Registered
ISO 9001:2015 / ISO 14001:2015

WORLD CLASS PRODUCT OF KOREA
세계일류상품

K-2 CARBIDE END MILLS

TiAlN-COATED SOLID CARBIDE END MILLS

General Purpose
Conventional / High Speed Milling
Wet / Dry Cutting

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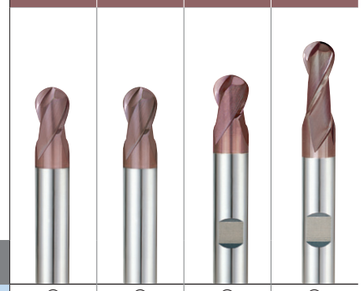
K-2 CARBIDE END MILLS

TiAlN-COATED SOLID CARBIDE END MILLS
General Purpose
Conventional / High Speed Milling
Wet / Dry Cutting

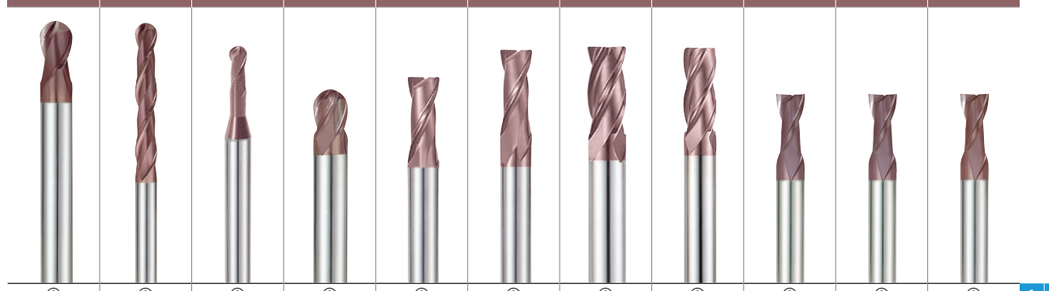
◎ : Excellent ○ : Good

SERIES	G9624	G9A70	G9437	G9438
FLUTE	2	2	2	2
HELIX ANGLE	30°	30°	≈ 30°	≈ 30°
CUTTING EDGE SHAPE	BALL NOSE	BALL NOSE	BALL NOSE	BALL NOSE
SIZE MIN	R1.0	R0.5	R1.0	R1.0
SIZE MAX	R10.0	R10.0	R10.0	R10.0
PAGE	8	9	10	11
	SHORT LENGTH	SHORT LENGTH	SHORT LENGTH	LONG LENGTH
	TiAlN	TiAlN	TiAlN	TiAlN



ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	G9624	G9A70	G9437	G9438
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎
	3		About 0.45% C	Quenched & tempered	250	25	◎	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎
	5		About 0.75% C	Quenched & tempered	300	32	◎	◎	◎	◎
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎
	7			Quenched & tempered	275	29	◎	◎	◎	◎
	8			Quenched & tempered	300	32	◎	◎	◎	◎
	9			Quenched & tempered	350	38	◎	◎	◎	◎
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎	◎
	11			Quenched & Tempered	325	35	◎	◎	◎	◎
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	○
	13		Martensitic	Quenched & Tempered	240	23	○	○	○	○
	14		Austenitic		180	10	○	○	○	○
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○	○
	16		Pearlitic (Martensitic)		260	26	○	○	○	○
	17	Nodular cast iron	Ferritic		160	3	○	○	○	○
	18		Pearlitic		250	25	○	○	○	○
	19	Malleable cast iron	Ferritic		130		○	○	○	○
	20		Pearlitic		230	21	○	○	○	○
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○	○
	22		Curable	Hardened	100		○	○	○	○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○	○
	24		≤ 12% Si, Curable	Hardened	90		○	○	○	○
	25		> 12% Si, Not Curable		130		○	○	○	○
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○
	27		CuZn, CuSnZn (Brass)		90		○	○	○	○
	28		CuSn, lead-free copper and electrolytic copper		100		○	○	○	○
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	○	○	○	○
	32			Cured	280	30	○	○	○	○
	33		Ni or Co Based	Annealed	250	25	○	○	○	○
	34			Cured	350	38	○	○	○	○
	35			Cast	320	34	○	○	○	○
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○	○
	37		Alpha + Beta Alloys	Hardened	1050 Rm		○	○	○	○
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42	○	○	○	○
	41	Hardened Cast Iron		Hardened	550	55				

SERIES	G9454	G9455	G9B81	G9634	G9B82	G9B83	G9B84	G9B85	G9424	G9G44	G9A68
FLUTE	2	2	2	4	2	2	4	4	2	2	2
HELIX ANGLE	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°
CUTTING EDGE SHAPE	BALL NOSE	BALL NOSE	BALL NOSE	BALL NOSE	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	SQUARE	SQUARE	SQUARE
SIZE MIN	R1.5	R1.5	R0.2	R1.0	D2.0	D3.0	D2.0	D3.0	D1.0	D3.0	D1.0
SIZE MAX	R10.0	R10.0	R2.0	R10.0	D12.0	D12.0	D12.0	D12.0	D20.0	D20.0	D20.0
PAGE	12	13	14	16	17	19	20	22	23	24	25
	LONG REACH	EXTRA LONG LENGTH	RIB PROCESSING	SHORT LENGTH	SHORT LENGTH	LONG REACH	SHORT LENGTH	LONG REACH	SHORT LENGTH	SHORT LENGTH WITH CHAMFER	SHORT LENGTH
	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN



G9454	G9455	G9B81	G9634	G9B82	G9B83	G9B84	G9B85	G9424	G9G44	G9A68		
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											41	

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General Purpose
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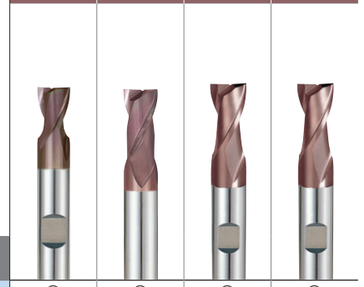
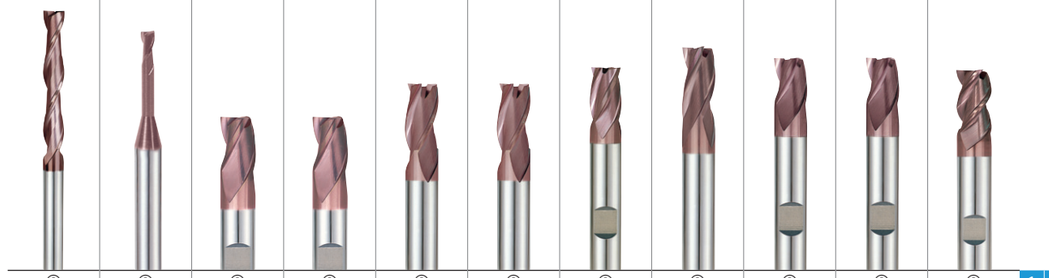
Wet / Dry Cutting

◎ : Excellent ○ : Good

SERIES	G9444	G9527	G9445	G9G45	G9452	G9B80	G9553 G9410	G9G46	G9425	G9G47	G9439	G9528	G9433	G9G48	G9447
FLUTE	2	2	2	2	2	2	3	3	3	3	3	3	3	3	3
HELIX ANGLE	≈ 30°	≈ 30°	≈ 30°	≈ 30°	30°	30°	30°	30°	30°	30°	≈ 30°	≈ 30°	≈ 30°	≈ 30°	45°
CUTTING EDGE SHAPE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE
SIZE MIN	D2.0	D3.5	D2.0	D3.0	D3.0	D0.4	D0.5	D3.0	D1.0	D3.0	D2.0	D3.5	D3.0	D3.0	D3.0
SIZE MAX	D20.0	D20.0	D20.0	D20.0	D20.0	D4.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0
PAGE	26	27	28	30	31	32	35	37	38	39	40	41	42	43	44
	SHORT LENGTH	LONG LENGTH	LONG LENGTH	LONG LENGTH with CHAMFER	EXTRA LONG LENGTH	RIB PROCESSING	THROW AWAY	THROW AWAY with CHAMFER	SHORT LENGTH	SHORT LENGTH with CHAMFER	SHORT LENGTH	LONG LENGTH	LONG LENGTH	LONG LENGTH with CHAMFER	LONG LENGTH
	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	G9444	G9527	G9445	G9G45	G9452	G9B80	G9553 G9410	G9G46	G9425	G9G47	G9439	G9528	G9433	G9G48	G9447		
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	1	P
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	2	
	3		About 0.45% C	Quenched & tempered	250	25	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	3	
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	4	
	5		About 0.75% C	Quenched & tempered	300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	5	
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	6	
	7			Quenched & tempered	275	29	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	7	
	8			Quenched & tempered	300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	8	
	9			Quenched & tempered	350	38	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	9	
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	10	
	11			Quenched & Tempered	325	35	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	11	
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	12	M
	13		Martensitic	Quenched & Tempered	240	23	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	13	
	14		Austenitic		180	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	14	
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	15	K
	16		Pearlitic (Martensitic)		260	26	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	16	
	17	Nodular cast iron	Ferritic		160	3	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	17	
	18		Pearlitic		250	25	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	18	
	19	Malleable cast iron	Ferritic		130		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	19	
	20		Pearlitic		230	21	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	20	
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	21	N
	22		Curable	Hardened	100		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	22	
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	23	
	24		≤ 12% Si, Curable	Hardened	90		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	24	
	25		> 12% Si, Not Curable		130		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	25	
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	26	
	27		CuZn, CuSnZn (Brass)		90		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	27	
	28		CuSn, lead-free copper and electrolytic copper		100		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	28	
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				○	○	○	○	○		○	○	○	○	○	○	○	○	○	29	
	30		Rubber, Wood, etc.																			30	
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	○	○	○	○	○		○	○	○	○	○	○	○	○	○	31	S
	32			Cured	280	30	○	○	○	○	○		○	○	○	○	○	○	○	○	○	32	
	33		Ni or Co Based	Annealed	250	25	○	○	○	○	○		○	○	○	○	○	○	○	○	○	33	
	34			Cured	350	38	○	○	○	○	○		○	○	○	○	○	○	○	○	○	34	
	35			Cast	320	34	○	○	○	○	○		○	○	○	○	○	○	○	○	○	35	
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○	○	○		○	○	○	○	○	○	○	○	○	36	
	37		Alpha + Beta Alloys	Hardened	1050 Rm		○	○	○	○	○		○	○	○	○	○	○	○	○	○	37	
H	38	Hardened steel		Hardened	550	55																38	H
	39			Hardened	630	60																39	
	40	Chilled Cast Iron		Cast	400	42	○	○	○	○	○		○	○	○	○	○	○	○	○	○	40	
	41	Hardened Cast Iron		Hardened	550	55																41	

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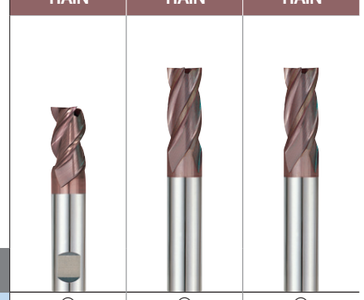
Wet / Dry Cutting

◎ : Excellent ○ : Good

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	G9G49	G9432	G9G50	G9A69	G9448	G9540	G9449	G9G51	G9453	G9F45 G9F46	G9A42	G9400	
							3	4	4	4	4	4	4	4	4	4&6	Multi Flute	2	
							45°	30°	30°	30°	≈ 30°	≈ 30°	≈ 30°	≈ 30°	30°	45°	30°	30°	
							SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	ROUGHING	DRILL MILL	
							D3.0	D1.0	D3.0	D1.0	D2.0	D3.5	D2.0	D3.0	D3.0	D3.0	D6.0	D3.0	
							D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D20.0	D25.0	D20.0	
							45	46	47	48	49	50	51	52	53	54	55	56	
							LONG LENGTH with CHAMFER	SHORT LENGTH	SHORT LENGTH with CHAMFER	SHORT LENGTH	SHORT LENGTH	LONG LENGTH	LONG LENGTH	LONG LENGTH with CHAMFER	EXTRA LONG LENGTH	SHORT LENGTH LONG LENGTH	LONG LENGTH	-	
							TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	X-Coating	TiAlN	
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	1
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	2
	3		About 0.45% C	Quenched & tempered	250	25	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	3
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	4
	5		About 0.75% C	Quenched & tempered	300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	5
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	6
	7			Quenched & tempered	275	29	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	7
	8			Quenched & tempered	300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	8
	9			Quenched & tempered	350	38	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	9
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	10
	11			Quenched & Tempered	325	35	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	11
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	○	○	○	○	○	○		○	○	12
	13		Martensitic	Quenched & Tempered	240	23	○	○	○	○	○	○	○	○	○		○	○	13
	14		Austenitic		180	10	○	○	○	○	○	○	○	○	○		○	○	14
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○	○	○	○	○	○	○	○	○	○	○	○	15
	16		Pearlitic (Martensitic)		260	26	○	○	○	○	○	○	○	○	○	○	○	○	16
	17	Nodular cast iron	Ferritic		160	3	○	○	○	○	○	○	○	○	○	○	○	○	17
	18		Pearlitic		250	25	○	○	○	○	○	○	○	○	○	○	○	○	18
	19	Malleable cast iron	Ferritic		130		○	○	○	○	○	○	○	○	○	○	○	○	19
	20		Pearlitic		230	21	○	○	○	○	○	○	○	○	○	○	○	○	20
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○	○	○	○	○	○	○		○	○	21
	22		Curable	Hardened	100		○	○	○	○	○	○	○	○	○		○	○	22
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○	○	○	○	○	○	○		○	○	23
	24		≤ 12% Si, Curable	Hardened	90		○	○	○	○	○	○	○	○	○		○	○	24
	25		> 12% Si, Not Curable		130		○	○	○	○	○	○	○	○	○		○	○	25
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○	○	○	○	○	○		○		26
	27		CuZn, CuSnZn (Brass)		90		○	○	○	○	○	○	○	○	○		○		27
	28		CuSn, lead-free copper and electrolytic copper		100		○	○	○	○	○	○	○	○	○		○		28
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				○	○	○	○	○	○	○	○	○				29
	30		Rubber, Wood, etc.																30
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	○	○	○	○	○	○	○	○	○		○		31
	32			Cured	280	30	○	○	○	○	○	○	○	○	○		○		32
	33		Ni or Co Based	Annealed	250	25	○	○	○	○	○	○	○	○	○		○		33
	34			Cured	350	38	○	○	○	○	○	○	○	○	○		○		34
	35			Cast	320	34	○	○	○	○	○	○	○	○	○		○		35
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○	○	○	○	○	○	○		○		36
	37		Alpha + Beta Alloys	Hardened	1050 Rm		○	○	○	○	○	○	○	○	○		○		37
H	38	Hardened steel		Hardened	550	55										○			38
	39			Hardened	630	60										○			39
	40	Chilled Cast Iron		Cast	400	42	○	○	○	○	○	○	○	○	○	○	○		40
	41	Hardened Cast Iron		Hardened	550	55										○			41

