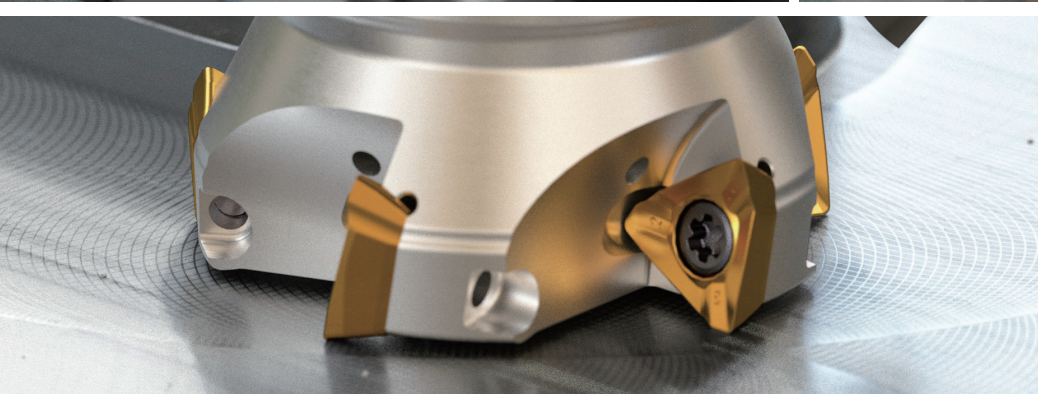




QUICK-SEARCH
YG-1 PRODUCTS!!
www.yg1.solutions



INDEXABLE FOCUS 2024 MILLING & DRILLING





HF4
YG MILL
 High Feed Milling Insert
ENMX
 for Narrow to wide and long reach application



FM10
YG MILL
PNMU
 10 Cutting Edges Negative Face Milling Insert
 YG-1 has developed an innovative milling product PNMU series. The PNMU has 10 cutting edges with a 36° entry angle which can give you higher productivity and stable cutting performance.

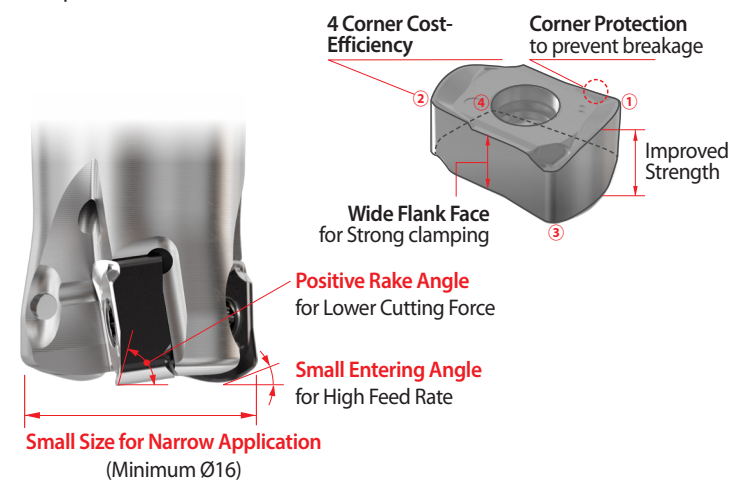
Features

- Cutter Diameter range : 16~125mm (.625"~6")
- Double-sided insert with 4 corners
- Wide flank face with reinforced insert shape
- Positive rake angle & Small entering angle

- ENMX[®] General**
Carbon Steel
Low Alloy Steel
Alloy Steel
- ENMX[®] -TR**
Reinforced Edge
High Alloy Steel
Hardened Steel
Cast Iron
- ENMX[®] -ST**
Sharp Geometry
Stainless Steel
Sticky Material
Super Alloy

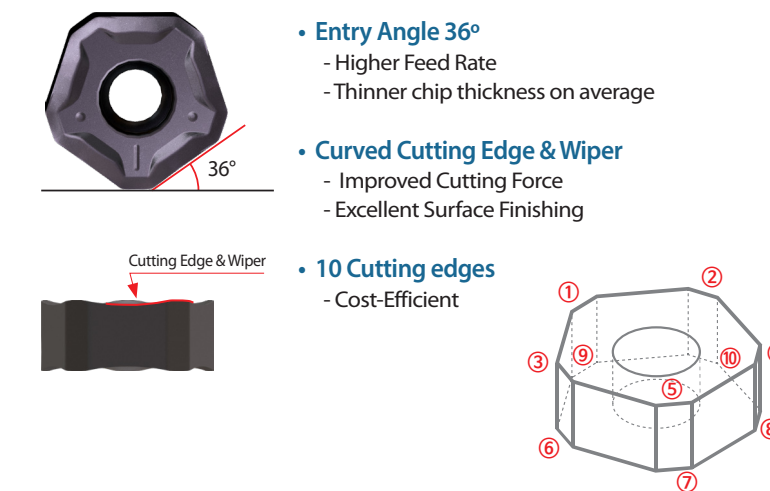
Key Technology

High feed milling, profiling, face milling, ramping, plunging, helical interpolation

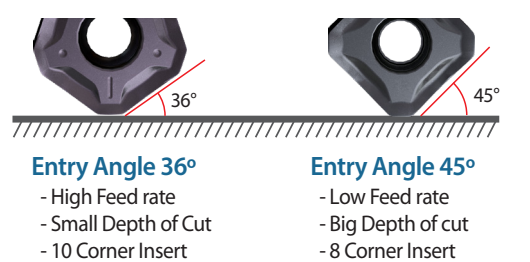


Features

- **Entry Angle 36°**
- Higher Feed Rate
- Thinner chip thickness on average
- **Curved Cutting Edge & Wiper**
- Improved Cutting Force
- Excellent Surface Finishing
- **10 Cutting edges**
- Cost-Efficient



Entry Angle Comparison



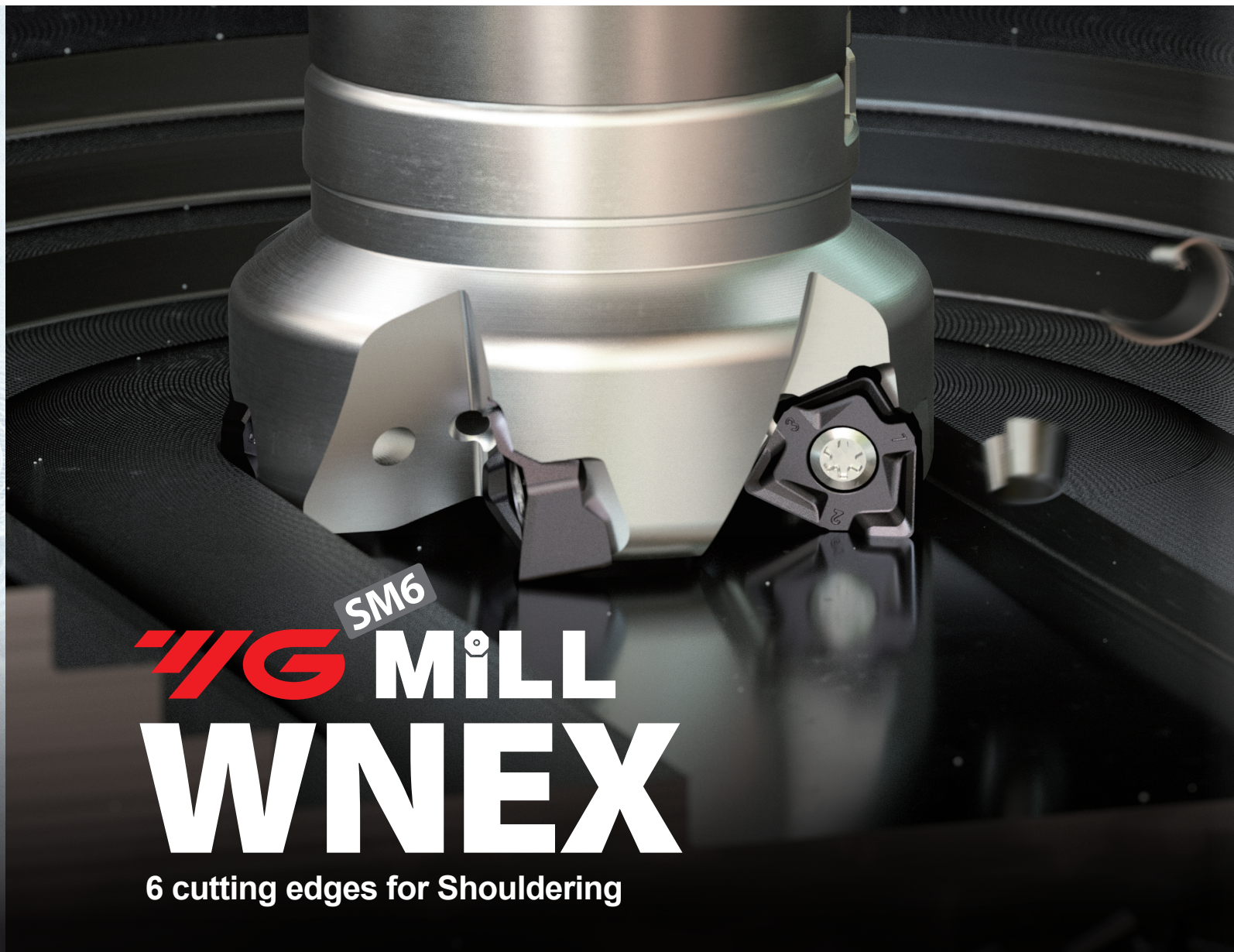
- Entry Angle 36°**
- High Feed rate
- Small Depth of Cut
- 10 Corner Insert
- Entry Angle 45°**
- Low Feed rate
- Big Depth of cut
- 8 Corner Insert



SM3
YGMILL
TPKT

True 90 degree Shoulder Milling

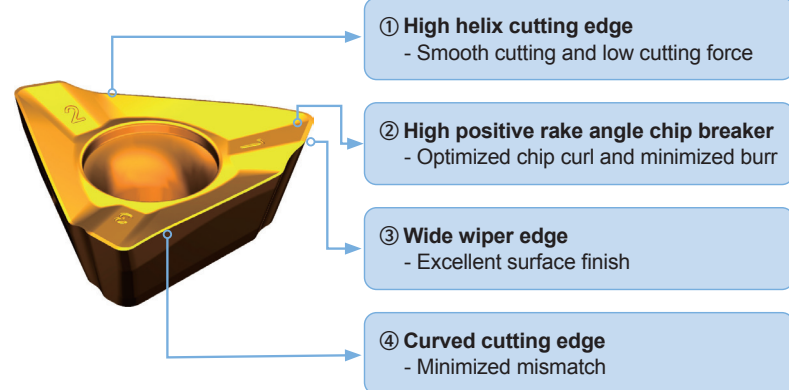
- 3 Cutting Edges for Shoulder Milling
- High Positive Helical Cutting edge
- Higher Cost Efficiency than 2 Cutting edges
- Wide selection and Optimal Machining with Various Cutters and Inserts



