

YU-VP15

BEST VALUE IN THE WORLD OF CUTTING TOOLS



V7 Plus *A*

HIGH PERFORMANCE CARBIDE END MILLS
FOR STEEL, CAST IRON, STAINLESS STEEL



MADE IN
USA ★

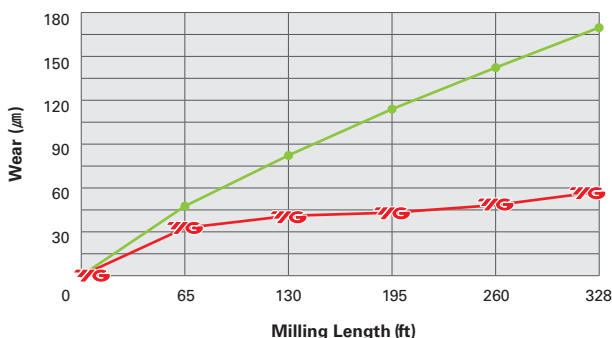
YG YG-1 CO., LTD.

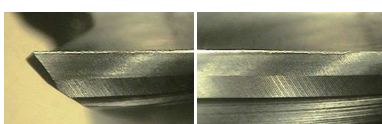
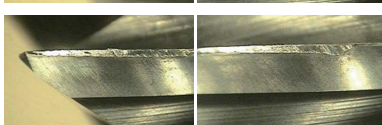
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NO.	MODEL	DESCRIPTION
UGMF68 UGMF69		CARBIDE, 4 FLUTE
UGMF70 UGMF71		CARBIDE, 4 FLUTE CORNER RADIUS
UGMF72 UGMF73		CARBIDE, 4 FLUTE with EXTENDED NECK
UGMF74 UGMF75		CARBIDE, 4 FLUTE with EXTENDED NECK, CORNER RADIUS
UGMF76 UGMF77		CARBIDE, 4 FLUTE



CASE STUDY 1

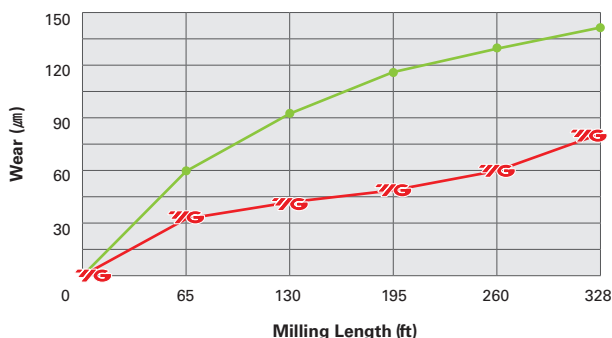
Test - I		V7 Plus4 > Competitor		 V7 PLUS A  Competitor
List	Tool	V7 Plus4	Competitor	
Wear(μm)		56.26	168.943	
Size		Ø6 x Ø6 x 12 x 50	Ø6 x Ø6 x 15 x 50	
Milling Length		328 ft		
Work Material		- JIS: SKD61 (HRc 30) - AISI: H31 - DIN: X40CrMoV51 (1.2344)		
Cutting Speed		293 ft/min		
RPM		4,750rev/min		
Feed		44.09 inch/min		
Feed per tooth		.002 inch/tooth		
Milling Method		Down & Side Cutting		
Milling Depth		Axial: .236, Radial: .012(inch)		
Coolant		Oil Mist		
Overhang		.787 inch		
Machine		Machining Center		

Comparison of the Cutting Edges	
	
Competitor	

◎:Excellent ○:Good

SIZE		Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	Copper	High Temperature Alloy	Cast Iron	Titanium	Stainless Steels	PAGE
MIN	MAX	~HB225	HB225~352	HRc30~40	HRc40~45						
1/8 11/32	1	◎	◎	◎	○		○	◎	○	◎	5
1/8 3/8	1	◎	◎	◎	○		○	◎	○	◎	6
1/4 3/8	1	◎	◎	◎	○		○	◎	○	◎	8
1/4 3/8	1	◎	◎	◎	○		○	◎	○	◎	9
3/8	1	◎	◎	◎	○		○	◎	○	◎	10

