



Being the best through innovation



SOLID CARBIDE

V7 MILL INOX END MILLS

- Silent Cutting of Stainless Steels up to HRc40.
Designed as Variable Leads, YG-1's Patent.

YG V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

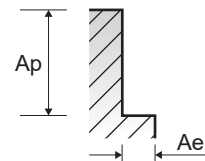
EMC75, EMD60, EMC76, EMD61, EMB12 EMB37, EMB13, EMB38, EMB20 SERIES

4 FLUTES - SIDE CUTTING

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1	
P	1-2	Non-alloy steel	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
	6	Low alloy steel	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
	10	High alloyed steel, and tool steel	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
M	12-13	Stainless steel	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	440	590	445	440	440	440	440	440	440	440	440	
					IPT(fz)	.0001	.0002	.0004	.0005	.0009	.0014	.0016	.0018	.0020	.0022	.0022	
					RPM	13475	12000	6815	5390	4490	3850	3370	2990	2700	2250	1685	
	14.1	Stainless steel	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	315	315	315	315	315	315	315	315	315	315	315	
					IPT(fz)	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0025	.0028	.0030	.0031	
					RPM	9625	6385	4810	3850	3210	2750	2400	2140	1925	1600	1200	
	S	31-35	Heat Resistant Super Alloys	0.35D	1.0D [0.6D]	SFM(Vc)	85	85	85	85	85	85	85	85	85	85	80
						IPT(fz)	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0025	.0027	.0031	.0034
						RPM	2565	1685	1285	1025	855	735	640	570	510	425	315
36-37		Titanium Alloys	0.5D	1.5D (1.2D) [0.6D]	SFM(Vc)	270	270	270	270	270	275	270	270	270	275	270	
					IPT(fz)	.0002	.0004	.0006	.0008	.0014	.0022	.0025	.0029	.0032	.0035	.0036	
					RPM	8320	5550	4160	3330	2770	2380	2080	1850	1660	1390	1040	

*() : Short length Type
*[] : Stub length Type



*1.2 x D Axial cutting depth should be applied for Short length series DIA over 5/16mm
*0.6 x D Axial cutting depth should be applied for Stub length series.



V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

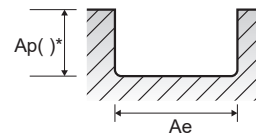
EMC75, EMD60, EMC76, EMD61, EMB12 EMB37, EMB13, EMB38, EMB20 SERIES

4 FLUTE - **SLOTING**

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1	
P	1-2	Non-alloy steel	1.0D	1.0D [0.6D]	SFM (Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT (fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
	6	Low alloy steel	1.0D	1.0D [0.6D]	SFM (Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT (fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
	10	High alloyed steel, and tool steel	1.0D	1.0D [0.6D]	SFM (Vc)	415	415	415	415	415	460	460	460	460	460	460	
					IPT (fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0019	.0021	.0023	.0026	.0025	
					RPM	12735	8490	6370	5100	4245	4010	3500	3110	2800	2340	1755	
M	12-13	Stainless steel	1.0D	1.0D [0.6D]	SFM (Vc)	440	590	445	440	440	440	440	440	440	440	440	
					IPT (fz)	.0001	.0002	.0004	.0005	.0009	.0014	.0016	.0018	.0020	.0022	.0022	
					RPM	13475	12000	6815	5390	4490	3850	3370	2990	2700	2250	1685	
	14.1	Stainless steel	1.0D	1.0D [0.6D]	SFM (Vc)	315	315	315	315	315	315	315	315	315	315	315	
					IPT (fz)	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0025	.0028	.0030	.0031	
					RPM	9625	6385	4810	3850	3210	2750	2400	2140	1925	1600	1200	
	S	31-35	Heat Resistant Super Alloys	1.0D	0.5D	SFM (Vc)	85	85	85	85	85	85	85	85	85	85	80
						IPT (fz)	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0025	.0027	.0031	.0034
						RPM	2565	1685	1285	1025	855	735	640	570	510	425	315
36-37		Titanium Alloys	1.0D	1.0D [0.6D]	SFM (Vc)	270	270	270	270	270	275	270	270	270	275	270	
					IPT (fz)	.0002	.0004	.0006	.0008	.0014	.0022	.0025	.0029	.0032	.0035	.0036	
					RPM	8320	5550	4160	3330	2770	2380	2080	1850	1660	1390	1040	

*() : Short length Type
*[] : Stub length Type



*1.2 x D Axial cutting depth should be applied for Short length series DIA over 5/16mm
*0.6 x D Axial cutting depth should be applied for Stub length series.