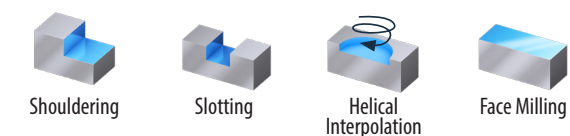
SM6
YGMILL
WNEX

6 cutting edges for Shouldering

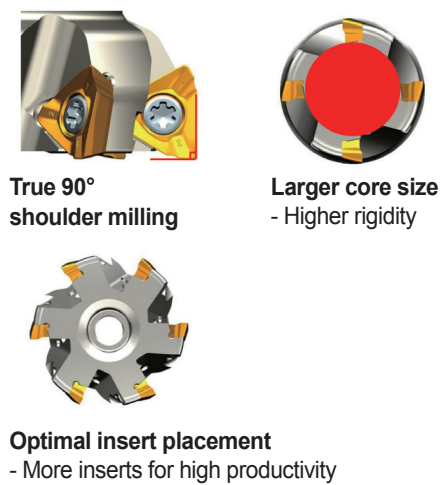
Features



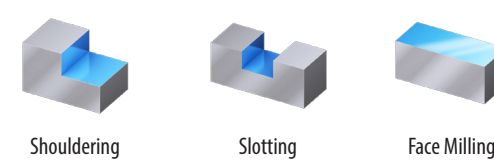
Applications



Key Technology



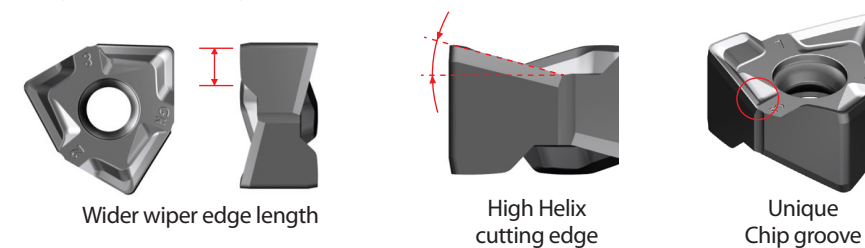
Applications



Features

- 6 cutting edges for Shouldering - High Cost-Efficiency
- High Positive Helical Cutting edge
- High Chipping Resistance with Reinforced cutting edge
- Ground Insert – High Precision Tolerance and Excellent Surface finish
- Diameter range : Ø32~Ø200
- Ap (max) : 7mm

Key Technology





TM4
YG MILL
LNKU

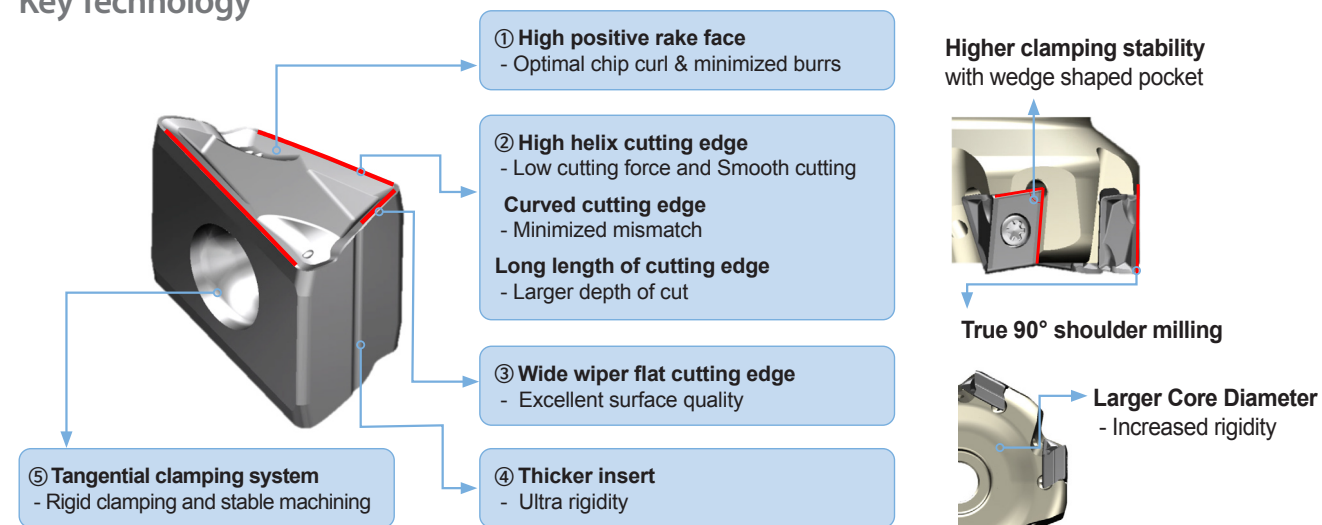
4 cutting edges High Productivity Tangential Insert



YG
X-DRILL
SYMIX

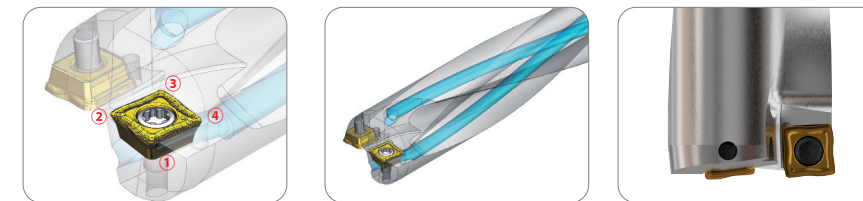
with highly efficient hole making solution

Key Technology



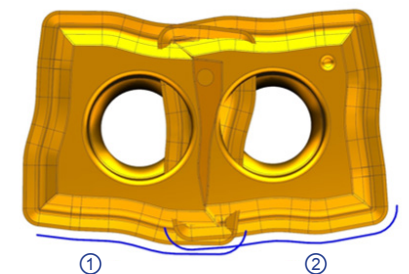
Features

- Economic square type 4 cutting edge insert
- One kind of insert in outer and inner pocket
- Twisted coolant channel and enlarged chip gullet for better chip evacuation
- Highly durable drill body due to high hardness and optimized material
- New post surface Treatment flute enables to improved chip evacuation in deeper machining





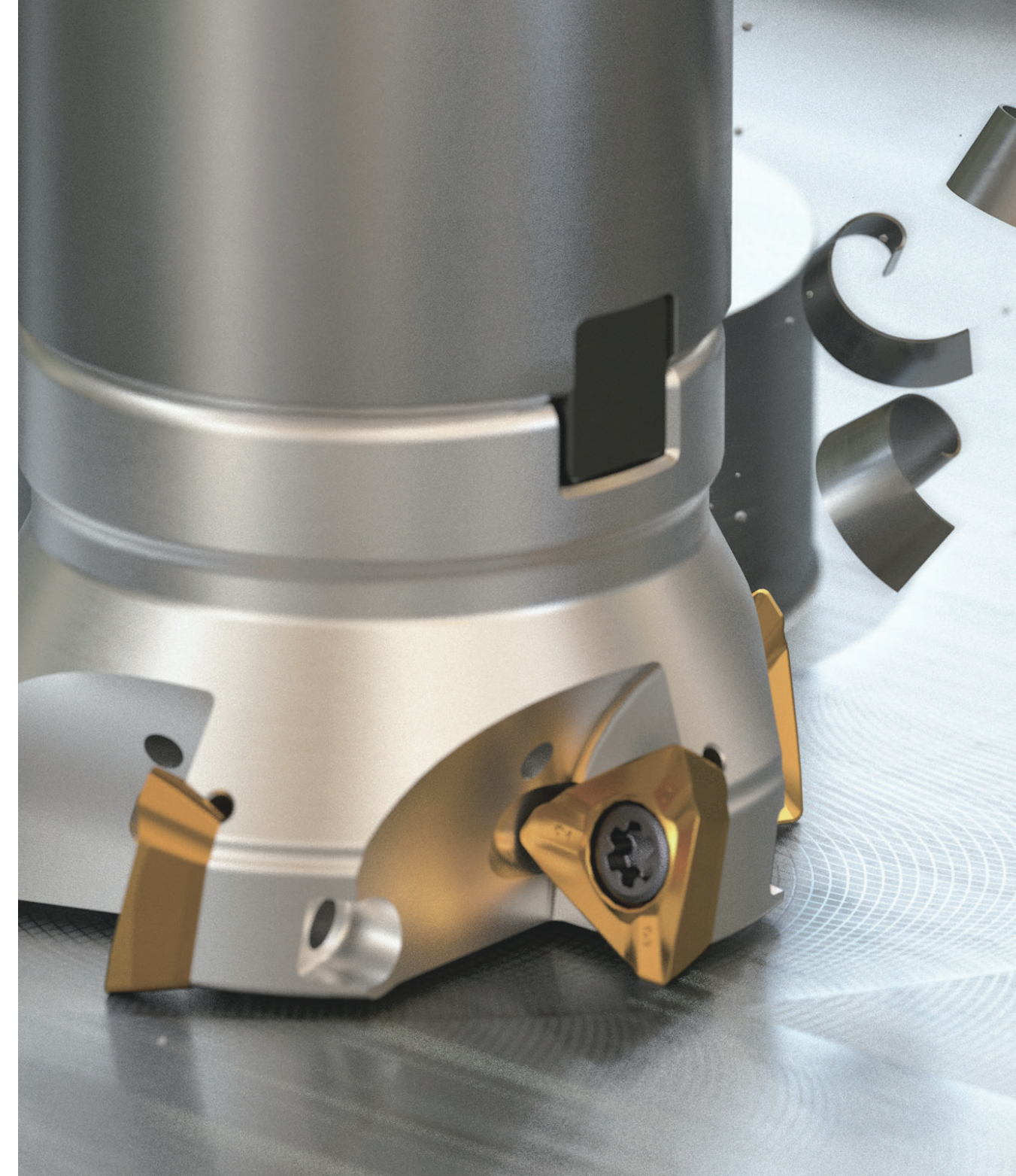
Key Technology

- Unique 1 chip curl per each flute
- True 4 cutting edges are available



INDEX

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		Milling Inserts Overview 13
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	Product	Drilling Inserts 31
Drilling		
		Drilling Holders 32
	Cutting conditions	Recommended cutting conditions 38



MILLING

Milling Grades and Chipbreakers

Milling Grades

Milling Grades	P Steel				M Stainless steel				K Cast iron				N Non-ferrous				S Super alloys				H Hardened Steel			
	P05	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35	H05	H15	H25
PVD	YG012	012																012						
	YG712	712																						
	YG713	713																						
	YG612	612				612												612						
	YG613	613				613																		
	YG501									501														
CVD	YG5020									5020														
Uncoated	YG50													50										