CASE STUDY 2

Test - II		V7 Plus4 > Competitor		V7 PLUS A Competitor	
List	Tool	V7 Plus4	Competitor		
Wear (μm)		81.064	140.470		
Size		Ø10 x Ø10 x 20 x 75	Ø10 x Ø10 x 25 x 75		
Milling Length		328 ft			
Work Material		- JIS: SKD61 (HRc 30) - AISI: H31 - DIN: X40CrMoV51 (1.2344)			
Cutting Speed		283 ft/min			
RPM		2,750rev/min			
Feed		40.94 inch/min			
Feed per tooth		.004 inch/tooth			
Milling Method		Down & Side Cutting			
Milling Depth		Axial: .394, Radial: .020(inch)			
Coolant		Oil Mist			
Overhang		1.102 inch			
Machine		Machining Center			
				Comparison of the Cutting Edges	
				V7 Plus4	
				Competitor	

ICON GUIDE



The tool is made of Micro grain carbide.



4 - flute tool



Multiple helix



Type of shank



Chamfer Angle



Cutting condition of tool see page 000

V7 Plus^A NEW ENGINEERED DESIGN!

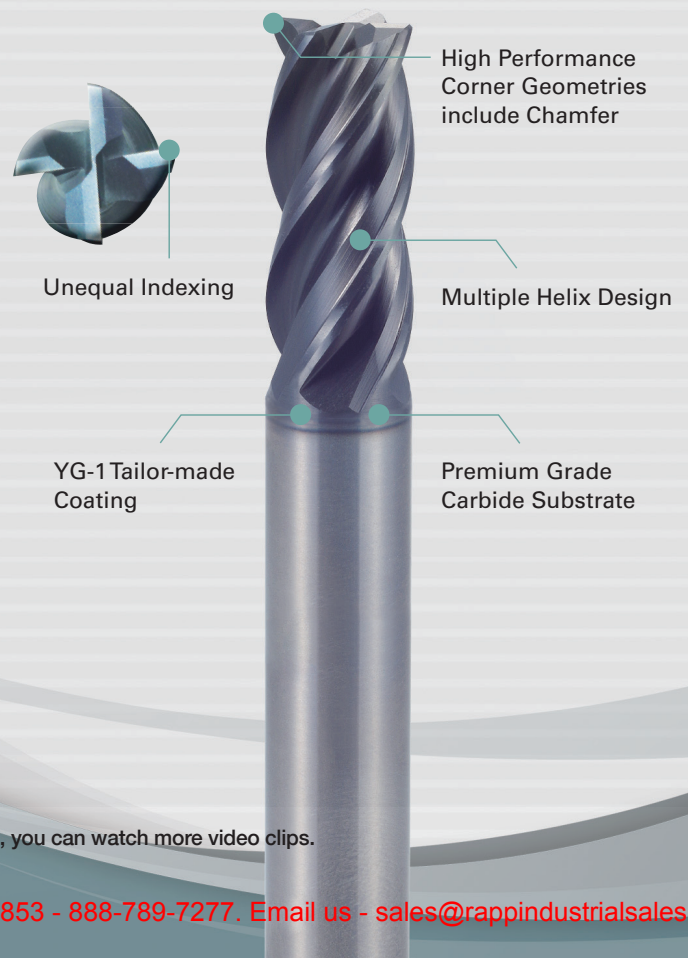
The **V7 Plus^A** for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40 has a unique design that maximizes chip removal and improves productivity in slotting and heavy profiling operations. The **V7 Plus^A** advanced geometry reduces chatter for increased tool life and increased productivity.

