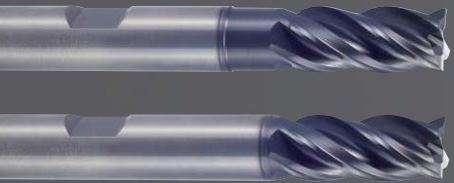


YE-VP15



V7 Plus
SOLID CARBIDE END MILLS



YG YG-1 CO., LTD.

HEAD OFFICE

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<http://www.yg1.kr>

E-mail: yg1@yg1.kr

Tool specifications are subject to change without prior notice.

YG1YEV150216

V7 Plus
SOLID CARBIDE END MILLS

HIGH PERFORMANCE CARBIDE END MILLS
FOR STEEL, CAST IRON, STAINLESS STEEL



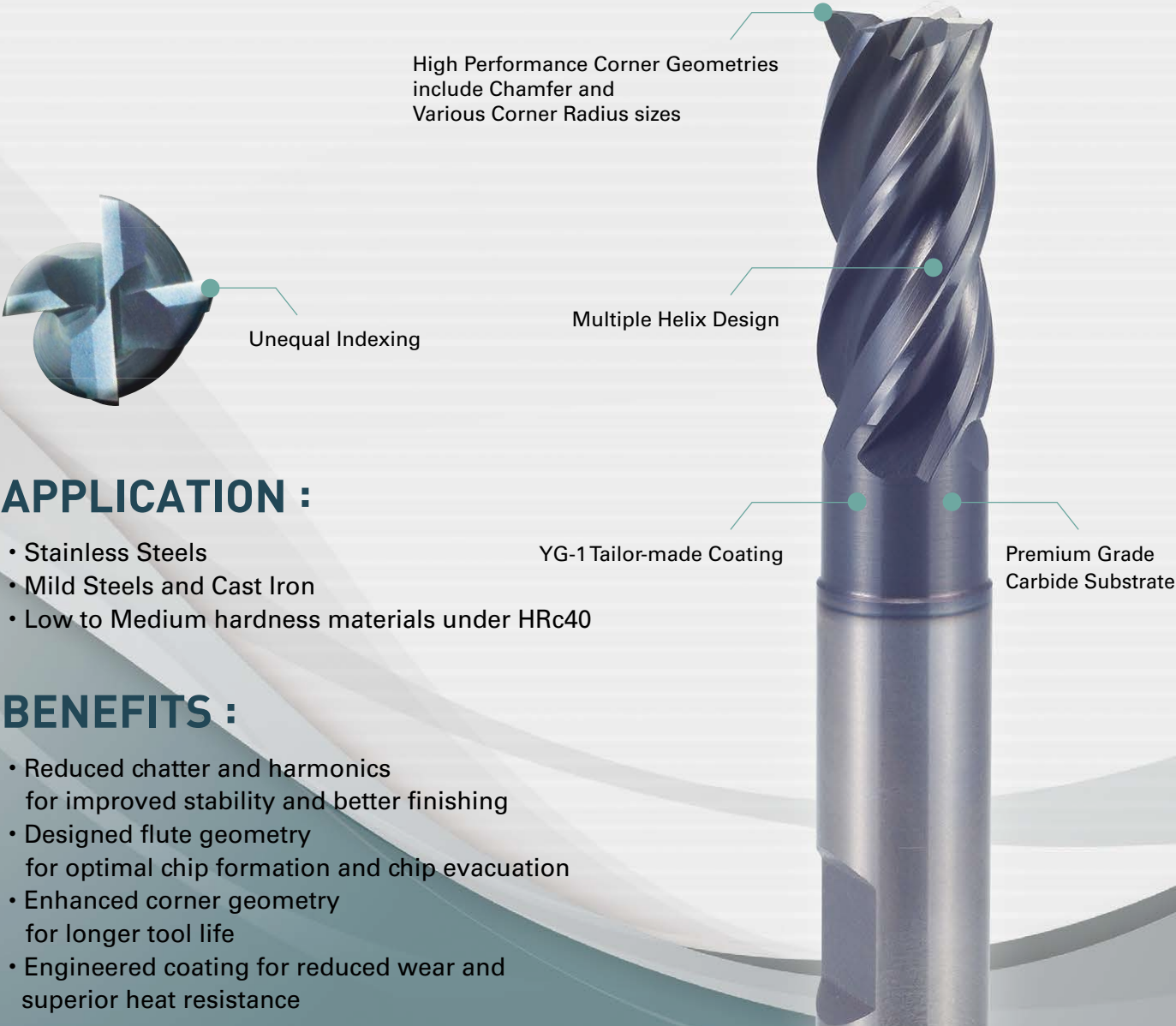
YG YG-1 CO., LTD.

