

YU-VP15

BEST VALUE IN THE WORLD OF CUTTING TOOLS



V7 Plus *A*

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

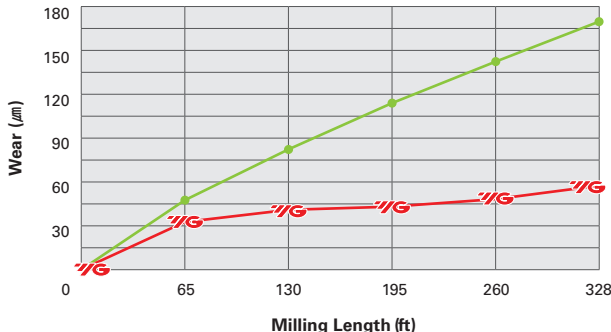


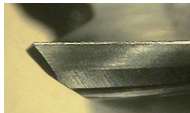
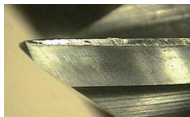
MADE IN
USA ★

YG YG-1 CO., LTD.

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

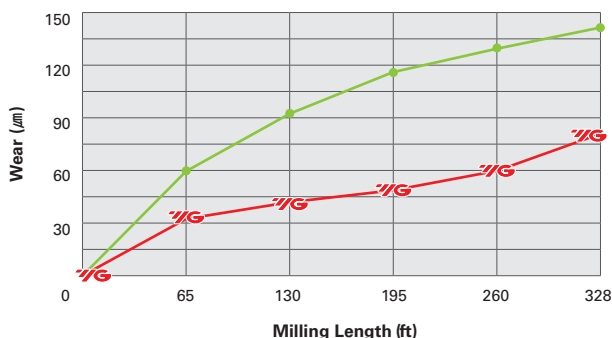
Test - I		V7 Plus A > Competitor		V7 PLUS A Competitor	
List	Tool	V7 Plus A	Competitor		
Wear(μm)		56.26	168.943		
Size		Ø6 x Ø6 x 12 x 50	Ø6 x Ø6 x 15 x 50		
Milling Length		328 ft			
Work Material		- JIS: SKD61 (HRc 30) - AISI: H31 - DIN: X40CrMoV51 (1.2344)			
Cutting Speed		293 ft/min			
RPM		4,750rev/min			
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			

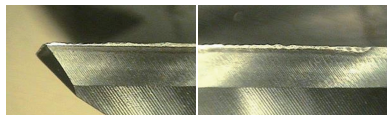
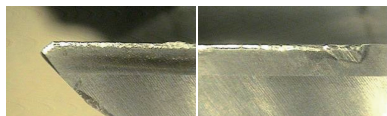
Comparison of the Cutting Edges	
V7 Plus A	 
Competitor	 

◎: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!

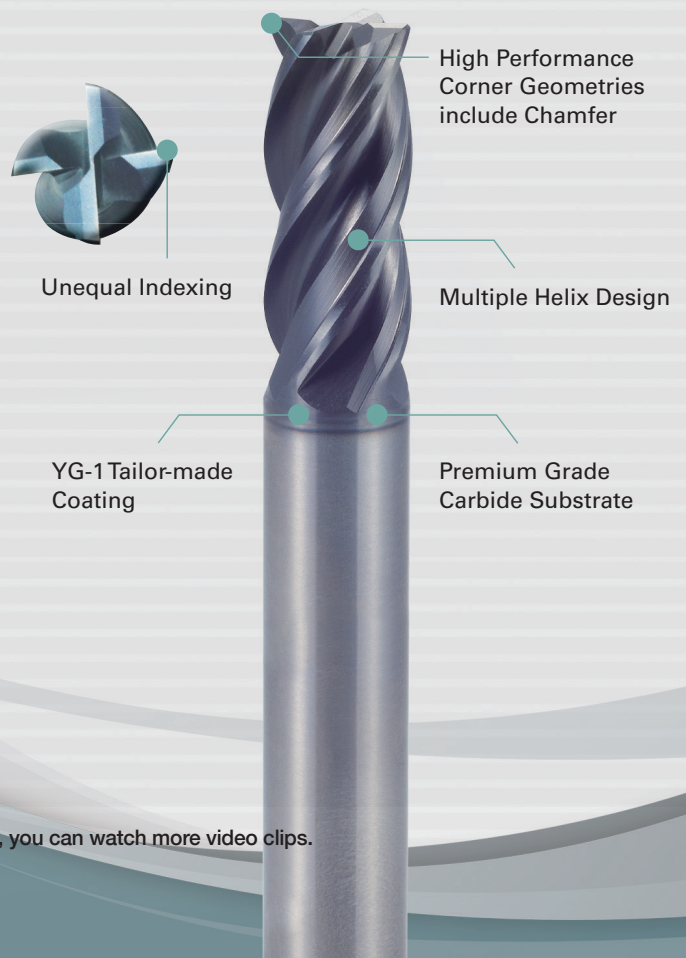
The **V7 Plus^A** for Stainless Steels, Mild Steels, Cast Iron, Low/Medium hardness materials under HRc40 has a unique design that maximizes chip removal and improves productivity in slotting and heavy profiling operations. The **V7 Plus^A** advanced geometry reduces chatter for increased tool life and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



