

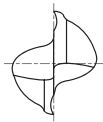


MICROGRAIN
CARBIDE END MILLS **G9F41**

SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE SHORT LENGTH
VOLLHARTMETALL, 2 SCHNEIDEN KURZ

- Suitable for dry milling applications at high temperatures.
 - Excellent high-performance end mills.
 - 2 flute design for slotting.
- Für die Trockenbearbeitung.
 - Hervorragendes Preis - Leistungsverhältnis.
 - 2 Schneiden zum Nutenfräsen.



Unit : mm

Description	Mill Diameter	Shank Diameter	Lenght of Cut	Overall Lenght
G9F41010N	1	4	3	50
G9F41020N	2	4	6	50
G9F41030N	3	4	8	50
G9F41040N	4	4	11	50
G9F41050N	5	6	13	50
G9F41060N	6	6	16	50
G9F41080N	8	8	20	60
G9F41100N	10	10	25	75
G9F41120N	12	12	32	75
G9F41140N	14	14	32	75
G9F41160N	16	16	32	75
G9F41200N	20	20	32	100

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6



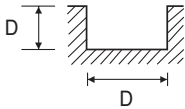
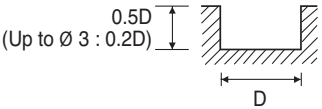
MICROGRAIN
CARBIDE END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE
VOLLHARTMETALL, 4 SCHNEIDEN

G9F41 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 STRENGTH	~ HRC 30 ~1000N/mm²		HRC 30 ~ HRC 45 1000~1500N/mm²									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1.0	14300	105	8500	65	7150	50	18700	205	44000	330	24700	200
2.0	7850	160	5150	100	4300	80	9350	220	22000	460	16500	340
3.0	6100	180	3800	120	3150	100	6050	220	15400	460	11000	340
4.0	5150	255	3150	155	2650	130	4600	220	11000	460	8800	340
5.0	4300	270	2550	160	2150	135	3650	220	9150	460	6800	340
6.0	3800	300	2300	190	1950	155	2950	255	7600	485	5700	375
8.0	2850	325	1700	170	1450	155	2200	275	5700	485	4400	375
10.0	2200	280	1350	135	1150	135	1850	285	4600	485	3400	375
12.0	1850	240	1150	110	950	110	1450	295	3750	485	2850	375
14.0	1700	215	1050	100	850	100	1300	310	3300	485	2400	375
16.0	1500	185	950	95	700	95	1100	320	2850	485	2200	375
20.0	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.

o :Excellent • : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70							
o	o	o				•		•	•	•	•	•