

YU-XP19 INCH / METRIC



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X-POWER **PRO**

PERFORMANCE UPGRADE
Y-COATED SOLID CARBIDE END MILLS
for Pre-Hardened Steels up to HRC55
for Mold & Die
for Dry & Wet Cutting





X-POWER ^{PRO}

Performance Upgrade

- Achieved from several tests to apply the most optimal technology
- New coating, raw material, honing technology

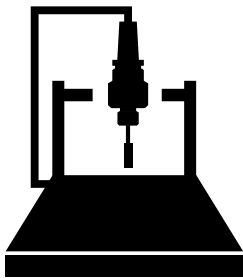
Work Material

- Pre-Hardened Steels up to HRc 55, and Cast Iron



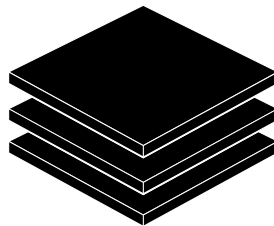
For Mold & Die Industries

- Plastic injection, die casting, military parts, automotive parts, electronic parts, etc.



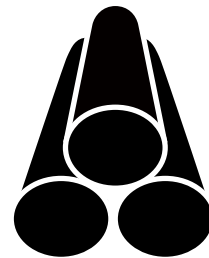
Honing

Advanced honing technology system made from YG-1



Coating

The optimal coating applied, chosen by several tests of different coating technologies



Raw Material

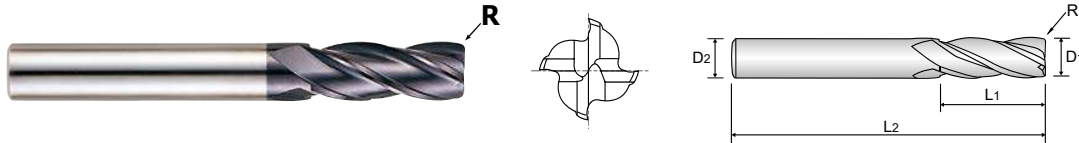
Made from high performance raw material with better quality



Y-COATED SOLID CARBIDE END MILLS 4 FLUTE STUB LENGTH CORNER RADIUS

GM639 PLAIN SHANK

- ▶ Designed to machine tool steel, alloy steel, mold steel and other high hardened materials.
- ▶ Superior workpiece finishes.
- ▶ Increased feed rate.



Mill Dia. Tolerance(inch)	Shank Dia. Tolerance
0 ~ -.0012	0 ~ -.0003

INCH

Unit : inch

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R (±.001)	D1	D2	L1	L2
GM639004	R.008	1/16	1/4	1/8	2-1/4
GM639008	R.01	1/8	1/4	1/4	2-1/4
GM639901	R.02	1/8	1/4	1/4	2-1/4
GM639012	R.01	3/16	1/4	3/8	2-1/2
GM639903	R.02	3/16	1/4	3/8	2-1/2
GM639904	R.03	3/16	1/4	3/8	2-1/2
GM639016	R.01	1/4	1/4	1/2	3
GM639905	R.02	1/4	1/4	1/2	3
GM639906	R.03	1/4	1/4	1/2	3
GM639020	R.02	5/16	5/16	1/2	3
GM639907	R.03	5/16	5/16	1/2	3
GM639908	R.06	5/16	5/16	1/2	3
GM639024	R.02	3/8	3/8	5/8	3
GM639910	R.03	3/8	3/8	5/8	3
GM639911	R.06	3/8	3/8	5/8	3
GM639912	R.09	3/8	3/8	5/8	3
GM639032	R.02	1/2	1/2	5/8	4
GM639913	R.03	1/2	1/2	5/8	4
GM639914	R.06	1/2	1/2	5/8	4
GM639915	R.09	1/2	1/2	5/8	4

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

◎ : Excellent ○ : Good



GM639, GM649, GM212

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE CORNER RADIUS - **SIDE CUTTING**

RPM = rev./min.

FEED = inch/min.

MATERIAL	P					
	"CARBON STEELS ALLOY STEELS CAST IRON"		"ALLOY STEELS TOOL STEELS"		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc50		HRc50 ~ HRc55	
STRENGTH	~ 1000N/mm ²		1000 ~ 1750N/mm ²		1750 ~ 2000N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
1/4	2890	9.4	2310	7.8	1510	3.6
5/16	2200	9.9	1740	7.8	1160	3.6
3/8	1850	9.9	1510	7.8	920	3.6
1/2	1510	7.8	1280	6.9	770	3.1
	