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HF4 **YG MILL**

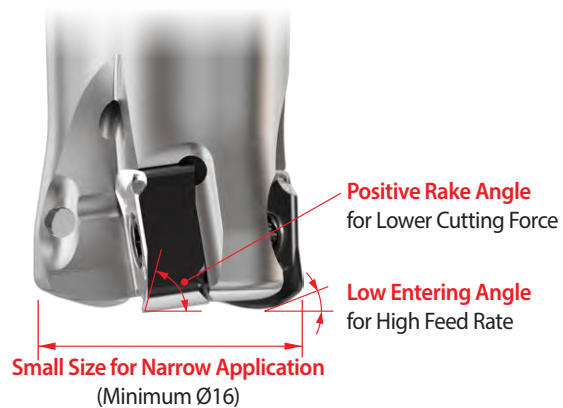
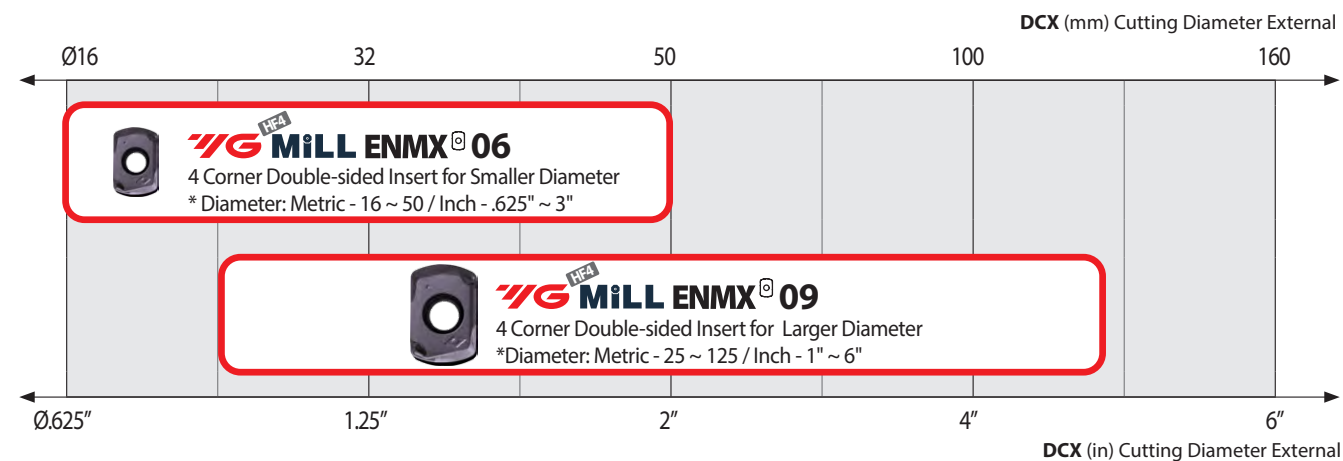
New HIGH FEED 4 Corner Milling Series

ENMX **MINI HIGH FEED**

for Narrow and Long Reach Application

- Variety of cutter range $\varnothing 16 \sim \varnothing 125$ ($\varnothing .625'' \sim \varnothing 6''$) with 2 different size of insert
- Double sided with 4 cutting edges
- Dedicated grade with chip breaker for ISO P, M, K and H
- Efficiency solutions with high feed, Facing, Ramping, Plunging and Helical interpolation.

