008N	E5I01008	R1/16	1/8	1/8	1/4	1-1/2
G9I01903N	E5I01903	R.0703	9/64	3/16	9/32	2
G9I01009N	E5I01009	R.0703	9/64	3/16	5/16	2
G9I01010N	E5I01010	R5/64	5/32	3/16	5/16	2
G9I01011N	E5I01011	R.0859	11/64	3/16	5/16	2
G9I01012N	E5I01012	R3/32	3/16	3/16	3/8	2
G9I01013N	E5I01013	R.1016	13/64	1/4	3/8	2
G9I01904N	E5I01904	R.1016	13/64	1/4	1/2	2-1/2
G9I01014N	E5I01014	R7/64	7/32	1/4	7/16	2
G9I01905N	E5I01905	R7/64	7/32	1/4	1/2	2-1/2
G9I01015N	E5I01015	R.1172	15/64	1/4	7/16	2
G9I01906N	E5I01906	R.1172	15/64	1/4	1/2	2-1/2
G9I01016N	E5I01016	R1/8	1/4	1/4	1/2	2
G9I01907N	E5I01907	R1/8	1/4	1/4	1/2	2-1/2
G9I01017N	E5I01017	R.1328	17/64	5/16	1/2	2-1/2
G9I01018N	E5I01018	R9/64	9/32	5/16	1/2	2
G9I01908N	E5I01908	R9/64	9/32	5/16	1/2	2-1/2
G9I01019N	E5I01019	R.1484	19/64	5/16	1/2	2-1/2
G9I01020N	E5I01020	R5/32	5/16	5/16	1/2	2
G9I01909N	E5I01909	R5/32	5/16	5/16	1/2	2-1/2
G9I01022N	E5I01022	R11/64	11/32	3/8	9/16	2-1/2
G9I01910N	E5I01910	R3/16	3/8	3/8	9/16	2-1/2
G9I01028N	E5I01028	R7/32	7/16	7/16	9/16	2-3/4
G9I01911N	E5I01911	R7/32	7/16	7/16	5/8	2-1/2
G9I01032N	E5I01032	R1/4	1/2	1/2	5/8	2-1/2
G9I01912N	E5I01912	R1/4	1/2	1/2	5/8	3
G9I01040N	E5I01040	R5/16	5/8	5/8	3/4	3
G9I01048N	E5I01048	R3/8	3/4	3/4	1	3

Mill Dia. Tolerance (inch)	
D1=D2	+0/-0.002
D1≠D2	+0/-0.0012

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
	IPM		8	8	9	8	8	8	7	7	7	7	7			
	5		0.7D	0.3D	SFM	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				
	6-7	Low 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
	IPM		8	8	9	8	8	8	7	7	7	7	7			
	8-9		0.7D	0.3D	SFM	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				
	10	High alloyed steel, and tool 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	
IPM	8		8	9	8	8	8	7	7	7	7	7				
11.1	0.7D		0.3D	SFM	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					
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.7D	0.3D	SFM	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
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.7D	0.3D	SFM	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.

