

3 FLUTE, STUB LENGTH END MILL 3 SCHNEIDEN FRÄSER, EXTRA KURZ

SERIES EP942

FLAT SHANK

SEITLICHEN MITNAHNEFLÄCHEN

PREMIUM
PM

30°

FLUTE
3

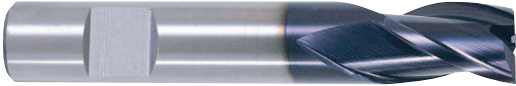
DIN
327

DIN1835B

P.97, 98

TANK-POWER

- Well balanced web design to minimize deflection and chattering.
Optimales kern-Design zur Minimierung von Abweichungen und Schnattern.
- 3 flute design possess the advantage of 2 flute and 4 flute end mill.
3 Schneiden Design besitzt die Vorteile von 2-bzw 4 Schneiden Fräsern.
- YG-1's new developed TANK-POWER Coating suitable for high speed cutting.
Die von YG-1 entwickelte TANK-POWER Beschichtung ist geeignet für Hochgeschwindigkeitsschnitt.



unit : mm

EDP No. FLAT	MILL DIAMETER e8	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
EP942010	1.0	6	2.5	47
EP942020	2.0	6	4	48
EP942030	3.0	6	5	49
EP942040	4.0	6	7	51
EP942050	5.0	6	8	52
EP942060	6.0	6	8	52
EP942070	7.0	10	10	60
EP942080	8.0	10	11	61
EP942090	9.0	10	11	61
EP942100	10.0	10	13	63
EP942120	12.0	12	16	73
EP942140	14.0	12	16	73
EP942160	16.0	16	19	79
EP942180	18.0	16	19	79
EP942200	20.0	20	22	88
EP942220	22.0	20	22	88
EP942250	25.0	25	26	102

- Uncoated end mills are available on your request.

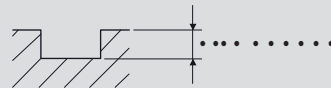
Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

Toleranzwerte in • +/- Tolerance range in • •					
Nennmaßbereich in • +/- Nominal-Diameter in • •					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
e8	• •14 • •28	• •20 • •38	• •25 • •47	• •32 • •59	• •40 • •73
h6	• 0 • •6	• 0 • •8	• 0 • •9	• 0 • •11	• 0 • •13

2 FLUTE, SHORT, SLOTTING

• EP936

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
	HARDNESS	~ 500N/mm2		~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc35		HRc35 ~ HRc40
STRENGTH	~ 500N/mm2		500 ~ 800N/mm2		800 ~ 1000N/mm2		1000 ~ 1100N/mm2		1100 ~ 1300N/mm2	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
	2	6700	100	5600	80	4700	70	3000	55	1900
3	4700	140	3900	120	3200	100	2200	70	1700	55
4	4100	200	3400	155	3000	140	1900	80	1500	65
5	3700	220	3100	175	2500	160	1600	90	1300	65
6	3300	230	2750	185	2200	165	1400	95	1100	75
8	2500	240	2100	210	1700	175	1100	100	850	75
10	2000	260	1700	230	1400	200	850	110	670	90
12	1700	240	1400	210	1100	180	700	100	550	75
14	1500	230	1200	200	950	170	600	95	480	70
16	1300	230	1100	185	850	155	530	90	420	70
18	1100	210	900	170	750	140	480	85	380	65
20	900	190	750	145	670	130	420	80	340	60
22	800	160	680	130	570	110	380	70	300	50
25	720	135	600	120	470	100	340	65	240	45



RPM=REVOLUTION PER MIN.
FEED=mm/min.