APPLICATION :

- Stainless Steels
- Mild Steels and Cast Iron
- Low to Medium hardness materials under HRc40

BENEFITS :

- Reduced chatter and harmonics for improved stability and better finishing
- Designed flute geometry for optimal chip formation and chip evacuation
- Enhanced corner geometry for longer tool life
- Engineered coating for reduced wear and superior heat resistance



You Tube

YG V7 Plus



* When you search 'YG-1 Cutting Tool' or 'YG-1 CO., LTD.', you can watch more video clips.

CARBIDE, 4 FLUTE

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



**MADE IN
USA**

UGMF68 / PLAIN SHANK

UGMF69 / FLAT SHANK



P.11~12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~-0.0012	h6

Unit : inch

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT				
UGMF68008	-	1/8	1/8	1/8	1-1/2
UGMF68901	-		1/8	3/8	1-1/2
UGMF68010	-	5/32	3/16	3/16	2
UGMF68902	-		3/16	7/16	2
UGMF68012	-	3/16	3/16	3/16	2
UGMF68903	-		3/16	7/16	2
UGMF68014	-	7/32	1/4	1/4	2
UGMF68904	-		1/4	7/16	2-1/2
UGMF68016	-	1/4	1/4	3/8	2
UGMF68905	-		1/4	3/4	2-1/2
UGMF68018	-	9/32	5/16	5/8	2-1/2
UGMF68020	-	5/16	5/16	7/16	2
UGMF68906	-		5/16	13/16	2-1/2
UGMF68022	UGMF69022	11/32	3/8	1/2	2-1/2
UGMF68024	UGMF69024	3/8	3/8	1/2	2-1/2
UGMF68907	UGMF69907		3/8	7/8	2-1/2
UGMF68028	UGMF69028	7/16	7/16	5/8	2-1/2
UGMF68908	UGMF69908		7/16	1	2-3/4
UGMF68032	UGMF69032	1/2	1/2	5/8	2-1/2
UGMF68909	UGMF69909		1/2	1	3
UGMF68910	UGMF69910		1/2	1-1/4	3-1/2
UGMF68040	UGMF69040	5/8	5/8	3/4	3
UGMF68911	UGMF69911		5/8	1-1/4	3-1/2
UGMF68048	UGMF69048	3/4	3/4	3/4	3
UGMF68912	UGMF69912		3/4	1-1/2	4
UGMF68064	UGMF69064	1	1	1	4
UGMF68913	UGMF69913		1	1-1/2	4
UGMF68914	UGMF69914		1	2	5

CARBIDE, 4 FLUTE CORNER RADIUS

- Special flute geometry and multiple helix eliminate vibrations
- Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



UGMF70 / PLAIN SHANK

UGMF71 / FLAT SHANK

**MADE IN
USA**



Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~-.0012	h6

Unit : inch

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT					
UGMF70008	-	R.010	1/8	1/8	1/8	1-1/2
UGMF70901	-			1/8	3/8	1-1/2
UGMF70902	-			1/8	3/8	1-1/2
UGMF70012	-	R.010	3/16	3/16	3/16	2
UGMF70903	-			3/16	7/16	2
UGMF70904	-			3/16	7/16	2
UGMF70016	-	R.010	1/4	1/4	3/8	2
UGMF70905	-			1/4	3/8	2
UGMF70906	-			1/4	3/8	2
UGMF70907	-	R.030	1/4	1/4	3/4	2-1/2
UGMF70908	-	R.015		1/4	3/4	2-1/2
UGMF70909	-	R.030		1/4	3/4	2-1/2
UGMF70020	-	R.030	5/16	5/16	7/16	2
UGMF70910	-			5/16	13/16	2-1/2
UGMF70911	-			5/16	13/16	2-1/2
UGMF70912	-	R.060		5/16	13/16	2-1/2
UGMF70024	UGMF71024	R.010	3/8	3/8	1/2	2-1/2
UGMF70913	UGMF71913	R.030		3/8	1/2	2-1/2
UGMF70914	UGMF71914	R.060		3/8	1/2	2-1/2
UGMF70915	UGMF71915	R.010	3/8	3/8	7/8	2-1/2
UGMF70916	UGMF71916	R.030		3/8	7/8	2-1/2
UGMF70917	UGMF71917	R.060		3/8	7/8	2-1/2
UGMF70028	UGMF71028	R.015	7/16	7/16	5/8	2-1/2
UGMF70918	UGMF71918	R.030		7/16	5/8	2-1/2
UGMF70919	UGMF71919	R.010		7/16	1	2-3/4
UGMF70920	UGMF71920	R.030	7/16	7/16	1	2-3/4
UGMF70921	UGMF71921	R.060		7/16	1	2-3/4
UGMF70032	UGMF71032	R.010	1/2	1/2	5/8	2-1/2
UGMF70922	UGMF71922	R.015		1/2	5/8	2-1/2
UGMF70923	UGMF71923	R.030		1/2	5/8	2-1/2
UGMF70924	UGMF71924	R.060	1/2	1/2	5/8	2-1/2
UGMF70925	UGMF71925	R.010		1/2	1	3

