

YG SPEED FREEK END MILLS

EK191 SERIES FLAT SHANK

HSS

T15, 3 FLUTE 42° HELIX REGULAR LENGTH ROUGHING for ALUMINUM

- ▶ High performance metal removal in aluminum alloys.
- ▶ Corner radius against chipping



T15
ALU
3
42°
FLAT
P.732

◆ U.S.A Stock

■ SQUARE Unit : Inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiCN COATED				
66515	66515 PC	1/2	1/2	1-1/4	3-1/4
66519	66519 PC	5/8	5/8	1-5/8	3-3/4
66524	66524 PC	3/4	3/4	1-5/8	3-7/8
66540	66540 PC	1	1	2	4-1/2
66541	66541 PC	1-1/4	1-1/4	2	4-1/2
66542	66542 PC	1-1/2	1-1/4	2	4-1/2
* 66543	* 66543 PC	2	2	2	5-3/4

* Combination Shank

T15
ALU
3
42°
±.001
FLAT
P.732

◆ U.S.A Stock

■ with CORNER RADIUS Unit : Inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiCN COATED	R				
66903	66903 PC	R .060	3/4	3/4	1-5/8	3-7/8
66904	66904 PC	R .090	3/4	3/4	1-5/8	3-7/8
66905	66905 PC	R .120	3/4	3/4	1-5/8	3-7/8
66906	66906 PC	R .060	1	1	2	4-1/2
66907	66907 PC	R .090	1	1	2	4-1/2
66908	66908 PC	R .120	1	1	2	4-1/2
66909	66909 PC	R .060	1-1/4	1-1/4	2	4-1/2
66910	66910 PC	R .090	1-1/4	1-1/4	2	4-1/2
66911	66911 PC	R .120	1-1/4	1-1/4	2	4-1/2

■ The TiN coated, or TiAlN coated is available on your request.

Mill Dia. Tolerance (inch)	
up to 1	0~+.0030
over 1	0~+.0060

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
									◎			

CBN END MILL

i-Xmill END MILL

X5070 END MILLS

4G MILLS END MILLS

X-SPEED ROUGHER END MILLS

X-POWER END MILLS

JET-POWER END MILLS

V7 Mill STEEL END MILLS

V7 Mill INOX END MILLS

ALU-POWER END MILLS

D-POWER END MILLS

STANDARD CARBIDE END MILLS

TANK-POWER END MILLS

STANDARD COBALT & HSS END MILLS

TECHNICAL DATA



**SPEED FREEK
END MILLS**

RECOMMENDED CUTTING CONDITIONS

CBN
END MILL

i-Xmill
END MILL

X5070
END MILLS

4G MILLS
END MILLS

X-SPEED
ROUGHER
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STANDARD
CARBIDE
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TANK-POWER
END MILLS

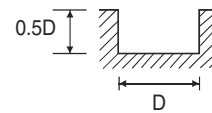
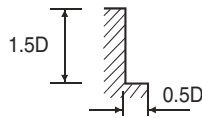
STANDARD
COBALT
& HSS
END MILLS

TECHNICAL
DATA

PREMIUM HSS-PM, 3 FLUTE 42° HELIX ROUGHING TiAIN COATED

EP922, EP924 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY			
	DIAMETER	RPM	FEED	FEED
12.0	2800	16.1	2800	21.7
16.0	2200	18.3	2200	24.6
20.0	1700	20.7	1700	27.6
25.0	1400	18.3	1400	24.6
32.0	1100	20.7	1100	27.6



※ The FEED, in long & long reach types, should be reduced by around 50%

RPM = rev./min.
FEED = inch/min.

SPEED FREEK

**YG T-15 3 FLUTE ALUMINUM ROUGHER
SPEEDS & FEEDS**

MATERIAL	UNCOATED	TiCN	CHIP LOAD PER TOOTH & CUTTING DIAMETER				
	SFM	SFM	1/2	3/4	1.00	1.25	2.00
ALUMINUM [SOFT]	250-500	400-2,500	.005	.007	.010	.012	.015
AIRCRAFT ALUMINUM [UNDER 10% SILICON]	250-750	500-3,250	.005	.007	.010	.012	.015

3/4 DIA. / TiCN COATED / 10,186 RPM [2,000 SFM] @ 213 IPM

SFM	$0.262 \times \text{CUTTER DIA} \times \text{RPM}$	FPT	$\frac{\text{IPM}}{N \times \text{RPM}}$
RPM	$3.82 \times \frac{\text{SFM}}{\text{CUTTER DIA}}$	IPR	$\frac{\text{IPM}}{\text{RPM}}$
IPM	$\text{FPT} \times N \times \text{RPM}$	CUTTING TIME	$\frac{\text{LENGTH OF CUT}}{\text{IPM}}$

SFM = SURFACE FEET PER MINUTE
RPM = REVOLUTIONS PER MINUTE
N = NUMBER OF TEETH
IPR = INCHES PER REVOLUTION
IPM = INCHES PER MINUTE
FPT = FEED PER TOOTH