

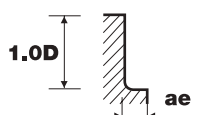
4 FLUTE CORNER RADIUS LONG NECK

SEME64 Series...

CUTTING DATA

Side Cutting

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.	LBS	RPM	Feed	Vc	Fz	ae	RPM	Feed	Vc	Fz	ae	RPM	Feed	Vc	Fz	ae
1	4	33100	360	104	0.003	0.021	21600	260	68	0.003	0.016	13200	140	41	0.003	0.013
1	6	29790	290	94	0.002	0.012	19440	210	61	0.003	0.009	11880	115	37	0.002	0.007
1	8	29790	290	94	0.002	0.012	19440	210	61	0.003	0.009	11880	115	37	0.002	0.007
1	10	29790	290	94	0.002	0.008	19440	210	61	0.003	0.006	11880	115	37	0.002	0.005
1	12	26480	230	83	0.002	0.008	17280	165	54	0.002	0.006	10560	90	33	0.002	0.005
1	16	19860	150	62	0.002	0.005	12960	110	41	0.002	0.003	7920	60	25	0.002	0.003
1	20	19860	150	62	0.002	0.003	12960	110	41	0.002	0.002	7920	60	25	0.002	0.002
1	22	9930	65	31	0.002	0.003	6480	45	20	0.002	0.002	3960	25	12	0.002	0.002
1	26	9930	65	31	0.002	0.003	6480	45	20	0.002	0.002	3960	25	12	0.002	0.002
1.2	3	29750	365	112	0.003	0.036	18900	265	71	0.004	0.027	11700	140	44	0.003	0.022
1.2	4	29750	365	112	0.003	0.025	18900	265	71	0.004	0.019	11700	140	44	0.003	0.015
1.2	6	29750	365	112	0.003	0.025	18900	265	71	0.004	0.019	11700	140	44	0.003	0.015
1.2	8	26780	295	101	0.003	0.014	17010	215	64	0.003	0.011	10530	115	40	0.003	0.009
1.2	10	26780	295	101	0.003	0.009	17010	215	64	0.003	0.007	10530	115	40	0.003	0.005
1.2	12	26780	295	101	0.003	0.009	17010	215	64	0.003	0.007	10530	115	40	0.003	0.005
1.2	16	23800	235	90	0.002	0.005	15120	170	57	0.003	0.004	9360	90	35	0.002	0.003
1.2	20	17850	155	67	0.002	0.004	11340	110	43	0.002	0.003	7020	60	26	0.002	0.002
1.5	4	26400	370	124	0.004	0.045	16200	270	76	0.004	0.034	10200	140	48	0.003	0.027
1.5	6	26400	370	124	0.004	0.032	16200	270	76	0.004	0.024	10200	140	48	0.003	0.019
1.5	8	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	10	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	12	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	14	23760	300	112	0.003	0.011	14580	220	69	0.004	0.008	9180	115	43	0.003	0.007
1.5	16	21120	235	100	0.003	0.011	12960	175	61	0.003	0.008	8160	90	38	0.003	0.007
1.5	20	21120	235	100	0.003	0.007	12960	175	61	0.003	0.005	8160	90	38	0.003	0.004
1.5	22	21120	235	100	0.003	0.007	12960	175	61	0.003	0.005	8160	90	38	0.003	0.004
1.5	26	15840	155	75	0.002	0.005	9720	115	46	0.003	0.003	6120	60	29	0.002	0.003
2	6	21600	380	136	0.004	0.060	13800	280	87	0.005	0.045	8640	150	54	0.004	0.036
2	8	21600	380	136	0.004	0.042	13800	280	87	0.005	0.032	8640	150	54	0.004	0.025
2	10	21600	380	136	0.004	0.042	13800	280	87	0.005	0.032	8640	150	54	0.004	0.025
2	12	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2	14	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2	16	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2	20	19440	310	122	0.004	0.015	12420	225	78	0.005	0.011	7780	120	49	0.004	0.009
2	22	17280	245	109	0.004	0.015	11040	180	69	0.004	0.011	6910	95	43	0.003	0.009
2	26	17280	245	109	0.004	0.015	11040	180	69	0.004	0.011	6910	95	43	0.003	0.009
2	30	17280	245	109	0.004	0.009	11040	180	69	0.004	0.007	6910	95	43	0.003	0.005
2.5	8	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	10	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	12	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	14	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	16	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	20	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	26	14400	250	113	0.004	0.019	9120	190	72	0.005	0.014	5860	95	46	0.004	0.011
2.5	30	14400	250	113	0.004	0.019	9120	190	72	0.005	0.014	5860	95	46	0.004	0.011
3	8	15900	400	150	0.006	0.090	10300	310	97	0.008	0.068	6300	150	59	0.006	0.054
3	10	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3	12	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3	14	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3	16	14310	325	135	0.006	0.036	9270	250	87	0.007	0.027	5670	120	53	0.005	0.022
3	20	14310	325	135	0.006	0.036	9270	250	87	0.007	0.027	5670	120	53	0.005	0.022
3	26	14310	325	135	0.006	0.023	9270	250	87	0.007	0.017	5670	120	53	0.005	0.014



