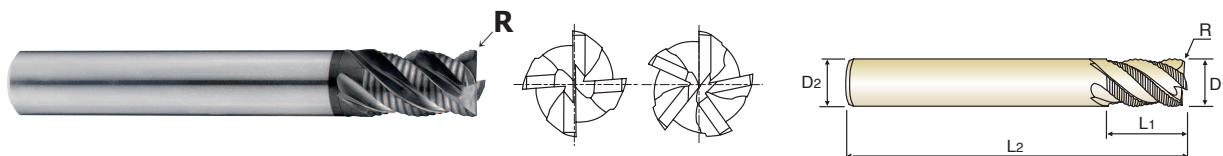


## CARBIDE, 4&5 FLUTE MULTIPLE HELIX LONG LENGTH CORNER RADIUS VOLLHARTMETALL, 4&5 SCHNEIDEN MEHRSPIRAL FRÄSER LANG ECKENRADIUS

- ▶ Unique flute design for excellent chip evacuation and vibration reduction.
- ▶ Optimal roughing tooth profile to reduce cutting forces.
- ▶ Special tool geometry for high feed rate and heavy cutting.
- ▶ Strong end tooth design for plunge and pocket milling.
- ▶ Custom engineered coating to allow long tool life and excellent chip evacuation.

- ▶ einzigartige Nutengeometrie für hervorragenden Spänetransport und Vibrationsreduzierung
- ▶ neuartiges Schruppprofil zur Reduzierung der Schnittkräfte
- ▶ Spezielle Werkzeuggeometrie für Hochvorschub- und Schwerzerspannung geeignet
- ▶ speziell entwickelte Schneidengeometrie für Tauch- und Taschenfräsen
- ▶ YG-1 eigene Beschichtung um lange Lebensdauer und sehr guten Spänetransport zu gewährleisten



Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	R	D1	D2	L1	L2	
G9D76060	G9D68060	R0.5	6.0	6	12	57	4
G9D76080	G9D68080	R0.5	8.0	8	16	63	4
G9D76100	G9D68100	R0.5	10.0	10	20	72	4
G9D76120	G9D68120	R0.5	12.0	12	24	83	4
G9D76160	G9D68160	R1.0	16.0	16	32	92	5
G9D76200	G9D68200	R1.0	20.0	20	40	104	5

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.05	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	◎	○			○		◎		○				



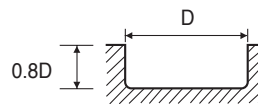
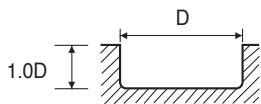
**X-SPEED ROUGHER  
END MILLS**

**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4&5 FLUTE MULTIPLE HELIX CORNER RADIUS - SLOTTING  
VOLLHARTMETALL, 4&5 SCHNEIDEN MEHRSPIRAL FRÄSER ECKENRADIUS - NUTENFRÄSEN**

**G9D75, G9D67, G9D76, G9D68, G9D77, G9D69 SERIES**

MATERIAL	ALLOYED STEELS, CARBON STEELS TOOL STEELS, CAST IRON				ALLOYED STEELS, CARBON STEELS TOOL STEELS, CAST IRON PREHARDENED STEELS				
	~ Hrc 25				Hrc 25 ~ Hrc 40				
	HARDNESS	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
DIAMETER									
6.0	12000	1550	225	0.032	10600	1100	200	0.026	
8.0	9000	1650	225	0.046	8100	1180	205	0.036	
10.0	7200	1650	225	0.057	6400	1180	200	0.046	
12.0	6000	1540	225	0.064	5400	1140	205	0.053	
16.0	4500	1500	225	0.067	4100	1050	205	0.051	
20.0	3600	1330	225	0.074	3200	900	200	0.056	

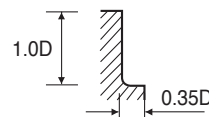
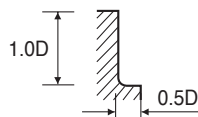


RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t

**CARBIDE, 4&5 FLUTE MULTIPLE HELIX CORNER RADIUS - SIDE CUTTING  
VOLLHARTMETALL, 4&5 SCHNEIDEN MEHRSPIRAL FRÄSER ECKENRADIUS - SEITENFRÄSEN**

**G9D75, G9D67, G9D76, G9D68, G9D77, G9D69 SERIES**

MATERIAL	ALLOYED STEELS, CARBON STEELS TOOL STEELS, CAST IRON				ALLOYED STEELS, CARBON STEELS TOOL STEELS, CAST IRON PREHARDENED STEELS				
	~ Hrc 25				Hrc 25 ~ Hrc 40				
	HARDNESS	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
DIAMETER									
6.0	15800	2570	300	0.041	14300	1850	270	0.032	
8.0	11900	2700	300	0.057	10700	1950	270	0.046	
10.0	9500	2700	300	0.071	8500	1950	265	0.057	
12.0	8000	2570	300	0.080	7100	1850	270	0.065	
16.0	6000	2450	300	0.082	5400	1750	270	0.065	
20.0	4800	2140	300	0.089	4300	1500	270	0.070	



RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t