

2 FLUTE

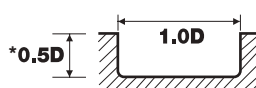
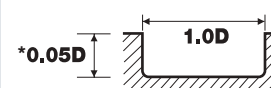
SEME35 Series

CUTTING DATA

Slotting

RANGE
INDEX

MATERIAL	NON-ALLOYED STEELS & ALLOY STEELS				ALLOY STEELS & HEAT RESISTANT STEELS				STAINLESS STEELS				HARDENED STEELS			
	CAST IRON															
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	RPM	Feed	Vc	Fz
0.1	42000	75	13	0.001	25200	45	8	0.001	21000	38	7	0.001	16800	15	5	0.000
0.2	42000	80	26	0.001	25200	48	16	0.001	21000	37	13	0.001	16800	16	11	0.000
0.3	39000	85	37	0.001	23400	51	22	0.001	19500	43	18	0.001	15600	17	15	0.001
0.4	39000	90	49	0.001	23400	54	29	0.001	19500	45	25	0.001	15600	18	20	0.001
0.5	36000	105	57	0.001	21600	63	34	0.001	18000	52	28	0.001	14400	21	23	0.001
0.6	32000	120	60	0.002	19200	72	36	0.002	16000	60	30	0.002	12800	24	24	0.001
0.7	28000	135	62	0.002	16800	81	37	0.002	14000	67	31	0.002	11200	27	25	0.001
0.8	25000	150	63	0.003	15000	90	38	0.003	12500	75	31	0.003	10000	30	25	0.002
0.9	23500	155	66	0.003	14100	93	40	0.003	11750	77	33	0.003	9400	31	27	0.002
1	21500	160	68	0.004	12900	96	41	0.004	10750	80	34	0.004	8600	32	27	0.002
1.2	18000	165	68	0.005	10800	99	41	0.005	9000	82.5	34	0.005	7200	33	27	0.002
1.5	15000	170	71	0.006	9000	102	42	0.006	7500	85	35	0.006	6000	34	28	0.003
2	11560	190	73	0.008	7560	120	48	0.008	6300	90	40	0.007	5040	35	32	0.003
2.5	10240	200	80	0.010	6560	130	52	0.010	5460	105	43	0.010	4200	37	33	0.004
3	8920	210	84	0.012	5560	140	52	0.013	4620	120	44	0.013	3360	40	32	0.006
3.5	8240	255	91	0.015	5090	160	56	0.016	4250	135	47	0.016	3150	40	35	0.006
4	7560	300	95	0.020	4620	180	58	0.019	3880	150	49	0.019	2940	40	37	0.007
4.5	6930	310	98	0.022	4200	185	59	0.022	3520	155	50	0.022	2630	45	37	0.009
5	6300	320	99	0.025	3780	190	59	0.025	3160	160	50	0.025	2320	50	36	0.011
5.5	5930	335	102	0.028	3570	205	62	0.029	3000	170	52	0.028	2160	52	37	0.012
6	5560	350	105	0.031	3360	220	63	0.033	2840	180	54	0.032	2000	55	38	0.014
6.5	5220	355	107	0.034	3150	215	64	0.034	2655	180	54	0.034	1920	60	39	0.016
7	4880	365	107	0.037	2940	210	65	0.036	2470	180	54	0.036	1840	65	40	0.018
7.5	4540	370	107	0.041	2730	205	64	0.038	2285	180	54	0.039	1760	70	41	0.020
8	4200	380	106	0.045	2520	200	63	0.040	2100	180	53	0.043	1680	75	42	0.022
8.5	3965	365	106	0.046	2390	190	64	0.040	1995	175	53	0.044	1600	70	43	0.022
9	3730	355	105	0.048	2260	180	64	0.040	1890	170	53	0.045	1520	65	43	0.021
9.5	3495	340	104	0.049	2130	170	64	0.040	1785	165	53	0.046	1440	60	43	0.021
10	3260	330	102	0.051	2000	160	63	0.040	1680	160	53	0.048	1360	60	43	0.022
10.5	3130	315	103	0.050	1920	150	63	0.039	1600	150	53	0.047	1310	58	43	0.022
11	3000	305	104	0.051	1840	145	64	0.039	1520	145	53	0.048	1260	55	44	0.022
11.5	2870	290	104	0.051	1760	135	64	0.038	1440	135	52	0.047	1210	55	44	0.023
12	2740	280	103	0.051	1680	130	63	0.039	1360	130	51	0.048	1160	55	44	0.024
13	2605	265	106	0.051	1600	125	65	0.039	1285	125	52	0.049	1095	52	45	0.024
14	2470	250	109	0.051	1520	120	67	0.039	1210	120	53	0.050	1030	47	45	0.023
15	2335	235	110	0.050	1440	115	68	0.040	1135	115	53	0.051	965	43	45	0.022
16	2200	220	111	0.050	1360	110	68	0.040	1060	110	53	0.052	900	40	45	0.022
17	2070	205	111	0.050	1285	100	69	0.039	1005	100	54	0.050	845	37	45	0.022
18	1940	195	110	0.050	1210	95	68	0.039	950	95	54	0.050	790	35	45	0.022
19	1810	180	108	0.050	1135	85	68	0.037	895	85	53	0.047	735	32	44	0.022
20	1680	170	106	0.051	1060	80	67	0.038	840	80	53	0.048	680	30	43	0.022
21	1615	160	107	0.050	1015	78	67	0.038	800	76	53	0.048	650	28	43	0.022
22	1550	155	107	0.050	970	76	67	0.039	775	72	54	0.046	620	26	43	0.021
23	1480	145	107	0.049	925	74	67	0.040	745	68	54	0.046	600	24	43	0.020
24	1425	135	107	0.047	885	72	67	0.041	715	64	54	0.045	570	22	43	0.019
25	1360	130	107	0.048	840	70	66	0.042	680	60	53	0.044	540	20	42	0.019

*up to 1mm Diameter **0.15D**, up to 3mm Diameter **0.2D***up to 1mm Diameter **0.02D**

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