V7 Plus

SOLID CARBIDE END MILLS

NEW ENGINEERED DESIGN!

The **V7 Plus** for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40 has a unique design that maximizes chip removal and improves productivity in slotting and heavy profiling operations. The **V7 Plus** advanced geometry reduces chatter for increased tool life and increased productivity.



APPLICATION :

- Stainless Steels
- Mild Steels and Cast Iron
- Low to Medium hardness materials under HRc40

BENEFITS :

- Reduced chatter and harmonics for improved stability and better finishing
- Designed flute geometry for optimal chip formation and chip evacuation
- Enhanced corner geometry for longer tool life
- Engineered coating for reduced wear and superior heat resistance



YouTube

YG V7 Plus



* When you search 'YG-1 Cutting Tool', you can watch more video clips.

SELECTION GUIDE

ITEM	MODEL	DESCRIPTION	SIZE		Carbon Steels ~HB225	Alloy Steels HB225~352	Prehardened Steels HRc30~40	Hardened Steels HRc40~55	High Temperature Alloy HRc55~	Cast Iron	Titanium	Stainless Steels	PAGE
			Min.	Max.									
GMF52 GMF53		CARBIDE, 4 FLUTE SHORT	3.0	20.0	◎	◎	◎	○	○	◎	○	◎	6
GMF54 GMF55		CARBIDE, 4 FLUTE SHORT, CORNER RADIUS	3.0	20.0	◎	◎	◎	○	○	◎	○	◎	7
GMF56 GMF57		CARBIDE, 4 FLUTE LONG	3.0	25.0	◎	◎	◎	○	○	◎	○	◎	8
GMF58 GMF59		CARBIDE, 4 FLUTE LONG, CORNER RADIUS	3.0	25.0	◎	◎	◎	○	○	◎	○	◎	9
GMF60 GMF61		CARBIDE, 4 FLUTE with EXTENDED NECK	3.0	20.0	◎	◎	◎	○	○	◎	○	◎	10
GMF62 GMF63		CARBIDE, 4 FLUTE with EXTENDED NECK, CORNER RADIUS	3.0	20.0	◎	◎	◎	○	○	◎	○	◎	11

ICON GUIDE



The tool is made of Micro grain carbide.