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					
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.010	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	-	R.010		5/16	13/16	2-1/2
UGMF70911	-	R.030		5/16	13/16	2-1/2
UGMF70912	-	R.060	3/8	5/16	13/16	2-1/2
UGMF70024	UGMF71024	R.010		3/8	1/2	2-1/2
UGMF70913	UGMF71913	R.030		3/8	1/2	2-1/2
UGMF70914	UGMF71914	R.060	3/8	3/8	1/2	2-1/2
UGMF70915	UGMF71915	R.010		3/8	7/8	2-1/2
UGMF70916	UGMF71916	R.030		3/8	7/8	2-1/2
UGMF70917	UGMF71917	R.060	7/16	3/8	7/8	2-1/2
UGMF70028	UGMF71028	R.015		7/16	5/8	2-1/2
UGMF70918	UGMF71918	R.030		7/16	5/8	2-1/2
UGMF70919	UGMF71919	R.010	1/2	7/16	1	2-3/4
UGMF70920	UGMF71920	R.030		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~-.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
USA**



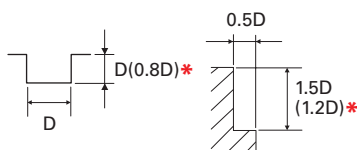
P.11~12

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

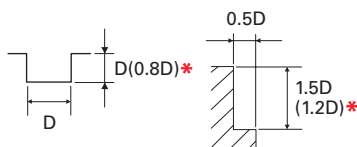
Unit : inch

EDP No.		MILL DIAMETER	SHANK DIAMETER	LENGTH OF CUT	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

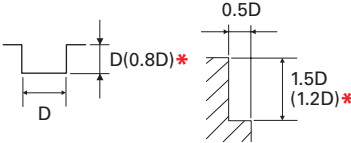
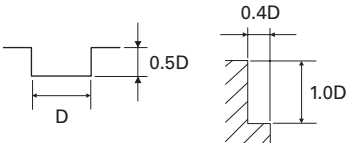
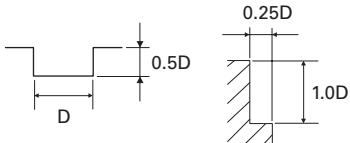
MATERIAL	P											
	CARBON STEELS				ALLOY STEELS				TOOL STEELS			
	10**, 11**, 12**, 12L**, 15**				41**, 43**, 51**, 86**				A2, D2, H13, P20, T15			
HARDNESS	~ HB 300				HB 300 ~ HB 380				~ HB 380			
STRENGTH	~ 1000N/mm ²				1000N/mm ² ~ 1300N/mm ²				~ 1300N/mm ²			
DIAMETER	RPM	FEED	SFM	Fz	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

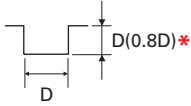
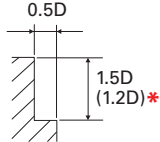


MATERIAL	K				M							
	CAST IRON				STAINLESS STEELS 300				STAINLESS STEELS 400			
	Gray, Malleable, Ductile				304, 316, 304L, 316LSUS316				416, 420F, 430F, 440F			
HARDNESS	~ HB 260											
STRENGTH	~ 870N/mm ²											
DIAMETER	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz
1/8	11880	11.8	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



