

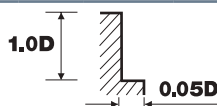
4 FLUTE

SEME36 & SEME71 Series

CUTTING DATA

Side Cutting

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
0.8	31250	225	79	0.002	18750	135	47	0.002	15630	115	39	0.002	12500	40	31	0.001
0.9	29300	235	83	0.002	17580	140	50	0.002	14650	115	41	0.002	11720	40	33	0.001
1	26800	240	84	0.002	16080	145	51	0.002	13400	120	42	0.002	10720	45	34	0.001
1.2	22500	250	85	0.003	13500	150	51	0.003	11250	125	42	0.003	9000	45	34	0.001
1.5	18750	255	88	0.003	11250	155	53	0.003	9380	130	44	0.003	7500	45	35	0.002
2	14450	280	91	0.005	9450	170	59	0.004	7880	140	50	0.004	6300	50	40	0.002
2.5	12800	300	101	0.006	8200	185	64	0.006	6830	155	54	0.006	5250	55	41	0.003
3	11150	320	105	0.007	6950	200	66	0.007	5780	170	54	0.007	4200	60	40	0.004
3.5	10300	445	113	0.011	6360	275	70	0.011	5310	225	58	0.011	3940	60	43	0.004
4	9450	570	119	0.015	5780	350	73	0.015	4850	280	61	0.014	3680	60	46	0.004
4.5	8660	585	122	0.017	5250	355	74	0.017	4400	290	62	0.016	3290	65	47	0.005
5	7880	600	124	0.019	4730	360	74	0.019	3950	300	62	0.019	2900	70	46	0.006
5.5	7410	630	128	0.021	4460	385	77	0.022	3750	315	65	0.021	2700	75	47	0.007
6	6950	660	131	0.024	4200	410	79	0.024	3550	330	67	0.023	2500	80	47	0.008
6.5	6530	675	133	0.026	3940	405	80	0.026	3320	335	68	0.025	2400	90	49	0.009
7	6100	685	134	0.028	3680	395	81	0.027	3090	340	68	0.028	2300	95	51	0.010
7.5	5680	700	134	0.031	3410	390	80	0.029	2860	345	67	0.030	2200	105	52	0.012
8	5250	710	132	0.034	3150	380	79	0.03	2630	350	66	0.033	2100	110	53	0.013
8.5	4960	685	132	0.035	2990	360	80	0.03	2490	340	66	0.034	2000	105	53	0.013
9	4660	660	132	0.035	2830	340	80	0.03	2360	325	67	0.034	1900	100	54	0.013
9.5	4370	635	130	0.036	2660	320	79	0.03	2230	315	67	0.035	1800	95	54	0.013
10	4080	610	128	0.037	2500	300	79	0.03	2100	300	66	0.036	1700	90	53	0.013
10.5	3910	590	129	0.038	2400	290	79	0.03	2000	285	66	0.036	1640	90	54	0.014
11	3750	565	130	0.038	2300	275	79	0.03	1900	270	66	0.036	1580	85	55	0.013
11.5	3590	545	130	0.038	2200	265	79	0.03	1800	255	65	0.035	1510	85	55	0.014
12	3430	520	129	0.038	2100	250	79	0.03	1700	240	64	0.035	1450	80	55	0.014
13	3260	495	133	0.038	2000	240	82	0.03	1620	230	66	0.035	1370	75	56	0.014
14	3090	465	136	0.038	1900	225	84	0.03	1540	220	68	0.036	1290	70	57	0.014
15	2920	440	138	0.038	1800	215	85	0.03	1460	210	69	0.036	1210	65	57	0.013
16	2750	420	138	0.038	1700	205	85	0.03	1380	200	69	0.036	1130	60	57	0.013
17	2590	390	138	0.038	1610	190	86	0.03	1290	190	69	0.037	1060	55	57	0.013
18	2430	365	137	0.038	1510	180	85	0.03	1210	175	68	0.036	990	50	56	0.013
19	2260	345	135	0.038	1420	170	85	0.03	1130	165	67	0.037	920	45	55	0.012
20	2100	320	132	0.038	1330	160	84	0.03	1050	150	66	0.036	850	40	53	0.012
21	2020	305	133	0.038	1270	155	84	0.031	1010	145	67	0.036	820	40	54	0.012
22	1940	295	134	0.038	1220	150	84	0.031	970	140	67	0.036	780	37	54	0.012
23	1860	280	134	0.038	1160	140	84	0.03	930	135	67	0.036	750	35	54	0.012
24	1780	265	134	0.037	1110	135	84	0.03	890	125	67	0.035	710	30	54	0.011
25	1700	250	134	0.037	1050	130	82	0.031	850	120	67	0.035	680	30	53	0.011



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*Exclusions apply.

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