YG V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

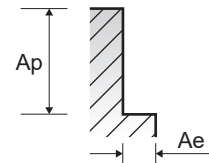
EMB41, EMB42, EMB43, EMB44 EMB14, EMB39, EMB15, EMB40 SERIES

4 FLUTES - SIDE CUTTING

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0		
P	1-2	Non-alloy steel	0.5D	1.5D (1.2D)	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	460		
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025		
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780		
	6	Low alloy steel	0.5D	1.5D (1.2D)	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	460		
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025		
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780		
	10	High alloyed steel, and tool steel	0.5D	1.5D (1.2D)	SFM(Vc)	415	415	415	415	415	460	460	460	460	460	460	460		
					IPT(fz)	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025		
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780		
M	12-13	Stainless steel	0.5D	1.5D (1.2D)	SFM(Vc)	440	590	445	440	440	440	440	440	440	440	440	440		
					IPT(fz)	.0001	.0002	.0004	.0005	.0009	.0013	.0016	.0017	.0018	.0020	.0022	.0022		
					RPM	14260	14260	8660	7130	5350	4280	3570	3060	2670	2380	2140	1710		
	14.1	Stainless steel	0.5D	1.5D (1.2D)	SFM(Vc)	315	315	315	315	315	315	315	315	315	315	315	315		
					IPT(fz)	.0002	.0003	.0005	.0007	.0011	.0019	.0022	.0023	.0025	.0028	.0030	.0031		
					RPM	10190	7600	6110	5100	3820	3060	2550	2180	1910	1700	1530	1220		
	S	31-35	Heat Resistant Super Alloys	0.35D	1.0D	SFM(Vc)	85	85	85	85	85	85	85	85	85	85	85	80	
						IPT(fz)	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0024	.0025	.0027	.0030	.0034	
						RPM	2720	2010	1630	1360	1020	820	680	580	510	450	410	320	
36-37		Titanium Alloys	0.5D	1.5D (1.2D)	SFM(Vc)	315	315	315	315	270	315	315	315	315	315	315	315		
					IPT(fz)	.0002	.0003	.0005	.0007	.0014	.0019	.0022	.0023	.0025	.0028	.0030	.0031		
					RPM	10190	7600	6110	5100	3280	3060	2550	2180	1910	1700	1530	1220		
						IPM(Feed)	11	13	15	17	22	27	27	24	23	23	23	18	
						IPM(Feed)	11	13	15	17	22	27	27	24	23	23	23	18	
						IPM(Feed)	11	13	15	17	22	27	27	24	23	23	23	18	
						IPM(Feed)	8	10	12	14	18	23	22	20	19	19	19	15	
						IPM(Feed)	8	10	12	14	17	23	22	20	19	19	19	15	
						IPM(Feed)	2	2	3	4	5	6	6	6	5	5	5	4	
						IPM(Feed)	8	10	12	14	18	23	22	20	19	19	19	15	

*() : Short length Type



*1.2 x D Axial cutting depth should be applied for Short length series DIA over 5/16mm



V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

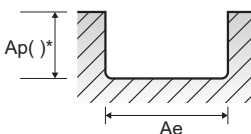
EMB41, EMB42, EMB43, EMB44 EMB14, EMB39, EMB15, EMB40 SERIES

4 FLUTE - **SLOTTING**

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
P	1-2	Non-alloy steel	1.0D	1.0D	SFM	415	415	415	415	415	460	460	460	460	460	460	460	
					IPT	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025	
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780	
	6	Low alloy steel	1.0D	1.0D	SFM	415	415	415	415	415	460	460	460	460	460	460	460	
					IPT	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025	
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780	
	10	High alloyed steel, and tool steel	1.0D	1.0D	SFM	415	415	415	415	415	460	460	460	460	460	460	460	
					IPT	.0002	.0003	.0005	.0006	.0011	.0015	.0018	.0019	.0021	.0023	.0026	.0025	
					RPM	13480	10110	8090	6740	5050	4460	3710	3180	2790	2480	2230	1780	
M	12-13	Stainless steel	1.0D	1.0D	SFM	440	590	445	440	440	440	440	440	440	440	440	440	
					IPT	.0001	.0002	.0004	.0005	.0009	.0013	.0016	.0017	.0018	.0020	.0022	.0022	
					RPM	14260	14260	8660	7130	5350	4280	3570	3060	2670	2380	2140	1710	
	14.1	Stainless steel	1.0D	1.0D	SFM	315	315	315	315	315	315	315	315	315	315	315	315	
					IPT	.0002	.0003	.0005	.0007	.0011	.0019	.0022	.0023	.0025	.0028	.0030	.0031	
					RPM	10190	7600	6110	5100	3820	3060	2550	2180	1910	1700	1530	1220	
	S	31-35	Heat Resistant Super Alloys	1.0D	0.5D	SFM	85	85	85	85	85	85	85	85	85	85	85	80
						IPT	.0002	.0003	.0005	.0007	.0012	.0019	.0022	.0024	.0025	.0027	.0030	.0034
						RPM	2720	2010	1630	1360	1020	820	680	580	510	450	410	320
36-37		Titanium Alloys	1.0D	1.0D	SFM	315	315	315	315	270	315	315	315	315	315	315	315	
					IPT	.0002	.0003	.0005	.0007	.0014	.0019	.0022	.0023	.0025	.0028	.0030	.0031	
					RPM	10190	7600	6110	5100	3280	3060	2550	2180	1910	1700	1530	1220	

