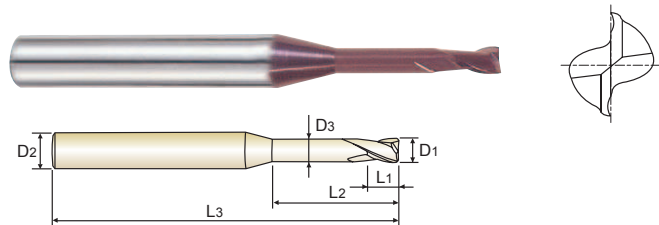


2 FLUTE, RIB PROCESSING

G9B80 SERIES

PLAIN SHANK

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



P.45



Unit : mm

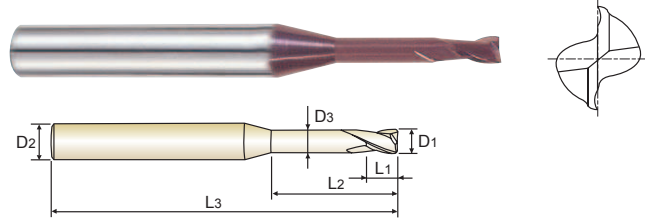
| EDP No. | MILL DIAMETER D1 | SHANK DIAMETER D2 | LENGTH OF CUT L1 | LENGTH BELOW SHANK L2 | OVERALL LENGTH L3 | NECK DIAMETER D3 |
|----------|---------------------|----------------------|---------------------|--------------------------|----------------------|---------------------|
| G9B80004 | 0.4 | 4 | 0.7 | 2 | 50 | 0.37 |
| G9B80901 | 0.4 | 4 | 0.7 | 4 | 50 | 0.37 |
| G9B80005 | 0.5 | 4 | 0.75 | 2 | 50 | 0.45 |
| G9B80902 | 0.5 | 4 | 0.75 | 4 | 50 | 0.45 |
| G9B80903 | 0.5 | 4 | 0.75 | 6 | 50 | 0.45 |
| G9B80006 | 0.6 | 4 | 0.9 | 2 | 50 | 0.55 |
| G9B80904 | 0.6 | 4 | 0.9 | 4 | 50 | 0.55 |
| G9B80905 | 0.6 | 4 | 0.9 | 6 | 50 | 0.55 |
| G9B80007 | 0.7 | 4 | 1.1 | 4 | 50 | 0.65 |
| G9B80906 | 0.7 | 4 | 1.1 | 6 | 50 | 0.65 |
| G9B80008 | 0.8 | 4 | 1.2 | 4 | 50 | 0.75 |
| G9B80907 | 0.8 | 4 | 1.2 | 6 | 50 | 0.75 |
| G9B80908 | 0.8 | 4 | 1.2 | 8 | 50 | 0.75 |
| G9B80009 | 0.9 | 4 | 1.4 | 6 | 50 | 0.85 |
| G9B80909 | 0.9 | 4 | 1.4 | 8 | 50 | 0.85 |
| G9B80910 | 0.9 | 4 | 1.4 | 10 | 50 | 0.85 |
| G9B80010 | 1.0 | 4 | 1.5 | 6 | 50 | 0.95 |
| G9B80911 | 1.0 | 4 | 1.5 | 8 | 50 | 0.95 |
| G9B80912 | 1.0 | 4 | 1.5 | 10 | 50 | 0.95 |
| G9B80913 | 1.0 | 4 | 1.5 | 12 | 50 | 0.95 |
| G9B80012 | 1.2 | 4 | 1.8 | 6 | 50 | 1.15 |
| G9B80914 | 1.2 | 4 | 1.8 | 8 | 50 | 1.15 |
| G9B80915 | 1.2 | 4 | 1.8 | 10 | 50 | 1.15 |
| G9B80916 | 1.2 | 4 | 1.8 | 12 | 50 | 1.15 |
| G9B80015 | 1.5 | 4 | 2.3 | 6 | 50 | 1.45 |
| G9B80917 | 1.5 | 4 | 2.3 | 8 | 50 | 1.45 |
| G9B80918 | 1.5 | 4 | 2.3 | 10 | 50 | 1.45 |
| G9B80919 | 1.5 | 4 | 2.3 | 12 | 50 | 1.45 |
| G9B80920 | 1.5 | 4 | 2.3 | 14 | 50 | 1.45 |
| G9B80921 | 1.5 | 4 | 2.3 | 16 | 50 | 1.45 |
| G9B80922 | 1.5 | 4 | 2.3 | 18 | 50 | 1.45 |
| G9B80923 | 1.5 | 4 | 2.3 | 20 | 50 | 1.45 |