4 - flute tool



Multiple helix



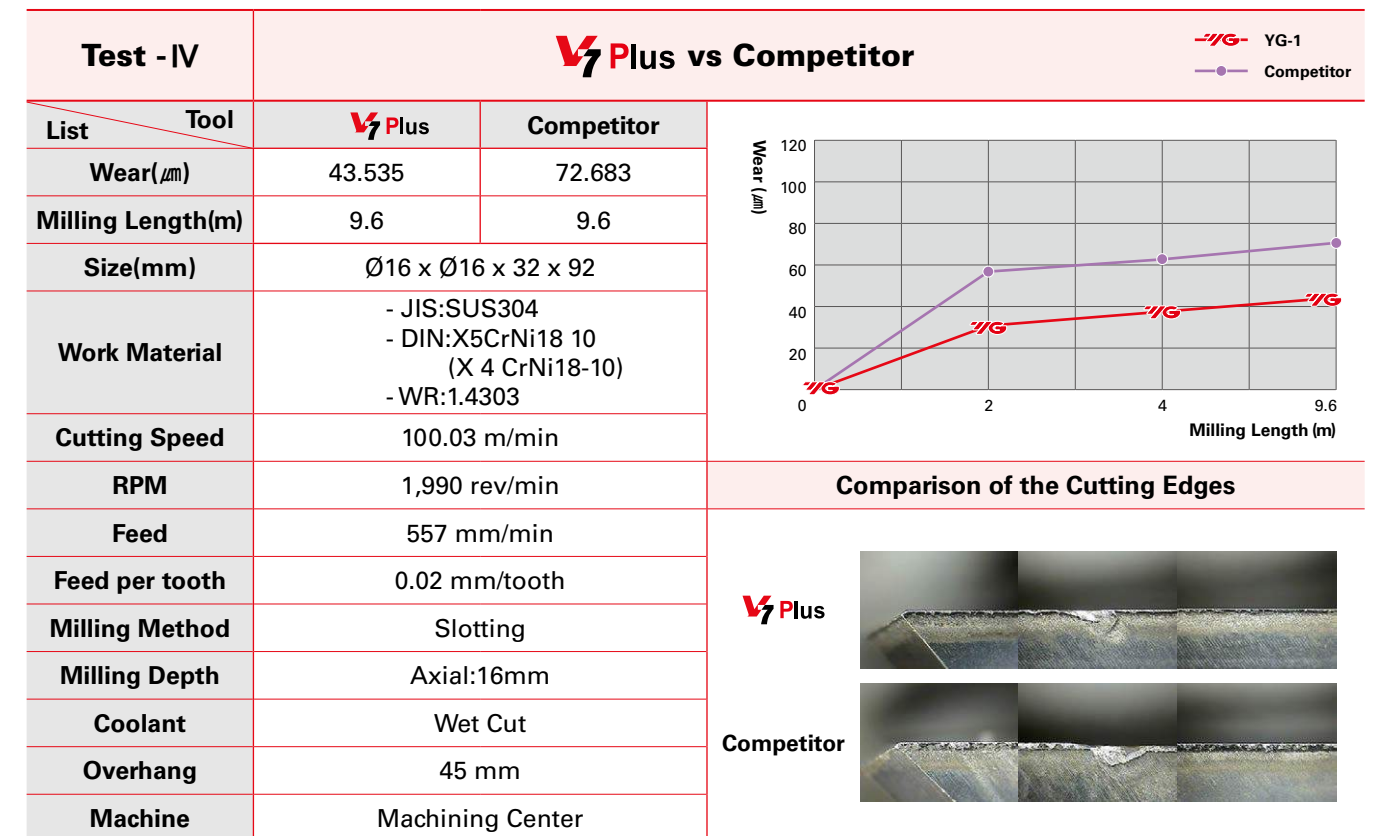
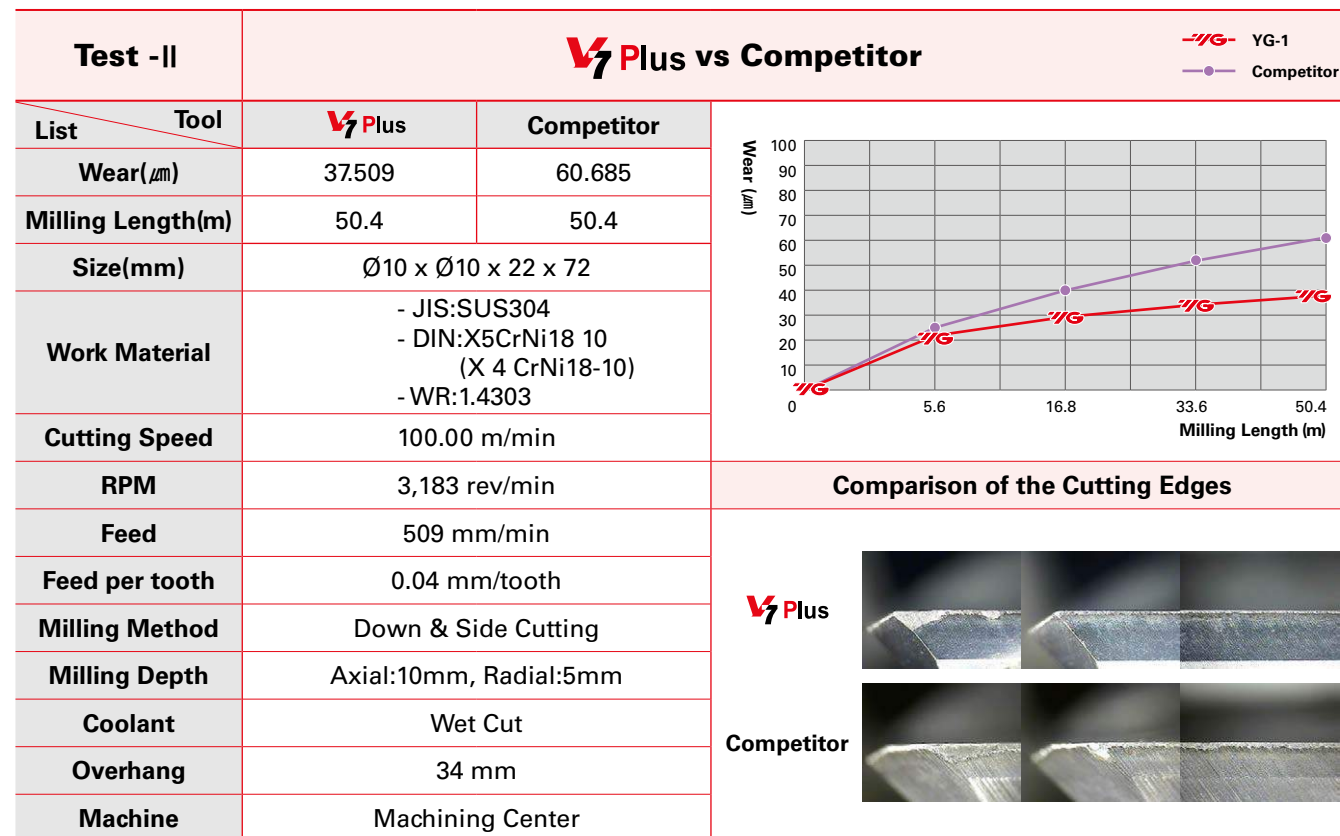
