

2 FLUTE LONG LENGTH

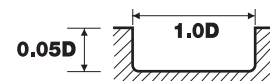
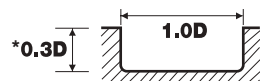
SEME70 Series...

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.	LOC	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	3	16000	70	50	0.002	12800	60	40	0.002	8000	30	25	0.002
1	4	16000	70	50	0.002	12800	60	40	0.002	8000	30	25	0.002
1	5	16000	70	50	0.002	12800	60	40	0.002	8000	30	25	0.002
1	6	14400	55	45	0.002	11520	50	36	0.002	7200	25	23	0.002
1	7	14400	55	45	0.002	11520	50	36	0.002	7200	25	23	0.002
1	8	14400	50	45	0.002	11520	45	36	0.002	7200	20	23	0.001
1	10	14400	50	45	0.002	11520	45	36	0.002	7200	20	23	0.001
1	12	12800	40	40	0.002	10240	35	32	0.002	6400	15	20	0.001
1.2	4	13500	75	51	0.003	10800	65	41	0.003	6750	30	25	0.002
1.2	6	13500	75	51	0.003	10800	65	41	0.003	6750	30	25	0.002
1.2	8	12150	60	46	0.002	9720	50	37	0.003	6080	25	23	0.002
1.2	10	12150	55	46	0.002	9720	45	37	0.002	6080	20	23	0.002
1.2	12	12150	55	46	0.002	9720	45	37	0.002	6080	20	23	0.002
1.5	6	11200	80	53	0.004	8960	70	42	0.004	5600	30	26	0.003
1.5	8	10080	70	48	0.003	8060	60	38	0.004	5040	30	24	0.003
1.5	10	10080	65	48	0.003	8060	55	38	0.003	5040	25	24	0.002
1.5	12	10080	60	48	0.003	8060	50	38	0.003	5040	25	24	0.002
1.5	14	10080	60	48	0.003	8060	50	38	0.003	5040	25	24	0.002
1.5	16	8960	45	42	0.003	7170	40	34	0.003	4480	20	21	0.002
2	8	9070	85	57	0.005	7260	70	46	0.005	4540	35	29	0.004
2	10	9070	85	57	0.005	7260	70	46	0.005	4540	35	29	0.004
2	12	8160	70	51	0.004	6530	60	41	0.005	4090	30	26	0.004
2	14	8160	70	51	0.004	6530	60	41	0.005	4090	30	26	0.004
2	16	8160	60	51	0.004	6530	50	41	0.004	4090	25	26	0.003
2.5	10	7700	95	60	0.006	6200	80	49	0.006	3850	40	30	0.005
2.5	12	7700	95	60	0.006	6200	80	49	0.006	3850	40	30	0.005
2.5	16	6930	75	54	0.005	5580	65	44	0.006	3470	30	27	0.004
2.5	20	6930	70	54	0.005	5580	55	44	0.005	3470	30	27	0.004
2.5	26	6160	55	48	0.004	4960	45	39	0.005	3080	20	24	0.003
3	10	6350	100	60	0.008	5150	85	49	0.008	3170	40	30	0.006
3	12	6350	100	60	0.008	5150	85	49	0.008	3170	40	30	0.006
3	14	6350	100	60	0.008	5150	85	49	0.008	3170	40	30	0.006
3	16	5720	90	54	0.008	4640	75	44	0.008	2850	40	27	0.007
3	20	5720	80	54	0.007	4640	70	44	0.008	2850	35	27	0.006
3	26	5720	70	54	0.006	4640	60	44	0.006	2850	30	27	0.005
3	30	5720	70	54	0.006	4640	60	44	0.006	2850	30	27	0.005
4	12	5150	120	65	0.012	4100	100	52	0.012	2580	50	32	0.010
4	16	5150	120	65	0.012	4100	100	52	0.012	2580	50	32	0.010
4	20	5150	120	65	0.012	4100	100	52	0.012	2580	50	32	0.010
4	26	4640	95	58	0.010	3690	85	46	0.012	2320	40	29	0.009
4	30	4640	95	58	0.010	3690	85	46	0.012	2320	40	29	0.009
5	20	4400	150	69	0.017	3480	125	55	0.018	2280	55	36	0.012
5	25	4400	150	69	0.017	3480	125	55	0.018	2280	55	36	0.012
5	30	3960	120	62	0.015	3130	100	49	0.016	2050	45	32	0.011
5	35	3960	120	62	0.015	3130	100	49	0.016	2050	45	32	0.011
5	40	3960	110	62	0.014	3130	90	49	0.014	2050	40	32	0.010
6	15	3800	180	72	0.024	3050	150	57	0.025	1970	70	37	0.018
6	20	3800	180	72	0.024	3050	150	57	0.025	1970	70	37	0.018
6	25	3800	180	72	0.024	3050	150	57	0.025	1970	70	37	0.018
6	30	3800	155	72	0.020	3050	130	57	0.021	1970	60	37	0.015
6	35	3420	140	64	0.020	2750	115	52	0.021	1770	55	33	0.016
6	40	3420	120	64	0.018	2750	100	52	0.018	1770	50	33	0.014

