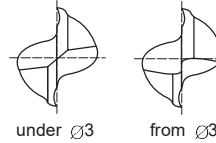


### CARBIDE, 2 FLUTE SHORT END MILL



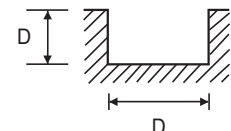
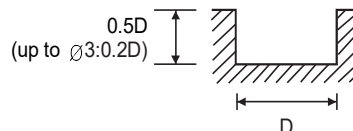
Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9F41010N	1.0	4	3	50
G9F41020N	2.0	4	6	50
G9F41030N	3.0	4	8	50
G9F41040N	4.0	4	11	50
G9F41050N	5.0	6	13	50
G9F41060N	6.0	6	16	50
G9F41080N	8.0	8	20	60
G9F41100N	10.0	10	25	75
G9F41120N	12.0	12	32	75
G9F41140N	14.0	14	32	75
G9F41160N	16.0	16	32	75
G9F41200N	20.0	20	32	100

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 - 0.030	h6

### CUTTING CONDITIONS

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALLOY STEELS PRE-HARDENED STEELS				STAINLESS STEELS				CAST IRON			
HARDNESS	~ HRC30				HRC30 ~ HRC50											
STRENGTH	~ 1000N/mm <sup>2</sup>				1000 ~ 1500N/mm <sup>2</sup>											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
1.0	15450	115	49	0.004	9200	70	29	0.004	7700	55	24	0.004	20200	220	63	0.005
2.0	8500	170	53	0.010	5550	110	35	0.010	4650	85	29	0.009	10100	240	63	0.012
3.0	6600	190	62	0.014	4100	130	39	0.016	3400	110	32	0.016	6550	240	62	0.018
4.0	5550	275	70	0.025	3400	165	43	0.024	2850	140	36	0.025	4950	240	62	0.024
5.0	4650	290	73	0.031	2750	170	43	0.031	2300	145	36	0.032	3950	240	62	0.030
6.0	4100	325	77	0.040	2500	205	47	0.041	2100	165	40	0.039	3200	275	60	0.043
8.0	3100	350	78	0.056	1850	185	46	0.050	1550	165	39	0.053	2400	295	60	0.061
10.0	2350	300	74	0.064	1450	145	46	0.050	1250	145	39	0.058	2000	310	63	0.078
12.0	2000	260	75	0.065	1250	120	47	0.048	1050	120	40	0.057	1550	320	58	0.103
14.0	1850	230	81	0.062	1150	110	51	0.048	900	110	40	0.061	1400	335	62	0.120
16.0	1600	200	80	0.063	1000	100	50	0.050	750	100	38	0.067	1200	345	60	0.144
20.0	1250	155	79	0.062	750	75	47	0.050	600	75	38	0.063	950	365	60	0.192



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