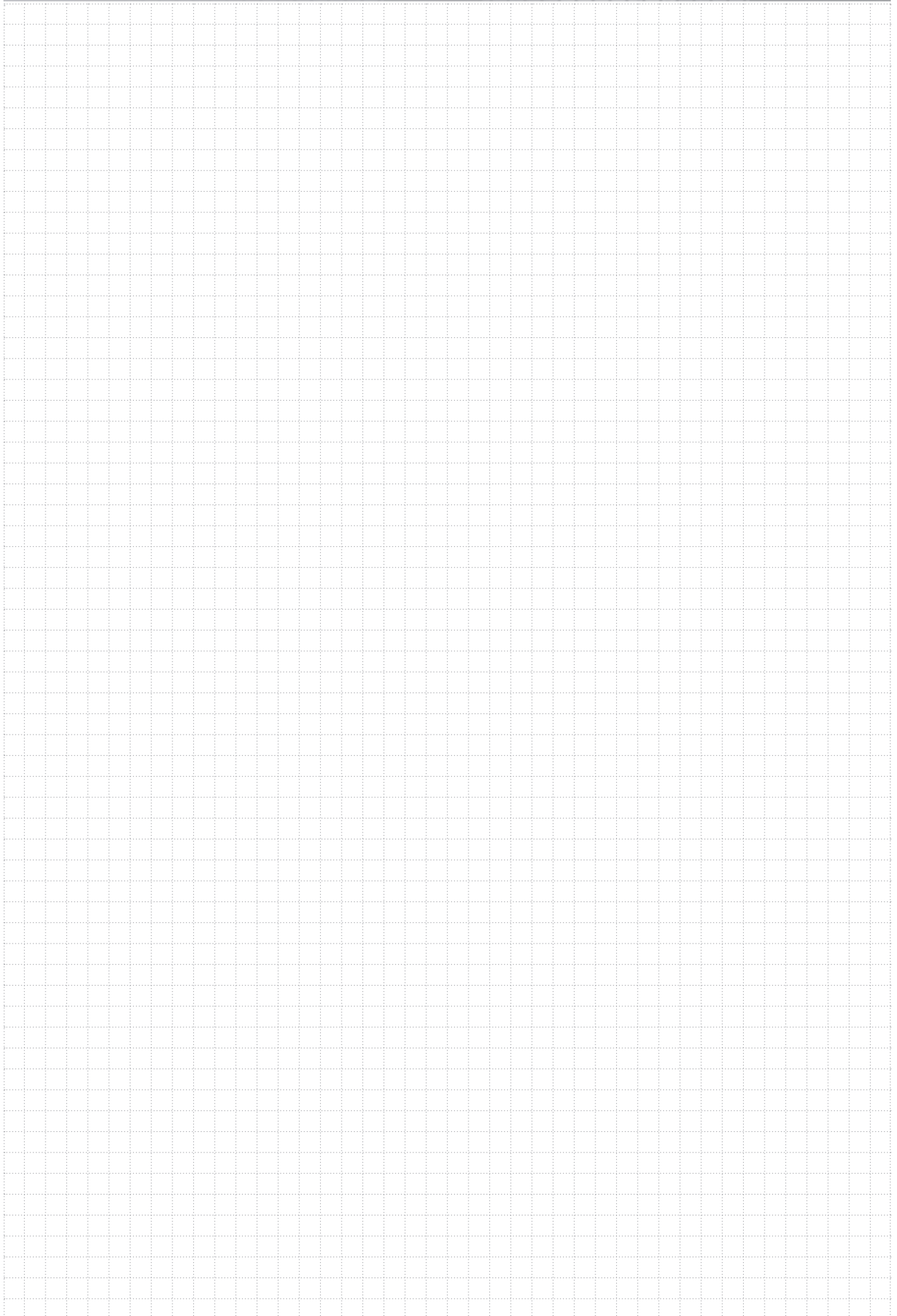
MATERIAL	M				S							
	STAINLESS STEELS (PH)				TITANIUM				HIGH TEMPERATURE ALLOY			
	17-4PH, 15-5PH, 13-8PH				Ti6Al4V, Ti5Al5V5Mo, Ti7Al4Mo				INCONEL, HASTELLOY, RENE			
HARDNESS												
STRENGTH												
DIAMETER	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz	RPM	FEED	SFM	Fz
1/8	10085	7.3	312	.0002	6165	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

