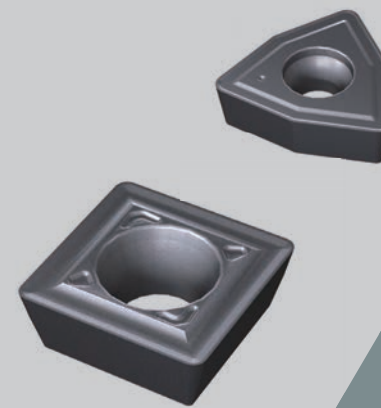


YG DRILL
INDEXABLE CUTTING TOOLS
YG UNIVERSAL LINE

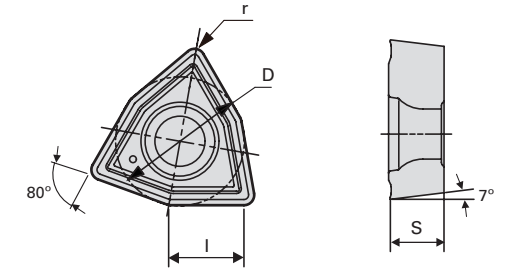


METRIC

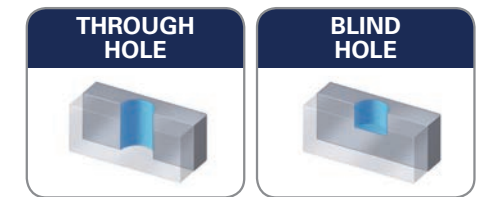
Designation	YG	S1	3	-	20	S	25	F	100	-	07
No.	①	②	③		④	⑤	⑥	⑦	⑧		⑨

No.	Meaning	Symbol	Explanation
①	Brand Name	YG	YG-1 Global
②	Insert Type	S1	S1 - SPMX...
③	Drilling Depth	3	3 - 3D, 5 - 5D...
④	Tool Diameter	20	Ø20, Ø30 ...
⑤	Tool Type (Interface)	S	Shank type
⑥	Shank Diameter	25	Ø25 - Shank diameter
⑦	Shank Type	F	Flange
		S	Straight
⑧	Tool Length	100	100mm, 150mm, 200mm...
⑨	Insert Size	07	05, 07, 09...

* Additional information(data) will be described in specific dimensions.

WCMX


Designation	Grade	Dimensions			
		I	D	S	r
WCMX 040208	YG602	3.33	6.35	2.38	0.8
WCMX 050308	YG602	3.39	7.94	3.18	0.8
WCMX 06T308	YG602	4.48	9.53	3.97	0.8
WCMX 080412	YG602	7.26	12.7	4.76	1.2



WCMX 0402
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.05	0.10	0.08	180	270	225
	Low Alloys	200	0.05	0.10	0.08	120	230	175
	High Alloys	220	0.07	0.10	0.09	70	170	120
M	Austenitic	190	0.05	0.10	0.08	170	230	200
K	Grey Cast Iron	140	0.10	0.11	0.11	150	230	190

WCMX 06T3
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.12	0.07	180	270	230
	Low Alloys	200	0.06	0.12	0.06	120	230	180
	High Alloys	220	0.08	0.12	0.10	70	170	120
M	Austenitic	190	0.06	0.12	0.09	170	230	200
K	Grey Cast Iron	140	0.12	0.13	0.13	150	230	190

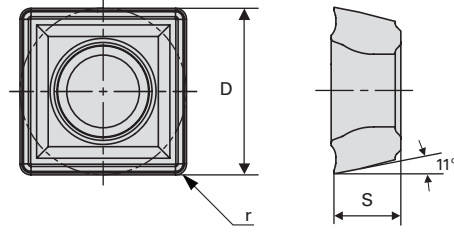
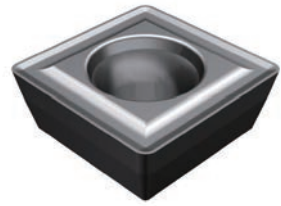
WCMX 0503
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.11	0.09	180	270	225
	Low Alloys	200	0.06	0.11	0.09	120	230	175
	High Alloys	220	0.09	0.11	0.10	70	170	120
M	Austenitic	190	0.06	0.11	0.09	170	230	200
K	Grey Cast Iron	140	0.13	0.12	0.13	150	230	190