LOC = Length of Cut

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

2 FLUTE LONG LENGTH

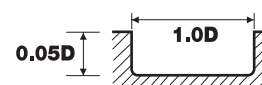
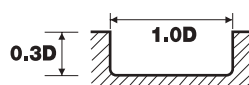
SEME70 Series continued

CUTTING DATA

Slotting

MATERIAL		NON-ALLOYED STEELS & ALLOY STEELS				ALLOY & HEAT RESISTANT STEELS				HARDENED STEELS			
		CAST IRON				STAINLESS STEELS							
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Strength		~ 1100N/mm ²				1110 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
Dia.	LOC	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
6	45	3420	120	64	0.018	2750	100	52	0.018	1770	50	33	0.014
8	25	2880	190	72	0.033	2280	150	57	0.033	1510	70	38	0.023
8	30	2880	190	72	0.033	2280	150	57	0.033	1510	70	38	0.023
8	35	2880	190	72	0.033	2280	150	57	0.033	1510	70	38	0.023
8	40	2880	160	72	0.028	2280	125	57	0.027	1510	60	38	0.020
8	45	2590	145	65	0.028	2050	115	52	0.028	1360	55	34	0.020
8	50	2590	130	65	0.025	2050	100	52	0.024	1360	50	34	0.018
10	30	2450	190	77	0.039	2000	150	63	0.038	1210	70	38	0.029
10	35	2450	190	77	0.039	2000	150	63	0.038	1210	70	38	0.029
10	40	2450	190	77	0.039	2000	150	63	0.038	1210	70	38	0.029
10	45	2450	160	77	0.033	2000	125	63	0.031	1210	60	38	0.025
10	50	2450	160	77	0.033	2000	125	63	0.031	1210	60	38	0.025
10	55	2210	145	69	0.033	1800	115	57	0.032	1090	55	34	0.025
10	60	2210	130	69	0.029	1800	100	57	0.028	1090	50	34	0.023
12	35	2000	150	75	0.038	1670	135	63	0.040	1010	55	38	0.027
12	40	2000	150	75	0.038	1670	135	63	0.040	1010	55	38	0.027
12	45	2000	130	75	0.033	1670	115	63	0.034	1010	45	38	0.022
12	50	2000	130	75	0.033	1670	115	63	0.034	1010	45	38	0.022
12	55	2000	130	75	0.033	1670	115	63	0.034	1010	45	38	0.022
12	60	2000	110	75	0.028	1670	100	63	0.030	1010	40	38	0.020
12	65	1800	100	68	0.028	1500	90	57	0.030	910	35	34	0.019
12	70	1800	100	68	0.028	1500	90	57	0.030	910	35	34	0.019
14	50	1850	125	81	0.034	1480	100	65	0.034	910	45	40	0.025
14	60	1850	125	81	0.034	1480	100	65	0.034	910	45	40	0.025
16	40	1700	140	85	0.041	1280	105	64	0.041	800	50	40	0.031
16	50	1700	140	85	0.041	1280	105	64	0.041	800	50	40	0.031
16	60	1700	120	85	0.035	1280	90	64	0.035	800	40	40	0.025
16	70	1700	120	85	0.035	1280	90	64	0.035	800	40	40	0.025
16	80	1700	105	85	0.031	1280	80	64	0.031	800	35	40	0.022
16	90	1530	95	77	0.031	1150	70	58	0.030	720	30	36	0.021
16	110	1530	95	77	0.031	1150	70	58	0.030	720	30	36	0.021
16	120	1530	95	77	0.031	1150	70	58	0.030	720	30	36	0.021
18	50	1450	120	82	0.041	1120	90	63	0.040	700	40	40	0.029
18	70	1450	100	82	0.034	1120	75	63	0.033	700	35	40	0.025
18	100	1310	80	74	0.031	1000	60	57	0.030	630	30	36	0.024
20	50	1220	100	77	0.041	950	75	60	0.039	600	35	38	0.029
20	60	1220	100	77	0.041	950	75	60	0.039	600	35	38	0.029
20	70	1220	85	77	0.035	950	65	60	0.034	600	30	38	0.025
20	80	1220	85	77	0.035	950	65	60	0.034	600	30	38	0.025
20	90	1220	75	77	0.031	950	55	60	0.029	600	25	38	0.021
20	110	1100	70	69	0.032	860	50	54	0.029	540	25	34	0.023
20	120	1100	70	69	0.032	860	50	54	0.029	540	25	34	0.023
22	75	1100	75	76	0.034	840	55	58	0.033	550	30	38	0.027
22	110	1100	70	76	0.032	840	50	58	0.030	550	25	38	0.023
25	70	980	80	77	0.041	750	60	59	0.040	480	30	38	0.031
25	90	980	70	77	0.036	750	50	59	0.033	480	25	38	0.026
25	110	980	70	77	0.036	750	50	59	0.033	480	25	38	0.026
25	120	980	60	77	0.031	750	45	59	0.030	480	25	38	0.026

LOC = Length of Cut



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