High Feed Milling HF4 Series



Application

- High feed milling, Profiling, Face milling, Ramping, Plunging, Helical interpolation

Features

- Diameter range : 16~125mm (.625"~5")
- Double-sided insert with 4 corners
- Wide flank face with reinforced insert shape
- Positive rake angle & low entering angle
- 3 Insert geometries



ENMX General
Carbon Steel
Low Alloy Steel



ENMX -TR
Reinforced Edge
High Alloy Steel
Hardened Steel
Cast Iron



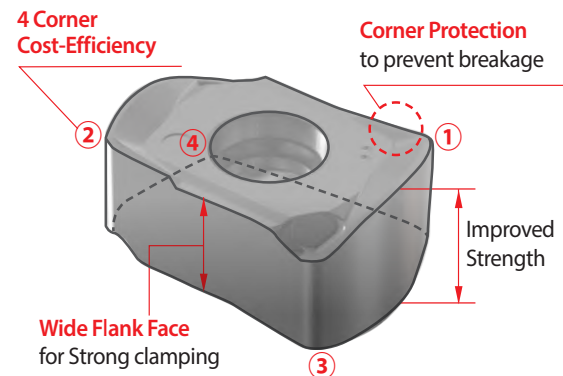
ENMX -ST
Reinforced Edge
High Alloy Steel
Hardened Steel
Cast Iron

Advantages

- Narrow application available (minimum Ø16)
- High versatile machining
- High cost-efficiency
- Rigid clamping on insert seat
- Prevent breakage on machining
- High feed rate available with low cutting force

Benefits

- Expand machining ability with high versatility & small diameter ability
- Boost up productivity with high feed rate
- Safe machining with rigidity and strong insert shape



YG HF4 Mill ENMX for Chip breakers & Grades

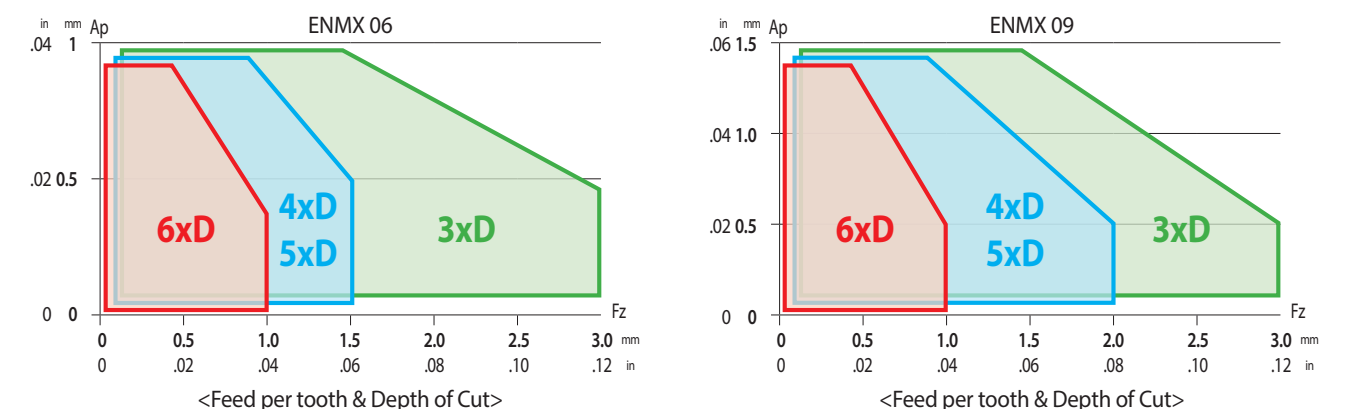
Chip breakers

P	M	K	S	Chip breaker	Application	ENMX Insert
	M	S		ST Sticky material	Aerospace Sticky materials Stainless Steel & Super Alloys	ENMX 06 (available) ENMX 09 (available)
P	M	K		General Universal	General Application Carbon Steels Low Alloyed Steels Low cutting force	ENMX 06 (available) ENMX 09 (available)
P		K		-TR Reinforced Edge	Mold & Die High Alloyed Steels Cast Irons	ENMX 06 (available) ENMX 09 (available)

