

YG SPEED FREEK END MILLS

EK192 SERIES FLAT SHANK

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

► High performance metal removal in aluminum alloys.



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				
67515	67515 PC	1/2	1/2	2	4
67519	67519 PC	5/8	5/8	2-1/2	4-5/8
67524	67524 PC	3/4	3/4	3	5-1/4
67540	67540 PC	1	1	4	6-1/2
67541	67541 PC	1-1/4	1-1/4	4	6-1/2
67542	67542 PC	1-1/2	1-1/4	4	6-1/2
* 67543	* 67543 PC	2	2	4	7-3/4
67544	67544 PC	1-1/4	1-1/4	6	8-1/2
67545	67545 PC	1-1/2	1-1/4	6	8-1/2
* 67546	* 67546 PC	2	2	6	9-3/4

■ with NECK

* Combination Shank

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
UNCOATED	TiCN COATED						
EK10482	EK10482C	3/4	3/4	1-1/2	3	5-1/4	.705
EK10483	EK10483C	3/4	3/4	1-1/2	4	6-1/4	.705
EK10642	EK10642C	1	1	1-1/2	3	5-1/2	.950
EK10643	EK10643C	1	1	2	4	6-1/2	.950
EK10644	EK10644C	1	1	2	6	8-1/2	.950
EK11601	EK11601C	1-1/4	1-1/4	2	4	6-1/2	1.200
EK11602	EK11602C	1-1/4	1-1/4	2	6	8-1/2	1.200

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

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

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							
									◎			

◎ : Excellent ○ : Good

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

CARBIDE

HSS



**SPEED FREEK
END MILLS**

EK192 SERIES

FLAT SHANK

**T15, 3 FLUTE 42° HELIX LONG LENGTH ROUGHING
with CORNER RADIUS for ALUMINUM**

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



T15
ALU
3
42°
±.001
FLAT
P.732

◆ U.S.A Stock

Unit : Inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiCN COATED	R				
67904	67904 PC	R .060	3/4	3/4	3	5-1/4
67905	67905 PC	R .090	3/4	3/4	3	5-1/4
67906	67906 PC	R .120	3/4	3/4	3	5-1/4
67907	67907 PC	R .060	1	1	4	6-1/2
67908	67908 PC	R .090	1	1	4	6-1/2
67909	67909 PC	R .120	1	1	4	6-1/2
67910	67910 PC	R .060	1-1/4	1-1/4	4	6-1/2
67911	67911 PC	R .090	1-1/4	1-1/4	4	6-1/2
67912	67912 PC	R .120	1-1/4	1-1/4	4	6-1/2
67913	67913 PC	R .060	1-1/4	1-1/4	6	8-1/2
67914	67914 PC	R .090	1-1/4	1-1/4	6	8-1/2
67915	67915 PC	R .120	1-1/4	1-1/4	6	8-1/2

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

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

◎ : 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							
									◎			



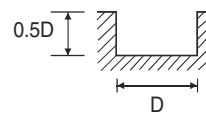
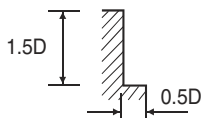
SPEED FREEK END MILLS

RECOMMENDED CUTTING CONDITIONS

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