YG012 H10 - H30 P10 - P30		Optimized Milling Grade for Pre-Hardened & Hardened steel • Applied Extreme Oxidation PVD layer and Crack-free Substrate • Excellent Cutting performance for Die & Mold application
YG712 P10 - P30		Milling Grade for Medium of Steel Application • Superior wear resistance and excellent toughness in high speed machining • Coating layer with high hardness and oxidation resistance
YG713 P15 - P25		Milling Grade for General Steel Application • Multi-layer TiAlN structure realizes stronger crater and flank wear resistance • Fine-grained carbide and balanced substrate
YG612 P20 - P40 M20 - M40 S20 - S40		Specialized Multi-Nano Coated Grade with high wear resistance and chipping resistance • Special Multi-Nano coating prevent crack and providing predictable tool life • Special universal Grade can achieve stable tool life in any workpiece
YG613 P30 - P50 M30 - M40		Milling Grade for Stainless Steel Application • New coating layer with lubrication preventing built-up edge on ultra fine grain substrate with high toughness. • The toughest substrate provides excellent cutting performance in stainless steel
YG501 K05 - K25		Hard Milling grade for Cast Iron • Substrate especially designed for high wear resistance • Excellent wear resistance in cast iron milling application
YG5020 K01 - K30		CVD Milling grade for Cast Iron • CVD coating for Excellent wear resistance • Improved Toughness for chipping resistance
YG50 N05 - N20		Uncoated Milling Grade for Aluminium • Submicron carbide substrate for high wear resistance • Preventing built up edge with shining surface

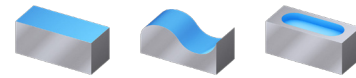
Milling Grades and Chipbreakers

Milling Chipbreakers

-AL		• For Aluminum • Very Sharp Geometry
-ST		• For Stainless Steel, Super Alloy • Sharp Geometry
-GN (General Type)		• First Choice for General Application
-TR		• For Hardened Steels • Reinforced Geometry
...W / ...N		• For Hardened Material and Cast Irons

Milling Cutters Overview

High Feed Milling



Negative 4 Corner

Cutter			
APMX		0.9	1
DCX		Ø16~18	Ø20~50
page		14	15

Face Milling

Negative 10 Corner

Cutter		
APMX		4
DC		Ø50~125
page		20

Shoulder Milling

3 Corner Positive

Cutter				
APMX		4.5	7.0	11.0
DC		Ø12~40	Ø20~63	Ø32~200
page		22	23	24

6 Corner Negative

Cutter			
APMX		7	11
DCX		Ø32~125	Ø40~160
page		26	18

Modular Shank

Modular Shank for Modular Head

Cutter		M08 ~ M16
page		28

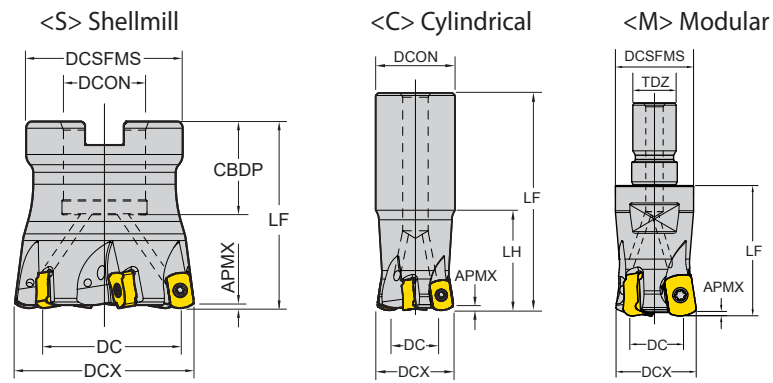
Milling Inserts Overview

Recommended Cutting Conditions : p.38

E 4 Corner	 Negative	ENMX	ENMX 0604 ENMX 0905	p. 16
L 4 Coner	 Negative	LNHU / LNKU	LNHU / LNKU 1306	p. 19
P 10 Corner	 Negative	PNMU	PNMU 1206	p. 21
T Triangle	 Positive 3 Corner	TPCT	TPCT 0703 TPCT 1104 TPCT 1605	p.25
	 Positive 3 Corner	TPKT	TPKT 0703 TPKT 1104 TPKT 1605	
W Trigon	 Negative 6 Corner	WNEX	WNEX 0806	p. 27

Milling - High Feed Milling - Cutter Cutters for ENMX

Entering Angle : 10°
4 Corner Negative



CICT : Number of Inserts
CBDP : Connection Bore Depth

Unit : mm

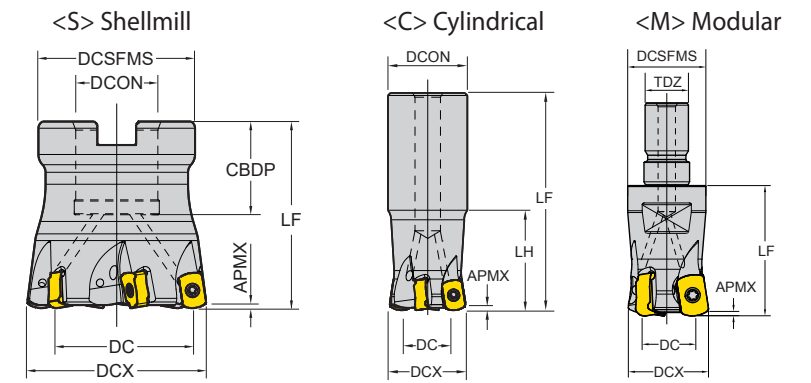
Series	APMX	Designation	EDP 1700..	DC	DCX	CICT	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	🔹				
ENMX 0604	0.9	EHF - ENMX06 - D16Z2C16 - L100	0644	9.0	16	2	100	Cylindrical	16	30	-	-	●				
		EHF - ENMX06 - D16Z2C16 - L150	0645	9.0	16	2	150		16	50	-	-	●				
		EHF - ENMX06 - D17Z2C16 - L100	0674	10.0	17	2	100		16	20	-	-	●				
		EHF - ENMX06 - D17Z2C16 - L150	0473	10.0	17	2	150		16	20	-	-	●				
	1	0.9	EHF - ENMX06 - D20Z3C20 - L130	0463	12.6	20	3	130	Cylindrical	20	50	-	-	●			
			EHF - ENMX06 - D20Z3C20 - L160	0646	12.6	20	3	160		20	80	-	-	●			
			EHF - ENMX06 - D21Z3C20 - L150	0475	13.6	21	3	150		20	20	-	-	●			
			EHF - ENMX06 - D21Z3C20 - L200	0476	13.6	21	3	200		20	20	-	-	●			
		1	0.9	EHF - ENMX06 - D25Z4C25 - L140	0647	17.6	25	4		140	25	60	-	-	●		
				EHF - ENMX06 - D25Z4C25 - L180	0464	17.6	25	4		180	25	80	-	-	●		
			1	0.9	EHF - ENMX06 - D25Z4C25 - L250	0648	17.6	25		4	250	25	120	-	-	●	
					EHF - ENMX06 - D26Z4C25 - L150	0479	18.6	26		4	150	25	30	-	-	●	
				1	0.9	EHF - ENMX06 - D26Z4C25 - L200	0480	18.6		26	4	200	25	30	-	-	●
						EHF - ENMX06 - D32Z5C32 - L150	0649	24.6		32	5	150	32	70	-	-	●
	ENMX 0905	0.9	MHF - ENMX06 - D16Z2M08	0691	9.0	16	2	23	Modular	M08	-	-	13	●			
			MHF - ENMX06 - D18Z2M08	0730	11.0	18	2	23		M08	-	-	13	●			
			MHF - ENMX06 - D20Z3M10	0692	12.6	20	3	30		M10	-	-	18	●			
			MHF - ENMX06 - D25Z4M12	0693	17.6	25	4	35		M12	-	-	21	●			
1		0.9	MHF - ENMX06 - D32Z5M16	0694	24.6	32	5	42	Modular	M16	-	-	29	●			
			MHF - ENMX06 - D35Z5M16	0695	27.6	35	5	42		M16	-	-	29	●			
		1	0.9	MHF - ENMX06 - D40Z6M16	0732	32.6	40	6		42	M16	-	-	29	●		
				MHF - ENMX06 - D42Z6M16	0696	34.6	42	6		42	M16	-	-	29	●		
			1	0.9	FHF - ENMX06 - D40Z6S16	0482	32.6	40		6	40	Shellmill	16	-	18	37	●
					FHF - ENMX06 - D50Z6S22	0471	42.6	50		6	50		22	-	25	42	●

* Clamping Torque (Nm) 1.2Nm

ENMX06	Screw	Wrench	Handle	BIT
Description	TP082507-GS	TPWBTP08	DH-H4	DB-TP08
EDP	18000206	18000218	18000189	18000190

Milling - High Feed Milling - Cutter Cutters for ENMX

Entering Angle : 10°
4 Corner Negative



CICT : Number of Inserts
CBDP : Connection Bore Depth

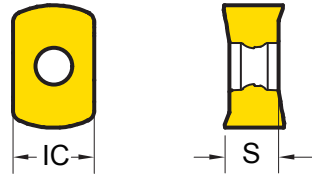
Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	CICT	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	🔹	
ENMX 0905	1.5	EHF - ENMX09 - D25Z2C25 - L150	0745	15	25	2	150	Cylindrical	25	70	-	-	●	
		EHF - ENMX09 - D26Z2C25 - L200	0746	16	26	2	200		25	30	-	-	●	
		EHF - ENMX09 - D26Z3C25 - L200	0747	16	26	3	200		25	30	-	-	●	
		EHF - ENMX09 - D32Z3C32 - L160	0748	22	32	3	160		32	70	-	-	●	
		EHF - ENMX09 - D33Z3C32 - L200	0749	23	33	3	200		32	30	-	-	●	
		EHF - ENMX09 - D33Z4C32 - L200	0750	23	33	4	200		32	40	-	-	●	
		EHF - ENMX09 - D40Z5C32 - L180	0751	30	40	5	180		32	40	-	-	●	
		FHF - ENMX09 - D50Z3S22	0820	40	50	3	50		Shellmill	22	-	20	42	●
		FHF - ENMX09 - D50Z4S22	0821	40	50	4	50			22	-	20	42	●
		FHF - ENMX09 - D50Z5S22	0752	40	50	5	50			22	-	20	42	●
	FHF - ENMX09 - D63Z4S22	0822	53	63	4	50	22	-		20	48	●		
	FHF - ENMX09 - D63Z5S22	0823	53	63	5	50	22	-		20	48	●		
	FHF - ENMX09 - D63Z6S22	0753	53	63	6	50	22	-		20	48	●		
	FHF - ENMX09 - D63Z7S22	0754	53	63	7	50	22	-		20	48	●		
	FHF - ENMX09 - D80Z8S27	0755	70	80	8	50	27	-		23	56	●		
	1	0.9	FHF - ENMX09 - D100Z10S32	0824	90	100	10	63	32	-	26	78	●	
			FHF - ENMX09 - D125Z12S40	0825	115	125	12	63	40	-	28	89	●	

* Clamping Torque (Nm) 2.0Nm

ENMX09	Screw	Wrench	Handle	BIT
Description	TP103509-GS	TPWBTP10	DH-H4	DB-TP10
EDP	18000266	18000280	18000189	18000271

Series	IC	S
ENMX 0604	6.3	4.21
ENMX 0905	9.0	5.40



EDP 1200..

