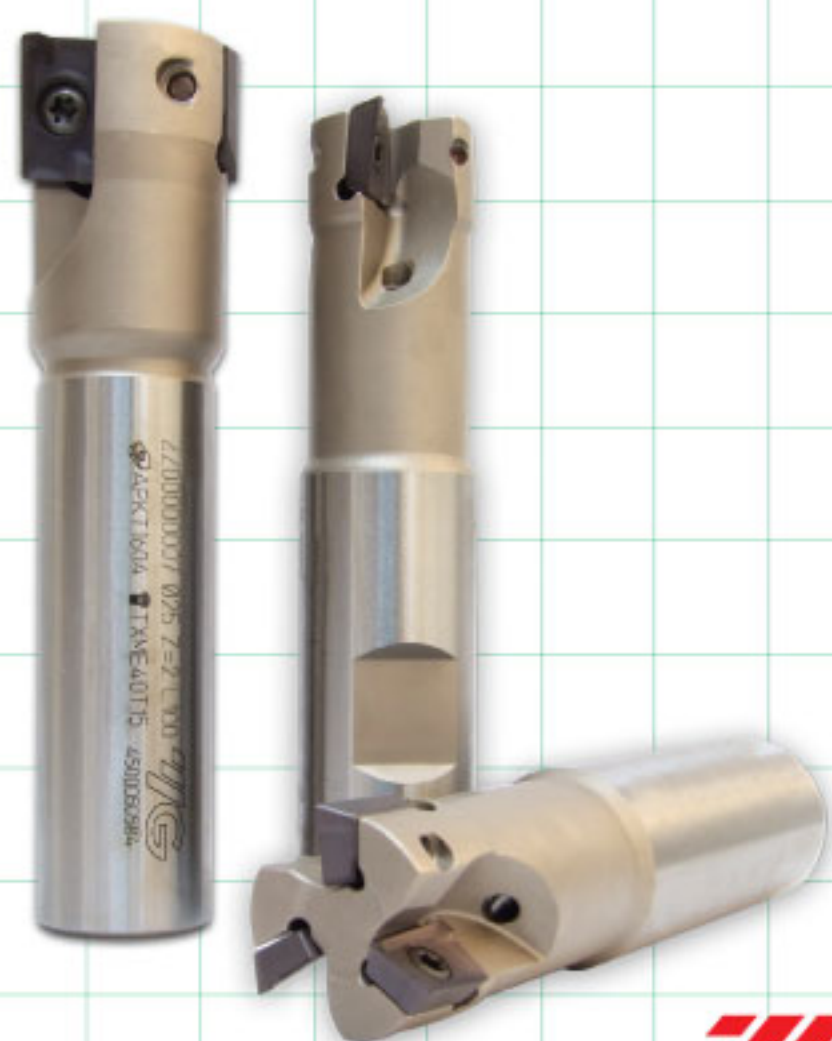


***i*-HS mill**
MILLING INSERTS & HOLDERS



***YG* YG-1 CO., LTD.**

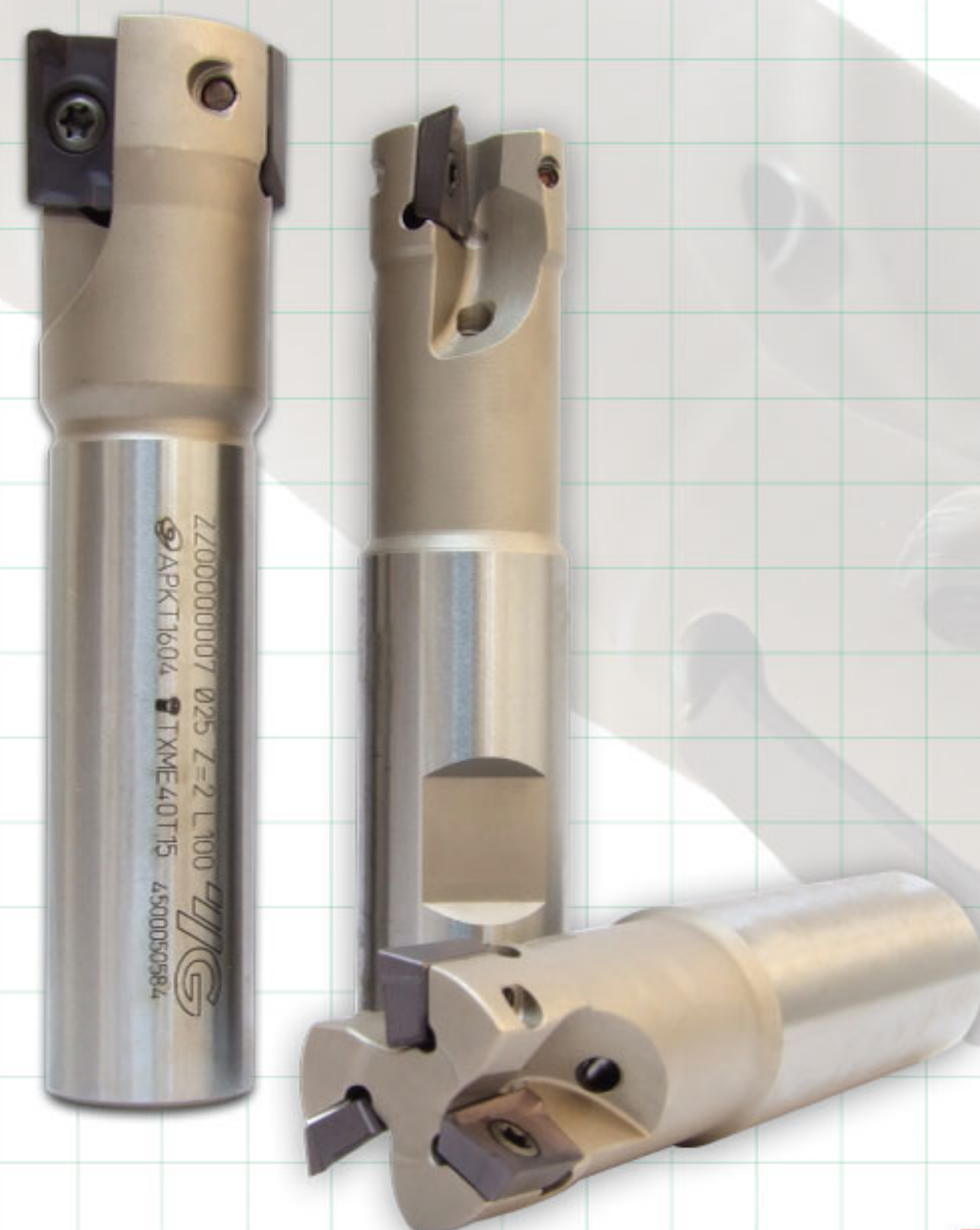
HEAD OFFICE

