

**YG K-2 CARBIDE
END MILLS**

G9624 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

**CARBIDE, 2 FULTE SHORT LENGTH BALL NOSE
VOLLHARTMETALL, 2 SCHNEIDEN KURZ STIRNRADIUS**

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

- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis.
- ▶ Bestimmt für das Fräsen von Nuten mit konvexem Grund, Sonderprofilen und zum Kopieren.



MG HM
YG STD
2
30°
R ±0.02
DIN 6535HA
P.823

Unit : mm

| EDP No. | Radius of Ball Nose R (±0.02) | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|----------|----------------------------------|---------------|----------------|---------------|----------------|
| G9624020 | R 1.0 | 2.0 | 6 | 4 | 48 |
| G9624025 | R 1.25 | 2.5 | 6 | 4 | 48 |
| G9624030 | R 1.5 | 3.0 | 6 | 4 | 48 |
| G9624040 | R 2.0 | 4.0 | 6 | 6 | 50 |
| G9624901 | R 2.0 | 4.0 | 4 | 12 | 40 |
| G9624050 | R 2.5 | 5.0 | 6 | 7 | 51 |
| G9624902 | R 2.5 | 5.0 | 5 | 14 | 50 |
| G9624060 | R 3.0 | 6.0 | 6 | 7 | 51 |
| G9624080 | R 4.0 | 8.0 | 8 | 9 | 59 |
| G9624100 | R 5.0 | 10.0 | 10 | 10 | 60 |
| G9624120 | R 6.0 | 12.0 | 12 | 14 | 71 |
| G9624140 | R 7.0 | 14.0 | 14 | 14 | 71 |
| G9624160 | R 8.0 | 16.0 | 16 | 16 | 76 |
| G9624180 | R 9.0 | 18.0 | 18 | 18 | 76 |
| G9624200 | R 10.0 | 20.0 | 20 | 20 | 82 |

| Mill Dia. Tolerance(mm) | Shank Dia. Tolerance |
|-------------------------|----------------------|
| 0~-0.03 | h6 |

◎ : Excellent ○ : Good

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



K-2 CARBIDE END MILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE

HSS

CBN
END MILLS

i-Xmill
END MILLS

X5070
END MILLS

X-POWER
END MILLS

JET-POWER
END MILLS

V7 Mill INOX
END MILLS

V7 Mill STEEL
END MILLS

ALU-POWER
END MILLS

D-POWER
END MILLS

K-2 CARBIDE
END MILLS

GENERAL
CARBIDE
END MILLS

TANK-POWER
END MILLS

GENERAL
HSS
END MILLS

MILLING
CUTTERS

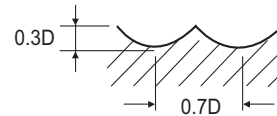
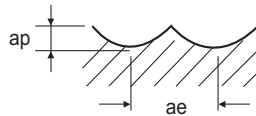
TECHNICAL
DATA

CARBIDE, 2 FLUTE BALL NOSE VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS

