# K-2 END MILLS

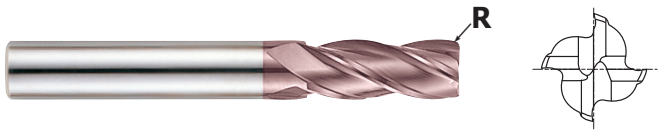
PLAIN SHANK **G9B85 SERIES**

## CARBIDE, 4 FLUTE LONG REACH CORNER RADIUS

**VOLLHARTMETALL, 4 SCHNEIDEN GROSSE REICHWEITE ECKENRADIUS**
**FRAISE CARBURE, 4 DENTS, TORIQUE LONGUE PORTÉE**
**4 TAGLIENTI, SERIE LUNGA, TORICA**

- 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.







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| Recommended ToolHolder | Flat Shank | Plain Shank |
|---|---|---|
| ◎ | END MILL HOLDER | HYDRAULIC CHUCK POWER MILLING CHUCK |
| ◎ | - | SHRINK FIT HOLDER |
| ○ | - | ER COLLET CHUCK SK SLIM CHUCK |

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 |
| Recommend | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ |

| 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 |
| Recommend | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | | | | | | | | | ○ | |


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