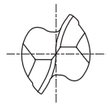


TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH BALL NOSE

G9624 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9624020	R1.0	**2.0**	6	4	48
G9624025	R1.25	**2.5**	6	4	48
G9624030	R1.5	**3.0**	6	4	48
G9624040	R2.0	**4.0**	6	6	50
G9624901	R2.0	**4.0**	4	12	40
G9624050	R2.5	**5.0**	6	7	51
G9624902	R2.5	**5.0**	5	14	50
G9624060	R3.0	**6.0**	6	7	51
G9624080	R4.0	**8.0**	8	9	59
G9624100	R5.0	**10.0**	10	10	60
G9624120	R6.0	**12.0**	12	14	71
G9624140	R7.0	**14.0**	14	14	71
G9624160	R8.0	**16.0**	16	16	76
G9624180	R9.0	**18.0**	18	18	76
G9624200	R10.0	**20.0**	20	20	82

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

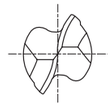
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH BALL NOSE

G9A70 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9A70010	R0.5	**1.0**	3	3	39
G9A70015	R0.75	**1.5**	3	5	39
G9A70020	R1.0	**2.0**	3	7	39
G9A70025	R1.25	**2.5**	3	8	39
G9A70030	R1.5	**3.0**	3	9	39
G9A70040	R2.0	**4.0**	4	14	51
G9A70050	R2.5	**5.0**	5	16	51
G9A70060	R3.0	**6.0**	6	19	64
G9A70080	R4.0	**8.0**	8	21	64
G9A70100	R5.0	**10.0**	10	22	70
G9A70110	R5.5	**11.0**	11	25	70
G9A70120	R6.0	**12.0**	12	25	76
G9A70160	R8.0	**16.0**	16	32	89
G9A70200	R10.0	**20.0**	20	38	102

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

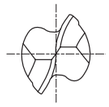
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH BALL NOSE

G9437 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | DIN 6527 | 2 | ≈30° | R ±0.02 | DIN 6535HB | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9437020	R1.0	**2.0**	6	3	50
G9437030	R1.5	**3.0**	6	4	50
G9437040	R2.0	**4.0**	6	5	54
G9437050	R2.5	**5.0**	6	6	54
G9437060	R3.0	**6.0**	6	7	54
G9437080	R4.0	**8.0**	8	9	58
G9437100	R5.0	**10.0**	10	11	66
G9437120	R6.0	**12.0**	12	12	73
G9437140	R7.0	**14.0**	14	14	75
G9437180	R9.0	**18.0**	18	18	84
G9437200	R10.0	**20.0**	20	20	92

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

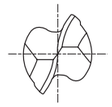
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH BALL NOSE

G9438 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | DIN 6527 | 2 | ≈30° | R ±0.02 | DIN 6535HA | DIN 6535HB | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9438020	R1.0	**2.0**	● 3	6	38
G9438030	R1.5	**3.0**	6	7	57
G9438040	R2.0	**4.0**	6	8	57
G9438050	R2.5	**5.0**	6	10	57
G9438060	R3.0	**6.0**	6	10	57
G9438080	R4.0	**8.0**	8	16	63
G9438100	R5.0	**10.0**	10	19	72
G9438120	R6.0	**12.0**	12	22	83
G9438140	R7.0	**14.0**	14	22	83
G9438160	R8.0	**16.0**	16	26	92
G9438180	R9.0	**18.0**	18	26	92
G9438200	R10.0	**20.0**	20	32	104

● with plain shank

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

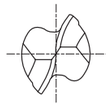
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG REACH BALL NOSE

G9454 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9454030	R1.5	**3.0**	3	5	75
G9454040	R2.0	**4.0**	4	8	75
G9454050	R2.5	**5.0**	5	9	75
G9454060	R3.0	**6.0**	6	10	100
G9454080	R4.0	**8.0**	8	12	100
G9454100	R5.0	**10.0**	10	14	100
G9454120	R6.0	**12.0**	12	16	100
G9454140	R7.0	**14.0**	14	18	100
G9454160	R8.0	**16.0**	16	22	150
G9454200	R10.0	**20.0**	20	26	150

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

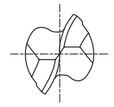
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE EXTRA LONG LENGTH BALL NOSE

G9455 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.57

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9455903	R1.5	**3.0**	3	20	60
G9455030	R1.5	**3.0**	3	30	75
G9455904	R2.0	**4.0**	4	20	60
G9455040	R2.0	**4.0**	4	30	75
G9455905	R2.5	**5.0**	5	25	75
G9455050	R2.5	**5.0**	5	40	100
G9455906	R3.0	**6.0**	6	30	75
G9455060	R3.0	**6.0**	6	50	150
G9455908	R4.0	**8.0**	8	30	75
G9455080	R4.0	**8.0**	8	50	150
G9455910	R5.0	**10.0**	10	40	100
G9455100	R5.0	**10.0**	10	60	150
G9455912	R6.0	**12.0**	12	45	100
G9455120	R6.0	**12.0**	12	75	150
G9455914	R7.0	**14.0**	14	45	100
G9455140	R7.0	**14.0**	14	75	150
G9455916	R8.0	**16.0**	16	45	100
G9455160	R8.0	**16.0**	16	75	150
G9455918	R9.0	**18.0**	18	45	100
G9455180	R9.0	**18.0**	18	75	150
G9455920	R10.0	**20.0**	20	45	100
G9455200	R10.0	**20.0**	20	75	150

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

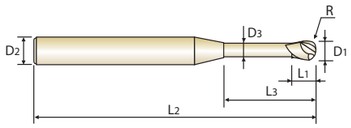
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE RIB PROCESSING

G9B81 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.58~59

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.02)	D1	D2	L1	L3	L2	D3
G9B81004	R0.2	**0.4**	4	0.7	2	50	0.37
G9B81005	R0.25	**0.5**	4	0.75	2	50	0.45
G9B81901	R0.25	**0.5**	4	0.75	4	50	0.45
G9B81902	R0.25	**0.5**	4	0.75	6	50	0.45
G9B81006	R0.3	**0.6**	4	0.9	2	50	0.55
G9B81903	R0.3	**0.6**	4	0.9	4	50	0.55
G9B81904	R0.3	**0.6**	4	0.9	6	50	0.55
G9B81008	R0.4	**0.8**	4	1.2	4	50	0.75
G9B81905	R0.4	**0.8**	4	1.2	6	50	0.75
G9B81906	R0.4	**0.8**	4	1.2	8	50	0.75
G9B81010	R0.5	**1.0**	4	1.5	6	50	0.95
G9B81907	R0.5	**1.0**	4	1.5	8	50	0.95
G9B81908	R0.5	**1.0**	4	1.5	10	50	0.95
G9B81909	R0.5	**1.0**	4	1.5	12	50	0.95
G9B81012	R0.6	**1.2**	4	1.8	8	50	1.15
G9B81910	R0.6	**1.2**	4	1.8	12	50	1.15
G9B81014	R0.7	**1.4**	4	2.1	16	50	1.35
G9B81015	R0.75	**1.5**	4	2.3	6	50	1.45
G9B81911	R0.75	**1.5**	4	2.3	8	50	1.45
G9B81912	R0.75	**1.5**	4	2.3	10	50	1.45
G9B81913	R0.75	**1.5**	4	2.3	12	50	1.45
G9B81914	R0.75	**1.5**	4	2.3	16	50	1.45

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

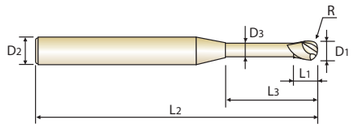
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE RIB PROCESSING

G9B81 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 2 | 30° | R ±0.02 | DIN 6535HA | P.58~59

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.02)	D1	D2	L1	L3	L2	D3
G9B81915	R0.75	**1.5**	4	2.3	20	50	1.45
G9B81016	R0.8	**1.6**	4	2.4	8	50	1.55
G9B81916	R0.8	**1.6**	4	2.4	12	50	1.55
G9B81917	R0.8	**1.6**	4	2.4	16	50	1.55
G9B81918	R0.8	**1.6**	4	2.4	20	50	1.55
G9B81020	R1.0	**2.0**	4	3	8	50	1.95
G9B81919	R1.0	**2.0**	4	3	10	50	1.95
G9B81920	R1.0	**2.0**	4	3	12	50	1.95
G9B81921	R1.0	**2.0**	4	3	14	50	1.95
G9B81922	R1.0	**2.0**	4	3	16	50	1.95
G9B81923	R1.0	**2.0**	4	3	20	50	1.95
G9B81030	R1.5	**3.0**	6	4.5	10	50	2.85
G9B81924	R1.5	**3.0**	6	4.5	12	50	2.85
G9B81925	R1.5	**3.0**	6	4.5	16	60	2.85
G9B81926	R1.5	**3.0**	6	4.5	20	60	2.85
G9B81927	R1.5	**3.0**	6	4.5	25	75	2.85
G9B81040	R2.0	**4.0**	6	6	12	50	3.85
G9B81928	R2.0	**4.0**	6	6	16	60	3.85
G9B81929	R2.0	**4.0**	6	6	20	75	3.85
G9B81930	R2.0	**4.0**	6	6	25	75	3.85
G9B81931	R2.0	**4.0**	6	6	30	75	3.85

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH BALL NOSE

G9634 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 4 flute allows for better work piece finishes.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.

CARBIDE | 4 | 30° | R ±0.02 | DIN 6535HA | P.60

Unit : mm

EDP No.	Radius of Ball Nose R (±0.02)	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9634020	R1.0	**2.0**	6	4	48
G9634030	R1.5	**3.0**	6	4	48
G9634040	R2.0	**4.0**	6	6	50
G9634050	R2.5	**5.0**	6	7	51
G9634060	R3.0	**6.0**	6	7	51
G9634080	R4.0	**8.0**	8	9	59
G9634100	R5.0	**10.0**	10	10	60
G9634120	R6.0	**12.0**	12	14	71
G9634140	R7.0	**14.0**	14	14	71
G9634160	R8.0	**16.0**	16	16	76
G9634180	R9.0	**18.0**	18	18	76
G9634200	R10.0	**20.0**	20	20	82

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH CORNER RADIUS

G9B82 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

CARBIDE | 2 | 30° | DIN 6535HA | P.61

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B82020	R0.2	**2.0**	4	4	50
G9B82901	R0.3	**2.0**	4	4	50
G9B82902	R0.5	**2.0**	4	4	50
G9B82025	R0.2	**2.5**	4	5	50
G9B82903	R0.3	**2.5**	4	5	50
G9B82904	R0.5	**2.5**	4	5	50
G9B82030	R0.2	**3.0**	4	6	50
G9B82905	R0.3	**3.0**	4	6	50
G9B82906	R0.5	**3.0**	4	6	50
G9B82907	R1.0	**3.0**	4	6	50
G9B82040	R0.2	**4.0**	4	8	50
G9B82908	R0.3	**4.0**	4	8	50
G9B82909	R0.5	**4.0**	4	8	50
G9B82910	R1.0	**4.0**	4	8	50
G9B82050	R0.2	**5.0**	6	10	50
G9B82911	R0.3	**5.0**	6	10	50
G9B82912	R0.5	**5.0**	6	10	50
G9B82913	R1.0	**5.0**	6	10	50
G9B82060	R0.2	**6.0**	6	12	50
G9B82914	R0.3	**6.0**	6	12	50
G9B82915	R0.5	**6.0**	6	12	50
G9B82916	R1.0	**6.0**	6	12	50

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH CORNER RADIUS

G9B82 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

CARBIDE | 2 | 30° | DIN 6535HA | P.61

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B82080	R0.5	**8.0**	8	16	60
G9B82917	R1.0	**8.0**	8	16	60
G9B82918	R1.5	**8.0**	8	16	60
G9B82919	R2.0	**8.0**	8	16	60
G9B82920	R2.5	**8.0**	8	16	60
G9B82100	R0.5	**10.0**	10	20	75
G9B82921	R1.0	**10.0**	10	20	75
G9B82922	R1.5	**10.0**	10	20	75
G9B82923	R2.0	**10.0**	10	20	75
G9B82924	R2.5	**10.0**	10	20	75
G9B82120	R0.5	**12.0**	12	24	75
G9B82925	R1.0	**12.0**	12	24	75
G9B82926	R1.5	**12.0**	12	24	75
G9B82927	R2.0	**12.0**	12	24	75
G9B82928	R2.5	**12.0**	12	24	75

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

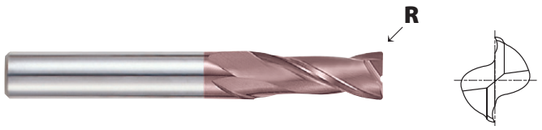
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG REACH CORNER RADIUS

G9B83 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.



CARBIDE | 2 | 30° | DIN 6535HA | P.61

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B83030	R0.5	**3.0**	4	6	75
G9B83901	R1.0	**3.0**	4	6	75
G9B83040	R0.5	**4.0**	4	8	75
G9B83902	R1.0	**4.0**	4	8	75
G9B83050	R0.5	**5.0**	6	10	75
G9B83903	R1.0	**5.0**	6	10	75
G9B83060	R0.5	**6.0**	6	12	75
G9B83904	R1.0	**6.0**	6	12	75
G9B83080	R0.5	**8.0**	8	16	100
G9B83905	R1.0	**8.0**	8	16	100
G9B83906	R1.5	**8.0**	8	16	100
G9B83907	R2.0	**8.0**	8	16	100
G9B83908	R2.5	**8.0**	8	16	100
G9B83100	R0.5	**10.0**	10	20	100
G9B83909	R1.0	**10.0**	10	20	100
G9B83910	R1.5	**10.0**	10	20	100
G9B83911	R2.0	**10.0**	10	20	100
G9B83912	R2.5	**10.0**	10	20	100
G9B83120	R0.5	**12.0**	12	24	100
G9B83913	R1.0	**12.0**	12	24	100
G9B83914	R1.5	**12.0**	12	24	100
G9B83915	R2.0	**12.0**	12	24	100
G9B83916	R2.5	**12.0**	12	24	100

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH CORNER RADIUS

G9B84 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.

CARBIDE | 4 | 30° | DIN 6535HA | P.62

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B84020	R0.2	**2.0**	4	4	50
G9B84901	R0.3	**2.0**	4	4	50
G9B84902	R0.5	**2.0**	4	4	50
G9B84025	R0.2	**2.5**	4	5	50
G9B84903	R0.3	**2.5**	4	5	50
G9B84904	R0.5	**2.5**	4	5	50
G9B84030	R0.2	**3.0**	4	6	50
G9B84905	R0.3	**3.0**	4	6	50
G9B84906	R0.5	**3.0**	4	6	50
G9B84907	R1.0	**3.0**	4	6	50
G9B84040	R0.2	**4.0**	4	8	50
G9B84908	R0.3	**4.0**	4	8	50
G9B84909	R0.5	**4.0**	4	8	50
G9B84910	R1.0	**4.0**	4	8	50
G9B84050	R0.2	**5.0**	6	10	50
G9B84911	R0.3	**5.0**	6	10	50
G9B84912	R0.5	**5.0**	6	10	50
G9B84913	R1.0	**5.0**	6	10	50
G9B84060	R0.2	**6.0**	6	12	50
G9B84914	R0.3	**6.0**	6	12	50
G9B84915	R0.5	**6.0**	6	12	50

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P										M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH CORNER RADIUS

G9B84 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Designed for milling of radius bottom slots, fillets and special contours.

