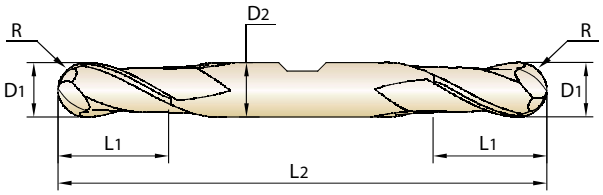
X-Coated **G9I04** SERIES
Uncoated **E5I04** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE REGULAR 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







CARBIDE | 2 | 30° | R ±.0008 | FLAT

P. 148-149

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
G9I04008N	**E5I04008**	R1/16	**1/8**	3/8	3/8	3
G9I04010N	**E5I04010**	R5/64	**5/32**	3/8	7/16	3
G9I04012N	**E5I04012**	R3/32	**3/16**	3/8	1/2	3
G9I04014N	**E5I04014**	R7/64	**7/32**	3/8	9/16	3-1/2
G9I04016N	**E5I04016**	R1/8	**1/4**	3/8	5/8	3-1/2
G9I04018N	**E5I04018**	R9/64	**9/32**	3/8	11/16	3-1/2
G9I04020N	**E5I04020**	R5/32	**5/16**	3/8	3/4	3-1/2
G9I04022N	**E5I04022**	R11/64	**11/32**	3/8	3/4	3-1/2
G9I04024N	**E5I04024**	R3/16	**3/8**	3/8	3/4	3-1/2
G9I04028N	**E5I04028**	R7/32	**7/16**	1/2	7/8	4
G9I04032N	**E5I04032**	R1/4	**1/2**	1/2	1	4

Mill Dia. Tolerance (inch)	
D1=D2	+0/-.002
D1≠D2	+0/-.0012

G9H98, G9I02, G9I04, G9I07

BALL NOSE / 2 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	.0005	.0007	.0009	.0010	.0013	.0016	.0017	.0018	.0023	.0028	.0036
					RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610
					IPM	5	5	6	5	5	5	5	4	4	5	4
	5		0.7D	0.3D	SFM	130	130	130	130	130	130	130	130	130	130	130
					IPT	.0003	.0004	.0005	.0006	.0008	.0010	.0010	.0011	.0015	.0018	.0022
					RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500
					IPM	2	2	3	2	2	3	2	2	2	2	2
	6-7	Low alloy steel	0.7D	0.3D	SFM	160	160	160	160	160	160	160	160	160	160	160
					IPT	.0005	.0007	.0009	.0010	.0013	.0016	.0017	.0018	.0023	.0028	.0036
					RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610
					IPM	5	5	6	5	5	5	5	4	4	5	4
	8-9		0.7D	0.3D	SFM	130	130	130	130	130	130	130	130	130	130	130
					IPT	.0003	.0004	.0005	.0006	.0008	.0010	.0010	.0011	.0015	.0018	.0022
					RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500
					IPM	2	2	3	2	2	3	2	2	2	2	2
	10	High alloyed steel, and tool steel	0.7D	0.3D	SFM	160	160	160	160	160	160	160	160	160	160	160
					IPT	.0005	.0007	.0009	.0010	.0013	.0016	.0017	.0018	.0023	.0028	.0036
					RPM	4890	3910	3260	2440	1960	1630	1400	1220	980	810	610
					IPM	5	5	6	5	5	5	5	4	4	5	4
	11.1		0.7D	0.3D	SFM	130	130	130	130	130	130	130	130	130	130	130
					IPT	.0003	.0004	.0005	.0006	.0008	.0010	.0010	.0011	.0015	.0018	.0022
					RPM	3970	3180	2650	1990	1590	1320	1140	990	790	660	500
					IPM	2	2	3	2	2	3	2	2	2	2	2
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	220
					IPT	.0006	.0010	.0014	.0019	.0032	.0053	.0050	.0047	.0062	.0073	.0066
					RPM	6720	5380	4480	3360	2690	2240	1920	1680	1340	1120	840
					IPM	8	11	13	13	17	24	19	16	17	16	11
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.7D	0.3D	SFM	660	660	660	660	660	660	660	660	660	660	660
					IPT	.0003	.0005	.0007	.0008	.0012	.0016	.0019	.0022	.0025	.0030	.0039
					RPM	20170	16130	13450	10080	8070	6720	5760	5040	4030	3360	2520
					IPM	14	15	19	16	19	21	21	22	20	20	19

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