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



*() : Short length Type

*1.2 x D Axial cutting depth should be applied for Short length series DIA over 5/16mm

YG V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

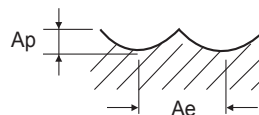
EMB78, EMB79 SERIES

4 FLUTES - PLANE

SFM(Vc) = ft./min.
 IPT(fz) = in./tooth
 RPM = rev./min.
 IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)										
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1
P	1-2	Non-alloy steel	0.5D	1.0D	SFM	445	445	445	445	445	445	440	445	445	445	440
					IPT	.0010	.0012	.0015	.0023	.0024	.0026	.0028	.0028	.0029	.0035	.0039
					RPM	13530	9020	6770	5410	4510	3870	3380	3010	2710	2260	1690
					IPM	53	43	41	51	43	40	37	34	32	32	27
	6	Low alloy steel	0.5D	1.0D	SFM	445	445	445	445	445	445	440	445	445	445	440
					IPT	.0010	.0012	.0015	.0023	.0024	.0026	.0028	.0028	.0029	.0035	.0039
					RPM	13530	9020	6770	5410	4510	3870	3380	3010	2710	2260	1690
					IPM	53	43	41	51	43	40	37	34	32	32	27
	10	High alloyed steel, and tool steel	0.5D	1.0D	SFM	445	445	445	445	445	445	440	445	445	445	440
IPT					.0010	.0012	.0015	.0023	.0024	.0026	.0028	.0028	.0029	.0035	.0039	
RPM					13530	9020	6770	5410	4510	3870	3380	3010	2710	2260	1690	
IPM					53	43	41	51	43	40	37	34	32	32	27	
M	12-13	Stainless steel	0.5D	1.0D	SFM	230	230	230	230	230	230	230	230	230	230	230
					IPT	.0006	.0010	.0012	.0016	.0018	.0019	.0020	.0021	.0021	.0023	.0023
					RPM	7020	4680	3510	2810	2340	2010	1750	1560	1400	1170	880
					IPM	16	18	16	18	17	15	14	13	12	11	8
	14.1	Stainless steel	0.5D	1.0D	SFM	255	255	255	255	255	255	255	255	255	255	255
					IPT	.0008	.0010	.0016	.0018	.0020	.0021	.0022	.0023	.0024	.0026	.0028
					RPM	7770	5180	3880	3110	2590	2220	1940	1730	1550	1290	970
					IPM	24	20	25	22	20	18	17	16	15	13	11
S	31-35	Heat Resistant Super Alloys	0.2D	0.3D	SFM	100	100	100	100	100	100	100	100	100	100	100
					IPT	.0004	.0004	.0006	.0010	.0011	.0013	.0015	.0017	.0018	.0021	.0020
					RPM	3010	2010	1500	1200	1000	860	750	670	600	500	380
	36-37	Titanium Alloys	0.5D	1.0D	SFM	180	180	180	180	180	180	180	180	180	180	180
					IPT	.0005	.0006	.0008	.0012	.0012	.0014	.0016	.0016	.0017	.0024	.0027
					RPM	5510	3680	2760	2210	1840	1580	1380	1230	1100	920	690
					IPM	10	9	9	10	9	9	8	8	9	7	

SFM = Surface Feet per Minute
 RPM = Revolutions Per Minute
 IPT = Inches Per Tooth
 IPM = Inches Per Minute
 Ap : Inch (Axial Depth of Cut)
 Ae : Inch (Radial Depth of Cut)