CARBIDE | 4 | 30° | DIN 6535HA | P.62

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B84916	R1.0	**6.0**	6	12	50
G9B84080	R0.5	**8.0**	8	16	60
G9B84917	R1.0	**8.0**	8	16	60
G9B84918	R1.5	**8.0**	8	16	60
G9B84919	R2.0	**8.0**	8	16	60
G9B84920	R2.5	**8.0**	8	16	60
G9B84100	R0.5	**10.0**	10	20	75
G9B84921	R1.0	**10.0**	10	20	75
G9B84922	R1.5	**10.0**	10	20	75
G9B84923	R2.0	**10.0**	10	20	75
G9B84924	R2.5	**10.0**	10	20	75
G9B84120	R0.5	**12.0**	12	24	75
G9B84925	R1.0	**12.0**	12	24	75
G9B84926	R1.5	**12.0**	12	24	75
G9B84927	R2.0	**12.0**	12	24	75
G9B84928	R2.5	**12.0**	12	24	75

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P										M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

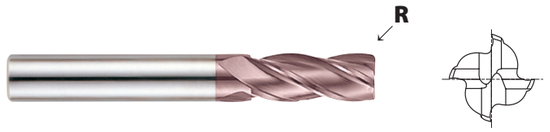
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE LONG REACH CORNER RADIUS

G9B85 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ Designed for milling of radius bottom slots, fillets and special contours.



CARBIDE | 4 | 30° | DIN 6535HA P.62

Unit : mm

EDP No.	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9B85030	R0.5	**3.0**	4	6	75
G9B85901	R1.0	**3.0**	4	6	75
G9B85040	R0.5	**4.0**	4	8	75
G9B85902	R1.0	**4.0**	4	8	75
G9B85050	R0.5	**5.0**	6	10	75
G9B85903	R1.0	**5.0**	6	10	75
G9B85060	R0.5	**6.0**	6	12	75
G9B85904	R1.0	**6.0**	6	12	75
G9B85080	R0.5	**8.0**	8	16	100
G9B85905	R1.0	**8.0**	8	16	100
G9B85906	R1.5	**8.0**	8	16	100
G9B85907	R2.0	**8.0**	8	16	100
G9B85908	R2.5	**8.0**	8	16	100
G9B85100	R0.5	**10.0**	10	20	100
G9B85909	R1.0	**10.0**	10	20	100
G9B85910	R1.5	**10.0**	10	20	100
G9B85911	R2.0	**10.0**	10	20	100
G9B85912	R2.5	**10.0**	10	20	100
G9B85120	R0.5	**12.0**	12	24	100
G9B85913	R1.0	**12.0**	12	24	100
G9B85914	R1.5	**12.0**	12	24	100
G9B85915	R2.0	**12.0**	12	24	100
G9B85916	R2.5	**12.0**	12	24	100

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○											○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH

G9424 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

CARBIDE | 2 | 30° | DIN 6535HA P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9424010	**1.0**	4	3	40
G9424015	**1.5**	4	4.5	40
G9424020	**2.0**	2	8	32
G9424025	**2.5**	2.5	8	32
G9424030	**3.0**	3	12	32
G9424035	**3.5**	3.5	12	32
G9424040	**4.0**	4	12	40
G9424045	**4.5**	4.5	14	50
G9424050	**5.0**	5	14	50
G9424055	**5.5**	5.5	16	50
G9424060	**6.0**	6	16	50
G9424070	**7.0**	7	20	60
G9424080	**8.0**	8	20	60
G9424090	**9.0**	9	20	60
G9424100	**10.0**	10	22	70
G9424120	**12.0**	12	22	70
G9424140	**14.0**	14	25	75
G9424160	**16.0**	16	25	75
G9424200	**20.0**	20	32	100

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH WITH CHAMFER

G9G44 PLAIN SHANK

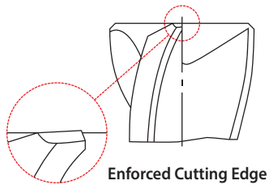
- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

CARBIDE | 2 | 30° | DIN 6535HA | C x 45° | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G44030	**3.0**	3	12	32	0.10
G9G44040	**4.0**	4	12	40	0.10
G9G44050	**5.0**	5	14	50	0.10
G9G44060	**6.0**	6	16	50	0.10
G9G44080	**8.0**	8	20	60	0.13
G9G44100	**10.0**	10	22	70	0.13
G9G44120	**12.0**	12	22	70	0.18
G9G44140	**14.0**	14	25	75	0.18
G9G44160	**16.0**	16	25	75	0.18
G9G44200	**20.0**	20	32	100	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

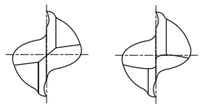
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH

G9A68 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.



CARBIDE | 2 | 30° | DIN 6535HA | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9A68010	**1.0**	3	3	39
G9A68015	**1.5**	3	5	39
G9A68020	**2.0**	3	7	39
G9A68025	**2.5**	3	7	39
G9A68030	**3.0**	3	9	39
G9A68040	**4.0**	4	14	51
G9A68050	**5.0**	5	16	51
G9A68060	**6.0**	6	19	64
G9A68080	**8.0**	8	21	64
G9A68100	**10.0**	10	22	70
G9A68120	**12.0**	12	25	76
G9A68160	**16.0**	16	32	89
G9A68200	**20.0**	20	38	102

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

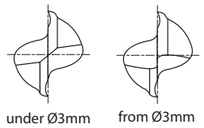
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE SHORT LENGTH

G9444 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE | DIN 6527 | 2 | ≈30° | DIN 6535HB | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9444020	**2.0**	6	3	50
G9444030	**3.0**	6	4	50
G9444035	**3.5**	6	4	50
G9444040	**4.0**	6	5	54
G9444045	**4.5**	6	5	54
G9444050	**5.0**	6	6	54
G9444060	**6.0**	6	7	54
G9444070	**7.0**	8	8	58
G9444080	**8.0**	8	9	58
G9444090	**9.0**	10	10	66
G9444100	**10.0**	10	11	66
G9444120	**12.0**	12	12	73
G9444140	**14.0**	14	14	75
G9444160	**16.0**	16	16	82
G9444180	**18.0**	18	18	84
G9444200	**20.0**	20	20	92

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P																			M			K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20										
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230										
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○										

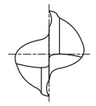
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH

G9527 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE | DIN 6528 | 2 | ≈30° | DIN 6535HA | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9527035	**3.5**	3.5	7	50
G9527040	**4.0**	4	8	50
G9527045	**4.5**	4.5	8	50
G9527050	**5.0**	5	10	50
G9527055	**5.5**	5.5	10	57
G9527060	**6.0**	6	10	57
G9527065	**6.5**	6.5	13	60
G9527070	**7.0**	7	13	60
G9527075	**7.5**	7.5	16	63
G9527080	**8.0**	8	16	63
G9527085	**8.5**	8.5	16	67
G9527090	**9.0**	9	16	67
G9527095	**9.5**	9.5	19	72
G9527100	**10.0**	10	19	72
G9527110	**11.0**	11	22	83
G9527120	**12.0**	12	22	83
G9527130	**13.0**	13	22	83
G9527140	**14.0**	14	22	83
G9527150	**15.0**	15	26	92
G9527160	**16.0**	16	26	92
G9527180	**18.0**	18	26	92
G9527200	**20.0**	20	32	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P																			M			K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20										
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230										
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○										

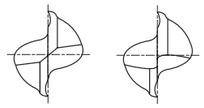
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH

G9445 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE | DIN 6527 | 2 | ≈30° | DIN 6535HA | DIN 6535HB | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9445901	2.0	● 3	6	38
G9445028	2.8	6	7	57
G9445030	3.0	6	7	57
G9445035	3.5	6	7	57
G9445038	3.8	6	8	57
G9445040	4.0	6	8	57
G9445045	4.5	6	8	57
G9445048	4.8	6	10	57
G9445050	5.0	6	10	57
G9445957	5.8	6	10	57
G9445060	6.0	6	10	57
G9445967	6.8	8	13	63
G9445070	7.0	8	13	63
G9445977	7.8	8	16	63
G9445080	8.0	8	16	63
G9445087	8.7	10	16	72
G9445090	9.0	10	16	72
G9445097	9.7	10	19	72
G9445100	10.0	10	19	72
G9445117	11.7	12	22	83
G9445120	12.0	12	22	83

● with plain shank

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

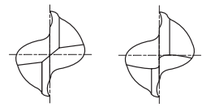
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH

G9445 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE | DIN 6527 | 2 | ≈30° | DIN 6535HA | DIN 6535HB | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9445137	13.7	14	22	83
G9445140	14.0	14	22	83
G9445157	15.7	16	26	92
G9445160	16.0	16	26	92
G9445177	17.7	18	26	92
G9445180	18.0	18	26	92
G9445197	19.7	20	32	104
G9445200	20.0	20	32	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

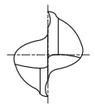
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH WITH CHAMFER

G9G45 FLAT SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

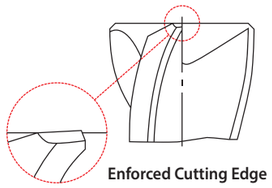


CARBIDE | DIN 6527 | 2 | ≈30° | DIN 6535HB | C x 45° | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G45030	**3.0**	6	7	57	0.10
G9G45040	**4.0**	6	8	57	0.10
G9G45050	**5.0**	6	10	57	0.10
G9G45060	**6.0**	6	10	57	0.10
G9G45080	**8.0**	8	16	63	0.13
G9G45100	**10.0**	10	19	72	0.13
G9G45120	**12.0**	12	22	83	0.18
G9G45140	**14.0**	14	22	83	0.18
G9G45160	**16.0**	16	26	92	0.18
G9G45200	**20.0**	20	32	104	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

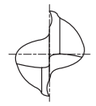
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE EXTRA LONG LENGTH

G9452 PLAIN SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.



CARBIDE | 2 | 30° | DIN 6535HA | P.63

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9452903	**3.0**	3	20	60
G9452030	**3.0**	3	30	75
G9452904	**4.0**	4	20	60
G9452040	**4.0**	4	30	75
G9452905	**5.0**	5	25	75
G9452050	**5.0**	5	40	100
G9452906	**6.0**	6	30	75
G9452060	**6.0**	6	50	150
G9452908	**8.0**	8	30	75
G9452080	**8.0**	8	50	150
G9452910	**10.0**	10	40	100
G9452100	**10.0**	10	60	150
G9452912	**12.0**	12	45	100
G9452120	**12.0**	12	75	150
G9452914	**14.0**	14	45	100
G9452140	**14.0**	14	65	150
G9452916	**16.0**	16	45	100
G9452160	**16.0**	16	65	150
G9452918	**18.0**	18	45	100
G9452180	**18.0**	18	65	150
G9452920	**20.0**	20	45	100
G9452200	**20.0**	20	65	150

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

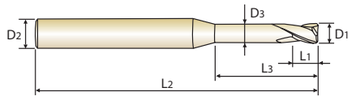
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE RIB PROCESSING

G9B80 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE 2 30° DIN 6535HA P.64~65

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	D1	D2	L1	L3	L2	D3
G9B80004	**0.4**	4	0.7	2	50	0.37
G9B80901	**0.4**	4	0.7	4	50	0.37
G9B80005	**0.5**	4	0.75	2	50	0.45
G9B80902	**0.5**	4	0.75	4	50	0.45
G9B80903	**0.5**	4	0.75	6	50	0.45
G9B80006	**0.6**	4	0.9	2	50	0.55
G9B80904	**0.6**	4	0.9	4	50	0.55
G9B80905	**0.6**	4	0.9	6	50	0.55
G9B80007	**0.7**	4	1.1	4	50	0.65
G9B80906	**0.7**	4	1.1	6	50	0.65
G9B80008	**0.8**	4	1.2	4	50	0.75
G9B80907	**0.8**	4	1.2	6	50	0.75
G9B80908	**0.8**	4	1.2	8	50	0.75
G9B80009	**0.9**	4	1.4	6	50	0.85
G9B80909	**0.9**	4	1.4	8	50	0.85
G9B80910	**0.9**	4	1.4	10	50	0.85
G9B80010	**1.0**	4	1.5	6	50	0.95
G9B80911	**1.0**	4	1.5	8	50	0.95
G9B80912	**1.0**	4	1.5	10	50	0.95
G9B80913	**1.0**	4	1.5	12	50	0.95
G9B80012	**1.2**	4	1.8	6	50	1.15
G9B80914	**1.2**	4	1.8	8	50	1.15
G9B80915	**1.2**	4	1.8	10	50	1.15
G9B80916	**1.2**	4	1.8	12	50	1.15

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

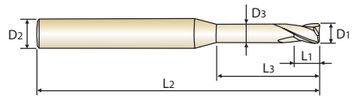
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE RIB PROCESSING

G9B80 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE 2 30° DIN 6535HA P.64~65

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	D1	D2	L1	L3	L2	D3
G9B80015	**1.5**	4	2.3	6	50	1.45
G9B80917	**1.5**	4	2.3	8	50	1.45
G9B80918	**1.5**	4	2.3	10	50	1.45
G9B80919	**1.5**	4	2.3	12	50	1.45
G9B80920	**1.5**	4	2.3	14	50	1.45
G9B80921	**1.5**	4	2.3	16	50	1.45
G9B80922	**1.5**	4	2.3	18	50	1.45
G9B80923	**1.5**	4	2.3	20	50	1.45
G9B80020	**2.0**	4	3	6	50	1.95
G9B80924	**2.0**	4	3	8	50	1.95
G9B80925	**2.0**	4	3	10	50	1.95
G9B80926	**2.0**	4	3	12	50	1.95
G9B80927	**2.0**	4	3	14	50	1.95
G9B80928	**2.0**	4	3	16	50	1.95
G9B80929	**2.0**	4	3	18	50	1.95
G9B80930	**2.0**	4	3	20	50	1.95
G9B80025	**2.5**	4	3.7	8	50	2.40
G9B80931	**2.5**	4	3.7	12	50	2.40
G9B80932	**2.5**	4	3.7	16	50	2.40
G9B80933	**2.5**	4	3.7	20	50	2.40
G9B80030	**3.0**	6	4.5	8	50	2.85
G9B80934	**3.0**	6	4.5	12	50	2.85
G9B80935	**3.0**	6	4.5	16	60	2.85
G9B80936	**3.0**	6	4.5	20	60	2.85

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

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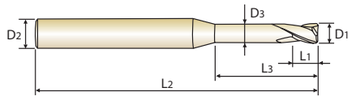
TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE RIB PROCESSING

G9B80 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 2 flute design for slotting.



CARBIDE | 2 | 30° | DIN 6535HA | P.64~65

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	D1	D2	L1	L3	L2	D3
G9B80937	**3.0**	6	4.5	25	75	2.85
G9B80040	**4.0**	6	6	12	50	3.85
G9B80938	**4.0**	6	6	16	60	3.85
G9B80939	**4.0**	6	6	20	75	3.85
G9B80940	**4.0**	6	6	25	75	3.85
G9B80941	**4.0**	6	6	30	75	3.85
G9B80942	**4.0**	6	6	35	75	3.85

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

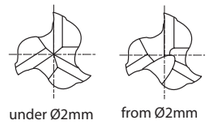
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○													

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH THROW AWAY

G9553 PLAIN SHANK
G9410 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.



