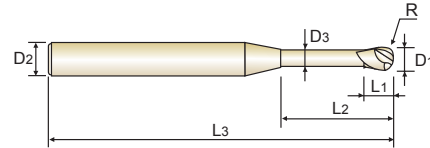
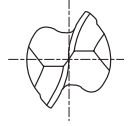


2 FLUTE, BALL NOSE, RIB PROCESSING

G9B81 SERIES

PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.



P.48



Unit : mm

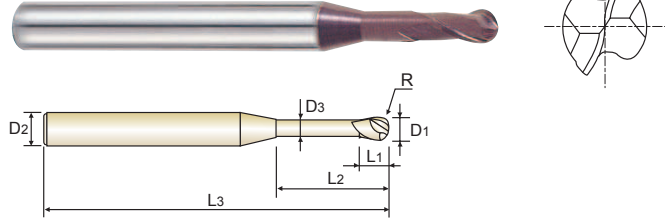
EDP No.	R ± 0.02	MILL DIAMETER D ₁	SHANK DIAMETER D ₂	LENGTH OF CUT L ₁	LENGTH BELOW SHANK L ₂	OVERALL LENGTH L ₃	NECK DIAMETER D ₃
G9B81004	RO.2	0.4	4	0.7	2	50	0.37
G9B81005	RO.25	0.5	4	0.75	2	50	0.45
G9B81901	RO.25	0.5	4	0.75	4	50	0.45
G9B81902	RO.25	0.5	4	0.75	6	50	0.45
G9B81006	RO.3	0.6	4	0.9	2	50	0.55
G9B81903	RO.3	0.6	4	0.9	4	50	0.55
G9B81904	RO.3	0.6	4	0.9	6	50	0.55
G9B81008	RO.4	0.8	4	1.2	4	50	0.75
G9B81905	RO.4	0.8	4	1.2	6	50	0.75
G9B81906	RO.4	0.8	4	1.2	8	50	0.75
G9B81010	RO.5	1.0	4	1.5	6	50	0.95
G9B81907	RO.5	1.0	4	1.5	8	50	0.95
G9B81908	RO.5	1.0	4	1.5	10	50	0.95
G9B81909	RO.5	1.0	4	1.5	12	50	0.95
G9B81012	RO.6	1.2	4	1.8	8	50	1.15
G9B81910	RO.6	1.2	4	1.8	12	50	1.15
G9B81014	RO.7	1.4	4	2.1	16	50	1.35
G9B81015	RO.75	1.5	4	2.3	6	50	1.45
G9B81911	RO.75	1.5	4	2.3	8	50	1.45
G9B81912	RO.75	1.5	4	2.3	10	50	1.45
G9B81913	RO.75	1.5	4	2.3	12	50	1.45
G9B81914	RO.75	1.5	4	2.3	16	50	1.45
G9B81915	RO.75	1.5	4	2.3	20	50	1.45
G9B81016	RO.8	1.6	4	2.4	8	50	1.55
G9B81916	RO.8	1.6	4	2.4	12	50	1.55
G9B81917	RO.8	1.6	4	2.4	16	50	1.55
G9B81918	RO.8	1.6	4	2.4	20	50	1.55

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Unit : mm

EDP No.	R ± 0.02	MILL DIAMETER D ₁	SHANK DIAMETER D ₂	LENGTH OF CUT L ₁	LENGTH BELOW SHANK L ₂	OVERALL LENGTH L ₃	NECK DIAMETER D ₃
G9B81020	R1.0	2.0	4	3	8	50	1.95
G9B81919	R1.0	2.0	4	3	10	50	1.95
G9B81920	R1.0	2.0	4	3	12	50	1.95
G9B81921	R1.0	2.0	4	3	14	50	1.95
G9B81922	R1.0	2.0	4	3	16	50	1.95
G9B81923	R1.0	2.0	4	3	20	50	1.95
G9B81030	R1.5	3.0	6	4.5	10	50	2.85
G9B81924	R1.5	3.0	6	4.5	12	50	2.85
G9B81925	R1.5	3.0	6	4.5	16	60	2.85
G9B81926	R1.5	3.0	6	4.5	20	60	2.85
G9B81927	R1.5	3.0	6	4.5	25	75	2.85
G9B81040	R2.0	4.0	6	6	12	50	3.85
G9B81928	R2.0	4.0	6	6	16	60	3.85
G9B81929	R2.0	4.0	6	6	20	75	3.85
G9B81930	R2.0	4.0	6	6	25	75	3.85
G9B81931	R2.0	4.0	6	6	30	75	3.85

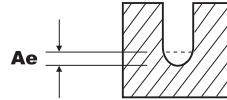
MILL DIA. TOLERANCE(mm)	SHANK DIA. TOLERANCE
0 - 0.030	h6

2 FLUTE, BALL NOSE, RIB PROCESSING

▶ G9B81 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	26350~34000	150~415	0.018~0.036	19100~24200	75~230	0.018~0.036
0.5	26350~34000	150~415	0.023~0.045	19100~24200	75~230	0.023~0.045
0.6	26350~34000	190~535	0.027~0.054	19100~24200	95~300	0.027~0.054
0.8	26350~34000	190~535	0.036~0.072	19100~24200	95~300	0.036~0.072
1	24650~31000	210~595	0.045~0.090	17400~22100	105~330	0.045~0.090
1.2	20500~26000	210~665	0.055~0.100	14500~18300	105~330	0.055~0.100
1.4	18000~22000	210~665	0.062~0.125	12800~15300	105~330	0.062~0.125
1.5	16000~20500	210~665	0.070~0.135	11500~14900	105~330	0.070~0.135
1.6	15500~20000	210~665	0.075~0.145	11200~14000	105~330	0.075~0.145
1.8	14500~18200	210~665	0.080~0.160	10200~12800	105~330	0.080~0.160
2	13000~16000	210~665	0.090~0.180	9400~11500	105~330	0.090~0.180
3	9000~11000	210~665	0.135~0.270	6000~11500	105~330	0.135~0.270
4	7200~9350	210~665	0.180~0.360	5000~6600	105~330	0.180~0.360

(Depth of Cut per one pass)



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

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