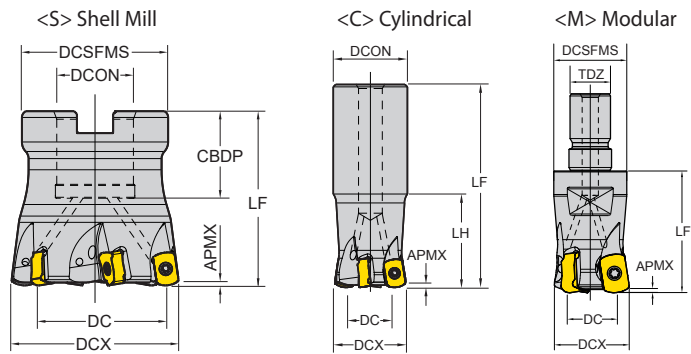
Grades

Grade	ENMX 06	ENMX 09	Application	ISO Range
YG602	•	•	Multi-Purpose Grade	P20 - P35 M20 - M40 K20 - K40 S15 - S25
YG712	•	•	Carbon or Alloyed Steel	P10 - P30
YG613	•	•	Stainless Steel	P30 - P50 M30 - M40

Ap / Fz Information by cutter length. (Alloy Steel)



YG HF4 Mill - Milling Cutter (Metric)

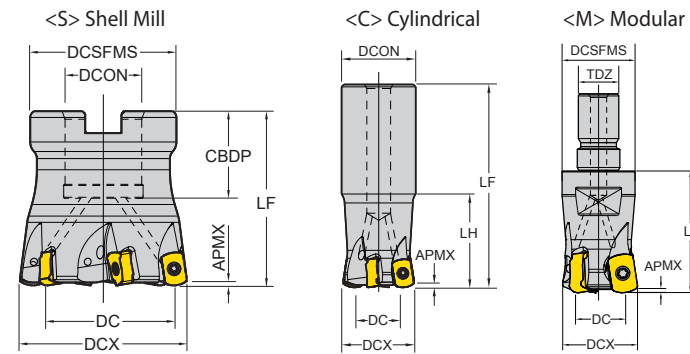


Series	Series	EDP 1800..	Designation
ENMX 0604	Wrench	0218	TPWBTP08
	Screw	0206	TP082507-GS
	Handle	0189	DH-H4
	Bit	0190	DB-TP08
ENMX 0905	Wrench	0216	TPWBTP09
	Screw	0214	TP093510-GS
	Handle	0189	DH-H4
	Bit	0209	DB-TP09

Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	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	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	EHF-ENMX06-D25Z4C25-L140	0647	17.6	25	4	140	Cylindrical	25	60	-	-	●
		EHF-ENMX06-D25Z4C25-L180	0464	17.6	25	4	180		25	80	-	-	●
		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	EHF-ENMX06-D26Z4C25-L200	0480	18.6	26	4	200	Cylindrical	25	30	-	-	●
		EHF-ENMX06-D32Z5C32-L150	0649	24.6	32	5	150		32	70	-	-	●
		EHF-ENMX06-D32Z5C32-L200	0465	24.6	32	5	200		32	100	-	-	●
	0.9	FHF-ENMX06-D40Z6S16	0482	32.6	40	6	40	Shell Mill	16	-	18	37	●
		FHF-ENMX06-D50Z6S22	0471	42.6	50	6	50		22	-	25	42	●
		MHF-ENMX06-D16Z2M08	0691	9.0	16	2	23	Modular	M08	-	-	13	●
		MHF-ENMX06-D18Z2M08	0730	11.0	18	2	23		M08	-	-	13	●
	1	MHF-ENMX06-D20Z3M10	0692	12.6	20	3	30	Modular	M10	-	-	18	●
		MHF-ENMX06-D25Z4M12	0693	17.6	25	4	35		M12	-	-	21	●
		MHF-ENMX06-D32Z5M16	0694	24.6	32	5	42		M16	-	-	29	●
		MHF-ENMX06-D35Z5M16	0695	27.6	35	5	42		M16	-	-	29	●
ENMX 0905	1.5	MHF-ENMX06-D40Z6M16	0732	32.6	40	6	42	Modular	M16	-	-	29	●
		MHF-ENMX06-D42Z6M16	0696	34.6	42	6	42		M16	-	-	29	●
	1.5	EHF-ENMX09-D25Z2C25-L150	0745	14.5	25	2	150	Cylindrical	25	70	-	-	●
		EHF-ENMX09-D26Z2C25-L200	0746	15.74	26	2	200		25	30	-	-	●
		EHF-ENMX09-D26Z3C25-L200	0747	15.74	26	3	200		25	30	-	-	●
		EHF-ENMX09-D32Z3C32-L160	0748	21.1	32	3	160		32	70	-	-	●
	1.5	EHF-ENMX09-D33Z3C32-L200	0749	22.26	33	3	200	Cylindrical	32	30	-	-	●
		EHF-ENMX09-D33Z4C32-L200	0750	22.26	33	4	200		32	40	-	-	●
		EHF-ENMX09-D40Z5C32-L180	0751	29.11	40	5	180		32	40	-	-	●
		FHF-ENMX09-D50Z5S22	0752	38.39	50	5	50	Shell Mill	22	-	20	42	●
	1.5	FHF-ENMX09-D63Z6S22	0753	51.28	63	6	50		22	-	20	48	●
		FHF-ENMX09-D63Z7S22	0754	51.28	63	7	50		22	-	20	48	●
		FHF-ENMX09-D80Z8S27	0755	67.4	80	8	50		27	-	23	56	●
	1.5	FHF-ENMX09-D100Z10S32	0824	86.74	100	10	63	Shell Mill	32	-	26	78	●
		FHF-ENMX09-D125Z12S40	0825	110.94	125	12	63		40	-	29	89	●
		MHF-ENMX09-D25Z2M12	0811	14.5	25	2	35	Modular	M12	35	-	21	●
		MHF-ENMX09-D25Z3M12	0812	14.5	25	3	35		M12	35	-	21	●
	1.5	MHF-ENMX09-D26Z2M12	0813	15.74	26	2	35		M12	35	-	21	●
		MHF-ENMX09-D26Z3M12	0814	15.74	26	3	35		M12	35	-	21	●
	1.5	MHF-ENMX09-D32Z3M16	0815	21.1	32	3	42	Modular	M16	42	-	29	●
		MHF-ENMX09-D32Z4M16	0816	21.1	32	4	42		M16	42	-	29	●
		MHF-ENMX09-D33Z2M16	0817	22.26	33	2	42		M16	42	-	29	●
		MHF-ENMX09-D33Z3M16	0818	22.26	33	3	42		M16	42	-	29	●
	1.5	MHF-ENMX09-D33Z4M16	0819	22.26	33	4	42	Modular	M16	42	-	29	●

YG HF4 Mill - Milling Cutter (Inch)



Series	Series	EDP 1800..	Designation
ENMX 0604	Wrench	0218	TPWBTP08
	Screw	0206	TP082507-GS
	Handle	0189	DH-H4
	Bit	0190	DB-TP08
ENMX 0905	Wrench	0216	TPWBTP09
	Screw	0214	TP093510-GS
	Handle	0189	DH-H4
	Bit	0209	DB-TP09