CARBIDE | 3 | 30° | PLAIN | FLAT | P.66~67

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
G9553005	-	**0.5**	3	1.5	38
G9553006	-	**0.6**	3	1.5	38
G9553008	-	**0.8**	3	2	38
G9553010	-	**1.0**	3	2	38
G9553012	-	**1.2**	3	2	38
G9553015	-	**1.5**	3	2	38
G9553018	-	**1.8**	3	2	38
-	**G9410020**	**2.0**	6	4	35
-	**G9410025**	**2.5**	6	5	36
-	**G9410030**	**3.0**	6	5	36
-	**G9410035**	**3.5**	6	6	37
-	**G9410040**	**4.0**	6	7	38
-	**G9410045**	**4.5**	6	8	38
-	**G9410050**	**5.0**	6	8	39
-	**G9410055**	**5.5**	6	8	39
-	**G9410957**	**5.8**	6	8	39
-	**G9410060**	**6.0**	6	8	39
-	**G9410967**	**6.8**	8	10	42
-	**G9410070**	**7.0**	8	10	42
-	**G9410977**	**7.8**	8	10	42
-	**G9410080**	**8.0**	8	11	43
-	**G9410087**	**8.7**	10	11	48
-	**G9410090**	**9.0**	10	11	48
-	**G9410097**	**9.7**	10	11	48

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

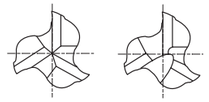
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH THROW AWAY

G9553 PLAIN SHANK
G9410 FLAT SHANK

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.



CARBIDE | 3 | 30° | PLAIN | FLAT | P.66~67

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
-	**G9410100**	**10.0**	10	13	50
-	**G9410120**	**12.0**	12	15	55
-	**G9410140**	**14.0**	14	15	58
-	**G9410160**	**16.0**	16	18	62
-	**G9410180**	**18.0**	18	20	70
-	**G9410200**	**20.0**	20	22	75

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH THROW AWAY WITH CHAMFER

G9G46 FLAT SHANK

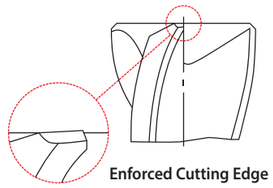
- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.

CARBIDE | 3 | 30° | FLAT | C x 45° | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G46030	**3.0**	6	5	36	0.10
G9G46040	**4.0**	6	7	38	0.10
G9G46050	**5.0**	6	8	39	0.10
G9G46060	**6.0**	6	8	39	0.10
G9G46080	**8.0**	8	11	43	0.13
G9G46100	**10.0**	10	13	50	0.13
G9G46120	**12.0**	12	15	55	0.18
G9G46140	**14.0**	14	15	58	0.18
G9G46160	**16.0**	16	18	62	0.18
G9G46200	**20.0**	20	22	75	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

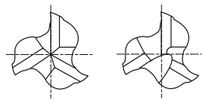
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH

G9425 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.



CARBIDE | 3 | 30° | DIN 6535HA | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9425010	**1.0**	4	3	40
G9425015	**1.5**	4	4.5	40
G9425020	**2.0**	2	8	32
G9425025	**2.5**	2.5	8	32
G9425030	**3.0**	3	12	32
G9425035	**3.5**	3.5	12	32
G9425040	**4.0**	4	12	40
G9425045	**4.5**	4.5	14	50
G9425050	**5.0**	5	14	50
G9425055	**5.5**	5.5	16	50
G9425060	**6.0**	6	16	50
G9425070	**7.0**	7	20	60
G9425080	**8.0**	8	20	60
G9425090	**9.0**	9	20	60
G9425100	**10.0**	10	22	70
G9425120	**12.0**	12	22	70
G9425140	**14.0**	14	25	75
G9425160	**16.0**	16	25	75
G9425200	**20.0**	20	32	100

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH WITH CHAMFER

G9G47 PLAIN SHANK

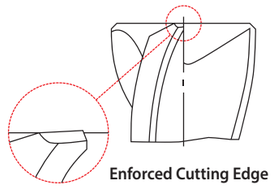
▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.

CARBIDE | 3 | 30° | DIN 6535HA | C x 45° | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G47030	**3.0**	3	12	32	0.10
G9G47040	**4.0**	4	12	40	0.10
G9G47050	**5.0**	5	14	50	0.10
G9G47060	**6.0**	6	16	50	0.10
G9G47080	**8.0**	8	20	60	0.13
G9G47100	**10.0**	10	22	70	0.13
G9G47120	**12.0**	12	22	70	0.18
G9G47140	**14.0**	14	25	75	0.18
G9G47160	**16.0**	16	25	75	0.18
G9G47200	**20.0**	20	32	100	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

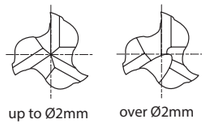
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE SHORT LENGTH

G9439 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.



CARBIDE | DIN 6527 | 3 | ≈30° | DIN 6535HB | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9439020	2.0	6	3	50
G9439030	3.0	6	4	50
G9439035	3.5	6	4	50
G9439040	4.0	6	5	54
G9439045	4.5	6	5	54
G9439050	5.0	6	6	54
G9439060	6.0	6	7	54
G9439070	7.0	8	8	58
G9439080	8.0	8	9	58
G9439090	9.0	10	10	66
G9439100	10.0	10	11	66
G9439120	12.0	12	12	73
G9439140	14.0	14	14	75
G9439160	16.0	16	16	82
G9439180	18.0	18	18	84
G9439200	20.0	20	20	92

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P																			M			K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20										
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230										
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○										

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE LONG LENGTH

G9528 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.

CARBIDE | DIN 6528 | 3 | ≈30° | DIN 6535HA | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9528035	3.5	3.5	7	50
G9528040	4.0	4	8	50
G9528045	4.5	4.5	8	50
G9528050	5.0	5	10	50
G9528055	5.5	5.5	10	57
G9528060	6.0	6	10	57
G9528065	6.5	6.5	13	60
G9528070	7.0	7	13	60
G9528075	7.5	7.5	16	63
G9528080	8.0	8	16	63
G9528085	8.5	8.5	16	67
G9528090	9.0	9	16	67
G9528095	9.5	9.5	19	72
G9528100	10.0	10	19	72
G9528110	11.0	11	22	83
G9528120	12.0	12	22	83
G9528130	13.0	13	22	83
G9528140	14.0	14	22	83
G9528150	15.0	15	26	92
G9528160	16.0	16	26	92
G9528180	18.0	18	26	92
G9528200	20.0	20	32	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P																			M			K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron			Malleable cast iron										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20										
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230										
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○										

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE LONG LENGTH

G9433 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.

CARBIDE | DIN 6527 | 3 | ≈30° | DIN 6535HB | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9433030	**3.0**	6	7	57
G9433040	**4.0**	6	8	57
G9433050	**5.0**	6	10	57
G9433060	**6.0**	6	10	57
G9433080	**8.0**	8	16	63
G9433090	**9.0**	10	16	72
G9433100	**10.0**	10	19	72
G9433120	**12.0**	12	22	83
G9433140	**14.0**	14	22	83
G9433160	**16.0**	16	26	92
G9433180	**18.0**	18	26	92
G9433200	**20.0**	20	32	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE LONG LENGTH WITH CHAMFER

G9G48 FLAT SHANK

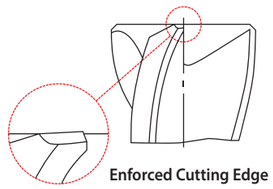
▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ 3 flute design combines the advantage of 2 flute and 4 flute end mill.

CARBIDE | DIN 6527 | 3 | ≈30° | DIN 6535HB | C x 45° | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G48030	**3.0**	6	7	57	0.10
G9G48040	**4.0**	6	8	57	0.10
G9G48050	**5.0**	6	10	57	0.10
G9G48060	**6.0**	6	10	57	0.10
G9G48080	**8.0**	8	16	63	0.13
G9G48100	**10.0**	10	19	72	0.13
G9G48120	**12.0**	12	22	83	0.18
G9G48140	**14.0**	14	22	83	0.18
G9G48160	**16.0**	16	26	92	0.18
G9G48200	**20.0**	20	32	104	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE 45° HELIX LONG LENGTH

G9447 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.

CARBIDE | DIN 6527 | 3 | 45° | DIN 6535HB | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9447030	**3.0**	6	7	57
G9447035	**3.5**	6	7	57
G9447040	**4.0**	6	8	57
G9447045	**4.5**	6	8	57
G9447050	**5.0**	6	10	57
G9447060	**6.0**	6	10	57
G9447070	**7.0**	8	13	63
G9447080	**8.0**	8	16	63
G9447090	**9.0**	10	16	72
G9447100	**10.0**	10	19	72
G9447120	**12.0**	12	22	83
G9447140	**14.0**	14	22	83
G9447160	**16.0**	16	26	92
G9447180	**18.0**	18	26	92
G9447200	**20.0**	20	32	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

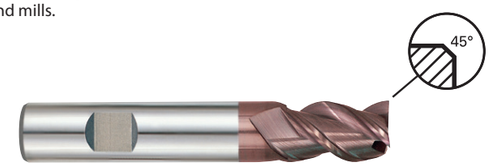
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

3 FLUTE 45° HELIX LONG LENGTH WITH CHAMFER

G9G49 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.

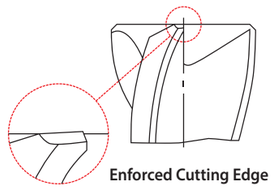


CARBIDE | DIN 6527 | 3 | 45° | DIN 6535HB | C x 45° | P.66~67

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G49030	**3.0**	6	7	57	0.10
G9G49040	**4.0**	6	8	57	0.10
G9G49050	**5.0**	6	10	57	0.10
G9G49060	**6.0**	6	10	57	0.10
G9G49080	**8.0**	8	16	63	0.13
G9G49100	**10.0**	10	19	72	0.13
G9G49120	**12.0**	12	22	83	0.18
G9G49140	**14.0**	14	22	83	0.18
G9G49160	**16.0**	16	26	92	0.18
G9G49200	**20.0**	20	32	104	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH

G9432 PLAIN SHANK

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

CARBIDE | 4 | 30° | DIN 6535HA | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9432010	1.0	4	3	40
G9432015	1.5	4	4.5	40
G9432020	2.0	2	8	32
G9432025	2.5	2.5	8	32
G9432030	3.0	3	12	32
G9432035	3.5	3.5	12	32
G9432040	4.0	4	12	40
G9432045	4.5	4.5	14	50
G9432050	5.0	5	14	50
G9432055	5.5	5.5	16	50
G9432060	6.0	6	16	50
G9432070	7.0	7	20	60
G9432080	8.0	8	20	60
G9432090	9.0	9	20	60
G9432100	10.0	10	22	70
G9432120	12.0	12	22	70
G9432140	14.0	14	25	75
G9432160	16.0	16	25	75
G9432200	20.0	20	32	100

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

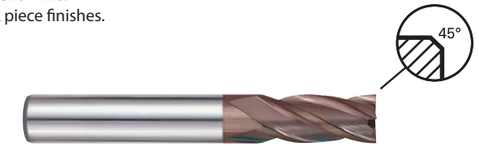
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH WITH CHAMFER

G9G50 PLAIN SHANK

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

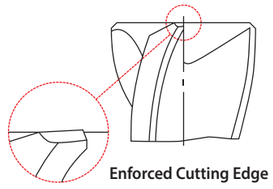


CARBIDE | 4 | 30° | DIN 6535HA | C x 45° | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G50030	3.0	3	12	32	0.10
G9G50040	4.0	4	12	40	0.10
G9G50050	5.0	5	14	50	0.10
G9G50060	6.0	6	16	50	0.10
G9G50080	8.0	8	20	60	0.13
G9G50100	10.0	10	22	70	0.13
G9G50120	12.0	12	22	70	0.18
G9G50140	14.0	14	25	75	0.18
G9G50160	16.0	16	25	75	0.18
G9G50200	20.0	20	32	100	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH

G9A69 PLAIN SHANK

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

CARBIDE | 4 | 30° | DIN 6535HA | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9A69010	**1.0**	3	3	39
G9A69015	**1.5**	3	5	39
G9A69020	**2.0**	3	7	39
G9A69025	**2.5**	3	7	39
G9A69030	**3.0**	3	10	39
G9A69040	**4.0**	4	14	51
G9A69050	**5.0**	5	16	51
G9A69060	**6.0**	6	19	64
G9A69080	**8.0**	8	21	64
G9A69100	**10.0**	10	22	70
G9A69120	**12.0**	12	25	76
G9A69160	**16.0**	16	32	89
G9A69200	**20.0**	20	38	102

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE SHORT LENGTH

G9448 FLAT SHANK

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

CARBIDE | DIN 6527 | 4 | ≈30° | DIN 6535HB | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9448020	**2.0**	6	4	50
G9448025	**2.5**	6	4	50
G9448030	**3.0**	6	5	50
G9448035	**3.5**	6	6	50
G9448040	**4.0**	6	8	54
G9448045	**4.5**	6	8	54
G9448050	**5.0**	6	9	54
G9448060	**6.0**	6	10	54
G9448070	**7.0**	8	11	58
G9448080	**8.0**	8	12	58
G9448090	**9.0**	10	13	66
G9448100	**10.0**	10	14	66
G9448120	**12.0**	12	16	73
G9448140	**14.0**	14	18	75
G9448160	**16.0**	16	22	82
G9448180	**18.0**	18	24	84
G9448200	**20.0**	20	26	92

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE LONG LENGTH

G9540 PLAIN SHANK

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

CARBIDE | DIN 6528 | 4 | ≈30° | DIN 6535HA | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9540035	**3.5**	3.5	10	50
G9540040	**4.0**	4	11	50
G9540045	**4.5**	4.5	11	50
G9540050	**5.0**	5	13	50
G9540055	**5.5**	5.5	13	57
G9540060	**6.0**	6	13	57
G9540065	**6.5**	6.5	16	60
G9540070	**7.0**	7	16	60
G9540075	**7.5**	7.5	19	63
G9540080	**8.0**	8	19	63
G9540085	**8.5**	8.5	19	67
G9540090	**9.0**	9	19	67
G9540095	**9.5**	9.5	22	72
G9540100	**10.0**	10	22	72
G9540110	**11.0**	11	26	83
G9540120	**12.0**	12	26	83
G9540130	**13.0**	13	26	83
G9540140	**14.0**	14	26	83
G9540150	**15.0**	15	32	92
G9540160	**16.0**	16	32	92
G9540180	**18.0**	18	32	92
G9540200	**20.0**	20	38	104

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE LONG LENGTH

G9449 FLAT SHANK

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

CARBIDE | DIN 6527 | 4 | ≈30° | DIN 6535HB | DIN 6535HA | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9449901	**2.0**	● 3	7	38
G9449030	**3.0**	6	8	57
G9449035	**3.5**	6	10	57
G9449040	**4.0**	6	11	57
G9449045	**4.5**	6	11	57
G9449050	**5.0**	6	13	57
G9449060	**6.0**	6	13	57
G9449070	**7.0**	8	16	63
G9449080	**8.0**	8	19	63
G9449090	**9.0**	10	19	72
G9449100	**10.0**	10	22	72
G9449120	**12.0**	12	26	83
G9449140	**14.0**	14	26	83
G9449160	**16.0**	16	32	92
G9449180	**18.0**	18	32	92
G9449200	**20.0**	20	38	104

● with plain shank

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

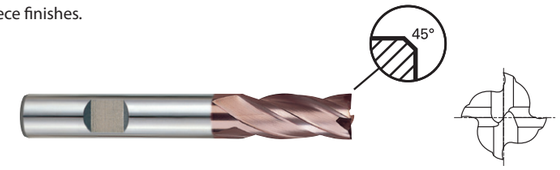
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE LONG LENGTH WITH CHAMFER

G9G51 FLAT SHANK

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

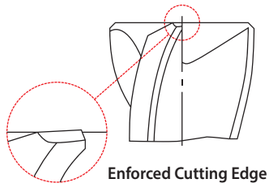


CARBIDE | DIN 6527 | 4 | ≈30° | DIN 6535HB | C x 45° | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
G9G51030	**3.0**	6	8	57	0.10
G9G51040	**4.0**	6	11	57	0.10
G9G51050	**5.0**	6	13	57	0.10
G9G51060	**6.0**	6	13	57	0.10
G9G51080	**8.0**	8	19	63	0.13
G9G51100	**10.0**	10	22	72	0.13
G9G51120	**12.0**	12	26	83	0.18
G9G51140	**14.0**	14	26	83	0.18
G9G51160	**16.0**	16	32	92	0.18
G9G51200	**20.0**	20	38	104	0.23

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4 FLUTE EXTRA LONG LENGTH

G9453 PLAIN SHANK

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

CARBIDE | 4 | 30° | DIN 6535HA | P.68

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9453903	**3.0**	3	20	60
G9453030	**3.0**	3	30	75
G9453904	**4.0**	4	20	60
G9453040	**4.0**	4	30	75
G9453905	**5.0**	5	25	75
G9453050	**5.0**	5	40	100
G9453906	**6.0**	6	30	75
G9453060	**6.0**	6	50	150
G9453908	**8.0**	8	30	75
G9453080	**8.0**	8	50	150
G9453910	**10.0**	10	40	100
G9453100	**10.0**	10	60	150
G9453912	**12.0**	12	45	100
G9453120	**12.0**	12	75	150
G9453914	**14.0**	14	45	100
G9453140	**14.0**	14	65	150
G9453916	**16.0**	16	45	100
G9453160	**16.0**	16	65	150
G9453918	**18.0**	18	45	100
G9453180	**18.0**	18	65	150
G9453920	**20.0**	20	45	100
G9453200	**20.0**	20	65	150

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

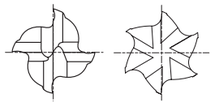
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

4&6 FLUTE 45° HELIX SHORT / LONG LENGTH

G9F45 PLAIN SHANK
G9F46 PLAIN SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.