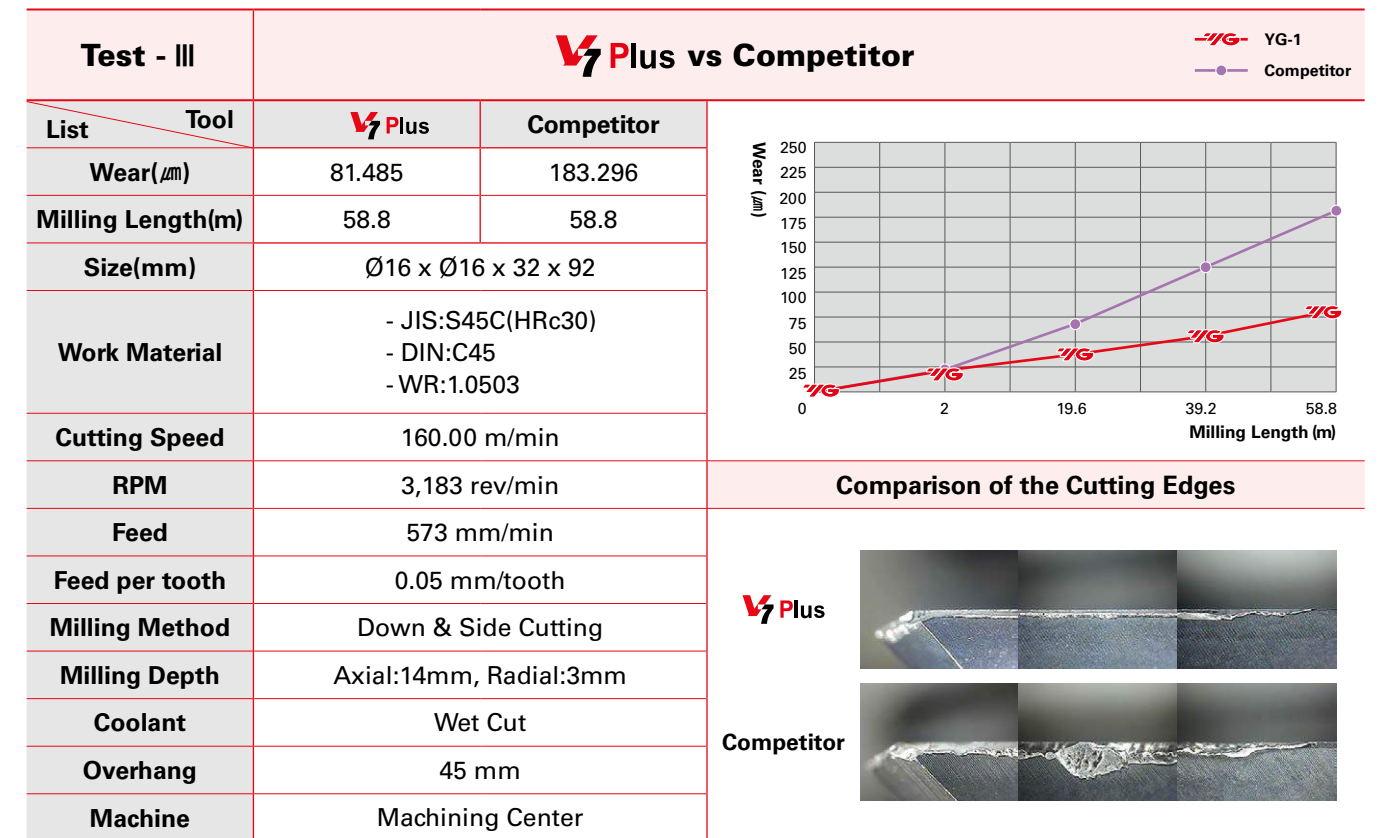
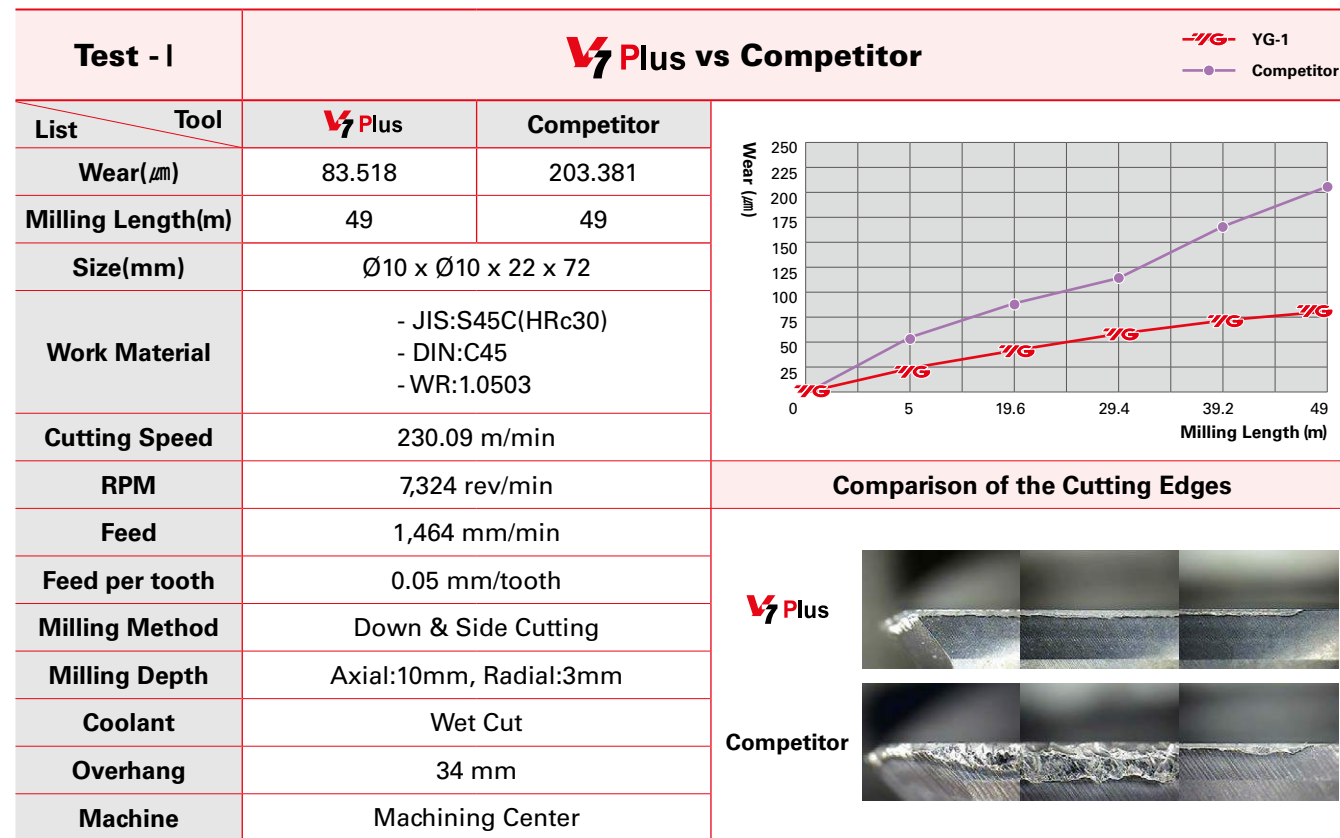
Type of shank



