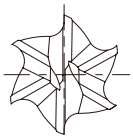
V7 PLUS END MILLS

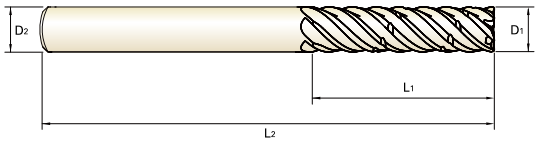
PLAIN SHANK **GMH56** SERIES
FLAT SHANK **GMH57** SERIES

CARBIDE, 6 FLUTE EXTRA LONG LENGTH CHIP SPLITTER

VOLLHARTMETALL, 6-SCHNEIDEN-SPANTEILER MIT EXTRA LANGER LÄNGE
Carbure, 6 Dents, Torique, Extra-Longue, Fendeur Des Copeaux
MD, 6 TAGLIENTI, SERIE EXTRA LUNGA CON ROMPI TRUCIOLO

- ▶Special chip splitter design for better chip removal shortened chip length at high axial machining
- ▶High Performance for Steels, Stainless Steels and Cast Iron
- ▶ Spezielles Spanteilerdesign für verbesserte Spanabfuhr durch kurze Späne bei hohem axialen Eingriff
- ▶ Hohe Leistung bei der Bearbeiting von Stählen, rostfreien Stählen und Gusseisen.





CARBIDE | 6 | 45° | PLAIN | FLAT | Y Coating | p.C439

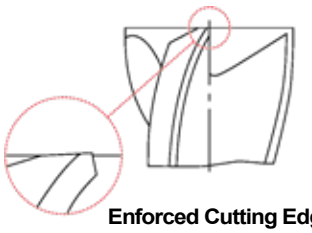
Recommended ToolHolder

Flat Shank	Page	Plain Shank	Page
END MILL HOLDER	D118 - 137	POWER MILLING CHUCK	D161 - 176
-	-	SHRINK FIT HOLDER	D47 - 72
-	-	HYDRAULIC CHUCK	D15 - 46
		ER COLLET CHUCK	D73 - 116
		SK SLIM CHUCK	D183 - 201

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	D1	D2	L1	L2
GMH56060	**GMH57060**	**6.0**	6	24	75
GMH56080	**GMH57080**	**8.0**	8	32	75
GMH56100	**GMH57100**	**10.0**	10	40	100
GMH56120	**GMH57120**	**12.0**	12	48	120
GMH56160	**GMH57160**	**16.0**	16	64	140
GMH56200	**GMH57200**	**20.0**	20	80	150
GMH56250	**GMH57250**	**25.0**	25	100	170

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5 * Shank Dia.≥Ø12 : h6



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend											○	○	○	○	○	○	○				

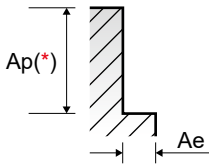
V7 PLUS END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

GMH58 GMH59 GMH56 GMH57 6 FLUTE CHIP SPLITTER - SIDE CUTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1-4	Non-alloy steel	0.05D	3.0D	Vc	300	300	300	300	300	300	300
					fz	0.068	0.116	0.144	0.173	0.202	0.225	0.232
					RPM	15915	11937	9549	7958	5968	4775	3820
					FEED	6494	8308	8251	8260	7234	6446	5317
	5	Low alloy steel	0.05D	3.0D	Vc	205	205	205	205	205	205	205
					fz	0.050	0.085	0.106	0.128	0.149	0.167	0.174
					RPM	10876	8157	6525	5438	4078	3263	2610
					FEED	3263	4160	4150	4176	3646	3269	2725
	6-7		0.05D	3.0D	Vc	300	300	300	300	300	300	300
					fz	0.068	0.116	0.144	0.173	0.202	0.225	0.232
					RPM	15915	11937	9549	7958	5968	4775	3820
					FEED	6494	8308	8251	8260	7234	6446	5317
	8-9		0.05D	3.0D	Vc	205	205	205	205	205	205	205
					fz	0.050	0.085	0.106	0.128	0.149	0.167	0.174
					RPM	10876	8157	6525	5438	4078	3263	2610
					FEED	3263	4160	4150	4176	3646	3269	2725
	10-11.1	High alloyed steel, and tool steel	0.05D	3.0D	Vc	100	100	100	100	100	100	100
					fz	0.041	0.071	0.088	0.105	0.123	0.137	0.144
					RPM	5305	3979	3183	2653	1989	1592	1273
					FEED	1305	1695	1681	1671	1468	1308	1100
M	12-13	Stainless steel	0.05D	3.0D	Vc	215	215	215	215	215	215	215
					fz	0.049	0.084	0.104	0.125	0.146	0.162	0.168
					RPM	11406	8555	6844	5703	4277	3422	2737
					FEED	3353	4312	4270	4277	3747	3326	2759
	14.1		0.05D	3.0D	Vc	145	145	145	145	145	145	145
					fz	0.041	0.071	0.088	0.105	0.123	0.137	0.143
					RPM	7692	5769	4615	3846	2885	2308	1846
					FEED	1892	2458	2437	2423	2129	1897	1584
	14.2		0.05D	3.0D	Vc	135	135	135	135	135	135	135
					fz	0.041	0.071	0.088	0.105	0.123	0.137	0.142
					RPM	7162	5371	4297	3581	2686	2149	1719
					FEED	1762	2288	2269	2256	1982	1766	1464
K	15-20	Grey cast iron	0.05D	3.0D	Vc	225	225	225	225	225	225	225
					fz	0.082	0.139	0.173	0.208	0.242	0.270	0.278
					RPM	11937	8952	7162	5968	4476	3581	2865
					FEED	5844	7477	7426	7434	6510	5801	4785
S	31-35	Heat Resistant Super Alloys	0.05D	3.0D	Vc	35	35	35	35	35	35	35
					fz	0.033	0.055	0.070	0.082	0.097	0.112	0.115
					RPM	1857	1393	1114	928	696	557	446
					FEED	368	460	468	457	405	374	307
	36-37	Titanium Alloys	0.05D	3.0D	Vc	115	115	115	115	115	115	115
					fz	0.033	0.055	0.070	0.083	0.097	0.113	0.117
					RPM	6101	4576	3661	3050	2288	1830	1464
					FEED	1208	1510	1537	1519	1332	1241	1028



