Registered
ISO 9001:2015 / ISO 14001:2015

WORLD CLASS PRODUCT OF KOREA
세계일류상품

4G MILLS

Y-COATED SOLID CARBIDE END MILLS

High Speed Cutting for Pre-Hardened Steels up to HRc55

YG-1 CO., LTD.

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Note The information is provided for reference only. Tool specifications are subject to change without prior notice.
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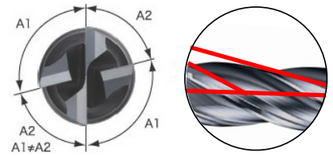
YG1E2200619008

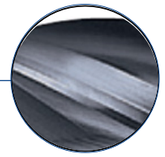
High Speed Cutting for Pre-Hardened Steels up to HRc55 - 4G MILLS

Suitable for a wide range of work material, specifically for increasing tool life when machining pre-hardened materials, low hardness materials, cast iron, etc. High speed cutting, dry and wet cut recommended together.



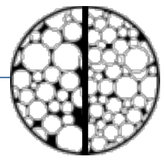
Unequal Index & Multiple Helix

4G Mills, 4 Flute Multiple Helix End Mills exclusively designed to reduce vibration and also to achieve excellent chip evacuation



Optimal Edge Preparation

All 4G Mills products contain an Optimal Edge Preparation to prevent chipping, also obtaining an excellent surface finish with a longer tool life in High Speed Cutting



Ultra Micro Grain & Nano Grain Carbide

Premium Grade Carbide Substrate Materials achieving exceptional wear resistance making it possible for High Precision Machining

High Technology Y-Coating

AlCr Based, YG-1`s High Technology
In-house coating for maximum tool life and high performance
Excellent quality coating developed by YG-1

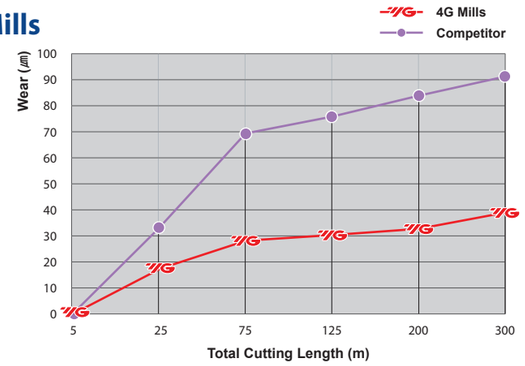
Holds a Large Variety of Product Range for Multiple Use

Large Variety of Products
For Several Different Applications with Different Size and Lengths
▶ Size : Ø0.03mm~Ø25.0mm

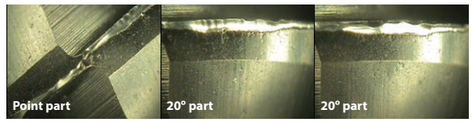
CASE STUDY

▶Y-Coated Solid Carbide 2 Flute, Ball End Mills

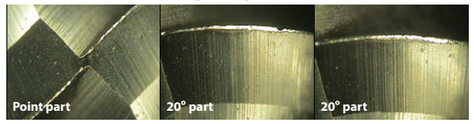
Cutting Conditions	
Tool	SEMD98060E
Size(mm)	Ø6 x 6 x 12 x 90
Work Material	KP4M (HRc35 / DIN 1.2738 Improved)
Cutting Speed	130.061 m/min.
RPM	6900 rev./min.
Feed	830 mm/min.
Feed per tooth	0.060 mm/tooth
Milling Method	Profiling
Milling Depth	Axial : 0.2 mm Radial : 1.2 mm
Coolant	Oil Mist
Overhang	26 mm
Machine	Machining Center



Competitor (Total Cutting Length : 300m)

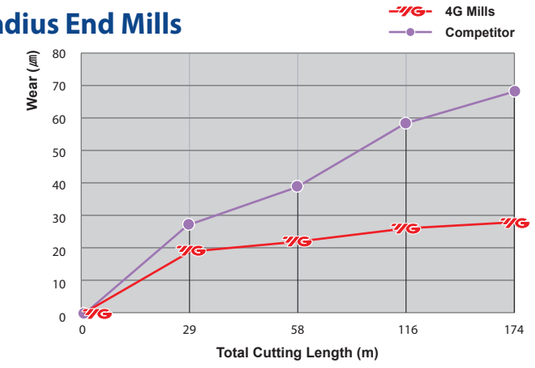


4G MILLS (Total Cutting Length : 300m)

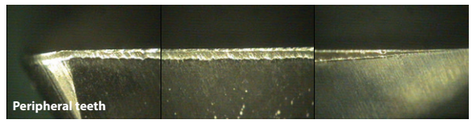


▶Y-Coated Solid Carbide 4 Flute, Corner Radius End Mills

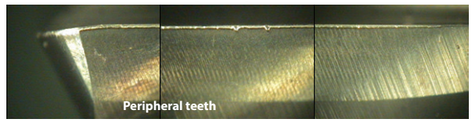
Cutting Conditions	
Tool	SEME0110005E
Size(mm)	Ø10(R0.5) x 10 x 25 x 100
Work Material	KP4M (HRc35 / DIN 1.2738 Improved)
Cutting Speed	51.522 m/min.
RPM	1640 rev./min.
Feed	180 mm/min.
Feed per tooth	0.027 mm/tooth
Milling Method	Down & Side Cutting
Milling Depth	Axial : 25 mm Radial : 0.5 mm
Coolant	Oil Mist
Overhang	41 mm
Machine	Machining Center



Competitor (Total Cutting Length : 174m)



4G MILLS (Total Cutting Length : 174m)



SELECTION GUIDE

MILLING TOOLS

SOLID CARBIDE
4G MILL
END MILLS

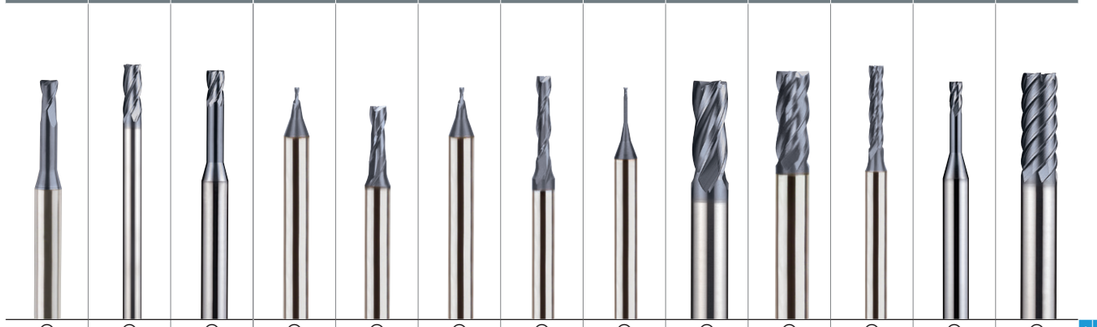
High Speed Cutting
for Pre-Hardened Steels up to HRc55

Material Groups
Go to page188
Please visit globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P 118

SERIES				SEMD98	SEM846	SEM846	SEMD99
FLUTE				2	2	2	2
HELIX ANGLE				30°	30°	30°	30°
CUTTING EDGE SHAPE				BALL NOSE	BALL NOSE	BALL NOSE	CORNER RADIUS
SIZE MIN				R0.05	R0.05	R0.25	D0.2
SIZE MAX				R12.5	R6.0	R1.0	D20.0
PAGE				8	14	24	27
				-	EXTENDED NECK	EXTENDED NECK (6mm Shank)	-
				Y-Coating	Y-Coating	Y-Coating	Y-Coating
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	
P	1	Non-alloy steel	About 0.15% C	Annealed	125		○ ○ ○ ○
	2		About 0.45% C	Annealed	190	13	○ ○ ○ ○
	3		About 0.45% C	Quenched & Tempered	250	25	○ ○ ○ ◎
	4		About 0.75% C	Annealed	270	28	◎ ◎ ◎ ◎
	5		About 0.75% C	Quenched & Tempered	300	32	◎ ◎ ◎ ◎
	6	Low alloy steel		Annealed	180	10	○ ○ ○ ○
	7			Quenched & Tempered	275	29	◎ ◎ ◎ ◎
	8			Quenched & Tempered	300	32	◎ ◎ ◎ ◎
	9			Quenched & Tempered	350	38	◎ ◎ ◎ ◎
	10	High alloyed steel, and tool steel		Annealed	200	15	○ ○ ○ ○
	11			Quenched & Tempered	325	35	◎ ◎ ◎ ◎
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	
	13		Martensitic	Quenched & Tempered	240	23	
	14		Austenitic		180	10	
K	15	Grey cast iron	Pearlitic / ferritic		180	10	○ ○ ○ ○
	16		Pearlitic (Martensitic)		260	26	○ ○ ○ ○
	17	Nodular cast iron	Ferritic		160	3	○ ○ ○ ○
	18		Pearlitic		250	25	○ ○ ○ ○
	19	Malleable cast iron	Ferritic		130		○ ○ ○ ○
	20		Pearlitic		230	21	○ ○ ○ ○
N	21	Aluminum-wrought alloy	Not Curable		60		
	22		Curable	Hardened	100		
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		
	24		≤ 12% Si, Curable	Hardened	90		
	25		> 12% Si, Not Curable		130		
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		
	27		CuZn, CuSnZn (Brass)		90		
	28		CuSn, lead-free copper and electrolytic copper		100		
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				
	30		Rubber, Wood, etc.				
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	
	32			Cured	280	30	
	33		Ni or Co Based	Annealed	250	25	
	34			Cured	350	38	
	35			Cast	320	34	
	36	Titanium Alloys	Pure Titanium		400 Rm		
	37		Alpha + Beta Alloys	Hardened	1050 Rm		
H	38	Hardened steel		Hardened	550	55	○ ○ ○ ○
	39			Hardened	630	60	
	40	Chilled Cast Iron		Cast	400	42	◎ ◎ ◎ ◎
	41	Hardened Cast Iron		Hardened	550	55	○ ○ ○ ○



SERIES	SEME61	SEME01	SEME64	SEME35	SEME35	SEME35	SEME70	SEM845	SEME36	SEME71	SEME72	SEME73	SEME75	
FLUTE	2	4	4	2	2	2	2	2	4	4	4	4	6	
HELIX ANGLE	30°	27°/30° (MULTIPLE HELIX)	27°/30° (MULTIPLE HELIX)	30°	30°	30°	30°	30°	27°/30° (MULTIPLE HELIX)	35°/38° (MULTIPLE HELIX)	30°	30°	45°	
CUTTING EDGE SHAPE	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	
SIZE MIN	D0.2	D1.0	D1.0	D0.1	D0.1	D0.1	D1.0	D0.1	D0.8	D1.0	D1.0	D1.0	D6.0	
SIZE MAX	D20.0	D20.0	D20.0	D25.0	D4.0	D3.0	D25.0	D12.0	D25.0	D20.0	D25.0	D12.0	D20.0	
PAGE	35	54	61	76	79	80	81	87	96	98	102	108	113	
	EXTENDED NECK	-	EXTENDED NECK	-	(4mm Shank)	(3mm Shank)	LONG LENGTH	EXTENDED NECK	-	(Sharp Corner Removal)	LONG LENGTH	EXTENDED NECK	-	
	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	Y-Coating	
ISO														
P	○	○	○	○	○	○	○	○	○	○	○	○	○	1
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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	11
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K	○	○	○	○	○	○	○	○	○	○	○	○	○	15
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	○	○	○	○	○	○	○	○	○	○	○	○	○	17
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SELECTION GUIDE

MILLING TOOLS

SOLID CARBIDE & HSS-PM

X-SPEED ROUGHER END MILLS

High Speed Cutting
for Pre-Hardened Steels up to HRc40

SERIES	G9D75 G9D67	G9D76 G9D68	G9D77 G9D69	GAE53
FLUTE	4&5	4&5	4&5	4&5
HELIX ANGLE	44°~45° (MULTIPLE HELIX)	44°~45° (MULTIPLE HELIX)	44°~45° (MULTIPLE HELIX)	44°~45° (MULTIPLE HELIX)
CUTTING EDGE SHAPE	CORNER RADIUS ROUGHING	CORNER RADIUS ROUGHING	CORNER RADIUS ROUGHING	CORNER RADIUS ROUGHING
SIZE MIN	D6.0	D6.0	D6.0	D6.0
SIZE MAX	D20.0	D20.0	D20.0	D20.0
PAGE	115	115	116	117
	SHORT LENGTH	LONG LENGTH	LONG REACH	SHORT LENGTH
	X-Coating	X-Coating	X-Coating	X-Coating
				HSS-PM

Material Groups
Go to page188
Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

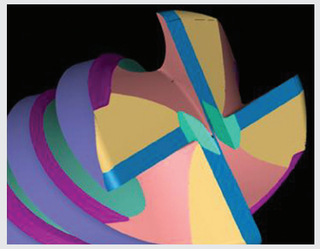
Recommended cutting conditions : P 186

ISO	VDI 3323	Material Description	Composition / Structure	/ Heat Treatment	HB	HRc				
P	1	Non-alloy steel	About 0.15% C	Annealed	125		○	○	○	○
	2		About 0.45% C	Annealed	190	13	○	○	○	○
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎
	5		About 0.75% C	Quenched & Tempered	300	32	◎	◎	◎	○
	6	Low alloy steel		Annealed	180	10	○	○	○	○
	7			Quenched & Tempered	275	29	◎	◎	◎	◎
	8			Quenched & Tempered	300	32	◎	◎	◎	○
	9			Quenched & Tempered	350	38	◎	◎	◎	○
	10	High alloyed steel, and tool steel		Annealed	200	15	○	○	○	○
	11			Quenched & Tempered	325	35	◎	◎	◎	○
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	
	13		Martensitic	Quenched & Tempered	240	23	○	○	○	
	14		Austenitic		180	10	○	○	○	◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎	◎	◎	◎
	16		Pearlitic (Martensitic)		260	26	◎	◎	◎	◎
	17	Nodular cast iron	Ferritic		160	3	◎	◎	◎	◎
	18		Pearlitic		250	25	◎	◎	◎	◎
	19	Malleable cast iron	Ferritic		130		◎	◎	◎	◎
	20		Pearlitic		230	21	◎	◎	◎	◎
N	21	Aluminum-wrought alloy	Not Curable		60					
	22		Curable	Hardened	100					
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75					
	24		≤ 12% Si, Curable	Hardened	90					
	25		> 12% Si, Not Curable		130					
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○
	27		CuZn, CuSnZn (Brass)		90		○	○	○	○
	28		CuSn, lead-free copper and electrolytic copper		100		○	○	○	○
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15				
	32			Cured	280	30				
	33		Ni or Co Based	Annealed	250	25				
	34			Cured	350	38				
	35			Cast	320	34				
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm					
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				

CHARACTERISTICS

Unique flute design for excellent chip evacuation and vibration reduction.
Optimal roughing tooth profile to reduce cutting forces.
Special tool geometry for high feed rate and heavy cutting.
Strong end tooth design for plunge and pocket milling.
Custom engineered coating to allow long tool life and excellent chip evacuation.

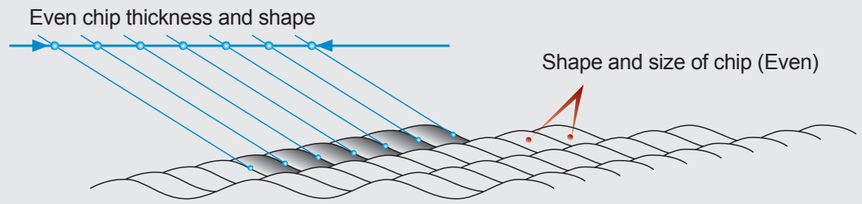
▶ 4 FLUTE



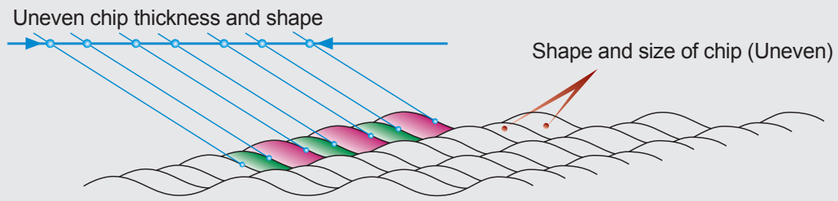
▶ 5 FLUTE

CHIP THICKNESS AND SHAPE

▶ **Conventional Roughing End Mills**



▶ **X-SPEED Rougher**

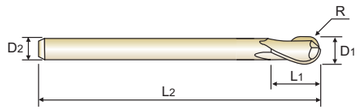


Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ With its unique ball nose geometry and cutting edges the cutting force has decreased, also increasing wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.



CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD98001SE	R0.05	**0.1**	4	0.1	40	Short
★ SEMD98001E	R0.05	**0.1**	4	0.2	40	Regular
SEMD980013SE	R0.05	**0.1**	3	0.2	40	3mm Shank
SEMD980015SE	R0.075	**0.15**	4	0.15	40	Short
SEMD980015E	R0.075	**0.15**	4	0.3	40	Regular
SEMD9800153SE	R0.075	**0.15**	3	0.3	40	3mm Shank
★ SEMD98002SE	R0.1	**0.2**	4	0.2	40	Short
★ SEMD98002E	R0.1	**0.2**	4	0.4	40	Regular
SEMD980023SE	R0.1	**0.2**	3	0.4	40	3mm Shank
★ SEMD98003SE	R0.15	**0.3**	4	0.3	40	Short
★ SEMD98003E	R0.15	**0.3**	4	0.6	40	Regular
SEMD980033SE	R0.15	**0.3**	3	0.6	40	3mm Shank
SEMD98004SE	R0.2	**0.4**	4	0.4	40	Short
★ SEMD98004E	R0.2	**0.4**	4	0.8	40	Regular
SEMD980043SE	R0.2	**0.4**	3	0.8	40	3mm Shank
★ SEMD98005SE	R0.25	**0.5**	4	0.5	40	Short
SEMD98005S6SE	R0.25	**0.5**	6	0.8	40	-
★ SEMD98005E	R0.25	**0.5**	4	1.0	40	Regular
SEMD980053SE	R0.25	**0.5**	3	1.0	40	3mm Shank
SEMD98006SE	R0.3	**0.6**	4	0.6	40	Short
★ SEMD98006E	R0.3	**0.6**	4	1.2	40	Regular
SEMD980063SE	R0.3	**0.6**	3	1.2	40	3mm Shank
SEMD98007SE	R0.35	**0.7**	4	0.7	40	Short
★ SEMD98007E	R0.35	**0.7**	4	1.4	40	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ With its unique ball nose geometry and cutting edges the cutting force has decreased, also increasing wear resistance.
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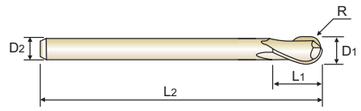

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD980073SE	R0.35	**0.7**	3	1.4	40	3mm Shank
SEMD98008SE	R0.4	**0.8**	4	0.8	40	Short
★ SEMD98008E	R0.4	**0.8**	4	1.6	40	Regular
SEMD980083SE	R0.4	**0.8**	3	1.6	40	3mm Shank
SEMD98009SE	R0.45	**0.9**	4	0.9	40	Short
★ SEMD98009E	R0.45	**0.9**	4	1.8	40	Regular
SEMD980093SE	R0.45	**0.9**	3	1.8	40	3mm Shank
SEMD98010040E	R0.5	**1.0**	6	1.5	40	Short
SEMD980103SE	R0.5	**1.0**	3	2.5	50	3mm Shank
SEMD98010S4SE	R0.5	**1.0**	4	1.5	40	-
★ SEMD980104SE	R0.5	**1.0**	4	2.5	50	Regular
★ SEMD98010E	R0.5	**1.0**	6	2.5	50	Regular
★ SEMD98010070E	R0.5	**1.0**	6	2.5	70	Long
SEMD98010100E	R0.5	**1.0**	6	2.5	100	Long
SEMD98012040E	R0.6	**1.2**	6	2	40	Short
SEMD980123SE	R0.6	**1.2**	3	3	50	3mm Shank
SEMD980124SE	R0.6	**1.2**	4	3	50	Regular
★ SEMD98012E	R0.6	**1.2**	6	3	50	Regular
SEMD98012070E	R0.6	**1.2**	6	3	70	Long
SEMD98012100E	R0.6	**1.2**	6	3	100	Long
SEMD98015040E	R0.75	**1.5**	6	2.5	40	Short
SEMD980153SE	R0.75	**1.5**	3	4	50	3mm Shank
★ SEMD980154SE	R0.75	**1.5**	4	4	50	Regular
★ SEMD98015E	R0.75	**1.5**	6	4	50	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

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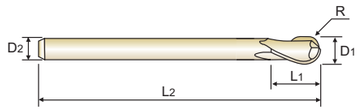

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD98015070E	R0.75	**1.5**	6	4	70	Long
SEMD98015100E	R0.75	**1.5**	6	4	100	Long
★ SEMD98020040E	R1.0	**2.0**	6	3	40	Short
SEMD980203SE	R1.0	**2.0**	3	5	50	3mm Shank
★ SEMD980204SE	R1.0	**2.0**	4	5	50	Regular
★ SEMD98020E	R1.0	**2.0**	6	5	50	Regular
★ SEMD98020080E	R1.0	**2.0**	6	5	80	Long
SEMD98020100E	R1.0	**2.0**	6	5	100	Long
SEMD98025040E	R1.25	**2.5**	6	4	40	Short
SEMD980253SE	R1.25	**2.5**	3	6	60	3mm Shank
★ SEMD980254SE	R1.25	**2.5**	4	6	60	Regular
★ SEMD98025E	R1.25	**2.5**	6	6	60	Regular
★ SEMD98025080E	R1.25	**2.5**	6	6	80	Long
SEMD98025100E	R1.25	**2.5**	6	6	100	Long
★ SEMD98030040E	R1.5	**3.0**	6	4.5	40	Short
SEMD980303SE	R1.5	**3.0**	3	6	60	3mm Shank
★ SEMD980304SE	R1.5	**3.0**	4	6	60	Regular
★ SEMD98030E	R1.5	**3.0**	6	6	60	Regular
★ SEMD98030080E	R1.5	**3.0**	6	6	80	Long
★ SEMD98030100E	R1.5	**3.0**	6	6	100	Long
★ SEMD98035E	R1.75	**3.5**	6	8	70	-
★ SEMD98040050E	R2.0	**4.0**	6	6	50	Short
★ SEMD980404SE	R2.0	**4.0**	4	8	70	Regular
★ SEMD98040E	R2.0	**4.0**	6	8	70	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

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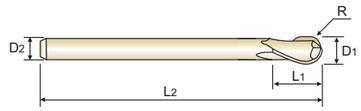

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD980401004SE	R2.0	**4.0**	4	8	100	Long
SEMD980401204SE	R2.0	**4.0**	4	8	120	Long
★ SEMD98040100E	R2.0	**4.0**	6	8	100	Long
★ SEMD98040120E	R2.0	**4.0**	6	8	120	Long
★ SEMD98045E	R2.25	**4.5**	6	9	80	-
★ SEMD98050060E	R2.5	**5.0**	6	7.5	60	Short
★ SEMD98050E	R2.5	**5.0**	6	10	80	Regular
SEMD980505SE	R2.5	**5.0**	5	10	80	5mm
★ SEMD98055E	R2.75	**5.5**	6	11	90	-
★ SEMD98060050E	R3.0	**6.0**	6	9	50	Short
★ SEMD98060060E	R3.0	**6.0**	6	9	60	Short
★ SEMD98060080E	R3.0	**6.0**	6	9	80	Short
★ SEMD98060E	R3.0	**6.0**	6	12	90	Regular
★ SEMD98060110E	R3.0	**6.0**	6	12	110	Long
★ SEMD98060130E	R3.0	**6.0**	6	12	130	Long
★ SEMD98060150E	R3.0	**6.0**	6	12	150	Long
★ SEMD98065E	R3.25	**6.5**	8	13	90	-
★ SEMD98070E	R3.5	**7.0**	8	14	90	-
★ SEMD98080050E	R4.0	**8.0**	8	12	50	Short
★ SEMD98080060E	R4.0	**8.0**	8	12	60	Short
★ SEMD98080080E	R4.0	**8.0**	8	12	80	Short
★ SEMD98080090E	R4.0	**8.0**	8	12	90	Short
★ SEMD98080E	R4.0	**8.0**	8	14	100	Regular
★ SEMD98080130E	R4.0	**8.0**	8	14	130	Long

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

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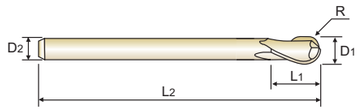

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD98080150E	R4.0	**8.0**	8	14	150	Long
★ SEMD98085E	R4.25	**8.5**	10	16	100	-
★ SEMD98090E	R4.5	**9.0**	10	18	100	-
SEMD98100050E	R5.0	**10.0**	10	15	50	Short
★ SEMD98100060E	R5.0	**10.0**	10	15	60	Short
★ SEMD98100080E	R5.0	**10.0**	10	15	80	Short
★ SEMD98100090E	R5.0	**10.0**	10	15	90	Short
★ SEMD98100E	R5.0	**10.0**	10	18	100	Regular
★ SEMD98100130E	R5.0	**10.0**	10	18	130	Long
★ SEMD98100150E	R5.0	**10.0**	10	18	150	Long
★ SEMD98100180E	R5.0	**10.0**	10	18	180	Long
SEMD98100200E	R5.0	**10.0**	10	18	200	Long
★ SEMD98110E	R5.5	**11.0**	12	20	100	-
SEMD98120060E	R6.0	**12.0**	12	18	60	Short
★ SEMD98120080E	R6.0	**12.0**	12	18	80	Short
SEMD98120090E	R6.0	**12.0**	12	18	90	Short
★ SEMD98120100E	R6.0	**12.0**	12	18	100	Short
★ SEMD98120E	R6.0	**12.0**	12	22	110	Regular
★ SEMD98120130E	R6.0	**12.0**	12	22	130	Long
★ SEMD98120150E	R6.0	**12.0**	12	22	150	Long
★ SEMD98120180E	R6.0	**12.0**	12	22	180	Long
★ SEMD98120200E	R6.0	**12.0**	12	22	200	Long
★ SEMD98130E	R6.5	**13.0**	12	24	100	-
★ SEMD98140E	R7.0	**14.0**	12	26	100	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE (Short, Regular, Long Shank)

SEMD98 SERIES

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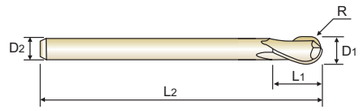

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.118-119

R0.05~R3 R3.25~R12.5

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD9814014SE	R7.0	**14.0**	14	26	100	-
SEMD9814016SE	R7.0	**14.0**	16	26	100	-
SEMD98150E	R7.5	**15.0**	16	28	140	-
★ SEMD98160100E	R8.0	**16.0**	16	24	100	Short
SEMD98160130E	R8.0	**16.0**	16	24	130	Short
★ SEMD98160E	R8.0	**16.0**	16	30	150	Regular
SEMD98160180E	R8.0	**16.0**	16	30	180	Long
★ SEMD98160200E	R8.0	**16.0**	16	30	200	Long
★ SEMD98180E	R9.0	**18.0**	16	34	150	Regular
SEMD9818018SE	R9.0	**18.0**	18	34	150	-
★ SEMD98200100E	R10.0	**20.0**	20	30	100	Short
SEMD98200130E	R10.0	**20.0**	20	30	130	Short
★ SEMD98200E	R10.0	**20.0**	20	38	150	Regular
SEMD98200200E	R10.0	**20.0**	20	38	200	Long
SEMD98250120E	R12.5	**25.0**	25	50	120	Short
SEMD98250E	R12.5	**25.0**	25	50	180	Regular

★ : Stock Item

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE with EXTENDED NECK

SEM846 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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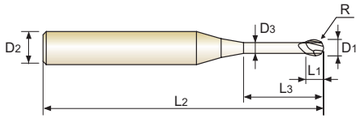

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM846001002E	R0.05	**0.1**	4	0.1	0.2	40	0.085
SEM846001003E	R0.05	**0.1**	4	0.1	0.3	40	0.085
SEM846001005E	R0.05	**0.1**	4	0.1	0.5	40	0.085
SEM84600101E	R0.05	**0.1**	4	0.1	1	40	0.085
★ SEM846002005E	R0.1	**0.2**	4	0.2	0.5	40	0.17
★ SEM84600201E	R0.1	**0.2**	4	0.2	1	40	0.17
SEM846002015E	R0.1	**0.2**	4	0.2	1.5	40	0.17
★ SEM84600202E	R0.1	**0.2**	4	0.2	2	40	0.17
SEM84600203E	R0.1	**0.2**	4	0.2	3	40	0.17
★ SEM84600301E	R0.15	**0.3**	4	0.3	1	40	0.27
★ SEM846003015E	R0.15	**0.3**	4	0.3	1.5	40	0.27
★ SEM84600302E	R0.15	**0.3**	4	0.3	2	40	0.27
SEM846003025E	R0.15	**0.3**	4	0.3	2.5	40	0.27
★ SEM84600303E	R0.15	**0.3**	4	0.3	3	40	0.27
★ SEM84600304E	R0.15	**0.3**	4	0.3	4	40	0.27
SEM84600305E	R0.15	**0.3**	4	0.3	5	40	0.27
★ SEM84600401E	R0.2	**0.4**	4	0.4	1	40	0.37
★ SEM846004015E	R0.2	**0.4**	4	0.4	1.5	40	0.37
★ SEM84600402E	R0.2	**0.4**	4	0.4	2	40	0.37
★ SEM846004025E	R0.2	**0.4**	4	0.4	2.5	40	0.37
★ SEM84600403E	R0.2	**0.4**	4	0.4	3	40	0.37
★ SEM84600404E	R0.2	**0.4**	4	0.4	4	40	0.37
★ SEM84600405E	R0.2	**0.4**	4	0.4	5	40	0.37
★ SEM84600406E	R0.2	**0.4**	4	0.4	6	40	0.37

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
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SEM846 SERIES

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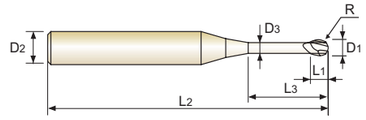

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84600408E	R0.2	**0.4**	4	0.4	8	40	0.37
SEM84600410E	R0.2	**0.4**	4	0.4	10	40	0.37
★ SEM84600501E	R0.25	**0.5**	4	0.5	1	45	0.45
SEM846005015E	R0.25	**0.5**	4	0.5	1.5	45	0.45
★ SEM84600502E	R0.25	**0.5**	4	0.5	2	45	0.45
SEM846005025E	R0.25	**0.5**	4	0.5	2.5	45	0.45
★ SEM84600503E	R0.25	**0.5**	4	0.5	3	45	0.45
★ SEM84600504E	R0.25	**0.5**	4	0.5	4	45	0.45
★ SEM84600505E	R0.25	**0.5**	4	0.5	5	45	0.45
★ SEM84600506E	R0.25	**0.5**	4	0.5	6	45	0.45
★ SEM84600508E	R0.25	**0.5**	4	0.5	8	45	0.45
★ SEM84600510E	R0.25	**0.5**	4	0.5	10	45	0.45
SEM84600512E	R0.25	**0.5**	4	0.5	12	45	0.45
SEM84600514E	R0.25	**0.5**	4	0.5	14	45	0.45
SEM84600516E	R0.25	**0.5**	4	0.5	16	45	0.45
★ SEM84600601E	R0.3	**0.6**	4	0.6	1	45	0.55
★ SEM84600602E	R0.3	**0.6**	4	0.6	2	45	0.55
★ SEM84600603E	R0.3	**0.6**	4	0.6	3	45	0.55
★ SEM84600604E	R0.3	**0.6**	4	0.6	4	45	0.55
★ SEM84600605E	R0.3	**0.6**	4	0.6	5	45	0.55
★ SEM84600606E	R0.3	**0.6**	4	0.6	6	45	0.55
★ SEM84600608E	R0.3	**0.6**	4	0.6	8	45	0.55
★ SEM84600610E	R0.3	**0.6**	4	0.6	10	45	0.55
★ SEM84600612E	R0.3	**0.6**	4	0.6	12	45	0.55

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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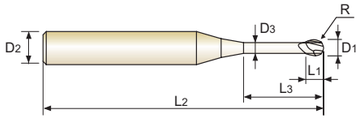

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84600614E	R0.3	**0.6**	4	0.6	14	45	0.55
SEM84600616E	R0.3	**0.6**	4	0.6	16	45	0.55
★ SEM84600702E	R0.35	**0.7**	4	0.7	2	45	0.65
★ SEM84600704E	R0.35	**0.7**	4	0.7	4	45	0.65
★ SEM84600706E	R0.35	**0.7**	4	0.7	6	45	0.65
SEM84600708E	R0.35	**0.7**	4	0.7	8	45	0.65
SEM84600710E	R0.35	**0.7**	4	0.7	10	45	0.65
SEM84600712E	R0.35	**0.7**	4	0.7	12	45	0.65
SEM84600801E	R0.4	**0.8**	4	0.8	1	45	0.75
★ SEM84600802E	R0.4	**0.8**	4	0.8	2	45	0.75
★ SEM84600803E	R0.4	**0.8**	4	0.8	3	45	0.75
★ SEM84600804E	R0.4	**0.8**	4	0.8	4	45	0.75
★ SEM84600805E	R0.4	**0.8**	4	0.8	5	45	0.75
★ SEM84600806E	R0.4	**0.8**	4	0.8	6	45	0.75
★ SEM84600808E	R0.4	**0.8**	4	0.8	8	45	0.75
★ SEM84600810E	R0.4	**0.8**	4	0.8	10	45	0.75
★ SEM84600812E	R0.4	**0.8**	4	0.8	12	45	0.75
SEM84600814E	R0.4	**0.8**	4	0.8	14	45	0.75
SEM84600816E	R0.4	**0.8**	4	0.8	16	45	0.75
SEM84600820E	R0.4	**0.8**	4	0.8	20	45	0.75
★ SEM84600904E	R0.45	**0.9**	4	0.9	4	45	0.85
SEM84600906E	R0.45	**0.9**	4	0.9	6	45	0.85
★ SEM84600908E	R0.45	**0.9**	4	0.9	8	45	0.85
SEM84600910E	R0.45	**0.9**	4	0.9	10	45	0.85

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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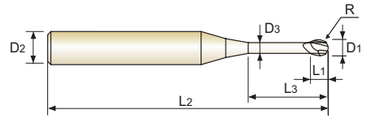