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



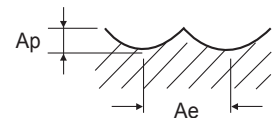
V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

EMB74, EMB75 SERIES

4 FLUTES - PLANE

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	18.0	20.0	25.0	
P	1-2	Non-alloy steel	0.5D	1.0D	SFM (Vc)	445	445	445	460	445	440	445	440	440	440	440	
					IPT (fz)	.0010	.0010	.0012	.0015	.0023	.0024	.0027	.0029	.0031	.0035	.0039	
					RPM	14320	10740	8590	7460	5370	4290	3580	2680	2380	2140	1710	
	6	Low alloy steel	0.5D	1.0D	SFM (Vc)	445	445	445	460	445	440	445	440	440	440	440	
					IPT (fz)	.0010	.0010	.0012	.0015	.0023	.0024	.0027	.0029	.0031	.0035	.0039	
					RPM	14320	10740	8590	7460	5370	4290	3580	2680	2380	2140	1710	
	10	High alloyed steel, and tool steel	0.5D	1.0D	SFM (Vc)	445	445	445	460	445	440	445	440	440	440	440	
					IPT (fz)	.0010	.0010	.0012	.0015	.0023	.0024	.0027	.0029	.0031	.0035	.0039	
					RPM	14320	10740	8590	7460	5370	4290	3580	2680	2380	2140	1710	
M	12-13	Stainless steel	0.5D	1.0D	SFM (Vc)	230	230	230	230	230	230	230	230	230	230	230	
					IPT (fz)	.0006	.0006	.0010	.0012	.0016	.0018	.0020	.0021	.0023	.0023	.0023	
					RPM	7420	5570	4450	3710	2780	2220	1850	1390	1230	1110	890	
	14.1	Stainless steel	0.5D	1.0D	SFM (Vc)	255	255	255	255	255	255	255	255	255	255	255	
					IPT (fz)	.0008	.0008	.0010	.0016	.0018	.0020	.0022	.0024	.0025	.0026	.0027	
					RPM	8220	6160	4930	4110	3080	2460	2050	1540	1370	1230	980	
	S	31-35	Heat Resistant Super Alloys	0.2D	0.3D	SFM (Vc)	100	100	100	100	100	100	100	95	100	95	100
						IPT (fz)	.0004	.0004	.0004	.0006	.0010	.0010	.0015	.0018	.0020	.0021	.0021
						RPM	3180	2380	1910	1590	1190	950	790	590	530	470	380
36-37		Titanium Alloys	0.5D	1.0D	SFM (Vc)	180	180	180	180	180	180	180	180	180	180	180	
					IPT (fz)	.0005	.0005	.0006	.0008	.0012	.0012	.0016	.0017	.0019	.0024	.0027	
					RPM	5830	4370	3500	2910	2180	1750	1450	1090	970	870	700	
						IPM (FEED)	56	42	41	45	50	41	39	31	30	30	27



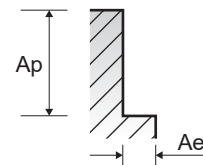
YG V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

