



X-SPEED ROUGHER END MILLS

G9D75 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

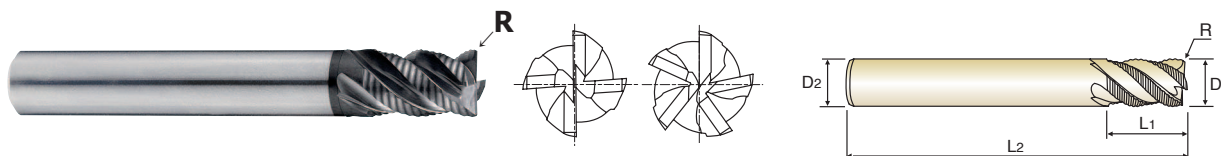
G9D67 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4&5 FLUTE MULTIPLE HELIX SHORT LENGTH CORNER RADIUS VOLLHARTMETALL, 4&5 SCHNEIDEN MEHRSPIRAL FRÄSER KURZ 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



P.826

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	
G9D75060	G9D67060	R0.5	6.0	6	9	57	4
G9D75080	G9D67080	R0.5	8.0	8	12	63	4
G9D75100	G9D67100	R0.5	10.0	10	15	72	4
G9D75120	G9D67120	R0.5	12.0	12	18	83	4
G9D75160	G9D67160	R1.0	16.0	16	24	92	5
G9D75200	G9D67200	R1.0	20.0	20	30	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									
◎	◎	◎	○			○		◎		○				



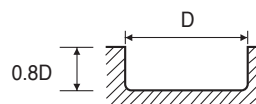
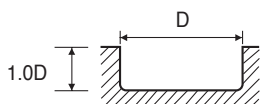
X-SPEED ROUGHER END MILLS

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			
HARDNESS	~ HRc 25				HRc 25 ~ HRc 40			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
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

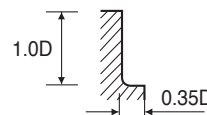
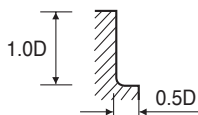


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

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			
HARDNESS	~ HRc 25				HRc 25 ~ HRc 40			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
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