2 FLUTE, RIB PROCESSING

G9B80 SERIES

PLAIN SHANK

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



Unit : mm

| EDP No. | MILL DIAMETER D1 | SHANK DIAMETER D2 | LENGTH OF CUT L1 | LENGTH BELOW SHANK L2 | OVERALL LENGTH L3 | NECK DIAMETER D3 |
|----------|---------------------|----------------------|---------------------|--------------------------|----------------------|---------------------|
| G9B80020 | 2.0 | 4 | 3 | 6 | 50 | 1.95 |
| G9B80924 | 2.0 | 4 | 3 | 8 | 50 | 1.95 |
| G9B80925 | 2.0 | 4 | 3 | 10 | 50 | 1.95 |
| G9B80926 | 2.0 | 4 | 3 | 12 | 50 | 1.95 |
| G9B80927 | 2.0 | 4 | 3 | 14 | 50 | 1.95 |
| G9B80928 | 2.0 | 4 | 3 | 16 | 50 | 1.95 |
| G9B80929 | 2.0 | 4 | 3 | 18 | 50 | 1.95 |
| G9B80930 | 2.0 | 4 | 3 | 20 | 50 | 1.95 |
| G9B80025 | 2.5 | 4 | 3.7 | 8 | 50 | 2.40 |
| G9B80931 | 2.5 | 4 | 3.7 | 12 | 50 | 2.40 |
| G9B80932 | 2.5 | 4 | 3.7 | 16 | 50 | 2.40 |
| G9B80933 | 2.5 | 4 | 3.7 | 20 | 50 | 2.40 |
| G9B80030 | 3.0 | 6 | 4.5 | 8 | 50 | 2.85 |
| G9B80934 | 3.0 | 6 | 4.5 | 12 | 50 | 2.85 |
| G9B80935 | 3.0 | 6 | 4.5 | 16 | 60 | 2.85 |
| G9B80936 | 3.0 | 6 | 4.5 | 20 | 60 | 2.85 |
| G9B80937 | 3.0 | 6 | 4.5 | 25 | 75 | 2.85 |
| G9B80040 | 4.0 | 6 | 6 | 12 | 50 | 3.85 |
| G9B80938 | 4.0 | 6 | 6 | 16 | 60 | 3.85 |
| G9B80939 | 4.0 | 6 | 6 | 20 | 75 | 3.85 |
| G9B80940 | 4.0 | 6 | 6 | 25 | 75 | 3.85 |
| G9B80941 | 4.0 | 6 | 6 | 30 | 75 | 3.85 |
| G9B80942 | 4.0 | 6 | 6 | 35 | 75 | 3.85 |

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

2 FLUTE FOR RIB PROCESSING

▶ G9B80 SERIES

| MATERIAL | MATERIALNON-ALLOYED STEELS ALLOY STEELS | | | ALLOY STEELS HEAT RESISTANT STEELS | | |
|----------|--|---------|-------------|---------------------------------------|---------|-------------|
| | ~ HRC30 | | | HRC30 ~ HRC45 | | |
| STRENGTH | ~ 1000N/mm ² | | | 1000 ~ 1500N/mm ² | | |
| DIAMETER | RPM | FEED | Ae(mm) | RPM | FEED | Ae(mm) |
| 0.4 | 26500~34000 | 170~370 | 0.007~0.018 | 19000~24000 | 72~290 | 0.007~0.018 |
| 0.5 | 26500~34000 | 170~370 | 0.009~0.022 | 19000~24000 | 72~290 | 0.009~0.022 |
| 0.6 | 26500~34000 | 210~485 | 0.011~0.026 | 19000~24000 | 95~365 | 0.011~0.026 |
| 0.7 | 26500~34000 | 210~485 | 0.012~0.031 | 19000~24000 | 95~365 | 0.012~0.031 |
| 0.8 | 23000~30000 | 240~535 | 0.014~0.035 | 16500~21000 | 100~410 | 0.014~0.035 |
| 0.9 | 21500~27000 | 240~610 | 0.030~0.060 | 15000~19000 | 135~460 | 0.030~0.060 |
| 1 | 19000~24000 | 240~690 | 0.045~0.090 | 13500~17000 | 160~510 | 0.045~0.090 |
| 1.2 | 15500~19000 | 240~765 | 0.055~0.100 | 11000~14000 | 160~510 | 0.055~0.100 |
| 1.4 | 13600~17000 | 240~765 | 0.062~0.125 | 9800~12000 | 160~510 | 0.062~0.125 |
| 1.5 | 12500~15500 | 240~765 | 0.070~0.135 | 8950~11500 | 160~510 | 0.070~0.135 |
| 1.6 | 12000~15000 | 240~765 | 0.075~0.145 | 8700~10900 | 160~510 | 0.075~0.145 |
| 1.8 | 11000~14000 | 240~765 | 0.080~0.160 | 7800~9800 | 160~510 | 0.080~0.160 |
| 2 | 10000~12500 | 240~765 | 0.090~0.180 | 7000~8950 | 160~510 | 0.090~0.180 |
| 2.5 | 8000~10000 | 240~765 | 0.112~0.235 | 5700~7200 | 160~510 | 0.112~0.235 |
| 3 | 6800~8500 | 240~765 | 0.135~0.270 | 4700~6000 | 160~510 | 0.135~0.270 |
| 4 | 5100~6500 | 240~765 | 0.180~0.360 | 3500~4500 | 160~510 | 0.180~0.360 |



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

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