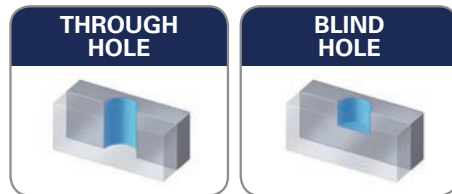
WCMX 0804
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.16	0.11	180	270	225
	Low Alloys	200	0.06	0.16	0.11	120	230	175
	High Alloys	220	0.09	0.16	0.13	70	170	120
M	Austenitic	190	0.06	0.15	0.11	170	230	200
K	Grey Cast Iron	140	0.10	0.18	0.14	150	230	190

SPMX 0502



Designation	Grade	Dimensions			
		l	D	S	r
SPMX 050204	YG602	-	5.00	2.38	0.4

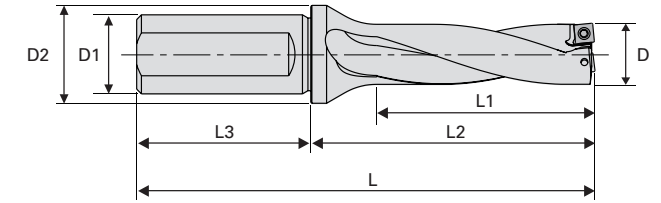


SPMX 0502

Recommended Cutting Condition

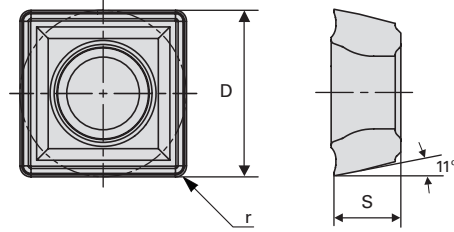
Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.04	0.09	0.07	180	270	225
	Low Alloys	200	0.04	0.09	0.07	120	230	175
	High Alloys	220	0.05	0.09	0.07	70	170	120
M	Austenitic	190	0.04	0.09	0.07	170	230	200
K	Grey Cast Iron	140	0.07	0.10	0.09	150	230	190

SPMX 0502 / Holder

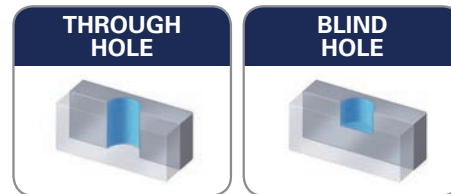


Designation	Dimensions								Spare parts		Geometry
	z	D	D1	D2	L1	L2	L3	L	Screw	Wrench	Relative Insert
YGS12-13S20F094-05	2	13.0	20	25	26	44	50	94	TP072043	TPWFTP07	SPMX 050204
YGS12-14S20F096-05	2	14.0	20	25	28	46	50	96			
YGS12-15S20F098-05	2	15.0	20	25	30	48	50	98			
YGS13-13S20F107-05	2	13.0	20	25	39	57	50	107			
YGS13-14S20F110-05	2	14.0	20	25	42	60	50	110			
YGS13-15S20F113-05	2	15.0	20	25	45	63	50	113			
YGS15-13S20F133-05	2	13.0	20	25	65	83	50	133			
YGS15-14S20F138-05	2	14.0	20	25	70	88	50	138			
YGS15-15S20F143-05	2	15.0	20	25	75	93	50	143			

SPMX 0602



Designation	Grade	Dimensions			
		l	D	S	r
SPMX 060204	YG602	-	6.00	2.41	0.4

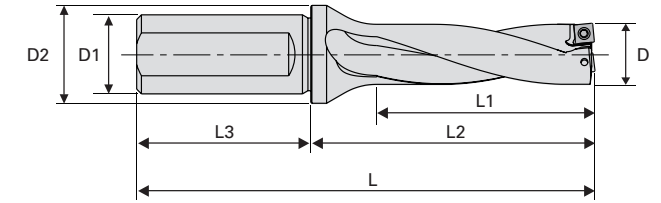


SPMX 0602

Recommended Cutting Condition

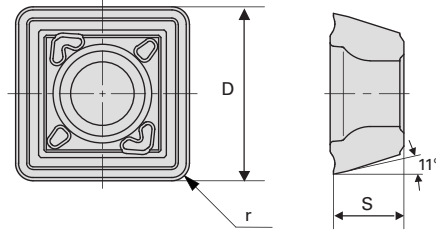
Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.04	0.09	0.07	180	270	225
	Low Alloys	200	0.04	0.09	0.07	120	230	175
	High Alloys	220	0.05	0.09	0.07	70	170	120
M	Austenitic	190	0.04	0.09	0.07	170	230	200
K	Grey Cast Iron	140	0.07	0.10	0.09	150	230	190