●: Stock item ○: Order made item

H20	P15	P25	P30	P40	K10	K15
P20			S30	S40		
YG012	YG712	YG713	YG612	YG613	YG5020	YG501
● 0734			● 0822	● 0606		
● 0736			● 0824	● 0703		
			● 0973	● 0625		
			● 0974	● 0706		
● 0733	● 0504	○ 0636	● 0823			
● 0735			● 0825			

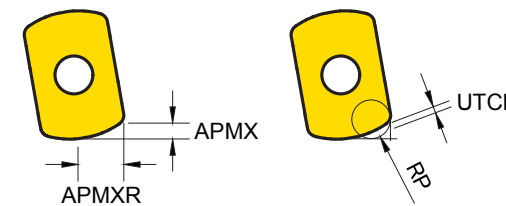
ENMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)
General	ENMX 0604		0.3 ~ 2.0	
	ENMX 0905		0.3 ~ 2.5	
-ST Stainless Steel	ENMX 0604 - ST		0.1 ~ 0.8	
	ENMX 0905 - ST		0.2 ~ 1.2	
-TR Hardened Steel	ENMX 0604 - TR		0.3 ~ 2.5	
	ENMX 0905 - TR		0.3 ~ 3.0	



ENMX 0604

Unit: mm

DCX Cutting Diameter Maximum	APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
16	3.5	R2.0	0.31	0.00
16~	3.7	R2.5	0.18	0.18
		R3.0	0.07	0.36

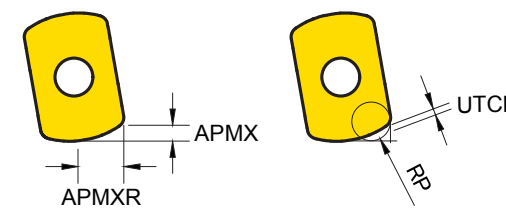


DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
16	0.9	3.5	2.4°	2.0	0.3	22	32	0.9	12.5
17	0.9	3.5	1.9°	2.0	0.3	24	34	0.9	13.5
20	1	3.7	1.8°	2.0	0.31	29	40	1	16.3
21	1	3.7	1.8°	2.0	0.31	31	42	1	17.3
25	1	3.7	1.2°	2.0	0.31	39	50	1	21.3
26	1	3.7	1.2°	2.0	0.31	41	52	1	22.3
32	1	3.7	0.8°	2.0	0.31	53	64	1	28.3
33	1	3.7	0.8°	2.0	0.31	55	66	1	29.3
40	1	3.7	0.6°	2.0	0.31	69	80	1	36.3
50	1	3.7	0.5°	2.0	0.31	89	98	1	46.3
63	1	3.7	0.4°	2.0	0.31	115	126	1	59.3

ENMX 0905

Unit: mm

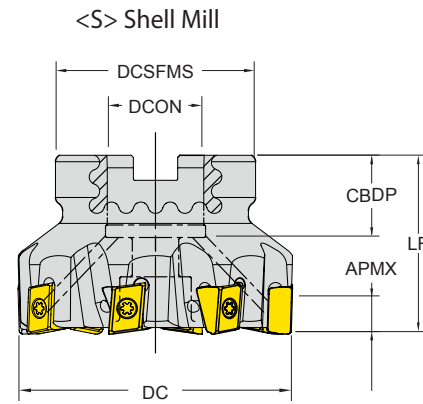
APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
4.7	R2.5	0.56	0
	R3.0	0.40	0.10
	R3.5	0.24	0.25
	R4.0	0.10	0.41
	R4.5	0	0.49



DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
25	1.5	5	3.8°	2.5	0.56	42	50	1.5	20
26	1.5	5	3.4°	2.5	0.56	44	52	1.5	21
32	1.5	5	2.3°	2.5	0.56	56	64	1.5	27
33	1.5	5	2.2°	2.5	0.56	58	66	1.5	28
40	1.5	5	1.6°	2.5	0.56	72	80	1.5	35
50	1.5	5	1.1°	2.5	0.56	92	100	1.5	45
63	1.5	5	0.8°	2.5	0.56	118	126	1.5	57
80	1.5	5	0.6°	2.5	0.56	152	160	1.5	74

Milling - Shoulder Milling - Cutter
Cutters for LNHU, LNKU

Entry Angle : 90°
 4 Corner Negative



ZEPF : Effective Number of Cutting Edges
 CBDP : Connection Bore Depth

Unit: mm

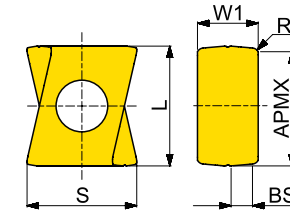
Series	APMX	Designation	EDP 1700..	DCX	CICT	LF	TYPE	DCON	LH	CBDP	DCSFMS	●
LNHU LNKU 1306	11	F90 - LNHU13R - D40Z4S16	0787	40	4	40	Shellmill	16	-	18	37	●
		F90 - LNHU13R - D40Z5S16	0884	40	5	40		16	-	18	37	●
		F90 - LNHU13R - D50Z5S22	0793	50	5	40		22	-	20	45	●
		F90 - LNHU13R - D50Z6S22	0794	50	6	40		22	-	20	45	●
		F90 - LNHU13R - D63Z6S22	0795	63	6	40		22	-	20	48	●
		F90 - LNHU13R - D63Z8S22	0796	63	8	40		22	-	20	48	●
		F90 - LNHU13R - D80Z10S27	0885	80	10	50		27	-	23	60	●
		F90 - LNHU13R - D80Z5S27	0910	80	5	50		27	-	23	60	●
		F90 - LNHU13R - D80Z7S27	0797	80	7	50		27	-	23	60	●
		F90 - LNHU13R - D80Z8S27	0798	80	8	50		27	-	23	60	●
		F90 - LNHU13R - D100Z13S32	0846	100	13	50		32	-	26	67	●
		F90 - LNHU13R - D100Z6S32	0911	100	6	50		32	-	26	67	●
		F90 - LNHU13R - D100Z8S32	0845	100	8	50		32	-	26	67	●
		F90 - LNHU13R - D100Z9S32	0886	100	9	50		32	-	26	67	●
		F90 - LNHU13R - D125Z11S40	0887	125	11	63		40	-	29	89	●
		F90 - LNHU13R - D125Z16S40	0888	125	16	63		40	-	29	89	●
		F90 - LNHU13R - D160Z13S40	0889	160	13	63		40	-	29	89	●
		F90 - LNHU13R - D160Z18S40	0890	160	18	63		40	-	29	89	●

** Clamping Torque (Nm) 3.0Nm

LNKU13	Screw	Wrench	Handle	BIT
Description	TP150412-GS	TPWBTP15	DH-H6	DB-TP15
EDP	18000225	18000217	18000210	18000208

Milling - Shoulder Milling - Inserts
LNHU, LNKU - Tangential Milling Negative (4 Corners)

Series	W1	L
LN*U 1306	6.7	13.2



EDP 1200..

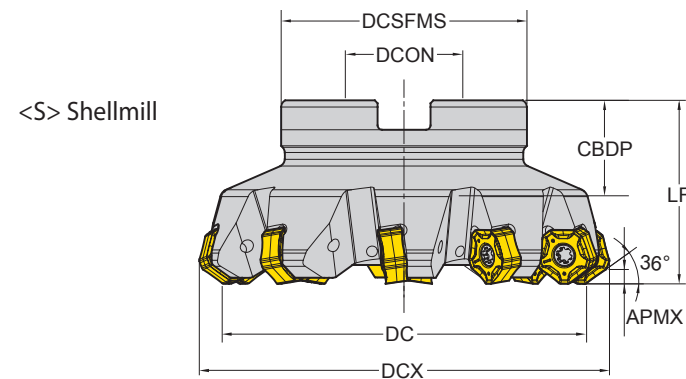
●: Stock item ○: Order made item

LNHU LNKU	Designation	RE (in)	Fz (in/tooth)	BS (in)	H20	P15	P25	P30	P40	K10	K15
					P20	M30	M40	S30	S40	YG5020	YG501
LNHU General	LNHU130608R	0.8	0.05~0.30	2.09	YG012	YG712	YG713	YG612	YG613	YG5020	YG501
					●	●	●	●	●	●	●
LNKU General	LNKU130608R	0.8	0.05~0.30	2.09	●	●	●	●	●	●	●
					0723	0724	0725	0740	0741	0742	
	LNKU130612R	1.2	0.05~0.3	1.73	●	●	●	●	●	●	●
					0764	0765	0766				



Milling - Face Milling - Cutter Cutters for PNMU

Entering Angle : 36°
10 Corner Negative



CICT : Number of Inserts
CDBP : Connection Bore Depth

□ : p. 21

Unit:mm

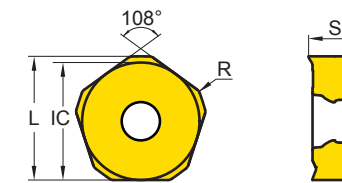
Series	APMX	Designation	EDP 1700..	DC	DCX	CICT	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	☉
PNMU 1206	4.0	F36 - PNMU12 - D50Z4S22	0774	50	63.6	4	40	Shellmill	22	20	42	-	-	●
		F36 - PNMU12 - D50Z5S22	0785	50	63.6	5	40		22	20	42	-	-	●
		F36 - PNMU12 - D63Z5S22	0775	63	76.6	5	40		22	20	48	-	-	●
		F36 - PNMU12 - D63Z6S22	0483	63	76.6	6	40		22	20	48	-	-	●
		F36 - PNMU12 - D80Z8S27	0466	80	93.6	8	50		27	23	58	-	-	●
		F36 - PNMU12 - D100Z10S32	0467	100	113.6	10	50		32	26	67	-	-	●
		F36 - PNMU12 - D125Z10S40	0786	125	138.6	10	63		40	29	89	-	-	●

* Clamping Torque (Nm) 3.0Nm

PNMU12	Screw	Wrench	Handle	BIT
Description	TP154008	TPWBTP15	DH-H4	DB-TP15
EDP	18000006	18000217	18000189	18000208

Milling - Face Milling - Inserts PNMU - Face Milling Negative (10 Corners)

Series	KRINS	IC	S
PNMU 1206	36	14.0	5.84



EDP 1200..

●: Stock item ○: Order made item

H20	P15	P25	P30	P40	K10	K15
P20			M30	M40		
			S30	S40		

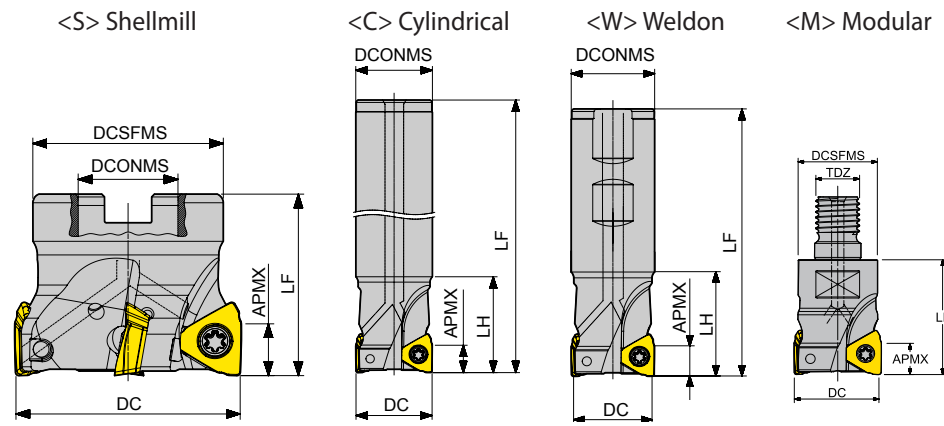
PNMU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..								
					YG012	YG712	YG713	YG612	YG613	YG5020	YG501G		
PNMU General	PNMU 1206ZNN	0.8	0.05~0.50	2.10	● 0753	● 0596	○ 0645	● 0826	● 0671	● 0534	● 538		
	PNMU 1206 - ST	0.8	0.05~0.30	2.10				● 0761	● 0760				
- ST Stainless Steel Super Alloy													



Scan this QR code to see our YG FM10 Mill at work.