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

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | CARBON STEELS ALLOY STEELS TOOL STEELS | | HARDENED STEELS | | CAST IRON | | ALUMINUM ALLOYS | |
|----------|--|------|--|------|-------------------------|------|-----------|------|-----------------|------|
| HARDNESS | ~ HRc 30 | | HRc 30 ~ HRc 45 | | HRc 45 ~ HRc 50 | | | | | |
| STRENGTH | ~1000N/mm ² | | 1000~1500N/mm ² | | 1500N/mm ² ~ | | | | | |
| DIAMETER | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 2.0 | 12350 | 640 | 9150 | 415 | 4000 | 125 | 10500 | 220 | 30800 | 395 |
| 3.0 | 11400 | 575 | 8550 | 390 | 3800 | 125 | 7050 | 230 | 20500 | 395 |
| 4.0 | 8950 | 630 | 7150 | 450 | 3600 | 150 | 5150 | 285 | 15400 | 395 |
| 5.0 | 7800 | 700 | 6200 | 490 | 3100 | 150 | 4150 | 330 | 12100 | 470 |
| 6.0 | 7250 | 870 | 5900 | 705 | 2700 | 160 | 3400 | 360 | 10300 | 470 |
| 8.0 | 6100 | 1090 | 4900 | 785 | 2050 | 190 | 2500 | 460 | 7900 | 540 |
| 10.0 | 5450 | 1330 | 4350 | 870 | 1750 | 190 | 2050 | 460 | 6150 | 540 |
| 12.0 | 4990 | 1500 | 3950 | 950 | 1500 | 210 | 1750 | 460 | 5150 | 630 |
| 14.0 | 4530 | 1495 | 3600 | 925 | 1300 | 210 | 1400 | 460 | 4300 | 630 |
| 16.0 | 4085 | 1470 | 3200 | 905 | 1150 | 210 | 1300 | 460 | 3850 | 540 |
| 18.0 | 3800 | 1425 | 3000 | 890 | 1050 | 210 | 1100 | 460 | 3400 | 540 |
| 20.0 | 3550 | 1425 | 2800 | 885 | 950 | 210 | 1050 | 420 | 2950 | 540 |

ap : D1~D6=0.2mm
D8~D20=0.3mm
ae : 0.2D



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

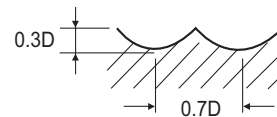
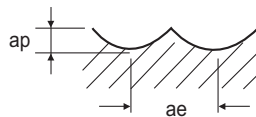
RPM = rev./min. FEED = mm/min.

CARBIDE, 4 FLUTE BALL NOSE VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS

G9634 SERIES

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | CARBON STEELS ALLOY STEELS TOOL STEELS | | HARDENED STEELS | | CAST IRON | | ALUMINUM ALLOYS | |
|----------|--|------|--|------|-------------------------|------|-----------|------|-----------------|------|
| HARDNESS | ~ HRc 30 | | HRc 30 ~ HRc 45 | | HRc 45 ~ HRc 50 | | | | | |
| STRENGTH | ~1000N/mm ² | | 1000~1500N/mm ² | | 1500N/mm ² ~ | | | | | |
| DIAMETER | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 2.0 | 13300 | 680 | 10000 | 405 | 4100 | 135 | 10500 | 330 | 30800 | 605 |
| 3.0 | 11500 | 870 | 8550 | 585 | 3850 | 190 | 7050 | 340 | 20500 | 605 |
| 4.0 | 8950 | 950 | 7150 | 680 | 3600 | 230 | 5150 | 430 | 15400 | 605 |
| 5.0 | 7800 | 1045 | 6200 | 745 | 3100 | 230 | 4150 | 495 | 12100 | 715 |
| 6.0 | 7250 | 1330 | 5900 | 1090 | 2700 | 235 | 3400 | 540 | 10300 | 715 |
| 8.0 | 6100 | 1660 | 4900 | 1185 | 2100 | 285 | 2500 | 680 | 7900 | 820 |
| 10.0 | 5450 | 1950 | 4350 | 1330 | 1750 | 290 | 2050 | 680 | 6150 | 820 |
| 12.0 | 4985 | 2230 | 4000 | 1425 | 1500 | 320 | 1750 | 680 | 5150 | 945 |
| 14.0 | 4500 | 2230 | 3600 | 1425 | 1300 | 320 | 1400 | 700 | 4300 | 945 |
| 16.0 | 4085 | 2230 | 3200 | 1380 | 1100 | 320 | 1300 | 700 | 3850 | 820 |
| 18.0 | 3800 | 2135 | 3000 | 1330 | 1050 | 320 | 1100 | 700 | 3400 | 820 |
| 20.0 | 3550 | 2135 | 2800 | 1330 | 950 | 320 | 1050 | 630 | 2950 | 820 |

ap : D1~D6=0.2mm
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RPM = rev./min. FEED = mm/min.