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84601002E	R0.5	**1.0**	4	1	2	50	0.95
★ SEM84601003E	R0.5	**1.0**	4	1	3	50	0.95
★ SEM84601004E	R0.5	**1.0**	4	1	4	50	0.95
★ SEM84601005E	R0.5	**1.0**	4	1	5	50	0.95
★ SEM84601006E	R0.5	**1.0**	4	1	6	50	0.95
★ SEM84601007E	R0.5	**1.0**	4	1	7	50	0.95
★ SEM84601008E	R0.5	**1.0**	4	1	8	50	0.95
SEM84601009E	R0.5	**1.0**	4	1	9	50	0.95
★ SEM84601010E	R0.5	**1.0**	4	1	10	50	0.95
★ SEM84601012E	R0.5	**1.0**	4	1	12	50	0.95
★ SEM84601014E	R0.5	**1.0**	4	1	14	50	0.95
★ SEM84601016E	R0.5	**1.0**	4	1	16	50	0.95
★ SEM84601018E	R0.5	**1.0**	4	1	18	50	0.95
★ SEM84601020E	R0.5	**1.0**	4	1	20	50	0.95
SEM84601022E	R0.5	**1.0**	4	1	22	60	0.95
★ SEM84601026E	R0.5	**1.0**	4	1	26	60	0.95
★ SEM84601030E	R0.5	**1.0**	4	1	30	70	0.95
SEM84601040E	R0.5	**1.0**	4	1	40	80	0.95
SEM84601050E	R0.5	**1.0**	4	1	50	100	0.95
★ SEM84601204E	R0.6	**1.2**	4	1.2	4	50	1.15
★ SEM84601206E	R0.6	**1.2**	4	1.2	6	50	1.15
★ SEM84601208E	R0.6	**1.2**	4	1.2	8	50	1.15
★ SEM84601210E	R0.6	**1.2**	4	1.2	10	50	1.15
★ SEM84601212E	R0.6	**1.2**	4	1.2	12	50	1.15

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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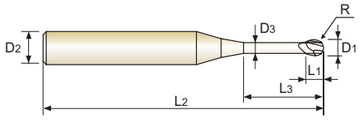

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84601216E	R0.6	**1.2**	4	1.2	16	50	1.15
SEM84601220E	R0.6	**1.2**	4	1.2	20	50	1.15
SEM84601226E	R0.6	**1.2**	4	1.2	26	60	1.15
SEM84601406E	R0.7	**1.4**	4	1.4	6	50	1.35
SEM84601408E	R0.7	**1.4**	4	1.4	8	50	1.35
SEM84601410E	R0.7	**1.4**	4	1.4	10	50	1.35
SEM84601412E	R0.7	**1.4**	4	1.4	12	50	1.35
SEM84601416E	R0.7	**1.4**	4	1.4	16	50	1.35
★ SEM84601503E	R0.75	**1.5**	4	1.5	3	50	1.45
★ SEM84601504E	R0.75	**1.5**	4	1.5	4	50	1.45
★ SEM84601505E	R0.75	**1.5**	4	1.5	5	50	1.45
★ SEM84601506E	R0.75	**1.5**	4	1.5	6	50	1.45
SEM84601507E	R0.75	**1.5**	4	1.5	7	50	1.45
★ SEM84601508E	R0.75	**1.5**	4	1.5	8	50	1.45
★ SEM84601510E	R0.75	**1.5**	4	1.5	10	50	1.45
★ SEM84601512E	R0.75	**1.5**	4	1.5	12	50	1.45
★ SEM84601514E	R0.75	**1.5**	4	1.5	14	50	1.45
★ SEM84601516E	R0.75	**1.5**	4	1.5	16	50	1.45
★ SEM84601518E	R0.75	**1.5**	4	1.5	18	50	1.45
★ SEM84601520E	R0.75	**1.5**	4	1.5	20	50	1.45
SEM84601522E	R0.75	**1.5**	4	1.5	22	60	1.45
SEM84601526E	R0.75	**1.5**	4	1.5	26	60	1.45
SEM84601530E	R0.75	**1.5**	4	1.5	30	70	1.45
SEM84601535E	R0.75	**1.5**	4	1.5	35	70	1.45

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE with EXTENDED NECK

SEM846 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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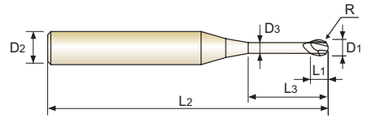

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84601540E	R0.75	**1.5**	4	1.5	40	80	1.45
SEM84601604E	R0.8	**1.6**	4	1.6	4	50	1.55
SEM84601606E	R0.8	**1.6**	4	1.6	6	50	1.55
★ SEM84601608E	R0.8	**1.6**	4	1.6	8	50	1.55
SEM84601610E	R0.8	**1.6**	4	1.6	10	50	1.55
★ SEM84601612E	R0.8	**1.6**	4	1.6	12	50	1.55
★ SEM84601616E	R0.8	**1.6**	4	1.6	16	50	1.55
SEM84601620E	R0.8	**1.6**	4	1.6	20	50	1.55
★ SEM84601804E	R0.9	**1.8**	4	1.8	4	50	1.75
SEM84601806E	R0.9	**1.8**	4	1.8	6	50	1.75
★ SEM84601808E	R0.9	**1.8**	4	1.8	8	50	1.75
SEM84601810E	R0.9	**1.8**	4	1.8	10	50	1.75
★ SEM84601812E	R0.9	**1.8**	4	1.8	12	50	1.75
★ SEM84601816E	R0.9	**1.8**	4	1.8	16	50	1.75
SEM84601820E	R0.9	**1.8**	4	1.8	20	50	1.75
★ SEM84602004E	R1.0	**2.0**	4	2	4	50	1.95
★ SEM84602006E	R1.0	**2.0**	4	2	6	50	1.95
★ SEM84602008E	R1.0	**2.0**	4	2	8	50	1.95
★ SEM84602010E	R1.0	**2.0**	4	2	10	50	1.95
★ SEM84602012E	R1.0	**2.0**	4	2	12	50	1.95
★ SEM84602014E	R1.0	**2.0**	4	2	14	50	1.95
★ SEM84602016E	R1.0	**2.0**	4	2	16	50	1.95
★ SEM84602018E	R1.0	**2.0**	4	2	18	50	1.95
★ SEM84602020E	R1.0	**2.0**	4	2	20	50	1.95

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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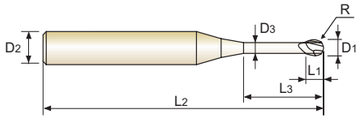

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84602022E	R1.0	**2.0**	4	2	22	60	1.95
★ SEM84602026E	R1.0	**2.0**	4	2	26	60	1.95
★ SEM84602030E	R1.0	**2.0**	4	2	30	70	1.95
★ SEM84602035E	R1.0	**2.0**	4	2	35	70	1.95
SEM84602040E	R1.0	**2.0**	4	2	40	80	1.95
SEM84602045E	R1.0	**2.0**	4	2	45	90	1.95
SEM84602050E	R1.0	**2.0**	4	2	50	100	1.95
SEM84602060E	R1.0	**2.0**	4	2	60	110	1.95
★ SEM84602508E	R1.25	**2.5**	4	2.5	8	50	2.40
★ SEM84602510E	R1.25	**2.5**	4	2.5	10	50	2.40
★ SEM84602512E	R1.25	**2.5**	4	2.5	12	50	2.40
★ SEM84602516E	R1.25	**2.5**	4	2.5	16	50	2.40
★ SEM84602520E	R1.25	**2.5**	4	2.5	20	50	2.40
SEM84602522E	R1.25	**2.5**	4	2.5	22	60	2.40
SEM84602526E	R1.25	**2.5**	4	2.5	26	60	2.40
SEM84602530E	R1.25	**2.5**	4	2.5	30	70	2.40
SEM84602535E	R1.25	**2.5**	4	2.5	35	70	2.40
SEM84602540E	R1.25	**2.5**	4	2.5	40	80	2.40
SEM84602545E	R1.25	**2.5**	4	2.5	45	90	2.40
SEM84602550E	R1.25	**2.5**	4	2.5	50	100	2.40
★ SEM84603006E	R1.5	**3.0**	6	3	6	50	2.85
★ SEM84603008E	R1.5	**3.0**	6	3	8	50	2.85
★ SEM84603010E	R1.5	**3.0**	6	3	10	50	2.85
★ SEM84603012E	R1.5	**3.0**	6	3	12	50	2.85

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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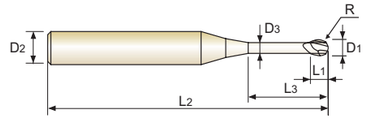

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN

P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84603014E	R1.5	**3.0**	6	3	14	60	2.85
SEM84603015E	R1.5	**3.0**	6	3	15	60	2.85
★ SEM84603016E	R1.5	**3.0**	6	3	16	60	2.85
★ SEM84603018E	R1.5	**3.0**	6	3	18	60	2.85
★ SEM84603020E	R1.5	**3.0**	6	3	20	60	2.85
★ SEM84603022E	R1.5	**3.0**	6	3	22	65	2.85
★ SEM84603026E	R1.5	**3.0**	6	3	26	65	2.85
★ SEM84603030E	R1.5	**3.0**	6	3	30	70	2.85
★ SEM84603035E	R1.5	**3.0**	6	3	35	70	2.85
★ SEM84603040E	R1.5	**3.0**	6	3	40	80	2.85
★ SEM84603045E	R1.5	**3.0**	6	3	45	90	2.85
★ SEM84603050E	R1.5	**3.0**	6	3	50	100	2.85
SEM84603060E	R1.5	**3.0**	6	3	60	100	2.85
★ SEM84604008E	R2.0	**4.0**	6	4	8	50	3.85
★ SEM84604010E	R2.0	**4.0**	6	4	10	50	3.85
★ SEM84604012E	R2.0	**4.0**	6	4	12	50	3.85
★ SEM84604014E	R2.0	**4.0**	6	4	14	60	3.85
★ SEM84604016E	R2.0	**4.0**	6	4	16	60	3.85
★ SEM84604018E	R2.0	**4.0**	6	4	18	60	3.85
★ SEM84604020E	R2.0	**4.0**	6	4	20	60	3.85
★ SEM84604022E	R2.0	**4.0**	6	4	22	65	3.85
★ SEM84604026E	R2.0	**4.0**	6	4	26	65	3.85
★ SEM84604030E	R2.0	**4.0**	6	4	30	70	3.85
★ SEM84604035E	R2.0	**4.0**	6	4	35	70	3.85

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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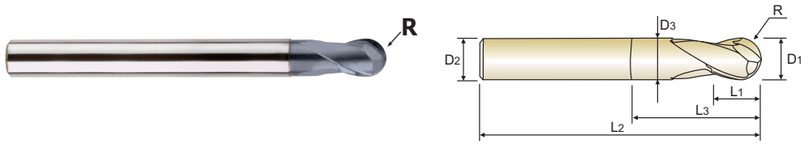

CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN | P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84604040E	R2.0	**4.0**	6	4	40	80	3.85
SEM84604045E	R2.0	**4.0**	6	4	45	90	3.85
★ SEM84604050E	R2.0	**4.0**	6	4	50	100	3.85
SEM84604055E	R2.0	**4.0**	6	4	55	100	3.85
SEM84604060E	R2.0	**4.0**	6	4	60	100	3.85
SEM84605015E	R2.5	**5.0**	6	6	15	60	4.85
★ SEM84605020E	R2.5	**5.0**	6	6	20	60	4.85
★ SEM84605026E	R2.5	**5.0**	6	6	26	65	4.85
★ SEM84605030E	R2.5	**5.0**	6	6	30	70	4.85
★ SEM84605035E	R2.5	**5.0**	6	6	35	70	4.85
★ SEM84605040E	R2.5	**5.0**	6	6	40	80	4.85
SEM84605045E	R2.5	**5.0**	6	6	45	90	4.85
★ SEM84605050E	R2.5	**5.0**	6	6	50	100	4.85
SEM84605055E	R2.5	**5.0**	6	6	55	100	4.85
SEM84605060E	R2.5	**5.0**	6	6	60	100	4.85
★ SEM84606020E	R3.0	**6.0**	6	8	20	60	5.85
★ SEM84606030E	R3.0	**6.0**	6	8	30	60	5.85
★ SEM84606020090E	R3.0	**6.0**	6	12	20	90	5.85
★ SEM84606030090E	R3.0	**6.0**	6	12	30	90	5.85
★ SEM84608025E	R4.0	**8.0**	8	10	25	70	7.70
★ SEM84608035E	R4.0	**8.0**	8	10	35	70	7.70
SEM84608025100E	R4.0	**8.0**	8	14	25	100	7.70
★ SEM84608035100E	R4.0	**8.0**	8	14	35	100	7.70
★ SEM84610030E	R5.0	**10.0**	10	12	30	75	9.70

★ : Stock Item

▶ NEXT PAGE

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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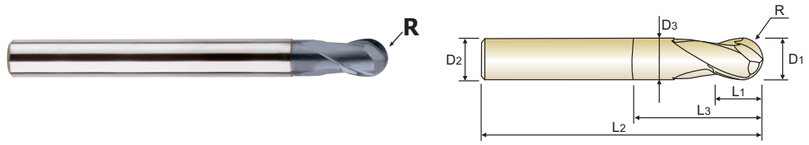


CARBIDE | 2 | 30° | R ±0.005 | R ±0.010 | PLAIN | P.120-131

R0.05~R3 R4~R6

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84610040E	R5.0	**10.0**	10	12	40	75	9.70
★ SEM84610030100E	R5.0	**10.0**	10	18	30	100	9.70
★ SEM84610040100E	R5.0	**10.0**	10	18	40	100	9.70
★ SEM84612032E	R6.0	**12.0**	12	14	32	80	11.70
SEM84612045E	R6.0	**12.0**	12	14	45	80	11.70
★ SEM84612032110E	R6.0	**12.0**	12	22	32	110	11.70
★ SEM84612045110E	R6.0	**12.0**	12	22	45	110	11.70

★ : Stock Item

Size	Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to R3	± 0.005	0 ~ - 0.012	h5
over R3	± 0.010	0 ~ - 0.015	

◎ : Excellent ○ : Good

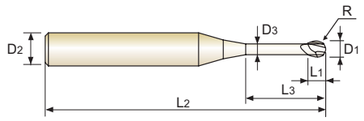
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE with EXTENDED NECK (6mm shank)

SEM846 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ With its unique ball nose geometry and cutting edges the cutting force has decreased, also increasing wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.



CARBIDE | 2 | 30° | R ±0.005 | PLAIN | P.120-131

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM846005016SE	R0.25	**0.5**	6	0.5	1	45	0.45
SEM846005026SE	R0.25	**0.5**	6	0.5	2	45	0.45
SEM846005046SE	R0.25	**0.5**	6	0.5	4	45	0.45
SEM846006016SE	R0.3	**0.6**	6	0.6	1	45	0.55
SEM846006026SE	R0.3	**0.6**	6	0.6	2	45	0.55
SEM846006036SE	R0.3	**0.6**	6	0.6	3	45	0.55
SEM846006046SE	R0.3	**0.6**	6	0.6	4	45	0.55
SEM846006056SE	R0.3	**0.6**	6	0.6	5	45	0.55
★ SEM846006066SE	R0.3	**0.6**	6	0.6	6	45	0.55
SEM846006086SE	R0.3	**0.6**	6	0.6	8	45	0.55
SEM846006106SE	R0.3	**0.6**	6	0.6	10	45	0.55
SEM846006126SE	R0.3	**0.6**	6	0.6	12	45	0.55
SEM846006146SE	R0.3	**0.6**	6	0.6	14	45	0.55
SEM846006166SE	R0.3	**0.6**	6	0.6	16	45	0.55
SEM846008016SE	R0.4	**0.8**	6	0.8	1	45	0.75
SEM846008026SE	R0.4	**0.8**	6	0.8	2	45	0.75
SEM846008036SE	R0.4	**0.8**	6	0.8	3	45	0.75
SEM846008046SE	R0.4	**0.8**	6	0.8	4	45	0.75
SEM846008056SE	R0.4	**0.8**	6	0.8	5	45	0.75
SEM846008066SE	R0.4	**0.8**	6	0.8	6	45	0.75
SEM846008086SE	R0.4	**0.8**	6	0.8	8	45	0.75
SEM846008106SE	R0.4	**0.8**	6	0.8	10	45	0.75
SEM846008126SE	R0.4	**0.8**	6	0.8	12	45	0.75
SEM846008146SE	R0.4	**0.8**	6	0.8	14	45	0.75

★ : Stock Item

▶ NEXT PAGE

Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.005	0 ~ - 0.012	h5

◎ : Excellent ○ : Good

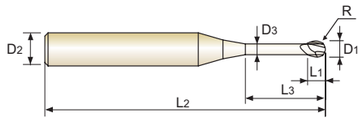
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE with EXTENDED NECK (6mm shank)

SEM846 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ With its unique ball nose geometry and cutting edges the cutting force has decreased, also increasing wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.



CARBIDE | 2 | 30° | R ±0.005 | PLAIN | P.120-131

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM846008166SE	R0.4	**0.8**	6	0.8	16	45	0.75
SEM846008206SE	R0.4	**0.8**	6	0.8	20	45	0.75
SEM846010026SE	R0.5	**1.0**	6	1	2	50	0.95
SEM846010036SE	R0.5	**1.0**	6	1	3	50	0.95
★ SEM846010046SE	R0.5	**1.0**	6	1	4	50	0.95
SEM846010056SE	R0.5	**1.0**	6	1	5	50	0.95
★ SEM846010066SE	R0.5	**1.0**	6	1	6	50	0.95
SEM846010076SE	R0.5	**1.0**	6	1	7	50	0.95
SEM846010086SE	R0.5	**1.0**	6	1	8	50	0.95
SEM846010096SE	R0.5	**1.0**	6	1	9	50	0.95
★ SEM846010106SE	R0.5	**1.0**	6	1	10	50	0.95
SEM846010126SE	R0.5	**1.0**	6	1	12	50	0.95
SEM846010146SE	R0.5	**1.0**	6	1	14	50	0.95
SEM846010166SE	R0.5	**1.0**	6	1	16	50	0.95
SEM846010186SE	R0.5	**1.0**	6	1	18	50	0.95
SEM846010206SE	R0.5	**1.0**	6	1	20	50	0.95
SEM846010226SE	R0.5	**1.0**	6	1	22	60	0.95
SEM846010266SE	R0.5	**1.0**	6	1	26	60	0.95
SEM846010306SE	R0.5	**1.0**	6	1	30	70	0.95
SEM846015036SE	R0.75	**1.5**	6	1.5	3	50	1.45
SEM846015046SE	R0.75	**1.5**	6	1.5	4	50	1.45
★ SEM846015066SE	R0.75	**1.5**	6	1.5	6	50	1.45
★ SEM846015086SE	R0.75	**1.5**	6	1.5	8	50	1.45
★ SEM846015106SE	R0.75	**1.5**	6	1.5	10	50	1.45

★ : Stock Item

▶ NEXT PAGE

Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.005	0 ~ - 0.012	h5

◎ : Excellent ○ : Good

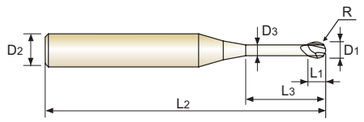
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE BALL NOSE with EXTENDED NECK (6mm shank)

SEM846 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ With its unique ball nose geometry and cutting edges the cutting force has decreased, also increasing wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.



CARBIDE | 2 | 30° | R ±0.005 | PLAIN | P.120-131

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM846015126SE	R0.75	**1.5**	6	1.5	12	50	1.45
SEM846015146SE	R0.75	**1.5**	6	1.5	14	50	1.45
SEM846015166SE	R0.75	**1.5**	6	1.5	16	50	1.45
SEM846015186SE	R0.75	**1.5**	6	1.5	18	50	1.45
SEM846015206SE	R0.75	**1.5**	6	1.5	20	50	1.45
SEM846015226SE	R0.75	**1.5**	6	1.5	22	60	1.45
SEM846015266SE	R0.75	**1.5**	6	1.5	26	60	1.45
SEM846015306SE	R0.75	**1.5**	6	1.5	30	70	1.45
SEM846015356SE	R0.75	**1.5**	6	1.5	35	70	1.45
SEM846015406SE	R0.75	**1.5**	6	1.5	40	80	1.45
SEM846020046SE	R1.0	**2.0**	6	2	4	50	1.95
★ SEM846020066SE	R1.0	**2.0**	6	2	6	50	1.95
★ SEM846020086SE	R1.0	**2.0**	6	2	8	50	1.95
★ SEM846020106SE	R1.0	**2.0**	6	2	10	50	1.95
★ SEM846020126SE	R1.0	**2.0**	6	2	12	50	1.95
SEM846020146SE	R1.0	**2.0**	6	2	14	50	1.95
★ SEM846020166SE	R1.0	**2.0**	6	2	16	50	1.95
SEM846020186SE	R1.0	**2.0**	6	2	18	50	1.95
★ SEM846020206SE	R1.0	**2.0**	6	2	20	50	1.95
SEM846020226SE	R1.0	**2.0**	6	2	22	60	1.95
SEM846020266SE	R1.0	**2.0**	6	2	26	60	1.95
SEM846020306SE	R1.0	**2.0**	6	2	30	70	1.95
SEM846020356SE	R1.0	**2.0**	6	2	35	70	1.95
SEM846020406SE	R1.0	**2.0**	6	2	40	80	1.95
SEM846020456SE	R1.0	**2.0**	6	2	45	90	1.95
SEM846020506SE	R1.0	**2.0**	6	2	50	100	1.95

★ : Stock Item

Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.005	0 ~ - 0.012	h5

◎ : Excellent ○ : Good

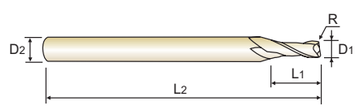
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	○	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

SEMD99 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available in short, regular and long shank end mills.
- ▶ Available with various corner radius end mills, from 0.02mm to 5.0mm corner radius.



CARBIDE | 2 | 30° | R ±0.010 (Ø0.2~Ø6) | R ±0.015 (Ø7~Ø20) | PLAIN | P.132-133

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD99002002E	R0.02	**0.2**	4	0.4	40	-
SEMD99002005E	R0.05	**0.2**	4	0.4	40	-
SEMD99003002E	R0.02	**0.3**	4	0.6	40	-
SEMD99003005E	R0.05	**0.3**	4	0.6	40	-
SEMD99004005E	R0.05	**0.4**	4	0.8	40	-
SEMD9900401E	R0.1	**0.4**	4	0.8	40	-
SEMD99005005E	R0.05	**0.5**	4	1	40	-
SEMD9900501E	R0.1	**0.5**	4	1	40	-
SEMD99006005E	R0.05	**0.6**	4	1.2	40	-
SEMD9900601E	R0.1	**0.6**	4	1.2	40	-
SEMD9900602E	R0.2	**0.6**	4	1.2	40	-
SEMD99007005E	R0.05	**0.7**	4	1.4	40	-
SEMD9900701E	R0.1	**0.7**	4	1.4	40	-
SEMD9900702E	R0.2	**0.7**	4	1.4	40	-
SEMD99008005E	R0.05	**0.8**	4	1.6	40	-
SEMD9900801E	R0.1	**0.8**	4	1.6	40	-
SEMD9900802E	R0.2	**0.8**	4	1.6	40	-
SEMD99009005E	R0.05	**0.9**	4	1.8	40	-
SEMD9900901E	R0.1	**0.9**	4	1.8	40	-
SEMD990100054SE	R0.05	**1.0**	4	2.5	50	4mm Shank
SEMD99010014SE	R0.1	**1.0**	4	2.5	50	4mm Shank
SEMD99010024SE	R0.2	**1.0**	4	2.5	50	4mm Shank
SEMD99010034SE	R0.3	**1.0**	4	2.5	50	4mm Shank
SEMD99010005E	R0.05	**1.0**	6	2.5	50	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

SEMD99 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available in short, regular and long shank end mills.
- ▶ Available with various corner radius end mills, from 0.02mm to 5.0mm corner radius.

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD9901001E	R0.1	**1.0**	6	2.5	50	-
★ SEMD9901002E	R0.2	**1.0**	6	2.5	50	-
★ SEMD9901003E	R0.3	**1.0**	6	2.5	50	-
SEMD990120054SE	R0.05	**1.2**	4	3	50	4mm Shank
SEMD99012014SE	R0.1	**1.2**	4	3	50	4mm Shank
SEMD99012024SE	R0.2	**1.2**	4	3	50	4mm Shank
SEMD99012034SE	R0.3	**1.2**	4	3	50	4mm Shank
SEMD99012005E	R0.05	**1.2**	6	3	50	-
SEMD9901201E	R0.1	**1.2**	6	3	50	-
SEMD9901202E	R0.2	**1.2**	6	3	50	-
SEMD9901203E	R0.3	**1.2**	6	3	50	-
SEMD990150054SE	R0.05	**1.5**	4	4	50	-
SEMD99015014SE	R0.1	**1.5**	4	4	50	4mm Shank
SEMD99015024SE	R0.2	**1.5**	4	4	50	4mm Shank
SEMD99015034SE	R0.3	**1.5**	4	4	50	4mm Shank
SEMD99015054SE	R0.5	**1.5**	4	4	50	4mm Shank
SEMD99015005E	R0.05	**1.5**	6	4	50	-
SEMD9901501E	R0.1	**1.5**	6	4	50	-
★ SEMD9901502E	R0.2	**1.5**	6	4	50	-
★ SEMD9901503E	R0.3	**1.5**	6	4	50	-
★ SEMD9901505E	R0.5	**1.5**	6	4	50	-
SEMD99020014SE	R0.1	**2.0**	4	6	50	4mm Shank
SEMD99020024SE	R0.2	**2.0**	4	6	50	4mm Shank
SEMD99020034SE	R0.3	**2.0**	4	6	50	4mm Shank

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

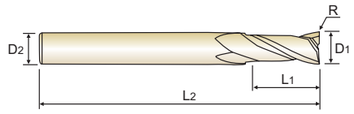
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

SEMD99 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available in short, regular and long shank end mills.
- ▶ Available with various corner radius end mills, from 0.02mm to 5.0mm corner radius.



CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD99020054SE	R0.5	**2.0**	4	6	50	4mm Shank
SEMD9902001E	R0.1	**2.0**	6	6	50	-
★ SEMD9902002E	R0.2	**2.0**	6	6	50	-
★ SEMD9902003E	R0.3	**2.0**	6	6	50	-
★ SEMD9902005E	R0.5	**2.0**	6	6	50	-
SEMD99025014SE	R0.1	**2.5**	4	7	60	4mm Shank
SEMD99025024SE	R0.2	**2.5**	4	7	60	4mm Shank
SEMD99025034SE	R0.3	**2.5**	4	7	60	4mm Shank
SEMD99025054SE	R0.5	**2.5**	4	7	60	4mm Shank
SEMD9902501E	R0.1	**2.5**	6	7	60	-
SEMD9902502E	R0.2	**2.5**	6	7	60	-
SEMD9902503E	R0.3	**2.5**	6	7	60	-
SEMD9902505E	R0.5	**2.5**	6	7	60	-
SEMD9903001E	R0.1	**3.0**	6	8	60	-
★ SEMD9903002E	R0.2	**3.0**	6	8	60	-
★ SEMD9903003E	R0.3	**3.0**	6	8	60	-
★ SEMD9903005E	R0.5	**3.0**	6	8	60	-
SEMD9903010E	R1.0	**3.0**	6	8	60	-
SEMD9903501E	R0.1	**3.5**	6	10	70	-
SEMD9903502E	R0.2	**3.5**	6	10	70	-
SEMD9903503E	R0.3	**3.5**	6	10	70	-
SEMD9903505E	R0.5	**3.5**	6	10	70	-
SEMD99040014SE	R0.1	**4.0**	4	10	70	4mm Shank
SEMD99040024SE	R0.2	**4.0**	4	10	70	4mm Shank

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

SEMD99 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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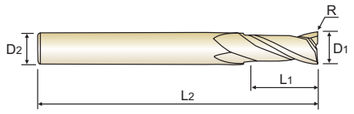

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD99040034SE	R0.3	**4.0**	4	10	70	4mm Shank
SEMD99040054SE	R0.5	**4.0**	4	10	70	4mm Shank
SEMD99040104SE	R1.0	**4.0**	4	10	70	4mm Shank
SEMD99040011004SE	R0.1	**4.0**	4	10	100	4mm Shank
SEMD99040021004SE	R0.2	**4.0**	4	10	100	4mm Shank
SEMD99040031004SE	R0.3	**4.0**	4	10	100	4mm Shank
SEMD99040051004SE	R0.5	**4.0**	4	10	100	4mm Shank
SEMD99040101004SE	R1.0	**4.0**	4	10	100	4mm Shank
SEMD9904001E	R0.1	**4.0**	6	10	70	Regular
★ SEMD9904002E	R0.2	**4.0**	6	10	70	Regular
★ SEMD9904003E	R0.3	**4.0**	6	10	70	Regular
★ SEMD9904005E	R0.5	**4.0**	6	10	70	Regular
★ SEMD9904010E	R1.0	**4.0**	6	10	70	Regular
SEMD9904501E	R0.1	**4.5**	6	11	80	-
SEMD9904502E	R0.2	**4.5**	6	11	80	-
SEMD9904503E	R0.3	**4.5**	6	11	80	-
SEMD9904505E	R0.5	**4.5**	6	11	80	-
SEMD9905001E	R0.1	**5.0**	6	13	90	-
★ SEMD9905002E	R0.2	**5.0**	6	13	90	-
★ SEMD9905003E	R0.3	**5.0**	6	13	90	-
★ SEMD9905005E	R0.5	**5.0**	6	13	90	-
★ SEMD9905010E	R1.0	**5.0**	6	13	90	-
SEMD9905501E	R0.1	**5.5**	6	13	90	-
SEMD9905502E	R0.2	**5.5**	6	13	90	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

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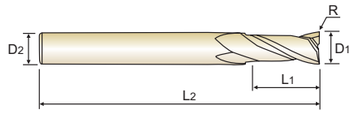

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD9905503E	R0.3	**5.5**	6	13	90	-
SEMD9905505E	R0.5	**5.5**	6	13	90	-
SEMD9905510E	R1.0	**5.5**	6	13	90	-
★ SEMD9906002060E	R0.2	**6.0**	6	15	60	Short
★ SEMD9906003060E	R0.3	**6.0**	6	15	60	Short
★ SEMD9906005060E	R0.5	**6.0**	6	15	60	Short
★ SEMD9906010060E	R1.0	**6.0**	6	15	60	Short
SEMD9906001E	R0.1	**6.0**	6	15	90	Regular
★ SEMD9906002E	R0.2	**6.0**	6	15	90	Regular
★ SEMD9906003E	R0.3	**6.0**	6	15	90	Regular
★ SEMD9906005E	R0.5	**6.0**	6	15	90	Regular
★ SEMD9906010E	R1.0	**6.0**	6	15	90	Regular
SEMD9906015E	R1.5	**6.0**	6	15	90	Regular
SEMD9906020E	R2.0	**6.0**	6	15	90	Regular
SEMD9906005E	R0.5	**6.0**	6	15	110	Long
SEMD9906010110E	R1.0	**6.0**	6	15	110	Long
SEMD9906005130E	R0.5	**6.0**	6	15	130	Long
SEMD9906010130E	R1.0	**6.0**	6	15	130	Long
SEMD9907001E	R0.1	**7.0**	8	16	90	-
SEMD9907002E	R0.2	**7.0**	8	16	90	-
SEMD9907003E	R0.3	**7.0**	8	16	90	-
SEMD9907005E	R0.5	**7.0**	8	16	90	-
SEMD9907010E	R1.0	**7.0**	8	16	90	-
SEMD9907020E	R2.0	**7.0**	8	16	90	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

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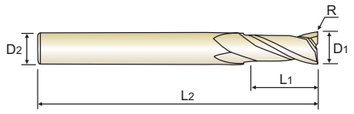

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN

P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Remark
	R	D1	D2	L1	L2	
SEMD9908003070E	R0.3	**8.0**	8	20	70	Short
★ SEMD9908005070E	R0.5	**8.0**	8	20	70	Short
★ SEMD9908010070E	R1.0	**8.0**	8	20	70	Short
SEMD9908001E	R0.1	**8.0**	8	20	100	Regular
SEMD9908002E	R0.2	**8.0**	8	20	100	Regular
SEMD9908003E	R0.3	**8.0**	8	20	100	Regular
★ SEMD9908005E	R0.5	**8.0**	8	20	100	Regular
★ SEMD9908010E	R1.0	**8.0**	8	20	100	Regular
★ SEMD9908015E	R1.5	**8.0**	8	20	100	Regular
★ SEMD9908020E	R2.0	**8.0**	8	20	100	Regular
SEMD9908025E	R2.5	**8.0**	8	20	100	Regular
SEMD9908030E	R3.0	**8.0**	8	20	100	Regular
SEMD9908005120E	R0.5	**8.0**	8	20	120	Long
SEMD9908010120E	R1.0	**8.0**	8	20	120	Long
SEMD9908015150E	R0.5	**8.0**	8	20	150	Long
SEMD9908010150E	R1.0	**8.0**	8	20	150	Long
SEMD9910003075E	R0.3	**10.0**	10	25	75	Short
★ SEMD9910005075E	R0.5	**10.0**	10	25	75	Short
★ SEMD9910010075E	R1.0	**10.0**	10	25	75	Short
SEMD9910001E	R0.1	**10.0**	10	25	100	Regular
SEMD9910002E	R0.2	**10.0**	10	25	100	Regular
SEMD9910003E	R0.3	**10.0**	10	25	100	Regular
★ SEMD9910005E	R0.5	**10.0**	10	25	100	Regular
★ SEMD9910010E	R1.0	**10.0**	10	25	100	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

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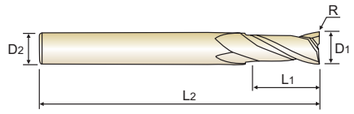


CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN

P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Remark
	R	D1	D2	L1	L2	
★ SEMD9910015E	R1.5	**10.0**	10	25	100	Regular
★ SEMD9910020E	R2.0	**10.0**	10	25	100	Regular
SEMD9910025E	R2.5	**10.0**	10	25	100	Regular
SEMD9910030E	R3.0	**10.0**	10	25	100	Regular
SEMD9910040E	R4.0	**10.0**	10	25	100	Regular
SEMD9910005130E	R0.5	**10.0**	10	25	130	Long
SEMD9910010130E	R1.0	**10.0**	10	25	130	Long
SEMD9910005150E	R0.5	**10.0**	10	25	150	Long
SEMD9910010150E	R1.0	**10.0**	10	25	150	Long
SEMD9911002E	R0.2	**11.0**	12	25	110	-
SEMD9911003E	R0.3	**11.0**	12	25	110	-
SEMD9911005E	R0.5	**11.0**	12	25	110	-
SEMD9911010E	R1.0	**11.0**	12	25	110	-
SEMD9911020E	R2.0	**11.0**	12	25	110	-
SEMD9912003080E	R0.3	**12.0**	12	30	80	Short
★ SEMD9912005080E	R0.5	**12.0**	12	30	80	Short
★ SEMD9912010080E	R1.0	**12.0**	12	30	80	Short
SEMD9912001E	R0.1	**12.0**	12	30	110	Regular
SEMD9912002E	R0.2	**12.0**	12	30	110	Regular
SEMD9912003E	R0.3	**12.0**	12	30	110	Regular
★ SEMD9912005E	R0.5	**12.0**	12	30	110	Regular
★ SEMD9912010E	R1.0	**12.0**	12	30	110	Regular
★ SEMD9912015E	R1.5	**12.0**	12	30	110	Regular
★ SEMD9912020E	R2.0	**12.0**	12	30	110	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

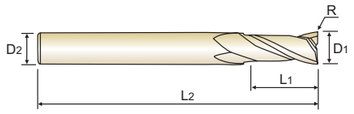
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)

SEMD99 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available in short, regular and long shank end mills.
- ▶ Available with various corner radius end mills, from 0.02mm to 5.0mm corner radius.



CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.132-133

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Radius of Ball Nose R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD9912025E	R2.5	**12.0**	12	30	110	Regular
★ SEMD9912030E	R3.0	**12.0**	12	30	110	Regular
SEMD9912040E	R4.0	**12.0**	12	30	110	Regular
SEMD9912050E	R5.0	**12.0**	12	30	110	Regular
SEMD9912005130E	R0.5	**12.0**	12	30	130	Long
SEMD9912010130E	R1.0	**12.0**	12	30	130	Long
SEMD9912005150E	R0.5	**12.0**	12	30	150	Long
SEMD9912010150E	R1.0	**12.0**	12	30	150	Long
SEMD9914005E	R0.5	**14.0**	16	35	150	-
★ SEMD9914010E	R1.0	**14.0**	16	35	150	-
SEMD9914020E	R2.0	**14.0**	16	35	150	-
SEMD9916005E	R0.5	**16.0**	16	32	150	-
★ SEMD9916010E	R1.0	**16.0**	16	32	150	-
SEMD9916015E	R1.5	**16.0**	16	32	150	-
★ SEMD9916020E	R2.0	**16.0**	16	32	150	-
SEMD9920005E	R0.5	**20.0**	20	38	150	-
★ SEMD9920010E	R1.0	**20.0**	20	38	150	-
SEMD9920015E	R1.5	**20.0**	20	38	150	-
★ SEMD9920020E	R2.0	**20.0**	20	38	150	-

★ : Stock Item

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

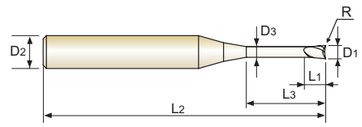
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available various products like regular length and long shank end mills etc.
- ▶ Available various corner radius end mills, from min. 0.02mm corner radius to max. 2.0mm corner radius.
- ▶ Available more various effective length and overall length end mills than previous standard products.



CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME61002002005E	R0.02	**0.2**	4	0.3	0.5	40	0.17	-
★ SEME6100200201E	R0.02	**0.2**	4	0.3	1	40	0.17	-
SEME61002002015E	R0.02	**0.2**	4	0.3	1.5	40	0.17	-
SEME6100200202E	R0.02	**0.2**	4	0.3	2	40	0.17	-
SEME61002005005E	R0.05	**0.2**	4	0.3	0.5	40	0.17	-
★ SEME6100200501E	R0.05	**0.2**	4	0.3	1	40	0.17	-
SEME61002005015E	R0.05	**0.2**	4	0.3	1.5	40	0.17	-
SEME6100200502E	R0.05	**0.2**	4	0.3	2	40	0.17	-
SEME61003005015SE	R0.05	**0.3**	4	0.25	1.5	40	0.27	-
★ SEME6100300201E	R0.02	**0.3**	4	0.5	1	40	0.27	-
★ SEME6100300202E	R0.02	**0.3**	4	0.5	2	40	0.27	-
SEME6100300203E	R0.02	**0.3**	4	0.5	3	40	0.27	-
★ SEME6100300501E	R0.05	**0.3**	4	0.5	1	40	0.27	-
★ SEME6100300502E	R0.05	**0.3**	4	0.5	2	40	0.27	-
SEME6100300503E	R0.05	**0.3**	4	0.5	3	40	0.27	-
SEME6100300502S6SE	R0.05	**0.3**	6	0.25	2	40	0.27	
★ SEME6100400501E	R0.05	**0.4**	4	0.6	1	40	0.37	-
★ SEME61004005015E	R0.05	**0.4**	4	0.6	1.5	40	0.37	-
★ SEME6100400502E	R0.05	**0.4**	4	0.6	2	40	0.37	-
★ SEME61004005025E	R0.05	**0.4**	4	0.6	2.5	40	0.37	-
SEME6100400503E	R0.05	**0.4**	4	0.6	3	40	0.37	-
SEME6100400504E	R0.05	**0.4**	4	0.6	4	40	0.37	-
★ SEME610040101E	R0.1	**0.4**	4	0.6	1	40	0.37	-
SEME6100401015E	R0.1	**0.4**	4	0.6	1.5	40	0.37	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
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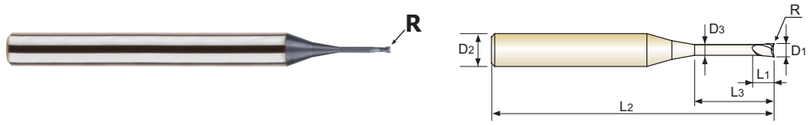

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610040102E	R0.1	**0.4**	4	0.6	2	40	0.37	-
SEME6100401025E	R0.1	**0.4**	4	0.6	2.5	40	0.37	-
SEME610040103E	R0.1	**0.4**	4	0.6	3	40	0.37	-
SEME610040104E	R0.1	**0.4**	4	0.6	4	40	0.37	-
★ SEME6100500501E	R0.05	**0.5**	4	0.7	1	45	0.45	-
★ SEME61005005015E	R0.05	**0.5**	4	0.7	1.5	45	0.45	-
★ SEME6100500502E	R0.05	**0.5**	4	0.7	2	45	0.45	-
SEME61005005025E	R0.05	**0.5**	4	0.7	2.5	45	0.45	-
SEME6100500503E	R0.05	**0.5**	4	0.7	3	45	0.45	-
★ SEME6100500504E	R0.05	**0.5**	4	0.7	4	45	0.45	-
SEME6100500505E	R0.05	**0.5**	4	0.7	5	45	0.45	-
SEME6100500506E	R0.05	**0.5**	4	0.7	6	45	0.45	-
SEME6100500504S6SE	R0.05	**0.5**	6	0.4	4	45	0.45	-
SEME610050101E	R0.1	**0.5**	4	0.7	1	45	0.45	-
SEME6100501015E	R0.1	**0.5**	4	0.7	1.5	45	0.45	-
★ SEME610050102E	R0.1	**0.5**	4	0.7	2	45	0.45	-
SEME6100501025E	R0.1	**0.5**	4	0.7	2.5	45	0.45	-
★ SEME610050103E	R0.1	**0.5**	4	0.7	3	45	0.45	-
SEME610050104E	R0.1	**0.5**	4	0.7	4	45	0.45	-
★ SEME610050105E	R0.1	**0.5**	4	0.7	5	45	0.45	-
SEME610050106E	R0.1	**0.5**	4	0.7	6	45	0.45	-
SEME610050102S6SE	R0.1	**0.5**	6	0.4	2	45	0.45	-
SEME610050104S6SE	R0.1	**0.5**	6	0.4	4	45	0.45	-
SEME6100600502E	R0.05	**0.6**	4	0.9	2	45	0.55	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available various products like regular length and long shank end mills etc.
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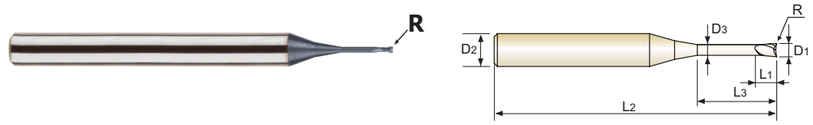

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME6100600503E	R0.05	**0.6**	4	0.9	3	45	0.55	-
SEME6100600504E	R0.05	**0.6**	4	0.9	4	45	0.55	-
★ SEME6100600506E	R0.05	**0.6**	4	0.9	6	45	0.55	-
SEME6100600508E	R0.05	**0.6**	4	0.9	8	45	0.55	-
SEME6100600510E	R0.05	**0.6**	4	0.9	10	45	0.55	-
★ SEME610060102E	R0.1	**0.6**	4	0.9	2	45	0.55	-
★ SEME610060103E	R0.1	**0.6**	4	0.9	3	45	0.55	-
★ SEME610060104E	R0.1	**0.6**	4	0.9	4	45	0.55	-
★ SEME610060106E	R0.1	**0.6**	4	0.9	6	45	0.55	-
SEME610060108E	R0.1	**0.6**	4	0.9	8	45	0.55	-
SEME610060110E	R0.1	**0.6**	4	0.9	10	45	0.55	-
★ SEME610060202E	R0.2	**0.6**	4	0.9	2	45	0.55	-
★ SEME610060203E	R0.2	**0.6**	4	0.9	3	45	0.55	-
★ SEME610060204E	R0.2	**0.6**	4	0.9	4	45	0.55	-
★ SEME610060206E	R0.2	**0.6**	4	0.9	6	45	0.55	-
SEME610060208E	R0.2	**0.6**	4	0.9	8	45	0.55	-
SEME610060210E	R0.2	**0.6**	4	0.9	10	45	0.55	-
SEME6100700502E	R0.05	**0.7**	4	1.2	2	45	0.65	-
SEME6100700504E	R0.05	**0.7**	4	1.2	4	45	0.65	-
SEME6100700506E	R0.05	**0.7**	4	1.2	6	45	0.65	-
SEME6100700508E	R0.05	**0.7**	4	1.2	8	45	0.65	-
SEME6100700510E	R0.05	**0.7**	4	1.2	10	45	0.65	-
SEME610070102E	R0.1	**0.7**	4	1.2	2	45	0.65	-
SEME610070104E	R0.1	**0.7**	4	1.2	4	45	0.65	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
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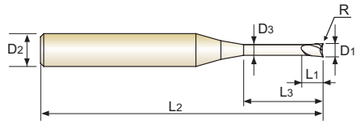

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610070106E	R0.1	**0.7**	4	1.2	6	45	0.65	-
SEME610070108E	R0.1	**0.7**	4	1.2	8	45	0.65	-
SEME610070110E	R0.1	**0.7**	4	1.2	10	45	0.65	-
SEME610070202E	R0.2	**0.7**	4	1.2	2	45	0.65	-
SEME610070204E	R0.2	**0.7**	4	1.2	4	45	0.65	-
SEME610070206E	R0.2	**0.7**	4	1.2	6	45	0.65	-
SEME610070208E	R0.2	**0.7**	4	1.2	8	45	0.65	-
SEME610070210E	R0.2	**0.7**	4	1.2	10	45	0.65	-
★ SEME6100800502E	R0.05	**0.8**	4	1.2	2	45	0.75	-
SEME6100800503E	R0.05	**0.8**	4	1.2	3	45	0.75	-
★ SEME6100800504E	R0.05	**0.8**	4	1.2	4	45	0.75	-
★ SEME6100800506E	R0.05	**0.8**	4	1.2	6	45	0.75	-
SEME6100800508E	R0.05	**0.8**	4	1.2	8	45	0.75	-
SEME6100800510E	R0.05	**0.8**	4	1.2	10	45	0.75	-
★ SEME610080102E	R0.1	**0.8**	4	1.2	2	45	0.75	-
★ SEME610080103E	R0.1	**0.8**	4	1.2	3	45	0.75	-
★ SEME610080104E	R0.1	**0.8**	4	1.2	4	45	0.75	-
★ SEME610080106E	R0.1	**0.8**	4	1.2	6	45	0.75	-
★ SEME610080108E	R0.1	**0.8**	4	1.2	8	45	0.75	-
SEME610080110E	R0.1	**0.8**	4	1.2	10	45	0.75	-
★ SEME610080202E	R0.2	**0.8**	4	1.2	2	45	0.75	-
★ SEME610080203E	R0.2	**0.8**	4	1.2	3	45	0.75	-
★ SEME610080204E	R0.2	**0.8**	4	1.2	4	45	0.75	-
★ SEME610080206E	R0.2	**0.8**	4	1.2	6	45	0.75	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

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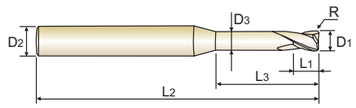

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610080208E	R0.2	**0.8**	4	1.2	8	45	0.75	-
★ SEME610080210E	R0.2	**0.8**	4	1.2	10	45	0.75	-
★ SEME6101000503E	R0.05	**1.0**	4	1.5	3	50	0.95	-
★ SEME6101000504E	R0.05	**1.0**	4	1.5	4	50	0.95	-
SEME6101000505E	R0.05	**1.0**	4	1.5	5	50	0.95	
★ SEME6101000506E	R0.05	**1.0**	4	1.5	6	50	0.95	-
SEME6101000508E	R0.05	**1.0**	4	1.5	8	50	0.95	-
SEME6101000510E	R0.05	**1.0**	4	1.5	10	50	0.95	-
SEME6101000512E	R0.05	**1.0**	4	1.5	12	50	0.95	-
SEME6101000514E	R0.05	**1.0**	4	1.5	14	50	0.95	-
SEME6101000516E	R0.05	**1.0**	4	1.5	16	50	0.95	-
SEME6101000520E	R0.05	**1.0**	4	1.5	20	50	0.95	-
★ SEME610100103E	R0.1	**1.0**	4	1.5	3	50	0.95	-
★ SEME610100104E	R0.1	**1.0**	4	1.5	4	50	0.95	-
SEME610100105E	R0.1	**1.0**	4	1.5	5	50	0.95	-
★ SEME610100106E	R0.1	**1.0**	4	1.5	6	50	0.95	-
★ SEME610100108E	R0.1	**1.0**	4	1.5	8	50	0.95	-
★ SEME610100110E	R0.1	**1.0**	4	1.5	10	50	0.95	-
SEME610100112E	R0.1	**1.0**	4	1.5	12	50	0.95	-
SEME610100114E	R0.1	**1.0**	4	1.5	14	50	0.95	-
SEME610100116E	R0.1	**1.0**	4	1.5	16	50	0.95	-
SEME610100120E	R0.1	**1.0**	4	1.5	20	50	0.95	-
★ SEME610100203E	R0.2	**1.0**	4	1.5	3	50	0.95	-
★ SEME610100204E	R0.2	**1.0**	4	1.5	4	50	0.95	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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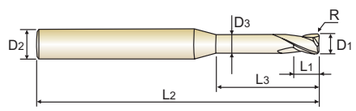

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610100205E	R0.2	**1.0**	4	1.5	5	50	0.95	
★ SEME610100206E	R0.2	**1.0**	4	1.5	6	50	0.95	-
★ SEME610100208E	R0.2	**1.0**	4	1.5	8	50	0.95	-
★ SEME610100210E	R0.2	**1.0**	4	1.5	10	50	0.95	-
★ SEME610100212E	R0.2	**1.0**	4	1.5	12	50	0.95	-
SEME610100214E	R0.2	**1.0**	4	1.5	14	50	0.95	-
SEME610100216E	R0.2	**1.0**	4	1.5	16	50	0.95	-
SEME610100220E	R0.2	**1.0**	4	1.5	20	50	0.95	-
SEME610100303E	R0.3	**1.0**	4	1.5	3	50	0.95	-
★ SEME610100304E	R0.3	**1.0**	4	1.5	4	50	0.95	-
★ SEME610100306E	R0.3	**1.0**	4	1.5	6	50	0.95	-
★ SEME610100308E	R0.3	**1.0**	4	1.5	8	50	0.95	-
★ SEME610100310E	R0.3	**1.0**	4	1.5	10	50	0.95	-
★ SEME610100312E	R0.3	**1.0**	4	1.5	12	50	0.95	-
SEME610100314E	R0.3	**1.0**	4	1.5	14	50	0.95	-
SEME610100316E	R0.3	**1.0**	4	1.5	16	50	0.95	-
SEME610100320E	R0.3	**1.0**	4	1.5	20	50	0.95	-
SEME6101200503E	R0.05	**1.2**	4	1.8	3	50	1.15	-
SEME6101200504E	R0.05	**1.2**	4	1.8	4	50	1.15	-
★ SEME6101200506E	R0.05	**1.2**	4	1.8	6	50	1.15	-
★ SEME6101200508E	R0.05	**1.2**	4	1.8	8	50	1.15	-
★ SEME6101200510E	R0.05	**1.2**	4	1.8	10	50	1.15	-
SEME6101200512E	R0.05	**1.2**	4	1.8	12	50	1.15	-
SEME6101200516E	R0.05	**1.2**	4	1.8	16	50	1.15	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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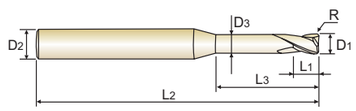

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME6101200520E	R0.05	**1.2**	4	1.8	20	50	1.15	-
SEME610120103E	R0.1	**1.2**	4	1.8	3	50	1.15	-
★ SEME610120104E	R0.1	**1.2**	4	1.8	4	50	1.15	-
★ SEME610120106E	R0.1	**1.2**	4	1.8	6	50	1.15	-
★ SEME610120108E	R0.1	**1.2**	4	1.8	8	50	1.15	-
SEME610120110E	R0.1	**1.2**	4	1.8	10	50	1.15	-
SEME610120112E	R0.1	**1.2**	4	1.8	12	50	1.15	-
SEME610120116E	R0.1	**1.2**	4	1.8	16	50	1.15	-
SEME610120120E	R0.1	**1.2**	4	1.8	20	50	1.15	-
SEME610120203E	R0.2	**1.2**	4	1.8	3	50	1.15	-
★ SEME610120204E	R0.2	**1.2**	4	1.8	4	50	1.15	-
★ SEME610120206E	R0.2	**1.2**	4	1.8	6	50	1.15	-
★ SEME610120208E	R0.2	**1.2**	4	1.8	8	50	1.15	-
★ SEME610120210E	R0.2	**1.2**	4	1.8	10	50	1.15	-
★ SEME610120212E	R0.2	**1.2**	4	1.8	12	50	1.15	-
SEME610120216E	R0.2	**1.2**	4	1.8	16	50	1.15	-
SEME610120220E	R0.2	**1.2**	4	1.8	20	50	1.15	-
SEME610120303E	R0.3	**1.2**	4	1.8	3	50	1.15	-
★ SEME610120304E	R0.3	**1.2**	4	1.8	4	50	1.15	-
★ SEME610120306E	R0.3	**1.2**	4	1.8	6	50	1.15	-
★ SEME610120308E	R0.3	**1.2**	4	1.8	8	50	1.15	-
★ SEME610120310E	R0.3	**1.2**	4	1.8	10	50	1.15	-
SEME610120312E	R0.3	**1.2**	4	1.8	12	50	1.15	-
SEME610120316E	R0.3	**1.2**	4	1.8	16	50	1.15	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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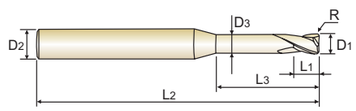

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610120320E	R0.3	1.2	4	1.8	20	50	1.15	-
★ SEME6101500504E	R0.05	1.5	4	2.3	4	50	1.45	-
★ SEME6101500506E	R0.05	1.5	4	2.3	6	50	1.45	-
★ SEME6101500508E	R0.05	1.5	4	2.3	8	50	1.45	-
SEME6101500510E	R0.05	1.5	4	2.3	10	50	1.45	-
SEME6101500512E	R0.05	1.5	4	2.3	12	50	1.45	-
SEME6101500514E	R0.05	1.5	4	2.3	14	50	1.45	-
SEME6101500516E	R0.05	1.5	4	2.3	16	50	1.45	-
SEME6101500520E	R0.05	1.5	4	2.3	20	50	1.45	-
SEME6101500522E	R0.05	1.5	4	2.3	22	60	1.45	-
SEME6101500526E	R0.05	1.5	4	2.3	26	60	1.45	-
★ SEME610150104E	R0.1	1.5	4	2.3	4	50	1.45	-
★ SEME610150106E	R0.1	1.5	4	2.3	6	50	1.45	-
★ SEME610150108E	R0.1	1.5	4	2.3	8	50	1.45	-
★ SEME610150110E	R0.1	1.5	4	2.3	10	50	1.45	-
★ SEME610150112E	R0.1	1.5	4	2.3	12	50	1.45	-
SEME610150114E	R0.1	1.5	4	2.3	14	50	1.45	-
SEME610150116E	R0.1	1.5	4	2.3	16	50	1.45	-
SEME610150120E	R0.1	1.5	4	2.3	20	50	1.45	-
SEME610150122E	R0.1	1.5	4	2.3	22	60	1.45	-
SEME610150126E	R0.1	1.5	4	2.3	26	60	1.45	-
★ SEME610150204E	R0.2	1.5	4	2.3	4	50	1.45	-
★ SEME610150206E	R0.2	1.5	4	2.3	6	50	1.45	-
★ SEME610150208E	R0.2	1.5	4	2.3	8	50	1.45	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

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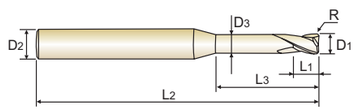

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610150210E	R0.2	1.5	4	2.3	10	50	1.45	-
★ SEME610150212E	R0.2	1.5	4	2.3	12	50	1.45	-
★ SEME610150214E	R0.2	1.5	4	2.3	14	50	1.45	-
★ SEME610150216E	R0.2	1.5	4	2.3	16	50	1.45	-
★ SEME610150220E	R0.2	1.5	4	2.3	20	50	1.45	-
SEME610150222E	R0.2	1.5	4	2.3	22	60	1.45	-
SEME610150226E	R0.2	1.5	4	2.3	26	60	1.45	-
★ SEME610150304E	R0.3	1.5	4	2.3	4	50	1.45	-
★ SEME610150306E	R0.3	1.5	4	2.3	6	50	1.45	-
★ SEME610150308E	R0.3	1.5	4	2.3	8	50	1.45	-
★ SEME610150310E	R0.3	1.5	4	2.3	10	50	1.45	-
★ SEME610150312E	R0.3	1.5	4	2.3	12	50	1.45	-
★ SEME610150314E	R0.3	1.5	4	2.3	14	50	1.45	-
★ SEME610150316E	R0.3	1.5	4	2.3	16	50	1.45	-
SEME610150320E	R0.3	1.5	4	2.3	20	50	1.45	-
SEME610150322E	R0.3	1.5	4	2.3	22	60	1.45	-
SEME610150326E	R0.3	1.5	4	2.3	26	60	1.45	-
★ SEME610150504E	R0.5	1.5	4	2.3	4	50	1.45	-
★ SEME610150506E	R0.5	1.5	4	2.3	6	50	1.45	-
★ SEME610150508E	R0.5	1.5	4	2.3	8	50	1.45	-
★ SEME610150510E	R0.5	1.5	4	2.3	10	50	1.45	-
★ SEME610150512E	R0.5	1.5	4	2.3	12	50	1.45	-
SEME610150514E	R0.5	1.5	4	2.3	14	50	1.45	-
★ SEME610150516E	R0.5	1.5	4	2.3	16	50	1.45	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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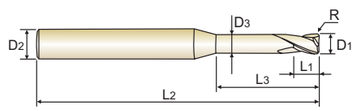

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610150520E	R0.5	**1.5**	4	2.3	20	50	1.45	-
SEME610150522E	R0.5	**1.5**	4	2.3	22	60	1.45	-
SEME610150526E	R0.5	**1.5**	4	2.3	26	60	1.45	-
★ SEME610200106E	R0.1	**2.0**	4	3	6	50	1.95	-
★ SEME610200108E	R0.1	**2.0**	4	3	8	50	1.95	-
★ SEME610200110E	R0.1	**2.0**	4	3	10	50	1.95	-
★ SEME610200112E	R0.1	**2.0**	4	3	12	50	1.95	-
SEME610200114E	R0.1	**2.0**	4	3	14	50	1.95	-
SEME610200116E	R0.1	**2.0**	4	3	16	50	1.95	-
SEME610200120E	R0.1	**2.0**	4	3	20	50	1.95	-
SEME610200122E	R0.1	**2.0**	4	3	22	60	1.95	-
SEME610200126E	R0.1	**2.0**	4	3	26	60	1.95	-
SEME610200130E	R0.1	**2.0**	4	3	30	70	1.95	-
★ SEME610200206E	R0.2	**2.0**	4	3	6	50	1.95	-
★ SEME610200208E	R0.2	**2.0**	4	3	8	50	1.95	-
★ SEME610200210E	R0.2	**2.0**	4	3	10	50	1.95	-
★ SEME610200212E	R0.2	**2.0**	4	3	12	50	1.95	-
★ SEME610200214E	R0.2	**2.0**	4	3	14	50	1.95	-
★ SEME610200216E	R0.2	**2.0**	4	3	16	50	1.95	-
★ SEME610200220E	R0.2	**2.0**	4	3	20	50	1.95	-
SEME610200222E	R0.2	**2.0**	4	3	22	60	1.95	-
SEME610200226E	R0.2	**2.0**	4	3	26	60	1.95	-
SEME610200230E	R0.2	**2.0**	4	3	30	70	1.95	-
★ SEME610200306E	R0.3	**2.0**	4	3	6	50	1.95	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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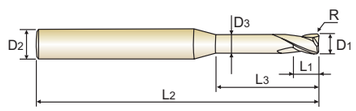

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610200308E	R0.3	**2.0**	4	3	8	50	1.95	-
★ SEME610200310E	R0.3	**2.0**	4	3	10	50	1.95	-
★ SEME610200312E	R0.3	**2.0**	4	3	12	50	1.95	-
SEME610200314E	R0.3	**2.0**	4	3	14	50	1.95	-
★ SEME610200316E	R0.3	**2.0**	4	3	16	50	1.95	-
★ SEME610200320E	R0.3	**2.0**	4	3	20	50	1.95	-
SEME610200322E	R0.3	**2.0**	4	3	22	60	1.95	-
SEME610200326E	R0.3	**2.0**	4	3	26	60	1.95	-
SEME610200330E	R0.3	**2.0**	4	3	30	70	1.95	-
★ SEME610200506E	R0.5	**2.0**	4	3	6	50	1.95	-
★ SEME610200508E	R0.5	**2.0**	4	3	8	50	1.95	-
★ SEME610200510E	R0.5	**2.0**	4	3	10	50	1.95	-
★ SEME610200512E	R0.5	**2.0**	4	3	12	50	1.95	-
★ SEME610200514E	R0.5	**2.0**	4	3	14	50	1.95	-
★ SEME610200516E	R0.5	**2.0**	4	3	16	50	1.95	-
★ SEME610200520E	R0.5	**2.0**	4	3	20	50	1.95	-
SEME610200522E	R0.5	**2.0**	4	3	22	60	1.95	-
★ SEME610200526E	R0.5	**2.0**	4	3	26	60	1.95	-
★ SEME610200530E	R0.5	**2.0**	4	3	30	70	1.95	-
SE5E6102005086SE	R0.5	**2.0**	6	3	8	50	1.95	
SEME610250108E	R0.1	**2.5**	4	4	8	50	2.40	-
SEME610250110E	R0.1	**2.5**	4	4	10	50	2.40	-
SEME610250112E	R0.1	**2.5**	4	4	12	50	2.40	-
SEME610250114E	R0.1	**2.5**	4	4	14	50	2.40	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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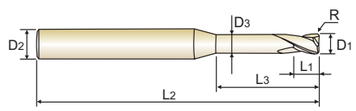

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610250116E	R0.1	2.5	4	4	16	50	2.40	-
SEME610250120E	R0.1	2.5	4	4	20	50	2.40	-
SEME610250126E	R0.1	2.5	4	4	26	60	2.40	-
SEME610250130E	R0.1	2.5	4	4	30	70	2.40	-
SEME610250208E	R0.2	2.5	4	4	8	50	2.40	-
SEME610250210E	R0.2	2.5	4	4	10	50	2.40	-
SEME610250212E	R0.2	2.5	4	4	12	50	2.40	-
SEME610250214E	R0.2	2.5	4	4	14	50	2.40	-
SEME610250216E	R0.2	2.5	4	4	16	50	2.40	-
SEME610250220E	R0.2	2.5	4	4	20	50	2.40	-
SEME610250226E	R0.2	2.5	4	4	26	60	2.40	-
SEME610250230E	R0.2	2.5	4	4	30	70	2.40	-
SEME610250308E	R0.3	2.5	4	4	8	50	2.40	-
SEME610250310E	R0.3	2.5	4	4	10	50	2.40	-
SEME610250312E	R0.3	2.5	4	4	12	50	2.40	-
SEME610250314E	R0.3	2.5	4	4	14	50	2.40	-
SEME610250316E	R0.3	2.5	4	4	16	50	2.40	-
SEME610250320E	R0.3	2.5	4	4	20	50	2.40	-
SEME610250326E	R0.3	2.5	4	4	26	60	2.40	-
SEME610250330E	R0.3	2.5	4	4	30	70	2.40	-
★ SEME610250508E	R0.5	2.5	4	4	8	50	2.40	-
SEME610250510E	R0.5	2.5	4	4	10	50	2.40	-
SEME610250512E	R0.5	2.5	4	4	12	50	2.40	-
SEME610250514E	R0.5	2.5	4	4	14	50	2.40	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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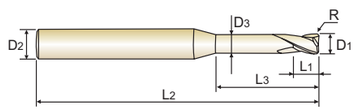

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610250516E	R0.5	2.5	4	4	16	50	2.40	-
SEME610250520E	R0.5	2.5	4	4	20	50	2.40	-
SEME610250526E	R0.5	2.5	4	4	26	60	2.40	-
SEME610250530E	R0.5	2.5	4	4	30	70	2.40	-
SEME610300108E	R0.1	3.0	6	4.5	8	50	2.85	-
★ SEME610300110E	R0.1	3.0	6	4.5	10	50	2.85	-
★ SEME610300112E	R0.1	3.0	6	4.5	12	50	2.85	-
SEME610300114E	R0.1	3.0	6	4.5	14	60	2.85	-
★ SEME610300116E	R0.1	3.0	6	4.5	16	60	2.85	-
★ SEME610300120E	R0.1	3.0	6	4.5	20	60	2.85	-
SEME610300126E	R0.1	3.0	6	4.5	26	65	2.85	-
SEME610300130E	R0.1	3.0	6	4.5	30	70	2.85	-
SEME610300135E	R0.1	3.0	6	4.5	35	70	2.85	-
SEME610300140E	R0.1	3.0	6	4.5	40	80	2.85	-
★ SEME610300208E	R0.2	3.0	6	4.5	8	50	2.85	-
★ SEME610300210E	R0.2	3.0	6	4.5	10	50	2.85	-
★ SEME610300212E	R0.2	3.0	6	4.5	12	50	2.85	-
SEME610300214E	R0.2	3.0	6	4.5	14	60	2.85	-
★ SEME610300216E	R0.2	3.0	6	4.5	16	60	2.85	-
★ SEME610300220E	R0.2	3.0	6	4.5	20	60	2.85	-
★ SEME610300226E	R0.2	3.0	6	4.5	26	65	2.85	-
SEME610300230E	R0.2	3.0	6	4.5	30	70	2.85	-
SEME610300235E	R0.2	3.0	6	4.5	35	70	2.85	-
SEME610300240E	R0.2	3.0	6	4.5	40	80	2.85	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

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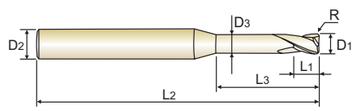

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610300308E	R0.3	**3.0**	6	4.5	8	50	2.85	-
★ SEME610300310E	R0.3	**3.0**	6	4.5	10	50	2.85	-
★ SEME610300312E	R0.3	**3.0**	6	4.5	12	50	2.85	-
★ SEME610300314E	R0.3	**3.0**	6	4.5	14	60	2.85	-
★ SEME610300316E	R0.3	**3.0**	6	4.5	16	60	2.85	-
★ SEME610300320E	R0.3	**3.0**	6	4.5	20	60	2.85	-
★ SEME610300326E	R0.3	**3.0**	6	4.5	26	65	2.85	-
SEME610300330E	R0.3	**3.0**	6	4.5	30	70	2.85	-
SEME610300335E	R0.3	**3.0**	6	4.5	35	70	2.85	-
SEME610300340E	R0.3	**3.0**	6	4.5	40	80	2.85	-
★ SEME610300508E	R0.5	**3.0**	6	4.5	8	50	2.85	-
★ SEME610300510E	R0.5	**3.0**	6	4.5	10	50	2.85	-
★ SEME610300512E	R0.5	**3.0**	6	4.5	12	50	2.85	-
★ SEME610300514E	R0.5	**3.0**	6	4.5	14	60	2.85	-
★ SEME610300516E	R0.5	**3.0**	6	4.5	16	60	2.85	-
★ SEME610300520E	R0.5	**3.0**	6	4.5	20	60	2.85	-
★ SEME610300526E	R0.5	**3.0**	6	4.5	26	65	2.85	-
★ SEME610300530E	R0.5	**3.0**	6	4.5	30	70	2.85	-
★ SEME610300535E	R0.5	**3.0**	6	4.5	35	70	2.85	-
SEME610300540E	R0.5	**3.0**	6	4.5	40	80	2.85	-
★ SEME610301008E	R1.0	**3.0**	6	4.5	8	50	2.85	-
★ SEME610301010E	R1.0	**3.0**	6	4.5	10	50	2.85	-
★ SEME610301012E	R1.0	**3.0**	6	4.5	12	50	2.85	-
SEME610301014E	R1.0	**3.0**	6	4.5	14	60	2.85	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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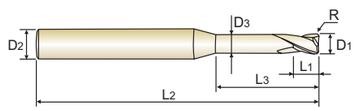