Milling - Shoulder Milling - Cutter Cutters for TPKT

Entering Angle : 90°
3 Corner Positive



CICT : Number of Inserts
CBDP : Connection Bore Depth

□: p. 25 Unit : mm

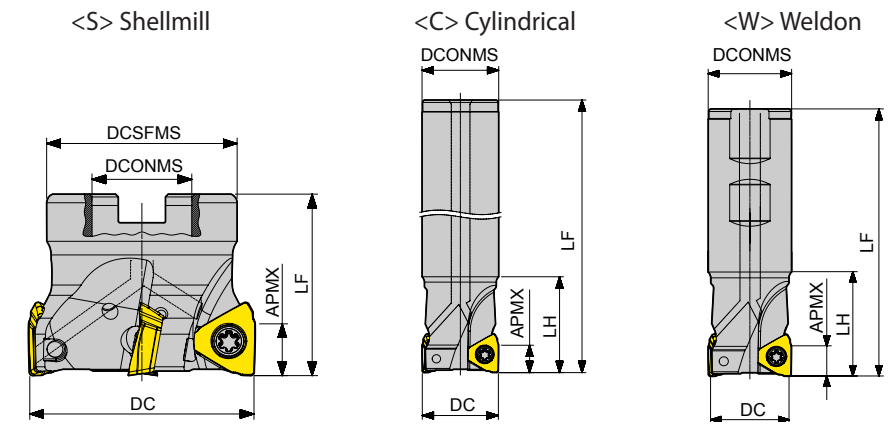
Series	APMX	Designation	EDP 1700..	DC	CICT	LF	TYPE	DCON /TDZ	LH	CBDP	DCSFMS	🔴
TPKT 0703	4.5	E90 - TP07 - D12Z1C12 - L80	1136	12	1	80	Cylindrical	12	20	-	-	●
		E90 - TP07 - D14Z1C12 - L80	1137	14	1	80		12	20	-	-	●
		E90 - TP07 - D16Z2C16 - L110	1138	16	2	110		16	25	-	-	●
		E90 - TP07 - D16Z2C16 - L150	1139	16	2	150		16	25	-	-	●
		E90 - TP07 - D16Z3C16 - L150	1140	16	3	150		16	25	-	-	●
		E90 - TP07 - D17Z2C16 - L150	1192	17	2	150		16	25	-	-	●
		E90 - TP07 - D17Z2C16 - L200	1193	17	2	200		16	25	-	-	●
		E90 - TP07 - D17Z3C16 - L150	1141	17	3	150		16	25	-	-	●
		E90 - TP07 - D18Z3C16 - L150	1142	18	3	150		16	25	-	-	●
		E90 - TP07 - D20Z3C20 - L160	1143	20	3	160		20	25	-	-	●
		E90 - TP07 - D21Z3C20 - L160	1194	21	3	160		20	25	-	-	●
		E90 - TP07 - D25Z5C25 - L115	1146	25	5	115		25	25	-	-	●
		E90 - TP07 - D42Z8C32 - L130	1161	42	8	130	32	30	-	-	●	
		E90 - TP07 - D25Z4W20 - L115	1144	25	4	115	20	25	-	-	●	
		E90 - TP07 - D25Z5W25 - L115	1145	25	5	115	25	25	-	-	●	
		E90 - TP07 - D32Z6W25 - L130	1147	32	6	130	25	30	-	-	●	
		E90 - TP07 - D40Z8W32 - L130	1148	40	8	130	32	30	-	-	●	
		F90 - TP07 - D32Z6S16	1149	32	6	32	16	-	18	30	●	
		F90 - TP07 - D35Z7S16	1150	35	7	35	16	-	18	30	●	
		F90 - TP07 - D40Z7S16	1151	40	7	40	16	-	18	38	●	
		F90 - TP07 - D40Z8S16	1152	40	8	40	16	-	18	38	●	
		F90 - TP07 - D40Z8S22	1153	40	8	40	22	-	20	38	●	
		F90 - TP07 - D50Z9S22	1162	50	9	40	22	-	20	45	●	
		F90 - TP07 - D52Z9S22	1163	52	9	40	22	-	20	45	●	
		M90 - TP07 - D16Z2M08	1154	16	2	40	M08	23	-	13	●	
		M90 - TP07 - D20Z3M10	1155	20	3	55	M10	35	-	18	●	
		M90 - TP07 - D22Z4M10	1156	22	4	55	M10	35	-	18	●	
		M90 - TP07 - D25Z5M12	1157	25	5	57	M12	35	-	21	●	
		M90 - TP07 - D32Z6M16	1158	32	6	68	M16	43	-	29	●	
		M90 - TP07 - D40Z7M16	1159	40	7	68	M16	43	-	29	●	
		M90 - TP07 - D42Z8M16	1160	42	8	68	M16	43	-	29	●	

** Clamping Torque (Nm) 0.6Nm

TPKT07	Screw	Wrench	Handle	BIT
Description	TP062004-GS	TPWBTP06	DH-H4	DB-TP06
EDP	18000252	18000277	18000189	18000274

Milling - Shoulder Milling - Cutter Cutters for TPKT

Entering Angle : 90°
3 Corner Positive



CICT : Number of Inserts
CBDP : Connection Bore Depth

□: p. 25 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	CICT	LF	TYPE	DCON /TDZ	LH	CBDP	DCSFMS	🔴
TPKT 1104	7.0	E90 - TP11 - D20Z2C20 - L170	1037	20	2	170	Cylindrical	20	40	-	-	●
		E90 - TP11 - D21Z2C20 - L150	1038	21	2	150		20	40	-	-	●
		E90 - TP11 - D21Z2C20 - L200	1039	21	2	200		20	40	-	-	●
		E90 - TP11 - D25Z3C25 - L200	1026	25	3	200		25	60	-	-	●
		E90 - TP11 - D26Z2C25 - L200	1041	26	2	200		25	40	-	-	●
		E90 - TP11 - D26Z2C25 - L250	1042	26	2	200		25	40	-	-	●
		E90 - TP11 - D26Z3C25 - L150	1043	26	3	150		25	40	-	-	●
		E90 - TP11 - D26Z3C25 - L200	1044	26	3	200		25	40	-	-	●
		E90 - TP11 - D32Z3C32 - L230	1045	32	3	230		32	60	-	-	●
		E90 - TP11 - D33Z3C32 - L200	1047	33	3	200		32	40	-	-	●
		E90 - TP11 - D40Z4C32 - L200	1048	40	4	200		32	60	-	-	●
		E90 - TP11 - D20Z2W20 - L90	0995	20	2	90		Weldon	20	40	-	-
		E90 - TP11 - D25Z3W25 - L100	1040	25	3	100	25		40	-	-	●
		E90 - TP11 - D32Z4W32 - L110	1046	32	4	110	32		40	-	-	●
		E90 - TP11 - D40Z5W32 - L115	1049	40	5	115	32	40	-	-	●	
		F90 - TP11 - D40Z5S16	1050	40	5	40	Shellmill	16	-	20	38	●
		F90 - TP11 - D50Z6S22	1051	50	6	40		22	-	20	42	●
		F90 - TP11 - D63Z7S22	1052	63	7	40		22	-	20	48	●
		F90 - TP11 - D63Z8S22	1053	63	8	40		22	-	20	48	●

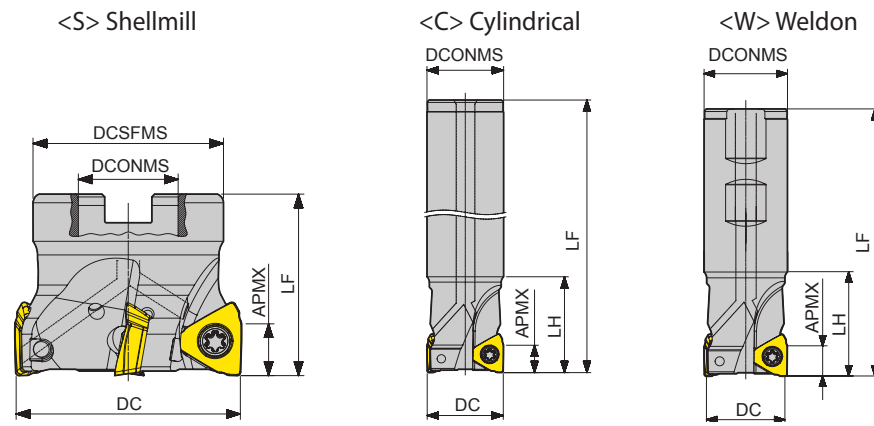
* Clamping Torque (Nm) 1.2Nm

TPKT1104 (D20, D21)	Screw	Wrench	Handle	BIT
Description	TP082562-GS	TPWBTP08	DH-H4	DB-TP08
EDP	18000265	18000218	18000189	18000190

TPKT1104 (over D25)	Screw	Wrench	Handle	BIT
Description	TP082506-GS	TPWBTP08	DH-H4	DB-TP08
EDP	18000259	18000218	18000189	18000190

Milling - Shoulder Milling - Cutter Cutters for TPKT

Entering Angle : 90°
3 Corner Positive



CICT : Number of Inserts
CBDP : Connection Bore Depth

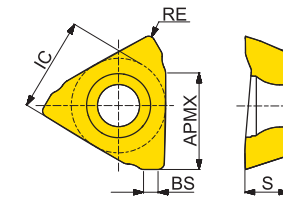
□ : p. 25 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	CICT	LF	TYPE	DCON /TDZ	LH	CBDP	DCSFMS	●
TPKT 1605	11.0	E90-TP16-D32Z2C32-L150	0941	32	2	150	Cylindrical	32	40	-	-	●
		E90-TP16-D32Z2C32-L250	0942	32	2	250		32	80	-	-	●
		E90-TP16-D32Z2C32-L200	0929	33	2	200		32	40	-	-	●
		E90-TP16-D32Z2C32-L250	1010	33	2	250		32	40	-	-	●
		E90-TP16-D40Z4C32-L200	0945	40	4	200		32	40	-	-	●
		E90-TP16-D40Z3W32-L110	0944	40	3	110	Weldon	32	40	-	-	●
		F90-TP16-D50Z4S22	0931	50	4	40	Shellmill	22	-	29	42	●
		F90-TP16-D63Z5S22	0932	63	5	40		22	-	29	48	●
		F90-TP16-D63Z6S22	0947	63	6	40		22	-	29	48	●
		F90-TP16-D80Z6S27	0948	80	6	50		27	-	39	56	●
		F90-TP16-D80Z7S27	0949	80	7	50		27	-	39	56	●
		F90-TP16-D100Z8S32	0950	100	8	50		32	-	39	67	●
		F90-TP16-D125Z10S40	0951	125	10	63		40	-	52	89	●
		F90-TP16-D125Z12S40	0952	125	12	63		40	-	52	89	●
		F90-TP16-D160Z11S40	0953	160	11	63		40	-	52	110	X
F90-TP16-D200Z11S60	0955	200	11	63	60	-		52	160	X		

* Clamping Torque (Nm) 0.6Nm

TPKT1605	Screw	Wrench	Handle	BIT
Description	TP062004-GS	TPWBTP06	DH-H4	DB-TP06
EDP	18000252	18000277	18000189	18000274

Milling - Shoulder Milling - Inserts TPCT, TPKT - Shoulder Milling Positive (3 Corner ISO)



Series	KRINS	IC	S
TP** 0703	90	5.51	2.62
TP** 1104	90	7.54	4.28
TP** 1605	90	11.66	5.38

EDP 1200..

