



K-2 CARBIDE END MILLS

4 Flute Multiple Helix Short & Long Length

Designed for semi-roughing application by optimizing the chip formation and evacuation
Also optimized to reduce vibration and achieve excellent surface finish

SHORT LENGTH

unit: mm

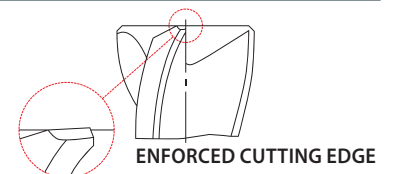
EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
PLAIN	FLAT					
G9H73030N	G9H74030N	3.0	6	5	50	0.10
G9H73040N	G9H74040N	4.0	6	8	54	0.15
G9H73050N	G9H74050N	5.0	6	9	54	0.15
G9H73060N	G9H74060N	6.0	6	10	54	0.20
G9H73080N	G9H74080N	8.0	8	12	58	0.20
G9H73100N	G9H74100N	10.0	10	14	66	0.30
G9H73120N	G9H74120N	12.0	12	16	73	0.35
G9H73160N	G9H74160N	16.0	16	22	82	0.40
G9H73200N	G9H74200N	20.0	20	26	92	0.50

LONG LENGTH

unit: mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer
PLAIN	FLAT					
G9H75030N	G9H76030N	3.0	6	8	57	0.10
G9H75040N	G9H76040N	4.0	6	11	57	0.15
G9H75050N	G9H76050N	5.0	6	13	57	0.15
G9H75060N	G9H76060N	6.0	6	13	57	0.20
G9H75080N	G9H76080N	8.0	8	19	63	0.20
G9H75100N	G9H76100N	10.0	10	22	72	0.30
G9H75120N	G9H76120N	12.0	12	26	83	0.35
G9H75160N	G9H76160N	16.0	16	32	92	0.40
G9H75200N	G9H76200N	20.0	20	38	104	0.50

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



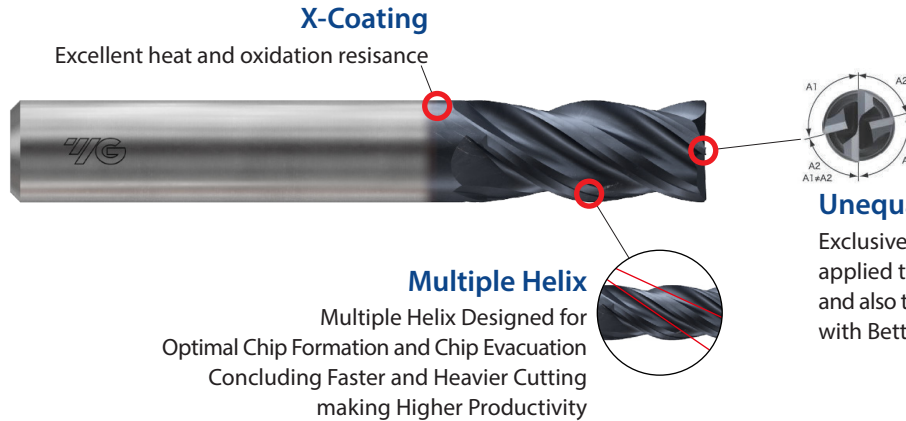
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Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

ISO	VDI 3323	Material Description	Side		Slotting		Parameter	Diameter (Ø)									
			Ae	Ap	Ae	Ap		3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1-4	Non-alloy steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	106	106	106	106	106	118	118	118	118	
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	
							RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869	
							FEED	228	270	298	361	459	571	588	497	487	
	5		0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	75	75	75	75	75	82	82	82	82	
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	
							RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302	
							FEED	158	189	210	256	322	396	410	347	340	
	6-7	Low alloy steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	106	106	106	106	106	118	118	118	118	
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	
							RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869	
							FEED	228	270	298	361	459	571	588	497	487	
	8-9		0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	75	75	75	75	75	82	82	82	82	
							fz	0.005	0.008	0.011	0.016	0.027	0.038	0.047	0.053	0.065	
							RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302	
							FEED	158	189	210	256	322	396	410	347	340	
10-11.1	High alloyed steel, and tool steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	45	45	45	45	45	49	49	49	49		
						fz	0.003	0.006	0.008	0.011	0.019	0.027	0.032	0.037	0.045		
						RPM	4753	3563	2849	2380	1785	1561	1302	973	777		
						FEED	56	84	91	105	137	168	168	144	140		
M	12-13		0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	104	104	104	104	104	104	104	104	104	
							fz	0.004	0.006	0.009	0.013	0.022	0.034	0.039	0.045	0.055	
							RPM	10990	8246	6594	5495	4123	3297	2751	2058	1652	
	14.1	Stainless steel	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	74	74	74	74	74	74	74	74	74	
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.077	
							RPM	7875	5908	4725	3934	2954	2359	1967	1477	1183	
	14.2		0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	67	67	67	67	67	67	67	67	67	
							fz	0.005	0.008	0.013	0.018	0.028	0.048	0.055	0.062	0.076	
							RPM	7056	5292	4235	3528	2646	2114	1764	1323	1057	
	K	15-20	Grey cast iron	0.3D	1.5D (1.2D)	1.0D	0.8D	Vc	78	78	78	78	78	86	86	86	86
								fz	0.006	0.01	0.014	0.02	0.034	0.048	0.058	0.065	0.081
								RPM	8316	6237	4991	4158	3122	2744	2282	1715	1372
						FEED	200	249	280	333	424	525	529	445	445		

*() : Short length