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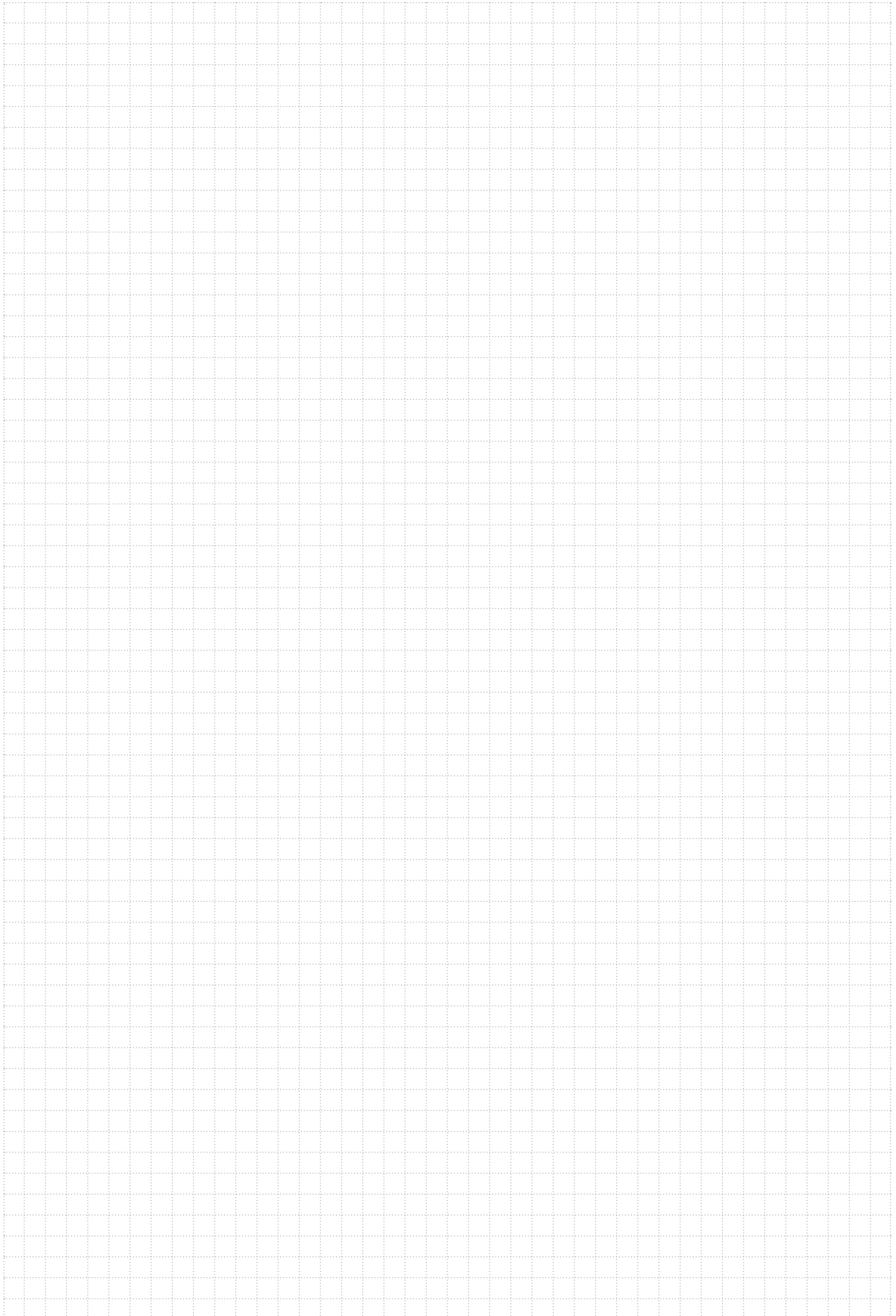
* Axial cutting depth			
Length of Cut	<1.5D	0.8D	1.2D
	≥1.5D	D	1.5D

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

MEMO



MEMO



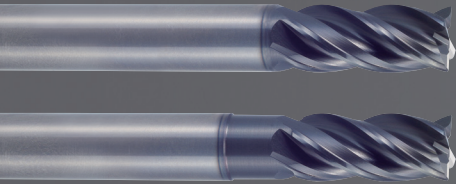
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Since 1982, our commitment to quality, reliability and striving for constant innovation has allowed us to expand our market share and our partners' global network. As one of the main leading tool manufacturers, we are dedicated in offering a unique customer experience by delivering high quality cutting tool solutions around the world. In order to be responsive and to offer local solutions, YG-1 has established a global network of over 75 countries and has set up international logistic centers. This is our pledge to provide the best service in order to satisfy our customers' needs at all time.