68, Cheongcheon-Dong, Bupyeong-Gu, Incheon, Korea

Phone : +82-32-526-0909, Fax : +82-32-526-4373

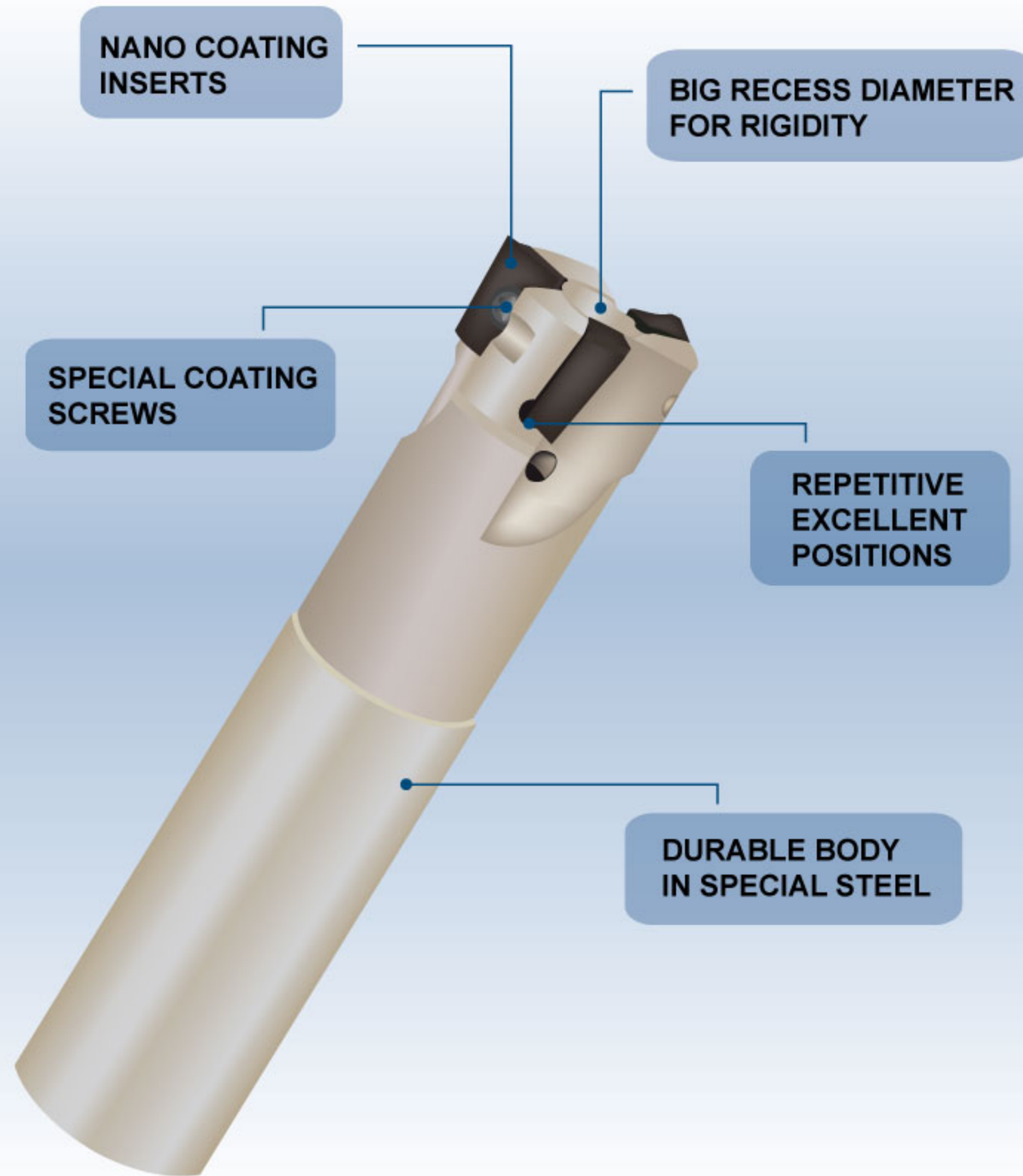
Web. : www.yg1.kr

E-mail : yg1@yg1.kr

