

2 FLUTE, LONG LENGTH

G9445 SERIES FLAT SHANK

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



MULTI PURPOSE

MG HM
DIN 6527
30°
2
FLAT
P.17



Unit : mm

| EDP No. | MILL DIAMETER | SHANK DIAMETER | LENGTH OF CUT | OVERALL LENGTH |
|----------|---------------|----------------|---------------|----------------|
| G9445901 | 2.0 | ●3 | 6 | 38 |
| G9445028 | 2.8 | 6 | 7 | 57 |
| G9445030 | 3.0 | 6 | 7 | 57 |
| G9445035 | 3.5 | 6 | 7 | 57 |
| G9445038 | 3.8 | 6 | 8 | 57 |
| G9445040 | 4.0 | 6 | 8 | 57 |
| G9445045 | 4.5 | 6 | 8 | 57 |
| G9445048 | 4.8 | 6 | 10 | 57 |
| G9445050 | 5.0 | 6 | 10 | 57 |
| G9445957 | 5.75 | 6 | 10 | 57 |
| G9445060 | 6.0 | 6 | 10 | 57 |
| G9445967 | 6.75 | 8 | 13 | 63 |
| G9445070 | 7.0 | 8 | 13 | 63 |
| G9445977 | 7.75 | 8 | 16 | 63 |
| G9445080 | 8.0 | 8 | 16 | 63 |
| G9445087 | 8.7 | 10 | 16 | 72 |
| G9445090 | 9.0 | 10 | 16 | 72 |
| G9445097 | 9.7 | 10 | 19 | 72 |
| G9445100 | 10.0 | 10 | 19 | 72 |
| G9445117 | 11.7 | 12 | 22 | 83 |
| G9445120 | 12.0 | 12 | 22 | 83 |
| G9445137 | 13.7 | 14 | 22 | 83 |
| G9445140 | 14.0 | 14 | 22 | 83 |
| G9445157 | 15.7 | 16 | 26 | 92 |
| G9445160 | 16.0 | 16 | 26 | 92 |
| G9445177 | 17.7 | 18 | 26 | 92 |
| G9445180 | 18.0 | 18 | 26 | 92 |
| G9445197 | 19.7 | 20 | 32 | 104 |
| G9445200 | 20.0 | 20 | 32 | 104 |

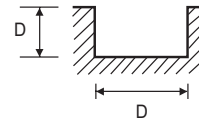
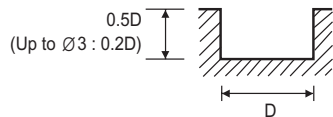
● with plain shank

| MILL DIA. TOLERANCE(mm) | SHANK DIA. TOLERANCE |
|-------------------------|----------------------|
| 0 - 0.030 | h6 |

2 FLUTE, FINISH, SLOTTING

▶ G9424, G9A68, G9444, G9527, G9445, G9452 Series

| MATERIAL | NON-ALLOYED STEELS, ALLOY STEELS, TOOL STEELS | | ALLOY STEELS, HEAT RESISTANT STEELS | | STAINLESS STEELS | | CAST IRON | | ALUMINUM ALLOYS | | COPPER, BRASS NON-FERROUS METALS | |
|----------|---|------|---|------|------------------|------|-----------|------|-----------------|------|--|------|
| HARDNESS | ~ HRc 30 | | HRc 30 ~ HRc 45 | | | | | | | | | |
| STRENGTH | ~ 1000N/mm ² | | 1000 ~ 1500N/mm ² | | | | | | | | | |
| DIAMETER | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 1 | 14300 | 105 | 8500 | 65 | 7150 | 50 | 18700 | 205 | 44000 | 330 | 24700 | 200 |
| 1.5 | 9350 | 150 | 5550 | 85 | 5600 | 80 | 12100 | 205 | 27500 | 385 | 20300 | 300 |
| 2 | 7850 | 160 | 5150 | 100 | 4300 | 80 | 9350 | 220 | 22000 | 460 | 16500 | 340 |
| 3 | 6100 | 180 | 3800 | 120 | 3150 | 100 | 6050 | 220 | 15400 | 460 | 11000 | 340 |
| 4 | 5150 | 255 | 3150 | 155 | 2650 | 130 | 4600 | 220 | 11000 | 460 | 8800 | 340 |
| 5 | 4300 | 270 | 2550 | 160 | 2150 | 135 | 3650 | 220 | 9150 | 460 | 6800 | 340 |
| 6 | 3800 | 300 | 2300 | 190 | 1950 | 155 | 2950 | 255 | 7600 | 485 | 5700 | 375 |
| 8 | 2850 | 325 | 1700 | 170 | 1450 | 155 | 2200 | 275 | 5700 | 485 | 4400 | 375 |
| 10 | 2200 | 280 | 1350 | 135 | 1150 | 135 | 1850 | 285 | 4600 | 485 | 3400 | 375 |
| 12 | 1850 | 240 | 1150 | 110 | 950 | 110 | 1450 | 295 | 3750 | 485 | 2850 | 375 |
| 14 | 1700 | 215 | 1050 | 100 | 850 | 100 | 1300 | 310 | 3300 | 485 | 2400 | 375 |
| 16 | 1500 | 185 | 950 | 95 | 700 | 95 | 1100 | 320 | 2850 | 485 | 2200 | 375 |
| 20 | 1150 | 145 | 700 | 70 | 550 | 70 | 900 | 340 | 2200 | 485 | 1700 | 375 |



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

RPM = rev./min. Feed = mm/min.