Unit : inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	
ENMX 0604	.035	EHF-ENMX06-D06Z2Z2W0625-L500i	0759	.310	.625	2	5.000	Cylindrical	.625	1.250	-	-	●
		EHF-ENMX06-D07Z3Z3W075-L500i	0669	.460	.750	2	5.000		.750	2.000	-	-	●
		EHF-ENMX06-D100Z4W100-L550i	0670	.710	1.000	4	5.500		1.000	2.500	-	-	●
		EHF-ENMX06-D125Z5W125-L600i	0671	.960	1.250	5	6.000		1.250	3.000	-	-	●
	.039	FHF-ENMX06-D150Z6S050i	0672	1.210	1.500	6	1.575	Shell Mill	.500	-	.750	1.340	●
		FHF-ENMX06-D200Z6S075i	0673	1.710	2.000	6	1.969		.750	-	.750	1.570	●
		FHF-ENMX06-D300Z10S100i	0760	2.710	3.000	10	2.480		1.000	-	1.024	2.835	●
	.035	MHF-ENMX06-D06Z2Z2M08i	0761	.310	.625	2	1.000	Modular	M08	-	-	.512	●
		MHF-ENMX06-D070Z2Z2M08i	0762	.410	.705	2	1.000		M08	-	-	.512	●
		MHF-ENMX06-D075Z3M10i	0763	.460	.750	3	1.250		M10	-	-	.709	●
		MHF-ENMX06-D083Z3M10i	0764	.540	.830	3	1.250		M10	-	-	.709	●
	.039	MHF-ENMX06-D100Z4M12i	0765	.710	1.000	4	1.500	Modular	M12	-	-	.827	●
		MHF-ENMX06-D112Z4M12i	0766	.830	1.125	4	1.500		M12	-	-	.827	●
		MHF-ENMX06-D125Z5M16i	0767	.960	1.250	5	1.750		M16	-	-	1.142	●
		MHF-ENMX06-D137Z5M16i	0768	1.080	1.375	5	1.750		M16	-	-	1.142	●
	.059	MHF-ENMX06-D150Z6M16i	0769	1.210	1.500	6	1.750	Modular	M16	-	-	1.142	●
		EHF-ENMX09-D100Z2W100-L550i	0777	0.61	1.0	2	5.5	Cylindrical	1.0	2.50	-	-	●
		EHF-ENMX09-D125Z3W125-L600i	0778	0.86	1.25	3	6.0		1.25	3.0	-	-	●
		EHF-ENMX09-D150Z4W125-L600i	0779	1.11	1.50	4	6.0		1.25	1.5	-	-	●
ENMX 0905	.059	FHF-ENMX09-D200Z5S075i	0780	1.6	2.0	5	1.969	Shell Mill	0.75	-	0.75	1.75	●
		FHF-ENMX09-D250Z6S075i	0781	2.1	2.5	6	1.969		0.75	-	0.75	2.2	●
		FHF-ENMX09-D300Z8S100i	0782	2.6	3.0	8	2.48		1.0	-	1.05	2.2	●
		FHF-ENMX09-D400Z10S125i	0783	3.6	4.0	10	2.48		1.25	-	1.26	3	●
	.059	FHF-ENMX09-D600Z14S200i	0784	5.6	6.0	14	2.48	Shell Mill	2.0	-	1.5	4.7	●
		MHF-ENMX09-D100Z2M12i	0852	0.6	1.0	2	1.5		M12	1.5	-	0.827	●
		MHF-ENMX09-D112Z2M12i	0853	0.73	1.125	2	1.5		M12	1.5	-	0.827	●
		MHF-ENMX09-D125Z3M16i	0854	0.82	1.25	3	1.75		M16	1.75	-	1.142	●
	.059	MHF-ENMX09-D137Z3M16i	0855	0.98	1.375	3	1.75	Modular	M16	1.75	-	1.142	●
		MHF-ENMX09-D150Z4M16i	0856	1.11	1.5	4	1.75		M16	1.75	-	1.142	●

YG HF4 Mill - Milling Inserts - ENMX06/09 (Metric / Inch)

		Series	IC	S
		ENMX 0604	6.3	4.21
		ENMX 0905	9.0	5.40

EDP 1200..

●: Stock item

		P25	P20	P40
		M30		M40
		K30		
		S20		

ENMX	Designation	Fz (mm/tooth)	Fz (inch/tooth)	YG602	YG712	YG613
ENMX General	ENMX 0604	0.3 ~ 2.0	.012~.079	● 0474		● 0606
	ENMX 0905	0.3 ~ 2.5	.012~.059	● 0702		● 0703
- ST Stainless Steel	ENMX 0604-ST	0.1 ~ 0.8	.004~.031	● 0623		● 0625
	ENMX 0905-ST	0.2 ~ 1.2	.012~.047	● 0705		● 0706
- TR Hardened Steel	ENMX 0604-TR	0.3 ~ 2.5	.012~.098	● 0459	● 0504	
	ENMX 0905-TR	0.3 ~ 3.0	.012~.079	● 0600		