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN | P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME610301016E	R1.0	**3.0**	6	4.5	16	60	2.85	-
★ SEME610301020E	R1.0	**3.0**	6	4.5	20	60	2.85	-
★ SEME610301026E	R1.0	**3.0**	6	4.5	26	65	2.85	-
SEME610301030E	R1.0	**3.0**	6	4.5	30	70	2.85	-
SEME610301035E	R1.0	**3.0**	6	4.5	35	70	2.85	-
SEME610301040E	R1.0	**3.0**	6	4.5	40	80	2.85	-
★ SEME610400110E	R0.1	**4.0**	6	6	10	50	3.85	-
★ SEME610400112E	R0.1	**4.0**	6	6	12	50	3.85	-
SEME610400114E	R0.1	**4.0**	6	6	14	60	3.85	-
★ SEME610400116E	R0.1	**4.0**	6	6	16	60	3.85	-
★ SEME610400120E	R0.1	**4.0**	6	6	20	60	3.85	-
SEME610400126E	R0.1	**4.0**	6	6	26	65	3.85	-
SEME610400130E	R0.1	**4.0**	6	6	30	70	3.85	-
SEME610400135E	R0.1	**4.0**	6	6	35	70	3.85	-
SEME610400140E	R0.1	**4.0**	6	6	40	80	3.85	-
SEME610400145E	R0.1	**4.0**	6	6	45	90	3.85	-
SEME610400150E	R0.1	**4.0**	6	6	50	100	3.85	-
★ SEME610400210E	R0.2	**4.0**	6	6	10	50	3.85	-
★ SEME610400212E	R0.2	**4.0**	6	6	12	50	3.85	-
SEME610400214E	R0.2	**4.0**	6	6	14	60	3.85	-
★ SEME610400216E	R0.2	**4.0**	6	6	16	60	3.85	-
★ SEME610400220E	R0.2	**4.0**	6	6	20	60	3.85	-
★ SEME610400226E	R0.2	**4.0**	6	6	26	65	3.85	-
SEME610400230E	R0.2	**4.0**	6	6	30	70	3.85	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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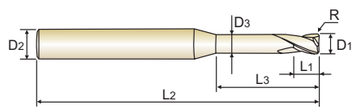

CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610400235E	R0.2	**4.0**	6	6	35	70	3.85	-
SEME610400240E	R0.2	**4.0**	6	6	40	80	3.85	-
SEME610400245E	R0.2	**4.0**	6	6	45	90	3.85	-
SEME610400250E	R0.2	**4.0**	6	6	50	100	3.85	-
SEME610400310E	R0.3	**4.0**	6	6	10	50	3.85	-
★ SEME610400312E	R0.3	**4.0**	6	6	12	50	3.85	-
SEME610400314E	R0.3	**4.0**	6	6	14	50	3.85	-
★ SEME610400316E	R0.3	**4.0**	6	6	16	50	3.85	-
★ SEME610400320E	R0.3	**4.0**	6	6	20	50	3.85	-
★ SEME610400326E	R0.3	**4.0**	6	6	26	65	3.85	-
SEME610400330E	R0.3	**4.0**	6	6	30	70	3.85	-
SEME610400335E	R0.3	**4.0**	6	6	35	70	3.85	-
SEME610400340E	R0.3	**4.0**	6	6	40	80	3.85	-
SEME610400345E	R0.3	**4.0**	6	6	45	90	3.85	-
SEME610400350E	R0.3	**4.0**	6	6	50	100	3.85	-
★ SEME610400510E	R0.5	**4.0**	6	6	10	50	3.85	-
★ SEME610400512E	R0.5	**4.0**	6	6	12	50	3.85	-
★ SEME610400514E	R0.5	**4.0**	6	6	14	60	3.85	-
★ SEME610400516E	R0.5	**4.0**	6	6	16	60	3.85	-
★ SEME610400520E	R0.5	**4.0**	6	6	20	60	3.85	-
★ SEME610400526E	R0.5	**4.0**	6	6	26	65	3.85	-
★ SEME610400530E	R0.5	**4.0**	6	6	30	70	3.85	-
★ SEME610400535E	R0.5	**4.0**	6	6	35	70	3.85	-
SEME610400540E	R0.5	**4.0**	6	6	40	80	3.85	-

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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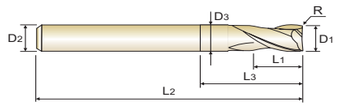


CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME610400545E	R0.5	**4.0**	6	6	45	90	3.85	-
SEME610400550E	R0.5	**4.0**	6	6	50	100	3.85	-
★ SEME610401010E	R1.0	**4.0**	6	6	10	50	3.85	-
★ SEME610401012E	R1.0	**4.0**	6	6	12	50	3.85	-
SEME610401014E	R1.0	**4.0**	6	6	14	60	3.85	-
★ SEME610401016E	R1.0	**4.0**	6	6	16	60	3.85	-
★ SEME610401020E	R1.0	**4.0**	6	6	20	60	3.85	-
★ SEME610401026E	R1.0	**4.0**	6	6	26	65	3.85	-
★ SEME610401030E	R1.0	**4.0**	6	6	30	70	3.85	-
SEME610401035E	R1.0	**4.0**	6	6	35	70	3.85	-
★ SEME610401040E	R1.0	**4.0**	6	6	40	80	3.85	-
SEME610401045E	R1.0	**4.0**	6	6	45	90	3.85	-
SEME610401050E	R1.0	**4.0**	6	6	50	100	3.85	-
SEME6105001E	R0.1	**5.0**	6	8	15	60	4.85	-
SEME6105002E	R0.2	**5.0**	6	8	15	60	4.85	-
SEME6105003E	R0.3	**5.0**	6	8	15	60	4.85	-
SEME6105005E	R0.5	**5.0**	6	8	15	60	4.85	-
SEME6105010E	R1.0	**5.0**	6	8	15	60	4.85	-
SEME6105015E	R1.5	**5.0**	6	8	15	60	4.85	-
SEME6105020E	R2.0	**5.0**	6	8	15	60	4.85	-
SEME6106001E	R0.1	**6.0**	6	9	20	60	5.85	Regular
★ SEME6106002E	R0.2	**6.0**	6	9	20	60	5.85	Regular
★ SEME6106003E	R0.3	**6.0**	6	9	20	60	5.85	Regular
★ SEME6106005E	R0.5	**6.0**	6	9	20	60	5.85	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

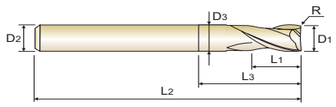
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available various products like regular length and long shank end mills etc.
- ▶ Available various corner radius end mills, from min. 0.02mm corner radius to max. 2.0mm corner radius.
- ▶ Available more various effective length and overall length end mills than previous standard products.



CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN

P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME6106010E	R1.0	**6.0**	6	9	20	60	5.85	Regular
SEME6106015E	R1.5	**6.0**	6	9	20	60	5.85	Regular
SEME6106020E	R2.0	**6.0**	6	9	20	60	5.85	Regular
SEME6106003090E	R0.3	**6.0**	6	15	30	90	5.85	Long
SEME610600524E	R0.5	**6.0**	6	9	24	90	5.85	-
★ SEME6106005090E	R0.5	**6.0**	6	15	30	90	5.85	Long
★ SEME6106010090E	R1.0	**6.0**	6	15	30	90	5.85	Long
SEME6108001E	R0.1	**8.0**	8	12	25	70	7.70	Regular
★ SEME6108002E	R0.2	**8.0**	8	12	25	70	7.70	Regular
★ SEME6108003E	R0.3	**8.0**	8	12	25	70	7.70	Regular
★ SEME6108005E	R0.5	**8.0**	8	12	25	70	7.70	Regular
★ SEME6108010E	R1.0	**8.0**	8	12	25	70	7.70	Regular
SEME6108015E	R1.5	**8.0**	8	12	25	70	7.70	Regular
SEME6108020E	R2.0	**8.0**	8	12	25	70	7.70	Regular
SEME6108003100E	R0.3	**8.0**	8	20	35	100	7.70	Long
★ SEME6108005100E	R0.5	**8.0**	8	20	35	100	7.70	Long
★ SEME6108010100E	R1.0	**8.0**	8	20	35	100	7.70	Long
SEME6110001E	R0.1	**10.0**	10	15	30	75	9.70	Regular
SEME6110002E	R0.2	**10.0**	10	15	30	75	9.70	Regular
★ SEME6110003E	R0.3	**10.0**	10	15	30	75	9.70	Regular
★ SEME6110005E	R0.5	**10.0**	10	15	30	75	9.70	Regular
★ SEME6110010E	R1.0	**10.0**	10	15	30	75	9.70	Regular
SEME6110015E	R1.5	**10.0**	10	15	30	75	9.70	Regular
SEME6110020E	R2.0	**10.0**	10	15	30	75	9.70	Regular

★ : Stock Item

▶ NEXT PAGE

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE CORNER RADIUS with EXTENDED NECK

SEME61 SERIES

- ▶ Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
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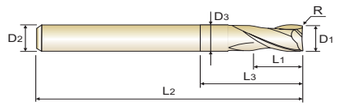


CARBIDE | 2 | 30° | R ±0.010 | R ±0.015 | PLAIN

P.134-141

Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME6110003100E	R0.3	**10.0**	10	25	40	100	9.70	Long
★ SEME6110005100E	R0.5	**10.0**	10	25	40	100	9.70	Long
★ SEME6110010100E	R1.0	**10.0**	10	25	40	100	9.70	Long
SEME6112002E	R0.2	**12.0**	12	18	32	80	11.70	Regular
SEME6112003E	R0.3	**12.0**	12	18	32	80	11.70	Regular
★ SEME6112005E	R0.5	**12.0**	12	18	32	80	11.70	Regular
★ SEME6112010E	R1.0	**12.0**	12	18	32	80	11.70	Regular
★ SEME6112015E	R1.5	**12.0**	12	18	32	80	11.70	Regular
SEME6112020E	R2.0	**12.0**	12	18	32	80	11.70	Regular
SEME6112003110E	R0.3	**12.0**	12	30	50	110	11.70	Long
SEME6112005110E	R0.5	**12.0**	12	30	50	110	11.70	Long
★ SEME6112010110E	R1.0	**12.0**	12	30	50	110	11.70	Long
★ SEME6116005E	R0.5	**16.0**	16	20	35	100	15.70	Regular
★ SEME6116010E	R1.0	**16.0**	16	20	35	100	15.70	Regular
SEME6116005150E	R0.5	**16.0**	16	35	50	150	15.70	Long
SEME6116010150E	R1.0	**16.0**	16	35	50	150	15.70	Long
★ SEME6120005E	R0.5	**20.0**	20	25	40	100	19.70	Regular
★ SEME6120010E	R1.0	**20.0**	20	25	40	100	19.70	Regular
SEME6120005150E	R0.5	**20.0**	20	40	55	150	19.70	Long
SEME6120010150E	R1.0	**20.0**	20	40	55	150	19.70	Long

★ : Stock Item

Size	Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	± 0.010	0 ~ - 0.012	h5
over Ø6	± 0.015	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

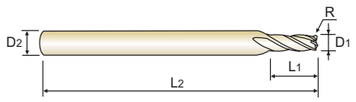
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
- ▶ Available in short, regular and long shank end mills.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME010100054SE	R0.05	1.0	4	2.5	50	4mm Shank
SEME01010014SE	R0.1	1.0	4	2.5	50	4mm Shank
SEME01010024SE	R0.2	1.0	4	2.5	50	4mm Shank
SEME01010034SE	R0.3	1.0	4	2.5	50	4mm Shank
SEME01010005E	R0.05	1.0	6	2.5	50	-
★ SEME0101001E	R0.1	1.0	6	2.5	50	-
SEME0101002E	R0.2	1.0	6	2.5	50	-
SEME0101003E	R0.3	1.0	6	2.5	50	-
SEME010120054SE	R0.05	1.2	4	3	50	4mm Shank
SEME01012014SE	R0.1	1.2	4	3	50	4mm Shank
SEME01012024SE	R0.2	1.2	4	3	50	4mm Shank
SEME01012034SE	R0.3	1.2	4	3	50	4mm Shank
SEME01012005E	R0.05	1.2	6	3	50	-
SEME0101201E	R0.1	1.2	6	3	50	-
SEME0101202E	R0.2	1.2	6	3	50	-
SEME0101203E	R0.3	1.2	6	3	50	-
SEME010150054SE	R0.05	1.5	4	4	50	4mm Shank
SEME01015014SE	R0.1	1.5	4	4	50	4mm Shank
SEME01015024SE	R0.2	1.5	4	4	50	4mm Shank
SEME01015034SE	R0.3	1.5	4	4	50	4mm Shank
SEME01015054SE	R0.5	1.5	4	4	50	4mm Shank
SEME01015005E	R0.05	1.5	6	4	50	-
SEME0101501E	R0.1	1.5	6	4	50	-
SEME0101502E	R0.2	1.5	6	4	50	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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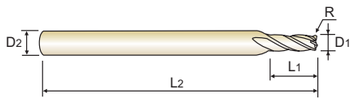

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME0101503E	R0.3	1.5	6	4	50	-
SEME0101505E	R0.5	1.5	6	4	50	-
SEME01020014SE	R0.1	2.0	4	6	50	4mm Shank
SEME01020024SE	R0.2	2.0	4	6	50	4mm Shank
SEME01020034SE	R0.3	2.0	4	6	50	4mm Shank
SEME01020054SE	R0.5	2.0	4	6	50	4mm Shank
★ SEME0102001E	R0.1	2.0	6	6	50	-
★ SEME0102002E	R0.2	2.0	6	6	50	-
SEME0102003E	R0.3	2.0	6	6	50	-
SEME0102005E	R0.5	2.0	6	6	50	-
SEME01025014SE	R0.1	2.5	4	7	60	4mm Shank
SEME01025024SE	R0.2	2.5	4	7	60	4mm Shank
SEME01025034SE	R0.3	2.5	4	7	60	4mm Shank
SEME01025054SE	R0.5	2.5	4	7	60	4mm Shank
SEME0102501E	R0.1	2.5	6	7	60	-
SEME0102502E	R0.2	2.5	6	7	60	-
SEME0102503E	R0.3	2.5	6	7	60	-
SEME0102505E	R0.5	2.5	6	7	60	-
SEME0103001E	R0.1	3.0	6	8	60	-
★ SEME0103002E	R0.2	3.0	6	8	60	-
★ SEME0103003E	R0.3	3.0	6	8	60	-
★ SEME0103005E	R0.5	3.0	6	8	60	-
SEME0103010E	R1.0	3.0	6	8	60	-
SEME0103501E	R0.1	3.5	6	10	70	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

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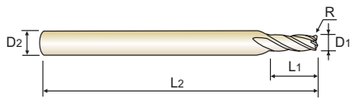


CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME0103502E	R0.2	**3.5**	6	10	70	-
SEME0103503E	R0.3	**3.5**	6	10	70	-
SEME0103505E	R0.5	**3.5**	6	10	70	-
SEME01040014SE	R0.1	**4.0**	4	10	70	4mm Shank
SEME01040024SE	R0.2	**4.0**	4	10	70	4mm Shank
SEME01040034SE	R0.3	**4.0**	4	10	70	4mm Shank
SEME01040054SE	R0.5	**4.0**	4	10	70	4mm Shank
SEME01040104SE	R1.0	**4.0**	4	10	70	4mm Shank
SEME01040011004SE	R0.1	**4.0**	4	10	100	4mm Shank
SEME01040021004SE	R0.2	**4.0**	4	10	100	4mm Shank
SEME01040031004SE	R0.3	**4.0**	4	10	100	4mm Shank
SEME01040051004SE	R0.5	**4.0**	4	10	100	4mm Shank
SEME01040101004SE	R1.0	**4.0**	4	10	100	4mm Shank
SEME0104001E	R0.1	**4.0**	6	10	70	Regular
★ SEME0104002E	R0.2	**4.0**	6	10	70	Regular
★ SEME0104003E	R0.3	**4.0**	6	10	70	Regular
★ SEME0104005E	R0.5	**4.0**	6	10	70	Regular
★ SEME0104010E	R1.0	**4.0**	6	10	70	Regular
SEME0104501E	R0.1	**4.5**	6	11	80	-
SEME0104502E	R0.2	**4.5**	6	11	80	-
SEME0104503E	R0.3	**4.5**	6	11	80	-
SEME0104505E	R0.5	**4.5**	6	11	80	-
SEME0105001E	R0.1	**5.0**	6	13	90	-
SEME0105002E	R0.2	**5.0**	6	13	90	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

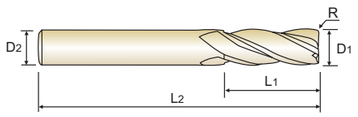
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
- ▶ Available in short, regular and long shank end mills.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEME0105003E	R0.3	**5.0**	6	13	90	-
★ SEME0105005E	R0.5	**5.0**	6	13	90	-
SEME0105010E	R1.0	**5.0**	6	13	90	-
SEME0105501E	R0.1	**5.5**	6	13	90	-
SEME0105502E	R0.2	**5.5**	6	13	90	-
SEME0105503E	R0.3	**5.5**	6	13	90	-
SEME0105505E	R0.5	**5.5**	6	13	90	-
SEME0105510E	R1.0	**5.5**	6	13	90	-
SEME0106001060E	R0.1	**6.0**	6	15	60	Short
SEME0106002060E	R0.2	**6.0**	6	15	60	Short
SEME0106001E	R0.1	**6.0**	6	15	90	Regular
★ SEME0106002E	R0.2	**6.0**	6	15	90	Regular
★ SEME0106003E	R0.3	**6.0**	6	15	90	Regular
★ SEME0106005E	R0.5	**6.0**	6	15	90	Regular
★ SEME0106010E	R1.0	**6.0**	6	15	90	Regular
SEME0106015E	R1.5	**6.0**	6	15	90	Regular
SEME0106020E	R2.0	**6.0**	6	15	90	Regular
SEME0106005110E	R0.5	**6.0**	6	15	110	Long
SEME0106010110E	R1.0	**6.0**	6	15	110	Long
SEME0106005130E	R0.5	**6.0**	6	15	130	Long
SEME0106010130E	R1.0	**6.0**	6	15	130	Long
SEME0107001E	R0.1	**7.0**	8	16	90	-
SEME0107002E	R0.2	**7.0**	8	16	90	-
SEME0107003E	R0.3	**7.0**	8	16	90	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

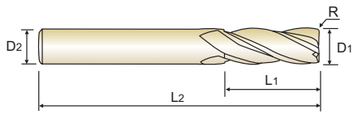
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
- ▶ Available in short, regular and long shank end mills.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME0107005E	R0.5	**7.0**	8	16	90	-
SEME0107010E	R1.0	**7.0**	8	16	90	-
SEME0107020E	R2.0	**7.0**	8	16	90	-
★ SEME0108003070E	R0.3	**8.0**	8	20	70	Short
★ SEME0108005070E	R0.5	**8.0**	8	20	70	Short
★ SEME0108010070E	R1.0	**8.0**	8	20	70	Short
SEME0108001E	R0.1	**8.0**	8	20	100	Regular
★ SEME0108002E	R0.2	**8.0**	8	20	100	Regular
★ SEME0108003E	R0.3	**8.0**	8	20	100	Regular
★ SEME0108005E	R0.5	**8.0**	8	20	100	Regular
★ SEME0108010E	R1.0	**8.0**	8	20	100	Regular
★ SEME0108015E	R1.5	**8.0**	8	20	100	Regular
★ SEME0108020E	R2.0	**8.0**	8	20	100	Regular
SEME0108025E	R2.5	**8.0**	8	20	100	Regular
SEME0108030E	R3.0	**8.0**	8	20	100	Regular
SEME0108005120E	R0.5	**8.0**	8	20	120	Long
SEME0108010120E	R1.0	**8.0**	8	20	120	Long
SEME0108005150E	R0.5	**8.0**	8	20	150	Long
SEME0108010150E	R1.0	**8.0**	8	20	150	Long
SEME0110003075E	R0.3	**10.0**	10	25	75	Short
SEME0110005075E	R0.5	**10.0**	10	25	75	Short
SEME0110010075E	R1.0	**10.0**	10	25	75	Short
SEME0110001E	R0.1	**10.0**	10	25	100	Regular
SEME0110002E	R0.2	**10.0**	10	25	100	Regular

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

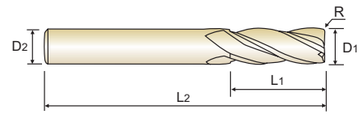
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
- ▶ Available in short, regular and long shank end mills.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME0110003E	R0.3	**10.0**	10	25	100	Regular
SEME0110005E	R0.5	**10.0**	10	25	100	Regular
★ SEME0110010E	R1.0	**10.0**	10	25	100	Regular
★ SEME0110015E	R1.5	**10.0**	10	25	100	Regular
★ SEME0110020E	R2.0	**10.0**	10	25	100	Regular
★ SEME0110025E	R2.5	**10.0**	10	25	100	Regular
SEME0110030E	R3.0	**10.0**	10	25	100	Regular
SEME0110040E	R4.0	**10.0**	10	25	100	Regular
SEME0110005130E	R0.5	**10.0**	10	22	130	Long
SEME0110010130E	R1.0	**10.0**	10	22	130	Long
SEME0110005150E	R0.5	**10.0**	10	22	150	Long
SEME0110010150E	R1.0	**10.0**	10	22	150	Long
★ SEME0111002E	R0.2	**11.0**	12	25	110	-
★ SEME0111003E	R0.3	**11.0**	12	25	110	-
SEME0111005E	R0.5	**11.0**	12	25	110	-
SEME0111010E	R1.0	**11.0**	12	25	110	-
SEME0111020E	R2.0	**11.0**	12	25	110	-
SEME0112003080E	R0.3	**12.0**	12	30	80	Short
SEME0112005080E	R0.5	**12.0**	12	30	80	Short
SEME0112010080E	R1.0	**12.0**	12	30	80	Short
SEME0112001E	R0.1	**12.0**	12	30	110	Regular
SEME0112002E	R0.2	**12.0**	12	30	110	Regular
SEME0112003E	R0.3	**12.0**	12	30	110	Regular
★ SEME0112005E	R0.5	**12.0**	12	30	110	Regular

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

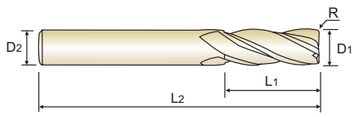
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS (Short, Regular, Long Shank)

SEME01 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
- ▶ Available in short, regular and long shank end mills.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.142-143

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEME0112010E	R1.0	**12.0**	12	30	110	Regular
★ SEME0112015E	R1.5	**12.0**	12	30	110	Regular
★ SEME0112020E	R2.0	**12.0**	12	30	110	Regular
SEME0112025E	R2.5	**12.0**	12	30	110	Regular
SEME0112030E	R3.0	**12.0**	12	30	110	Regular
SEME0112040E	R4.0	**12.0**	12	30	110	Regular
SEME0112050E	R5.0	**12.0**	12	30	110	Regular
SEME0112005130E	R0.5	**12.0**	12	30	130	Long
SEME0112010130E	R1.0	**12.0**	12	30	130	Long
SEME0112005150E	R0.5	**12.0**	12	30	130	Long
SEME0112010150E	R1.0	**12.0**	12	30	130	Long
SEME0114005E	R0.5	**14.0**	16	35	150	-
SEME0114010E	R1.0	**14.0**	16	35	150	-
SEME0114020E	R2.0	**14.0**	16	35	150	-
★ SEME0116005E	R0.5	**16.0**	16	32	150	-
★ SEME0116010E	R1.0	**16.0**	16	32	150	-
★ SEME0116015E	R1.5	**16.0**	16	32	150	-
★ SEME0116020E	R2.0	**16.0**	16	32	150	-
SEME0120005E	R0.5	**20.0**	20	38	150	-
★ SEME0120010E	R1.0	**20.0**	20	38	150	-
SEME0120015E	R1.5	**20.0**	20	38	150	-
★ SEME0120020E	R2.0	**20.0**	20	38	150	-

★ : Stock Item

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

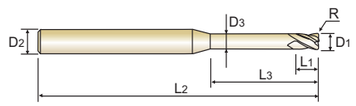
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME6401000503E	R0.05	**1.0**	4	1.5	3	50	0.95	-
SEME6401000504E	R0.05	**1.0**	4	1.5	4	50	0.95	-
SEME6401000506E	R0.05	**1.0**	4	1.5	6	50	0.95	-
SEME6401000508E	R0.05	**1.0**	4	1.5	8	50	0.95	-
SEME6401000510E	R0.05	**1.0**	4	1.5	10	50	0.95	-
SEME6401000512E	R0.05	**1.0**	4	1.5	12	50	0.95	-
SEME6401000514E	R0.05	**1.0**	4	1.5	14	50	0.95	-
SEME6401000516E	R0.05	**1.0**	4	1.5	16	50	0.95	-
SEME6401000520E	R0.05	**1.0**	4	1.5	20	50	0.95	-
SEME640100103E	R0.1	**1.0**	4	1.5	3	50	0.95	-
★ SEME640100104E	R0.1	**1.0**	4	1.5	4	50	0.95	-
★ SEME640100106E	R0.1	**1.0**	4	1.5	6	50	0.95	-
★ SEME640100108E	R0.1	**1.0**	4	1.5	8	50	0.95	-
SEME640100110E	R0.1	**1.0**	4	1.5	10	50	0.95	-
SEME640100112E	R0.1	**1.0**	4	1.5	12	50	0.95	-
SEME640100114E	R0.1	**1.0**	4	1.5	14	50	0.95	-
SEME640100116E	R0.1	**1.0**	4	1.5	16	50	0.95	-
SEME640100120E	R0.1	**1.0**	4	1.5	20	50	0.95	-
SEME640100203E	R0.2	**1.0**	4	1.5	3	50	0.95	-
★ SEME640100204E	R0.2	**1.0**	4	1.5	4	50	0.95	-
★ SEME640100206E	R0.2	**1.0**	4	1.5	6	50	0.95	-
★ SEME640100208E	R0.2	**1.0**	4	1.5	8	50	0.95	-
★ SEME640100210E	R0.2	**1.0**	4	1.5	10	50	0.95	-
SEME640100212E	R0.2	**1.0**	4	1.5	12	50	0.95	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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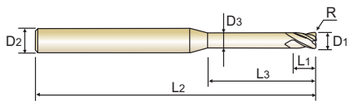
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640100214E	R0.2	**1.0**	4	1.5	14	50	0.95	-
SEME640100216E	R0.2	**1.0**	4	1.5	16	50	0.95	-
SEME640100220E	R0.2	**1.0**	4	1.5	20	50	0.95	-
SEME640100303E	R0.3	**1.0**	4	1.5	3	50	0.95	-
★ SEME640100304E	R0.3	**1.0**	4	1.5	4	50	0.95	-
★ SEME640100306E	R0.3	**1.0**	4	1.5	6	50	0.95	-
★ SEME640100308E	R0.3	**1.0**	4	1.5	8	50	0.95	-
SEME640100310E	R0.3	**1.0**	4	1.5	10	50	0.95	-
SEME640100312E	R0.3	**1.0**	4	1.5	12	50	0.95	-
SEME640100314E	R0.3	**1.0**	4	1.5	14	50	0.95	-
SEME640100316E	R0.3	**1.0**	4	1.5	16	50	0.95	-
SEME640100320E	R0.3	**1.0**	4	1.5	20	50	0.95	-
SEME6401200503E	R0.05	**1.2**	4	1.8	3	50	1.15	-
SEME6401200504E	R0.05	**1.2**	4	1.8	4	50	1.15	-
SEME6401200506E	R0.05	**1.2**	4	1.8	6	50	1.15	-
SEME6401200508E	R0.05	**1.2**	4	1.8	8	50	1.15	-
SEME6401200510E	R0.05	**1.2**	4	1.8	10	50	1.15	-
SEME6401200512E	R0.05	**1.2**	4	1.8	12	50	1.15	-
SEME6401200516E	R0.05	**1.2**	4	1.8	16	50	1.15	-
SEME6401200520E	R0.05	**1.2**	4	1.8	20	50	1.15	-
SEME640120103E	R0.1	**1.2**	4	1.8	3	50	1.15	-
★ SEME640120104E	R0.1	**1.2**	4	1.8	4	50	1.15	-
★ SEME640120106E	R0.1	**1.2**	4	1.8	6	50	1.15	-
★ SEME640120108E	R0.1	**1.2**	4	1.8	8	50	1.15	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

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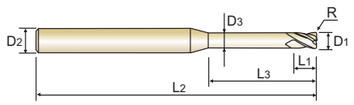

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640120110E	R0.1	**1.2**	4	1.8	10	50	1.15	-
SEME640120112E	R0.1	**1.2**	4	1.8	12	50	1.15	-
SEME640120116E	R0.1	**1.2**	4	1.8	16	50	1.15	-
SEME640120120E	R0.1	**1.2**	4	1.8	20	50	1.15	-
SEME640120203E	R0.2	**1.2**	4	1.8	3	50	1.15	-
★ SEME640120204E	R0.2	**1.2**	4	1.8	4	50	1.15	-
★ SEME640120206E	R0.2	**1.2**	4	1.8	6	50	1.15	-
★ SEME640120208E	R0.2	**1.2**	4	1.8	8	50	1.15	-
SEME640120210E	R0.2	**1.2**	4	1.8	10	50	1.15	-
SEME640120212E	R0.2	**1.2**	4	1.8	12	50	1.15	-
SEME640120216E	R0.2	**1.2**	4	1.8	16	50	1.15	-
SEME640120220E	R0.2	**1.2**	4	1.8	20	50	1.15	-
SEME640120303E	R0.3	**1.2**	4	1.8	3	50	1.15	-
★ SEME640120304E	R0.3	**1.2**	4	1.8	4	50	1.15	-
★ SEME640120306E	R0.3	**1.2**	4	1.8	6	50	1.15	-
★ SEME640120308E	R0.3	**1.2**	4	1.8	8	50	1.15	-
SEME640120310E	R0.3	**1.2**	4	1.8	10	50	1.15	-
SEME640120312E	R0.3	**1.2**	4	1.8	12	50	1.15	-
SEME640120316E	R0.3	**1.2**	4	1.8	16	50	1.15	-
SEME640120320E	R0.3	**1.2**	4	1.8	20	50	1.15	-
SEME6401500504E	R0.05	**1.5**	4	2.3	4	50	1.45	-
SEME6401500506E	R0.05	**1.5**	4	2.3	6	50	1.45	-
SEME6401500508E	R0.05	**1.5**	4	2.3	8	50	1.45	-
SEME6401500510E	R0.05	**1.5**	4	2.3	10	50	1.45	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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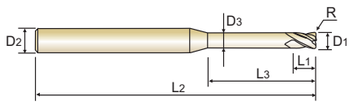

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME6401500512E	R0.05	1.5	4	2.3	12	50	1.45	-
SEME6401500514E	R0.05	1.5	4	2.3	14	50	1.45	-
SEME6401500516E	R0.05	1.5	4	2.3	16	50	1.45	-
SEME6401500520E	R0.05	1.5	4	2.3	20	50	1.45	-
SEME6401500522E	R0.05	1.5	4	2.3	22	60	1.45	-
SEME6401500526E	R0.05	1.5	4	2.3	26	60	1.45	-
SEME640150104E	R0.1	1.5	4	2.3	4	50	1.45	-
★ SEME640150106E	R0.1	1.5	4	2.3	6	50	1.45	-
★ SEME640150108E	R0.1	1.5	4	2.3	8	50	1.45	-
★ SEME640150110E	R0.1	1.5	4	2.3	10	50	1.45	-
★ SEME640150112E	R0.1	1.5	4	2.3	12	50	1.45	-
SEME640150114E	R0.1	1.5	4	2.3	14	50	1.45	-
SEME640150116E	R0.1	1.5	4	2.3	16	50	1.45	-
SEME640150118E	R0.1	1.5	4	2.3	18	50	1.45	
SEME640150120E	R0.1	1.5	4	2.3	20	50	1.45	-
SEME640150122E	R0.1	1.5	4	2.3	22	60	1.45	-
SEME640150126E	R0.1	1.5	4	2.3	26	60	1.45	-
SEME640150204E	R0.2	1.5	4	2.3	4	50	1.45	-
★ SEME640150206E	R0.2	1.5	4	2.3	6	50	1.45	-
★ SEME640150208E	R0.2	1.5	4	2.3	8	50	1.45	-
★ SEME640150210E	R0.2	1.5	4	2.3	10	50	1.45	-
★ SEME640150212E	R0.2	1.5	4	2.3	12	50	1.45	-
SEME640150214E	R0.2	1.5	4	2.3	14	50	1.45	-
SEME640150216E	R0.2	1.5	4	2.3	16	50	1.45	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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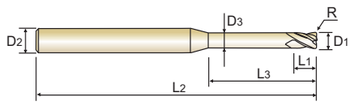

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640150220E	R0.2	1.5	4	2.3	20	50	1.45	-
SEME640150222E	R0.2	1.5	4	2.3	22	60	1.45	-
SEME640150226E	R0.2	1.5	4	2.3	26	60	1.45	-
SEME640150304E	R0.3	1.5	4	2.3	4	50	1.45	-
★ SEME640150306E	R0.3	1.5	4	2.3	6	50	1.45	-
★ SEME640150308E	R0.3	1.5	4	2.3	8	50	1.45	-
★ SEME640150310E	R0.3	1.5	4	2.3	10	50	1.45	-
★ SEME640150312E	R0.3	1.5	4	2.3	12	50	1.45	-
SEME640150314E	R0.3	1.5	4	2.3	14	50	1.45	-
SEME640150316E	R0.3	1.5	4	2.3	16	50	1.45	-
SEME640150320E	R0.3	1.5	4	2.3	20	50	1.45	-
SEME640150322E	R0.3	1.5	4	2.3	22	60	1.45	-
SEME640150326E	R0.3	1.5	4	2.3	26	60	1.45	-
SEME640150504E	R0.5	1.5	4	2.3	4	50	1.45	-
★ SEME640150506E	R0.5	1.5	4	2.3	6	50	1.45	-
★ SEME640150508E	R0.5	1.5	4	2.3	8	50	1.45	-
★ SEME640150510E	R0.5	1.5	4	2.3	10	50	1.45	-
★ SEME640150512E	R0.5	1.5	4	2.3	12	50	1.45	-
SEME640150514E	R0.5	1.5	4	2.3	14	50	1.45	-
SEME640150516E	R0.5	1.5	4	2.3	16	50	1.45	-
SEME640150520E	R0.5	1.5	4	2.3	20	50	1.45	-
SEME640150522E	R0.5	1.5	4	2.3	22	60	1.45	-
SEME640150526E	R0.5	1.5	4	2.3	26	60	1.45	-
★ SEME640200106E	R0.1	2.0	4	3	6	50	1.95	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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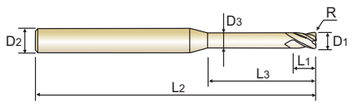