(*) : If product's Length of Cut(L.O.C) is below 2D, it must be applied with L.O.C x 90%

SELECTION GUIDE

YG MILLING TOOLS

SERIES	GMG55 GMG56	GMF54 GMF55	GMF58 GMF59
FLUTE	4	4	4
HELIX ANGLE	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)
CUTTING EDGE SHAPE	BALL NOSE	CORNER RADIUS	CORNER RADIUS
SIZE MIN	R1.5	D3.0	D3.0
SIZE MAX	R12.5	D20.0	D25.0
PAGE	C418	C419	C420
	LONG LENGTH	SHORT LENGTH	LONG LENGTH
	Y-Coating	Y-Coating	Y-Coating

SOLID CARBIDE
V7 PLUS END MILLS

High performance carbide end mills
for Steels, Cast Iron and Stainless Steels

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p. C436

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc			
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	◎
	5		About 0.75% C	Quenched & Tempered	300	32	◎	◎	◎
	6	Low alloy steel		Annealed	180	10	◎	◎	◎
	7			Quenched & Tempered	275	29	◎	◎	◎
	8			Quenched & Tempered	300	32	◎	◎	◎
	9			Quenched & Tempered	350	38	◎	◎	◎
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎
	11			Quenched & Tempered	325	35	◎	◎	◎
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	◎	◎	◎
	13		Martensitic	Quenched & Tempered	240	23	◎	◎	◎
	14		Austenitic		180	10	◎	◎	◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	◎	◎
	16		Pearlitic (Martensitic)		260	26	◎	◎	◎
	17	Nodular cast iron	Ferritic		160	3	◎	◎	◎
	18		Pearlitic		250	25	◎	◎	◎
	19	Malleable cast iron	Ferritic		130		◎	◎	◎
	20		Pearlitic		230	21	◎	◎	◎
N	21	Aluminum-wrought alloy	Not Curable		60				
	22		Curable	Hardened	100				
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75				
	24		≤ 12% Si, Curable	Hardened	90				
	25		> 12% Si, Not Curable		130				
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90				
	28		CuSn, lead-free copper and electrolytic copper		100				
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic						
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	○	○	○
	32			Cured	280	30	○	○	○
	33		Ni or Co Based	Annealed	250	25	○	○	○
	34			Cured	350	38	○	○	○
	35			Cast	320	34	○	○	○
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○
	37		Alpha + Beta Alloys	Hardened	1050 Rm		○	○	○
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42			
	41	Hardened Cast Iron		Hardened	550	55			

GMF62 GMF63	GMF52 GMF53	GMF56 GMF57	GMF60 GMF61	GMG16 GMG17	GMG18 GMG19	GMH58 GMH59	GMG12 GMG13	GMG14 GMG15	GMH56 GMH57	EMB72 EMB73	
4	4	4	4	6	6	6	6	6	6	5	
35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	35°/37° (MULTIPLE HELIX)	45°	45°	45°	45°	45°	45°	41°~ 45°	
CORNER RADIUS	SQUARE	SQUARE	SQUARE	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	SQUARE	SQUARE	SQUARE	SQUARE	
D3.0	D3.0	D3.0	D3.0	D6.0	D6.0	D6.0	D6.0	D6.0	D6.0	D6.0	
D20.0	D20.0	D25.0	D20.0	D25.0	D25.0	D25.0	D25.0	D25.0	D25.0	D25.0	
C421	**C424**	**C425**	**C426**	**C428**	**C429**	**C431**	**C432**	**C433**	**C434**	**C435**	
LONG LENGTH with NECK	SHORT LENGTH	LONG LENGTH	LONG LENGTH with NECK	LONG LENGTH	EXTRA LONG LENGTH	EXTRA LONG LENGTH	LONG LENGTH	EXTRA LONG LENGTH	EXTRA LONG LENGTH	LONG LENGTH	
Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	AlTiN	
						CHIP SPLITTER			CHIP SPLITTER	V7 INOX	
											
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