YG HF4 Mill - Technical Information (Metric)

ENMX 0604

		Unit:mm	
RP	UTCN	Overcut	
Programmed Corner R	Uncut Thickness		
R2.0	0.31	0.00	
R2.5	0.18	0.18	
R3.0	0.07	0.36	

DCX	APMX	APMXR	RMPX	RP	UTCN	Diameter	Diameter	Pitch	Ae
External Cutter Diameter	Maximum Depth of Cut	Maximum Radial Depth of Cut	Maximum Ramping Angle(°)	Programmed Corner Radius	Uncut Thickness	Minimum Cutting Diameter	Maximum Cutting Diameter	Helical Interpolation Pitch	Enlarge Width
16	0.9	3.5	3.5°	R2.0	0.3	21	30	0.9	12
20	1	3.7	1.8°	R2.0	0.31	29	38	1	16
25	1	3.7	1.2°	R2.0	0.31	39	48	1	21
32	1	3.7	0.8°	R2.0	0.31	53	62	1	28
40	1	3.7	0.6°	R2.0	0.31	69	78	1	36
50	1	3.7	0.5°	R2.0	0.31	89	98	1	46

ENMX 0905

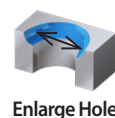
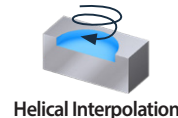
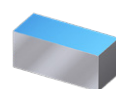
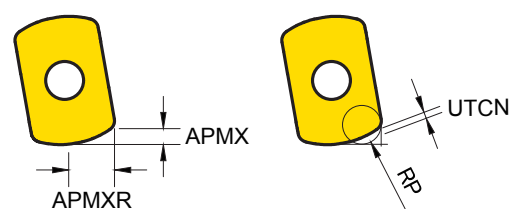
		Unit:mm	
RP	UTCN	Overcut	
Programmed Corner R	Uncut Thickness		
R2.5	0.56	0.00	
R3.0	0.40	0.10	
R3.5	0.24	0.25	
R4.0	0.10	0.41	
R4.5	0	0.49	

DCX	APMX	APMXR	RMPX	RP	UTCN	Diameter	Diameter	Pitch	Ae
External Cutter Diameter	Maximum Depth of Cut	Maximum Radial Depth of Cut	Maximum Ramping Angle(°)	Programmed Corner Radius	Uncut Thickness	Minimum Cutting Diameter	Maximum Cutting Diameter	Helical Interpolation Pitch	Enlarge Width
25	1.5	4.7	3.8°	2.5	0.56	42	48	1.5	20
26	1.5	4.7	3.5°	2.5	0.56	44	50	1.5	21
32	1.5	4.7	2.4°	2.5	0.56	56	62	1.5	27
33	1.5	4.7	2.2°	2.5	0.56	58	64	1.5	28
40	1.5	4.7	1.6°	2.5	0.56	72	78	1.5	35
50	1.5	4.7	1.1°	2.5	0.56	92	98	1.5	45
63	1.5	4.7	0.8°	2.5	0.56	118	124	1.5	57
80	1.5	4.7	0.6°	2.5	0.56	152	158	1.5	74
100	1.5	4.7	0.5°	R2.5	0.56	192	198	1.5	57
125	1.5	4.7	0.4°	R2.5	0.56	242	248	1.5	74

Cutting Speed			Vc (m/min.)						Vc (ft/min)					
ISO	VDI	Sub Group	YG602		YG712		YG613		YG602		YG712		YG613	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	280	220	320	100	210	590	1250	560	980	330	690
	6~9	Low-Alloyed Steel	150	250	190	290	70	180	390	980	590	820	230	590
	10~11	High-Alloyed Steel	70	140	90	155	40	90	230	490	330	460	130	290
M	12~13	Ferritic & Martensitic	120	200	-	-	70	180	390	660	-	-	230	590
	14	Austenitic Stainless Steel	130	250	-	-	70	200	430	820	-	-	230	660
K	15~16	Grey Cast Iron	120	250	-	-	-	-	390	820	-	-	-	-
	17~18	Nodular Cast Iron	130	220	-	-	-	-	430	720	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	80	150	-	-	-	-
H	38~41	Hard Materials	40	80	-	-	-	-	130	260	-	-	-	-