● : Stock item ○ : Order made item

H20	P15	P25	P30	P40	K10	N15
P20			M30	M40		
			S30	S40		

TPCT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG012	YG712	YG713	YG612	YG613	YG5020	YG50
-AL	TPCT 070302R-AL	0.2	0.05~0.22	1.35							● 1008
	TPCT 070304R-AL	0.4	0.05~0.22	1.15							● 1009
	TPCT 070308R-AL	0.8	0.05~0.22	0.75							● 1011
	TPCT 110404R-AL	0.4	0.05~0.25	1.5							● 0894
	TPCT 110408R-AL	0.8	0.05~0.25	1.1							● 0895
	TPCT 160504R-AL	0.4	0.05~0.5	2.4							● 0896
	TPCT 160508R-AL	0.8	0.05~0.5	1.9							● 0897



TPKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG012	YG712	YG713	YG612	YG613	YG5020	YG501
TPKT General	TPKT 070302R-GN	0.2	0.05~0.2	1.00	● 0987	● 0989		● 0986	● 0988		
	TPKT 070304R-GN	0.4	0.05~0.2	0.90	● 0991	● 0993		● 0990	● 0992	● 0994	● 0995
	TPKT 070308R-GN	0.8	0.05~0.2	0.50	● 0997	● 0999		● 0996	● 0998	● 1000	● 1001
	TPKT 110404R-GN	0.4	0.05~0.24	1.60	● 0802	● 0807		● 0801		● 0808	
	TPKT 110408R-GN	0.8	0.05~0.24	1.15	● 0804	● 0811		● 0803		● 0812	
	TPKT 110416R-GN	1.6	0.05~0.24	0.60	● 0806	● 0815		● 0805		● 0816	
	TPKT 160504R-GN	0.4	0.05~0.29	2.15	● 0888	● 0889		● 0887		● 0890	
	TPKT 160508R-GN	0.8	0.05~0.29	1.79	● 0781	● 0779		● 0718		● 0780	
	TPKT 160516R-GN	1.6	0.05~0.29	1.20	● 0785	● 0786		● 0784		● 0787	
	TPKT 160524R-GN	2.4	0.05~0.29	0.70	● 0789	● 0790		● 0788		● 0791	
	TPKT 070302R-ST	0.2	0.05~0.13	1.00				● 1002		● 1003	
	TPKT 070304R-ST	0.4	0.05~0.13	0.90				● 1004		● 1005	
	TPKT 070308R-ST	0.8	0.05~0.13	0.50				● 1006		● 1007	
	TPKT 110404R-ST	0.4	0.05~0.15	1.60				● 0809		● 0810	
	TPKT 110408R-ST	0.8	0.05~0.15	1.15				● 0813		● 0814	
TPKT 160504R-ST	0.4	0.05~0.15	2.15				● 0891		● 0892		
TPKT 160508R-ST	0.8	0.05~0.15	1.79				● 0758		● 0759		

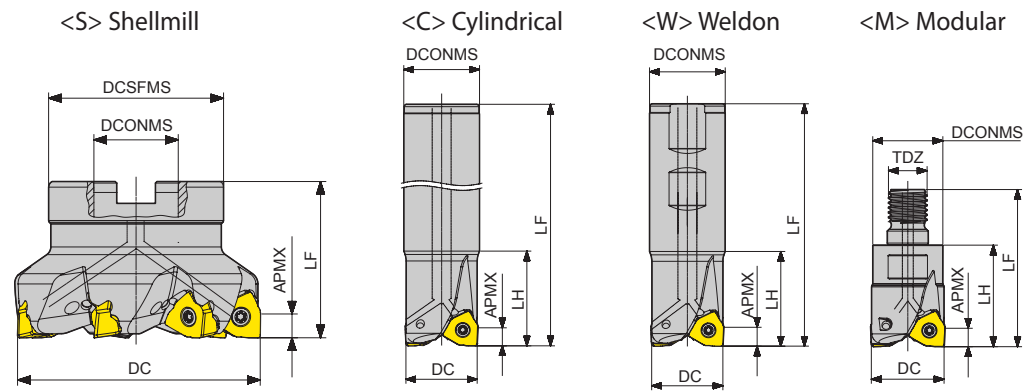


H20	P15	P25	P30	P40	K10	K15
P20			M30	M40		
			S30	S40		



Milling - Shoulder Milling - Cutter Cutters for WNEX

Entering Angle : 90°
6 Corner Negative



CICT : Number of Inserts
CBDP : Connection Bore Depth

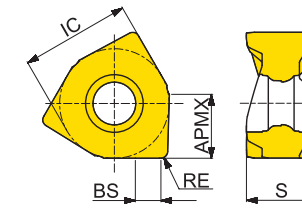
Unit : mm

Series	APMX	Designation	EDP 1700..	DC	CICT	LF	TYPE	DCON /TDZ	LH	CBDP	DCSFMS	●	
WNEX 0806	7.0	E90 - WN08 - D32Z2W32 - L120	0969	32	2	120	Weldon	32	40	-	-	●	
		E90 - WN08 - D40Z3W32 - L120	0972	40	3	120		32	40	-	-	●	
		E90 - WN08 - D40Z4W32 - L120	0973	40	4	120		32	40	-	-	●	
		E90 - WN08 - D50Z4W32 - L120	0974	50	4	120		32	40	-	-	●	
		E90 - WN08 - D50Z5W32 - L120	0990	50	5	120		32	40	-	-	●	
		E90 - WN08 - D32Z2C32 - L120	0991	32	2	120	Cylindrical	32	40	-	-	●	
		E90 - WN08 - D32Z2C32 - L200	0872	32	2	200		32	60	-	-	●	
		E90 - WN08 - D33Z2C32 - L200	0873	33	2	200		32	40	-	-	●	
		E90 - WN08 - D40Z3C32 - L120	0994	40	3	120		32	40	-	-	●	
		E90 - WN08 - D40Z3C32 - L200	0874	40	3	200		32	40	-	-	●	
		E90 - WN08 - D40Z4C32 - L120	0996	40	4	120		32	40	-	-	●	
		E90 - WN08 - D50Z4C32 - L120	0997	50	4	120		32	40	-	-	●	
		E90 - WN08 - D50Z5C32 - L120	0998	50	5	120		32	40	-	-	●	
		F90 - WN08 - D50Z4S22	0875	50	4	40		Shellmill	22	-	20	44	●
		F90 - WN08 - D50Z5S22	0976	50	5	40			22	-	20	44	●
		F90 - WN08 - D63Z5S22	0876	63	5	40	22		-	20	48	●	
		F90 - WN08 - D63Z6S22	0977	63	6	40	22		-	20	48	●	
		F90 - WN08 - D80Z4S27	0999	80	4	50	27		-	20	56	●	
		F90 - WN08 - D80Z6S25.4	1000	80	6	50	25.4		-	26.64	56	●	
		F90 - WN08 - D80Z7S27	0878	80	7	50	27		-	23	56	●	
		F90 - WN08 - D80Z7S25.4	0877	80	7	50	25.4		-	26.64	56	●	
		F90 - WN08 - D80Z9S27	0978	80	9	50	27		-	23	56	●	
		F90 - WN08 - D100Z8S31.75 - WOC	1002	100	8	50	31.75		-	32	67	X	
		F90 - WN08 - D100Z9S32	0979	100	9	50	32	-	26	67	●		
		F90 - WN08 - D100Z11S32	0980	100	11	50	32	-	26	67	●		
		F90 - WN08 - D125Z10S38.1 - WOC	1003	125	10	63	38.1	-	38	85	X		
		F90 - WN08 - D125Z11S40	0981	125	11	63	40	-	29	85	●		
		F90 - WN08 - D125Z14S40	0982	125	14	63	40	-	29	85	●		
		M90 - WN08 - D32Z2M16	1004	32	2	65	Modular	M16	42	-	29	●	
		M90 - WN08 - D40Z3M16	1005	40	3	65		M16	42	-	29	●	
		M90 - WN08 - D40Z4M16	0984	40	4	65		M16	42	-	29	●	

* Clamping Torque (Nm) 3.0Nm

WNEX0806	Screw	Wrench	Handle	BIT
Description	TP154011-GS	TPWBTP15	DH-H4	DB-TP15
EDP	18000251	18000217	18000189	18000208

Milling - Shoulder Milling - Inserts WNEX - Shoulder Milling Negative (6 Corners)



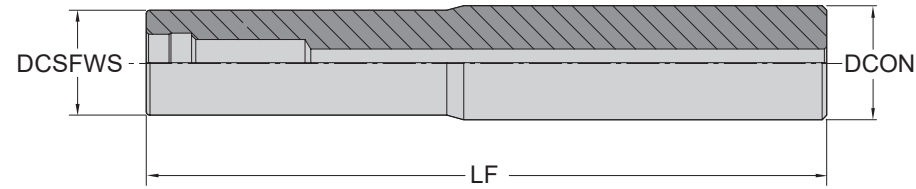
Series	IC	S
WNE* 0806	12.9	6.25

EDP 1200..

