



K-2 CARBIDE END MILLS

4 Flute Multiple Helix Short & Long Length

Designed for semi-roughing application by optimizing the chip formation and evacuation
Also optimized to reduce vibration and achieve excellent surface finish

SHORT LENGTH

unit: mm

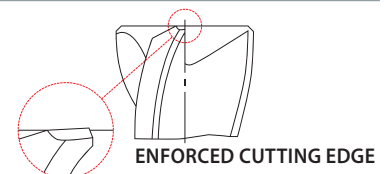
EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
PLAIN	FLAT					
G9H73030N	G9H74030N	3.0	6	5	50	0.10
G9H73040N	G9H74040N	4.0	6	8	54	0.15
G9H73050N	G9H74050N	5.0	6	9	54	0.15
G9H73060N	G9H74060N	6.0	6	10	54	0.20
G9H73080N	G9H74080N	8.0	8	12	58	0.20
G9H73100N	G9H74100N	10.0	10	14	66	0.30
G9H73120N	G9H74120N	12.0	12	16	73	0.35
G9H73160N	G9H74160N	16.0	16	22	82	0.40
G9H73200N	G9H74200N	20.0	20	26	92	0.50

LONG LENGTH

unit: mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
PLAIN	FLAT					
G9H75030N	G9H76030N	3.0	6	8	57	0.10
G9H75040N	G9H76040N	4.0	6	11	57	0.15
G9H75050N	G9H76050N	5.0	6	13	57	0.15
G9H75060N	G9H76060N	6.0	6	13	57	0.20
G9H75080N	G9H76080N	8.0	8	19	63	0.20
G9H75100N	G9H76100N	10.0	10	22	72	0.30
G9H75120N	G9H76120N	12.0	12	26	83	0.35
G9H75160N	G9H76160N	16.0	16	32	92	0.40
G9H75200N	G9H76200N	20.0	20	38	104	0.50

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ -0.03	h5



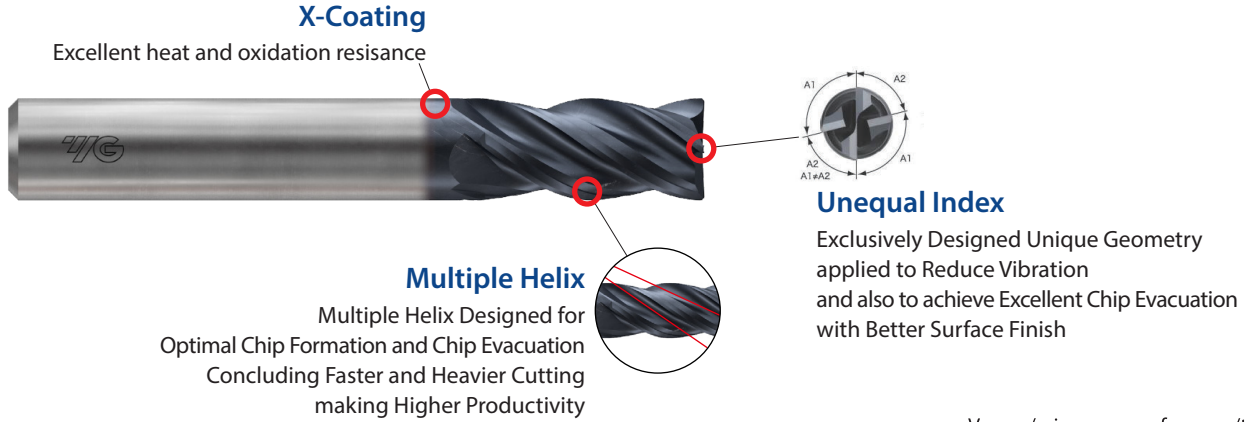
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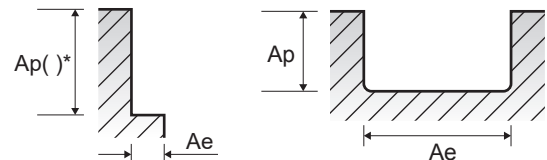
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Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

ISO	VDI 3323	Material Description	Side		Slotting		Parameter	Diameter (Ø)								
			Ae	Ap	Ae	Ap		3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-4	Non-alloy steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	106	106	106	106	106	118	118	118	118
	fz						0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	
	RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869						
	FEED	228	270	298	361	459	571	588	497	487						
	5	Low alloy steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	75	75	75	75	75	82	82	82	82
fz	0.005						0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065		
RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302							
FEED	158	189	210	256	322	396	410	347	340							
6-7	Low alloy steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	106	106	106	106	106	118	118	118	118	
fz						0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065		
RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869							
FEED	228	270	298	361	459	571	588	497	487							
8-9	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	75	75	75	75	75	82	82	82	82	
fz						0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065		
RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302							
FEED	158	189	210	256	322	396	410	347	340							
10-11.1	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	45	45	45	45	45	49	49	49	49	
fz						0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.037	0.045		
RPM	4753	3563	2849	2380	1785	1561	1302	973	777							
FEED	56	84	91	105	137	168	168	144	140							
M	12-13	Stainless steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	104	104	104	104	104	104	104	104	
	fz						0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.045	0.055	
	RPM						10990	8246	6594	5495	4123	3297	2751	2058	1652	
FEED	175	200	238	287	364	448	427	371	364							
14.1	Stainless steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	74	74	74	74	74	74	74	74		
fz						0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.077		
RPM						7875	5908	4725	3934	2954	2359	1967	1477	1183		
FEED	158	189	245	284	329	455	434	368	364							
14.2	Stainless steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	67	67	67	67	67	67	67	67		
fz						0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.076		
RPM						7056	5292	4235	3528	2646	2114	1764	1323	1057		
FEED	140	168	221	256	298	406	389	329	322							
K	15-20	Grey cast iron	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	78	78	78	78	78	86	86	86	86
							fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.065	0.081
							RPM	8316	6237	4991	4158	3122	2744	2282	1715	1372
							FEED	200	249	280	333	424	525	529	445	445

*() : Short length



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