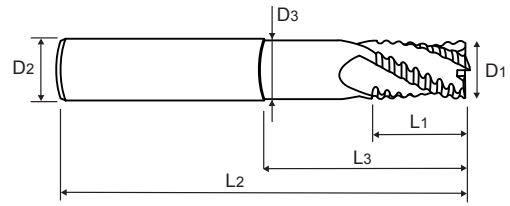
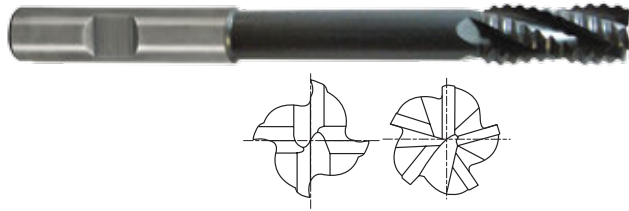


PREMIUM HSS-PM, MULTI FLUTE ROUGHING WITH NECK - COARSE

- ▶ High chip removal and minimizing breakages of cutting edges.
- ▶ Designed to machine carbon steels, alloyed steels, stainless steels
- ▶ YG-1's new developed TANK-POWER Coating suitable for high speed cutting



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	No. of Flute
UNCOATED	TANK-POWER COATED	D1(js12)	D2(h6)	L1	L3	L2	D3	
E9E43100	GAE43100	10.0	10.0	22	69	110	8.5	4
E9E43120	GAE43120	12.0	12.0	26	78	125	10.5	4
E9E43160	GAE43160	16.0	16.0	32	87	138	14	4
E9E43200	GAE43200	20.0	20.0	38	108	160	18	4
E9E43250	GAE43250	25.0	25.0	45	155	216	23	5

Tolerances according to DIN 7160 & 7161

Tolerance range in μm						
Nominal-Diameter in mm						
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	$\begin{matrix} 0 \\ -6 \end{matrix}$	$\begin{matrix} 0 \\ -8 \end{matrix}$	$\begin{matrix} 0 \\ -9 \end{matrix}$	$\begin{matrix} 0 \\ -11 \end{matrix}$	$\begin{matrix} 0 \\ -13 \end{matrix}$	$\begin{matrix} 0 \\ -16 \end{matrix}$

Cutting Condition

E9E43 Series

MATERIAL	STRUCTURAL STEELS CARBON STEELS				STRUCTURAL STEELS CARBON STEELS CAST IRONS				CARBON STEELS ALLOY STEELS TOOL STEELS				PREHARDENED STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS			
HARDNESS					~ HRc 20				HRc 20~30				HRc 30~40							
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
10	1300	220	41	0.042	1000	165	32	0.041	710	105	23	0.037	600	85	19	0.035	660	100	21	0.038
12	1100	220	41	0.050	820	175	32	0.053	600	120	23	0.050	500	95	19	0.048	560	125	21	0.056
16	820	220	41	0.067	640	175	32	0.068	450	120	23	0.067	370	95	19	0.064	420	125	21	0.074
20	660	225	41	0.085	510	175	32	0.086	360	120	23	0.083	300	95	19	0.079	330	125	21	0.095
25	540	220	41	0.081	400	165	32	0.083	280	115	23	0.082	240	95	19	0.079	270	120	21	0.089

GAE43 Series

MATERIAL	STRUCTURAL STEELS CARBON STEELS				STRUCTURAL STEELS CARBON STEELS CAST IRONS				CARBON STEELS ALLOY STEELS TOOL STEELS				PREHARDENED STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS			
HARDNESS					~ HRc 20				HRc 20~30				HRc 30~40							
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
10	1900	355	60	0.047	1500	270	47	0.045	1050	165	33	0.039	890	135	28	0.038	950	145	30	0.038
12	1600	355	60	0.055	1200	280	47	0.058	900	195	33	0.054	740	155	28	0.052	800	175	30	0.055
16	1200	355	60	0.074	950	280	47	0.074	660	195	33	0.074	550	155	28	0.070	600	175	30	0.073
20	960	360	60	0.094	760	280	47	0.092	530	195	33	0.092	440	155	28	0.088	480	175	30	0.091
25	790	355	60	0.090	600	270	47	0.090	420	185	33	0.088	360	155	28	0.086	390	170	30	0.087

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