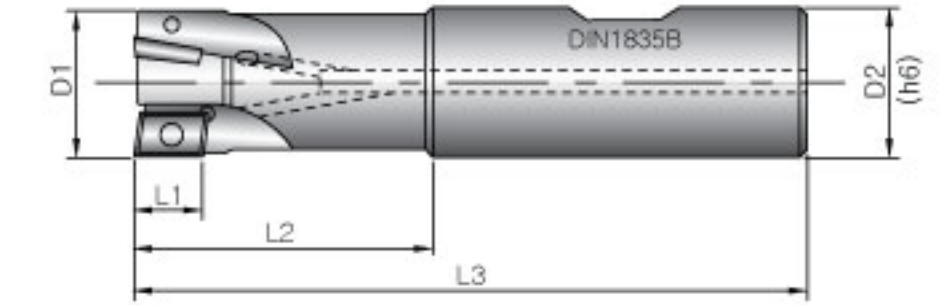


***YG* YG-1 CO., LTD.**

Features of *i*-HS mill



Holder

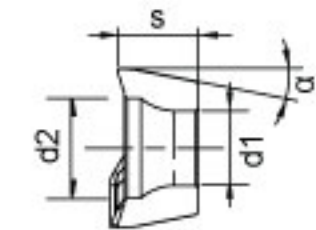
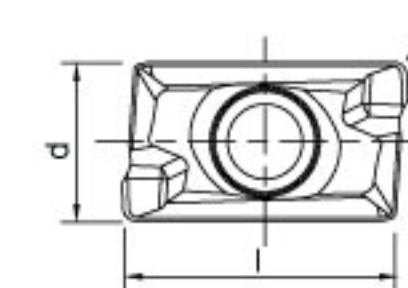