EMB76, EMB77 SERIES

5 FLUTES - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1	
P	1-2	Non-alloy steel	0.25D	1.25D	SFM (Vc)	450	450	450	450	450	450	450	450	450	
					IPT (fz)	.0013	.0015	.0020	.0022	.0025	.0027	.0030	.0035	.0040	
					RPM	6870	5490	4580	3920	3430	3050	2750	2290	1720	
					IPM (FEED)	46	41	46	44	43	42	41	40	34	
	6	Low alloy steel	0.25D	1.25D	SFM (Vc)	450	450	450	450	450	450	450	450	450	
					IPT (fz)	.0013	.0015	.0020	.0022	.0025	.0027	.0030	.0035	.0040	
					RPM	6870	5490	4580	3920	3430	3050	2750	2290	1720	
					IPM (FEED)	46	41	46	44	43	42	41	40	34	
	10	High alloyed steel, and tool steel	0.25D	1.25D	SFM (Vc)	450	450	450	450	450	450	450	450	450	
					IPT (fz)	.0013	.0015	.0020	.0022	.0025	.0027	.0030	.0035	.0040	
					RPM	6870	5490	4580	3920	3430	3050	2750	2290	1720	
					IPM (FEED)	46	41	46	44	43	42	41	40	34	
M	12-13	Stainless steel	0.25D	1.25D	SFM (Vc)	350	350	350	350	350	350	350	350	350	
					IPT (fz)	.0012	.0012	.0015	.0016	.0017	.0025	.0027	.0030	.0035	
					RPM	5310	4250	3540	3040	2660	2360	2130	1770	1330	
					IPM (FEED)	32	27	26	24	22	30	28	26	23	
	14.1	Stainless steel	0.25D	1.25D	SFM (Vc)	375	375	375	375	375	375	375	375	375	
					IPT (fz)	.0012	.0013	.0015	.0020	.0025	.0026	.0027	.0030	.0035	
					RPM	5710	4570	3810	3270	2860	2540	2290	1900	1430	
					IPM (FEED)	34	29	29	33	36	33	31	29	25	
S	31-35	Heat Resistant Super Alloys	0.25D	1.0D	SFM (Vc)	90	90	90	90	90	90	90	90	90	
					IPT (fz)	.0007	.0008	.0010	.0012	.0014	.0018	.0019	.0024	.0030	
					RPM	1350	1080	900	770	680	600	540	450	340	
					IPM (FEED)	4	4	5	5	5	5	5	5	5	
	36-37	Titanium Alloys	0.25D	1.25D	SFM (Vc)	275	275	275	275	275	275	275	275	275	
					IPT (fz)	.0012	.0012	.0015	.0017	.0020	.0022	.0025	.0030	.0035	
					RPM	4200	3360	2800	2400	2100	1860	1680	1400	1050	
					IPM (FEED)	25	21	21	21	21	21	21	21	18	



HSS

CBN
END MILLS

i-Xmill
END MILLS

i-SMART
MODULAR
END MILLS

X5070
END MILLS

4G MILL
END MILLS

X-POWER
PRO
END MILLS

TitaNox-
POWER
END MILLS

JET-POWER
END MILLS

V7 PLUS A
END MILLS

V7 MILL
INOX

ALU-POWER
HPC
END MILLS

ALU-
POWER
END MILLS

D-POWER
GRAPHITE
END MILLS

STANDARD
CARBIDE

ONLY ONE
COATED PM60
END MILLS

SINE-
POWER

TANK-
POWER
END MILLS

STANDARD
COBALT &
HSS

TECHNICAL
DATA



V7 MILL INOX END MILLS

RECOMMENDED CUTTING CONDITIONS

EMB72, EMB73 SERIES

5 FLUTES - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						6.0	8.0	10.0	12.0	14.0	16.0	20.0
P	1-2	Non-alloy steel	0.25D	1.25D	SFM (Vc)	445	445	445	445	445	445	445
					IPT (fz)	.0013	.0015	.0020	.0025	.0027	.0030	.0035
					RPM	7160	5370	4300	3580	3070	2690	2150
	6	Low alloy steel	0.25D	1.25D	SFM (Vc)	450	450	450	450	450	450	450
					IPT (fz)	.0013	.0015	.0020	.0022	.0025	.0027	.0035
					RPM	6870	5490	4580	3920	3430	3050	2290
	10	High alloyed steel, and tool steel	0.25D	1.25D	SFM (Vc)	450	450	450	450	450	450	450
					IPT (fz)	.0013	.0015	.0020	.0022	.0025	.0027	.0035
					RPM	6870	5490	4580	3920	3430	3050	2290
M	12-13	Stainless steel	0.25D	1.25D	SFM (Vc)	345	345	345	475	345	345	345
					IPT (fz)	.0012	.0013	.0015	.0017	.0025	.0027	.0030
					RPM	5570	4180	3340	3850	2390	2090	1670
	14.1	Stainless steel	0.25D	1.25D	SFM (Vc)	375	380	375	375	380	380	375
					IPT (fz)	.0012	.0013	.0015	.0025	.0026	.0027	.0030
					RPM	6100	4580	3660	3050	2620	2290	1830
S	31-35	Heat Resistant Super Alloys	0.25D	1.0D	SFM (Vc)	80	80	80	80	80	80	80
					IPT (fz)	.0007	.0008	.0010	.0014	.0018	.0019	.0023
					RPM	1330	1000	800	660	570	500	400
	36-37	Titanium Alloys	0.25D	1.25D	SFM (Vc)	280	280	280	280	280	280	280
					IPT (fz)	.0012	.0012	.0015	.0020	.0022	.0025	.0030
					RPM	4510	3380	2710	2260	1930	1690	1350
					IPM (FEED)	27	21	20	22	22	21	20