CARBIDE | 4&6 | 45° | DIN 6535HA P.69

SHORT

Unit : mm

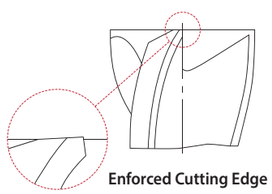
EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
G9F45030	**3.0**	4	6	50	4
G9F45040	**4.0**	4	11	50	4
G9F45050	**5.0**	6	13	50	6
G9F45060	**6.0**	6	16	50	6
G9F45080	**8.0**	8	19	60	6
G9F45100	**10.0**	10	22	75	6
G9F45120	**12.0**	12	26	75	6
G9F45140	**14.0**	14	30	90	6
G9F45160	**16.0**	16	32	100	6
G9F45180	**18.0**	18	38	100	6
G9F45000	**20.0**	20	38	100	6

LONG

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
G9F46120	**12.0**	12	50	100	6
G9F46160	**16.0**	16	65	150	6
G9F46200	**20.0**	20	75	150	6

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																		○	○	○	○

X-COATED SOLID CARBIDE END MILLS

MULTI FLUTE LONG LENGTH ROUGHING - COARSE

G9A42 FLAT SHANK

▶ Suitable for dry milling applications at high temperatures.
▶ Excellent high-performance end mills.
▶ Fast chip ejection.

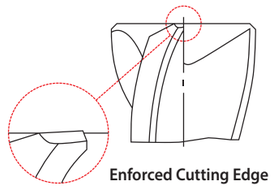
CARBIDE | COARSE | 3-5 | 30° | DIN 6535HB | C x 45° P.70

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute	Chamfer
	h10	h5				
G9A42060	**6.0**	6	16	57	3	0.60
G9A42080	**8.0**	8	16	63	3	0.60
G9A42100	**10.0**	10	22	72	4	0.60
G9A42120	**12.0**	12	26	83	4	0.74
G9A42140	**14.0**	14	26	83	4	0.94
G9A42160	**16.0**	16	32	92	4	0.94
G9A42180	**18.0**	18	32	92	4	0.94
G9A42200	**20.0**	20	38	104	4	0.94
G9A42250	**25.0**	25	45	121	5	0.94

Tolerances according to DIN 7160 & 7161

	Tolerance range in ㎛				
	Nominal-Diameter in ㎜				
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h5	0 - 4	0 - 5	0 - 6	0 - 8	0 - 9



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○			○	

TiAlN-COATED SOLID CARBIDE END MILLS

2 FLUTE DRILL MILLS

G9400 PLAIN SHANK

CARBIDE | YG STD | 2 | 30° | DIN 6535HA

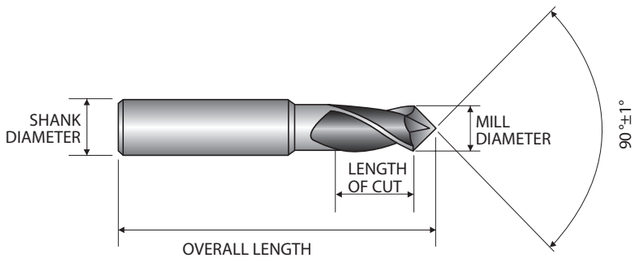
P.71~73

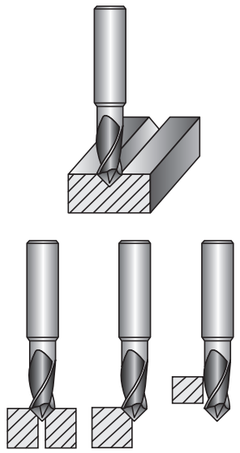
Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
G9400030	**3.0**	4	6	50
G9400040	**4.0**	5	8	50
G9400050	**5.0**	6	10	50
G9400060	**6.0**	8	12	60
G9400080	**8.0**	10	16	70
G9400100	**10.0**	12	18	70
G9400120	**12.0**	12	20	70
G9400140	**14.0**	14	24	80
G9400160	**16.0**	16	26	80
G9400200	**20.0**	20	32	100

▶ TiN, TiCN and TiAlN Coatings are available on your request.

- Performs many drilling and milling operations that are not presently done with the standard end mill.
- Among the many vertical milling machine operations, applications for the Drill Mill are: Drilling, Slotting, NC Milling, Drilling & Slotting, Profile Milling and Chamfering.





Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
Ø3 ~ Ø10=h9 Ø12 ~ Ø20=d9	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○	○	○																

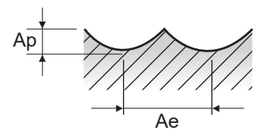
G9624, G9A70, G9437, G9438, G9454, G9455 SERIES

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

2 FLUTE BALL NOSE

ISO	VDI 3323	Material Description	Ae	Parameter	Mill Diameter (Ø) 2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	1-4	Non-alloy steel	0.2D	Vc	80	105	110	125	135	155	170	190	200	205	215	225
				fz	0.026	0.025	0.035	0.045	0.06	0.089	0.122	0.15	0.165	0.18	0.188	0.201
				RPM	12732	11141	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	662	557	613	716	859	1098	1320	1512	1501	1468	1430	1440
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	5		0.2D	Vc	55	80	90	95	110	125	135	150	160	160	170	175
				fz	0.023	0.023	0.031	0.04	0.06	0.08	0.1	0.12	0.128	0.141	0.148	0.158
				RPM	8754	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	403	390	444	484	700	796	859	955	931	898	890	880
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	6-7	Low alloy steel	0.2D	Vc	80	105	110	125	135	155	170	190	200	205	215	225
				fz	0.026	0.025	0.035	0.045	0.06	0.089	0.122	0.15	0.165	0.18	0.188	0.201
				RPM	12732	11141	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	662	557	613	716	859	1098	1320	1512	1501	1468	1430	1440
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	8-9		0.2D	Vc	55	80	90	95	110	125	135	150	160	160	170	175
				fz	0.023	0.023	0.031	0.04	0.06	0.08	0.1	0.12	0.128	0.141	0.148	0.158
				RPM	8754	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	403	390	444	484	700	796	859	955	931	898	890	880
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	10	High alloyed steel, and tool steel	0.2D	Vc	80	105	110	125	135	155	170	190	200	205	215	225
				fz	0.026	0.025	0.035	0.045	0.06	0.089	0.122	0.15	0.165	0.18	0.188	0.201
				RPM	12732	11141	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	662	557	613	716	859	1098	1320	1512	1501	1468	1430	1440
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	11.1 - 11.2		0.2D	Vc	55	80	90	95	110	125	135	150	160	160	170	175
				fz	0.023	0.023	0.031	0.04	0.06	0.08	0.1	0.12	0.128	0.141	0.148	0.158
				RPM	8754	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	403	390	444	484	700	796	859	955	931	898	890	880
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.7D	Vc	65	65	65	65	65	65	65	65	60	65	60	65
				fz	0.01	0.016	0.028	0.04	0.053	0.092	0.112	0.131	0.164	0.177	0.209	0.2
				RPM	10345	6897	5173	4138	3448	2586	2069	1724	1364	1293	1061	1035
				FEED	207	221	290	331	366	476	463	452	447	458	444	414
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
N	21~22	Aluminum-wrought alloy	0.7D	Vc	195	195	195	190	195	200	195	195	190	195	190	185
				fz	0.006	0.01	0.013	0.019	0.023	0.034	0.044	0.061	0.073	0.07	0.079	0.092
				RPM	31035	20690	15518	12096	10345	7958	6207	5173	4320	3879	3360	2944
				FEED	372	414	403	460	476	541	546	631	631	543	531	542
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	23~25	Aluminum-cast, alloyed	0.7D	Vc	195	195	195	190	195	200	195	195	190	195	190	185
				fz	0.006	0.01	0.013	0.019	0.023	0.034	0.044	0.061	0.073	0.07	0.079	0.092
				RPM	31035	20690	15518	12096	10345	7958	6207	5173	4320	3879	3360	2944
				FEED	372	414	403	460	476	541	546	631	631	543	531	542
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
H	38.1	Hardened steel	0.2D	Vc	25	35	45	50	50	50	55	55	55	60	60	60
				fz	0.016	0.016	0.021	0.024	0.03	0.046	0.054	0.07	0.081	0.091	0.1	0.111
				RPM	3979	3714	3581	3183	2653	1989	1751	1459	1251	1194	1061	955
				FEED	127	119	150	153	159	183	189	204	203	217	212	212
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	40	Chilled Cast Iron	0.2D	Vc	55	80	90	95	110	125	135	150	160	160	170	175
				fz	0.023	0.023	0.031	0.04	0.06	0.08	0.1	0.12	0.128	0.141	0.148	0.158
				RPM	8754	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	403	390	444	484	700	796	859	955	931	898	890	880
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3

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



G9B81 SERIES

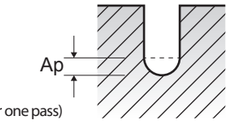
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.
Ap = mm

2 FLUTE BALL NOSE

ISO	VDI 3323	Material Description	Parameter	Mill Diameter (Ø) 0.4	0.5	0.6	0.8	1.0
P	1-4	Non-alloy steel	Vc	33~43	41~53	50~64	66~85	77~97
			fz	0.003~0.006	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010
			RPM	26350~34000	26350~34000	26350~34000	26350~34000	24650~31000
			FEED	150~415	150~415	190~535	190~535	210~595
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090
	5		Vc	24~30	30~38	36~46	48~61	55~69
			fz	0.002~0.005	0.002~0.005	0.002~0.006	0.002~0.006	0.003~0.007
			RPM	19100~24200	19100~24200	19100~24200	19100~24200	17400~22100
			FEED	75~230	75~230	95~300	95~300	105~330
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090
	6-7	Low alloy steel	Vc	33~43	41~53	50~64	66~85	77~97
			fz	0.003~0.006	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010
			RPM	26350~34000	26350~34000	26350~34000	26350~34000	24650~31000
			FEED	150~415	150~415	190~535	190~535	210~595
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090
	8-9		Vc	24~30	30~38	36~46	48~61	55~69
			fz	0.002~0.005	0.002~0.005	0.002~0.006	0.002~0.006	0.003~0.007
			RPM	19100~24200	19100~24200	19100~24200	19100~24200	17400~22100
			FEED	75~230	75~230	95~300	95~300	105~330
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090
	10	High alloyed steel, and tool steel	Vc	33~43	41~53	50~64	66~85	77~97
			fz	0.003~0.006	0.003~0.006	0.004~0.008	0.004~0.008	0.004~0.010
			RPM	26350~34000	26350~34000	26350~34000	26350~34000	24650~31000
			FEED	150~415	150~415	190~535	190~535	210~595
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090
	11.1 - 11.2		Vc	24~30	30~38	36~46	48~61	55~69
			fz	0.002~0.005	0.002~0.005	0.002~0.006	0.002~0.006	0.003~0.007
			RPM	19100~24200	19100~24200	19100~24200	19100~24200	17400~22100
			FEED	75~230	75~230	95~300	95~300	105~330
			Ap	0.018~0.036	0.023~0.045	0.027~0.054	0.036~0.072	0.045~0.090

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

▶ NEXT PAGE



(Depth of cut per one pass)

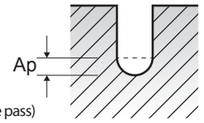
G9B81 SERIES

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

2 FLUTE BALL NOSE

VDI 3323	Material Description	Parameter	Mill Diameter (Ø) 1.2	1.4	1.5	1.6	1.8	2.0	3.0	4.0
1-4	Non-alloy steel	Vc	77~98	79~97	75~97	78~101	82~103	82~101	85~104	90~117
		fz	0.005~0.013	0.006~0.015	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.036
		RPM	20500~26000	18000~22000	16000~20500	15500~20000	14500~18200	13000~16000	9000~11000	7200~9350
		FEED	210~665	210~665	210~665	210~665	210~665	210~665	210~665	210~665
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360
5		Vc	55~69	56~67	54~70	56~70	58~72	59~72	57~108	63~83
		fz	0.004~0.009	0.004~0.011	0.005~0.011	0.005~0.012	0.005~0.013	0.006~0.014	0.009~0.014	0.011~0.025
		RPM	14500~18300	12800~15300	11500~14900	11200~14000	10200~12800	9400~11500	6000~11500	5000~6600
		FEED	105~330	105~330	105~330	105~330	105~330	105~330	105~330	105~330
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360
6-7	Low alloy steel	Vc	77~98	79~97	75~97	78~101	82~103	82~101	85~104	90~117
		fz	0.005~0.013	0.006~0.015	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.036
		RPM	20500~26000	18000~22000	16000~20500	15500~20000	14500~18200	13000~16000	9000~11000	7200~9350
		FEED	210~665	210~665	210~665	210~665	210~665	210~665	210~665	210~665
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360
8-9		Vc	55~69	56~67	54~70	56~70	58~72	59~72	57~108	63~83
		fz	0.004~0.009	0.004~0.011	0.005~0.011	0.005~0.012	0.005~0.013	0.006~0.014	0.009~0.014	0.011~0.025
		RPM	14500~18300	12800~15300	11500~14900	11200~14000	10200~12800	9400~11500	6000~11500	5000~6600
		FEED	105~330	105~330	105~330	105~330	105~330	105~330	105~330	105~330
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360
10	High alloyed steel, and tool steel	Vc	77~98	79~97	75~97	78~101	82~103	82~101	85~104	90~117
		fz	0.005~0.013	0.006~0.015	0.007~0.016	0.007~0.017	0.007~0.018	0.008~0.021	0.012~0.030	0.015~0.036
		RPM	20500~26000	18000~22000	16000~20500	15500~20000	14500~18200	13000~16000	9000~11000	7200~9350
		FEED	210~665	210~665	210~665	210~665	210~665	210~665	210~665	210~665
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360
11.1 - 11.2		Vc	55~69	56~67	54~70	56~70	58~72	59~72	57~108	63~83
		fz	0.004~0.009	0.004~0.011	0.005~0.011	0.005~0.012	0.005~0.013	0.006~0.014	0.009~0.014	0.011~0.025
		RPM	14500~18300	12800~15300	11500~14900	11200~14000	10200~12800	9400~11500	6000~11500	5000~6600
		FEED	105~330	105~330	105~330	105~330	105~330	105~330	105~330	105~330
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.135~0.270	0.180~0.360