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME640200108E	R0.1	2.0	4	3	8	50	1.95	-
★ SEME640200110E	R0.1	2.0	4	3	10	50	1.95	-
★ SEME640200112E	R0.1	2.0	4	3	12	50	1.95	-
SEME640200114E	R0.1	2.0	4	3	14	50	1.95	-
SEME640200116E	R0.1	2.0	4	3	16	50	1.95	-
SEME640200120E	R0.1	2.0	4	3	20	50	1.95	-
SEME640200122E	R0.1	2.0	4	3	22	60	1.95	-
SEME640200126E	R0.1	2.0	4	3	26	60	1.95	-
SEME640200130E	R0.1	2.0	4	3	30	70	1.95	-
★ SEME640200206E	R0.2	2.0	4	3	6	50	1.95	-
★ SEME640200208E	R0.2	2.0	4	3	8	50	1.95	-
★ SEME640200210E	R0.2	2.0	4	3	10	50	1.95	-
★ SEME640200212E	R0.2	2.0	4	3	12	50	1.95	-
SEME640200214E	R0.2	2.0	4	3	14	50	1.95	-
SEME640200216E	R0.2	2.0	4	3	16	50	1.95	-
SEME640200220E	R0.2	2.0	4	3	20	50	1.95	-
SEME640200222E	R0.2	2.0	4	3	22	60	1.95	-
SEME640200226E	R0.2	2.0	4	3	26	60	1.95	-
SEME640200230E	R0.2	2.0	4	3	30	70	1.95	-
★ SEME640200306E	R0.3	2.0	4	3	6	50	1.95	-
★ SEME640200308E	R0.3	2.0	4	3	8	50	1.95	-
★ SEME640200310E	R0.3	2.0	4	3	10	50	1.95	-
★ SEME640200312E	R0.3	2.0	4	3	12	50	1.95	-
SEME640200314E	R0.3	2.0	4	3	14	50	1.95	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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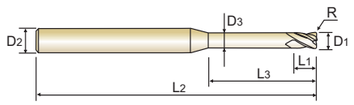
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640200316E	R0.3	2.0	4	3	16	50	1.95	-
SEME640200320E	R0.3	2.0	4	3	20	50	1.95	-
SEME640200322E	R0.3	2.0	4	3	22	60	1.95	-
SEME640200326E	R0.3	2.0	4	3	26	60	1.95	-
SEME640200330E	R0.3	2.0	4	3	30	70	1.95	-
★ SEME640200506E	R0.5	2.0	4	3	6	50	1.95	-
★ SEME640200508E	R0.5	2.0	4	3	8	50	1.95	-
★ SEME640200510E	R0.5	2.0	4	3	10	50	1.95	-
★ SEME640200512E	R0.5	2.0	4	3	12	50	1.95	-
★ SEME640200514E	R0.5	2.0	4	3	14	50	1.95	-
★ SEME640200516E	R0.5	2.0	4	3	16	50	1.95	-
★ SEME640200520E	R0.5	2.0	4	3	20	50	1.95	-
SEME640200522E	R0.5	2.0	4	3	22	60	1.95	-
SEME640200526E	R0.5	2.0	4	3	26	60	1.95	-
SEME640200530E	R0.5	2.0	4	3	30	70	1.95	-
SEME640250108E	R0.1	2.5	4	4	8	50	2.40	-
SEME640250110E	R0.1	2.5	4	4	10	50	2.40	-
SEME640250112E	R0.1	2.5	4	4	12	50	2.40	-
SEME640250114E	R0.1	2.5	4	4	14	50	2.40	-
SEME640250116E	R0.1	2.5	4	4	16	50	2.40	-
SEME640250120E	R0.1	2.5	4	4	20	50	2.40	-
SEME640250126E	R0.1	2.5	4	4	26	60	2.40	-
SEME640250130E	R0.1	2.5	4	4	30	70	2.40	-
SEME640250208E	R0.2	2.5	4	4	8	50	2.40	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

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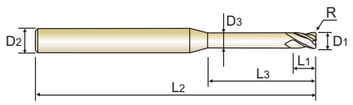

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640250210E	R0.2	**2.5**	4	4	10	50	2.40	-
SEME640250212E	R0.2	**2.5**	4	4	12	50	2.40	-
SEME640250214E	R0.2	**2.5**	4	4	14	50	2.40	-
SEME640250216E	R0.2	**2.5**	4	4	16	50	2.40	-
SEME640250220E	R0.2	**2.5**	4	4	20	50	2.40	-
SEME640250226E	R0.2	**2.5**	4	4	26	60	2.40	-
SEME640250230E	R0.2	**2.5**	4	4	30	70	2.40	-
SEME640250308E	R0.3	**2.5**	4	4	8	50	2.40	-
SEME640250310E	R0.3	**2.5**	4	4	10	50	2.40	-
SEME640250312E	R0.3	**2.5**	4	4	12	50	2.40	-
SEME640250314E	R0.3	**2.5**	4	4	14	50	2.40	-
SEME640250316E	R0.3	**2.5**	4	4	16	50	2.40	-
SEME640250320E	R0.3	**2.5**	4	4	20	50	2.40	-
SEME640250326E	R0.3	**2.5**	4	4	26	60	2.40	-
SEME640250330E	R0.3	**2.5**	4	4	30	70	2.40	-
SEME640250508E	R0.5	**2.5**	4	4	8	50	2.40	-
SEME640250510E	R0.5	**2.5**	4	4	10	50	2.40	-
SEME640250512E	R0.5	**2.5**	4	4	12	50	2.40	-
SEME640250514E	R0.5	**2.5**	4	4	14	50	2.40	-
SEME640250516E	R0.5	**2.5**	4	4	16	50	2.40	-
SEME640250520E	R0.5	**2.5**	4	4	20	50	2.40	-
SEME640250526E	R0.5	**2.5**	4	4	26	60	2.40	-
SEME640250530E	R0.5	**2.5**	4	4	30	70	2.40	-
★ SEME640300108E	R0.1	**3.0**	6	4.5	8	50	2.85	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

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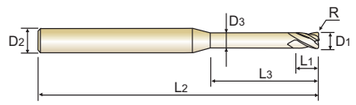

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME640300110E	R0.1	**3.0**	6	4.5	10	50	2.85	-
★ SEME640300112E	R0.1	**3.0**	6	4.5	12	50	2.85	-
SEME640300114E	R0.1	**3.0**	6	4.5	14	60	2.85	-
★ SEME640300116E	R0.1	**3.0**	6	4.5	16	60	2.85	-
SEME640300120E	R0.1	**3.0**	6	4.5	20	60	2.85	-
SEME640300126E	R0.1	**3.0**	6	4.5	26	65	2.85	-
SEME640300130E	R0.1	**3.0**	6	4.5	30	70	2.85	-
SEME640300135E	R0.1	**3.0**	6	4.5	35	70	2.85	-
SEME640300140E	R0.1	**3.0**	6	4.5	40	80	2.85	-
SEME640300208E	R0.2	**3.0**	6	4.5	8	50	2.85	-
★ SEME640300210E	R0.2	**3.0**	6	4.5	10	50	2.85	-
★ SEME640300212E	R0.2	**3.0**	6	4.5	12	50	2.85	-
SEME640300214E	R0.2	**3.0**	6	4.5	14	60	2.85	-
★ SEME640300216E	R0.2	**3.0**	6	4.5	16	60	2.85	-
SEME640300218E	R0.2	**3.0**	6	4.5	18	60	2.85	-
★ SEME640300220E	R0.2	**3.0**	6	4.5	20	60	2.85	-
SEME640300226E	R0.2	**3.0**	6	4.5	26	65	2.85	-
SEME640300230E	R0.2	**3.0**	6	4.5	30	70	2.85	-
SEME640300235E	R0.2	**3.0**	6	4.5	35	70	2.85	-
SEME640300240E	R0.2	**3.0**	6	4.5	40	80	2.85	-
★ SEME640300308E	R0.3	**3.0**	6	4.5	8	50	2.85	-
★ SEME640300310E	R0.3	**3.0**	6	4.5	10	50	2.85	-
★ SEME640300312E	R0.3	**3.0**	6	4.5	12	50	2.85	-
★ SEME640300314E	R0.3	**3.0**	6	4.5	14	60	2.85	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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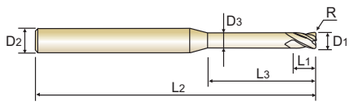

CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME640300316E	R0.3	3.0	6	4.5	16	60	2.85	-
★ SEME640300320E	R0.3	3.0	6	4.5	20	60	2.85	-
SEME640300326E	R0.3	3.0	6	4.5	26	65	2.85	-
SEME640300330E	R0.3	3.0	6	4.5	30	70	2.85	-
SEME640300335E	R0.3	3.0	6	4.5	35	70	2.85	-
SEME640300340E	R0.3	3.0	6	4.5	40	80	2.85	-
★ SEME640300508E	R0.5	3.0	6	4.5	8	50	2.85	-
★ SEME640300510E	R0.5	3.0	6	4.5	10	50	2.85	-
★ SEME640300512E	R0.5	3.0	6	4.5	12	50	2.85	-
SEME640300514E	R0.5	3.0	6	4.5	14	60	2.85	-
★ SEME640300516E	R0.5	3.0	6	4.5	16	60	2.85	-
★ SEME640300520E	R0.5	3.0	6	4.5	20	60	2.85	-
★ SEME640300526E	R0.5	3.0	6	4.5	26	65	2.85	-
★ SEME640300530E	R0.5	3.0	6	4.5	30	70	2.85	-
SEME640300535E	R0.5	3.0	6	4.5	35	70	2.85	-
SEME640300540E	R0.5	3.0	6	4.5	40	80	2.85	-
★ SEME640301008E	R1.0	3.0	6	4.5	8	50	2.85	-
★ SEME640301010E	R1.0	3.0	6	4.5	10	50	2.85	-
★ SEME640301012E	R1.0	3.0	6	4.5	12	50	2.85	-
SEME640301014E	R1.0	3.0	6	4.5	14	60	2.85	-
★ SEME640301016E	R1.0	3.0	6	4.5	16	60	2.85	-
★ SEME640301020E	R1.0	3.0	6	4.5	20	60	2.85	-
SEME640301026E	R1.0	3.0	6	4.5	26	65	2.85	-
★ SEME640301030E	R1.0	3.0	6	4.5	30	70	2.85	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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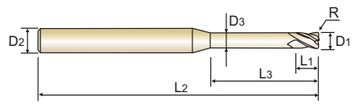


CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640301035E	R1.0	3.0	6	4.5	35	70	2.85	-
SEME640301040E	R1.0	3.0	6	4.5	40	80	2.85	-
★ SEME640400110E	R0.1	4.0	6	6	10	50	3.85	-
★ SEME640400112E	R0.1	4.0	6	6	12	50	3.85	-
SEME640400114E	R0.1	4.0	6	6	14	60	3.85	-
★ SEME640400116E	R0.1	4.0	6	6	16	60	3.85	-
★ SEME640400120E	R0.1	4.0	6	6	20	60	3.85	-
SEME640400126E	R0.1	4.0	6	6	26	65	3.85	-
SEME640400130E	R0.1	4.0	6	6	30	70	3.85	-
SEME640400135E	R0.1	4.0	6	6	35	70	3.85	-
SEME640400140E	R0.1	4.0	6	6	40	80	3.85	-
SEME640400145E	R0.1	4.0	6	6	45	90	3.85	-
SEME640400150E	R0.1	4.0	6	6	50	100	3.85	-
★ SEME640400210E	R0.2	4.0	6	6	10	50	3.85	-
★ SEME640400212E	R0.2	4.0	6	6	12	50	3.85	-
SEME640400214E	R0.2	4.0	6	6	14	60	3.85	-
★ SEME640400216E	R0.2	4.0	6	6	16	60	3.85	-
★ SEME640400220E	R0.2	4.0	6	6	20	60	3.85	-
SEME640400224E	R0.2	4.0	6	6	24	65	3.85	-
★ SEME640400226E	R0.2	4.0	6	6	26	65	3.85	-
SEME640400230E	R0.2	4.0	6	6	30	70	3.85	-
SEME640400235E	R0.2	4.0	6	6	35	70	3.85	-
SEME640400240E	R0.2	4.0	6	6	40	80	3.85	-
SEME640400245E	R0.2	4.0	6	6	45	90	3.85	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

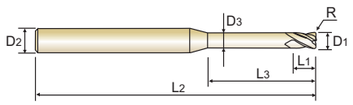
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME640400250E	R0.2	**4.0**	6	6	50	100	3.85	-
★ SEME640400310E	R0.3	**4.0**	6	6	10	50	3.85	-
★ SEME640400312E	R0.3	**4.0**	6	6	12	50	3.85	-
★ SEME640400314E	R0.3	**4.0**	6	6	14	60	3.85	-
★ SEME640400316E	R0.3	**4.0**	6	6	16	60	3.85	-
★ SEME640400320E	R0.3	**4.0**	6	6	20	60	3.85	-
★ SEME640400326E	R0.3	**4.0**	6	6	26	65	3.85	-
SEME640400330E	R0.3	**4.0**	6	6	30	70	3.85	-
SEME640400335E	R0.3	**4.0**	6	6	35	70	3.85	-
SEME640400340E	R0.3	**4.0**	6	6	40	80	3.85	-
SEME640400345E	R0.3	**4.0**	6	6	45	90	3.85	-
SEME640400350E	R0.3	**4.0**	6	6	50	100	3.85	-
★ SEME640400510E	R0.5	**4.0**	6	6	10	50	3.85	-
★ SEME640400512E	R0.5	**4.0**	6	6	12	50	3.85	-
★ SEME640400514E	R0.5	**4.0**	6	6	14	60	3.85	-
★ SEME640400516E	R0.5	**4.0**	6	6	16	60	3.85	-
★ SEME640400520E	R0.5	**4.0**	6	6	20	60	3.85	-
★ SEME640400526E	R0.5	**4.0**	6	6	26	65	3.85	-
★ SEME640400530E	R0.5	**4.0**	6	6	30	70	3.85	-
★ SEME640400535E	R0.5	**4.0**	6	6	35	70	3.85	-
★ SEME640400540E	R0.5	**4.0**	6	6	40	80	3.85	-
SEME640400545E	R0.5	**4.0**	6	6	45	90	3.85	-
SEME640400550E	R0.5	**4.0**	6	6	50	100	3.85	-
★ SEME640401010E	R1.0	**4.0**	6	6	10	50	3.85	-

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

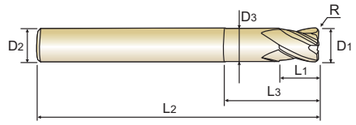
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN | P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME640401012E	R1.0	**4.0**	6	6	12	50	3.85	-
SEME640401014E	R1.0	**4.0**	6	6	14	60	3.85	-
★ SEME640401016E	R1.0	**4.0**	6	6	16	60	3.85	-
★ SEME640401020E	R1.0	**4.0**	6	6	20	60	3.85	-
★ SEME640401026E	R1.0	**4.0**	6	6	26	65	3.85	-
★ SEME640401030E	R1.0	**4.0**	6	6	30	70	3.85	-
SEME640401035E	R1.0	**4.0**	6	6	35	70	3.85	-
SEME640401040E	R1.0	**4.0**	6	6	40	80	3.85	-
SEME640401045E	R1.0	**4.0**	6	6	45	90	3.85	-
SEME640401050E	R1.0	**4.0**	6	6	50	100	3.85	-
SEME6405001E	R0.1	**5.0**	6	8	15	60	4.85	-
SEME6405002E	R0.2	**5.0**	6	8	15	60	4.85	-
SEME6405003E	R0.3	**5.0**	6	8	15	60	4.85	-
SEME6405005E	R0.5	**5.0**	6	8	15	60	4.85	-
SEME6405010E	R1.0	**5.0**	6	8	15	60	4.85	-
SEME6405015E	R1.5	**5.0**	6	8	15	60	4.85	-
SEME6405020E	R2.0	**5.0**	6	8	15	60	4.85	-
SEME6406001E	R0.1	**6.0**	6	9	20	60	5.85	Regular
★ SEME6406002E	R0.2	**6.0**	6	9	20	60	5.85	Regular
★ SEME6406003E	R0.3	**6.0**	6	9	20	60	5.85	Regular
★ SEME6406005E	R0.5	**6.0**	6	9	20	60	5.85	Regular
★ SEME6406010E	R1.0	**6.0**	6	9	20	60	5.85	Regular
SEME6406015E	R1.5	**6.0**	6	9	20	60	5.85	Regular
SEME6406020E	R2.0	**6.0**	6	9	20	60	5.85	Regular

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

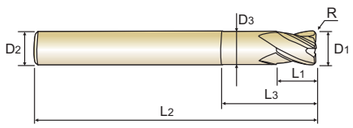
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
★ SEME6406003090E	R0.3	**6.0**	6	15	30	90	5.85	Long
SE5E640600524LE	R0.5	**6.0**	6	9	24	90	5.85	-
★ SEME6406005090E	R0.5	**6.0**	6	15	30	90	5.85	Long
★ SEME6406010090E	R1.0	**6.0**	6	15	30	90	5.85	Long
SEME6408001E	R0.1	**8.0**	8	12	25	70	7.70	Regular
★ SEME6408002E	R0.2	**8.0**	8	12	25	70	7.70	Regular
★ SEME6408003E	R0.3	**8.0**	8	12	25	70	7.70	Regular
★ SEME6408005E	R0.5	**8.0**	8	12	25	70	7.70	Regular
★ SEME6408010E	R1.0	**8.0**	8	12	25	70	7.70	Regular
SEME6408015E	R1.5	**8.0**	8	12	25	70	7.70	Regular
SEME6408020E	R2.0	**8.0**	8	12	25	70	7.70	Regular
SEME6408003100E	R0.3	**8.0**	8	20	35	100	7.70	Long
★ SEME6408005100E	R0.5	**8.0**	8	20	35	100	7.70	Long
★ SEME6408010100E	R1.0	**8.0**	8	20	35	100	7.70	Long
SEME6410001E	R0.1	**10.0**	10	15	30	75	9.70	Regular
SEME6410002E	R0.2	**10.0**	10	15	30	75	9.70	Regular
SEME6410003E	R0.3	**10.0**	10	15	30	75	9.70	Regular
★ SEME6410005E	R0.5	**10.0**	10	15	30	75	9.70	Regular
★ SEME6410010E	R1.0	**10.0**	10	15	30	75	9.70	Regular
★ SEME6410015E	R1.5	**10.0**	10	15	30	75	9.70	Regular
SEME6410020E	R2.0	**10.0**	10	15	30	75	9.70	Regular
SEME6410003100E	R0.3	**10.0**	10	25	40	100	9.70	Long
★ SEME6410005100E	R0.5	**10.0**	10	25	40	100	9.70	Long
★ SEME6410010100E	R1.0	**10.0**	10	25	40	100	9.70	Long

★ : Stock Item

▶ NEXT PAGE

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

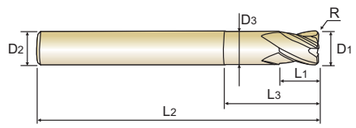
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK

SEME64 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | R ±0.02 | PLAIN

P.144-147

D<Ø3, 30˚

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	Remark
SEME6412002E	R0.2	**12.0**	12	18	32	80	11.70	Regular
SEME6412003E	R0.3	**12.0**	12	18	32	80	11.70	Regular
★ SEME6412005E	R0.5	**12.0**	12	18	32	80	11.70	Regular
★ SEME6412010E	R1.0	**12.0**	12	18	32	80	11.70	Regular
★ SEME6412015E	R1.5	**12.0**	12	18	32	80	11.70	Regular
★ SEME6412020E	R2.0	**12.0**	12	18	32	80	11.70	Regular
SEME6412003110E	R0.3	**12.0**	12	30	50	110	11.70	Long
★ SEME6412005110E	R0.5	**12.0**	12	30	50	110	11.70	Long
★ SEME6412010110E	R1.0	**12.0**	12	30	50	110	11.70	Long
★ SEME6416005E	R0.5	**16.0**	16	20	35	100	15.70	Regular
★ SEME6416010E	R1.0	**16.0**	16	20	35	100	15.70	Regular
SEME6416005150E	R0.5	**16.0**	16	35	50	150	15.70	Long
SEME6416010150E	R1.0	**16.0**	16	35	50	150	15.70	Long
★ SEME6420005E	R0.5	**20.0**	20	25	40	100	19.70	Regular
★ SEME6420010E	R1.0	**20.0**	20	25	40	100	19.70	Regular
SEME6420005150E	R0.5	**20.0**	20	40	55	150	19.70	Long
SEME6420010150E	R1.0	**20.0**	20	40	55	150	19.70	Long

★ : Stock Item

Corner Radius Tolerance (mm)	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
± 0.02	0 ~ - 0.03	h5

◎ : Excellent ○ : Good

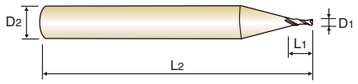
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	◎	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE

SEME35 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ From a sharp edge geometry at the end tooth, cutting abilities at work process is increased.



CARBIDE | 2 | 30° | PLAIN P.148-151

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME35001E	0.1	4	0.2	40
★ SEME350015E	0.15	4	0.3	40
★ SEME35002E	0.2	4	0.4	40
SEME350025E	0.25	4	0.5	40
★ SEME35003E	0.3	4	0.6	40
SEME350035E	0.35	4	0.7	40
★ SEME35004E	0.4	4	0.8	40
SEME350045E	0.45	4	0.9	40
★ SEME35005E	0.5	4	1.0	40
SEME350055E	0.55	4	1.1	40
★ SEME35006E	0.6	4	1.2	40
SEME350065E	0.65	4	1.3	40
★ SEME35007E	0.7	4	1.4	40
SEME350075E	0.75	4	1.5	40
★ SEME35008E	0.8	4	1.6	40
SEME350085E	0.85	4	1.7	40
★ SEME35009E	0.9	4	1.8	40
SEME350095E	0.95	4	2	40
★ SEME35010E	1.0	6	2.5	50
★ SEME35012E	1.2	6	3	50
★ SEME35015E	1.5	6	4	50
★ SEME35020E	2.0	6	6	50
★ SEME35025E	2.5	6	7	50
★ SEME35030E	3.0	6	8	50

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0~ - 0.012	h5
over Ø6	0~ - 0.015	

◎ : Excellent ○ : Good

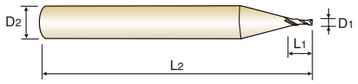
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE

SEME35 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ From a sharp edge geometry at the end tooth, cutting abilities at work process is increased.



CARBIDE | 2 | 30° | PLAIN P.148-151

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME35035E	3.5	6	10	50
★ SEME35040E	4.0	6	10	50
★ SEME35045E	4.5	6	14	50
★ SEME35050E	5.0	6	15	60
★ SEME35055E	5.5	6	15	60
★ SEME35060E	6.0	6	15	60
★ SEME35065E	6.5	8	18	60
★ SEME35070E	7.0	8	20	60
★ SEME35075E	7.5	8	20	60
★ SEME35080E	8.0	8	20	70
★ SEME35085E	8.5	10	22	70
★ SEME35090E	9.0	10	22	70
★ SEME35095E	9.5	10	24	70
★ SEME35100E	10.0	10	25	75
★ SEME35105E	10.5	12	26	75
★ SEME35110E	11.0	12	30	75
SEME35115E	11.5	12	30	80
★ SEME35120E	12.0	12	30	80
★ SEME35130E	13.0	12	35	100
SEME3514012SE	14.0	12	35	100
★ SEME3514014SE	14.0	14	35	100
★ SEME35140E	14.0	16	35	100
★ SEME35150E	15.0	16	38	100
★ SEME35160E	16.0	16	40	100

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0~ - 0.012	h5
over Ø6	0~ - 0.015	

◎ : Excellent ○ : Good

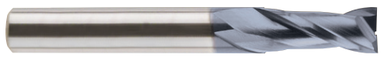
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

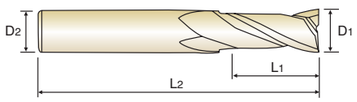
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE

SEME35 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ From a sharp edge geometry at the end tooth, cutting abilities at work process is increased.





CARBIDE 2 30° PLAIN P.148-151

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
SEME35170E	17.0	16	42	100
★ SEME35180E	18.0	16	45	100
SEME3518018SE	18.0	18	45	100
SEME35190E	19.0	20	45	100
★ SEME35200E	20.0	20	45	100
SEME35210E	21.0	20	45	100
SEME35220E	22.0	20	45	100
SEME35230E	23.0	25	50	120
SEME35240E	24.0	25	50	120
SEME35250E	25.0	25	50	120

★ : Stock Item

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0~ - 0.012	h5
over Ø6	0~ - 0.015	

◎ : Excellent ○ : Good

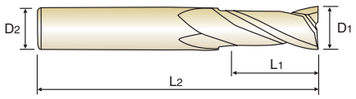
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE (4mm Shank)

SEME35 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ From a sharp edge geometry at the end tooth, cutting abilities at work process is increased.



CARBIDE 2 30° PLAIN P.148-151

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME350104SE	1.0	4	2.5	50
★ SEME350114SE	1.1	4	3	50
★ SEME350124SE	1.2	4	3	50
★ SEME350134SE	1.3	4	3	50
★ SEME350144SE	1.4	4	4	50
★ SEME350154SE	1.5	4	4	50
★ SEME350164SE	1.6	4	4	50
★ SEME350174SE	1.7	4	4	50
★ SEME350184SE	1.8	4	5	50
★ SEME350194SE	1.9	4	5	50
★ SEME350204SE	2.0	4	6	50
SEME350214SE	2.1	4	6	50
★ SEME350224SE	2.2	4	6	50
★ SEME350234SE	2.3	4	6	50
★ SEME350244SE	2.4	4	6	50
★ SEME350254SE	2.5	4	8	50
★ SEME350264SE	2.6	4	8	50
★ SEME350274SE	2.7	4	8	50
★ SEME350284SE	2.8	4	8	50
SEME350294SE	2.9	4	8	50
★ SEME350304SE	3.0	4	8	50
SEME350354SE	3.5	4	10	50
★ SEME350404SE	4.0	4	10	50
★ SEME350404S080E	4.0	4	10	80

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0~ - 0.012	h5

◎ : Excellent ○ : Good

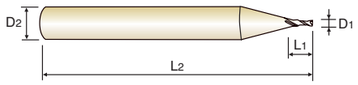
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE (3mm Shank)

SEME35 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ From a sharp edge geometry at the end tooth, cutting abilities at work process is increased.



CARBIDE 2 30° PLAIN P.148-151

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME350013SE	0.1	3	0.2	40
★ SEME350023SE	0.2	3	0.4	40
★ SEME350033SE	0.3	3	0.6	40
★ SEME350043SE	0.4	3	0.8	40
★ SEME350053SE	0.5	3	1.0	40
★ SEME350063SE	0.6	3	1.2	40
★ SEME350073SE	0.7	3	1.4	40
★ SEME350083SE	0.8	3	1.6	40
★ SEME350093SE	0.9	3	1.8	40
★ SEME350103SE	1.0	3	2.5	50
★ SEME350123SE	1.2	3	3	50
★ SEME350153SE	1.5	3	4	50
★ SEME350203SE	2.0	3	6	50
★ SEME350253SE	2.5	3	7	50
★ SEME350303SE	3.0	3	8	50

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0~ - 0.012	h5

◎ : Excellent ○ : Good

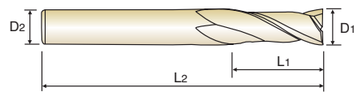
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
▶ Available in various lengths of cut and also overall lengths.



CARBIDE 2 30° PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7001003E	1.0	6	3	60
★ SEME7001004E	1.0	6	4	60
SEME7001005E	1.0	6	5	60
★ SEME7001006E	1.0	6	6	60
SEME7001007E	1.0	6	7	60
★ SEME7001008E	1.0	6	8	60
★ SEME7001010E	1.0	6	10	60
SEME7001012E	1.0	6	12	60
SEME7001204E	1.2	6	4	60
SEME7001206E	1.2	6	6	60
SEME7001208E	1.2	6	8	60
SEME7001210E	1.2	6	10	60
SEME7001212E	1.2	6	12	60
★ SEME7001506E	1.5	6	6	60
★ SEME7001508E	1.5	6	8	60
★ SEME7001510E	1.5	6	10	60
★ SEME7001512E	1.5	6	12	60
SEME7001514E	1.5	6	14	60
★ SEME7001516E	1.5	6	16	60
★ SEME7002008E	2.0	6	8	60
★ SEME7002010E	2.0	6	10	60
★ SEME7002012E	2.0	6	12	60
SEME7002014E	2.0	6	14	60
★ SEME7002016E	2.0	6	16	60

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

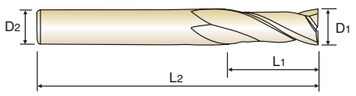
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Available in various lengths of cut and also overall lengths.



CARBIDE | 2 | 30° | PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7002510E	2.5	6	10	60
SEME7002512E	2.5	6	12	60
★ SEME7002516E	2.5	6	16	60
SEME7002520E	2.5	6	20	60
SEME7002526E	2.5	6	26	60
SEME70030163SE	3.0	3	16	100
★ SEME7003010E	3.0	6	10	70
★ SEME7003012E	3.0	6	12	70
★ SEME7003014E	3.0	6	14	70
★ SEME7003016E	3.0	6	16	70
★ SEME7003020E	3.0	6	20	70
★ SEME7003026E	3.0	6	26	70
SEME7003030E	3.0	6	30	70
SEME70040204SE	4.0	4	20	100
★ SEME7004012E	4.0	6	12	70
★ SEME7004016E	4.0	6	16	70
★ SEME7004020E	4.0	6	20	70
★ SEME7004026E	4.0	6	26	70
★ SEME7004030E	4.0	6	30	70
★ SEME7005020E	5.0	6	20	70
★ SEME7005025E	5.0	6	25	70
SEME7005025100E	5.0	6	25	100
★ SEME7005030E	5.0	6	30	80
SEME7005035E	5.0	6	35	90

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

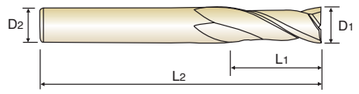
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Available in various lengths of cut and also overall lengths.



CARBIDE | 2 | 30° | PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7005040E	5.0	6	40	100
★ SEME7006015E	6.0	6	15	60
★ SEME7006015080E	6.0	6	15	80
★ SEME7006020E	6.0	6	20	70
★ SEME7006020090E	6.0	6	20	90
★ SEME7006025E	6.0	6	25	75
★ SEME7006030E	6.0	6	30	80
★ SEME7006030100E	6.0	6	30	100
★ SEME7006030150E	6.0	6	30	150
★ SEME7006035E	6.0	6	35	90
★ SEME7006040E	6.0	6	40	90
★ SEME7006040120E	6.0	6	40	120
★ SEME7006045E	6.0	6	45	150
★ SEME7008025E	8.0	8	25	80
★ SEME7008030E	8.0	8	30	80
★ SEME7008030100E	8.0	8	30	100
★ SEME7008035E	8.0	8	35	90
★ SEME7008040E	8.0	8	40	90
★ SEME7008040120E	8.0	8	40	120
SEME7008040150E	8.0	8	40	150
★ SEME7008045E	8.0	8	45	100
★ SEME7008050E	8.0	8	50	100
SEME7008050150E	8.0	8	50	150
★ SEME7010030E	10.0	10	30	80

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

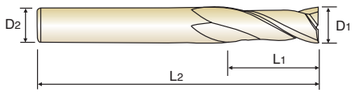
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Available in various lengths of cut and also overall lengths.



CARBIDE 2 30° PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7010030100E	10.0	10	30	100
★ SEME7010035E	10.0	10	35	90
★ SEME7010040E	10.0	10	40	90
★ SEME7010040120E	10.0	10	40	120
★ SEME7010045E	10.0	10	45	100
★ SEME7010050E	10.0	10	50	100
★ SEME7010050150E	10.0	10	50	150
SEME7010050200E	10.0	10	50	200
SEME7010055E	10.0	10	55	150
★ SEME7010060E	10.0	10	60	110
SEME7010060200E	10.0	10	60	200
★ SEME7012035E	12.0	12	35	90
★ SEME7012040E	12.0	12	40	100
★ SEME7012040120E	12.0	12	40	120
★ SEME7012045E	12.0	12	45	130
★ SEME7012050E	12.0	12	50	100
★ SEME7012050150E	12.0	12	50	150
★ SEME7012055E	12.0	12	55	110
★ SEME7012060E	12.0	12	60	110
★ SEME7012060150E	12.0	12	60	150
SEME7012060200E	12.0	12	60	200
SEME7012065E	12.0	12	65	150
SEME7012070E	12.0	12	70	120
SEME7012070200E	12.0	12	70	200

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

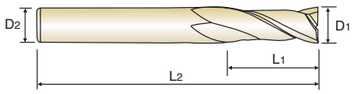
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Available in various lengths of cut and also overall lengths.



CARBIDE 2 30° PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
SEME7014050E	14.0	16	50	110
★ SEME7014060E	14.0	16	60	150
★ SEME7016040E	16.0	16	40	150
SEME7016050E	16.0	16	50	110
SEME7016050150E	16.0	16	50	150
SEME7016060E	16.0	16	60	120
SEME7016070E	16.0	16	70	130
★ SEME7016070150E	16.0	16	70	150
SEME7016070200E	16.0	16	70	200
SEME7016080E	16.0	16	80	150
SEME7016090E	16.0	16	90	150
SEME70160110E	16.0	16	110	200
SEME70160120E	16.0	16	120	250
SEME7018050E	18.0	20	50	120
SEME7018070E	18.0	20	70	130
SEME70180100E	18.0	20	100	200
SEME7020050E	20.0	20	50	110
SEME7020050150E	20.0	20	50	150
SEME7020060E	20.0	20	60	130
SEME7020070E	20.0	20	70	130
SEME7020080E	20.0	20	80	150
SEME7020090E	20.0	20	90	150
★ SEME7020090200E	20.0	20	90	200
★ SEME70200110E	20.0	20	110	200

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

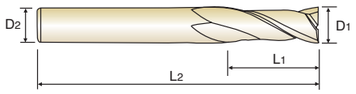
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE LONG LENGTH

SEME70 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ Available in various lengths of cut and also overall lengths.