Chamfer Angle

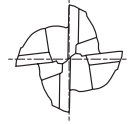


Cutting condition of tool see the page 000



CARBIDE, 4 FLUTE SHORT

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF52 / PLAIN SHANK

GMF53 / FLAT SHANK



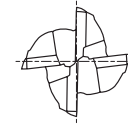
MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH	CHAMFER
PLAIN	FLAT					
GMF52030	GMF53030	3.0	6	7	54	0.10
GMF52040	GMF53040	4.0	6	8	54	0.15
GMF52050	GMF53050	5.0	6	10	54	0.15
GMF52060	GMF53060	6.0	6	10	54	0.20
GMF52080	GMF53080	8.0	8	12	58	0.20
GMF52100	GMF53100	10.0	10	14	66	0.30
GMF52120	GMF53120	12.0	12	16	73	0.35
GMF52140	GMF53140	14.0	14	18	75	0.40
GMF52160	GMF53160	16.0	16	22	82	0.40
GMF52180	GMF53180	18.0	18	24	84	0.50
GMF52200	GMF53200	20.0	20	26	92	0.50

CARBIDE, 4 FLUTE SHORT CORNER RADIUS

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF54 / PLAIN SHANK

GMF55 / FLAT SHANK



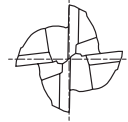
MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT					
GMF54030	GMF55030	R0.3	3.0	6	7	54
GMF54040	GMF55040	R0.3	4.0	6	8	54
GMF54050	GMF55050	R0.3	5.0	6	10	54
GMF54060	GMF55060	R0.3	6.0	6	10	54
GMF54904	GMF55904	R0.5		6	10	54
GMF54080	GMF55080	R0.5	8.0	8	12	58
GMF54100	GMF55100	R0.5	10.0	10	14	66
GMF54120	GMF55120	R0.5	12.0	12	16	73
GMF54140	GMF55140	R0.5	14.0	14	18	75
GMF54160	GMF55160	R1.0	16.0	16	22	82
GMF54180	GMF55180	R1.0	18.0	18	24	84
GMF54200	GMF55200	R1.0	20.0	20	26	92

