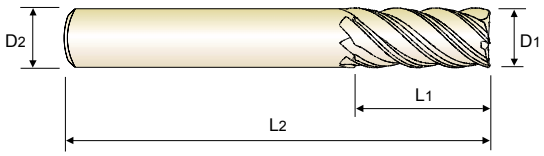
Y-COATED SOLID CARBIDE END MILLS
5 FLUTE LONG LENGTH

GMG26 PLAIN SHANK
GMG27 FLAT SHANK

- ▶ Excellent results and long tool life when machining Titanium and other hard to machine materials.
- ▶ High rigidity of flutes making it possible to use for heavy profile and high speed milling.
- ▶ Protected corner chipping of end teeth, also Corner Radius & Chamfer are adopted

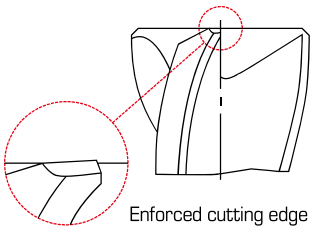


MG HM | 5 | 43/44/45° | PLAIN | FLAT | C x 45° | P. 15

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Chamfer Size
PLAIN	FLAT	D_1	D_2	L_1	L_2	
GMG26060	GMG27060	6.0	6	13	57	0.20
GMG26080	GMG27080	8.0	8	19	63	0.20
GMG26100	GMG27100	10.0	10	22	72	0.30
GMG26120	GMG27120	12.0	12	26	83	0.35
GMG26160	GMG27160	16.0	16	36	92	0.40
GMG26200	GMG27200	20.0	20	44	104	0.50
GMG26250	GMG27250	25.0	25	54	121	0.50

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ -0.03	h6



◎ : Excellent ○ : Good

P					H	M	K	N					S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○	○	○				◎							◎	○

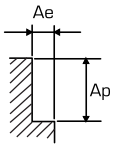
· Phone: +82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr

Y-COATED SOLID CARBIDE END MILLS
5 FLUTE

GMG24, GMG25, GMG26, GMG27, GMG28, GMG29, GMG30, GMG31 SERIES

Speed and Feed Recommendations							Diameter (mm)								
ISO Hardness (Brinell)	Work Materials	Type of Cut	Ap x D1	Ae x D1	Vc	Parameters	6	8	10	12	14	16	18	20	25
P < 300	CARBON STEELS 1.1191(C45) 1.0726(35 S 20) 1.0715(9 SMn 28) 1.0718(9 SMnPb 28)	Side Cutting	1.5	0.3	144 (115-173)	RPM	7639	5730	4584	3820	3274	2865	2546	2292	1833
						Fz	0.034	0.038	0.050	0.063	0.069	0.076	0.083	0.089	0.101
						FEED	1299	1089	1146	1203	1130	1089	1057	1020	926
P > 300 P < 380	ALLOY STEELS 1.2330(35 CrMo 4) 1.6565(40NiCrMo6) 1.7033(34Cr4) 1.6523(21 NiCrMo2)	Side Cutting	1.5	0.3	101 (81-121)	RPM	5358	4019	3215	2679	2296	2009	1786	1607	1286
						Fz	0.034	0.038	0.050	0.063	0.069	0.076	0.083	0.089	0.101
						FEED	911	764	804	844	792	764	741	715	649
P < 380	TOOL STEELS 1.2363(X100 CrMoV 5 1) 1.2379(X155 CrVMo 12 1) 1.2344(X40 CrMoV 5 1) 1.3243(S 6-5-2-5)	Side Cutting	1.5	0.3	60 (48-72)	RPM	3183	2387	1910	1592	1364	1194	1061	955	764
						Fz	0.024	0.027	0.035	0.044	0.049	0.054	0.058	0.062	0.071
						FEED	382	322	334	350	334	322	308	296	271
K < 260	CAST IRON 0.6020(GG20) 0.8145(GTS-45-06) 0.7060(GGG-60)	Side Cutting	1.5	0.3	106 (85-127)	RPM	5623	4218	3374	2812	2410	2109	1874	1687	1350
						Fz	0.043	0.048	0.063	0.079	0.087	0.096	0.103	0.111	0.126
						FEED	1209	1012	1063	1111	1048	1012	965	936	850
M	STAINLESS STEELS 300 1.4301(X5 CrNi 18 10) 1.4436(X3 CrNiMo 17 13 3) 1.4306(X2 CrNi 19 11) 1.4435(X2 CrNiMo 18 14 3)	Side Cutting	1.5	0.3	82 (66-98)	RPM	4350	3263	2610	2175	1864	1631	1450	1305	1044
						Fz	0.030	0.032	0.038	0.063	0.065	0.069	0.070	0.076	0.088
						FEED	653	522	496	685	606	563	508	496	459
M	STAINLESS STEELS 400 1.4005(X12 CrS 13) 1.4104(X12 CrMoS 17)	Side Cutting	1.5	0.3	117 (94-140)	RPM	6207	4655	3724	3104	2660	2328	2069	1862	1490
						Fz	0.024	0.025	0.030	0.046	0.051	0.054	0.057	0.061	0.071
						FEED	745	582	559	714	678	628	590	568	529
M	STAINLESS STEELS(PH) 1.4594(Z7 CNU 15.05)	Side Cutting	1.5	0.3	59 (47-71)	RPM	3130	2348	1878	1565	1341	1174	1043	939	751
						Fz	0.030	0.032	0.038	0.063	0.065	0.069	0.070	0.076	0.088
						FEED	470	376	357	493	436	405	365	357	331
S	TITANIUM Ti6Al4V Ti5Al5V5Mo Ti7Al4Mo	Side Cutting	1.5	0.3	69 (55-83)	RPM	3661	2745	2196	1830	1569	1373	1220	1098	879
						Fz	0.027	0.029	0.034	0.057	0.059	0.062	0.063	0.069	0.079
						FEED	494	398	373	522	463	426	384	379	347
S	HIGH TEMPERATURE ALLOYS RENE, INCONEL WASPALOY HASTELLOY	Side Cutting	1.5	0.1	31 (25-37)	RPM	1645	1233	987	822	705	617	548	493	395
						Fz	0.021	0.022	0.027	0.044	0.046	0.048	0.049	0.053	0.062
						FEED	173	136	133	181	162	148	134	131	122

Side Cutting



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

Note

* Maximum recommended depth shown
* Finish cuts typically require reduced feed rates and/or higher spindle speed, with radial width of 2% x D1 or less
* Reduce speed and feed recommendations for materials harder than listed
* Above recommendations are based on ideal conditions.
  Adjust parameters accordingly for smaller taper machining centers or less rigid conditions
* Special design available for Inconel applications