CARBIDE, 4 FLUTE CORNER RADIUS

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



UGMF70 / PLAIN SHANK

UGMF71 / FLAT SHANK

**MADE IN
USA**



P.11~12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~.0012	h6

Unit : inch

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT					
UGMF70926	UGMF71926	R.030	1/2	1/2	1	3
UGMF70927	UGMF71927	R.060		1/2	1	3
UGMF70928	UGMF71928	R.125		1/2	1	3
UGMF70929	UGMF71929	R.010		1/2	1-1/4	3-1/2
UGMF70930	UGMF71930	R.015		1/2	1-1/4	3-1/2
UGMF70931	UGMF71931	R.030		1/2	1-1/4	3-1/2
UGMF70932	UGMF71932	R.060		1/2	1-1/4	3-1/2
UGMF70933	UGMF71933	R.125		1/2	1-1/4	3-1/2
UGMF70040	UGMF71040	R.010	5/8	5/8	3/4	3
UGMF70934	UGMF71934	R.030		5/8	3/4	3
UGMF70935	UGMF71935	R.060		5/8	3/4	3
UGMF70936	UGMF71936	R.010		5/8	1-1/4	3-1/2
UGMF70937	UGMF71937	R.015		5/8	1-1/4	3-1/2
UGMF70938	UGMF71938	R.030		5/8	1-1/4	3-1/2
UGMF70939	UGMF71939	R.060		5/8	1-1/4	3-1/2
UGMF70940	UGMF71940	R.125		5/8	1-1/4	3-1/2
UGMF70048	UGMF71048	R.030	3/4	3/4	3/4	3
UGMF70941	UGMF71941	R.060		3/4	3/4	3
UGMF70942	UGMF71942	R.015		3/4	1-1/2	4
UGMF70943	UGMF71943	R.030		3/4	1-1/2	4
UGMF70944	UGMF71944	R.060		3/4	1-1/2	4
UGMF70945	UGMF71945	R.125		3/4	1-1/2	4
UGMF70064	UGMF71064	R.015	1	1	1	4
UGMF70946	UGMF71946	R.030		1	1	4
UGMF70947	UGMF71947	R.060		1	1	4
UGMF70948	UGMF71948	R.015		1	1-1/2	4
UGMF70949	UGMF71949	R.030		1	1-1/2	4
UGMF70950	UGMF71950	R.060		1	1-1/2	4
UGMF70951	UGMF71951	R.125		1	1-1/2	4
UGMF70952	UGMF71952	R.015		1	2	5
UGMF70953	UGMF71953	R.030		1	2	5
UGMF70954	UGMF71954	R.060		1	2	5

CARBIDE, 4 FLUTE with EXTENDED NECK

- Special flute geometry and multiple helix eliminate vibrations
- Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