unit : mm

HOLDER							INSERT		Screw No.	Wrench No.
EDP No.	D1	L1	L2	L3	D2	Z	Shank	EDP No.	Type	
ZZ00000001	16	10	37	85	16	2	Weldon	XZ00000003	APKT1003PDER-RM	TXME30T08
• ZZ00000002	20	10	40	90	20	3		XZ00000004	APKT1604PDER-RM	TXME40T15
• ZZ00000003	25	16	40	100	20	2				
ZZ00000004	32	16	50	110	25	3				
ZZ00000005	16	10	37	85	16	2	Plain	XZ00000003	APKT1003PDER-RM	TXME30T08
• ZZ00000006	20	10	40	90	20	3		XZ00000004	APKT1604PDER-RM	TXME40T15
• ZZ00000007	25	16	40	100	20	2				
ZZ00000008	32	16	50	110	25	3				

• Set Promotion

Milling Insert



unit : mm

EDP No.	Type	Material		d	l	s	r	d1	d2	α°
		P	M							
XZ00000003	APKT1003PDER-RM	YG212AP(CY22A)		6.70	10.78	3.5	0.4	2.8	3.9	11
XZ00000004	APKT1604PDER-RM			9.52	16.39	5.3	0.8	4.5	6.0	11

NEW Application for Cast Iron(K) : YG232AC / Ductile Iron(K) : YG233AP

Set Promotion

unit : mm

SET No.	HOLDER		INSERT	
	EDP No.	Shank	EDP No.	Type
ISET0010	ZZ00000002	Weldon	XZ00000003	APKT1003PDER-RM
ISET0011	ZZ00000003		XZ00000004	APKT1604PDER-RM
ISET0014	ZZ00000006	Plain	XZ00000003	APKT1003PDER-RM
ISET0015	ZZ00000007		XZ00000004	APKT1604PDER-RM

► Contents : Milling Insert 20pcs + Holder(including screws) 1pc + Wrench 1pc

Cutting Condition

► Main application for steel(P) and stainless(M) and Cast Iron(K) ◀

Work material		Vc(m/min.)		feed(mm/tooth)	
		min.	max.	min.	max.
P	Non alloyed steel	150	260	0.18	0.32
	Low alloyed steel	80	220	0.15	0.25
	High alloyed steel	90	180	0.12	0.22
M	Stainless steel	60	200	0.15	0.25
K	Cast Iron	80	250	0.10	0.30
	Ductile Iron	80	200	0.10	0.30

Test Result

► YG-1 (Wear : 0.113mm)



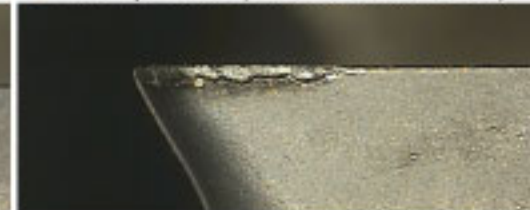
► Competitor (Wear : 0.230mm)



► YG-1 (Wear : 0.090mm)



► Competitor (Wear : 0.159mm)



Cutting Condition

Tool : Ø20, APKT1003PDER-RM(SET0010) Depth : 1mm x 10mm(ap x ae)
Material : SKD61(HRC50) Milling Length : 6m
RPM : 1274 Milling Method : Down Cutting
Feed : 0.18mm/rev. Coolant : Wet Cut

Cutting Condition

Tool : Ø20, APKT1003PDER-RM(SET0010) Depth : 1mm x 8mm(ap x ae)
Material : KP4(HRC30) Milling Length : 40m
RPM : 2229 Milling Method : Down Cutting
Feed : 0.15mm/rev. Coolant : Wet Cut