SPMX 0602 / Holder

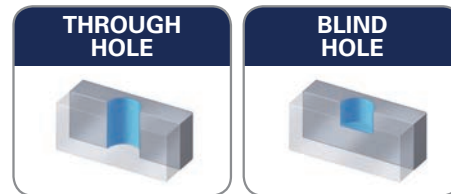


Designation	Dimensions								Spare parts		Geometry
	z	D	D1	D2	L1	L2	L3	L	Screw	Wrench	Relative Insert
YGS12-16S25F109-06	2	16.0	25	32	32	53	56	109	TP072252	TPWFTP07	SPMX 060204
YGS12-17S25F111-06	2	17.0	25	32	34	55	56	111			
YGS12-18S25F113-06	2	18.0	25	32	36	57	56	113			
YGS12-19S25F115-06	2	19.0	25	32	38	59	56	115			
YGS12-20S25F118-06	2	20.0	25	32	40	62	56	118			
YGS12-21S25F120-06	2	21.0	25	32	42	64	56	120			
YGS13-16S25F125-06	2	16.0	25	32	48	69	56	125			
YGS13-17S25F128-06	2	17.0	25	32	51	72	56	128			
YGS13-18S25F131-06	2	18.0	25	32	54	75	56	131			
YGS13-19S25F134-06	2	19.0	25	32	57	78	56	134			
YGS13-20S25F138-06	2	20.0	25	32	60	82	56	138			
YGS13-21S25F144-06	2	21.0	25	32	63	85	56	141			
YGS15-16S25F157-06	2	16.0	25	32	80	101	56	157			
YGS15-17S25F162-06	2	17.0	25	32	85	106	56	162			
YGS15-18S25F167-06	2	18.0	25	32	90	111	56	167			
YGS15-19S25F172-06	2	19.0	25	32	95	116	56	172			
YGS15-20S25F178-06	2	20.0	25	32	100	122	56	178			
YGS15-21S25F183-06	2	21.0	25	32	105	127	56	183			

SPMX 07T3



Designation	Grade	Dimensions			
		l	D	S	r
SPMX 07T308	YG602	-	7.95	3.99	0.8

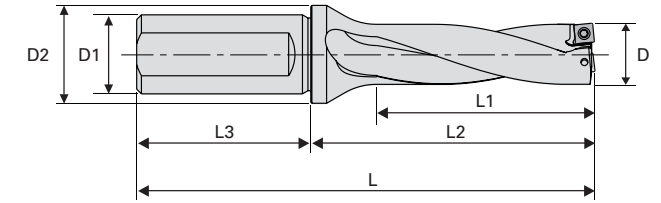


SPMX 07T3

Recommended Cutting Condition

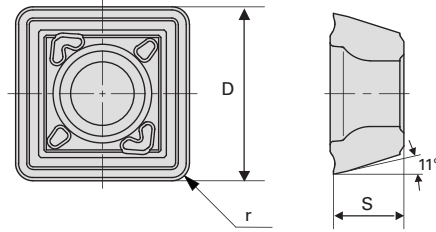
Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.05	0.10	0.08	180	270	220
	Low Alloys	200	0.05	0.10	0.08	120	230	180
	High Alloys	220	0.07	0.10	0.10	70	170	120
M	Austenitic	190	0.05	0.10	0.08	170	230	200
K	Grey Cast Iron	140	0.10	0.11	0.11	150	230	190