UGMF72 / PLAIN SHANK

UGMF73 / FLAT SHANK

**MADE IN
USA**



P.11~12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~-0.0012	h6

Unit : inch

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	LENGTH BELOW SHANK	OVERALL LENGTH
PLAIN	FLAT					
UGMF72016	-	1/4	1/4	3/8	3/4	4
UGMF72901	-		1/4	3/8	1-1/8	4
UGMF72902	-		1/4	3/8	2-1/8	4
UGMF72024	UGMF73024	3/8	3/8	1/2	1-1/8	4
UGMF72903	UGMF73903		3/8	1/2	2-1/8	4
UGMF72904	UGMF73904		3/8	1/2	3-1/8	6
UGMF72032	UGMF73032	1/2	1/2	5/8	1-1/2	4
UGMF72905	UGMF73905		1/2	5/8	2-1/4	4
UGMF72906	UGMF73906		1/2	5/8	3-3/8	6
UGMF72040	UGMF73040	5/8	5/8	3/4	1-5/8	4
UGMF72907	UGMF73907		5/8	3/4	2-3/8	6
UGMF72908	UGMF73908		5/8	3/4	3-3/8	6
UGMF72048	UGMF73048	3/4	3/4	1	2	4
UGMF72909	UGMF73909		3/4	1	3	6
UGMF72910	UGMF73910		3/4	1	4	6
UGMF72064	UGMF73064	1	1	1-1/8	2	4
UGMF72911	UGMF73911		1	1-1/8	3	6
UGMF72912	UGMF73912		1	1-1/8	4	6

CARBIDE, 4 FLUTE with EXTENDED NECK, CORNER RADIUS

- Special flute geometry and multiple helix eliminate vibrations
- Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



UGMF74 / PLAIN SHANK

UGMF75 / FLAT SHANK

**MADE IN
USA**



P.11~12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~-0.0012	h6

Unit : inch

EDP No.		CORNER RADIUS	MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	LENGTH BELOW SHANK	OVERALL LENGTH
PLAIN	FLAT						
UGMF74016	-	R.015	1/4	1/4	3/8	3/4	4
UGMF74901	-			1/4	3/8	1-1/8	4
UGMF74902	-			1/4	3/8	2-1/8	4
UGMF74024	UGMF75024	R.030	3/8	3/8	1/2	1-1/8	4
UGMF74903	UGMF75903			3/8	1/2	2-1/8	4
UGMF74904	UGMF75904			3/8	1/2	3-1/8	6
UGMF74032	UGMF75032	R.030	1/2	1/2	5/8	1-1/2	4
UGMF74905	UGMF75905			1/2	5/8	2-1/4	4
UGMF74906	UGMF75906			1/2	5/8	3-3/8	6
UGMF74040	UGMF75040	R.030	5/8	5/8	3/4	1-5/8	4
UGMF74907	UGMF75907			5/8	3/4	2-3/8	6
UGMF74908	UGMF75908			5/8	3/4	3-3/8	6
UGMF74048	UGMF75048	R.030	3/4	3/4	1	2	4
UGMF74909	UGMF75909			3/4	1	3	6
UGMF74910	UGMF75910			3/4	1	4	6
UGMF74064	UGMF75064	R.030	1	1	1-1/8	2	4
UGMF74911	UGMF75911			1	1-1/8	3	6
UGMF74912	UGMF75912			1	1-1/8	4	6

CARBIDE, 4 FLUTE

- Special flute geometry and multiple helix eliminate vibrations
- Excellent performance for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40



