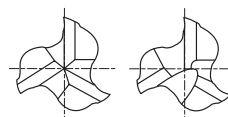




FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN
FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

PREMIUM HSS-PM, 3 FLUTE STUB LENGTH
PREMIUM HSS-PM, 3 SCHNEIDEN EXTRA KURZ

- ▶ Well balanced web design to minimize deflection and chattering.
- ▶ 3 flute design possess the advantage of 2 flute and 4 flute end mill.
- ▶ YG-1's new developed TANK-POWER Coating suitable for high speed cutting.
- ▶ Verstärkter Kern zur Erhöhung der Stabilität.
- ▶ 3 Schneiden Design besitzt die Vorteile von 2- bzw 4 Schneiden Fräsem.
- ▶ Neuentwickelte Beschichtung für Hochgeschwindigkeitsfräsen.



up to Ø1mm over Ø1mm



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TANK-POWER COATED	e8	h6		
E9942010	GA942010	1.0	6	2.5	47
E9942020	GA942020	2.0	6	4	48
E9942030	GA942030	3.0	6	5	49
E9942040	GA942040	4.0	6	7	51
E9942050	GA942050	5.0	6	8	52
E9942060	GA942060	6.0	6	8	52
E9942070	GA942070	7.0	10	10	60
E9942080	GA942080	8.0	10	11	61
E9942090	GA942090	9.0	10	11	61
E9942100	GA942100	10.0	10	13	63
E9942120	GA942120	12.0	12	16	73
E9942140	GA942140	14.0	12	16	73
E9942160	GA942160	16.0	16	19	79
E9942180	GA942180	18.0	16	19	79
E9942200	GA942200	20.0	20	22	88
E9942220	GA942220	22.0	20	22	88
E9942250	GA942250	25.0	25	26	102

Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

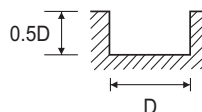
Tolerance range in μm / Toleranzwerte in μm					
Nominal-Diameter in mm / Nennmaßbereich in mm					
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30
e8	— 14 — 28	— 20 — 38	— 25 — 47	— 32 — 59	— 40 — 73
h6	0 — 6	0 — 8	0 — 9	0 — 11	0 — 13

◎ : Excellent ○ : Good

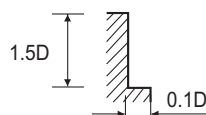
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
◎	◎	○				○		◎		○		

**PREMIUM HSS-PM, 3 FLUTE - SLOTTING
PREMIUM HSS-PM, 3 SCHNEIDEN - NUTENFRÄSEN****GA942, GAA30** SERIES

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
HARDNESS			~ HRC20		HRC20 ~ HRC30		HRC30 ~ HRC35		HRC35 ~ HRC40	
STRENGTH	~ 500N/mm ²		500 ~ 800N/mm ²		800 ~ 1000N/mm ²		1000 ~ 1100N/mm ²		1100 ~ 1300N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	6500	70	5500	55	4800	45	3000	35	1900	28
3.0	4600	102	3900	85	3350	52	2200	45	1800	45
4.0	4300	140	3600	115	3000	80	1900	52	1500	55
5.0	3800	160	3200	130	2600	92	1700	62	1300	55
6.0	3350	230	2800	190	2300	140	1450	92	1100	75
8.0	2600	240	2200	210	1800	150	1150	102	890	85
10.0	100	250	1800	210	1400	160	890	115	680	92
12.0	1800	275	1450	230	1200	170	740	115	580	92
14.0	1600	250	1350	220	1000	160	660	110	500	85
16.0	1350	240	1150	210	890	150	560	102	440	85
18.0	1150	240	890	190	790	150	500	95	400	80
20.0	950	230	790	190	700	140	440	92	360	80
22.0	840	230	730	195	600	150	400	95	315	85
25.0	750	240	630	210	490	160	360	102	250	85

RPM = rev./min.
FEED = mm/min.**PREMIUM HSS-PM, 3 FLUTE - SIDE CUTTING
PREMIUM HSS-PM, 3 SCHNEIDEN - SEITENFRÄSEN****GA942, GAA30** SERIES

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
HARDNESS			~ HRC20		HRC20 ~ HRC30		HRC30 ~ HRC35		HRC35 ~ HRC40	
STRENGTH	~ 500N/mm ²		500 ~ 800N/mm ²		800 ~ 1000N/mm ²		1000 ~ 1100N/mm ²		1100 ~ 1300N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	8200	100	6800	80	5500	65	3800	50	2400	40
3.0	5800	145	4800	120	3800	75	2700	65	2200	65
4.0	5200	185	4400	155	3500	110	2300	75	1900	75
5.0	4700	210	4000	175	2900	125	2000	85	1700	75
6.0	4200	300	3600	250	2600	190	1800	125	1500	100
8.0	3200	330	2600	270	2000	200	1300	140	1100	115
10.0	2500	350	2100	290	1600	210	1000	150	890	125
12.0	2100	350	1800	300	1400	230	900	150	740	125
14.0	1800	350	1500	285	1150	210	780	140	630	120
16.0	1600	330	1300	275	1000	200	660	140	550	115
18.0	1350	310	1150	265	890	195	580	130	500	110
20.0	1250	300	1050	255	780	190	520	125	440	110
22.0	1150	310	950	265	740	195	470	130	400	110
25.0	1000	330	840	275	630	210	420	135	360	120

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