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

4 FLUTE CORNER RADIUS LONG NECK

SEME64 Series continued

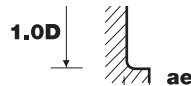
CUTTING DATA

Side Cutting

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/mm²					1110 ~ 1500N/mm²					1500 ~ 2000N/mm²				
Dia.	LBS	RPM	Feed	Vc	Fz	ae	RPM	Feed	Vc	Fz	ae	RPM	Feed	Vc	Fz	ae
3	30	14310	325	135	0.006	0.023	9270	250	87	0.007	0.017	5670	120	53	0.005	0.014
3	35	12720	255	120	0.005	0.023	8240	200	78	0.006	0.017	5040	95	48	0.005	0.014
3	40	12720	255	120	0.005	0.014	8240	200	78	0.006	0.010	5040	95	48	0.005	0.008
4	10	12800	500	161	0.010	0.120	8200	360	103	0.011	0.090	5150	160	65	0.008	0.072
4	12	12800	500	161	0.010	0.120	8200	360	103	0.011	0.090	5150	160	65	0.008	0.072
4	14	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4	16	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4	20	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4	26	11520	405	145	0.009	0.048	7380	290	93	0.010	0.036	4640	130	58	0.007	0.029
4	30	11520	405	145	0.009	0.048	7380	290	93	0.010	0.036	4640	130	58	0.007	0.029
4	35	11520	405	145	0.009	0.030	7380	290	93	0.010	0.023	4640	130	58	0.007	0.018
4	40	11520	405	145	0.009	0.030	7380	290	93	0.010	0.023	4640	130	58	0.007	0.018
4	45	10240	320	129	0.008	0.030	6560	230	82	0.009	0.023	4120	100	52	0.006	0.018
4	50	10240	320	129	0.008	0.030	6560	230	82	0.009	0.023	4120	100	52	0.006	0.018
5	15	11000	510	173	0.012	0.150	7000	430	110	0.015	0.113	4560	200	72	0.011	0.090
6	20	9500	510	179	0.013	0.126	6000	430	113	0.018	0.095	3930	200	74	0.013	0.076
6	30	9500	510	179	0.013	0.126	6000	430	113	0.018	0.095	3930	200	74	0.013	0.076
8	25	7200	550	181	0.019	0.168	4550	430	114	0.024	0.126	3020	200	76	0.017	0.101
8	35	7200	550	181	0.019	0.168	4550	430	114	0.024	0.126	3020	200	76	0.017	0.101
10	30	6000	550	188	0.023	0.300	4000	430	126	0.027	0.225	2420	200	76	0.021	0.180
10	40	6000	550	188	0.023	0.210	4000	430	126	0.027	0.158	2420	200	76	0.021	0.126
12	32	5000	430	188	0.022	0.360	3340	380	126	0.028	0.270	2000	160	75	0.020	0.216
12	45	5000	430	188	0.022	0.252	3340	380	126	0.028	0.189	2000	160	75	0.020	0.151
16	35	3720	330	187	0.022	0.480	2520	280	127	0.028	0.360	1540	135	77	0.022	0.288
16	50	3720	330	187	0.022	0.336	2520	280	127	0.028	0.252	1540	135	77	0.022	0.202
20	40	3000	270	188	0.023	0.600	1950	210	123	0.027	0.450	1200	100	75	0.021	0.360
20	55	3000	270	188	0.023	0.600	1950	210	123	0.027	0.450	1200	100	75	0.021	0.360

LBS = Length Below Shank

ae = Width of cut per pass



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