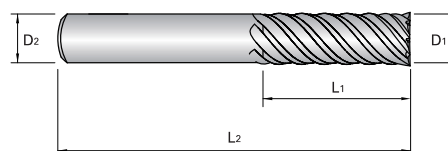


END MILLS for GENERAL



CARBIDE, 6 FLUTE 45° HELIX

- High speed cutting and finish milling with high feed rate.
- Excellent surface finishes.
- Application in high speed machining, wet and dry cutting condition.



CARBIDE

6

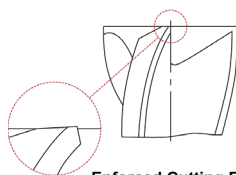
45°

PLAIN

X Coating



p.57



Enforced Cutting Edge

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.030	h5

G9J58

SERIES

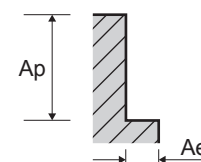
Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	D1	D2	L1	L2
G9J58999N	6.0	6	15	50
G9J58998N	8.0	8	20	60
G9J58997N	10.0	10	25	75
G9J58996N	12.0	12	30	75
G9J58995N	16.0	16	40	100

RECOMMENDED CUTTING CONDITIONS

Vc = (m/min.)
fz = (mm/tooth)
RPM = (rev/min.)
FEED = (mm/min.)

G9J58 SERIES		6 FLUTE - SIDE CUTTING								
ISO	VDI 3323	Material Description	Ae(mm)	Ap(mm)	Parameter	Diameter (Ø)				
						6.0	8.0	10.0	12.0	16.0
P	3-4	Non-alloy steel	0.05D	1.5D	Vc	105	106	104	107	106
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	5590	4210	3320	2835	2105
					FEED	995	960	900	895	785
	5	Non-alloy steel	0.03D	1.5D	Vc	70	71	70	71	71
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	3725	2810	2215	1890	1405
					FEED	675	640	600	600	520
	7	Low alloy steel	0.05D	1.5D	Vc	105	106	104	107	106
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	5590	4210	3320	2835	2105
					FEED	995	960	900	895	785
K	15-16	Grey cast iron	0.05D	1.5D	Vc	70	71	70	71	71
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	3725	2810	2215	1890	1405
					FEED	675	640	600	600	520
	17-18	Nodular cast iron	0.05D	1.5D	Vc	105	106	104	107	106
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	5590	4210	3320	2835	2105
					FEED	995	960	900	895	785
	19-20	Malleable cast iron	0.05D	1.5D	Vc	105	106	104	107	106
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	5590	4210	3320	2835	2105
					FEED	995	960	900	895	785
H	38.1	Hardened steel	0.03D	1.5D	Vc	54	54	54	54	54
					fz	0.023	0.029	0.033	0.039	0.046
					RPM	2860	2160	1730	1440	1080
					FEED	400	370	340	340	300
	38.2	Hardened steel	0.02D	1D	Vc	43	44	43	43	44
					fz	0.018	0.023	0.027	0.032	0.038
					RPM	2270	1730	1380	1135	865
					FEED	250	235	220	215	195
	40	Chilled Cast Iron	0.03D	1.5D	Vc	70	71	70	71	71
					fz	0.030	0.038	0.045	0.053	0.062
					RPM	3725	2810	2215	1890	1405
					FEED	675	640	600	600	520
	41	Hardened Cast Iron	0.02D	1D	Vc	43	44	43	43	44
					fz	0.018	0.023	0.027	0.032	0.038
					RPM	2270	1730	1380	1135	865
					FEED	250	235	220	215	195



[illegible]