YG HF4 Mill - Technical Information (Inch)

ENMX 0604

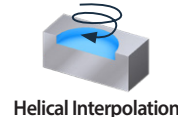
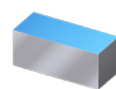
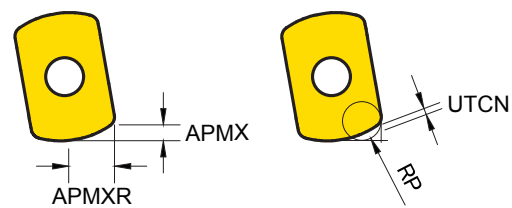


Unit: inch

RP Programmed Corner R	UTCN Uncut Thickness	Overcut
.079	.012	.000
.098	.007	.007
.118	.003	.014

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
.625	.035	.137	3.4°	R.079	.011	.817	1.171	.035	.487
.750	.039	.145	2.0°	R.079	.012	1.067	1.421	.039	.612
1.00	.039	.145	1.2°	R.079	.012	1.567	1.921	.039	.862
1.25	.039	.145	0.9°	R.079	.012	2.067	2.421	.039	1.112
1.50	.039	.145	0.7°	R.079	.012	2.567	2.921	.039	1.362
2.00	.039	.145	0.5°	R.079	.012	3.567	3.921	.039	1.862
3.00	.039	.145	0.3°	R.079	.012	5.567	5.922	.039	2.862

ENMX 0905



Unit: inch

RP Programmed Corner R	UTCN Uncut Thickness	Overcut
.098	.022	.000
.118	.015	.004
.137	.009	.001
.157	.004	.016
.177	.000	.019

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
1.0	.059	.185	3.8°	R.098	.022	1.685	1.921	.059	.803
1.25	.059	.185	2.4°	R.098	.022	2.185	2.421	.059	1.053
1.5	.059	.185	1.7°	R.098	.022	2.685	2.921	.059	1.303
2.0	.059	.185	1.1°	R.098	.022	3.685	3.921	.059	1.803
2.5	.059	.185	0.8°	R.098	.022	4.685	4.921	.059	2.303
3.0	.059	.185	0.7°	R.098	.022	5.685	5.921	.059	2.803
4.0	.059	.185	0.4°	R.098	.022	7.685	7.921	.059	3.803
6.0	.059	.185	0.3°	R.098	.022	11.685	11.921	.059	5.803

YG HF4 Mill - ENMX06 - Success Story

P Carbon Steel 1.1121
JIS S10C DIN Ck10 AISI 1010

	YG	Competitor A
Designation	ENMX 0604	High Feed
Chip breaker	TR	General
Grade	YG602	P Grade
Cutter Dia	16 mm	16 mm
ZEFP (Effective number of edge)	2	2
Vc (Cutting Speed)	100 m/min (328.08 ft/min)	90 m/min (295.27 ft/min)
Fz (Feed per tooth)	0.58 mm/tooth (.022 in/tooth)	0.42 mm/tooth (.016 in/tooth)
Ap (Depth of Cut)	0.5 mm (.019 in)	0.2 mm (.007 in)
Tool Life	32 pcs +166% Tool Life	12 pcs

