

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

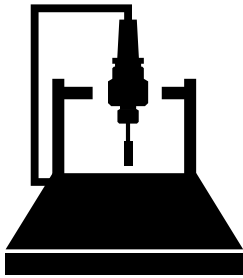
Work Material

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



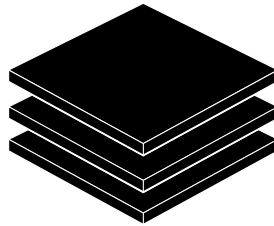
For Mold & Die Industries

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



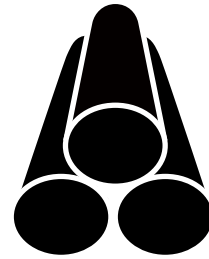
Honing

Advanced honing technology system made from YG-1



Coating

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



Raw Material

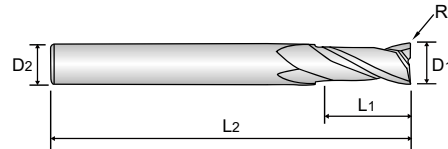
Made from high performance raw material with better quality



Y-COATED SOLID CARBIDE END MILLS 2 FLUTE LONG LENGTH CORNER RADIUS

GM818 PLAIN SHANK

- ▶ Designed to machine tool steels, alloy steels, mold steels and other hardened materials
- ▶ Superior workpiece finishes
- ▶ Increased feed rates



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

METRIC

Unit : mm

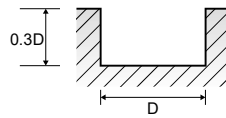
EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R	D1	D2	L1	L2
GM818911	R0.5	4.0	6	15	50
GM818060	R0.5	6.0	6	20	60
GM818901	R1.0	6.0	6	20	60
GM818080	R0.5	8.0	8	25	70
GM818902	R1.0	8.0	8	25	70
GM818100	R0.5	10.0	10	30	90
GM818905	R1.0	10.0	10	30	90
GM818908	R1.0	12.0	12	30	90

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

**GM818** Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH CORNER RADIUS - **SLOTING**RPM = rev./min. Vc = m/min.
FEED = mm/min. Fz = mm/tooth

MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~HRC45				HRC30~HRC45				HRC45~HRC55			
STRENGTH	~1500N/mm ²				1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
4.0	5900	185	75	0.016	3750	95	45	0.013	2370	30	30	0.006
5.0	5040	230	80	0.023	3190	110	50	0.017	2090	35	35	0.008
6.0	4350	275	80	0.032	2770	140	50	0.025	1800	35	35	0.010
8.0	3300	295	85	0.045	2090	140	55	0.033	1390	35	35	0.013
10.0	2770	295	85	0.053	1800	140	55	0.039	1110	35	35	0.016
12.0	2270	230	85	0.051	1530	125	60	0.041	920	35	35	0.019



MATERIAL	K			
	CAST IRON			
HARDNESS				
STRENGTH				
DIAMETER	RPM	FEED	Vc	Fz
4.0	5900	185	75	0.016
5.0	5040	230	80	0.023
6.0	4350	275	80	0.032
8.0	3300	295	85	0.045
10.0	2770	295	85	0.053
12.0	2270	230	85	0.051