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 YG-1 TOOL(U.S.A) PHONE : +1 800 765 8665 FAX : +1 866 941 8665 E-mail : heatherlee@yg1usa.com	 YG-1 HONG KONG LTD.(HONG KONG) PHONE : +852 2439 9018 FAX : +852 2439 9020 E-mail : enquiry@yghk.com.hk	 YG-1 VIETNAM CO., LTD. PHONE : +84 4 3795 7233 FAX : +84 4 3795 7232 E-mail : yg1vietnam@yg1.co.kr
 REGAL CUTTING TOOLS INC.(U.S.A) PHONE : +1 815 389 3461 FAX : +1 815 389 9858 E-mail : customerservice@regalcuttingtools.com	 YG CUTTING TOOL CORP. PVT. LTD.(INDIA) PHONE : +91 80 4354 3600 FAX : +91 80 4354 3613 E-mail : marketing@yg1india.com	 YG-1 AUSTRALIA PTY. LTD.(AUSTRALIA) PHONE : +61 3 9558 0177 FAX : +61 3 9558 2778 E-mail : ygone@yg1.kr
 YG-1 LATIN AMERICA(BRAZIL) PHONE : +55 11 4496 2170 FAX : +55 11 4591 1438 E-mail : walter.campos@yg1.com.br	 YG-1 INDUSTRIES INDIA PVT.LTD.(INDIA) PHONE : +91 22 2580 6241 FAX : +91 22 2580 3576 E-mail : thanesales@yg1india.com	 YG-1 EUROPE(FRANCE) PHONE : +33 172 84 4070 FAX : +33 172 84 4086 E-mail : yg1@yg1.eu
 YG-1 CANADA INC.(CANADA) PHONE : +1 905 335 2500 FAX : +1 905 335 4003 E-mail : reception@yg1.ca	 PT.YGI TOOLS (INDONESIA) PHONE : +62 21 4585 8141 FAX : +62 21 4587 7412 E-mail : yg1tools@gmail.com	 YG-1 DEUTSCHLAND GmbH(GERMANY) PHONE : +49 6173 9667 0 FAX : +49 6173 9667 29 E-mail : info@yg-1.de
 MINICUT INTERNATIONAL INC.(CANADA) PHONE : +1 514-352-6464 FAX : +1 514-352-6644 E-mail : international@minicut.com	 YG-1 JAPAN CO., LTD.(JAPAN) PHONE : +81 6 6305 9897 FAX : +81 6 6305 9898 E-mail : toyokazu-kitaoka@yg1.jp	 YG-1 POLAND Sp. z o.o.(POLAND) PHONE : +48 22 622 2586 FAX : +48 22 622 2587 E-mail : info@yg-1.pl
 YG-1 TOOLS MEXICO SA DE CV(MEXICO) PHONE : +52 55 5576 8798 FAX : +52 55 5576 8790 E-mail : khmin@yg1.kr	 NEW SANKYO CUTTING TOOLS(JAPAN) PHONE : +81 87 876 1155 FAX : +81 87 876 3461 E-mail : newsankyo@newsankyo-tool.co.jp	 YG-1 CO., TRADING SRL(ROMANIA) PHONE : +40 21 25 25 501~3 FAX : +40 21 25 25 506 E-mail : kimromko@yg1.kr
 NEW CENTURY TOOL CO., LTD.(CHINA) PHONE : +86 532 8676 9779 FAX : +86 532 8676 9105 E-mail : qnct@qnct.cn	 YG-1 MALAYSIA SDN. BHD.(MALAYSIA) PHONE : +603 5569 4834 FAX : +603 5569 4814 E-mail : enquiries@yg-1.com.my	 TEKNO TAKIM San. Tic. AS.(TURKEY) PHONE : +90 212 671 1590 FAX : +90 212 671 1595 E-mail : info@teknotakim.com
 QINGDAO YG-1 TOOL CO.,LTD.(CHINA) PHONE : +86 532 8519 7366 FAX : +86 532 8519 7959 E-mail : qyg1@qyg1.com	 YG-1 TOOLS ASIA PTE. LTD.(SINGAPORE) PHONE : +65 6842 0468 FAX : +65 6842 0482 E-mail : ctang@yg1.kr	
 YG-1 SHANGHAI CO.,LTD.(CHINA) PHONE : +86 21 6383 1661 FAX : +86 21 6383 1771 E-mail : enquiry@yg-1china.com	 YG-1 THAILAND CO., LTD.(THAILAND) PHONE : +662 732 0186~7 FAX : +662 732 0188 E-mail : info@yg1.co.th	



YG-1 CO., LTD.

YG-1 Korea

211, Sewolcheon-ro, Bupyeong-gu, Incheon, Korea

PHONE: +82-32-526-0909, FAX: +82-32-526-4373

<http://www.yg1.kr>

E-mail: yg1@yg1.kr

YG-1 USA

730 Corporate Woods Parkway Vernon Hills, IL 60061 U.S.A

PHONE: 800-765-8665, FAX: 866-941-8665

Technical Assistance: 888-868-5988

<http://www.yg1usa.com>

Tool specifications are subject to change without prior notice.