CARBIDE 2 30° PLAIN P.152-157

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
SEME70200120E	20.0	20	120	250
SEME7022075E	22.0	20	75	150
SEME70220110E	22.0	20	110	200
SEME7025070E	25.0	25	70	150
SEME7025090E	25.0	25	90	150
SEME70250110E	25.0	25	110	200
SEME70250120E	25.0	25	120	250

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

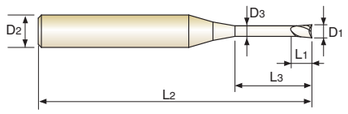
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ For 1.0mm and under 1.0mm diameter size products, it is designed with a double neck to increase tool rigidity and to minimize vibration.
- ▶ Available in several effective lengths of cut and also overall lengths to apply on various rib processing.



CARBIDE 2 30° PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM845001003E	0.1	4	0.15	0.3	40	0.085
★ SEM845001005E	0.1	4	0.15	0.5	40	0.085
SEM84500101E	0.1	4	0.15	1	40	0.085
SEM84500150035SE	0.15	4	0.2	0.35	40	0.13
★ SEM845002005E	0.2	4	0.3	0.5	40	0.17
★ SEM84500201E	0.2	4	0.3	1	40	0.17
★ SEM845002015E	0.2	4	0.3	1.5	40	0.17
★ SEM84500202E	0.2	4	0.3	2	40	0.17
★ SEM84500301E	0.3	4	0.5	1	40	0.27
★ SEM845003015E	0.3	4	0.5	1.5	40	0.27
★ SEM84500302E	0.3	4	0.5	2	40	0.27
SEM845003025E	0.3	4	0.5	2.5	40	0.27
★ SEM84500303E	0.3	4	0.5	3	40	0.27
★ SEM84500304E	0.3	4	0.5	4	40	0.27
SEM84500305E	0.3	4	0.5	5	40	0.27
★ SEM84500401E	0.4	4	0.6	1	40	0.37
★ SEM845004015E	0.4	4	0.6	1.5	40	0.37
★ SEM84500402E	0.4	4	0.6	2	40	0.37
★ SEM845004025E	0.4	4	0.6	2.5	40	0.37
★ SEM84500403E	0.4	4	0.6	3	40	0.37
★ SEM84500404E	0.4	4	0.6	4	40	0.37
★ SEM84500405E	0.4	4	0.6	5	40	0.37
SEM84500406E	0.4	4	0.6	6	40	0.37
SEM84500408E	0.4	4	0.6	8	40	0.37

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

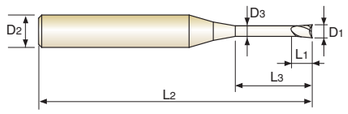
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ For 1.0mm and under 1.0mm diameter size products, it is designed with a double neck to increase tool rigidity and to minimize vibration.
- ▶ Available in several effective lengths of cut and also overall lengths to apply on various rib processing.



CARBIDE 2 30° PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84500410E	0.4	4	0.6	10	40	0.37
★ SEM84500501E	0.5	4	0.7	1	45	0.45
SEM845005015E	0.5	4	0.7	1.5	45	0.45
★ SEM84500502E	0.5	4	0.7	2	45	0.45
SEM845005025E	0.5	4	0.7	2.5	45	0.45
★ SEM84500503E	0.5	4	0.7	3	45	0.45
★ SEM84500504E	0.5	4	0.7	4	45	0.45
★ SEM84500505E	0.5	4	0.7	5	45	0.45
★ SEM84500506E	0.5	4	0.7	6	45	0.45
SEM84500508E	0.5	4	0.7	8	45	0.45
SEM84500510E	0.5	4	0.7	10	45	0.45
SEM84500512E	0.5	4	0.7	12	45	0.45
SEM84500514E	0.5	4	0.7	14	45	0.45
SEM84500516E	0.5	4	0.7	16	45	0.45
★ SEM84500602E	0.6	4	0.9	2	45	0.55
★ SEM84500603E	0.6	4	0.9	3	45	0.55
★ SEM84500604E	0.6	4	0.9	4	45	0.55
★ SEM84500605E	0.6	4	0.9	5	45	0.55
★ SEM84500606E	0.6	4	0.9	6	45	0.55
★ SEM84500608E	0.6	4	0.9	8	45	0.55
★ SEM84500610E	0.6	4	0.9	10	45	0.55
SEM84500612E	0.6	4	0.9	12	45	0.55
SEM84500614E	0.6	4	0.9	14	45	0.55
SEM84500616E	0.6	4	0.9	16	45	0.55

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
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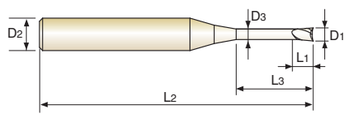
- ▶ Available in several effective lengths of cut and also overall lengths to apply on various rib processing.



CARBIDE 2 30° PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84500702E	0.7	4	1.2	2	45	0.65
★ SEM84500704E	0.7	4	1.2	4	45	0.65
★ SEM84500706E	0.7	4	1.2	6	45	0.65
SEM84500708E	0.7	4	1.2	8	45	0.65
SEM84500710E	0.7	4	1.2	10	45	0.65
SEM84500712E	0.7	4	1.2	12	45	0.65
★ SEM84500802E	0.8	4	1.2	2	45	0.75
★ SEM84500803E	0.8	4	1.2	3	45	0.75
★ SEM84500804E	0.8	4	1.2	4	45	0.75
★ SEM84500805E	0.8	4	1.2	5	45	0.75
★ SEM84500806E	0.8	4	1.2	6	45	0.75
★ SEM84500808E	0.8	4	1.2	8	45	0.75
★ SEM84500810E	0.8	4	1.2	10	45	0.75
SEM84500812E	0.8	4	1.2	12	45	0.75
SEM84500814E	0.8	4	1.2	14	45	0.75
SEM84500816E	0.8	4	1.2	16	45	0.75
SEM84500820E	0.8	4	1.2	20	45	0.75
SEM84500906E	0.9	4	1.3	6	45	0.85
SEM84500908E	0.9	4	1.3	8	45	0.85
SEM84500910E	0.9	4	1.3	10	45	0.85
★ SEM84501002E	1.0	4	1.5	2	50	0.95
★ SEM84501003E	1.0	4	1.5	3	50	0.95
★ SEM84501004E	1.0	4	1.5	4	50	0.95
★ SEM84501005E	1.0	4	1.5	5	50	0.95

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

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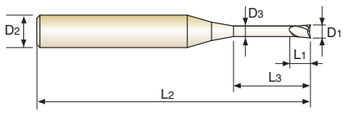

CARBIDE | 2 | 30° | PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84501006E	1.0	4	1.5	6	50	0.95
SEM84501007E	1.0	4	1.5	7	50	0.95
★ SEM84501008E	1.0	4	1.5	8	50	0.95
★ SEM84501010E	1.0	4	1.5	10	50	0.95
★ SEM84501012E	1.0	4	1.5	12	50	0.95
★ SEM84501014E	1.0	4	1.5	14	50	0.95
★ SEM84501016E	1.0	4	1.5	16	50	0.95
SEM84501018E	1.0	4	1.5	18	50	0.95
★ SEM84501020E	1.0	4	1.5	20	50	0.95
SEM84501022E	1.0	4	1.5	22	60	0.95
SEM84501026E	1.0	4	1.5	26	60	0.95
SEM84501030E	1.0	4	1.5	30	70	0.95
SEM84501040E	1.0	4	1.5	40	80	0.95
SEM84501050E	1.0	4	1.5	50	100	0.95
SEM84501204E	1.2	4	1.8	4	50	1.15
★ SEM84501206E	1.2	4	1.8	6	50	1.15
★ SEM84501208E	1.2	4	1.8	8	50	1.15
★ SEM84501210E	1.2	4	1.8	10	50	1.15
★ SEM84501212E	1.2	4	1.8	12	50	1.15
SEM84501214E	1.2	4	1.8	14	50	1.15
SEM84501216E	1.2	4	1.8	16	50	1.15
SEM84501220E	1.2	4	1.8	20	50	1.15
SEM84501226E	1.2	4	1.8	26	60	1.15
SEM84501230E	1.2	4	1.8	30	70	1.15

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

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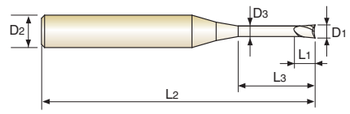

CARBIDE | 2 | 30° | PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84501406E	1.4	4	2.1	6	50	1.35
★ SEM84501408E	1.4	4	2.1	8	50	1.35
SEM84501410E	1.4	4	2.1	10	50	1.35
SEM84501414E	1.4	4	2.1	14	50	1.35
SEM84501416E	1.4	4	2.1	16	50	1.35
SEM84501420E	1.4	4	2.1	20	50	1.35
★ SEM84501504E	1.5	4	2.3	4	50	1.45
SEM84501505E	1.5	4	2.3	5	50	1.45
★ SEM84501506E	1.5	4	2.3	6	50	1.45
SEM84501507E	1.5	4	2.3	7	50	1.45
★ SEM84501508E	1.5	4	2.3	8	50	1.45
★ SEM84501510E	1.5	4	2.3	10	50	1.45
★ SEM84501512E	1.5	4	2.3	12	50	1.45
★ SEM84501514E	1.5	4	2.3	14	50	1.45
★ SEM84501516E	1.5	4	2.3	16	50	1.45
★ SEM84501518E	1.5	4	2.3	18	50	1.45
★ SEM84501520E	1.5	4	2.3	20	50	1.45
SEM84501522E	1.5	4	2.3	22	60	1.45
SEM84501526E	1.5	4	2.3	26	60	1.45
SEM84501530E	1.5	4	2.3	30	70	1.45
SEM84501608E	1.6	4	2.3	8	50	1.55
SEM84501610E	1.6	4	2.3	10	50	1.55
SEM84501612E	1.6	4	2.3	12	50	1.55
SEM84501616E	1.6	4	2.3	16	50	1.55

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

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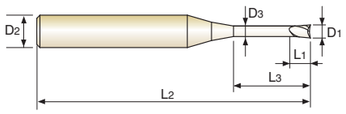

CARBIDE | 2 | 30° | PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEM84501620E	1.6	4	2.3	20	50	1.55
★ SEM84501808E	1.8	4	2.7	8	50	1.75
★ SEM84501810E	1.8	4	2.7	10	50	1.75
★ SEM84501812E	1.8	4	2.7	12	50	1.75
SEM84501816E	1.8	4	2.7	16	50	1.75
SEM84501820E	1.8	4	2.7	20	50	1.75
★ SEM84502006E	2.0	4	3	6	50	1.95
★ SEM84502008E	2.0	4	3	8	50	1.95
★ SEM84502010E	2.0	4	3	10	50	1.95
★ SEM84502012E	2.0	4	3	12	50	1.95
★ SEM84502014E	2.0	4	3	14	50	1.95
★ SEM84502016E	2.0	4	3	16	50	1.95
SEM84502018E	2.0	4	3	18	50	1.95
★ SEM84502020E	2.0	4	3	20	50	1.95
SEM84502022E	2.0	4	3	22	60	1.95
★ SEM84502026E	2.0	4	3	26	60	1.95
★ SEM84502030E	2.0	4	3	30	70	1.95
★ SEM84502035E	2.0	4	3	35	70	1.95
★ SEM84502040E	2.0	4	3	40	80	1.95
SEM84502045E	2.0	4	3	45	90	1.95
SEM84502050E	2.0	4	3	50	100	1.95
SEM84502060E	2.0	4	3	60	110	1.95
★ SEM84502508E	2.5	4	4	8	50	2.40
★ SEM84502510E	2.5	4	4	10	50	2.40

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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2 FLUTE with EXTENDED NECK

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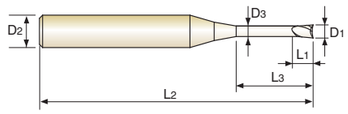

CARBIDE | 2 | 30° | PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84502512E	2.5	4	4	12	50	2.40
SEM84502514E	2.5	4	4	14	50	2.40
★ SEM84502516E	2.5	4	4	16	50	2.40
SEM84502518E	2.5	4	4	18	50	2.40
★ SEM84502520E	2.5	4	4	20	50	2.40
SEM84502522E	2.5	4	4	22	60	2.40
★ SEM84502526E	2.5	4	4	26	60	2.40
SEM84502530E	2.5	4	4	30	70	2.40
SEM84502535E	2.5	4	4	35	70	2.40
SEM84502540E	2.5	4	4	40	80	2.40
SEM84502545E	2.5	4	4	45	90	2.40
SEM84502550E	2.5	4	4	50	100	2.40
★ SEM84503006E	3.0	6	4.5	6	50	2.85
★ SEM84503008E	3.0	6	4.5	8	50	2.85
★ SEM84503010E	3.0	6	4.5	10	50	2.85
★ SEM84503012E	3.0	6	4.5	12	50	2.85
★ SEM84503014E	3.0	6	4.5	14	60	2.85
★ SEM84503016E	3.0	6	4.5	16	60	2.85
★ SEM84503018E	3.0	6	4.5	18	60	2.85
★ SEM84503020E	3.0	6	4.5	20	60	2.85
SEM84503022E	3.0	6	4.5	22	65	2.85
★ SEM84503026E	3.0	6	4.5	26	65	2.85
★ SEM84503030E	3.0	6	4.5	30	70	2.85
★ SEM84503035E	3.0	6	4.5	35	70	2.85

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

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ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

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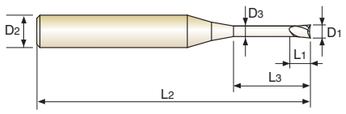
- ▶ For 1.0mm and under 1.0mm diameter size products, it is designed with a double neck to increase tool rigidity and to minimize vibration.
- ▶ Available in several effective lengths of cut and also overall lengths to apply on various rib processing.



CARBIDE 2 30° PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84503040E	3.0	6	4.5	40	80	2.85
SEM84503045E	3.0	6	4.5	45	90	2.85
SEM84503050E	3.0	6	4.5	50	100	2.85
SEM84503060E	3.0	6	4.5	60	100	2.85
SEM84504008E	4.0	6	6	8	50	3.85
★ SEM84504010E	4.0	6	6	10	50	3.85
★ SEM84504012E	4.0	6	6	12	50	3.85
SEM84504014E	4.0	6	6	14	60	3.85
★ SEM84504016E	4.0	6	6	16	60	3.85
★ SEM84504018E	4.0	6	6	18	60	3.85
★ SEM84504020E	4.0	6	6	20	60	3.85
SEM84504022E	4.0	6	6	22	65	3.85
★ SEM84504026E	4.0	6	6	26	65	3.85
★ SEM84504030E	4.0	6	6	30	70	3.85
★ SEM84504035E	4.0	6	6	35	70	3.85
★ SEM84504040E	4.0	6	6	40	80	3.85
★ SEM84504045E	4.0	6	6	45	90	3.85
SEM84504050E	4.0	6	6	50	100	3.85
SEM84504060E	4.0	6	6	60	100	3.85
SEM84505016E	5.0	6	8	16	60	4.85
★ SEM84505020E	5.0	6	8	20	60	4.85
SEM84505026E	5.0	6	8	26	65	4.85
★ SEM84505030E	5.0	6	8	30	70	4.85
★ SEM84505035E	5.0	6	8	35	75	4.85

★ : Stock Item

▶ NEXT PAGE

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

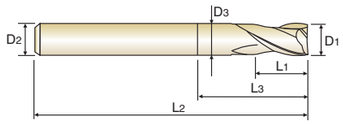
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
2 FLUTE with EXTENDED NECK

SEM845 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ For 1.0mm and under 1.0mm diameter size products, it is designed with a double neck to increase tool rigidity and to minimize vibration.
- ▶ Available in several effective lengths of cut and also overall lengths to apply on various rib processing.



CARBIDE 2 30° PLAIN P.158-167

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEM84505040E	5.0	6	8	40	80	4.85
★ SEM84505050E	5.0	6	8	50	90	4.85
SEM84505060E	5.0	6	8	60	100	4.85
★ SEM84506015E	6.0	6	9	15	60	5.85
★ SEM84506020E	6.0	6	9	20	60	5.85
★ SEM84506030E	6.0	6	9	30	70	5.85
★ SEM84506032E	6.0	6	9	32	90	5.85
★ SEM84508025E	8.0	8	12	25	70	7.70
★ SEM84508030E	8.0	8	12	30	80	7.70
★ SEM84508042E	8.0	8	12	42	100	7.70
★ SEM84510030E	10.0	10	15	30	75	9.70
SEM84510035E	10.0	10	15	35	80	9.70
★ SEM84510045E	10.0	10	15	45	100	9.70
★ SEM84512035E	12.0	12	20	35	80	11.70
SEM84512040E	12.0	12	20	40	90	11.70
★ SEM84512050E	12.0	12	20	50	110	11.70

★ : Stock Item

Size	Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
up to Ø6	0 ~ - 0.012	h5
over Ø6	0 ~ - 0.015	

◎ : Excellent ○ : Good

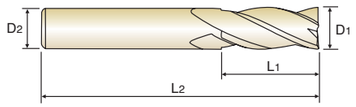
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX

SEME36 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter end mills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | PLAIN P.168-171

D<Ø3, 30˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME36008E	0.8	4	1.6	40	4mm Shank
SEME36009E	0.9	4	1.8	40	4mm Shank
SEME360104SE	1.0	4	2.5	50	4mm Shank
★ SEME36010E	1.0	6	2.5	50	-
SEME360124SE	1.2	4	3	50	4mm Shank
SEME36012E	1.2	6	3	50	-
SEME360154SE	1.5	4	4	50	4mm Shank
★ SEME36015E	1.5	6	4	50	-
SEME360204SE	2.0	4	6	50	4mm Shank
★ SEME36020E	2.0	6	6	50	-
SEME360254SE	2.5	4	7	50	4mm Shank
★ SEME36025E	2.5	6	7	50	-
★ SEME36030E	3.0	6	8	50	-
★ SEME36035E	3.5	6	10	50	-
★ SEME36040E	4.0	6	10	50	-
★ SEME36045E	4.5	6	14	50	-
★ SEME36050E	5.0	6	15	60	-
★ SEME36055E	5.5	6	15	60	-
★ SEME36060E	6.0	6	15	60	-
★ SEME36065E	6.5	8	18	60	-
★ SEME36070E	7.0	8	20	60	-
★ SEME36075E	7.5	8	20	60	-
★ SEME36080E	8.0	8	20	70	-
★ SEME36085E	8.5	10	22	70	-

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

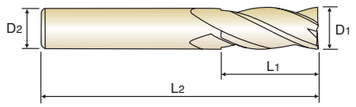
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE MULTIPLE HELIX

SEME36 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter end mills minimizing vibration and decreasing wear in cutting.



CARBIDE | 4 | 27°/30° | PLAIN P.168-171

D<Ø3, 30˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEME36090E	9.0	10	22	70	-
★ SEME36095E	9.5	10	24	70	-
★ SEME36100E	10.0	10	25	75	-
SEME36105E	10.5	12	26	75	-
★ SEME36110E	11.0	12	30	75	-
SEME36115E	11.5	12	30	80	-
★ SEME36120E	12.0	12	30	80	-
SEME36130E	13.0	12	35	100	-
SEME3614012SE	14.0	12	35	100	-
★ SEME3614014SE	14.0	14	35	100	-
★ SEME36140E	14.0	16	35	100	-
SEME36150E	15.0	16	38	100	-
★ SEME36160E	16.0	16	40	100	-
SEME36170E	17.0	16	42	100	-
★ SEME36180E	18.0	16	45	100	-
★ SEME3618018SE	18.0	18	45	100	-
SEME36190E	19.0	20	45	100	-
★ SEME36200E	20.0	20	45	100	-
SEME36210E	21.0	20	45	100	-
SEME36220E	22.0	20	45	100	-
SEME36230E	23.0	25	50	120	-
SEME36240E	24.0	25	50	120	-
SEME36250E	25.0	25	50	120	-

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

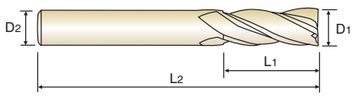
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

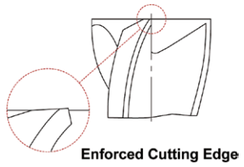
Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX (Sharp Corner Removal)

SEME71 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
  - Equal index flutes design for long length and single helix (38°) end mills.
- ▶ Gash land geometry applied at the end tooth, achieving heavy duty cutting.
- ▶ Available various length products like short, regular and long length end mills etc.
- ▶ Available in short, regular and long shank end mills.





Enforced Cutting Edge

CARBIDE | 4 | 35°/38° | PLAIN P.168-171

D<Ø3, Long Length 38˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME71010014SE	1.0	4	1	40	4mm Shank
SEME71010024SE	1.0	4	2	40	4mm Shank
SEME710104SE	1.0	4	2.5	50	4mm Shank
SEME71010034SE	1.0	4	3	50	4mm Shank
SEME71010044SE	1.0	4	4	50	4mm Shank
SEME71010064SE	1.0	4	6	50	4mm Shank
SEME7101001E	1.0	6	1	40	Short
SEME7101002E	1.0	6	2	40	Short
★ SEME71010E	1.0	6	2.5	50	Regular
SEME7101003E	1.0	6	3	50	Long
SEME7101004E	1.0	6	4	50	Long
SEME7101006E	1.0	6	6	50	Long
SEME71012024SE	1.2	4	2	40	4mm Shank
SEME710124SE	1.2	4	3	50	4mm Shank
SEME71012044SE	1.2	4	4	50	4mm Shank
SEME71012064SE	1.2	4	6	50	4mm Shank
SEME7101202E	1.2	6	2	40	Short
★ SEME71012E	1.2	6	3	50	Regular
SEME7101204E	1.2	6	4	50	Long
SEME7101206E	1.2	6	6	50	Long
SEME710150154SE	1.5	4	1.5	40	4mm Shank
SEME71015034SE	1.5	4	3	40	4mm Shank
SEME710154SE	1.5	4	4	50	4mm Shank
SEME71015064SE	1.5	4	6	50	4mm Shank

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

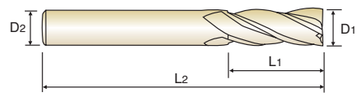
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

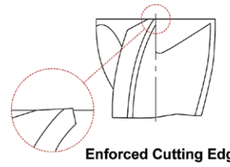
Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX (Sharp Corner Removal)

SEME71 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
  - Equal index flutes design for long length and single helix (38°) end mills.
- ▶ Gash land geometry applied at the end tooth, achieving heavy duty cutting.
- ▶ Available various length products like short, regular and long length end mills etc.
- ▶ Available in short, regular and long shank end mills.





Enforced Cutting Edge

CARBIDE | 4 | 35°/38° | PLAIN P.168-171

D<Ø3, Long Length 38˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME71015084SE	1.5	4	8	50	4mm Shank
SEME71015104SE	1.5	4	10	50	4mm Shank
SEME71015015E	1.5	6	1.5	40	Short
SEME7101503E	1.5	6	3	40	Short
★ SEME71015E	1.5	6	4	50	Regular
SEME7101506E	1.5	6	6	50	Long
SEME7101508E	1.5	6	8	50	Long
SEME7101510E	1.5	6	10	50	Long
SEME71020024SE	2.0	4	2	40	4mm Shank
SEME71020044SE	2.0	4	4	40	4mm Shank
SEME710204SE	2.0	4	6	50	4mm Shank
SEME71020084SE	2.0	4	8	50	4mm Shank
SEME71020104SE	2.0	4	10	50	4mm Shank
SEME71020124SE	2.0	4	12	50	4mm Shank
SEME7102002E	2.0	6	2	40	Short
SEME7102004E	2.0	6	4	40	Short
★ SEME71020E	2.0	6	6	50	Regular
SEME7102008E	2.0	6	8	50	Long
SEME7102010E	2.0	6	10	50	Long
SEME7102012E	2.0	6	12	50	Long
SEME710250254SE	2.5	4	2.5	40	4mm Shank
SEME71025054SE	2.5	4	5	40	4mm Shank
SEME710254SE	2.5	4	7	50	4mm Shank
SEME71025104SE	2.5	4	10	50	4mm Shank

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

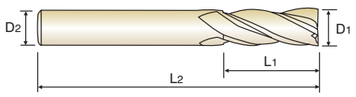
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

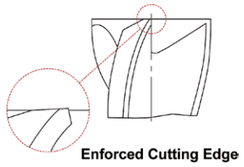
Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX (Sharp Corner Removal)

SEME71 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
  - Equal index flutes design for long length and single helix (38°) end mills.
- ▶ Gash land geometry applied at the end tooth, achieving heavy duty cutting.
- ▶ Available various length products like short, regular and long length end mills etc.
- ▶ Available in short, regular and long shank end mills.





Enforced Cutting Edge

CARBIDE | 4 | 35°/38° | PLAIN P.168-171

D<Ø3, Long Length 38˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME71025124SE	2.5	4	12	50	4mm Shank
SEME71025025E	2.5	6	2.5	40	Short
SEME7102505E	2.5	6	5	40	Short
★ SEME71025E	2.5	6	7	50	Regular
SEME7102510E	2.5	6	10	50	Long
SEME7102512E	2.5	6	12	50	Long
SEME7103003E	3.0	6	3	40	Short
SEME7103006E	3.0	6	6	40	Short
★ SEME71030E	3.0	6	8	50	Regular
SEME7103010E	3.0	6	10	50	Long
SEME7103012E	3.0	6	12	50	Long
SEME7103014E	3.0	6	14	50	Long
SEME7104004E	4.0	6	4	40	Short
SEME7104008E	4.0	6	8	40	Short
★ SEME71040E	4.0	6	10	50	Regular
SEME7104012E	4.0	6	12	50	Long
SEME7104014E	4.0	6	14	50	Long
SEME7104016E	4.0	6	16	50	Long
SEME7105005E	5.0	6	5	50	Short
SEME7105010E	5.0	6	10	50	Short
★ SEME71050E	5.0	6	15	60	Regular
SEME7105020E	5.0	6	20	60	Long
SEME7105025E	5.0	6	25	60	Long
SEME7106006E	6.0	6	6	50	Short

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

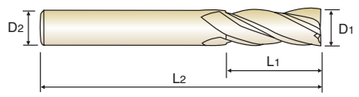
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

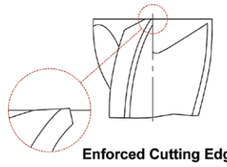
Y-COATED SOLID CARBIDE END MILLS

4 FLUTE MULTIPLE HELIX (Sharp Corner Removal)

SEME71 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Multiple Helix for 3.0mm and over 3.0mm diameter endmills minimizing vibration and decreasing wear in cutting.
  - Equal index flutes design for long length and single helix (38°) end mills.
- ▶ Gash land geometry applied at the end tooth, achieving heavy duty cutting.
- ▶ Available various length products like short, regular and long length end mills etc.
- ▶ Available in short, regular and long shank end mills.





Enforced Cutting Edge

CARBIDE | 4 | 35°/38° | PLAIN P.168-171

D<Ø3, Long Length 38˚

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME7106012E	6.0	6	12	50	Short
★ SEME71060E	6.0	6	15	60	Regular
SEME7106020E	6.0	6	20	60	Long
SEME7106025E	6.0	6	25	60	Long
SEME7108016E	8.0	8	16	60	Short
★ SEME71080E	8.0	8	20	70	Regular
SEME7108025E	8.0	8	25	70	Long
SEME7108030E	8.0	8	30	70	Long
★ SEME7110022E	10.0	10	22	65	Short
★ SEME71100E	10.0	10	25	75	Regular
★ SEME7110030E	10.0	10	30	75	Long
★ SEME7110035E	10.0	10	35	75	Long
SEME7112026E	12.0	12	26	70	Short
★ SEME71120E	12.0	12	30	80	Regular
★ SEME7112035E	12.0	12	35	80	Long
★ SEME7112040E	12.0	12	40	80	Long
SEME71140E	14.0	16	35	100	Regular
★ SEME7116032E	16.0	16	32	100	Short
★ SEME71160E	16.0	16	40	100	Regular
SEME71180E	18.0	20	45	100	Regular
★ SEME71200E	20.0	20	45	100	Regular

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

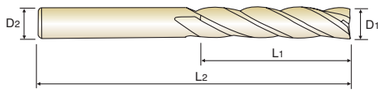
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎			○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
▶ Available in short, regular and long shank end mills.



CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7201003E	1.0	6	3	60
★ SEME7201004E	1.0	6	4	60
★ SEME7201005E	1.0	6	5	60
★ SEME7201006E	1.0	6	6	60
SEME7201007E	1.0	6	7	60
★ SEME7201008E	1.0	6	8	60
SEME7201010E	1.0	6	10	60
SEME7201012E	1.0	6	12	60
SEME7201204E	1.2	6	4	60
SEME7201206E	1.2	6	6	60
SEME7201208E	1.2	6	8	60
SEME7201210E	1.2	6	10	60
SEME7201212E	1.2	6	12	60
★ SEME7201506E	1.5	6	6	60
★ SEME7201508E	1.5	6	8	60
SEME7201510E	1.5	6	10	60
SEME7201512E	1.5	6	12	60
SEME7201514E	1.5	6	14	60
SEME7201516E	1.5	6	16	60
★ SEME7202008E	2.0	6	8	60
★ SEME7202010E	2.0	6	10	60
★ SEME7202012E	2.0	6	12	60
★ SEME7202014E	2.0	6	14	60
★ SEME7202016E	2.0	6	16	60

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

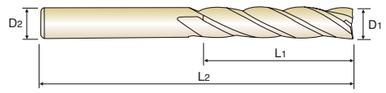
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
▶ Available in short, regular and long shank end mills.



CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7202510E	2.5	6	10	60
★ SEME7202512E	2.5	6	12	60
SEME7202516E	2.5	6	16	60
SEME7202520E	2.5	6	20	60
SEME7202526E	2.5	6	26	60
SEME72030163SE	3.0	3	16	100
★ SEME7203010E	3.0	6	10	70
★ SEME7203012E	3.0	6	12	70
★ SEME7203014E	3.0	6	14	70
★ SEME7203016E	3.0	6	16	70
★ SEME7203020E	3.0	6	20	70
★ SEME7203026E	3.0	6	26	70
★ SEME7203030E	3.0	6	30	70
★ SEME72040204SE	4.0	4	20	100
★ SEME7204012E	4.0	6	12	70
★ SEME7204016E	4.0	6	16	70
★ SEME7204020E	4.0	6	20	70
★ SEME7204026E	4.0	6	26	70
★ SEME7204030E	4.0	6	30	70
★ SEME7205020E	5.0	6	20	70
★ SEME7205025E	5.0	6	25	70
★ SEME7205025100E	5.0	6	25	100
★ SEME7205030E	5.0	6	30	80
★ SEME7205035E	5.0	6	35	90

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
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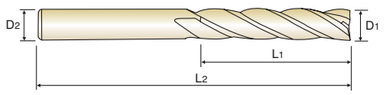
▶ Available in short, regular and long shank end mills.



CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7205040E	5.0	6	40	100
★ SEME7206015E	6.0	6	15	60
★ SEME7206015080E	6.0	6	15	80
★ SEME7206020E	6.0	6	20	70
★ SEME7206020090E	6.0	6	20	90
★ SEME7206025E	6.0	6	25	75
★ SEME7206030E	6.0	6	30	80
★ SEME7206030100E	6.0	6	30	100
SEME7206030150E	6.0	6	30	150
★ SEME7206035E	6.0	6	35	90
★ SEME7206040E	6.0	6	40	90
★ SEME7206040120E	6.0	6	40	120
★ SEME7206045E	6.0	6	45	150
★ SEME7208025E	8.0	8	25	80
★ SEME7208030E	8.0	8	30	80
★ SEME7208030100E	8.0	8	30	100
★ SEME7208035E	8.0	8	35	90
★ SEME7208040E	8.0	8	40	90
SEME7208040120E	8.0	8	40	120
SEME7208040150E	8.0	8	40	150
★ SEME7208045E	8.0	8	45	100
★ SEME7208050E	8.0	8	50	100
★ SEME7208050150E	8.0	8	50	150
★ SEME7210030E	10.0	10	30	80

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

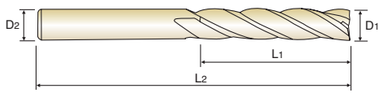
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
▶ Available in short, regular and long shank end mills.



CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7210030100E	10.0	10	30	100
★ SEME7210035E	10.0	10	35	90
★ SEME7210040E	10.0	10	40	90
★ SEME7210040120E	10.0	10	40	120
★ SEME7210045E	10.0	10	45	100
★ SEME7210050E	10.0	10	50	100
★ SEME7210050150E	10.0	10	50	150
SEME7210050200E	10.0	10	50	200
★ SEME7210055E	10.0	10	55	150
★ SEME7210060E	10.0	10	60	110
SEME7210060200E	10.0	10	60	200
★ SEME7212035E	12.0	12	35	90
★ SEME7212040E	12.0	12	40	100
★ SEME7212040120E	12.0	12	40	120
★ SEME7212045E	12.0	12	45	130
★ SEME7212050E	12.0	12	50	100
★ SEME7212050150E	12.0	12	50	150
★ SEME7212055E	12.0	12	55	110
★ SEME7212060E	12.0	12	60	110
★ SEME7212060150E	12.0	12	60	150
SEME7212060200E	12.0	12	60	200
SEME7212065E	12.0	12	65	150
SEME7212070E	12.0	12	70	120
SEME7212070200E	12.0	12	70	200

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

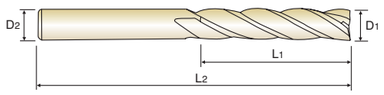
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
▶ Available in short, regular and long shank end mills.



CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME7214050E	14.0	16	50	110
★ SEME7214060E	14.0	16	60	150
SEME7216040E	16.0	16	40	150
★ SEME7216050E	16.0	16	50	110
SEME7216050150E	16.0	16	50	150
★ SEME7216060E	16.0	16	60	120
★ SEME7216070E	16.0	16	70	130
★ SEME7216070150E	16.0	16	70	150
SEME7216070200E	16.0	16	70	200
SEME7216080E	16.0	16	80	150
SEME7216090E	16.0	16	90	150
SEME72160110E	16.0	16	110	200
SEME72160120E	16.0	16	120	250
SEME7218050E	18.0	20	50	120
SEME7218070E	18.0	20	70	130
SEME72180100E	18.0	20	100	200
★ SEME7220050E	20.0	20	50	110
SEME7220050150E	20.0	20	50	150
★ SEME7220060E	20.0	20	60	130
★ SEME7220070E	20.0	20	70	130
SEME7220080E	20.0	20	80	150
★ SEME7220090E	20.0	20	90	150
★ SEME7220090200E	20.0	20	90	200
SEME72200110E	20.0	20	110	200

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE LONG LENGTH

SEME72 SERIES

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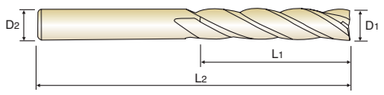

CARBIDE 4 30° PLAIN P.172-177

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
★ SEME72200120E	20.0	20	120	250
SEME7222075E	22.0	20	75	150
SEME72220110E	22.0	20	110	200
SEME7225070E	25.0	25	70	150
★ SEME7225090E	25.0	25	90	150
SEME72250110E	25.0	25	110	200
SEME72250120E	25.0	25	120	250

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE with EXTENDED NECK

SEME73 SERIES

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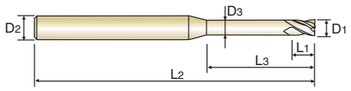

CARBIDE | 4 | 30° | PLAIN P.178-183

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEME7301002E	1.0	4	1.5	2	50	0.95
SEME7301003E	1.0	4	1.5	3	50	0.95
★ SEME7301004E	1.0	4	1.5	4	50	0.95
★ SEME7301005E	1.0	4	1.5	5	50	0.95
★ SEME7301006E	1.0	4	1.5	6	50	0.95
SEME7301007E	1.0	4	1.5	7	50	0.95
★ SEME7301008E	1.0	4	1.5	8	50	0.95
★ SEME7301010E	1.0	4	1.5	10	50	0.95
★ SEME7301012E	1.0	4	1.5	12	50	0.95
SEME7301014E	1.0	4	1.5	14	50	0.95
SEME7301016E	1.0	4	1.5	16	50	0.95
SEME7301018E	1.0	4	1.5	18	50	0.95
SEME7301020E	1.0	4	1.5	20	50	0.95
SEME7301022E	1.0	4	1.5	22	60	0.95
SEME7301026E	1.0	4	1.5	26	60	0.95
SEME7301030E	1.0	4	1.5	30	70	0.95
SEME7301040E	1.0	4	1.5	40	80	0.95
SEME7301050E	1.0	4	1.5	50	100	0.95
SEME7301204E	1.2	4	1.8	4	50	1.15
SEME7301206E	1.2	4	1.8	6	50	1.15
SEME7301208E	1.2	4	1.8	8	50	1.15
SEME7301210E	1.2	4	1.8	10	50	1.15
SEME7301212E	1.2	4	1.8	12	50	1.15
SEME7301214E	1.2	4	1.8	14	50	1.15
SEME7301216E	1.2	4	1.8	16	50	1.15
SEME7301220E	1.2	4	1.8	20	50	1.15

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE with EXTENDED NECK

SEME73 SERIES

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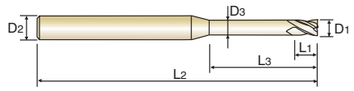

CARBIDE | 4 | 30° | PLAIN P.178-183

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEME7301226E	1.2	4	1.8	26	60	1.15
SEME7301230E	1.2	4	1.8	30	70	1.15
SEME7301504E	1.5	4	2.3	4	50	1.45
SEME7301505E	1.5	4	2.3	5	50	1.45
★ SEME7301506E	1.5	4	2.3	6	50	1.45
SEME7301507E	1.5	4	2.3	7	50	1.45
★ SEME7301508E	1.5	4	2.3	8	50	1.45
★ SEME7301510E	1.5	4	2.3	10	50	1.45
★ SEME7301512E	1.5	4	2.3	12	50	1.45
SEME7301514E	1.5	4	2.3	14	50	1.45
★ SEME7301516E	1.5	4	2.3	16	50	1.45
SEME7301518E	1.5	4	2.3	18	50	1.45
SEME7301520E	1.5	4	2.3	20	50	1.45
SEME7301522E	1.5	4	2.3	22	60	1.45
SEME7301526E	1.5	4	2.3	26	60	1.45
SEME7301530E	1.5	4	2.3	30	70	1.45
★ SEME7302006E	2.0	4	3	6	50	1.95
★ SEME7302008E	2.0	4	3	8	50	1.95
★ SEME7302010E	2.0	4	3	10	50	1.95
★ SEME7302012E	2.0	4	3	12	50	1.95
★ SEME7302014E	2.0	4	3	14	50	1.95
★ SEME7302016E	2.0	4	3	16	50	1.95
SEME7302018E	2.0	4	3	18	50	1.95
★ SEME7302020E	2.0	4	3	20	50	1.95
SEME7302022E	2.0	4	3	22	60	1.95
★ SEME7302026E	2.0	4	3	26	60	1.95

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE with EXTENDED NECK

SEME73 SERIES

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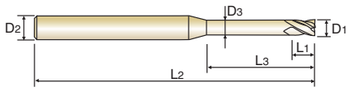

CARBIDE | 4 | 30° | PLAIN P.178-183

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
SEME7302030E	2.0	4	3	30	70	1.95
SEME7302035E	2.0	4	3	35	70	1.95
SEME7302040E	2.0	4	3	40	80	1.95
SEME7302045E	2.0	4	3	45	90	1.95
SEME7302050E	2.0	4	3	50	100	1.95
SEME7302060E	2.0	4	3	60	110	1.95
SEME7302508E	2.5	4	4	8	50	2.40
★ SEME7302510E	2.5	4	4	10	50	2.40
★ SEME7302512E	2.5	4	4	12	50	2.40
SEME7302514E	2.5	4	4	14	50	2.40
SEME7302516E	2.5	4	4	16	50	2.40
SEME7302518E	2.5	4	4	18	50	2.40
SEME7302520E	2.5	4	4	20	50	2.40
SEME7302522E	2.5	4	4	22	60	2.40
SEME7302526E	2.5	4	4	26	60	2.40
SEME7302530E	2.5	4	4	30	70	2.40
SEME7302535E	2.5	4	4	35	70	2.40
SEME7302540E	2.5	4	4	40	80	2.40
SEME7302545E	2.5	4	4	45	90	2.40
SEME7302550E	2.5	4	4	50	100	2.40
SEME7303006E	3.0	6	4.5	6	50	2.85
★ SEME7303008E	3.0	6	4.5	8	50	2.85
★ SEME7303010E	3.0	6	4.5	10	50	2.85
SEME7303012E	3.0	6	4.5	12	50	2.85
★ SEME7303014E	3.0	6	4.5	14	60	2.85
SEME7303016E	3.0	6	4.5	16	60	2.85

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE with EXTENDED NECK

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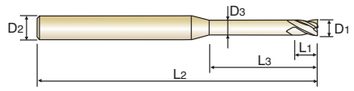


CARBIDE | 4 | 30° | PLAIN P.178-183

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEME7303018E	3.0	6	4.5	18	60	2.85
SEME7303020E	3.0	6	4.5	20	60	2.85
★ SEME7303022E	3.0	6	4.5	22	65	2.85
★ SEME7303026E	3.0	6	4.5	26	65	2.85
SEME7303030E	3.0	6	4.5	30	70	2.85
SEME7303035E	3.0	6	4.5	35	70	2.85
SEME7303040E	3.0	6	4.5	40	80	2.85
SEME7303045E	3.0	6	4.5	45	90	2.85
SEME7303050E	3.0	6	4.5	50	100	2.85
SEME7303060E	3.0	6	4.5	60	100	2.85
SEME7304008E	4.0	6	6	8	50	3.85
★ SEME7304010E	4.0	6	6	10	50	3.85
SEME7304012E	4.0	6	6	12	50	3.85
★ SEME7304014E	4.0	6	6	14	60	3.85
SEME7304016E	4.0	6	6	16	60	3.85
★ SEME7304018E	4.0	6	6	18	60	3.85
SEME7304020E	4.0	6	6	20	60	3.85
★ SEME7304022E	4.0	6	6	22	65	3.85
SEME7304025E	4.0	6	6	25	65	3.85
★ SEME7304026E	4.0	6	6	26	65	3.85
SEME7304030E	4.0	6	6	30	70	3.85
★ SEME7304035E	4.0	6	6	35	70	3.85
SEME7304040E	4.0	6	6	40	80	3.85
SEME7304045E	4.0	6	6	45	90	3.85
SEME7304050E	4.0	6	6	50	100	3.85
SEME7304060E	4.0	6	6	60	100	3.85

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

▶ NEXT PAGE

◎ : Excellent ○ : Good

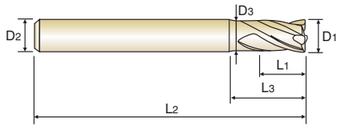
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
4 FLUTE with EXTENDED NECK

SEME73 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent for cutting prehardened steels, carbon steels, alloy steels of molds and dies, up to HRc55 and machine parts.
- ▶ Available in several effective lengths of cut and also overall lengths than previous standard products.



CARBIDE | 4 | 30° | PLAIN P.178-183

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
★ SEME7305016E	5.0	6	8	16	60	4.85
SEME7305020E	5.0	6	8	20	60	4.85
SEME7305026E	5.0	6	8	26	65	4.85
SEME7305030E	5.0	6	8	30	70	4.85
★ SEME7305035E	5.0	6	8	35	75	4.85
SEME7305040E	5.0	6	8	40	80	4.85
SEME7305050E	5.0	6	8	50	90	4.85
★ SEME7305060E	5.0	6	8	60	100	4.85
★ SEME7306015E	6.0	6	9	15	60	5.85
★ SEME7306020E	6.0	6	9	20	60	5.85
★ SEME7306030E	6.0	6	9	30	70	5.85
★ SEME7306032E	6.0	6	9	32	90	5.85
SEME7308025E	8.0	8	12	25	70	7.70
★ SEME7308030E	8.0	8	12	30	80	7.70
★ SEME7308042E	8.0	8	12	42	100	7.70
SEME7310030E	10.0	10	15	30	75	9.70
★ SEME7310035E	10.0	10	15	35	80	9.70
★ SEME7310045E	10.0	10	15	45	100	9.70
SEME7312035E	12.0	12	20	35	80	11.70
★ SEME7312040E	12.0	12	20	40	90	11.70
SEME7312050E	12.0	12	20	50	110	11.70

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

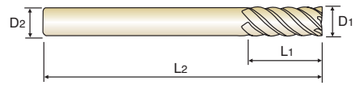
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	○	○	○	○	○	○

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS
6 FLUTE 45° HELIX (Regular, Long Shank)

SEME75 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ From the 45 helix angle, better surface roughness can be achieved at side cutting.
- ▶ Available in several effective lengths of cut and also overall lengths



CARBIDE | 6 | 45° | PLAIN P.184-185

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEME75060E	6.0	6	15	60	Regular
SEME7506020E	6.0	6	20	70	Long
★ SEME7506030E	6.0	6	30	80	Long
SEME7506030110E	6.0	6	30	110	Long
★ SEME75080E	8.0	8	20	70	Regular
★ SEME7508030E	8.0	8	30	80	Long
SEME7508035E	8.0	8	35	90	Long
★ SEME7508040E	8.0	8	40	90	Long
SEME7508040130E	8.0	8	40	130	Long
★ SEME75100E	10.0	10	25	75	Regular
SEME7510030E	10.0	10	30	80	Long
★ SEME7510040E	10.0	10	40	90	Long
SEME7510050E	10.0	10	50	100	Long
SEME7510050150E	10.0	10	50	150	Long
★ SEME75120E	12.0	12	30	80	Regular
★ SEME7512040E	12.0	12	40	90	Long
★ SEME7512050E	12.0	12	50	100	Long
SEME7512060E	12.0	12	60	110	Long
SEME7512060150E	12.0	12	60	150	Long
★ SEME75160E	16.0	16	40	100	Regular
SEME7516050E	16.0	16	50	110	Long
★ SEME7516060E	16.0	16	60	120	Long
SEME7516090E	16.0	16	90	150	Long
SEME75160110E	16.0	16	110	200	Long

★ : Stock Item

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

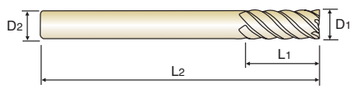
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

Y-COATED SOLID CARBIDE END MILLS

6 FLUTE 45° HELIX (Regular, Long Shank)

SEME75 SERIES

- ▶ New coating and tool geometry applied resulting outstanding cutting abilities and wear resistance.
- ▶ Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- ▶ From the 45 helix angle, better surface roughness can be achieved at side cutting.
- ▶ Available in several effective lengths of cut and also overall lengths



CARBIDE | 6 | 45° | PLAIN P.184-185

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEME75160110250E	**16.0**	16	110	250	Long
★ SEME75200E	**20.0**	20	45	100	Regular
★ SEME7520060E	**20.0**	20	60	120	Long
SEME7520070E	**20.0**	20	70	130	Long
SEME75200110E	**20.0**	20	110	200	Long
SEME75200110250E	**20.0**	20	110	250	Long
SEME75200110300E	**20.0**	20	110	300	Long

★ : Stock Item

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.03	h5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎				○	○	○	○	○	○

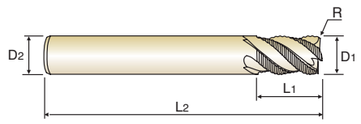
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend																		○		◎	○

X-COATED SOLID CARBIDE END MILLS

4&5 FLUTE MULTIPLE HELIX CORNER RADIUS

PLAIN SHANK	G9D75	G9D76
FLAT SHANK	G9D67	G9D68

- ▶ Unique flute design for excellent chip evacuation and vibration reduction.
- ▶ Optimal roughing tooth profile to reduce cutting forces.
- ▶ Special tool geometry for high feed rate and heavy cutting.
- ▶ Strong end tooth design for plunge and pocket milling.
- ▶ Custom engineered coating to allow long tool life and excellent chip evacuation.



CARBIDE | 4&5 | 44°~45° | PLAIN | FLAT P.186

SHORT LENGTH

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	No. of Flute
G9D75060	G9D67060	R0.5	**6.0**	6	9	57	4
G9D75080	G9D67080	R0.5	**8.0**	8	12	63	4
G9D75100	G9D67100	R0.5	**10.0**	10	15	72	4
G9D75120	G9D67120	R0.5	**12.0**	12	18	83	4
G9D75160	G9D67160	R1.0	**16.0**	16	24	92	5
G9D75200	G9D67200	R1.0	**20.0**	20	30	104	5

LONG LENGTH

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	No. of Flute
G9D76060	G9D68060	R0.5	**6.0**	6	12	57	4
G9D76080	G9D68080	R0.5	**8.0**	8	16	63	4
G9D76100	G9D68100	R0.5	**10.0**	10	20	72	4
G9D76120	G9D68120	R0.5	**12.0**	12	24	83	4
G9D76160	G9D68160	R1.0	**16.0**	16	32	92	5
G9D76200	G9D68200	R1.0	**20.0**	20	40	104	5

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.05	h5

◎ : Excellent ○ : Good

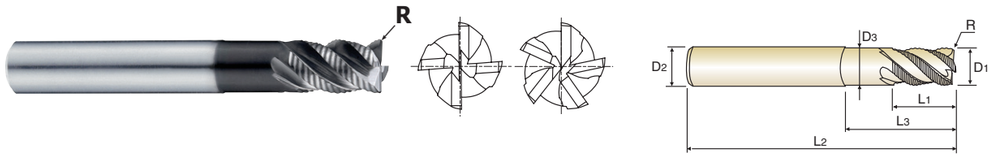
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	◎	◎	◎	◎	◎	◎

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend						○	○	○													

X-COATED SOLID CARBIDE END MILLS
4&5 FLUTE MULTIPLE HELIX LONG REACH CORNER RADIUS

PLAIN SHANK **G9D77** SERIES
FLAT SHANK **G9D69** SERIES

- ▶ Unique flute design for excellent chip evacuation and vibration reduction.
- ▶ Optimal roughing tooth profile to reduce cutting forces.
- ▶ Special tool geometry for high feed rate and heavy cutting.
- ▶ Strong end tooth design for plunge and pocket milling.
- ▶ Custom engineered coating to allow long tool life and excellent chip evacuation.



CARBIDE 4&5 44°~45° PLAIN FLAT P.186

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3	No. of Flute
G9D77060	G9D69060	R0.5	**6.0**	6	9	18	57	5.50	4
G9D77080	G9D69080	R0.5	**8.0**	8	12	24	63	7.50	4
G9D77100	G9D69100	R0.5	**10.0**	10	15	30	72	9.50	4
G9D77120	G9D69120	R0.5	**12.0**	12	18	36	83	11.50	4
G9D77160	G9D69160	R1.0	**16.0**	16	24	48	100	15.50	5
G9D77200	G9D69200	R1.0	**20.0**	20	30	60	110	19.20	5

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.05	h5

◎ : Excellent ○ : Good

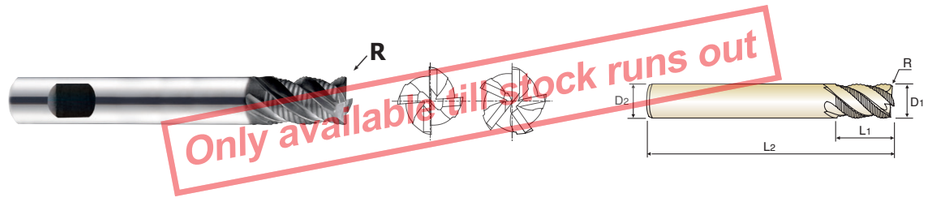
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	◎	○	◎	◎	◎	○	◎	○	○	○	◎	◎	◎	◎	◎	◎

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend						○	○	○													

X-COATED HSS-PM END MILLS
4&5 FLUTE MULTIPLE HELIX SHORT LENGTH CORNER RADIUS

FLAT SHANK **GAE53** SERIES

- ▶ Unique flute design for excellent chip evacuation and vibration reduction.
- ▶ Optimal roughing tooth profile to reduce cutting forces.
- ▶ Special tool geometry for high feed rate and heavy cutting.
- ▶ Strong end tooth design for plunge and pocket milling.
- ▶ Custom engineered coating to allow long tool life and excellent chip evacuation.



HSS PM 4&5 44°~45° FLAT P.187

Unit : mm

	EDP No. FLAT	Corner Radius R	Mill Diameter D1(js12)	Shank Diameter D2(h6)	Length of Cut L1	Overall Length L2	No. of Flute
▲	GAE53060	R0.5	**6.0**	6	13	57	4
▲	GAE53070	R0.5	**7.0**	10	16	66	4
▲	GAE53080	R0.5	**8.0**	10	19	69	4
▲	GAE53090	R0.5	**9.0**	10	19	69	4
▲	GAE53100	R0.5	**10.0**	10	22	72	4
▲	GAE53120	R0.5	**12.0**	12	26	83	4
▲	GAE53140	R1.0	**14.0**	16	26	83	5
▲	GAE53160	R1.0	**16.0**	16	32	92	5
▲	GAE53180	R1.0	**18.0**	20	32	92	5
▲	GAE53200	R1.0	**20.0**	20	38	104	5

▲ : Only available till stock runs out

Tolerances according to DIN 7160 & 7161

Tolerance range in ㎛						
Nominal-Diameter in ㎜						
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13	0 - 16

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommend	○	○	◎	◎	○	○	◎	○	○	○	○			◎	◎	◎	◎	◎	◎	◎

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend						○	○	○													

SEMD98 SERIES 2 FLUTE BALL NOSE

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.2	1.5	2.0	2.5
P	1-5	Non-alloy steel	0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	113	141	187	187
					fz	0.007	0.012	0.015	0.019	0.024	0.029	0.034	0.039	0.044	0.048	0.051	0.054	0.057	0.074
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	29974	29921	29762	23810
					FEED	579	726	891	1149	1436	1754	2041	2328	2646	2872	3057	3231	3393	3524
	6-8	Low alloy steel	0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	113	141	187	187
					fz	0.007	0.012	0.015	0.019	0.024	0.029	0.034	0.039	0.044	0.048	0.051	0.054	0.057	0.074
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	29974	29921	29762	23810
					FEED	579	726	891	1149	1436	1754	2041	2328	2646	2872	3057	3231	3393	3524
	9		0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	109	136	180	180
					fz	0.006	0.011	0.014	0.017	0.021	0.025	0.029	0.033	0.038	0.042	0.045	0.047	0.05	0.066
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	28913	28860	28648	22918
					FEED	497	665	832	1028	1257	1512	1741	1970	2285	2513	2602	2713	2865	3025
	10-11.1	High alloyed steel, and tool steel	0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	113	141	187	187
					fz	0.007	0.012	0.015	0.019	0.024	0.029	0.034	0.039	0.044	0.048	0.051	0.054	0.057	0.074
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	29974	29921	29762	23810
					FEED	579	726	891	1149	1436	1754	2041	2328	2646	2872	3057	3231	3393	3524
	11.2		0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	109	136	180	180
					fz	0.006	0.011	0.014	0.017	0.021	0.025	0.029	0.033	0.038	0.042	0.045	0.047	0.05	0.066
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	28913	28860	28648	22918
					FEED	497	665	832	1028	1257	1512	1741	1970	2285	2513	2602	2713	2865	3025
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	113	141	187	187
					fz	0.007	0.012	0.015	0.019	0.024	0.029	0.034	0.039	0.044	0.048	0.051	0.054	0.057	0.074
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	29974	29921	29762	23810
					FEED	579	726	891	1149	1436	1754	2041	2328	2646	2872	3057	3231	3393	3524
H	38.1 - 38.2	Hardened steel	0.08D	0.05D	Vc	10	17	25	34	42	51	59	68	76	85	97	122	151	151
					fz	0.006	0.011	0.013	0.017	0.021	0.024	0.029	0.033	0.038	0.042	0.045	0.047	0.05	0.063
					RPM	31831	27056	26526	27056	26738	27056	26829	27056	26880	27056	25730	25889	24032	19226
					FEED	382	595	690	920	1123	1299	1556	1786	2043	2273	2316	2434	2403	2422
	40	Chilled Cast Iron	0.08D	0.05D	Vc	13	19	28	38	47	57	66	75	85	94	109	136	180	180
					fz	0.006	0.011	0.014	0.017	0.021	0.025	0.029	0.033	0.038	0.042	0.045	0.047	0.05	0.066
					RPM	41380	30239	29709	30239	29921	30239	30012	29842	30063	29921	28913	28860	28648	22918
					FEED	497	665	832	1028	1257	1512	1741	1970	2285	2513	2602	2713	2865	3025
	41	Hardened Cast Iron	0.08D	0.05D	Vc	10	17	25	34	42	51	59	68	76	85	97	122	151	151
					fz	0.006	0.011	0.013	0.017	0.021	0.024	0.029	0.033	0.038	0.042	0.045	0.047	0.05	0.063
					RPM	31831	27056	26526	27056	26738	27056	26829	27056	26880	27056	25730	25889	24032	19226
					FEED	382	595	690	920	1123	1299	1556	1786	2043	2273	2316	2434	2403	2422

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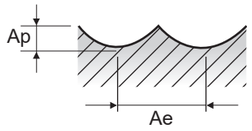
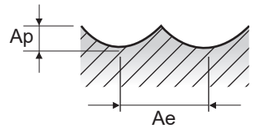


SEMD98 SERIES 2 FLUTE BALL NOSE

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø)																					
		3.0	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	8.0	8.5	9.0	10.0	11.0	12.0	13.0	14.0	15.0	16.0	18.0	20.0	25.0
1-5	Vc	187	187	187	184	175	168	157	159	159	167	168	168	175	168	157	162	165	167	168	170	168	167
	fz	0.091	0.106	0.121	0.136	0.156	0.164	0.174	0.179	0.184	0.189	0.192	0.195	0.199	0.205	0.212	0.218	0.224	0.23	0.238	0.25	0.264	0.27
	RPM	19841	17007	14881	13015	11141	9723	8329	7786	7230	6645	6291	5942	5570	4861	4165	3967	3752	3544	3342	3006	2674	2126
	FEED	3611	3605	3601	3540	3476	3189	2899	2788	2661	2512	2416	2317	2217	1993	1766	1729	1681	1630	1591	1503	1412	1148
6-8	Vc	187	187	187	184	175	168	157	159	159	167	168	168	175	168	157	162	165	167	168	170	168	167
	fz	0.091	0.106	0.121	0.136	0.156	0.164	0.174	0.179	0.184	0.189	0.192	0.195	0.199	0.205	0.212	0.218	0.224	0.23	0.238	0.25	0.264	0.27
	RPM	19841	17007	14881	13015	11141	9723	8329	7786	7230	6645	6291	5942	5570	4861	4165	3967	3752	3544	3342	3006	2674	2126
	FEED	3611	3605	3601	3540	3476	3189	2899	2788	2661	2512	2416	2317	2217	1993	1766	1729	1681	1630	1591	1503	1412	1148
9	Vc	180	180	180	177	168	162	152	153	153	161	162	161	168	161	151	155	158	160	161	164	162	162
	fz	0.083	0.097	0.111	0.122	0.138	0.144	0.153	0.156	0.159	0.164	0.167	0.17	0.174	0.18	0.188	0.197	0.208	0.221	0.206	0.215	0.227	0.231
	RPM	19099	16370	14324	12520	10695	9376	8064	7493	6957	6406	6067	5694	5348	4659	4005	3795	3592	3395	3203	2900	2578	2063
	FEED	3170	3176	3180	3055	2952	2700	2468	2338	2212	2101	2026	1936	1861	1677	1506	1495	1494	1501	1320	1247	1171	953
10-11.1	Vc	187	187	187	184	175	168	157	159	159	167	168	168	175	168	157	162	165	167	168	170	168	167
	fz	0.091	0.106	0.121	0.136	0.156	0.164	0.174	0.179	0.184	0.189	0.192	0.195	0.199	0.205	0.212	0.218	0.224	0.23	0.238	0.25	0.264	0.27
	RPM	19841	17007	14881	13015	11141	9723	8329	7786	7230	6645	6291	5942	5570	4861	4165	3967	3752	3544	3342	3006	2674	2126
	FEED	3611	3605	3601	3540	3476	3189	2899	2788	2661	2512	2416	2317	2217	1993	1766	1729	1681	1630	1591	1503	1412	1148
11.2	Vc	180	180	180	177	168	162	152	153	153	161	162	161	168	161	151	155	158	160	161	164	162	162
	fz	0.083	0.097	0.111	0.122	0.138	0.144	0.153	0.156	0.159	0.164	0.167	0.17	0.174	0.18	0.188	0.197	0.208	0.221	0.206	0.215	0.227	0.231
	RPM	19099	16370	14324	12520	10695	9376	8064	7493	6957	6406	6067	5694	5348	4659	4005	3795	3592	3395	3203	2900	2578	2063
	FEED	3170	3176	3180	3055	2952	2700	2468	2338	2212	2101	2026	1936	1861	1677	1506	1495	1494	1501	1320	1247	1171	953
15-20	Vc	187	187	187	184	175	168	157	159	159	167	168	168	175	168	157	162	165	167	168	170	168	167
	fz	0.091	0.106	0.121	0.136	0.156	0.164	0.174	0.179	0.184	0.189	0.192	0.195	0.199	0.205	0.212	0.218	0.224	0.23	0.238	0.25	0.264	0.27
	RPM	19841	17007	14881	13015	11141	9723	8329	7786	7230	6645	6291	5942	5570	4861	4165	3967	3752	3544	3342	3006	2674	2126
	FEED	3611	3605	3601	3540	3476	3189	2899	2788	2661	2512	2416	2317	2217	1993	1766	1729	1681	1630	1591	1503	1412	1148
38.1 - 38.2	Vc	151	151	151	148	141	135	124	127	128	136	136	136	141	136	127	131	133	135	136	137	136	136
	fz	0.075	0.088	0.1	0.111	0.125	0.132	0.141	0.144	0.147	0.15	0.153	0.156	0.16	0.164	0.17	0.173	0.178	0.183	0.189	0.198	0.208	0.211
	RPM	16022	13733	12016	10469	8976	7813	6578	6219	5821	5411	5093	4810	4488	3935	3369	3208	3024	2865	2706	2423	2165	1732
	FEED	2403	2417	2403	2324	2244	2063	1855	1791	1711	1623	1558	1501	1436	1291	1145	1110	1077	1049	1023	959	900	731
40	Vc	180	180	180	177	168	162	152	153	153	161	162	161	168	161	151	155	158	160	161	164	162	162
	fz	0.083	0.097	0.111	0.122	0.138	0.144	0.153	0.156	0.159	0.164	0.167	0.17	0.174	0.18	0.188	0.197	0.208	0.221	0.206	0.215	0.227	0.231
	RPM	19099	16370	14324	12520	10695	9376	8064	7493	6957	6406	6067	5694	5348	4659	4005	3795	3592	3395	3203	2900	2578	2063
	FEED	3170	3176	3180	3055	2952	2700	2468	2338	2212	2101	2026	1936	1861	1677	1506	1495	1494	1501	1320	1247	1171	953
41	Vc	151	151	151	148	141	135	124	127	128	136	136	136	141	136	127	131	133	135	136	137	136	136
	fz	0.075	0.088	0.1	0.111	0.125	0.132	0.141	0.144	0.147	0.15	0.153	0.156	0.16	0.164	0.17	0.173	0.178	0.183	0.189	0.198	0.208	0.211
	RPM	16022	13733	12016	10469	8976	7813	6578	6219	5821	5411	5093	4810	4488	3935	3369	3208	3024	2865	2706	2423	2165	1732
	FEED	2403	2417	2403	2324	2244	2063	1855	1791	1711	1623	1558	1501	1436	1291	1145	1110	1077	1049	1023	959	900	731



SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				0.1	0.1	0.1	0.1	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3
			LBS	0.2	0.3	0.5	1	0.5	1	1.5	2	3	1	1.5	2	2.5	3	4	5
P	1-5	Non-alloy steel	Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.004	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	499	499	357	357	357	323	178
			Ap	0.009	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.003	0.019	0.019	0.011	0.007	0.007	0.004	0.003
	6-8	Low alloy steel	Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.004	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	499	499	357	357	357	323	178
			Ap	0.009	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.003	0.019	0.019	0.011	0.007	0.007	0.004	0.003
	9		Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	399	399	357	357	357	242	178
			Ap	0.007	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.003	0.015	0.015	0.008	0.005	0.005	0.003	0.002
	10-11.1	High alloyed steel, and tool steel	Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.004	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	499	499	357	357	357	323	178
			Ap	0.009	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.003	0.019	0.019	0.011	0.007	0.007	0.004	0.003
	11.2		Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	399	399	357	357	357	242	178
			Ap	0.007	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.003	0.015	0.015	0.008	0.005	0.005	0.003	0.002
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.004	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	499	499	357	357	357	323	178
			Ap	0.009	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.003	0.019	0.019	0.011	0.007	0.007	0.004	0.003
H	38.1 - 38.2	Hardened steel	Vc	16	16	16	14	27	27	24	24	24	40	40	36	36	36	32	24
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003
			RPM	50930	50930	50930	44563	42972	42972	38197	38197	38197	42441	42441	38197	38197	38197	33953	25465
			FEED	204	204	204	178	258	258	229	229	229	340	340	306	306	306	204	153
			Ap	0.005	0.005	0.004	0.001	0.01	0.007	0.004	0.003	0.002	0.011	0.011	0.006	0.004	0.004	0.002	0.002
	40	Chilled Cast Iron	Vc	16	16	16	14	31	31	28	28	28	47	47	42	42	42	38	28
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003
			RPM	50930	50930	50930	44563	49338	49338	44563	44563	44563	49869	49869	44563	44563	44563	40319	29709
			FEED	204	204	204	178	296	296	267	267	267	399	399	357	357	357	242	178
			Ap	0.007	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.003	0.015	0.015	0.008	0.005	0.005	0.003	0.002
	41	Hardened Cast Iron	Vc	16	16	16	14	27	27	24	24	24	40	40	36	36	36	32	24
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003
			RPM	50930	50930	50930	44563	42972	42972	38197	38197	38197	42441	42441	38197	38197	38197	33953	25465
			FEED	204	204	204	178	258	258	229	229	229	340	340	306	306	306	204	153
			Ap	0.005	0.005	0.004	0.001	0.01	0.007	0.004	0.003	0.002	0.011	0.011	0.006	0.004	0.004	0.002	0.002

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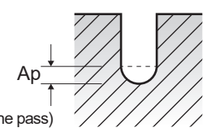

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																	
		0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
	LBS	1	1.5	2	2.5	3	4	5	6	8	10	1	1.5	2	2.5	3	4	5	6	8
1-5	Vc	52	52	52	46	46	46	41	41	31	15	54	54	54	54	48	48	48	43	32
	fz	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007
	RPM	41380	41380	41380	36606	36606	36606	32627	32627	24669	11937	34377	34377	34377	34377	30558	30558	30558	27375	20372
	FEED	497	497	497	366	366	366	326	326	197	95	688	688	688	688	550	550	550	438	285
	Ap	0.036	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007
6-8	Vc	52	52	52	46	46	46	41	41	31	15	54	54	54	54	48	48	48	43	32
	fz	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007
	RPM	41380	41380	41380	36606	36606	36606	32627	32627	24669	11937	34377	34377	34377	34377	30558	30558	30558	27375	20372
	FEED	497	497	497	366	366	366	326	326	197	95	688	688	688	688	550	550	550	438	285
	Ap	0.036	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007
9	Vc	49	49	49	44	44	44	39	39	29	15	51	51	51	51	46	46	46	41	30
	fz	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.003	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.006
	RPM	38993	38993	38993	35014	35014	35014	31035	31035	23077	11937	32468	32468	32468	32468	29285	29285	29285	26101	19099
	FEED	390	390	390	350	350	350	248	248	185	72	584	584	584	584	469	469	469	365	229
	Ap	0.028	0.02	0.02	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005
10-11.1	Vc	52	52	52	46	46	46	41	41	31	15	54	54	54	54	48	48	48	43	32
	fz	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007
	RPM	41380	41380	41380	36606	36606	36606	32627	32627	24669	11937	34377	34377	34377	34377	30558	30558	30558	27375	20372
	FEED	497	497	497	366	366	366	326	326	197	95	688	688	688	688	550	550	550	438	285
	Ap	0.036	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007
11.2	Vc	49	49	49	44	44	44	39	39	29	15	51	51	51	51	46	46	46	41	30
	fz	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.003	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.006
	RPM	38993	38993	38993	35014	35014	35014	31035	31035	23077	11937	32468	32468	32468	32468	29285	29285	29285	26101	19099
	FEED	390	390	390	350	350	350	248	248	185	72	584	584	584	584	469	469	469	365	229
	Ap	0.028	0.02	0.02	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005
15-20	Vc	52	52	52	46	46	46	41	41	31	15	54	54	54	54	48	48	48	43	32
	fz	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007
	RPM	41380	41380	41380	36606	36606	36606	32627	32627	24669	11937	34377	34377	34377	34377	30558	30558	30558	27375	20372
	FEED	497	497	497	366	366	366	326	326	197	95	688	688	688	688	550	550	550	438	285
	Ap	0.036	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007
38.1 - 38.2	Vc	43	43	43	39	39	39	34	34	26	13	45	45	45	45	40	40	40	36	27
	fz	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.006
	RPM	34218	34218	34218	31035	31035	31035	27056	27056	20690	10345	28648	28648	28648	28648	25465	25465	25465	22918	17189
	FEED	342	342	342	248	248	248	216	216	166	62	516	516	516	516	407	407	407	321	206
	Ap	0.02	0.014	0.014	0.008	0.008	0.005	0.005	0.003	0.002	0.002	0.025	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.004
40	Vc	49	49	49	44	44	44	39	39	29	15	51	51	51	51	46	46	46	41	30
	fz	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.003	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.006
	RPM	38993	38993	38993	35014	35014	35014	31035	31035	23077	11937	32468	32468	32468	32468	29285	29285	29285	26101	19099
	FEED	390	390	390	350	350	350	248	248	185	72	584	584	584	584	469	469	469	365	229
	Ap	0.028	0.02	0.02	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005
41	Vc	43	43	43	39	39	39	34	34	26	13	45	45	45	45	40	40	40	36	27
	fz	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.006
	RPM	34218	34218	34218	31035	31035	31035	27056	27056	20690	10345	28648	28648	28648	28648	25465	25465	25465	22918	17189
	FEED	342	342	342	248	248	248	216	216	166	62	516	516	516	516	407	407	407	321	206
	Ap	0.02	0.014	0.014	0.008	0.008	0.005	0.005	0.003	0.002	0.002	0.025	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.004

