

MULTI FLUTE, COARSE PITCH ROUGHING, LONG LENGTH

G9A42 SERIES

FLAT SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ Fast chip ejection.



MULTI PURPOSE



Unit : mm

EDP No.	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH	No. OF FLUTE
G9A42060	6.0	6	16	57	3
G9A42080	8.0	8	16	63	3
G9A42100	10.0	10	22	72	4
G9A42120	12.0	12	26	83	4
G9A42140	14.0	14	26	83	4
G9A42160	16.0	16	32	92	4
G9A42180	18.0	18	32	92	4
G9A42200	20.0	20	38	104	4
G9A42250	25.0	25	45	121	5

Tolerances according to DIN 7160 & 7161

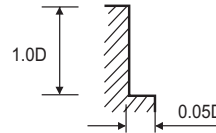
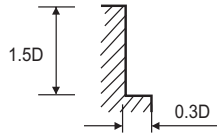
Tolerance range in μm					
Nominal-Diameter in mm					
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30
h10	$\begin{matrix} 0 \\ -40 \end{matrix}$	$\begin{matrix} 0 \\ -48 \end{matrix}$	$\begin{matrix} 0 \\ -58 \end{matrix}$	$\begin{matrix} 0 \\ -70 \end{matrix}$	$\begin{matrix} 0 \\ -84 \end{matrix}$
h6	$\begin{matrix} 0 \\ -6 \end{matrix}$	$\begin{matrix} 0 \\ -8 \end{matrix}$	$\begin{matrix} 0 \\ -9 \end{matrix}$	$\begin{matrix} 0 \\ -11 \end{matrix}$	$\begin{matrix} 0 \\ -13 \end{matrix}$

$\mu\text{m} = 1/1000\text{mm}$

MULTI FLUTE, ROUGHING, SIDE CUTTING

▶ G9A42 SERIES

MATERIAL	NON-ALLOYED STEELS, ALLOY STEELS, TOOL STEELS		ALLOY STEELS, HEAT RESISTANT STEELS		STAINLESS STEELS		INCONEL	
HARDNESS	~ HRc 30		HRc 30 ~ HRc 38		HRc 38 ~ HRc 45			
STRENGTH	~ 1000N/mm ²		1000 ~ 1200N/mm ²		1200 ~ 1400N/mm ²			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	13250	1970	10550	710	7150	480	2050	160
8	9850	1970	7800	710	5350	480	1550	150
10	7800	1970	6450	710	4350	480	1100	160
12	6800	2040	5100	680	3550	480	1000	160
14	5800	2040	4400	710	3050	480	750	110
16	5100	2040	4100	650	2800	430	700	90
18	4400	1970	3750	610	2300	360	600	90
20	4100	1840	3050	480	2050	310	550	90
25	3650	1830	2700	530	1850	350	500	90



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

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