



For European Market Only

W/G

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



ENFORCED CUTTING EDGE

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

G9H75030N	3X6X8X57	10.26 €
G9H75040N	4X6X11X57	10.26 €
G9H75050N	5X6X13X57	10.26 €
G9H75060N	6X6X13X57	10.26 €
G9H75080N	8X8X19X63	14.70 €
G9H75100N	10X10X22X72	24.48 €
G9H75120N	12X12X26X83	31.29 €
G9H75160N	16X16X32X92	59.14 €
G9H75200N	20X20X38X104	114.08 €

X-Coating
Excellent heat and oxidation resistance

Multiple Helix
Multiple Helix Designed for Optimal Chip Formation and Chip Evacuation Concluding Faster and Heavier Cutting making Higher Productivity

Unequal Index
Exclusively Designed Unique Geometry applied to Reduce Vibration and also to achieve Excellent Chip Evacuation with Better Surface Finish

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
	5		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869
							FEED	228	270	298	361	459	571	588	497	487
	6-7	Low alloy steel	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
	8-9		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	7945	5957	4767	3976	2982	2604	2170	1631	1302
							FEED	158	189	210	256	322	396	410	347	340
	10-11	High alloyed steel and tool 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
12-13		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	11291	8470	6776	5642	4235	3745	3122	2338	1869	
						FEED	228	270	298	361	459	571	588	497	487	
M	12-13	Stainless 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
	14.1		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	4753	3563	2849	2380	1785	1561	1302	973	777
							FEED	56	84	91	105	137	168	168	144	140
	14.2		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
	14.1		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	10990	8246	6594	5495	4123	3297	2751	2058	1652
							FEED	175	200	238	287	364	448	427	371	364
	14.2		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
14.1		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	7875	5908	4725	3934	2954	2359	1967	1477	1183	
						FEED	158	189	245	284	329	455	434	368	364	
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	
14.1		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	7056	5292	4235	3528	2646	2114	1764	1323	1057	
						FEED	140	168	221	256	298	406	389	329	322	
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	
15-20		0.3D	1.5D (1.2D)	1.0D	0.8D	RPM	8316	6237	4991	4158	3122	2744	2282	1715	1372	
						FEED	200	249	280	333	424	525	529	445	445	

*(): Short length

