

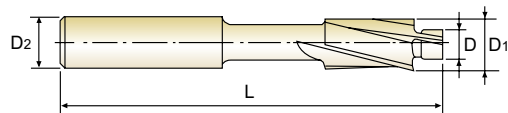
YG YG-1 CO., LTD.

A419



 HSS-E, 3 SCHNEIDEN FLACHSENKER MIT FESTEM FÜHRUNGZAPFEN
 FRAISES À LAMER HSS-E 3 DENTS TÊTE DE VIS À 180°
 LAMATORI A TRE TAGLIENTI IN HSS-E per sedi di viti a testa cilindrica a 180°

► Die Flachsenker mit festem Führungzapfen dienen dem 180° Ansenken für Zylinderkopfschrauben und Auswerferstiften in Formen



Unit : mm

EDP No.	ITEM No.	Screw Size	Pilot Diameter	Cutter Diameter	Shank Diameter	Overall Length
PLAIN	PLAIN		D(e8)	D1(z9)	D2(h9)	L
EL950909	YG54M3-T	M3	2.5	6.0	5	71
EL950910	YG54M3.5-T	M3.5	2.9	6.5	5	71
EL950911	YG54M4-T	M4	3.3	8.0	5	71
EL950912	YG54M5-T	M5	4.2	10.0	8	80
EL950913	YG54M6-T	M6	5.0	11.0	8	80
EL950914	YG54M8-T	M8	6.8	15.0	12.5	100
EL950915	YG54M10-T	M10	8.5	18.0	12.5	100
EL950916	YG54M12-T	M12	10.2	20.0	12.5	100

Toleranzen nach DIN 7160 & 7161

Nominal-Diameter in mm / Nennmaßbereich in mm					Nominal-Diameter in mm / Nennmaßbereich in mm				
	von 1 to 3 über 1 bis 3	über 3 to 6 über 3 bis 6	über 6 to 10 über 6 bis 10	über 10 to 18 über 10 bis 18		von 6 to 10 über 6 bis 10	über 10 to 14 über 10 bis 14	über 14 to 18 über 14 bis 18	über 18 to 24 über 18 bis 24
Tolerance range in µm / Toleranzwerte in µm					Tolerance range in µm / Toleranzwerte in µm				
e8	- 14 - 28	- 20 - 38	- 25 - 47	- 32 - 59	z9	+ 78 + 42	+ 93 + 50	+ 103 + 60	+ 125 + 73
h9	- 0 - 25	0 - 30	0 - 36	0 - 43					

◎ : 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																						
HB	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
Recommended	⊙	⊙	⊙	⊙	⊙	⊙	⊗	⊙	○	⊙	⊕	200	240	180	180	260	160	250	130	230		
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																						
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	○	○	○	○																		



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

ISO	VDI 3323	Material Description	Parameter	Cutter Diameter (Ø)								
				6.0	6.5	8.0	10.0	11.0	15.0	18.0	20.0	
P	1	Non-alloy steel	Vc	25	25	25	25	25	25	25	25	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	1326	1224	995	796	723	531	442	398	
			FEED	322	297	242	258	234	172	167	150	
	2		Vc	24	24	24	24	24	24	24	24	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	1273	1175	955	764	694	509	424	382	
			FEED	309	286	232	248	225	165	160	144	
	3		Vc	18	18	18	18	18	18	18	18	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	955	881	716	573	521	382	318	286	
			FEED	232	214	174	186	169	124	120	108	
	4		Vc	18	18	18	18	18	18	18	18	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	955	881	716	573	521	382	318	286	
			FEED	232	214	174	186	169	124	120	108	
	5	Vc	18	18	18	18	18	18	18	18		
		fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13		
		RPM	955	881	716	573	521	382	318	286		
		FEED	232	214	174	186	169	124	120	108		
	6	Low alloy steel	Vc	24	24	24	24	24	24	24	24	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	1273	1175	955	764	694	509	424	382	
			FEED	309	286	232	248	225	165	160	144	
	7		Vc	18	18	18	18	18	18	18	18	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	955	881	716	573	521	382	318	286	
			FEED	232	214	174	186	169	124	120	108	
	8		Vc	18	18	18	18	18	18	18	18	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	955	881	716	573	521	382	318	286	
			FEED	232	214	174	186	169	124	120	108	
9	Vc		15	15	15	15	15	15	15	15		
	fz		0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13		
	RPM		796	735	597	477	434	318	265	239		
	FEED		193	178	145	155	141	103	100	90		
10	High alloyed steel, and tool steel	Vc	24	24	24	24	24	24	24	24		
		fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13		
		RPM	1273	1175	955	764	694	509	424	382		
		FEED	309	286	232	248	225	165	160	144		
11		Vc	18	18	18	18	18	18	18	18		
		fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13		
		RPM	955	881	716	573	521	382	318	286		
		FEED	232	214	174	186	169	124	120	108		
N		21	Aluminum-wrought alloy	Vc	30	30	30	30	30	30	30	30
				fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13
				RPM	1592	1469	1194	955	868	637	531	477
				FEED	382	353	286	315	286	210	207	186
		22		Vc	30	30	30	30	30	30	30	30
				fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13
				RPM	1592	1469	1194	955	868	637	531	477
				FEED	382	353	286	315	286	210	207	186
	23	Aluminum-cast, alloyed	Vc	20	20	20	20	20	20	20	20	
			fz	0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13	
			RPM	1061	979	796	637	579	424	354	318	
			FEED	255	235	191	210	191	140	138	124	
24	Vc		20	20	20	20	20	20	20	20		
	fz		0.08	0.08	0.08	0.11	0.11	0.11	0.13	0.13		
	RPM		1061	979	796	637	579	424	354	318		
	FEED		255	235	191	210	191	140	138	124		