● : Stock item ○ : Order made item

H20	P15	P25	P30	P40	K10	K15
P20			M30	M40		
			S30	S40		

WNEX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG012	YG712	YG713	YG612	YG613	YG5020	YG501
General	WNEX 080604R - GN	0.4	0.05~0.26	3.2	●	●		●		●	
	WNEX 080608R - GN	0.8	0.05~0.26	2.8	●	●		●	●	●	●
	WNEX 080612R - GN	1.2	0.05~0.26	2.4	●	●		●		●	
	WNEX 080616R - GN	1.6	0.05~0.26	2.0	●	●		●		●	
	WNEX 080620R - GN	2.0	0.05~0.26	1.6	●	●		●		●	
-ST Stainless Steel Super Alloy	WNEX 080604R - ST	0.4	0.05~0.19	3.6				●	●		
	WNEX 080608R - ST	0.8	0.05~0.19	3.3				●	●		
	WNEX 080612R - ST	1.2	0.05~0.19	2.8				●	●		
	WNEX 080616R - ST	1.6	0.05~0.19	2.4				●	●		
	WNEX 080620R - ST	2.0	0.05~0.19	2.0				●	●		
								●	●		



Unit:mm

Series	Designation	EDP 1700..	DCSFWS	LF	TYPE	DCON	⚡
M08	EM - M08 - D13C16 - L100	0634	13	100	Cylindrical	16	●
	EM - M08 - D15C16 - L130	0635	15	130		16	●
M10	EM - M10 - D18C20 - L130	0636	18	130	Cylindrical	20	●
M12	EM - M12 - D23C25 - L150	0637	23	150	Cylindrical	25	●
	EM - M12 - D23C25 - L200	0638	23	200		25	●
	EM - M12 - D23C25 - L250	0639	23	250		25	●
M16	EM - M16 - D30C32 - L150	0640	30	150	Cylindrical	32	●
	EM - M16 - D30C32 - L200	0641	30	200		32	●
	EM - M16 - D30C32 - L250	0642	30	250		32	●
	EM - M16 - D30C32 - L300	0643	30	300		32	●

Mounting Bolt

DCON	Description	EDP
Φ16	YHBM08-L20	18000224
Φ16 HF	YHBM08-L25	18000238
Φ22	YHBM10-L25	18000239
Φ22 HF	YHBM10-L30	18000240
Φ25.4 (Metric O.D)	YHBM12-L30	18000241
Φ27	YHBM12-L30	18000241
Φ31.75 (Metric O.D)	YMBM16-L42	18000242
Φ32	YMBM16-L42	18000242
Φ32 HF	YMBM16-L50	18000258
Φ38.1 (Metric O.D)	YMBM20-L54	18000243
Φ40	YMBM20-L54	18000243
Φ0.5" (Φ12.7)	YHBU250-L25.4	18000244
Φ0.75" (Φ19.05)	YHBU375-L25.4	18000245
Φ0.75" (Φ19.05) HF	YHBU375-L31.75	18000246
Φ1.0" (Φ25.4)	YHBU500-L38.1	18000247
Φ1.25" (Φ31.75)	YMBU625-L52	18000248
Φ1.5" (Φ38.1)	YMBU750-L60	18000249
Φ2.0" (Φ50.8)	YMBU1000-L70	18000250



DRILLING

Drilling Overview

Recommended Cutting Conditions : p.38

Drilling Grades

Drilling Grades	P Steel					M Stainless steel					K Cast iron				
	P05	P15	P25	P35	P45	M05	M15	M25	M35	M45	K05	K15	K25	K35	K45
PVD	YG713		713					713					713		
	YG602		602					602					602		
	YG613			613					613						

YG713 P15 - P30 M15 - M30 K15 - K30 H20 - H30	PVD - TiAlN 	Drilling Grade for General Steel Application • Multi-layer TiAlN structure realizes stronger crater and flank wear resistance • Fine-grained carbide and balanced substrate
YG602 P20 - P35 M20 - M40 K20 - K40 S15 - S25	PVD - TiAlN 	Universal grade for General Drilling Application • Ultra Dense PVD Coating with optimal thermal resistance & strength • Sub-Micron substrate designed for demanding application
YG613 P30 - P50 M30 - M50	PVD - TiAlN 	Drilling Grade for Stainless Steel Application • New coating layer with lubrication preventing built-up edge on ultra fine grain substrate with high toughness. • The toughest substrate provides excellent cutting performance in stainless steel

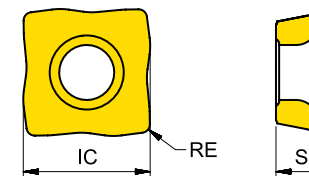
Universal Drilling Inserts

	4 Corner	SYMX Series	SYMX	05, 06, 07, 08
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Drilling Chipbreakers

P	M	K
P	M	K
General Inserts (No Description) • First Choice for General Application		

Drilling - Inserts X-Drill Inserts (SYMX)

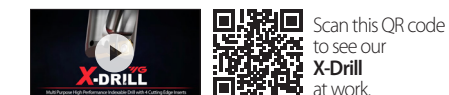


Series	IC	S
SYMX 0502	4.97	2.35
SYMX 0602	5.99	2.35
SYMX 07T2	7.01	2.80
SYMX 0803	8.30	3.20

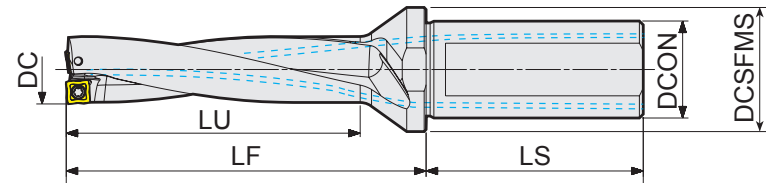
SYMX	Designation	RE (mm)	Fn (mm/rev.)	EDP 3200..		
				P25 M25 K30	P20 M20 K20	P40 M40
General	SYMX 050204	0.4	0.06~0.12	●	●	●
	SYMX 060204	0.4	0.06~0.12	●	●	●
	SYMX 07T206	0.6	0.06~0.12	●	●	●
	SYMX 080306	0.6	0.08~0.20	●	●	●



● : Stock item ○ : Order made item



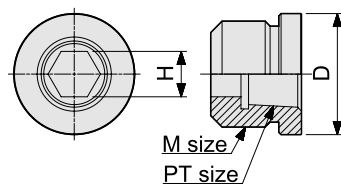
Drilling - Drill Holder
X-Drill Holder (SYM05) (DC 14~16)



☐: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM05 050204	14	28	YGSY2-140S20-05	1019	46	96.0	20	25	50
		42	YGSY3-140S20-05	1031	60	110.0			
		56	YGSY4-140S20-05	1043	74	124.0			
		70	YGSY5-140S20-05	1055	88	138.0			
	14.5	29	YGSY2-145S20-05	1134	49	99.0			
		43.5	YGSY3-145S20-05	1149	64	114.0			
		58	YGSY4-145S20-05	1164	79	129.0			
	15	72.5	YGSY5-145S20-05	1179	94	144			
		30	YGSY2-150S20-05	1020	49	99.0			
		45	YGSY3-150S20-05	1032	64	114.0			
	15.5	60	YGSY4-150S20-05	1044	79	129.0			
		75	YGSY5-150S20-05	1056	94	144.0			
		31	YGSY2-155S20-05	1135	52	102.0			
		46.5	YGSY3-155S20-05	1150	68	118.0			
	16	62	YGSY4-155S20-05	1165	84	134.0			
		77.5	YGSY5-155S20-05	1180	100	150			
		32	YGSY2-160S25-05	1021	52	102.0			
		48	YGSY3-160S20-05	1033	68	118.0			
	16.5	64	YGSY4-160S20-05	1045	84	134.0			
		80	YGSY5-160S20-05	1057	100	150.0			
33		YGSY2-165S20-05	1136	54	104				
	49.5	YGSY3-165S20-05	1151	71	121				
	66	YGSY4-165S20-05	1166	88	138				
	82.5	YGSY5-165S20-05	1181	105	155				

PLUG (DCON20)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M12-1/8	38000001	20	14	M12x1.0	PT 1/8	6

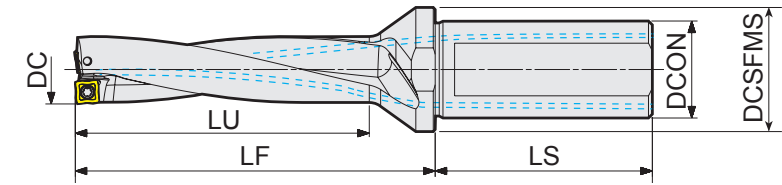
* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 0.6Nm

SYM05	Screw	Wrench
Description	TP062004-GS	TPWFTP06
EDP	18000252	18000262

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

Drilling - Drill Holder
X-Drill Holder (SYM06) (DC 17~20)

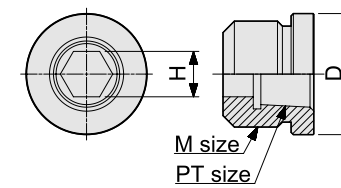


☐: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM06 060204	17	34	YGSY2-170S25-06	0851	54	110.0	25	32	56
		51	YGSY3-170S25-06	0855	71	127.0			
		68	YGSY4-170S25-06	0859	88	144.0			
		85	YGSY5-170S25-06	0863	105	161.0			
	17.5	35	YGSY2-175S25-06	1137	57	113.0			
		52.5	YGSY3-175S25-06	1152	75	131.0			
		70	YGSY4-175S25-06	1167	93	149.0			
	18	87.5	YGSY5-175S25-06	1182	111	167.0			
		36	YGSY2-180S25-06	0852	57	113.0			
		54	YGSY3-180S25-06	0856	75	131.0			
		72	YGSY4-180S25-06	0860	93	149.0			
	18.5	90	YGSY5-180S25-06	0864	111	167.0			
		37	YGSY2-185S25-06	1138	59	115.0			
		55.5	YGSY3-185S25-06	1153	78	134.0			
		74	YGSY4-185S25-06	1168	97	153.0			
		92.5	YGSY5-185S25-06	1183	116	172.0			

▶ NEXT PAGE

PLUG (DCON25)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M14-1/8	38000002	25	16	M14x1.0	PT 1/8	6

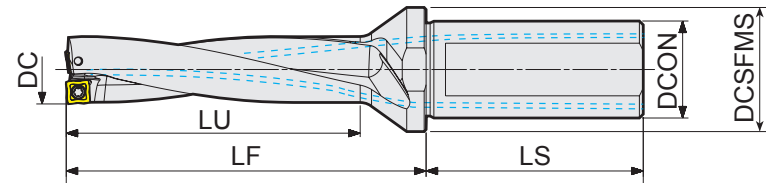
* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 0.7Nm

SYM06	Screw	Wrench
Description	TP072205-GS	TPWFTP07
EDP	18000253	18000001

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

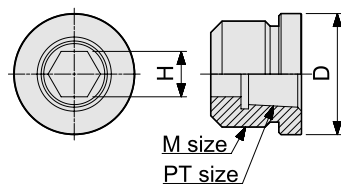
Drilling - Drill Holder
X-Drill Holder (SYM06) (DC 17~20)



☐: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM06 060204	19	38	YGSY2 - 190S25 - 06	0853	59	115.0	25	32	56
		57	YGSY3 - 190S25 - 06	0857	78	134.0			
		76	YGSY4 - 190S25 - 06	0861	97	153.0			
		95	YGSY5 - 190S25 - 06	0865	116	172.0			
	19.5	39	YGSY2-195S25-06	1139	63	119.0			
		58.5	YGSY3-195S25-06	1154	83	139.0			
		78	YGSY4-195S25-06	1169	103	159.0			
	20	97.5	YGSY5-195S25-06	1184	123	179.0			
		40	YGSY2 - 200S25 - 06	0854	63	119.0			
		60	YGSY3 - 200S25 - 06	0858	83	139.0			
	20.5	80	YGSY4 - 200S25 - 06	0862	103	159.0			
		100	YGSY5 - 200S25 - 06	0866	123	179.0			
		41	YGSY2-205S25-06	1140	65	121			
		61.5	YGSY3-205S25-06	1155	86	142			
		82	YGSY4-205S25-06	1170	107	163			
		102.5	YGSY5-205S25-06	1185	128	184			