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



(Depth of cut per one pass)

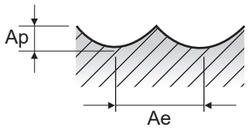
G9634 SERIES

4 FLUTE BALL NOSE

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

ISO	VDI 3323	Material Description	Ae	Parameter	Mill Diameter (Ø)											
					2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	1-4	Non-alloy steel	0.2D	Vc	85	110	110	125	135	155	170	190	200	205	215	225
				fz	0.013	0.019	0.027	0.033	0.046	0.068	0.089	0.112	0.124	0.136	0.14	0.15
				RPM	13528	11671	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	703	887	945	1050	1318	1677	1926	2258	2255	2219	2129	2149
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	5		0.2D	Vc	65	80	90	95	110	125	135	150	160	160	170	175
				fz	0.01	0.017	0.024	0.03	0.046	0.06	0.076	0.089	0.099	0.108	0.111	0.119
				RPM	10345	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	414	577	688	726	1074	1194	1306	1416	1441	1375	1335	1326
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	6-7	Low alloy steel	0.2D	Vc	85	110	110	125	135	155	170	190	200	205	215	225
				fz	0.013	0.019	0.027	0.033	0.046	0.068	0.089	0.112	0.124	0.136	0.14	0.15
				RPM	13528	11671	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	703	887	945	1050	1318	1677	1926	2258	2255	2219	2129	2149
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	8-9		0.2D	Vc	65	80	90	95	110	125	135	150	160	160	170	175
				fz	0.01	0.017	0.024	0.03	0.046	0.06	0.076	0.089	0.099	0.108	0.111	0.119
				RPM	10345	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	414	577	688	726	1074	1194	1306	1416	1441	1375	1335	1326
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	10	High alloyed steel, and tool steel	0.2D	Vc	85	110	110	125	135	155	170	190	200	205	215	225
				fz	0.013	0.019	0.027	0.033	0.046	0.068	0.089	0.112	0.124	0.136	0.14	0.15
				RPM	13528	11671	8754	7958	7162	6167	5411	5040	4547	4078	3802	3581
				FEED	703	887	945	1050	1318	1677	1926	2258	2255	2219	2129	2149
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	11.1 - 11.2		0.2D	Vc	65	80	90	95	110	125	135	150	160	160	170	175
				fz	0.01	0.017	0.024	0.03	0.046	0.06	0.076	0.089	0.099	0.108	0.111	0.119
				RPM	10345	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	414	577	688	726	1074	1194	1306	1416	1441	1375	1335	1326
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.7D	Vc	65	65	65	65	65	65	65	65	60	65	60	65
				fz	0.008	0.012	0.021	0.03	0.04	0.068	0.083	0.097	0.125	0.135	0.159	0.15
				RPM	10345	6897	5173	4138	3448	2586	2069	1724	1364	1293	1061	1035
				FEED	331	331	434	497	552	703	687	669	682	698	675	621
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
N	21~22	Aluminum-wrought alloy	0.7D	Vc	195	195	195	190	195	200	195	195	190	195	190	185
				fz	0.005	0.007	0.01	0.015	0.017	0.026	0.033	0.046	0.055	0.053	0.06	0.069
				RPM	31035	20690	15518	12096	10345	7958	6207	5173	4320	3879	3360	2944
				FEED	621	579	621	726	703	828	819	952	950	822	806	813
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	23~25	Aluminum-cast, alloyed	0.7D	Vc	195	195	195	190	195	200	195	195	190	195	190	185
				fz	0.005	0.007	0.01	0.015	0.017	0.026	0.033	0.046	0.055	0.053	0.06	0.069
				RPM	31035	20690	15518	12096	10345	7958	6207	5173	4320	3879	3360	2944
				FEED	621	579	621	726	703	828	819	952	950	822	806	813
				Ap	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3
H	38.1	Hardened steel	0.2D	Vc	25	35	45	50	50	55	55	55	55	55	60	60
				fz	0.008	0.012	0.016	0.019	0.022	0.034	0.041	0.053	0.062	0.073	0.076	0.084
				RPM	3979	3714	3581	3183	2653	2188	1751	1459	1251	1094	1061	955
				FEED	127	178	229	242	233	298	287	309	310	320	323	321
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
	40	Chilled Cast Iron	0.2D	Vc	65	80	90	95	110	125	135	150	160	160	170	175
				fz	0.01	0.017	0.024	0.03	0.046	0.06	0.076	0.089	0.099	0.108	0.111	0.119
				RPM	10345	8488	7162	6048	5836	4974	4297	3979	3638	3183	3006	2785
				FEED	414	577	688	726	1074	1194	1306	1416	1441	1375	1335	1326
				Ap	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3

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



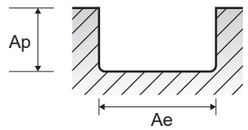
G9B82, G9B83 SERIES

2 FLUTE CORNER RADIUS - SLOTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	50	55	65	70	70	70	70	70
					fz	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065
					RPM	7958	5836	5173	4456	3714	2785	2228	1857
					FEED	159	175	259	276	290	318	285	241
	5		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	30	35	40	40	45	45	40	45
					fz	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048
					RPM	4775	3714	3183	2546	2387	1790	1273	1194
					FEED	95	119	159	158	196	179	127	115
	6-7	Low alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	50	55	65	70	70	70	70	70
					fz	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065
					RPM	7958	5836	5173	4456	3714	2785	2228	1857
					FEED	159	175	259	276	290	318	285	241
	8-9		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	30	35	40	40	45	45	40	45
					fz	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048
					RPM	4775	3714	3183	2546	2387	1790	1273	1194
					FEED	95	119	159	158	196	179	127	115
	10	High alloyed steel, and tool steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	50	55	65	70	70	70	70	70
					fz	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065
					RPM	7958	5836	5173	4456	3714	2785	2228	1857
					FEED	159	175	259	276	290	318	285	241
	11.1 - 11.2		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	30	35	40	40	45	45	40	45
					fz	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048
					RPM	4775	3714	3183	2546	2387	1790	1273	1194
					FEED	95	119	159	158	196	179	127	115
M	14.1	Stainless steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	30	35	35	35	35	35	35
					fz	0.009	0.016	0.025	0.031	0.04	0.053	0.059	0.058
					RPM	3979	3183	2785	2228	1857	1393	1114	928
					FEED	72	102	139	138	149	148	131	108
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	55	55	60	55
					fz	0.012	0.018	0.024	0.03	0.043	0.063	0.077	0.102
					RPM	9549	5836	4775	3501	2918	2188	1910	1459
					FEED	229	210	229	210	251	276	294	298
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	145	140	145	145	145	145	140
					fz	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065
					RPM	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	446	462	468	462	492	496	489	483
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	145	140	145	145	145	145	140
					fz	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065
					RPM	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	446	462	468	462	492	496	489	483
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	105	105	110	105	105	110	105	105
					fz	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066
					RPM	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	334	334	333	334	368	376	368	368
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	105	105	110	105	105	110	105	105
					fz	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066
					RPM	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	334	334	333	334	368	376	368	368
H	40	Chilled Cast Iron	1.0D	1.0D	Vc	30	35	40	40	45	45	40	45
					fz	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048
					RPM	4775	3714	3183	2546	2387	1790	1273	1194
					FEED	95	119	159	158	196	179	127	115

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



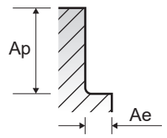
G9B84, G9B85 SERIES

4 FLUTE CORNER RADIUS - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)									
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-4	Non-alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	5		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
	6-7	Low alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	8-9		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
	10	High alloyed steel, and tool steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387
					FEED	140	233	229	267	484	519	554	616	509	449
	11.1 - 11.2		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216
M	14.1	Stainless steel	0.1D	1.0D	Vc	25	35	35	35	40	40	45	45	45	45
					fz	0.002	0.004	0.006	0.009	0.018	0.024	0.029	0.042	0.044	0.045
					RPM	7958	7427	5570	3714	3183	2546	2387	1790	1432	1194
					FEED	64	119	134	134	229	244	277	301	252	215
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	60	55	55	55	60	55
					fz	0.008	0.013	0.017	0.026	0.035	0.044	0.065	0.093	0.116	0.155
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459
					FEED	611	607	649	607	668	616	759	814	886	905
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070
H	40	Chilled Cast Iron	1.0D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459
					FEED	76	119	153	172	302	306	362	333	266	216

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



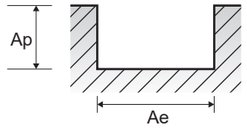
G9424, G9G44, G9A68, G9444, G9527, G9445, G9G45, G9452 SERIES

2 FLUTE - SLOTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)												
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
	5		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72
	6-7	Low alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
	8-9		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72
	10	High alloyed steel, and tool steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	45	50	55	65	70	70	70	70	70	75	75	70
					fz	0.004	0.008	0.01	0.015	0.025	0.031	0.039	0.057	0.064	0.065	0.063	0.062	0.063
					RPM	14324	9549	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	115	153	159	175	259	276	290	318	285	241	215	185	140
	11.1 - 11.2		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72
M	14.1	Stainless steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	20	25	25	30	35	35	35	35	35	35	35	35	35
					fz	0.003	0.007	0.009	0.016	0.025	0.031	0.04	0.053	0.059	0.058	0.059	0.068	0.064
					RPM	6366	5305	3979	3183	2785	2228	1857	1393	1114	928	796	696	557
					FEED	38	74	72	102	139	138	149	148	131	108	94	95	71
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	60	55	55	55	60	55	55	55	55
					fz	0.005	0.008	0.012	0.018	0.024	0.03	0.043	0.063	0.077	0.102	0.119	0.145	0.189
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875
					FEED	191	187	229	210	229	210	251	276	294	298	298	317	331
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	357	386	446	462	468	462	492	496	489	483	481	490	490
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.004	0.007	0.01	0.015	0.021	0.025	0.032	0.043	0.053	0.065	0.073	0.085	0.11
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	357	386	446	462	468	462	492	496	489	483	481	490	490
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.004	0.007	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066	0.078	0.085	0.11
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	204	282	334	334	333	334	368	376	368	368	372	372	368
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.004	0.007	0.01	0.015	0.019	0.025	0.033	0.043	0.055	0.066	0.078	0.085	0.11
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	204	282	334	334	333	334	368	376	368	368	372	372	368
H	40	Chilled Cast Iron	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.004	0.008	0.01	0.016	0.025	0.031	0.041	0.05	0.05	0.048	0.048	0.05	0.05
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	64	85	95	119	159	158	196	179	127	115	98	99	72

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



G9B80 SERIES

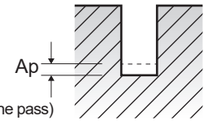
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.
Ap = mm

2 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Mill Diameter (Ø)						
				0.4	0.5	0.6	0.7	0.8	0.9	1.0
P	1-4	Non-alloy steel	Vc	33~43	42~53	50~64	58~75	58~75	61~76	60~75
			fz	0.003~0.005	0.003~0.005	0.004~0.007	0.004~0.007	0.005~0.009	0.006~0.011	0.006~0.014
			RPM	26500~34000	26500~34000	26500~34000	26500~34000	23000~30000	21500~27000	19000~24000
			FEED	170~370	170~370	210~485	210~485	240~535	240~610	240~690
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090
	5		Vc	24~30	30~38	36~45	42~53	41~53	42~54	42~53
			fz	0.002~0.006	0.002~0.006	0.003~0.008	0.003~0.008	0.003~0.010	0.005~0.012	0.006~0.015
			RPM	19000~24000	19000~24000	19000~24000	19000~24000	16500~21000	15000~19000	13500~17000
			FEED	72~290	72~290	95~365	95~365	100~410	135~460	160~510
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090
	6-7	Low alloy steel	Vc	33~43	42~53	50~64	58~75	58~75	61~76	60~75
			fz	0.003~0.005	0.003~0.005	0.004~0.007	0.004~0.007	0.005~0.009	0.006~0.011	0.006~0.014
			RPM	26500~34000	26500~34000	26500~34000	26500~34000	23000~30000	21500~27000	19000~24000
			FEED	170~370	170~370	210~485	210~485	240~535	240~610	240~690
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090
	8-9		Vc	24~30	30~38	36~45	42~53	41~53	42~54	42~53
			fz	0.002~0.006	0.002~0.006	0.003~0.008	0.003~0.008	0.003~0.010	0.005~0.012	0.006~0.015
			RPM	19000~24000	19000~24000	19000~24000	19000~24000	16500~21000	15000~19000	13500~17000
			FEED	72~290	72~290	95~365	95~365	100~410	135~460	160~510
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090
	10	High alloyed steel, and tool steel	Vc	33~43	42~53	50~64	58~75	58~75	61~76	60~75
			fz	0.003~0.005	0.003~0.005	0.004~0.007	0.004~0.007	0.005~0.009	0.006~0.011	0.006~0.014
			RPM	26500~34000	26500~34000	26500~34000	26500~34000	23000~30000	21500~27000	19000~24000
			FEED	170~370	170~370	210~485	210~485	240~535	240~610	240~690
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090
	11.1 - 11.2		Vc	24~30	30~38	36~45	42~53	41~53	42~54	42~53
			fz	0.002~0.006	0.002~0.006	0.003~0.008	0.003~0.008	0.003~0.010	0.005~0.012	0.006~0.015
			RPM	19000~24000	19000~24000	19000~24000	19000~24000	16500~21000	15000~19000	13500~17000
			FEED	72~290	72~290	95~365	95~365	100~410	135~460	160~510
			Ap	0.007~0.018	0.009~0.022	0.011~0.026	0.012~0.031	0.014~0.035	0.030~0.060	0.045~0.090

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

▶ NEXT PAGE



(Depth of cut per one pass)