UGMF76 / PLAIN SHANK

UGMF77 / FLAT SHANK

**MADE IN
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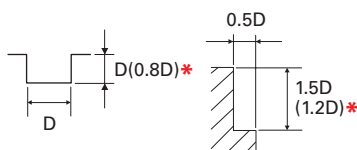
P.11~12

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance (inch)
0~-.0012	h6

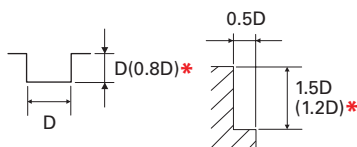
Unit : inch

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	OVERALL LENGTH	CHAMFER
PLAIN	FLAT					
UGMF76024	UGMF77024	3/8	3/8	7/8	2-1/2	.011
UGMF76032	UGMF77032	1/2	1/2	5/8	2-1/2	.013
UGMF76901	UGMF77901		1/2	1-1/4	3-1/2	.013
UGMF76040	UGMF77040	5/8	5/8	1-1/4	3-1/2	.015
UGMF76048	UGMF77048	3/4	3/4	1-1/2	4	.019
UGMF76064	UGMF77064	1	1	1-1/2	4	.019

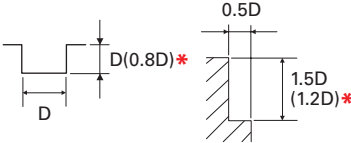
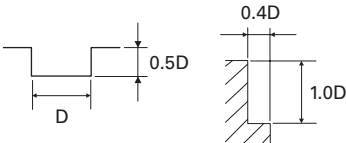
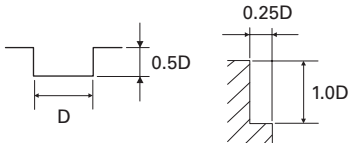
MATERIAL	P											
	CARBON STEELS				ALLOY STEELS				TOOL STEELS			
	10**, 11**, 12**, 12L**, 15**				41**, 43**, 51**, 86**				A2, D2, H13, P20, T15			
HARDNESS	~ HB 300				HB 300 ~ HB 380				~ HB 380			
STRENGTH	~ 1000N/mm ²				1000N/mm ² ~ 1300N/mm ²				~ 1300N/mm ²			
DIAMETER	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz	RPM	FEED	Vc	Fz
1/8	16170	13.0	500	.0002	11315	9.1	350	.0002	6790	3.7	210	.0001
5/32	12125	15.6	500	.0003	8485	10.8	350	.0003	5090	4.5	210	.0002
3/16	9700	17.5	500	.0005	6790	12.2	350	.0004	4075	5.1	210	.0003
7/32	8890	19.0	509	.0005	6223	13.3	356	.0005	3735	5.5	214	.0004
1/4	8080	20.5	500	.0006	5655	14.4	350	.0006	3395	5.9	210	.0004
9/32	7070	23.3	521	.0009	4948	16.2	364	.0009	2970	6.7	219	.0006
5/16	6060	26.2	500	.0011	4240	18.1	350	.0011	2545	7.5	210	.0007
11/32	5703	29.2	514	.0013	3990	20.4	359	.0013	2393	8.5	215	.0009
3/8	5345	32.3	551	.0015	3740	22.6	386	.0015	2240	9.4	231	.0011
7/16	4898	32.6	561	.0017	3420	22.7	392	.0017	2050	9.4	235	.0012
1/2	4450	32.9	551	.0018	3100	22.8	384	.0018	1860	9.4	230	.0013
5/8	3340	28.0	551	.0021	2330	19.3	385	.0021	1400	8.1	231	.0014
3/4	2670	27.4	551	.0026	1870	19.1	386	.0026	1120	7.9	231	.0018
1	2140	21.7	552	.0025	1495	15.0	386	.0025	895	6.3	231	.0018

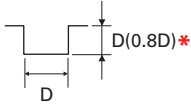
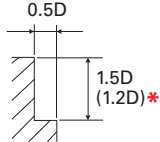