SPMX 07T3 / Holder

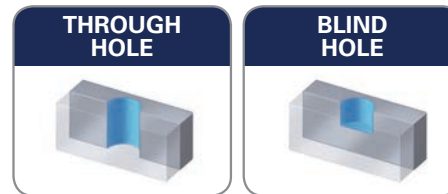


Designation	Dimensions								Spare parts		Geometry
	z	D	D1	D2	L1	L2	L3	L	Screw	Wrench	Relative Insert
YGS12-22S32F134-07	2	22.0	32	45	44	74	60	134	TP082564	TPWFTP08	SPMX 07T308
YGS12-23S32F136-07	2	23.0	32	45	46	76	60	136			
YGS12-24S32F138-07	2	24.0	32	45	48	78	60	138			
YGS12-25S32F140-07	2	25.0	32	45	50	80	60	140			
YGS12-26S32F142-07	2	26.0	32	45	52	82	60	142			
YGS12-27S32F144-07	2	27.0	32	45	54	84	60	144			
YGS13-22S32F156-07	2	22.0	32	45	66	96	60	156			
YGS13-23S32F159-07	2	23.0	32	45	69	99	60	159			
YGS13-24S32F162-07	2	24.0	32	45	72	102	60	162			
YGS13-25S32F165-07	2	25.0	32	45	75	105	60	165			
YGS13-26S32F168-07	2	26.0	32	45	78	108	60	168			
YGS13-27S32F171-07	2	27.0	32	45	81	111	60	171			
YGS15-22S32F200-07	2	22.0	32	45	110	140	60	200			
YGS15-23S32F205-07	2	23.0	32	45	115	145	60	205			
YGS15-24S32F210-07	2	24.0	32	45	120	150	60	210			
YGS15-25S32F215-07	2	25.0	32	45	125	155	60	215			
YGS15-26S32F168-07	2	26.0	32	45	130	160	60	220			
YGS15-27S32F171-07	2	27.0	32	45	135	165	60	225			

SPMX 0904



Designation	Grade	Dimensions			
		l	D	S	r
SPMX 090408	YG602	-	9.80	4.30	0.8

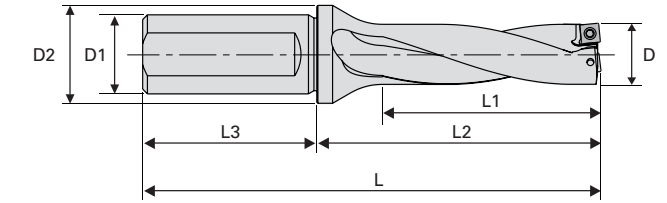


SPMX 0904

Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.11	0.09	180	270	225
	Low Alloys	200	0.06	0.11	0.09	120	230	175
	High Alloys	220	0.09	0.11	0.10	70	170	120
M	Austenitic	190	0.06	0.11	0.09	170	230	200
K	Grey Cast Iron	140	0.13	0.12	0.13	150	230	190

SPMX 0904 / Holder



Designation	Dimensions								Spare parts		Geometry
	z	D	D1	D2	L1	L2	L3	L	Screw	Wrench	Relative Insert
YGS12-28S32F146-09	2	28.0	32	45	56	86	60	146	TP153588	TPWFTP15	SPMX 090408
YGS12-29S32F148-09	2	29.0	32	45	58	88	60	148			
YGS12-30S32F151-09	2	30.0	32	55	60	91	60	151			
YGS12-31S32F153-09	2	31.0	32	55	62	93	60	153			
YGS12-32S32F155-09	2	32.0	32	55	64	95	60	155			
YGS12-33S32F157-09	2	33.0	32	55	66	97	60	157			
YGS13-28S32F174-09	2	28.0	32	45	84	114	60	174			
YGS13-29S32F177-09	2	29.0	32	45	87	117	60	177			
YGS13-30S32F181-09	2	30.0	32	55	90	121	60	181			
YGS13-31S32F184-09	2	31.0	32	55	93	124	60	184			
YGS13-32S32F187-09	2	32.0	32	55	96	127	60	187			
YGS13-33S32F190-09	2	33.0	32	55	99	130	60	190			
YGS15-28S32F230-09	2	28.0	32	45	140	170	60	230			
YGS15-29S32F235-09	2	29.0	32	45	145	175	60	235			
YGS15-30S32F241-09	2	30.0	32	55	150	181	60	241			
YGS15-31S32F246-09	2	31.0	32	55	155	186	60	246			
YGS15-32S32F251-09	2	32.0	32	55	160	191	60	251			
YGS15-33S32F256-09	2	33.0	32	55	165	196	60	256			