



GYG72 SERIES
GYF99 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE

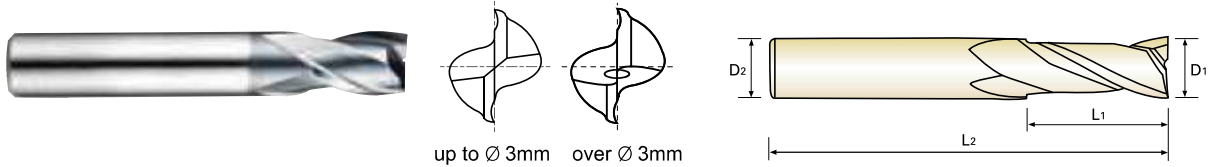
HSS

PM60, 2 FLUTE SHORT LENGTH (Center Cut)

PM60, 2 Schneiden, kurz, Zentrumschnitt

Revêtue YG-AICrN - PM60, 2 dents, série courte (Coupe au centre)

Rivestita PM60, 2 TAGLIENTI SERIE CORTA (Tagliante al centro)



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	D1	D2	L1	L2
GYG72010	GYF99010	1.0	6	2.5	47
GYG72020	GYF99020	2.0	6	4	48
GYG72030	GYF99030	3.0	6	5	49
GYG72040	GYF99040	4.0	6	7	51
GYG72050	GYF99050	5.0	6	8	52
GYG72060	GYF99060	6.0	6	8	52
GYG72070	GYF99070	7.0	8	10	60
GYG72080	GYF99080	8.0	8	11	61
GYG72090	GYF99090	9.0	10	11	61
GYG72100	GYF99100	10.0	10	13	63
GYG72120	GYF99120	12.0	12	16	73
GYG72140	GYF99140	14.0	12	16	73
GYG72160	GYF99160	16.0	16	19	79
GYG72180	GYF99180	18.0	16	19	79
GYG72200	GYF99200	20.0	20	22	88
GYG72220	GYF99220	22.0	20	22	88
GYG72250	GYF99250	25.0	25	26	102

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 ~ -0.03	h6

© : Excellent ○ : Good

P				H	M	K	N					S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70									
◎	◎	○	○		◎	◎	○						

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR TYPE END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS END MILLS

V7 MILL INOX END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

D-POWER CFRP END MILLS

ROUTERS

CRX S END MILLS

K-2 END MILLS

GENERAL CARBIDE END MILLS

ONLY ONE COATED PM60 END MILLS

TANK-POWER END MILLS

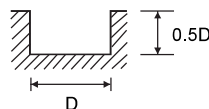
GENERAL HSS END MILLS

MILLING CUTTERS

TECHNICAL DATA

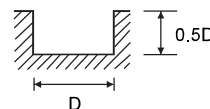
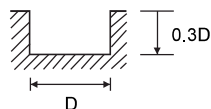
PM60, 2 FLUTE SHORT (Center Cut)
PM60, 2 Schneiden, kurz, Zentrumschnitt
GYG72, GYF99 SERIES

MATERIAL	P															
	STRUCTURAL STEELS CARBON STEELS				STRUCTURAL STEELS CARBON STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				PREHARDENED STEELS ALLOY STEELS TOOL STEELS			
HARDNESS					~ HRC20				HRc20 ~ HRc30				HRc30 ~ HRc35			
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1100N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	8400	140	53	0.008	7080	110	44	0.008	5880	95	37	0.008	3780	80	24	0.011
3.0	6000	190	57	0.016	4920	160	46	0.016	4020	140	38	0.017	2760	95	26	0.017
4.0	5160	275	65	0.027	4320	210	54	0.024	3780	190	48	0.025	2400	110	30	0.023
5.0	4680	305	74	0.033	3900	240	61	0.031	3120	220	49	0.035	2040	120	32	0.029
6.0	4200	320	79	0.038	3480	250	66	0.036	2760	230	52	0.042	1740	130	33	0.037
8.0	3120	330	78	0.053	2640	290	66	0.055	2160	240	54	0.056	1380	140	35	0.051
10.0	2520	360	79	0.071	2160	320	68	0.074	1740	275	55	0.079	1080	150	34	0.069
12.0	2160	330	81	0.076	1740	290	66	0.083	1380	250	52	0.091	890	140	34	0.079
14.0	1920	320	84	0.083	1500	250	66	0.083	1200	235	53	0.098	760	130	33	0.086
16.0	1620	320	81	0.099	1380	235	69	0.085	1070	215	54	0.100	670	120	34	0.090
18.0	1380	290	78	0.105	1140	235	64	0.103	950	190	54	0.100	600	120	34	0.100
20.0	1140	265	72	0.116	940	200	59	0.106	840	180	53	0.107	530	110	33	0.104
22.0	1010	220	70	0.109	850	180	59	0.106	720	150	50	0.104	480	95	33	0.099
25.0	900	185	71	0.103	760	170	60	0.112	590	140	46	0.119	430	90	34	0.105



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

MATERIAL	P								M				K			
	ALLOY STEELS TOOL STEELS				ALLOY STEELS TOOL STEELS				STAINLESS STEELS				CAST IRON			
HARDNESS	HRc35 ~ HRc40				HRc40 ~ HRc45											
STRENGTH	1100 ~ 1300N/mm ²				1300 ~ 1400N/mm ²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	2400	50	15	0.010	1680	35	11	0.010	2640	55	17	0.010	7080	110	44	0.008
3.0	2160	75	20	0.017	1510	55	14	0.018	2380	85	22	0.018	4920	160	46	0.016
4.0	1920	90	24	0.023	1340	65	17	0.024	2110	100	27	0.024	4320	210	54	0.024
5.0	1620	90	25	0.028	1130	65	18	0.029	1780	100	28	0.028	3900	240	61	0.031
6.0	1380	100	26	0.036	970	70	18	0.036	1520	110	29	0.036	3480	250	66	0.036
8.0	1070	100	27	0.047	750	70	19	0.047	1180	110	30	0.047	2640	290	66	0.055
10.0	840	120	26	0.071	590	85	19	0.072	920	130	29	0.071	2160	320	68	0.074
12.0	700	100	26	0.071	490	70	18	0.071	770	110	29	0.071	1740	290	66	0.083
14.0	600	95	26	0.079	420	65	18	0.077	660	105	29	0.080	1500	250	66	0.083
16.0	530	95	27	0.090	370	65	19	0.088	580	105	29	0.091	1380	235	69	0.085
18.0	480	90	27	0.094	340	65	19	0.096	530	100	30	0.094	1140	235	64	0.103
20.0	430	85	27	0.099	300	60	19	0.100	470	95	30	0.101	940	200	59	0.106
22.0	380	65	26	0.086	270	45	19	0.083	420	70	29	0.083	850	180	59	0.106
25.0	300	60	24	0.100	210	40	16	0.095	330	65	26	0.098	760	170	60	0.112



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