CARBIDE, 4 FLUTE LONG

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF56 / PLAIN SHANK

GMF57 / FLAT SHANK



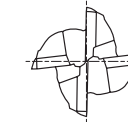
MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH	CHAMFER
PLAIN	FLAT					
GMF56030	GMF57030	3.0	6	8	57	0.10
GMF56040	GMF57040	4.0	6	11	57	0.15
GMF56050	GMF57050	5.0	6	13	57	0.15
GMF56060	GMF57060	6.0	6	13	57	0.20
GMF56080	GMF57080	8.0	8	19	63	0.20
GMF56100	GMF57100	10.0	10	22	72	0.30
GMF56120	GMF57120	12.0	12	26	83	0.35
GMF56140	GMF57140	14.0	14	26	83	0.40
GMF56160	GMF57160	16.0	16	32	92	0.40
GMF56180	GMF57180	18.0	18	32	92	0.50
GMF56200	GMF57200	20.0	20	38	104	0.50
GMF56250	GMF57250	25.0	25	38	104	0.50

CARBIDE, 4 FLUTE LONG CORNER RADIUS

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF58 / PLAIN SHANK

GMF59 / FLAT SHANK



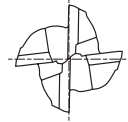
MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT					
GMF58030	GMF59030	R0.3	3.0	6	8	57
GMF58040	GMF59040	R0.3	4.0	6	11	57
GMF58050	GMF59050	R0.3	5.0	6	13	57
GMF58060	GMF59060	R0.3	6.0	6	13	57
GMF58904	GMF59904	R0.5		6	13	57
GMF58905	GMF59905	R1.0		6	13	57
GMF58080	GMF59080	R0.5	8.0	8	19	63
GMF58906	GMF59906	R1.0		8	19	63
GMF58100	GMF59100	R0.5	10.0	10	22	72
GMF58120	GMF59120	R0.5	12.0	12	26	83
GMF58140	GMF59140	R0.5	14.0	14	26	83
GMF58160	GMF59160	R1.0	16.0	16	32	92
GMF58913	GMF59913	R3.0		16	32	92
GMF58180	GMF59180	R1.0	18.0	18	32	92
GMF58200	GMF59200	R1.0	20.0	20	38	104
GMF58250	GMF59250	R1.0	25.0	25	38	104

CARBIDE, 4 FLUTE with EXTENDED NECK

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF60 / PLAIN SHANK

GMF61 / FLAT SHANK



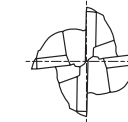
MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	LENGTH BELOW SHANK	OVERALL LENGTH	NECK DIAMETER	CHAMFER
PLAIN	FLAT							
GMF60030	GMF61030	3.0	6	7	12	54	2.7	0.10
GMF60901	GMF61901		6	7	17	57	2.7	0.10
GMF60902	GMF61902		6	8	14	57	2.7	0.10
GMF60040	GMF61040	4.0	6	8	15	57	3.7	0.15
GMF60903	GMF61903		6	8	22	63	3.7	0.15
GMF60904	GMF61904		6	11	16	57	3.7	0.15
GMF60050	GMF61050	5.0	6	10	17	57	4.7	0.15
GMF60905	GMF61905		6	10	27	67	4.7	0.15
GMF60906	GMF61906		6	13	18	57	4.7	0.15
GMF60060	GMF61060	6.0	6	10	15	57	5.5	0.20
GMF60907	GMF61907		6	10	20	62	5.5	0.20
GMF60908	GMF61908		6	10	32	74	5.5	0.20
GMF60909	GMF61909	8.0	6	13	21	57	5.5	0.20
GMF60080	GMF61080		8	12	20	63	7.5	0.20
GMF60910	GMF61910		8	12	30	73	7.5	0.20
GMF60911	GMF61911	10.0	8	12	46	90	7.5	0.20
GMF60912	GMF61912		8	19	27	63	7.5	0.20
GMF60100	GMF61100		10	14	25	72	9.2	0.30
GMF60913	GMF61913	12.0	10	14	35	82	9.2	0.30
GMF60914	GMF61914		10	14	55	102	9.2	0.30
GMF60915	GMF61915		10	22	32	72	9.2	0.30
GMF60120	GMF61120	16.0	12	16	30	83	11.0	0.35
GMF60916	GMF61916		12	16	40	93	11.0	0.35
GMF60917	GMF61917		12	16	64	117	11.0	0.35
GMF60918	GMF61918	20.0	12	26	38	83	11.0	0.35
GMF60160	GMF61160		16	22	38	92	15.0	0.40
GMF60919	GMF61919		16	22	55	109	15.0	0.40
GMF60920	GMF61920	20.0	16	22	87	141	15.0	0.40
GMF60921	GMF61921		16	32	44	92	15.0	0.40
GMF60200	GMF61200		20	26	50	104	19.0	0.50
GMF60922	GMF61922	20.0	20	26	70	124	19.0	0.50
GMF60923	GMF61923		20	26	110	164	19.0	0.50
GMF60924	GMF61924		20	38	54	104	19.0	0.50

