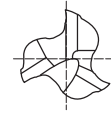


### CARBIDE, 3 FLUTE SHORT END MILL



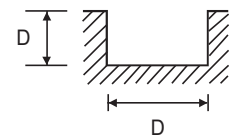
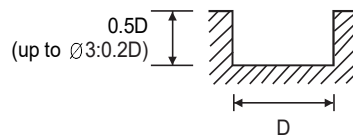
Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9F43010N	1.0	4	3	50
G9F43020N	2.0	4	6	50
G9F43030N	3.0	4	8	50
G9F43040N	4.0	4	11	50
G9F43050N	5.0	6	13	50
G9F43060N	6.0	6	16	50
G9F43080N	8.0	8	20	60
G9F43100N	10.0	10	25	75
G9F43120N	12.0	12	32	75
G9F43140N	14.0	14	32	75
G9F43160N	16.0	16	32	75
G9F43200N	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				~ HRC30							
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	175	49	0.004	9200	105	29	0.004	7700	85	24	0.004	20200	330	63	0.005
2.0	8500	255	53	0.010	5550	165	35	0.010	4650	130	29	0.009	10100	360	63	0.012
3.0	6600	285	62	0.014	4100	195	39	0.016	3400	165	32	0.016	6550	360	62	0.018
4.0	5550	415	70	0.025	3400	250	43	0.024	2850	210	36	0.025	4950	360	62	0.024
5.0	4650	435	73	0.031	2750	255	43	0.031	2300	220	36	0.032	3950	360	62	0.030
6.0	4100	490	77	0.040	2500	310	47	0.041	2100	220	40	0.039	3200	415	60	0.043
8.0	3100	525	78	0.056	1850	280	46	0.050	1550	220	39	0.053	2400	445	60	0.061
10.0	2350	450	74	0.064	1450	220	46	0.050	1250	220	39	0.058	2000	465	63	0.078
12.0	2000	390	75	0.065	1250	180	47	0.048	1050	180	40	0.057	1550	480	58	0.103
14.0	1850	345	81	0.062	1150	165	51	0.048	900	165	40	0.061	1400	505	62	0.120
16.0	1600	300	80	0.063	1000	150	50	0.050	750	150	38	0.067	1200	520	60	0.144
20.0	1250	235	79	0.062	750	115	47	0.050	600	115	38	0.063	950	550	60	0.192



1.0	15450	210	49	0.005	9200	125	29	0.005	7700	100	24	0.004	20200	365	63	0.006
2.0	8500	305	53	0.012	5550	200	35	0.012	4650	155	29	0.011	10100	395	63	0.013
3.0	6600	340	62	0.017	4100	235	39	0.019	3400	200	32	0.020	6550	395	62	0.020
4.0	5550	500	70	0.030	3400	300	43	0.029	2850	250	36	0.029	4950	395	62	0.027
5.0	4650	520	73	0.037	2750	305	43	0.037	2300	265	36	0.038	3950	395	62	0.033
6.0	4100	590	77	0.048	2500	370	47	0.049	2100	265	40	0.042	3200	455	60	0.047
8.0	3100	630	78	0.068	1850	335	46	0.060	1550	265	39	0.057	2400	490	60	0.068
10.0	2350	540	74	0.077	1450	265	46	0.061	1250	265	39	0.071	2000	510	63	0.085
12.0	2000	470	75	0.078	1250	215	47	0.057	1050	215	40	0.068	1550	530	58	0.114
14.0	1850	415	81	0.075	1150	200	51	0.058	900	200	40	0.074	1400	555	62	0.132
16.0	1600	360	80	0.075	1000	180	50	0.060	750	180	38	0.080	1200	570	60	0.158
20.0	1250	280	79	0.075	750	140	47	0.062	600	140	38	0.078	950	605	60	0.212

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