PLUG (DCON25)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M14-1/8	38000002	25	16	M14x1.0	PT 1/8	6

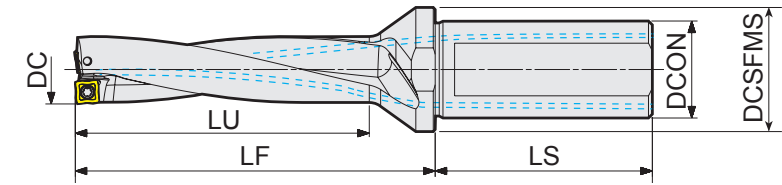
* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 0.7Nm

SYM06	Screw	Wrench
Description	TP072205-GS	TPWFTP07
EDP	18000253	18000001

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

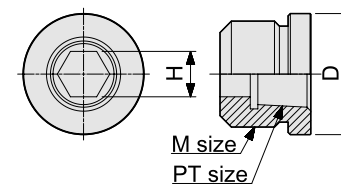
Drilling - Drill Holder
X-Drill Holder (SYM07) (DC 21~23)



☐: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM07 07T206	21	42	YGSY2 - 210S25 - 07	1022	65	121.0	25	32	56
		63	YGSY3 - 210S25 - 07	1034	86	142.0			
		84	YGSY4 - 210S25 - 07	1046	107	163.0			
		105	YGSY5 - 210S25 - 07	1058	128	184.0			
	21.5	43	YGSY2-215S25-07	1141	67	123.0			
		64.5	YGSY3-215S25-07	1156	89	145.0			
		86	YGSY4-215S25-07	1171	111	167.0			
	22	107.5	YGSY5-215S25-07	1186	133	189.0			
		44	YGSY2 - 220S25 - 07	1023	67	123.0			
		66	YGSY3 - 220S25 - 07	1035	89	145.0			
	22.5	88	YGSY4 - 220S25 - 07	1047	111	167.0			
		110	YGSY5 - 220S25 - 07	1059	133	189.0			
		45	YGSY2-225S25-07	1142	68	124.0			
		67.5	YGSY3-225S25-07	1157	91	147.0			
	23	90	YGSY4-225S25-07	1172	114	170.0			
		112.5	YGSY5-225S25-07	1187	137	193.0			
		46	YGSY2 - 230S25 - 07	1024	68	124.0			
		69	YGSY3 - 230S25 - 07	1036	91	147.0			
	23.5	92	YGSY4 - 230S25 - 07	1048	114	170.0			
		115	YGSY5 - 230S25 - 07	1060	137	193.0			
		47	YGSY2-235S25-07	1143	70	126			
		70.5	YGSY3-235S25-07	1158	94	150			
		94	YGSY4-235S25-07	1173	118	174			
		117.5	YGSY5-235S25-07	1188	142	198			

PLUG (DCON25)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M14-1/8	38000002	25	16	M14x1.0	PT 1/8	6

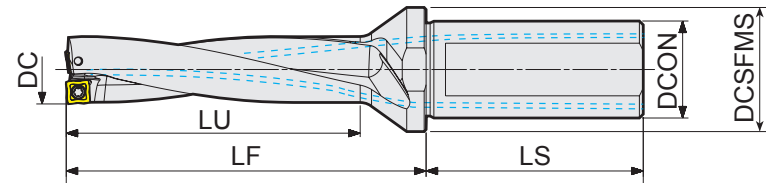
* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 0.7Nm

SYM07	Screw	Wrench
Description	TP072205-GS	TPWFTP07
EDP	18000253	18000001

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

Drilling - Drill Holder
X-Drill Holder (SYM08) (DC 24~28)

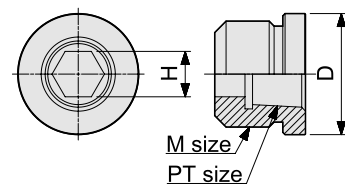


□: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM080306	24	48	YGSY2-240S32-08	1025	70	130.0	32	40	60
		72	YGSY3-240S32-08	1037	94	154.0			
		96	YGSY4-240S32-08	1049	118	178.0			
		120	YGSY5-240S32-08	1061	142	202.0			
	24.5	49	YGSY2-245S32-08	1144	72	132.0			
		73.5	YGSY3-245S32-08	1159	97	157.0			
		98	YGSY4-245S32-08	1174	122	182.0			
		122.5	YGSY5-245S32-08	1189	147	207.0			
	25	50	YGSY2-250S32-08	1026	72	132.0			
		75	YGSY3-250S32-08	1038	97	157.0			
		100	YGSY4-250S32-08	1050	122	182.0			
		125	YGSY5-250S32-08	1062	147	207.0			
	25.5	55	YGSY2-255S32-08	1145	73	133.0			
		76.5	YGSY3-255S32-08	1160	99	159.0			
		102	YGSY4-255S32-08	1175	125	185.0			
		127.5	YGSY5-255S32-08	1190	151	211.0			

▶ NEXT PAGE

PLUG (DCON32)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M22-1/4	38000003	32	24	M22x1.25	PT 1/4	10

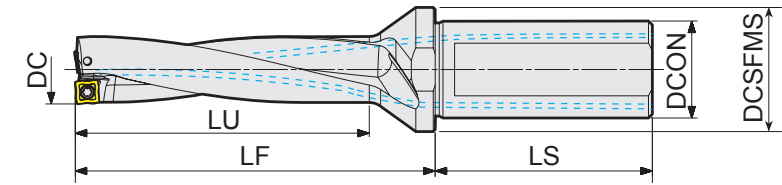
* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 1.2Nm

SYM08	Screw	Wrench
Description	TP072506-GS	TPWFTP07
EDP	18000261	18000001

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

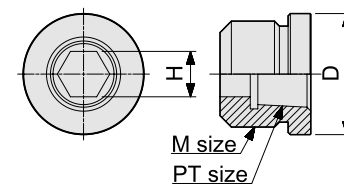
Drilling - Drill Holder
X-Drill Holder (SYM08) (DC 24~28)



□: p.31 Unit:mm

Series	DC	LU	Designation	EDP 3700..	LF	OAL	DCON	DCSFMS	LS
SYM080306	26.5	53	YGSY2-265S32-08	1146	77	137.0	32	40	60
		79.5	YGSY3-265S32-08	1161	104	164.0			
		106	YGSY4-265S32-08	1176	131	191.0			
		132.5	YGSY5-265S32-08	1191	158	218.0			
	27	54	YGSY2-270S32-08	1028	77	137.0			
		81	YGSY3-270S32-08	1040	104	164.0			
		108	YGSY4-270S32-08	1052	131	191.0			
		135	YGSY5-270S32-08	1064	158	218.0			
	27.5	55	YGSY2-275S32-08	1147	79	139.0			
		82.5	YGSY3-275S32-08	1162	107	167.0			
		110	YGSY4-275S32-08	1177	135	195.0			
		137.5	YGSY5-275S32-08	1192	163	223.0			
	28	56	YGSY2-280S32-08	1029	79	139.0			
		84	YGSY3-280S32-08	1041	107	167.0			
		112	YGSY4-280S32-08	1053	135	195.0			
		140	YGSY5-280S32-08	1065	163	223.0			
	28.5	57	YGSY2-285S32-08	1148	81	141			
		85.5	YGSY3-285S32-08	1163	110	170			
		114	YGSY4-285S32-08	1178	139	199			
		142.5	YGSY5-285S32-08	1193	168	228			

PLUG (DCON32)



Designation	EDP No.	DCON	ØD	M size	PT size	H
PLUG M22-1/4	38000003	32	24	M22x1.25	PT 1/4	10

* Plug for turning lathe should be ordered separately.

* Clamping Torque (Nm) 1.2Nm

SYM08	Screw	Wrench
Description	TP072506-GS	TPWFTP07
EDP	18000261	18000001

Plug	DCON	Ø 20	Ø 25	Ø 32
	Description	PLUG M12-1/8	PLUG M14-1/8	PLUG M22-1/4
EDP	38000001	38000002	38000003	

Technical Information

Recommended cutting conditions

Milling

Cutting Speed																							
ISO	VDI	Sub Group	YG012		YG712		YG713		YG622		YG612		YG602		YG613		YG501(G)		YG5020		YG50		
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	
P	1-5	Non-Alloyed Steel	180	280	170	300	200	300	140	400	180	280	180	270	100	210	-	-	-	-	-	-	-
	6-9	Low-Alloyed Steel	150	250	180	250	170	270	120	320	150	250	150	240	70	180	-	-	-	-	-	-	-
	10-11	High-Alloyed Steel	80	150	100	140	85	145	70	170	70	140	70	130	40	90	-	-	-	-	-	-	-
M	12-13	Ferritic & Martensitic	-	-	-	-	-	-	-	-	120	200	120	180	70	180	-	-	-	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	-	-	130	250	30	230	70	200	-	-	-	-	-	-	-
K	15-16	Grey Cast Iron	-	-	-	-	-	-	120	270	-	-	120	250	-	-	160	300	200	350	-	-	-
	17-18	Nodular Cast Iron	-	-	-	-	-	-	130	240	-	-	120	220	-	-	130	210	150	300	-	-	-
N	21-30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	300	800
S	31-37	Superalloys & Titanium	-	-	-	-	-	-	-	-	25	45	5	45	-	-	-	-	-	-	-	-	-
H	38-41	Hard Materials	70	120	-	-	-	-	40	100	-	-	-	-	-	-	-	-	-	-	-	-	-

Drilling

Cutting Speed									
ISO	VDI	Sub Group	Vc (m/min.)						
			YG602		YG713		YG613		
			Min	Max	Min	Max	Min	Max	
P	1-5	Non-Alloyed Steel	180	380	200	300	100	210	
	6-9	Low-Alloyed Steel	120	300	170	270	70	180	
	10-11	High-Alloyed Steel	70	150	85	145	40	90	
M	12-13	Ferritic & Martensitic	120	200	-	-	70	180	
	14	Austenitic Stainless Steel	130	250	-	-	70	200	
K	15-16	Grey Cast Iron	120	250	-	-	-	-	
	17-18	Nodular Cast Iron	130	220	-	-	-	-	
H	38-41	Hard Materials	-	-	-	-	-	-	

HIGH QUALITY PRODUCTS and ON TIME DELIVERY for WORLD-WIDE CUSTOMERS

Since 1982, YG-1 has been committed to quality, innovation and the unique customer experience. Our performance and experience have granted YG-1 the global impression of one of the leading manufacturers of high quality cutting tool solutions. This global footprint expands over 75 countries, with international logistic centers, pledging to our customers to give the best service available today - and tomorrow.

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