CARBIDE, 4 FLUTE with EXTENDED NECK CORNER RADIUS

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



GMF62 / PLAIN SHANK

GMF63 / FLAT SHANK



MILL DIA. TOLERANCE (mm)	SHANK DIA. TOLERANCE
0~0.03	h6

Unit : mm

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	LENGTH BELOW SHANK	OVERALL LENGTH	NECK DIAMETER
PLAIN	FLAT							
GMF62030	GMF63030	R0.3	3.0	6	7	12	54	2.7
GMF62902	GMF63902	R0.3		6	7	17	57	2.7
GMF62040	GMF63040	R0.3		6	8	15	57	3.7
GMF62905	GMF63905	R0.3	4.0	6	8	22	63	3.7
GMF62050	GMF63050	R0.3		6	10	17	57	4.7
GMF62908	GMF63908	R0.3		6	10	27	67	4.7
GMF62910	GMF63910	R0.5	5.0	6	10	15	57	5.5
GMF62913	GMF63913	R0.5		6	10	20	62	5.5
GMF62916	GMF63916	R0.5		6	10	32	74	5.5
GMF62080	GMF63080	R0.5	6.0	8	12	20	63	7.5
GMF62919	GMF63919	R0.5		8	12	30	73	7.5
GMF62921	GMF63921	R0.5		8	12	46	90	7.5
GMF62100	GMF63100	R0.5	8.0	10	14	25	72	9.2
GMF62924	GMF63924	R0.5		10	14	35	82	9.2
GMF62926	GMF63926	R0.5		10	14	55	102	9.2
GMF62120	GMF63120	R0.5	10.0	12	16	30	83	11.0
GMF62930	GMF63930	R0.5		12	16	40	93	11.0
GMF62933	GMF63933	R0.5		12	16	64	117	11.0
GMF62160	GMF63160	R1.0	12.0	16	22	38	92	15.0
GMF62938	GMF63938	R1.0		16	22	55	109	15.0
GMF62941	GMF63941	R1.0		16	22	87	141	15.0
GMF62200	GMF63200	R1.0	16.0	20	26	50	104	19.0
GMF62946	GMF63946	R1.0		20	26	70	124	19.0
GMF62949	GMF63949	R1.0		20	26	110	164	19.0

MATERIAL	P											
	CARBON STEEL 1.1191(C45) 1.0726(35 S 20) 1.0715(9 SMn 28) 1.0718(9 SMnPb 28)				ALLOY STEEL 1.2330(35 CrMo 4) 1.6565(40NiCrMo6) 1.7033(34Cr4) 1.6523(2 NiCrMo2)				TOOL STEEL 1.2363(X100 CrMoV 5 1) 1.2379(X 155 CrVMo 12 1) 1.2344(X 40 CrMoV 5 1) 1.3243(S 6-5-2-5)			
HARDNESS	~ HB 300				HB 300 ~ HB 380				~ HB 380			
STRENGTH	~ 1000N/mm ²				1000N/mm ² ~ 1300N/mm ²				~ 1300N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
3.0	16170	330	152	0.005	11315	230	107	0.005	6790	95	64	0.003
4.0	12125	395	152	0.008	8485	275	107	0.008	5090	115	64	0.006
5.0	9700	445	152	0.011	6790	310	107	0.011	4075	130	64	0.008
6.0	8080	520	152	0.016	5655	365	107	0.016	3395	150	64	0.011
8.0	6060	665	152	0.027	4240	460	107	0.027	2545	190	64	0.019
10.0	5345	820	168	0.038	3740	575	117	0.038	2240	240	70	0.027
12.0	4450	835	168	0.047	3100	580	117	0.047	1860	240	70	0.032
14.0	3815	745	168	0.049	2670	520	117	0.049	1600	215	70	0.034
16.0	3340	710	168	0.053	2330	490	117	0.053	1400	205	70	0.037
18.0	2970	700	168	0.059	2075	490	117	0.059	1245	205	70	0.041
20.0	2670	695	168	0.065	1870	485	117	0.065	1120	200	70	0.045
25.0	2140	550	168	0.064	1495	380	117	0.064	895	160	70	0.045

