

YG D-POWER GRAPHITE END MILLS

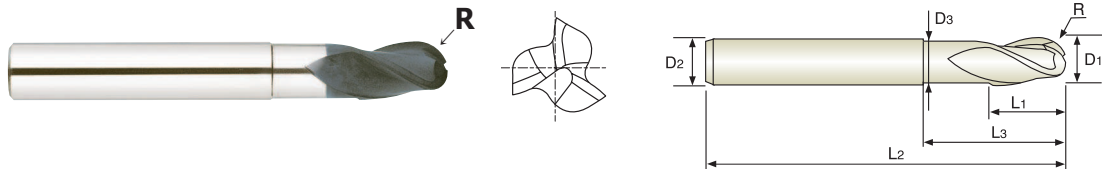
EI881 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 3 FLUTE SHORT LENGTH BALL NOSE with NECK
VOLLHARTMETALL, 3 SCHNEIDEN KURZ STIRNRADIUS mit ABGESETZTEM SCHAFTTETL

- ▶ Higher hardness of film and excellent wear-resistance increase the tool life surprisingly.
- ▶ Ultra fine film of YG-1's diamond coated carbide ball end mills ensure the smooth and excellent surface on work materials.
- ▶ High performance on graphite, wrought aluminum, bakelite, plastics, wood, brass etc. YG-1's diamond coated carbide ball end mills have good result for the machining of non-ferrous metals and non-metallic materials.

- ▶ Höhere Härte der Beschichtung und ausgezeichnete Verschleißfestigkeit verlängern die Standzeit beachtlich.
- ▶ Ultrafeiner Film auf YG-1 Diamant - beschichteten Hartmetall Schaffräser gewährleisten eine glatte und ausgezeichnete Oberflächengüte.
- ▶ Hohe Leistungsfähigkeit bei Graphit, Aluminium ohne Silicon, Bakelit, Plastik, Holz, Messing, etc. YG-1 Diamant - beschichtete Hartmetall Schaffräser zeigen gute Ergebnisse beim Bearbeiten von NE - Metallen und Nichtmetall - Werkstoffen.



MG HM 3 30° ±0.01 PLAIN P.1015

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.01)	D1	D2	L1	L3	L2	D3
EI881020	R1.0	2.0	6	3	5	60	1.9
EI881025	R1.25	2.5	6	4	6	60	2.4
EI881030	R1.5	3.0	6	4.5	6.5	60	2.8
EI881035	R1.75	3.5	6	5	7	65	3.2
EI881040	R2.0	4.0	6	6	8	65	3.7
EI881050	R2.5	5.0	6	7.5	10	65	4.6
EI881060	R3.0	6.0	6	9	12	75	5.6
EI881080	R4.0	8.0	8	12	25	75	7.4
EI881100	R5.0	10.0	10	15	30	80	9.4
EI881120	R6.0	12.0	12	18	36	90	11.4

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

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70									
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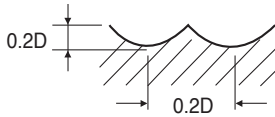
YG D-POWER GRAPHITE END MILLS

CARBIDE, 2 FLUTE MINIATURE BALL NOSE

VOLLHARTMETALL, 2 SCHNEIDEN MINI STIRNRADIUS

EI997, EIB93, EIB87 SERIES

MATERIAL	GRAPHITE			
DIAMETER	RPM	FEED	Vc	fz
R0.2 × 0.4	40000	600	50	0.008
R0.3 × 0.6	40000	800	75	0.010
R0.4 × 0.8	40000	960	100	0.012
R0.5 × 1.0	40000	1200	125	0.015
R0.6 × 1.2	40000	1440	150	0.018
R0.75 × 1.5	40000	1600	190	0.020
R1.0 × 2.0	40000	2000	250	0.025
R1.5 × 3.0	27000	2200	255	0.041
R2.0 × 4.0	20000	2900	250	0.073
R2.5 × 5.0	16000	2900	250	0.091
R3.0 × 6.0	14000	2900	265	0.104



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

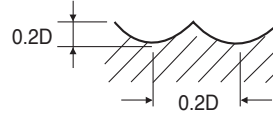
**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

CARBIDE, 2 FLUTE BALL NOSE

VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS

EI880, EI451, EI450 SERIES

MATERIAL	GRAPHITE			
DIAMETER	RPM	FEED	Vc	fz
R1.0 × 2.0	16000	800	100	0.025
R1.25 × 2.5	16000	1120	125	0.035
R1.5 × 3.0	16000	1450	150	0.045
R1.75 × 3.5	16000	1750	175	0.055
R2.0 × 4.0	16000	2100	200	0.066
R2.5 × 5.0	15500	2550	245	0.082
R3.0 × 6.0	15000	2950	285	0.098
R4.0 × 8.0	13000	3000	325	0.115
R5.0 × 10.0	11500	3050	360	0.133
R6.0 × 12.0	10500	3150	395	0.150



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

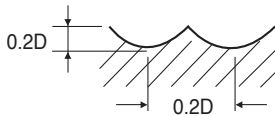
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CARBIDE, 3 FLUTE BALL NOSE

VOLLHARTMETALL, 3 SCHNEIDEN STIRNRADIUS

EI881 SERIES

MATERIAL	GRAPHITE			
DIAMETER	RPM	FEED	Vc	fz
R1.0 × 2.0	16000	1200	100	0.025
R1.25 × 2.5	16000	1700	125	0.035
R1.5 × 3.0	16000	2150	150	0.045
R1.75 × 3.5	16000	2650	175	0.055
R2.0 × 4.0	16000	3100	200	0.065
R2.5 × 5.0	15500	3800	245	0.082
R3.0 × 6.0	15000	4450	285	0.099
R4.0 × 8.0	13000	4500	325	0.115
R5.0 × 10.0	11500	4600	360	0.133
R6.0 × 12.0	10500	4750	395	0.151



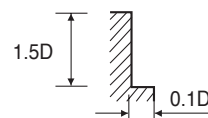
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CARBIDE, 2 FLUTE LONG LENGTH

VOLLHARTMETALL, 2 SCHNEIDEN LANG

EIB04 SERIES

MATERIAL	GRAPHITE			
DIAMETER	RPM	FEED	Vc	fz
0.4	40000	200	50	0.003
0.6	40000	350	75	0.004
0.8	40000	550	100	0.007
1.0	40000	700	125	0.009
1.5	40000	800	190	0.010
2.0	25000	800	155	0.016
3.0	20000	800	190	0.020
4.0	18000	950	225	0.026
5.0	14000	1200	220	0.043
6.0	11000	1400	205	0.064
8.0	8000	1300	200	0.081
10.0	6500	1200	205	0.092
12.0	5500	1200	205	0.109



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

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