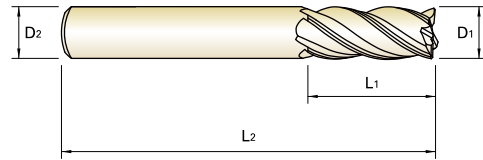
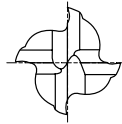


CARBIDE, 4 FLUTE SHORT LENGTH

- VOLLHARTMETALL, 4 SCHNEIDEN KURZ
- FRAISE CARBURE, 4 DENTS, COURTE
- 4 TAGLIENTI, CORTA

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 4 flute allows for better work piece finishes.

- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis.
- ▶ 4 Schneiden erzeugen eine bessere Oberflächengüte des Werkstücks.



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	D1	D2	L1	L2
G9F42010N	1	4	3	50
G9F42999N	1,5	4	4	50
G9F42020N	2	4	6	50
G9F42998N	2,5	4	8	50
G9F42030N	3	4	8	50
G9F42997N	3,5	4	10	50
G9F42040N	4	4	11	50
G9F42996N	4,5	4,5	12	50
G9F42050N	5	6	13	50
G9F42060N	6	6	16	50
G9F42995N	7	7	20	60
G9F42080N	8	8	20	60
G9F42994N	9	9	20	60
G9F42100N	10	10	25	75
G9F42120N	12	12	32	75
G9F42140N	14	14	32	75
G9F42160N	16	16	32	75
G9F42200N	20	20	32	100

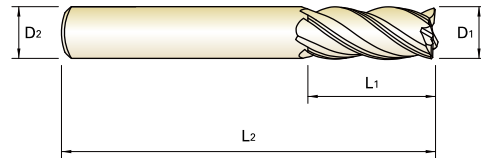
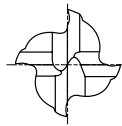
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 ~ - 0,030	h6

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Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 ~ - 0,030	h6

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALLOY STEELS PRE-HARDEND STEELS				STAINLESS STEELS				CAST IRON			
	~ HRc30				HRc30 ~ HRc50											
HARDNESS	~ 1000N/mm ²				1000 ~ 1500N/mm ²											
STRENGTH	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
1	19000	160	60	0,002	11050	90	35	0,002	9350	80	29	0,002	20200	670	63	0,008
1,5	12750	230	60	0,005	7600	125	36	0,004	7600	130	36	0,004	13050	670	61	0,013
2	10650	260	67	0,006	6950	155	44	0,006	5800	130	36	0,006	10100	690	63	0,017
2,5	9165	255	72	0,007	5855	165	46	0,007	4840	135	38	0,007	4895	695	62	0,022
3	8200	290	77	0,009	5150	185	49	0,009	4250	155	40	0,009	6550	690	62	0,026
3,5	7460	420	82	0,014	4640	260	51	0,014	3820	200	42	0,013	5640	700	62	0,031
4	6950	525	87	0,019	4250	325	53	0,019	3550	260	45	0,018	4950	690	62	0,035
4,5	6295	530	89	0,021	3750	315	53	0,021	3185	270	45	0,021	4385	700	62	0,040
5	5800	550	91	0,024	3450	330	54	0,024	2900	275	46	0,024	3950	690	62	0,044
6	5100	605	96	0,030	3100	380	58	0,031	2600	300	49	0,029	3200	830	60	0,065
7	4365	645	96	0,037	2640	370	58	0,035	2230	315	49	0,035	2730	865	60	0,079
8	3850	655	97	0,043	2300	350	58	0,038	1950	325	49	0,042	2400	880	60	0,092
9	3395	611	96	0,045	2050	305	58	0,037	1700	300	48	0,044	2195	915	62	0,104
10	2950	560	93	0,047	1850	275	58	0,037	1500	275	47	0,046	2000	930	63	0,116
12	2550	475	96	0,047	1550	230	58	0,037	1250	220	47	0,044	1550	970	58	0,156
14	2250	425	99	0,047	1400	210	62	0,038	1150	205	51	0,045	1400	1020	62	0,182
16	2000	380	101	0,048	1250	185	63	0,037	1050	185	53	0,044	1200	1050	60	0,219
20	1550	290	97	0,047	950	145	60	0,038	750	140	47	0,047	950	1120	60	0,295
	Ap : 1.0D, Ae : 0.1D												Ap : 1.5D, Ae : 0.1D			

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

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