* () : Short length & Neck type
0.8xD(Slotting), 1.2xD(Side Cutting) Axial
cutting depth should be applied for Short length(GMF52, GMF53, GMF54, GMF55)
& Neck type(GMF60, GMF61, GMF62, GMF63) series diameter over 8mm

MATERIAL	K				M							
	CAST IRON 0.6020(GG20) 0.8145(GTS-45-06) 0.7060(GGG-60)				STAINLESS STEELS 300 1.4301(X 5 CrNi 18 9) 1.4436(X 5 CrNiMo 17 13 3) 1.4306(X2CrNi18 9) 1.4435(X2 CrNiMo18 14 3)				STAINLESS STEELS 400 1.4005(X12CrS 13) 1.4104(X12CrMoS17)			
HARDNESS	~ HB 260											
STRENGTH	~ 870N/mm ²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
3.0	11880	300	112	0.006	11205	210	106	0.005	15690	225	148	0.004
4.0	8910	360	112	0.010	8400	275	106	0.008	11740	280	148	0.006
5.0	7130	405	112	0.014	6725	340	106	0.013	9405	340	148	0.009
6.0	5940	480	112	0.020	5605	395	106	0.018	7845	395	148	0.013
8.0	4455	600	112	0.034	4205	475	106	0.028	5880	510	148	0.022
10.0	3930	755	123	0.048	3365	645	106	0.048	4705	640	148	0.034
12.0	3255	760	123	0.058	2800	620	106	0.055	3925	620	148	0.039
14.0	2805	680	123	0.061	2400	570	106	0.059	3365	570	148	0.042
16.0	2450	640	123	0.065	2105	525	106	0.062	2940	525	148	0.045
18.0	2180	640	123	0.073	1870	520	106	0.070	2615	520	148	0.050
20.0	1965	635	123	0.081	1680	515	106	0.077	2355	515	148	0.055
25.0	1570	495	123	0.079	1345	415	106	0.077	1885	415	148	0.055
	* () : Short length & Neck type 0.8xD(Slotting), 1.2xD(Side Cutting) Axial cutting depth should be applied for Short length(GMF52, GMF53, GMF54, GMF55) & Neck type(GMF60, GMF61, GMF62, GMF63) series diameter over 8mm RPM = rev./min., Feed = mm/min Vc = m/min., fz = mm/tooth											

MATERIAL	M				S							
	STAINLESS STEELS (PH) 1.4545(Z7 CNU15.05)				TITANIUM Ti6Al4V Ti5Al5V5Mo Ti7Al4Mo				HIGH TEMPERATURE ALLOY INCONEL HASTELLOY RENE			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
3.0	10085	185	95	0.005	6165	100	58	0.004	2805	35	26	0.003
4.0	7560	245	95	0.008	4620	135	58	0.007	2100	45	26	0.005
5.0	6055	305	95	0.013	3700	165	58	0.011	1685	55	26	0.008
6.0	5045	355	95	0.018	3085	195	58	0.016	1405	65	26	0.012
8.0	3785	425	95	0.028	2315	235	58	0.025	1050	80	26	0.019
10.0	3030	580	95	0.048	1855	315	58	0.042	840	110	26	0.033
12.0	2520	555	95	0.055	1540	305	58	0.050	700	105	26	0.038
14.0	2160	510	95	0.059	1320	280	58	0.053	600	95	26	0.040
16.0	1895	470	95	0.062	1160	255	58	0.055	525	90	26	0.043
18.0	1685	465	95	0.069	1030	255	58	0.062	465	90	26	0.048
20.0	1515	460	95	0.076	925	250	58	0.068	420	90	26	0.054
25.0	1215	370	95	0.076	740	205	58	0.069	335	70	26	0.052

RPM = rev./min.
Feed = mm/min.
Vc = m/min.
fz = mm/tooth

MEMO

HIGH QUALITY PRODUCTS AND ON TIME DELIVERY FOR WORLD-WIDE CUSTOMERS

Since 1982, our commitment to quality, reliability and striving for constant innovation has allowed us to expand our market share and our partners' global network. As one of the main leading tool manufacturers, we are dedicated in offering a unique customer experience by delivering high quality cutting tool solutions around the world. In order to be responsive and to offer local solutions, YG-1 has established a global network over 75 countries and has set up international logistic centers. This is our pledge to provide the best service in order to satisfy our customers' needs at all time.



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