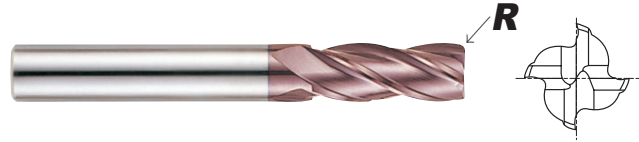


4 FLUTE, LONG REACH, CORNER RADIUS

G9B85 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.



MG HM
YG STD
30°
4
PLAIN
P.54



Unit : mm

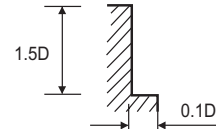
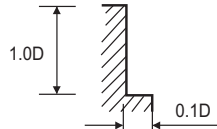
EDP No.	MILL DIAMETER	CORNER RADIUS	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
G9B85030	3.0	R0.5	4	6	75
G9B85901	3.0	R1.0	4	6	75
G9B85040	4.0	R0.5	4	8	75
G9B85902	4.0	R1.0	4	8	75
G9B85050	5.0	R0.5	6	10	75
G9B85903	5.0	R1.0	6	10	75
G9B85060	6.0	R0.5	6	12	75
G9B85904	6.0	R1.0	6	12	75
G9B85080	8.0	R0.5	8	16	100
G9B85905	8.0	R1.0	8	16	100
G9B85906	8.0	R1.5	8	16	100
G9B85907	8.0	R2.0	8	16	100
G9B85908	8.0	R2.5	8	16	100
G9B85100	10.0	R0.5	10	20	100
G9B85909	10.0	R1.0	10	20	100
G9B85910	10.0	R1.5	10	20	100
G9B85911	10.0	R2.0	10	20	100
G9B85912	10.0	R2.5	10	20	100
G9B85120	12.0	R0.5	12	24	100
G9B85913	12.0	R1.0	12	24	100
G9B85914	12.0	R1.5	12	24	100
G9B85915	12.0	R2.0	12	24	100
G9B85916	12.0	R2.5	12	24	100

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

4 FLUTE, FINISH, SIDE CUTTING

▶ G9B84, G9B85 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	17600	150	10250	85	8650	75	18700	620	44000	1050	24700	605
1.5	11800	215	7050	115	7050	120	12100	620	27500	1160	20300	910
2	9850	240	6450	145	5350	120	9350	640	22000	1320	16500	1035
3	7600	270	4750	170	3950	145	6050	640	15400	1320	11000	1035
4	6450	485	3950	300	3300	240	4600	640	11000	1320	8800	1035
5	5350	510	3200	305	2700	255	3650	640	9150	1320	6800	1035
6	4750	560	2850	350	2400	280	2950	770	7600	1430	5700	1100
8	3550	605	2150	325	1800	300	2200	815	5700	1430	4400	1100
10	2750	520	1700	255	1450	255	1850	860	4600	1430	3400	1100
12	2350	440	1450	215	1150	205	1450	900	3750	1430	2850	1100



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

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