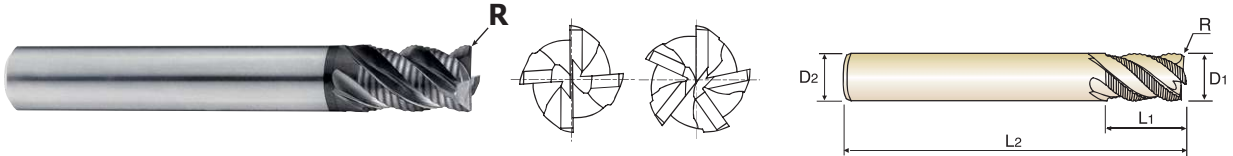


CARBIDE, 4&5 FLUTE MULTIPLE HELIX CORNER RADIUS

- VOLLHARTMETALL, 4&5 SCHNEIDEN MEHRSPIRAL Fräser KURZ ECKENRADIUS
- Fraise carbure, 4&5 dents, torique, hélice multiple, courte
- MD, 4 & 5 TAGLIANTI, TORICA, SERIE CORTA

- ▶ Unique flute design for excellent chip evacuation and vibration reduction.
- ▶ Optimal roughing tooth profile to reduce cutting forces.
- ▶ Special tool geometry for high feed rate and heavy cutting.
- ▶ Strong end tooth design for plunge and pocket milling.
- ▶ Custom engineered coating to allow long tool life and excellent chip evacuation.

- ▶ einzigartige Nutengeometrie für hervorragenden Späntransport und Vibrationsreduzierung
- ▶ neuartiges Schruppprofil zur Reduzierung der Schnittkräfte
- ▶ Spezielle Werkzeuggeometrie für Hochvorschub- und Schwerzerspannung geeignet
- ▶ speziell entwickelte Schneidengeometrie für Tauch- und Taschenfräsen
- ▶ YG-1 eigene Beschichtung um lange Lebensdauer und sehr guten Späntransport zu gewährleisten



SHORT LENGTH

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	R	D1	D2	L1	L2	
G9D75060	G9D67060	R0.5	6.0	6	9	57	4
G9D75080	G9D67080	R0.5	8.0	8	12	63	4
G9D75100	G9D67100	R0.5	10.0	10	15	72	4
G9D75120	G9D67120	R0.5	12.0	12	18	83	4
G9D75160	G9D67160	R1.0	16.0	16	24	92	5
G9D75200	G9D67200	R1.0	20.0	20	30	104	5

LONG LENGTH

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	R	D1	D2	L1	L2	
G9D76060	G9D68060	R0.5	6.0	6	12	57	4
G9D76080	G9D68080	R0.5	8.0	8	16	63	4
G9D76100	G9D68100	R0.5	10.0	10	20	72	4
G9D76120	G9D68120	R0.5	12.0	12	24	83	4
G9D76160	G9D68160	R1.0	16.0	16	32	92	5
G9D76200	G9D68200	R1.0	20.0	20	40	104	5

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.05	h5

ISO Material Description	P										M				K						
	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 Material Description	N					S										H					
	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						○	○	○													

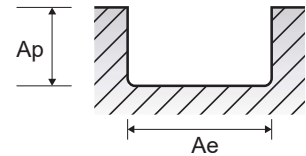
G9D75 G9D67 **G9D76 G9D68** **G9D77 G9D69**

4&5 FLUTE CORNER RADIUS ROUGHING

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

SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325
	4-5	Non-alloy steel	1.0D	0.8D	Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
					RPM	10610	8157	6366	5438	4078	3183
	6	Low alloy steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
	7-9	Low alloy steel	1.0D	0.8D	Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
RPM					10610	8157	6366	5438	4078	3183	
10	High alloyed steel, and tool steel	1.0D	1.0D	Vc	225	225	225	225	225	225	
				fz	0.032	0.046	0.057	0.064	0.067	0.074	
				RPM	11937	8952	7162	5968	4476	3581	
11.1	High alloyed steel, and tool steel	1.0D	0.8D	Vc	200	205	200	205	205	200	
				fz	0.026	0.036	0.046	0.053	0.051	0.056	
				RPM	10610	8157	6366	5438	4078	3183	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325



SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125
	4-5	Non-alloy steel	0.35D	1.0D	Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
					RPM	14324	10743	8435	7162	5371	4297
	6	Low alloy steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
	7-9	Low alloy steel	0.35D	1.0D	Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
RPM					14324	10743	8435	7162	5371	4297	
10	High alloyed steel, and tool steel	0.5D	1.0D	Vc	300	300	300	300	300	300	
				fz	0.041	0.057	0.071	0.08	0.082	0.089	
				RPM	15915	11937	9549	7958	5968	4775	
11.1	High alloyed steel, and tool steel	0.35D	1.0D	Vc	270	270	265	270	270	270	
				fz	0.032	0.046	0.057	0.065	0.065	0.07	
				RPM	14324	10743	8435	7162	5371	4297	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125