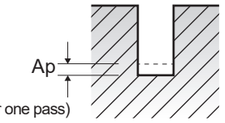
G9B80 SERIES

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

2 FLUTE - SLOTTING

VDI 3323	Material Description	Parameter	Mill Diameter (Ø)								
			1.2	1.4	1.5	1.6	1.8	2.0	2.5	3.0	4.0
1-4	Non-alloy steel	Vc	58~72	60~75	59~73	60~75	62~79	63~79	63~79	64~80	64~82
		fz	0.008~0.020	0.009~0.023	0.010~0.025	0.010~0.026	0.011~0.027	0.012~0.031	0.015~0.038	0.018~0.045	0.024~0.059
		RPM	15500~19000	13600~17000	12500~15500	12000~15000	11000~14000	10000~12500	8000~10000	6800~8500	5100~6500
		FEED	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360
5		Vc	41~53	43~53	42~54	44~55	44~55	44~56	45~57	44~57	44~57
		fz	0.007~0.018	0.008~0.021	0.009~0.022	0.009~0.023	0.010~0.026	0.011~0.028	0.014~0.035	0.017~0.043	0.023~0.057
		RPM	11000~14000	9800~12000	8950~11500	8700~10900	7800~9800	7000~8950	5700~7200	4700~6000	3500~4500
		FEED	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360
6-7	Low alloy steel	Vc	58~72	60~75	59~73	60~75	62~79	63~79	63~79	64~80	64~82
		fz	0.008~0.020	0.009~0.023	0.010~0.025	0.010~0.026	0.011~0.027	0.012~0.031	0.015~0.038	0.018~0.045	0.024~0.059
		RPM	15500~19000	13600~17000	12500~15500	12000~15000	11000~14000	10000~12500	8000~10000	6800~8500	5100~6500
		FEED	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360
8-9		Vc	41~53	43~53	42~54	44~55	44~55	44~56	45~57	44~57	44~57
		fz	0.007~0.018	0.008~0.021	0.009~0.022	0.009~0.023	0.010~0.026	0.011~0.028	0.014~0.035	0.017~0.043	0.023~0.057
		RPM	11000~14000	9800~12000	8950~11500	8700~10900	7800~9800	7000~8950	5700~7200	4700~6000	3500~4500
		FEED	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360
10	High alloyed steel, and tool steel	Vc	58~72	60~75	59~73	60~75	62~79	63~79	63~79	64~80	64~82
		fz	0.008~0.020	0.009~0.023	0.010~0.025	0.010~0.026	0.011~0.027	0.012~0.031	0.015~0.038	0.018~0.045	0.024~0.059
		RPM	15500~19000	13600~17000	12500~15500	12000~15000	11000~14000	10000~12500	8000~10000	6800~8500	5100~6500
		FEED	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765	240~765
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360
11.1 - 11.2		Vc	41~53	43~53	42~54	44~55	44~55	44~56	45~57	44~57	44~57
		fz	0.007~0.018	0.008~0.021	0.009~0.022	0.009~0.023	0.010~0.026	0.011~0.028	0.014~0.035	0.017~0.043	0.023~0.057
		RPM	11000~14000	9800~12000	8950~11500	8700~10900	7800~9800	7000~8950	5700~7200	4700~6000	3500~4500
		FEED	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510	160~510
		Ap	0.055~0.100	0.062~0.125	0.070~0.135	0.075~0.145	0.080~0.160	0.090~0.180	0.112~0.235	0.135~0.270	0.180~0.360

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



(Depth of cut per one pass)

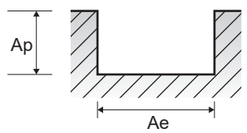
G9553, G9G46, G9410, G9425, G9G47, G9439
G9528, G9433, G9G48, G9447, G9G49 SERIES

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

3 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø) 1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	60	50	55	65	70	70	70	70	70	75	75	70
					fz	0.002	0.003	0.005	0.007	0.012	0.015	0.018	0.027	0.03	0.031	0.029	0.029	0.029
					RPM	14324	12732	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	86	115	119	123	186	201	201	226	201	173	148	130	97
	5		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.002	0.004	0.005	0.007	0.012	0.014	0.02	0.024	0.023	0.022	0.022	0.023	0.024
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	48	64	72	78	115	107	143	129	88	79	68	69	52
	6-7	Low alloy steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	60	50	55	65	70	70	70	70	70	75	75	70
					fz	0.002	0.003	0.005	0.007	0.012	0.015	0.018	0.027	0.03	0.031	0.029	0.029	0.029
					RPM	14324	12732	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	86	115	119	123	186	201	201	226	201	173	148	130	97
	8-9		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.002	0.004	0.005	0.007	0.012	0.014	0.02	0.024	0.023	0.022	0.022	0.023	0.024
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	48	64	72	78	115	107	143	129	88	79	68	69	52
	10	High alloyed steel, and tool steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	45	60	50	55	65	70	70	70	70	70	75	75	70
					fz	0.002	0.003	0.005	0.007	0.012	0.015	0.018	0.027	0.03	0.031	0.029	0.029	0.029
					RPM	14324	12732	7958	5836	5173	4456	3714	2785	2228	1857	1705	1492	1114
					FEED	86	115	119	123	186	201	201	226	201	173	148	130	97
	11.1 - 11.2		1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.002	0.004	0.005	0.007	0.012	0.014	0.02	0.024	0.023	0.022	0.022	0.023	0.024
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	48	64	72	78	115	107	143	129	88	79	68	69	52
M	14.1	Stainless steel	1.0D	0.5D (Up to Ø3 : 0.2D)	Vc	20	25	25	30	35	35	35	35	35	35	35	35	35
					fz	0.002	0.003	0.004	0.007	0.011	0.015	0.019	0.025	0.028	0.026	0.027	0.031	0.03
					RPM	6366	5305	3979	3183	2785	2228	1857	1393	1114	928	796	696	557
					FEED	38	48	48	67	92	100	106	104	94	72	64	65	50
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	60	55	60	55	60	55	55	55	60	55	55	55	55
					fz	0.003	0.005	0.007	0.011	0.013	0.018	0.026	0.036	0.046	0.063	0.073	0.086	0.115
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875
					FEED	172	175	201	193	186	189	228	236	264	276	274	282	302
N	21~22	Aluminum-wrought alloy	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.002	0.004	0.006	0.009	0.013	0.015	0.019	0.026	0.032	0.038	0.043	0.05	0.065
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	267	331	401	415	434	415	438	450	443	423	425	433	434
	23~25	Aluminum-cast, alloyed	1.0D	1.0D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.002	0.004	0.006	0.009	0.013	0.015	0.019	0.026	0.032	0.038	0.043	0.05	0.065
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	267	331	401	415	434	415	438	450	443	423	425	433	434
	26-28	Copper and Copper Alloys (Bronze / Brass)	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.002	0.004	0.006	0.009	0.012	0.015	0.02	0.025	0.032	0.039	0.046	0.05	0.065
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	153	242	301	301	315	301	334	328	321	326	329	328	326
	29.1	Non Metallic Materials	1.0D	1.0D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.002	0.004	0.006	0.009	0.012	0.015	0.02	0.025	0.032	0.039	0.046	0.05	0.065
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	153	242	301	301	315	301	334	328	321	326	329	328	326
H	40	Chilled Cast Iron	1.0D	1.0D	Vc	25	25	30	35	40	40	45	45	40	45	45	50	45
					fz	0.002	0.004	0.005	0.007	0.012	0.014	0.02	0.024	0.023	0.022	0.022	0.023	0.024
					RPM	7958	5305	4775	3714	3183	2546	2387	1790	1273	1194	1023	995	716
					FEED	48	64	72	78	115	107	143	129	88	79	68	69	52

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



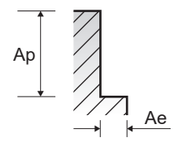
G9553, G9G46, G9410, G9425, G9G47, G9439
G9528, G9433, G9G48, G9447, G9G49 SERIES

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

3 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø) 1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	105	175	172	201	363	390	430	451	381	337	289	272	202
	5		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.037	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	57	89	115	129	227	229	271	249	200	162	139	136	97
	6-7	Low alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	105	175	172	201	363	390	430	451	381	337	289	272	202
	8-9		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.037	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	57	89	115	129	227	229	271	249	200	162	139	136	97
	10	High alloyed steel, and tool steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.03	0.042	0.047	0.047	0.047	0.048	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	105	175	172	201	363	390	430	451	381	337	289	272	202
	11.1 - 11.2		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.037	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	57	89	115	129	227	229	271	249	200	162	139	136	97
M	14.1	Stainless steel	0.1D	1.0D	Vc	25	35	35	35	40	40	45	45	45	45	45	45	45
					fz	0.002	0.004	0.006	0.009	0.018	0.024	0.03	0.042	0.045	0.045	0.044	0.048	0.048
					RPM	7958	7427	5570	3714	3183	2546	2387	1790	1432	1194	1023	895	716
					FEED	48	89	100	100	172	183	215	226	193	161	135	129	103
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	Vc	60	55	60	55	60	55	55	55	60	55	55	55	55
					fz	0.008	0.013	0.017	0.026	0.035	0.044	0.064	0.093	0.115	0.154	0.181	0.22	0.285
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875
					FEED	458	455	487	455	501	462	560	611	659	674	679	722	748
N	21~22	Aluminum-wrought alloy	0.1D	1.5D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.006	0.01	0.016	0.021	0.031	0.037	0.048	0.064	0.08	0.098	0.111	0.129	0.167
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	802	828	1070	969	1036	1025	1108	1108	1108	1092	1098	1116	1116
	23~25	Aluminum-cast, alloyed	0.1D	1.5D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.006	0.01	0.016	0.021	0.031	0.037	0.048	0.064	0.08	0.098	0.111	0.129	0.167
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	802	828	1070	969	1036	1025	1108	1108	1108	1092	1098	1116	1116
	26-28	Copper and Copper Alloys (Bronze / Brass)	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.006	0.011	0.016	0.023	0.029	0.037	0.048	0.063	0.081	0.096	0.115	0.125	0.162
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	458	665	802	769	762	742	802	827	812	802	824	821	812
	29.1	Non Metallic Materials	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.006	0.011	0.016	0.023	0.029	0.037	0.048	0.063	0.081	0.096	0.115	0.125	0.162
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	458	665	802	769	762	742	802	827	812	802	824	821	812
H	40	Chilled Cast Iron	0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.037	0.038	0.037
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	57	89	115	129	227	229	271	249	200	162	139	136	97

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



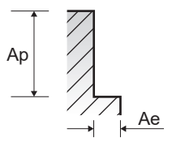
G9432, G9G50, G9A69, G9448, G9540, G9449, G9G51, G9453 SERIES

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

4 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)												
						1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-4	Non-alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047	0.047	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	140	233	229	267	484	519	554	616	509	449	385	355	269
	5		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133
	6-7	Low alloy steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047	0.047	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	140	233	229	267	484	519	554	616	509	449	385	355	269
	8-9		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133
	10	High alloyed steel, and tool steel	0.1D	1.0D	Vc	55	55	60	70	80	85	90	90	85	90	90	95	90
					fz	0.002	0.005	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047	0.047	0.047	0.047
					RPM	17507	11671	9549	7427	6366	5411	4775	3581	2706	2387	2046	1890	1432
					FEED	140	233	229	267	484	519	554	616	509	449	385	355	269
	11.1 - 11.2		0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133
M	14.1	Stainless steel	0.1D	1.0D	Vc	25	35	35	35	40	40	45	45	45	45	45	50	45
					fz	0.002	0.004	0.006	0.009	0.018	0.024	0.029	0.042	0.044	0.045	0.045	0.045	0.046
					RPM	7958	7427	5570	3714	3183	2546	2387	1790	1432	1194	1023	995	716
					FEED	64	119	134	134	229	244	277	301	252	215	184	179	132
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	Vc	60	55	60	55	60	55	55	55	60	55	55	55	55
					fz	0.008	0.013	0.017	0.026	0.035	0.044	0.065	0.093	0.116	0.155	0.182	0.22	0.288
					RPM	19099	11671	9549	5836	4775	3501	2918	2188	1910	1459	1251	1094	875
					FEED	611	607	649	607	668	616	759	814	886	905	910	963	1008
N	21~22	Aluminum-wrought alloy	0.1D	1.5D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095	0.108	0.125	0.163
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411	1424	1442	1453
	23~25	Aluminum-cast, alloyed	0.1D	1.5D	Vc	140	130	140	145	140	145	145	145	145	140	145	145	140
					fz	0.006	0.011	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095	0.108	0.125	0.163
					RPM	44563	27587	22282	15385	11141	9231	7692	5769	4615	3714	3297	2885	2228
					FEED	1070	1214	1337	1292	1337	1329	1446	1454	1440	1411	1424	1442	1453
	26-28	Copper and Copper Alloys (Bronze / Brass)	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096	0.115	0.125	0.162
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070	1098	1094	1083
	29.1	Non Metallic Materials	0.1D	1.5D	Vc	80	95	105	105	110	105	105	110	105	105	105	110	105
					fz	0.006	0.011	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096	0.115	0.125	0.162
					RPM	25465	20160	16711	11141	8754	6685	5570	4377	3342	2785	2387	2188	1671
					FEED	611	887	1070	1070	1015	1016	1070	1103	1083	1070	1098	1094	1083
H	40	Chilled Cast Iron	0.1D	1.0D	Vc	30	35	40	45	50	50	55	55	55	55	55	60	55
					fz	0.002	0.004	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037	0.038	0.037	0.038
					RPM	9549	7427	6366	4775	3979	3183	2918	2188	1751	1459	1251	1194	875
					FEED	76	119	153	172	302	306	362	333	266	216	190	177	133

