



E9A26 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

GAA26 SERIES

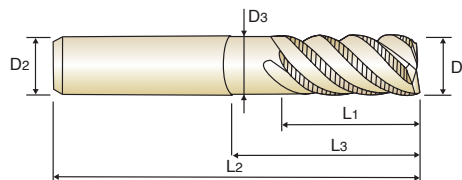
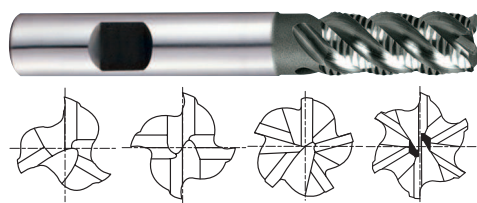
FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

PREMIUM HSS-PM, MULTI FLUTE 45° HELIX SHORT LENGTH ROUGHING - FINE

PREMIUM HSS-PM, MULTI SCHNEIDEN 45° RECHTSSPIRALE KURZ SCHRUPFRÄSER - FEIN

- ▶ High chip removal and minimizing breakages of cutting edges.
- ▶ Designed to machine carbon steels, alloyed steels, stainless steels
- ▶ YG-1's new developed TANK-POWER Coating suitable for high speed cutting

- ▶ Schnelle Spanabfuhr und Minimierung von Schneidkantenausbrüchen
- ▶ Geeignet zum Fräsen von Stahl, legiertem Stahl und rostfreier Stahl.
- ▶ Neuentwickelte Beschichtung für Hochgeschwindigkeitsfräsen.



P.1162, 1163

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	No. of Flute
UNCOATED	TANK-POWER COATED	D1(js12)	D2(h6)	L1	L3	L2	D3	
E9A26040	GAA26040	4.0	6	11	-	57	-	3
E9A26050	GAA26050	5.0	6	13	-	57	-	4
E9A26060	GAA26060	6.0	6	13	-	57	-	4
E9A26070	GAA26070	7.0	10	16	-	66	-	4
E9A26080	GAA26080	8.0	10	19	-	69	-	4
E9A26090	GAA26090	9.0	10	19	-	69	-	4
E9A26100	GAA26100	10.0	10	22	31	72	9.5	4
E9A26120	GAA26120	12.0	12	26	37	83	11.5	4
E9A26140	GAA26140	14.0	12	26	-	83	-	5
E9A26160	GAA26160	16.0	16	32	44	92	15	5
E9A26180	GAA26180	18.0	16	32	-	92	-	6
E9A26200	GAA26200	20.0	20	38	54	104	19	6
E9A26250	GAA26250	25.0	25	45	63	121	24	6

Tolerances according to DIN 7160 & 7161

Toleranzen nach DIN 7160 & 7161

Tolerance range in μm / Toleranzwerte in μm						
Nominal-Diameter in mm / Nennmaßbereich in mm						
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30	over 30 to 50 über 30 bis 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13	0 - 16

◎ : Excellent ○ : Good

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									
◎	◎	○				○		◎		◎				



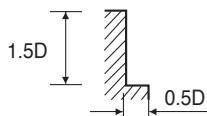
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

PREMIUM HSS-PM, MULTI FLUTE ROUGHING - SIDE CUTTING PREMIUM HSS-PM, MULTI SCHNEIDEN SCHRUPFRÄSER - SEITENFRÄSEN

GAA26 SERIES

MATERIAL	STRUCTURAL STEELS CARBON STEELS				STRUCTURAL STEELS CARBON STEELS CAST IRONS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS					~ HRc20				HRc20 ~ HRc30			
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	2800	230	55	0.021	2200	180	40	0.020	1600	115	30	0.018
8.0	2400	290	60	0.030	1900	230	50	0.030	1400	160	35	0.029
10.0	1900	415	60	0.055	1500	315	45	0.053	1050	195	35	0.046
12.0	1600	415	60	0.065	1200	330	45	0.069	900	230	35	0.064
14.0	1400	415	60	0.059	1050	330	45	0.063	760	230	35	0.061
16.0	1200	415	60	0.069	950	330	50	0.069	660	230	35	0.070
18.0	1050	415	60	0.066	890	330	50	0.062	610	230	35	0.063
20.0	960	425	60	0.074	760	330	50	0.072	530	230	35	0.072
22.0	890	425	60	0.080	650	330	45	0.085	470	230	30	0.082
25.0	790	415	60	0.088	600	315	45	0.088	420	220	35	0.087

MATERIAL	PREHARDENED STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS			
HARDNESS	HRc30 ~ HRc40							
STRENGTH	1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	1300	105	25	0.020	1450	110	25	0.019
8.0	1050	125	25	0.030	1200	140	30	0.029
10.0	890	160	30	0.045	950	170	30	0.045
12.0	740	180	30	0.061	800	205	30	0.064
14.0	630	180	30	0.057	690	205	30	0.059
16.0	550	180	30	0.065	600	205	30	0.068
18.0	490	180	30	0.061	550	205	30	0.062
20.0	440	180	30	0.068	480	205	30	0.071
22.0	400	180	30	0.075	430	205	30	0.079
25.0	360	180	30	0.083	390	200	30	0.085



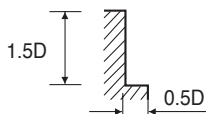
※ The FEED, in long & long reach types, should be reduced by around 50%

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

PREMIUM HSS-PM, MULTI FLUTE ROUGHING - SIDE CUTTING
PREMIUM HSS-PM, MULTI SCHNEIDEN SCHRUPFRÄSER - SEITENFRÄSEN
E9A26 SERIES

MATERIAL	STRUCTURAL STEELS CARBON STEELS				STRUCTURAL STEELS CARBON STEELS CAST IRONS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS					~ HRC20				HRC20 ~ HRC30			
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	1900	140	35	0.018	1500	110	30	0.018	1050	70	20	0.017
8.0	1600	180	40	0.028	1300	140	35	0.027	900	100	25	0.028
10.0	1300	260	40	0.050	1000	195	30	0.049	710	125	20	0.044
12.0	1100	260	40	0.059	820	205	30	0.063	600	140	25	0.058
14.0	930	260	40	0.056	710	205	30	0.058	510	140	20	0.055
16.0	820	260	40	0.063	640	205	30	0.064	450	140	25	0.062
18.0	710	260	40	0.061	610	205	35	0.056	410	140	25	0.057
20.0	660	265	40	0.067	510	205	30	0.067	360	140	25	0.065
22.0	610	265	40	0.072	440	205	30	0.078	320	140	20	0.073
25.0	540	260	40	0.080	400	195	30	0.081	280	135	20	0.080

MATERIAL	PREHARDENED STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS			
HARDNESS	HRC30 ~ HRC40							
STRENGTH	1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	900	65	15	0.018	1020	80	20	0.020
8.0	740	80	20	0.027	840	100	20	0.030
10.0	600	100	20	0.042	660	120	20	0.045
12.0	500	110	20	0.055	560	145	20	0.065
14.0	430	110	20	0.051	480	145	20	0.060
16.0	370	110	20	0.059	420	145	20	0.069
18.0	330	110	20	0.056	380	145	20	0.064
20.0	300	110	20	0.061	330	145	20	0.073
22.0	270	110	20	0.068	300	145	20	0.081
25.0	240	110	20	0.076	270	140	20	0.086



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RPM = rev./min.
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