MATERIAL	K				M							
	CAST IRON				STAINLESS STEELS 300				STAINLESS STEELS 400			
	Gray, Malleable, Ductile				304, 316, 304L, 316LSUS316				416, 420F, 430F, 440F			
HARDNESS	~ HB 260											
STRENGTH	~ 870N/mm ²											
DIAMETER	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz
1/8	11880	11.8	368	.0002	11205	8.3	347	.0002	15690	8.9	486	.0001
5/32	8910	14.2	368	.0004	8400	10.8	347	.0003	11740	11.0	484	.0002
3/16	7130	15.9	368	.0006	6725	13.4	347	.0005	9405	13.4	485	.0004
7/32	6535	17.4	374	.0007	6165	14.5	353	.0006	8625	14.5	494	.0004
1/4	5940	18.9	368	.0008	5605	15.6	347	.0006	7845	15.6	486	.0005
9/32	5198	21.3	383	.0011	4905	17.1	361	.0009	6863	17.8	505	.0007
5/16	4455	23.6	368	.0013	4205	18.7	347	.0011	5880	20.1	485	.0009
11/32	4193	26.7	378	.0016	3785	22.0	341	.0015	5293	22.6	477	.0011
3/8	3930	29.7	405	.0019	3365	25.4	347	.0019	4705	25.2	485	.0013
7/16	3593	29.8	412	.0021	3083	24.9	353	.0020	4315	24.8	494	.0014
1/2	3255	29.9	403	.0023	2800	24.4	347	.0022	3925	24.4	486	.0016
5/8	2450	25.2	404	.0026	2105	20.7	347	.0025	2940	20.7	485	.0018
3/4	1965	25.0	405	.0032	1680	20.3	347	.0030	2355	20.3	486	.0022
1	1570	19.5	405	.0031	1345	16.3	347	.0030	1885	16.3	486	.0022



MATERIAL	M				S							
	STAINLESS STEELS (PH)				TITANIUM				HIGH TEMPERATURE ALLOY			
	17-4PH, 15-5PH, 13-8PH				Ti6Al4V, Ti5Al5V5Mo, Ti7Al4Mo				INCONEL, HASTELLOY, RENE			
HARDNESS												
STRENGTH												
DIAMETER	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz
1/8	10085	7.3	312	.0002	6165	3.9	191	.0002	2805	1.4	87	.0001
5/32	7560	9.6	312	.0003	4620	5.3	191	.0003	2100	1.8	87	.0002
3/16	6055	12.0	312	.0005	3700	6.5	191	.0004	1685	2.2	87	.0003
7/32	5550	13.0	318	.0006	3393	7.1	194	.0005	1545	2.4	88	.0004
1/4	5045	14.0	312	.0007	3085	7.7	191	.0006	1405	2.6	87	.0005
9/32	4415	15.4	325	.0009	2700	8.5	199	.0008	1228	2.9	90	.0006
5/16	3785	16.7	312	.0011	2315	9.3	191	.0010	1050	3.1	87	.0007
11/32	3408	19.8	307	.0015	2085	10.8	188	.0013	945	3.7	85	.0010
3/8	3030	22.8	313	.0019	1855	12.4	191	.0017	840	4.3	87	.0013
7/16	2775	22.3	318	.0020	1698	12.2	195	.0018	770	4.2	88	.0014
1/2	2520	21.9	312	.0022	1540	12.0	191	.0019	700	4.1	87	.0015
5/8	1895	18.5	313	.0024	1160	10.0	191	.0022	525	3.5	87	.0017
3/4	1515	18.1	313	.0030	925	9.8	191	.0027	420	3.5	87	.0021
1	1215	14.6	313	.0030	740	8.1	191	.0027	335	2.8	86	.0021

*Axial cutting depth			
Length of Cut	<1.5D	0.8D	1.2D
	≥1.5D	D	1.5D

RPM = rev./min.
 FEED = inch/min.
 SFM = ft/min
 Fz = inch/tooth

MEMO

MEMO

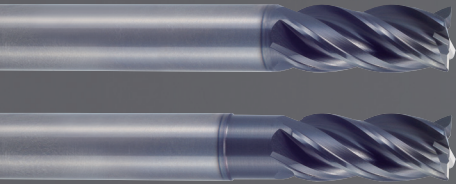
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