

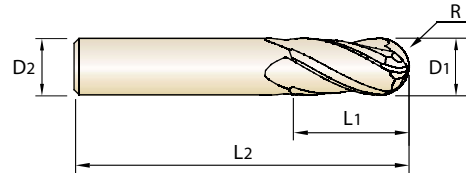
YGBasiX END MILLS



X-Coated **G9105** SERIES
Uncoated **E5105** SERIES

X-COATED & UNCOATED SOLID CARBIDE END MILLS 4 FLUTE BALL NOSE 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. 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
G9105001N	E5105001	R.0078	1/64	1/8	3/64	1-1/2
G9105002N	E5105002	R1/64	1/32	1/8	3/32	1-1/2
G9105901N	E5105901	R1/64	1/32	1/8	1/8	1-1/2
G9105003N	E5105003	R.0234	3/64	1/8	1/8	1-1/2
G9105004N	E5105004	R1/32	1/16	1/8	1/4	1-1/2
G9105005N	E5105005	R.0391	5/64	1/8	1/4	1-1/2
G9105006N	E5105006	R3/64	3/32	1/8	3/8	1-1/2
G9105007N	E5105007	R.0547	7/64	1/8	3/8	1-1/2
G9105008N	E5105008	R1/16	1/8	1/8	1/2	1-1/2
G9105009N	E5105009	R.0703	9/64	3/16	9/16	2
G9105010N	E5105010	R5/64	5/32	3/16	9/16	2
G9105011N	E5105011	R.0859	11/64	3/16	9/16	2
G9105902N	E5105902	R.0859	11/64	3/16	5/8	2
G9105012N	E5105012	R3/32	3/16	3/16	5/8	2
G9105013N	E5105013	R.1016	13/64	1/4	5/8	2-1/2
G9105014N	E5105014	R7/64	7/32	1/4	5/8	2-1/2
G9105015N	E5105015	R.1172	15/64	1/4	3/4	2-1/2
G9105016N	E5105016	R1/8	1/4	1/4	3/4	2-1/2
G9105017N	E5105017	R.1328	17/64	5/16	3/4	2-1/2
G9105018N	E5105018	R9/64	9/32	5/16	3/4	2-1/2
G9105019N	E5105019	R.1484	19/64	5/16	13/16	2-1/2
G9105020N	E5105020	R5/32	5/16	5/16	13/16	2-1/2
G9105021N	E5105021	R.1641	21/64	3/8	1	2-1/2
G9105022N	E5105022	R11/64	11/32	3/8	7/8	2-1/2
G9105903N	E5105903	R11/64	11/32	3/8	1	2-1/2
G9105023N	E5105023	R.1797	23/64	3/8	1	2-1/2
G9105024N	E5105024	R3/16	3/8	3/8	1	2-1/2
G9105025N	E5105025	R.1953	25/64	7/16	1	2-3/4
G9105026N	E5105026	R13/64	13/32	7/16	1	2-3/4
G9105027N	E5105027	R.2109	27/64	7/16	1	2-3/4
G9105028N	E5105028	R7/32	7/16	7/16	1	2-3/4
G9105029N	E5105029	R.2266	29/64	1/2	1	3
G9105030N	E5105030	R15/64	15/32	1/2	1	3
G9105031N	E5105031	R.2422	31/64	1/2	1	3
G9105032N	E5105032	R1/4	1/2	1/2	1	3
G9105036N	E5105036	R9/32	9/16	9/16	1-1/4	3-1/2
G9105040N	E5105040	R5/16	5/8	5/8	1-1/4	3-1/2
G9105044N	E5105044	R11/32	11/16	3/4	1-1/2	4
G9105048N	E5105048	R3/8	3/4	3/4	1-1/2	4
G9105056N	E5105056	R7/16	7/8	7/8	1-1/2	4
G9105064N	E5105064	R1/2	1	1	1-1/2	4

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
	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.