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



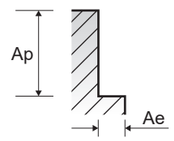
G9F45, G9F46 SERIES

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

4&6 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)										
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	1-4	Non-alloy steel	0.05D	1.5D	Vc	82	83	98	98	97	97	99	98	98	97	97
					fz	0.024	0.033	0.025	0.03	0.045	0.045	0.053	0.058	0.062	0.065	0.069
					RPM	8700	6605	6239	5199	3860	3088	2626	2228	1950	1715	1544
					FEED	835	872	936	936	1042	834	835	775	725	669	639
	5		0.03D	1.5D	Vc	54	55	65	65	65	64	66	66	65	65	64
					fz	0.024	0.033	0.027	0.03	0.038	0.045	0.053	0.057	0.062	0.066	0.07
					RPM	5730	4377	4138	3448	2586	2037	1751	1501	1293	1149	1019
					FEED	550	578	670	621	590	550	557	513	481	455	428
	6-7	Low alloy steel	0.05D	1.5D	Vc	82	83	98	98	97	97	99	98	98	97	97
					fz	0.024	0.033	0.025	0.03	0.045	0.045	0.053	0.058	0.062	0.065	0.069
					RPM	8700	6605	6239	5199	3860	3088	2626	2228	1950	1715	1544
					FEED	835	872	936	936	1042	834	835	775	725	669	639
	8-9		0.03D	1.5D	Vc	54	55	65	65	65	64	66	66	65	65	64
					fz	0.024	0.033	0.027	0.03	0.038	0.045	0.053	0.057	0.062	0.066	0.07
					RPM	5730	4377	4138	3448	2586	2037	1751	1501	1293	1149	1019
					FEED	550	578	670	621	590	550	557	513	481	455	428
	10	High alloyed steel, and tool steel	0.05D	1.5D	Vc	82	83	98	98	97	97	99	98	98	97	97
					fz	0.024	0.033	0.025	0.03	0.045	0.045	0.053	0.058	0.062	0.065	0.069
					RPM	8700	6605	6239	5199	3860	3088	2626	2228	1950	1715	1544
					FEED	835	872	936	936	1042	834	835	775	725	669	639
	11.1 - 11.2		0.03D	1.5D	Vc	54	55	65	65	65	64	66	66	65	65	64
					fz	0.024	0.033	0.027	0.03	0.038	0.045	0.053	0.057	0.062	0.066	0.07
					RPM	5730	4377	4138	3448	2586	2037	1751	1501	1293	1149	1019
					FEED	550	578	670	621	590	550	557	513	481	455	428
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1.5D	Vc	82	83	98	98	97	97	99	98	98	97	97
					fz	0.024	0.033	0.025	0.03	0.045	0.045	0.053	0.058	0.062	0.065	0.069
					RPM	8700	6605	6239	5199	3860	3088	2626	2228	1950	1715	1544
					FEED	835	872	936	936	1042	834	835	775	725	669	639
H	38.1	Hardened steel	0.03D	1.5D	Vc	54	55	65	65	65	64	66	66	65	65	64
					fz	0.024	0.033	0.027	0.03	0.038	0.045	0.053	0.057	0.062	0.066	0.07
					RPM	5730	4377	4138	3448	2586	2037	1751	1501	1293	1149	1019
					FEED	550	578	670	621	590	550	557	513	481	455	428
	38.2 ~ 39.1		0.03D	1.5D	Vc	45	45	50	50	50	50	50	50	50	50	50
					fz	0.018	0.025	0.02	0.023	0.029	0.033	0.029	0.041	0.046	0.05	0.052
					RPM	4775	3581	3183	2653	1989	1592	1326	1137	995	884	796
					FEED	344	358	382	366	346	315	231	280	275	265	248
	39.2		0.02D	1D	Vc	35	35	40	40	40	40	40	40	40	40	41
					fz	0.014	0.02	0.016	0.018	0.023	0.027	0.031	0.034	0.037	0.039	0.042
					RPM	3714	2785	2546	2122	1592	1273	1061	909	796	707	653
					FEED	208	223	244	229	220	206	197	186	177	166	164
	40	Chilled Cast Iron	0.03D	1.5D	Vc	54	55	65	65	65	64	66	66	65	65	64
					fz	0.024	0.033	0.027	0.03	0.038	0.045	0.053	0.057	0.062	0.066	0.07
					RPM	5730	4377	4138	3448	2586	2037	1751	1501	1293	1149	1019
					FEED	550	578	670	621	590	550	557	513	481	455	428
	41	Hardened Cast Iron	0.03D	1.5D	Vc	45	45	50	50	50	50	50	50	50	50	50
					fz	0.018	0.025	0.02	0.023	0.029	0.033	0.029	0.041	0.046	0.05	0.052
					RPM	4775	3581	3183	2653	1989	1592	1326	1137	995	884	796
					FEED	344	358	382	366	346	315	231	280	275	265	248

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



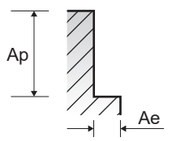
G9A42 SERIES

MULTI FLUTE ROUGHING - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Mill Diameter (Ø)								
						6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0
P	1-4	Non-alloy steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	5		0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
	6-7	Low alloy steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	8-9		0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
	10	High alloyed steel, and tool steel	0.3D	1.5D	Vc	250	250	245	255	255	255	250	260	285
					fz	0.05	0.067	0.063	0.075	0.088	0.1	0.112	0.112	0.1
					RPM	13263	9947	7799	6764	5798	5073	4421	4138	3629
					FEED	1989	1999	1965	2029	2041	2029	1981	1854	1814
	11.1 - 11.2		0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521
M	14.1	Stainless steel	0.05D	1.0D	Vc	135	135	135	135	135	140	130	130	145
					fz	0.022	0.022	0.028	0.034	0.039	0.038	0.039	0.038	0.038
					RPM	7162	5371	4297	3581	3069	2785	2299	2069	1846
					FEED	473	355	481	487	479	423	359	314	351
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	Vc	40	40	35	40	35	35	35	35	40
					fz	0.026	0.024	0.036	0.04	0.037	0.032	0.038	0.041	0.06
					RPM	2122	1592	1114	1061	796	696	619	557	509
					FEED	166	115	160	170	118	89	94	91	153
H	40	Chilled Cast Iron	0.3D	1.5D	Vc	200	195	205	190	195	205	210	190	210
					fz	0.022	0.023	0.028	0.033	0.04	0.04	0.041	0.039	0.039
					RPM	10610	7759	6525	5040	4434	4078	3714	3024	2674
					FEED	700	535	731	665	709	653	609	472	521

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



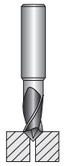
G9400 SERIES

2 FLUTE DRILL MILLS - CHAMFERING

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

ISO	VDI 3323	Material Description	Parameter	Mill Diameter (Ø)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-2	Non-alloy steel	Vc	60	65	65	60	60	65	70	70	85
			fz	0.025	0.031	0.04	0.052	0.071	0.083	0.1	0.125	0.137
			RPM	6366	5173	4138	3183	2387	2069	1857	1393	1353
			FEED	318	321	331	331	339	343	371	348	371
	3-4		Vc	45	55	55	55	55	55	60	65	65
			fz	0.023	0.027	0.036	0.043	0.058	0.073	0.091	0.105	0.14
			RPM	4775	4377	3501	2918	2188	1751	1592	1293	1035
			FEED	220	236	252	251	254	256	290	272	290
	5		Vc	40	45	45	40	40	50	50	50	55
			fz	0.023	0.028	0.035	0.044	0.06	0.066	0.083	0.115	0.134
			RPM	4244	3581	2865	2122	1592	1592	1326	995	875
			FEED	195	201	201	187	191	210	220	229	235
	6	Low alloy steel	Vc	60	65	65	60	60	65	70	70	85
			fz	0.025	0.031	0.04	0.052	0.071	0.083	0.1	0.125	0.137
			RPM	6366	5173	4138	3183	2387	2069	1857	1393	1353
			FEED	318	321	331	331	339	343	371	348	371
	7		Vc	45	55	55	55	55	55	60	65	65
			fz	0.023	0.027	0.036	0.043	0.058	0.073	0.091	0.105	0.14
			RPM	4775	4377	3501	2918	2188	1751	1592	1293	1035
			FEED	220	236	252	251	254	256	290	272	290
	8-9		Vc	40	45	45	40	40	50	50	50	55
			fz	0.023	0.028	0.035	0.044	0.06	0.066	0.083	0.115	0.134
			RPM	4244	3581	2865	2122	1592	1592	1326	995	875
			FEED	195	201	201	187	191	210	220	229	235
	10	High alloyed steel, and tool steel	Vc	60	65	65	60	60	65	70	70	85
			fz	0.025	0.031	0.04	0.052	0.071	0.083	0.1	0.125	0.137
			RPM	6366	5173	4138	3183	2387	2069	1857	1393	1353
			FEED	318	321	331	331	339	343	371	348	371
	11.1		Vc	40	45	45	40	40	50	50	50	55
			fz	0.023	0.028	0.035	0.044	0.06	0.066	0.083	0.115	0.134
			RPM	4244	3581	2865	2122	1592	1592	1326	995	875
			FEED	195	201	201	187	191	210	220	229	235
M	14.1	Stainless steel	Vc	30	35	40	35	35	40	40	40	45
			fz	0.021	0.025	0.029	0.037	0.055	0.064	0.078	0.11	0.122
			RPM	3183	2785	2546	1857	1393	1273	1061	796	716
			FEED	134	139	148	137	153	163	166	175	175
N	21~22	Aluminum-wrought alloy	Vc	145	160	150	150	155	175	185	195	195
			fz	0.025	0.032	0.045	0.057	0.075	0.085	0.1	0.134	0.175
			RPM	15385	12732	9549	7958	6167	5570	4907	3879	3104
			FEED	769	815	859	907	925	947	981	1040	1086
	23~25	Aluminum-cast, alloyed	Vc	145	160	150	150	155	175	185	195	195
			fz	0.025	0.032	0.045	0.057	0.075	0.085	0.1	0.134	0.175
			RPM	15385	12732	9549	7958	6167	5570	4907	3879	3104
			FEED	769	815	859	907	925	947	981	1040	1086

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



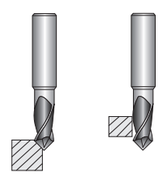
G9400 SERIES

2 FLUTE DRILL MILLS - CHAMFERING & SIDE CUTTING

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

ISO	VDI 3323	Material Description	Parameter	Mill Diameter (Ø)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-2	Non-alloy steel	Vc	80	85	85	80	80	90	95	90	95
			fz	0.008	0.01	0.013	0.018	0.025	0.03	0.037	0.054	0.063
			RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512
			FEED	136	135	141	153	159	172	186	193	191
	3-4		Vc	50	55	55	55	55	55	60	65	60
			fz	0.008	0.01	0.013	0.018	0.024	0.03	0.041	0.05	0.064
			RPM	5305	4377	3501	2918	2188	1751	1592	1293	955
			FEED	85	88	91	105	105	105	131	129	122
	5		Vc	45	50	50	50	45	55	55	55	55
			fz	0.008	0.009	0.012	0.017	0.025	0.027	0.036	0.046	0.06
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	76	72	76	90	90	95	105	101	105
	6	Low alloy steel	Vc	80	85	85	80	80	90	95	90	95
			fz	0.008	0.01	0.013	0.018	0.025	0.03	0.037	0.054	0.063
			RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512
			FEED	136	135	141	153	159	172	186	193	191
	7		Vc	50	55	55	55	55	55	60	65	60
			fz	0.008	0.01	0.013	0.018	0.024	0.03	0.041	0.05	0.064
			RPM	5305	4377	3501	2918	2188	1751	1592	1293	955
			FEED	85	88	91	105	105	105	131	129	122
	8-9		Vc	45	50	50	50	45	55	55	55	55
			fz	0.008	0.009	0.012	0.017	0.025	0.027	0.036	0.046	0.06
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	76	72	76	90	90	95	105	101	105
	10	High alloyed steel, and tool steel	Vc	80	85	85	80	80	90	95	90	95
			fz	0.008	0.01	0.013	0.018	0.025	0.03	0.037	0.054	0.063
			RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512
			FEED	136	135	141	153	159	172	186	193	191
	11.1		Vc	45	50	50	50	45	55	55	55	55
			fz	0.008	0.009	0.012	0.017	0.025	0.027	0.036	0.046	0.06
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	76	72	76	90	90	95	105	101	105
M	14.1	Stainless steel	Vc	30	35	40	35	40	45	45	45	40
			fz	0.008	0.01	0.013	0.018	0.024	0.027	0.036	0.046	0.069
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	51	56	66	67	76	77	86	82	88
N	21~22	Aluminum-wrought alloy	Vc	185	210	210	205	205	225	230	230	230
			fz	0.008	0.01	0.013	0.019	0.03	0.037	0.045	0.05	0.064
			RPM	19629	16711	13369	10876	8157	7162	6101	4576	3661
			FEED	314	334	348	413	489	530	549	458	469
	23~25	Aluminum-cast, alloyed	Vc	185	210	210	205	205	225	230	230	230
			fz	0.008	0.01	0.013	0.019	0.03	0.037	0.045	0.05	0.064
			RPM	19629	16711	13369	10876	8157	7162	6101	4576	3661
			FEED	314	334	348	413	489	530	549	458	469
S	36-37	Titanium Alloys	Vc	30	35	40	35	40	45	45	45	40
			fz	0.008	0.01	0.013	0.018	0.024	0.027	0.036	0.046	0.069
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	51	56	66	67	76	77	86	82	88

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



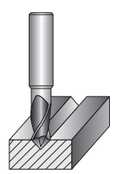
G9400 SERIES

2FLUTE DRILL MILLS - V-GROOVING

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

ISO	VDI 3323	Material Description	Parameter	Mill Diameter (Ø)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-2	Non-alloy steel	Vc	80	85	85	80	80	90	95	100	95
			fz	0.005	0.006	0.008	0.01	0.014	0.016	0.018	0.023	0.029
			RPM	8488	6764	5411	4244	3183	2865	2520	1989	1512
			FEED	85	81	87	85	89	92	91	92	88
	3-4		Vc	55	60	55	55	55	55	55	65	60
			fz	0.004	0.004	0.006	0.007	0.012	0.014	0.02	0.022	0.028
			RPM	5836	4775	3501	2918	2188	1751	1459	1293	955
			FEED	47	38	42	41	53	49	58	57	53
	5		Vc	45	50	50	50	45	55	55	55	55
			fz	0.004	0.004	0.006	0.008	0.014	0.015	0.018	0.023	0.03
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	38	32	38	42	50	53	53	50	53
	6	Low alloy steel	Vc	80	85	85	80	80	90	95	100	95
			fz	0.005	0.006	0.008	0.01	0.014	0.016	0.018	0.023	0.029
			RPM	8488	6764	5411	4244	3183	2865	2520	1989	1512
			FEED	85	81	87	85	89	92	91	92	88
	7		Vc	55	60	55	55	55	55	55	65	60
			fz	0.004	0.004	0.006	0.007	0.012	0.014	0.02	0.022	0.028
			RPM	5836	4775	3501	2918	2188	1751	1459	1293	955
			FEED	47	38	42	41	53	49	58	57	53
	8-9		Vc	45	50	50	50	45	55	55	55	55
			fz	0.004	0.004	0.006	0.008	0.014	0.015	0.018	0.023	0.03
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	38	32	38	42	50	53	53	50	53
	10	High alloyed steel, and tool steel	Vc	80	85	85	80	80	90	95	100	95
			fz	0.005	0.006	0.008	0.01	0.014	0.016	0.018	0.023	0.029
			RPM	8488	6764	5411	4244	3183	2865	2520	1989	1512
			FEED	85	81	87	85	89	92	91	92	88
	11.1		Vc	45	50	50	50	45	55	55	55	55
			fz	0.004	0.004	0.006	0.008	0.014	0.015	0.018	0.023	0.03
			RPM	4775	3979	3183	2653	1790	1751	1459	1094	875
			FEED	38	32	38	42	50	53	53	50	53
M	14.1	Stainless steel	Vc	30	35	40	35	40	45	45	45	40
			fz	0.004	0.005	0.006	0.008	0.01	0.011	0.013	0.019	0.028
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	25	28	31	30	32	32	31	34	36
N	21~22	Aluminum-wrought alloy	Vc	185	210	210	205	205	220	230	230	230
			fz	0.008	0.01	0.013	0.016	0.022	0.026	0.03	0.041	0.052
			RPM	19629	16711	13369	10876	8157	7003	6101	4576	3661
			FEED	314	334	348	348	359	364	366	375	381
	23~25	Aluminum-cast, alloyed	Vc	185	210	210	205	205	220	230	230	230
			fz	0.008	0.01	0.013	0.016	0.022	0.026	0.03	0.041	0.052
			RPM	19629	16711	13369	10876	8157	7003	6101	4576	3661
			FEED	314	334	348	348	359	364	366	375	381
S	36-37	Titanium Alloys	Vc	30	35	40	35	40	45	45	45	40
			fz	0.004	0.005	0.006	0.008	0.01	0.011	0.013	0.019	0.028
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	25	28	31	30	32	32	31	34	36

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



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

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HIGH QUALITY PRODUCTS and ON TIME DELIVERY for WORLD-WIDE CUSTOMERS

Since 1982, YG-1 has been committed to quality, innovation and the unique customer experience.
Our performance and experience have granted YG-1 the global impression of one of the leading manufacturers of high quality cutting tool solutions. This global footprint expands over 75 countries, with international logistic centers, pledging to our customers to give the best service available today - and tomorrow.

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YG-1 CO., LTD.

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