

2 FLUTE CORNER RADIUS

SEMD99 Series

CUTTING DATA

Slotting

MATERIAL	NON-ALLOYED STEELS & ALLOY STEELS				ALLOY & HEAT RESISTANT STEELS				HARDENED STEELS			
	CAST IRON				STAINLESS STEELS							
Hardness	~ HRc 35				HRc 35 ~ HRc 45				HRc 45 ~ HRc 55			
Strength	~ 1100N/mm ²				1110 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
0.2	44000	145	28	0.002	28800	60	18	0.001	17600	40	11	0.001
0.3	41000	170	39	0.002	27000	70	25	0.001	16500	45	16	0.001
0.4	41000	170	52	0.002	27000	70	34	0.001	16500	45	21	0.001
0.5	36000	190	57	0.003	23400	80	37	0.002	14300	50	22	0.002
0.6	30000	210	57	0.004	19800	90	37	0.002	12100	55	23	0.002
0.7	30000	210	66	0.004	19800	90	44	0.002	12100	55	27	0.002
0.8	30000	210	75	0.004	19800	90	50	0.002	12100	55	30	0.002
0.9	30000	225	85	0.004	18900	90	53	0.002	11550	55	33	0.002
1	27600	240	87	0.004	18000	100	57	0.003	11000	60	35	0.003
1.2	24800	245	93	0.005	15750	105	59	0.003	9750	60	37	0.003
1.5	22000	250	104	0.006	13500	110	64	0.004	8500	60	40	0.004
2	18000	260	113	0.007	11560	120	73	0.005	7200	70	45	0.005
2.5	15000	270	118	0.009	9500	130	75	0.007	6100	70	48	0.006
3	13240	280	125	0.011	8560	140	81	0.008	5280	70	50	0.007
3.5	11980	310	132	0.013	7690	155	85	0.010	4790	75	53	0.008
4	10720	340	135	0.016	6820	170	86	0.012	4300	80	54	0.009
4.5	9940	380	141	0.019	6310	185	89	0.015	4300	90	61	0.010
5	9160	420	144	0.023	5800	200	91	0.017	3800	100	60	0.013
5.5	8530	460	147	0.027	5420	225	94	0.021	3540	110	61	0.016
6	7900	500	149	0.032	5040	250	95	0.025	3280	120	62	0.018
7	6950	520	153	0.037	4420	250	97	0.028	2900	120	64	0.021
8	6000	540	151	0.045	3800	250	96	0.033	2520	120	63	0.024
10	5040	540	158	0.054	3280	250	103	0.038	2020	120	63	0.030
11	4580	480	158	0.052	3030	240	105	0.040	1850	110	64	0.030
12	4120	420	155	0.051	2780	230	105	0.041	1680	100	63	0.030
14	3610	390	159	0.054	2440	200	107	0.041	1480	90	65	0.030
16	3100	360	156	0.058	2100	170	106	0.040	1280	80	64	0.031
20	2520	280	158	0.056	1640	120	103	0.037	1000	60	63	0.030

RPM: revolutions per minute Feed: mm per minute Vc: surface speed (metres per minute) Fz: feed per tooth

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