3 FLUTE, STUB, SLOTTING

• EP942

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
	HARDNESS	~ 500N/mm2		~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc35		HRc35 ~ HRc40
STRENGTH	~ 500N/mm2		500 ~ 800N/mm2		800 ~ 1000N/mm2		1000 ~ 1100N/mm2		1100 ~ 1300N/mm2	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
	2	6200	60	5200	50	4600	40	2900	30	1800
3	4400	90	3700	75	3200	45	2100	40	1700	40
4	4100	120	3400	100	2900	70	1800	45	1450	50
5	3600	140	3000	115	2500	80	1600	55	1250	50
6	3200	200	2700	165	2200	120	1400	80	1050	65
8	2500	210	2100	180	1700	130	1100	90	850	75
10	2000	220	1700	185	1350	140	850	100	650	80
12	1700	240	1400	200	1150	150	700	100	550	80
14	1500	220	1300	190	950	140	630	95	480	75
16	1300	210	1100	180	850	130	530	90	420	75
18	1100	210	850	170	750	130	480	85	380	70
20	900	200	750	165	670	120	420	80	340	70
22	800	200	700	170	570	130	380	85	300	75
25	720	210	600	180	470	140	340	90	240	75

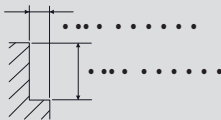


RPM=REVOLUTION PER MIN.
FEED=mm/min.

3 FLUTE, STUB, SIDE CUTTING

• EP942

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc35		HRc35 ~ HRc40	
STRENGTH	~ 500N/mm2		500 ~ 800N/mm2		800 ~ 1000N/mm2		1000 ~ 1100N/mm2		1100 ~ 1300N/mm2	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	7800	85	6500	70	5200	55	3600	45	2300	35
3	5500	125	4600	105	3600	65	2600	55	2100	55
4	5000	160	4200	135	3300	95	2200	65	1800	65
5	4500	180	3800	155	2800	110	1900	75	1600	65
6	4000	260	3400	220	2500	165	1700	110	1400	90
8	3000	290	2500	240	1900	175	1250	120	1000	100
10	2400	300	2000	250	1500	185	1000	130	850	110
12	2000	310	1700	260	1300	200	850	130	700	110
14	1700	300	1400	250	1100	185	750	125	600	105
16	1500	290	1250	240	950	175	625	120	520	100
18	1300	270	1100	230	850	170	550	115	480	95
20	1200	260	1000	220	750	165	500	110	420	95
22	1100	270	900	230	700	170	450	115	380	95
25	950	290	800	240	600	185	400	120	340	105

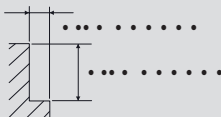


RPM=REVOLUTION PER MIN.
FEED=mm/min.

4 FLUTE, SHORT, SIDE CUTTING

• EP938

MATERIAL	STRUCTURAL STEELS CARBON STEELS		STRUCTURAL STEELS CARBON STEELS CAST IRONS		CARBON STEELS ALLOY STEELS TOOL STEELS		PREHARDENED STEELS ALLOY STEELS TOOL STEELS		ALLOY STEELS TOOL STEELS AUSTENITIC STAINLESS STEELS	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc35		HRc35 ~ HRc40	
STRENGTH	~ 500N/mm2		500 ~ 800N/mm2		800 ~ 1000N/mm2		1000 ~ 1100N/mm2		1100 ~ 1300N/mm2	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	8800	250	8000	210	5800	150	3900	110	3200	75
3	6300	360	5700	300	4200	220	2800	155	2300	110
4	5000	420	4500	350	3400	260	2200	175	1900	130
5	4200	440	3800	370	2800	275	1900	190	1600	140
6	3700	470	3400	390	2500	285	1700	200	1400	155
8	3000	500	2500	420	1900	320	1300	210	1100	160
10	2200	550	2000	460	1500	330	1000	230	850	175
12	1900	500	1700	420	1300	320	850	210	690	160
14	1700	480	1500	400	1100	300	750	200	600	150
16	1550	440	1300	370	950	290	650	190	520	145
18	1400	400	1200	350	850	270	600	170	480	130
20	1200	380	1000	320	750	240	500	155	420	120
22	1000	360	900	280	650	220	450	140	380	115
25	950	320	800	265	600	200	400	130	340	110



RPM=REVOLUTION PER MIN.
FEED=mm/min.