↑ 166%
Tool Life

32 pcs

YG
ENMX



12 pcs
Competitor A
High Feed

P Carbon Steel 1.0503
JIS S45C DIN C45 AISI 1045

	YG	Competitor B
Designation	ENMX 0604	High Feed
Chip breaker	TR	General
Grade	YG602	P Grade
Cutter Dia	20 mm	20 mm
ZEFP (Effective number of edge)	3	3
Vc (Cutting Speed)	188 m/min (616.79 ft/min)	157 m/min (515.09 ft/min)
Fz (Feed per tooth)	1.5 mm/tooth (.059 in/tooth)	0.8 mm/tooth (.031 in/tooth)
Ap (Depth of Cut)	0.5 mm (.019 in)	
Tool Life	3 pcs +200% Tool Life	1 pc

↑ 200%
Tool Life

3 pcs

YG
ENMX



1 pc
Competitor B
High Feed

YG HF4 Mill - ENMX06 - Success Story

P Tool Steel 1.6565
JIS SNCM447 DIN 40NiCrMo6 AISI 4340

	YG	Competitor C
Designation	ENMX 0604	High Feed
Chip breaker	TR	General
Grade	YG602	P Grade
Cutter Dia	25 mm	20 mm
ZEFP (Effective number of edge)	4	4
Vc (Cutting Speed)	150 m/min (492.13 ft/min)	
Fz (Feed per tooth)	0.39 mm/tooth (.015 in/tooth)	
Ap (Depth of Cut)	0.5 mm (.019 in)	
Tool Life	20 pcs +100% Tool Life	10 pcs

↑
100%
Tool Life

20 pcs

YG
ENMX



10 pcs
Competitor C
High Feed

YG HF4 Mill - ENMX09 - Success Story

P Tool Steel 1.2344
JIS SKD61 DIN X40CrMoV5-1 AISI H13

	YG	Competitor E
Designation	ENMX0905-TR	High Feed
Chip breaker	TR	General
Grade	YG602	P Grade
Cutter Dia	25 mm	25mm
ZEFP (Effective number of edge)	2	2
Vc (Cutting Speed)	220 m/min (719 ft/min)	
Vf (Feed per Minute / Table Feed)	2164 mm/min (85.19 in/min)	
Ap (Depth of Cut)	0.5 mm (0.02 in)	
Tool Life	4 Hours	2.5 Hours

↑
62.5%
Tool Life

4 Hours

YG
ENMX



2.5 Hours
Competitor E
High Feed

P Alloy Steel 1.6565
JIS SNCM447 DIN 40NiCrMo6 AISI 4340

	YG	Competitor D
Designation	ENMX 0604	High Feed
Chip breaker	GN	General
Grade	YG602	P Grade
Cutter Dia	20 mm	20 mm
ZEFP (Effective number of edge)	3	3
Vc (Cutting Speed)	180 m/min (590.55 ft/min)	
Fz (Feed per tooth)	0.66 mm/tooth (.025 in/tooth)	
Ap (Depth of Cut)	0.5 mm (.019 in)	
Tool Life	7 pcs +75% Tool Life	4 pcs

↑
75%
Tool Life

7 pcs

YG
ENMX



4 pcs
Competitor D
High Feed

P Tool Steel 1.2344
JIS SKD61 DIN X40CrMoV5-1 AISI H13

	YG	Competitor F
Designation	ENMX0905-TR	High Feed
Chip breaker	TR	General
Grade	YG622	P Grade
Cutter Dia	25 mm	25mm
ZEFP (Effective number of edge)	2	3
Vc (Cutting Speed)	157 m/min (513 ft/min)	196 m/min (641 ft/min)
Vf (Feed per Minute / Table Feed)	4500 mm/min (177.16 in/min)	3600 mm/min (141.73 in/min)
Ap (Depth of Cut)	0.5 mm (0.02 in)	0.3 mm (0.011 in)
Tool Life	4 Hours	2.5 Hours

↑
62.5%
Tool Life

4 Hours

YG
ENMX



2.5 Hours
Competitor E
High Feed



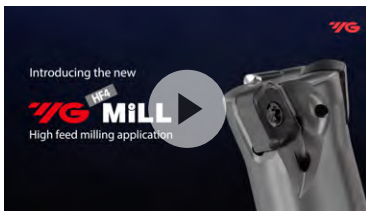
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