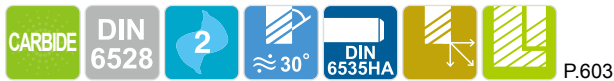
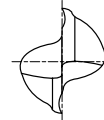


CARBIDE, 2 FLUTE LONG LENGTH

 **VOLLHARTMETALL, 2 SCHNEIDEN LANG**
 **Fraise carbure, 2 dents, longue**
 **2 TAGLIENTI, SERIE LUNGA**

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis.
- ▶ 2 Schneiden zum Nutenfräsen.



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9527035	3.5	3.5	7	50
G9527040	4.0	4	8	50
G9527045	4.5	4.5	8	50
G9527050	5.0	5	10	50
G9527055	5.5	5.5	10	57
G9527060	6.0	6	10	57
G9527065	6.5	6.5	13	60
G9527070	7.0	7	13	60
G9527075	7.5	7.5	16	63
G9527080	8.0	8	16	63
G9527085	8.5	8.5	16	67
G9527090	9.0	9	16	67
G9527095	9.5	9.5	19	72
G9527100	10.0	10	19	72
G9527110	11.0	11	22	83
G9527120	12.0	12	22	83
G9527130	13.0	13	22	83
G9527140	14.0	14	22	83
G9527150	15.0	15	26	92
G9527160	16.0	16	26	92
G9527180	18.0	18	26	92
G9527200	20.0	20	32	104

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

© : Excellent ○ : Good

ISO	P											M			K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○			
ISO	N										S										H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommend	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		

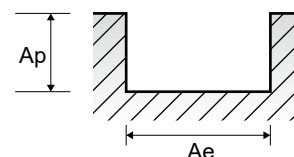
G9424, G9G44, G9A68, G9444, G9527, G9445, G9G45, G9452 SERIES

2 FLUTE - SLOTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)													
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	
P	1-4	Non-alloy steel	1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70	
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063	
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114	
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140	
	5		1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45	
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05	
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716	
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72	
	6-7	Low alloy steel	1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70	
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063	
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114	
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140	
	8-9		1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45	
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05	
RPM					7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716		
FEED					64	85	95	119	159	158	196	179	127	115	98	99	72		
10	High alloyed steel, and tool steel	1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70		
				fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063		
				RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114		
				FEED	115	153	159	175	259	276	290	318	285	241	215	185	140		
11.1 - 11.2		1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45		
				fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05		
				RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716		
				FEED	64	85	95	119	159	158	196	179	127	115	98	99	72		
M	14.1	Stainless steel	1.0D (Up to Ø3 : 0.2D)	0.5D (Up to Ø3 : 0.2D)	Vc	20	25	25	30	35	35	35	35	35	35	35	35		
					fz	0.003	0.007	0.009	0.016	0.025	0.031	0.04	0.053	0.059	0.058	0.059	0.068	0.064	
					RPM	6366	5305	3979	3183	2785	2228	1857	1393	1114	928	796	696	557	
					FEED	38	74	72	102	139	138	149	148	131	108	94	95	71	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	60	55	55	55	60	55	55	55		
					fz	0.005	0.008	0.012	0.018	0.024	0.03	0.043	0.063	0.077	0.102	0.119	0.145	0.189	
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875	
					FEED	191	187	229	210	229	210	251	276	294	298	298	317	331	
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140	
					fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11	
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228	
					FEED	357	386	446	462	468	462	492	496	489	483	481	490	490	
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140	
					fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11	
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228	
					FEED	357	386	446	462	468	462	492	496	489	483	481	490	490	
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105	
					fz	0.004	0.007	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066	0.078	0.085	0.11	
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671	
					FEED	204	282	334	334	333	334	368	376	368	368	372	372	368	
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105	
					fz	0.004	0.007	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066	0.078	0.085	0.11	
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671	
					FEED	204	282	334	334	333	334	368	376	368	368	372	372	368	
H	40	Chilled Cast Iron	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45	
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05	
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716	
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72	

※ The FEED, in long & extra long types, should be reduced by around 50%





SOLID CARBIDE
K-2
END MILLS

General Purpose with Coating
Conventional or High Speed Milling, Wet or Dry Cutting



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◎ : Excellent ○ : Good

Recommended cutting conditions : P 597

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc				
P	1	Non-alloy steel	About 0.15% C	Annealed	125					
	2		About 0.45% C	Annealed	190	13				
	3		About 0.45% C	Quenched & Tempered	250	25				
	4		About 0.75% C	Annealed	270	28				
	5		About 0.75% C	Quenched & Tempered	300	32				
	6	Low alloy steel		Annealed	180	10				
	7			Quenched & Tempered	275	29				
	8			Quenched & Tempered	300	32				
	9			Quenched & Tempered	350	38				
	10	High alloyed steel, and tool steel		Annealed	200	15				
11			Quenched & Tempered	325	35					
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15				
	13		Martensitic	Quenched & Tempered	240	23				
	14		Austenitic		180	10				
K	15	Grey cast iron	Pearlitic / ferritic		180	10				
	16		Pearlitic (Martensitic)		260	26				
	17	Nodular cast iron	Ferritic		160	3				
	18		Pearlitic		250	25				
	19	Malleable cast iron	Ferritic		130					
	20		Pearlitic		230	21				
N	21	Aluminum-wrought alloy	Not Curable		60					
	22		Curable Hardened		100					
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75					
	24		≤ 12% Si, Curable Hardened		90					
	25		> 12% Si, Not Curable		130					
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110					
	27		CuZn, CuSnZn (Brass)		90					
	28		CuSn, lead-free copper and electrolytic copper		100					
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15				
	32			Cured	280	30				
	33			Annealed	250	25				
	34		Ni or Co Based	Cured	350	38				
	35			Cast	320	34				
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm					
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				