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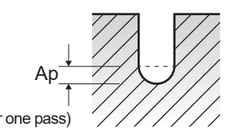

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																	
			0.5	0.5	0.5	0.5	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.7	0.7	0.7
		LBS	10	12	14	16	1	2	3	4	5	6	8	10	12	14	16	2	4	6
P	1-5	Vc	32	16	16	5	64	64	64	58	58	58	52	39	39	19	19	75	68	68
		fz	0.007	0.006	0.006	0.005	0.015	0.015	0.015	0.013	0.013	0.013	0.012	0.01	0.01	0.009	0.009	0.017	0.015	0.015
		RPM	20372	10186	10186	3183	33953	33953	33953	30770	30770	30770	27587	20690	20690	10080	10080	34105	30922	30922
		FEED	285	122	122	32	1019	1019	1019	800	800	800	662	414	414	181	181	1160	928	928
		Ap	0.005	0.005	0.005	0.005	0.038	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016
	6-8	Vc	32	16	16	5	64	64	64	58	58	58	52	39	39	19	19	75	68	68
		fz	0.007	0.006	0.006	0.005	0.015	0.015	0.015	0.013	0.013	0.013	0.012	0.01	0.01	0.009	0.009	0.017	0.015	0.015
		RPM	20372	10186	10186	3183	33953	33953	33953	30770	30770	30770	27587	20690	20690	10080	10080	34105	30922	30922
		FEED	285	122	122	32	1019	1019	1019	800	800	800	662	414	414	181	181	1160	928	928
		Ap	0.005	0.005	0.005	0.005	0.038	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016
	9	Vc	30	15	15	5	61	61	61	55	55	55	49	37	37	18	18	71	64	64
		fz	0.006	0.005	0.005	0.005	0.013	0.013	0.013	0.012	0.012	0.012	0.01	0.009	0.009	0.008	0.008	0.014	0.013	0.013
		RPM	19099	9549	9549	3183	32362	32362	32362	29178	29178	29178	25995	19629	19629	9549	9549	32286	29103	29103
		FEED	229	95	95	32	841	841	841	700	700	700	520	353	353	153	153	904	757	757
		Ap	0.004	0.004	0.004	0.004	0.029	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012
	10-11.1	Vc	32	16	16	5	64	64	64	58	58	58	52	39	39	19	19	75	68	68
		fz	0.007	0.006	0.006	0.005	0.015	0.015	0.015	0.013	0.013	0.013	0.012	0.01	0.01	0.009	0.009	0.017	0.015	0.015
		RPM	20372	10186	10186	3183	33953	33953	33953	30770	30770	30770	27587	20690	20690	10080	10080	34105	30922	30922
		FEED	285	122	122	32	1019	1019	1019	800	800	800	662	414	414	181	181	1160	928	928
		Ap	0.005	0.005	0.005	0.005	0.038	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016
	11.2	Vc	30	15	15	5	61	61	61	55	55	55	49	37	37	18	18	71	64	64
		fz	0.006	0.005	0.005	0.005	0.013	0.013	0.013	0.012	0.012	0.012	0.01	0.009	0.009	0.008	0.008	0.014	0.013	0.013
		RPM	19099	9549	9549	3183	32362	32362	32362	29178	29178	29178	25995	19629	19629	9549	9549	32286	29103	29103
		FEED	229	95	95	32	841	841	841	700	700	700	520	353	353	153	153	904	757	757
		Ap	0.004	0.004	0.004	0.004	0.029	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012
K	15-20	Vc	32	16	16	5	64	64	64	58	58	58	52	39	39	19	19	75	68	68
		fz	0.007	0.006	0.006	0.005	0.015	0.015	0.015	0.013	0.013	0.013	0.012	0.01	0.01	0.009	0.009	0.017	0.015	0.015
		RPM	20372	10186	10186	3183	33953	33953	33953	30770	30770	30770	27587	20690	20690	10080	10080	34105	30922	30922
		FEED	285	122	122	32	1019	1019	1019	800	800	800	662	414	414	181	181	1160	928	928
		Ap	0.005	0.005	0.005	0.005	0.038	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016
H	38.1 - 38.2	Vc	27	13	13	4	54	54	54	48	48	48	43	32	32	16	16	63	56	56
		fz	0.006	0.006	0.006	0.004	0.012	0.012	0.012	0.011	0.011	0.011	0.01	0.008	0.008	0.007	0.007	0.013	0.012	0.012
		RPM	17189	8276	8276	2546	28648	28648	28648	25465	25465	25465	22812	16977	16977	8488	8488	28648	25465	25465
		FEED	206	99	99	20	688	688	688	560	560	560	456	272	272	119	119	745	611	611
		Ap	0.003	0.003	0.003	0.003	0.021	0.021	0.021	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009
	40	Vc	30	15	15	5	61	61	61	55	55	55	49	37	37	18	18	71	64	64
		fz	0.006	0.005	0.005	0.005	0.013	0.013	0.013	0.012	0.012	0.012	0.01	0.009	0.009	0.008	0.008	0.014	0.013	0.013
		RPM	19099	9549	9549	3183	32362	32362	32362	29178	29178	29178	25995	19629	19629	9549	9549	32286	29103	29103
		FEED	229	95	95	32	841	841	841	700	700	700	520	353	353	153	153	904	757	757
		Ap	0.004	0.004	0.004	0.004	0.029	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012
	41	Vc	27	13	13	4	54	54	54	48	48	48	43	32	32	16	16	63	56	56
		fz	0.006	0.006	0.006	0.004	0.012	0.012	0.012	0.011	0.011	0.011	0.01	0.008	0.008	0.007	0.007	0.013	0.012	0.012
		RPM	17189	8276	8276	2546	28648	28648	28648	25465	25465	25465	22812	16977	16977	8488	8488	28648	25465	25465
		FEED	206	99	99	20	688	688	688	560	560	560	456	272	272	119	119	745	611	611
		Ap	0.003	0.003	0.003	0.003	0.021	0.021	0.021	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009

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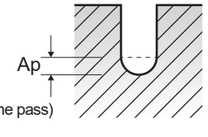

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																		
		0.7	0.7	0.7	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.9	0.9	0.9	0.9	1.0
	LBS	8	10	12	2	3	4	5	6	8	10	12	14	16	20	4	6	8	10	2
1-5	Vc	60	60	45	86	86	86	77	77	77	69	69	52	52	26	83	83	83	74	97
	fz	0.013	0.013	0.012	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.013	0.013	0.011	0.019	0.019	0.019	0.017	0.025
	RPM	27284	27284	20463	34218	34218	34218	30637	30637	30637	27454	27454	20690	20690	10345	29355	29355	29355	26172	30876
	FEED	709	709	491	1232	1232	1232	980	980	980	769	769	538	538	228	1115	1115	1115	890	1544
	Ap	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.032	0.02	0.02	0.09
6-8	Vc	60	60	45	86	86	86	77	77	77	69	69	52	52	26	83	83	83	74	97
	fz	0.013	0.013	0.012	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.013	0.013	0.011	0.019	0.019	0.019	0.017	0.025
	RPM	27284	27284	20463	34218	34218	34218	30637	30637	30637	27454	27454	20690	20690	10345	29355	29355	29355	26172	30876
	FEED	709	709	491	1232	1232	1232	980	980	980	769	769	538	538	228	1115	1115	1115	890	1544
	Ap	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.032	0.02	0.02	0.09
9	Vc	57	57	43	81	81	81	73	73	73	65	65	49	49	24	78	78	78	69	91
	fz	0.012	0.012	0.01	0.016	0.016	0.016	0.014	0.014	0.014	0.013	0.013	0.011	0.011	0.01	0.017	0.017	0.017	0.015	0.023
	RPM	25920	25920	19553	32229	32229	32229	29046	29046	29046	25863	25863	19496	19496	9549	27587	27587	27587	24404	28966
	FEED	622	622	391	1031	1031	1031	813	813	813	672	672	429	429	191	938	938	938	732	1332
	Ap	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.025	0.016	0.016	0.07
10-11.1	Vc	60	60	45	86	86	86	77	77	77	69	69	52	52	26	83	83	83	74	97
	fz	0.013	0.013	0.012	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.013	0.013	0.011	0.019	0.019	0.019	0.017	0.025
	RPM	27284	27284	20463	34218	34218	34218	30637	30637	30637	27454	27454	20690	20690	10345	29355	29355	29355	26172	30876
	FEED	709	709	491	1232	1232	1232	980	980	980	769	769	538	538	228	1115	1115	1115	890	1544
	Ap	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.032	0.02	0.02	0.09
11.2	Vc	57	57	43	81	81	81	73	73	73	65	65	49	49	24	78	78	78	69	91
	fz	0.012	0.012	0.01	0.016	0.016	0.016	0.014	0.014	0.014	0.013	0.013	0.011	0.011	0.01	0.017	0.017	0.017	0.015	0.023
	RPM	25920	25920	19553	32229	32229	32229	29046	29046	29046	25863	25863	19496	19496	9549	27587	27587	27587	24404	28966
	FEED	622	622	391	1031	1031	1031	813	813	813	672	672	429	429	191	938	938	938	732	1332
	Ap	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.025	0.016	0.016	0.07
15-20	Vc	60	60	45	86	86	86	77	77	77	69	69	52	52	26	83	83	83	74	97
	fz	0.013	0.013	0.012	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.013	0.013	0.011	0.019	0.019	0.019	0.017	0.025
	RPM	27284	27284	20463	34218	34218	34218	30637	30637	30637	27454	27454	20690	20690	10345	29355	29355	29355	26172	30876
	FEED	709	709	491	1232	1232	1232	980	980	980	769	769	538	538	228	1115	1115	1115	890	1544
	Ap	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.032	0.02	0.02	0.09
38.1 - 38.2	Vc	50	50	38	72	72	72	64	64	64	57	57	43	43	21	69	69	69	61	81
	fz	0.011	0.011	0.009	0.015	0.015	0.015	0.014	0.014	0.014	0.012	0.012	0.011	0.011	0.009	0.016	0.016	0.016	0.014	0.021
	RPM	22736	22736	17280	28648	28648	28648	25465	25465	25465	22680	22680	17109	17109	8356	24404	24404	24404	21574	25783
	FEED	500	500	311	859	859	859	713	713	713	544	544	376	376	150	781	781	781	604	1083
	Ap	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.01	0.01	0.006	0.004	0.004	0.004	0.018	0.018	0.011	0.011	0.05
40	Vc	57	57	43	81	81	81	73	73	73	65	65	49	49	24	78	78	78	69	91
	fz	0.012	0.012	0.01	0.016	0.016	0.016	0.014	0.014	0.014	0.013	0.013	0.011	0.011	0.01	0.017	0.017	0.017	0.015	0.023
	RPM	25920	25920	19553	32229	32229	32229	29046	29046	29046	25863	25863	19496	19496	9549	27587	27587	27587	24404	28966
	FEED	622	622	391	1031	1031	1031	813	813	813	672	672	429	429	191	938	938	938	732	1332
	Ap	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.025	0.016	0.016	0.07
41	Vc	50	50	38	72	72	72	64	64	64	57	57	43	43	21	69	69	69	61	81
	fz	0.011	0.011	0.009	0.015	0.015	0.015	0.014	0.014	0.014	0.012	0.012	0.011	0.011	0.009	0.016	0.016	0.016	0.014	0.021
	RPM	22736	22736	17280	28648	28648	28648	25465	25465	25465	22680	22680	17109	17109	8356	24404	24404	24404	21574	25783
	FEED	500	500	311	859	859	859	713	713	713	544	544	376	376	150	781	781	781	604	1083
	Ap	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.01	0.01	0.006	0.004	0.004	0.004	0.018	0.018	0.011	0.011	0.05

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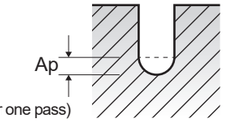

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																	
			1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.2
		LBS	3	4	5	6	7	8	10	12	14	16	18	20	22	26	30	40	50	4
P	1-5	Vc	97	97	97	87	87	87	87	77	77	58	58	58	29	29	29	10	10	99
		fz	0.025	0.025	0.025	0.022	0.022	0.022	0.022	0.02	0.02	0.017	0.017	0.017	0.015	0.015	0.015	0.012	0.012	0.026
		RPM	30876	30876	30876	27693	27693	27693	27693	24510	24510	18462	18462	18462	9231	9231	9231	3183	3183	26261
		FEED	1544	1544	1544	1218	1218	1218	1218	980	980	628	628	628	277	277	277	76	76	1366
		Ap	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076
	6-8	Vc	97	97	97	87	87	87	87	77	77	58	58	58	29	29	29	10	10	99
		fz	0.025	0.025	0.025	0.022	0.022	0.022	0.022	0.02	0.02	0.017	0.017	0.017	0.015	0.015	0.015	0.012	0.012	0.026
		RPM	30876	30876	30876	27693	27693	27693	27693	24510	24510	18462	18462	18462	9231	9231	9231	3183	3183	26261
		FEED	1544	1544	1544	1218	1218	1218	1218	980	980	628	628	628	277	277	277	76	76	1366
		Ap	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076
	9	Vc	91	91	91	82	82	82	82	73	73	55	55	55	27	27	27	9	9	93
		fz	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.018	0.018	0.016	0.016	0.016	0.013	0.013	0.013	0.011	0.011	0.023
		RPM	28966	28966	28966	26101	26101	26101	26101	23237	23237	17507	17507	17507	8594	8594	8594	2865	2865	24669
		FEED	1332	1332	1332	1044	1044	1044	1044	837	837	560	560	560	223	223	223	63	63	1135
		Ap	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059
	10-11.1	Vc	97	97	97	87	87	87	87	77	77	58	58	58	29	29	29	10	10	99
		fz	0.025	0.025	0.025	0.022	0.022	0.022	0.022	0.02	0.02	0.017	0.017	0.017	0.015	0.015	0.015	0.012	0.012	0.026
		RPM	30876	30876	30876	27693	27693	27693	27693	24510	24510	18462	18462	18462	9231	9231	9231	3183	3183	26261
		FEED	1544	1544	1544	1218	1218	1218	1218	980	980	628	628	628	277	277	277	76	76	1366
		Ap	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076
	11.2	Vc	91	91	91	82	82	82	82	73	73	55	55	55	27	27	27	9	9	93
		fz	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.018	0.018	0.016	0.016	0.016	0.013	0.013	0.013	0.011	0.011	0.023
		RPM	28966	28966	28966	26101	26101	26101	26101	23237	23237	17507	17507	17507	8594	8594	8594	2865	2865	24669
		FEED	1332	1332	1332	1044	1044	1044	1044	837	837	560	560	560	223	223	223	63	63	1135
		Ap	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059
K	15-20	Vc	97	97	97	87	87	87	87	77	77	58	58	58	29	29	29	10	10	99
		fz	0.025	0.025	0.025	0.022	0.022	0.022	0.022	0.02	0.02	0.017	0.017	0.017	0.015	0.015	0.015	0.012	0.012	0.026
		RPM	30876	30876	30876	27693	27693	27693	27693	24510	24510	18462	18462	18462	9231	9231	9231	3183	3183	26261
		FEED	1544	1544	1544	1218	1218	1218	1218	980	980	628	628	628	277	277	277	76	76	1366
		Ap	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076
H	38.1 - 38.2	Vc	81	81	81	73	73	73	73	65	65	48	48	48	24	24	24	8	8	83
		fz	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013	0.013	0.013	0.011	0.011	0.022
		RPM	25783	25783	25783	23237	23237	23237	23237	20690	20690	15279	15279	15279	7639	7639	7639	2546	2546	22016
		FEED	1083	1083	1083	883	883	883	883	703	703	458	458	458	199	199	199	56	56	969
		Ap	0.05	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005	0.005	0.005	0.005	0.003	0.042
	40	Vc	91	91	91	82	82	82	82	73	73	55	55	55	27	27	27	9	9	93
		fz	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.018	0.018	0.016	0.016	0.016	0.013	0.013	0.013	0.011	0.011	0.023
		RPM	28966	28966	28966	26101	26101	26101	26101	23237	23237	17507	17507	17507	8594	8594	8594	2865	2865	24669
		FEED	1332	1332	1332	1044	1044	1044	1044	837	837	560	560	560	223	223	223	63	63	1135
		Ap	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059
	41	Vc	81	81	81	73	73	73	73	65	65	48	48	48	24	24	24	8	8	83
		fz	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013	0.013	0.013	0.011	0.011	0.022
		RPM	25783	25783	25783	23237	23237	23237	23237	20690	20690	15279	15279	15279	7639	7639	7639	2546	2546	22016
		FEED	1083	1083	1083	883	883	883	883	703	703	458	458	458	199	199	199	56	56	969
		Ap	0.05	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005	0.005	0.005	0.005	0.003	0.042

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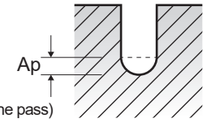

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																		
		1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.4	1.4	1.4	1.4	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
	LBS	6	8	10	12	16	20	26	6	8	10	16	4	5	6	7	8	10	12	14
1-5	Vc	99	89	89	89	79	59	30	95	85	85	76	113	113	113	113	101	101	101	101
	fz	0.026	0.024	0.024	0.024	0.021	0.018	0.016	0.03	0.027	0.027	0.024	0.033	0.033	0.033	0.033	0.03	0.03	0.03	0.03
	RPM	26261	23608	23608	23608	20955	15650	7958	21600	19326	19326	17280	23979	23979	23979	23979	21433	21433	21433	21433
	FEED	1366	1133	1133	1133	880	563	255	1296	1044	1044	829	1583	1583	1583	1583	1286	1286	1286	1286
	Ap	0.076	0.043	0.027	0.027	0.016	0.011	0.011	0.088	0.05	0.05	0.032	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034
6-8	Vc	99	89	89	89	79	59	30	95	85	85	76	113	113	113	113	101	101	101	101
	fz	0.026	0.024	0.024	0.024	0.021	0.018	0.016	0.03	0.027	0.027	0.024	0.033	0.033	0.033	0.033	0.03	0.03	0.03	0.03
	RPM	26261	23608	23608	23608	20955	15650	7958	21600	19326	19326	17280	23979	23979	23979	23979	21433	21433	21433	21433
	FEED	1366	1133	1133	1133	880	563	255	1296	1044	1044	829	1583	1583	1583	1583	1286	1286	1286	1286
	Ap	0.076	0.043	0.027	0.027	0.016	0.011	0.011	0.088	0.05	0.05	0.032	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034
9	Vc	93	84	84	84	75	56	28	89	80	80	71	106	106	106	106	96	96	96	96
	fz	0.023	0.021	0.021	0.021	0.019	0.016	0.014	0.027	0.024	0.024	0.022	0.03	0.03	0.03	0.03	0.027	0.027	0.027	0.027
	RPM	24669	22282	22282	22282	19894	14854	7427	20235	18189	18189	16143	22494	22494	22494	22494	20372	20372	20372	20372
	FEED	1135	936	936	936	756	475	208	1093	873	873	710	1350	1350	1350	1350	1100	1100	1100	1100
	Ap	0.059	0.034	0.021	0.021	0.013	0.008	0.008	0.069	0.039	0.039	0.025	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026
10-11.1	Vc	99	89	89	89	79	59	30	95	85	85	76	113	113	113	113	101	101	101	101
	fz	0.026	0.024	0.024	0.024	0.021	0.018	0.016	0.03	0.027	0.027	0.024	0.033	0.033	0.033	0.033	0.03	0.03	0.03	0.03
	RPM	26261	23608	23608	23608	20955	15650	7958	21600	19326	19326	17280	23979	23979	23979	23979	21433	21433	21433	21433
	FEED	1366	1133	1133	1133	880	563	255	1296	1044	1044	829	1583	1583	1583	1583	1286	1286	1286	1286
	Ap	0.076	0.043	0.027	0.027	0.016	0.011	0.011	0.088	0.05	0.05	0.032	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034
11.2	Vc	93	84	84	84	75	56	28	89	80	80	71	106	106	106	106	96	96	96	96
	fz	0.023	0.021	0.021	0.021	0.019	0.016	0.014	0.027	0.024	0.024	0.022	0.03	0.03	0.03	0.03	0.027	0.027	0.027	0.027
	RPM	24669	22282	22282	22282	19894	14854	7427	20235	18189	18189	16143	22494	22494	22494	22494	20372	20372	20372	20372
	FEED	1135	936	936	936	756	475	208	1093	873	873	710	1350	1350	1350	1350	1100	1100	1100	1100
	Ap	0.059	0.034	0.021	0.021	0.013	0.008	0.008	0.069	0.039	0.039	0.025	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026
15-20	Vc	99	89	89	89	79	59	30	95	85	85	76	113	113	113	113	101	101	101	101
	fz	0.026	0.024	0.024	0.024	0.021	0.018	0.016	0.03	0.027	0.027	0.024	0.033	0.033	0.033	0.033	0.03	0.03	0.03	0.03
	RPM	26261	23608	23608	23608	20955	15650	7958	21600	19326	19326	17280	23979	23979	23979	23979	21433	21433	21433	21433
	FEED	1366	1133	1133	1133	880	563	255	1296	1044	1044	829	1583	1583	1583	1583	1286	1286	1286	1286
	Ap	0.076	0.043	0.027	0.027	0.016	0.011	0.011	0.088	0.05	0.05	0.032	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034
38.1 - 38.2	Vc	83	74	74	74	66	50	25	79	71	71	63	94	94	94	94	85	85	85	85
	fz	0.022	0.02	0.02	0.02	0.017	0.015	0.013	0.026	0.023	0.023	0.021	0.027	0.027	0.027	0.027	0.024	0.024	0.024	0.024
	RPM	22016	19629	19629	19629	17507	13263	6631	17962	16143	16143	14324	19947	19947	19947	19947	18038	18038	18038	18038
	FEED	969	785	785	785	595	398	172	934	743	743	602	1077	1077	1077	1077	866	866	866	866
	Ap	0.042	0.024	0.015	0.015	0.009	0.006	0.006	0.049	0.028	0.028	0.018	0.075	0.053	0.053	0.053	0.03	0.03	0.03	0.019
40	Vc	93	84	84	84	75	56	28	89	80	80	71	106	106	106	106	96	96	96	96
	fz	0.023	0.021	0.021	0.021	0.019	0.016	0.014	0.027	0.024	0.024	0.022	0.03	0.03	0.03	0.03	0.027	0.027	0.027	0.027
	RPM	24669	22282	22282	22282	19894	14854	7427	20235	18189	18189	16143	22494	22494	22494	22494	20372	20372	20372	20372
	FEED	1135	936	936	936	756	475	208	1093	873	873	710	1350	1350	1350	1350	1100	1100	1100	1100
	Ap	0.059	0.034	0.021	0.021	0.013	0.008	0.008	0.069	0.039	0.039	0.025	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026
41	Vc	83	74	74	74	66	50	25	79	71	71	63	94	94	94	94	85	85	85	85
	fz	0.022	0.02	0.02	0.02	0.017	0.015	0.013	0.026	0.023	0.023	0.021	0.027	0.027	0.027	0.027	0.024	0.024	0.024	0.024
	RPM	22016	19629	19629	19629	17507	13263	6631	17962	16143	16143	14324	19947	19947	19947	19947	18038	18038	18038	18038
	FEED	969	785	785	785	595	398	172	934	743	743	602	1077	1077	1077	1077	866	866	866	866
	Ap	0.042	0.024	0.015	0.015	0.009	0.006	0.006	0.049	0.028	0.028	0.018	0.075	0.053	0.053	0.053	0.03	0.03	0.03	0.019

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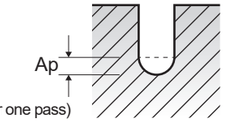

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																	
			1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.8	1.8	1.8
		LBS	16	18	20	22	26	30	35	40	4	6	8	10	12	16	20	4	6	8
P	1-5	Vc	90	90	90	90	68	68	34	34	112	112	112	100	100	100	89	126	126	126
		fz	0.026	0.026	0.026	0.026	0.023	0.023	0.02	0.02	0.035	0.035	0.035	0.032	0.032	0.032	0.028	0.04	0.04	0.04
		RPM	19099	19099	19099	19099	14430	14430	7215	7215	22282	22282	22282	19894	19894	19894	17706	22282	22282	22282
		FEED	993	993	993	993	664	664	289	289	1560	1560	1560	1273	1273	1273	992	1783	1783	1783
		Ap	0.034	0.034	0.02	0.02	0.014	0.014	0.01	0.01	0.101	0.101	0.101	0.058	0.058	0.036	0.036	0.113	0.113	0.113
	6-8	Vc	90	90	90	90	68	68	34	34	112	112	112	100	100	100	89	126	126	126
		fz	0.026	0.026	0.026	0.026	0.023	0.023	0.02	0.02	0.035	0.035	0.035	0.032	0.032	0.032	0.028	0.04	0.04	0.04
		RPM	19099	19099	19099	19099	14430	14430	7215	7215	22282	22282	22282	19894	19894	19894	17706	22282	22282	22282
		FEED	993	993	993	993	664	664	289	289	1560	1560	1560	1273	1273	1273	992	1783	1783	1783
		Ap	0.034	0.034	0.02	0.02	0.014	0.014	0.01	0.01	0.101	0.101	0.101	0.058	0.058	0.036	0.036	0.113	0.113	0.113
	9	Vc	85	85	85	85	64	64	32	32	106	106	106	95	95	95	84	119	119	119
		fz	0.024	0.024	0.024	0.024	0.021	0.021	0.018	0.018	0.031	0.031	0.031	0.028	0.028	0.028	0.025	0.035	0.035	0.035
		RPM	18038	18038	18038	18038	13581	13581	6791	6791	21088	21088	21088	18900	18900	18900	16711	21044	21044	21044
		FEED	866	866	866	866	570	570	244	244	1307	1307	1307	1058	1058	1058	836	1473	1473	1473
		Ap	0.026	0.026	0.016	0.016	0.011	0.011	0.008	0.008	0.078	0.078	0.078	0.045	0.045	0.028	0.028	0.088	0.088	0.088
	10-11.1	Vc	90	90	90	90	68	68	34	34	112	112	112	100	100	100	89	126	126	126
		fz	0.026	0.026	0.026	0.026	0.023	0.023	0.02	0.02	0.035	0.035	0.035	0.032	0.032	0.032	0.028	0.04	0.04	0.04
		RPM	19099	19099	19099	19099	14430	14430	7215	7215	22282	22282	22282	19894	19894	19894	17706	22282	22282	22282
		FEED	993	993	993	993	664	664	289	289	1560	1560	1560	1273	1273	1273	992	1783	1783	1783
		Ap	0.034	0.034	0.02	0.02	0.014	0.014	0.01	0.01	0.101	0.101	0.101	0.058	0.058	0.036	0.036	0.113	0.113	0.113
	11.2	Vc	85	85	85	85	64	64	32	32	106	106	106	95	95	95	84	119	119	119
		fz	0.024	0.024	0.024	0.024	0.021	0.021	0.018	0.018	0.031	0.031	0.031	0.028	0.028	0.028	0.025	0.035	0.035	0.035
		RPM	18038	18038	18038	18038	13581	13581	6791	6791	21088	21088	21088	18900	18900	18900	16711	21044	21044	21044
		FEED	866	866	866	866	570	570	244	244	1307	1307	1307	1058	1058	1058	836	1473	1473	1473
		Ap	0.026	0.026	0.016	0.016	0.011	0.011	0.008	0.008	0.078	0.078	0.078	0.045	0.045	0.028	0.028	0.088	0.088	0.088
K	15-20	Vc	90	90	90	90	68	68	34	34	112	112	112	100	100	100	89	126	126	126
		fz	0.026	0.026	0.026	0.026	0.023	0.023	0.02	0.02	0.035	0.035	0.035	0.032	0.032	0.032	0.028	0.04	0.04	0.04
		RPM	19099	19099	19099	19099	14430	14430	7215	7215	22282	22282	22282	19894	19894	19894	17706	22282	22282	22282
		FEED	993	993	993	993	664	664	289	289	1560	1560	1560	1273	1273	1273	992	1783	1783	1783
		Ap	0.034	0.034	0.02	0.02	0.014	0.014	0.01	0.01	0.101	0.101	0.101	0.058	0.058	0.036	0.036	0.113	0.113	0.113
H	38.1 - 38.2	Vc	75	75	75	75	57	57	28	28	93	93	93	84	84	84	74	105	105	105
		fz	0.022	0.022	0.022	0.022	0.019	0.019	0.016	0.016	0.03	0.03	0.03	0.027	0.027	0.027	0.024	0.033	0.033	0.033
		RPM	15915	15915	15915	15915	12096	12096	5942	5942	18502	18502	18502	16711	16711	16711	14722	18568	18568	18568
		FEED	700	700	700	700	460	460	190	190	1110	1110	1110	902	902	902	707	1225	1225	1225
		Ap	0.019	0.019	0.011	0.011	0.008	0.008	0.005	0.005	0.056	0.056	0.056	0.032	0.032	0.02	0.02	0.063	0.063	0.063
	40	Vc	85	85	85	85	64	64	32	32	106	106	106	95	95	95	84	119	119	119
		fz	0.024	0.024	0.024	0.024	0.021	0.021	0.018	0.018	0.031	0.031	0.031	0.028	0.028	0.028	0.025	0.035	0.035	0.035
		RPM	18038	18038	18038	18038	13581	13581	6791	6791	21088	21088	21088	18900	18900	18900	16711	21044	21044	21044
		FEED	866	866	866	866	570	570	244	244	1307	1307	1307	1058	1058	1058	836	1473	1473	1473
		Ap	0.026	0.026	0.016	0.016	0.011	0.011	0.008	0.008	0.078	0.078	0.078	0.045	0.045	0.028	0.028	0.088	0.088	0.088
	41	Vc	75	75	75	75	57	57	28	28	93	93	93	84	84	84	74	105	105	105
		fz	0.022	0.022	0.022	0.022	0.019	0.019	0.016	0.016	0.03	0.03	0.03	0.027	0.027	0.027	0.024	0.033	0.033	0.033
		RPM	15915	15915	15915	15915	12096	12096	5942	5942	18502	18502	18502	16711	16711	16711	14722	18568	18568	18568
		FEED	700	700	700	700	460	460	190	190	1110	1110	1110	902	902	902	707	1225	1225	1225
		Ap	0.019	0.019	0.011	0.011	0.008	0.008	0.005	0.005	0.056	0.056	0.056	0.032	0.032	0.02	0.02	0.063	0.063	0.063

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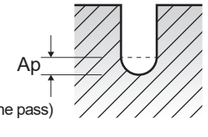

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																		
		1.8	1.8	1.8	1.8	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	LBS	10	12	16	20	6	8	10	12	14	16	18	20	22	26	30	35	40	45	50
1-5	Vc	113	113	113	100	113	113	113	102	102	102	102	102	90	90	90	68	68	34	34
	fz	0.036	0.036	0.036	0.032	0.05	0.05	0.05	0.045	0.045	0.045	0.045	0.045	0.04	0.04	0.04	0.035	0.035	0.03	0.03
	RPM	19983	19983	19983	17684	17985	17985	17985	16234	16234	16234	16234	16234	14324	14324	14324	10823	10823	5411	5411
	FEED	1439	1439	1439	1132	1798	1798	1798	1461	1461	1461	1461	1461	1146	1146	1146	758	758	325	325
	Ap	0.065	0.065	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018
6-8	Vc	113	113	113	100	113	113	113	102	102	102	102	102	90	90	90	68	68	34	34
	fz	0.036	0.036	0.036	0.032	0.05	0.05	0.05	0.045	0.045	0.045	0.045	0.045	0.04	0.04	0.04	0.035	0.035	0.03	0.03
	RPM	19983	19983	19983	17684	17985	17985	17985	16234	16234	16234	16234	16234	14324	14324	14324	10823	10823	5411	5411
	FEED	1439	1439	1439	1132	1798	1798	1798	1461	1461	1461	1461	1461	1146	1146	1146	758	758	325	325
	Ap	0.065	0.065	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018
9	Vc	107	107	107	95	107	107	107	96	96	96	96	96	85	85	85	64	64	32	32
	fz	0.031	0.031	0.031	0.028	0.045	0.045	0.045	0.04	0.04	0.04	0.04	0.04	0.036	0.036	0.036	0.031	0.031	0.027	0.027
	RPM	18922	18922	18922	16800	17030	17030	17030	15279	15279	15279	15279	15279	13528	13528	13528	10186	10186	5093	5093
	FEED	1173	1173	1173	941	1533	1533	1533	1222	1222	1222	1222	1222	974	974	974	632	632	275	275
	Ap	0.05	0.05	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014
10-11.1	Vc	113	113	113	100	113	113	113	102	102	102	102	102	90	90	90	68	68	34	34
	fz	0.036	0.036	0.036	0.032	0.05	0.05	0.05	0.045	0.045	0.045	0.045	0.045	0.04	0.04	0.04	0.035	0.035	0.03	0.03
	RPM	19983	19983	19983	17684	17985	17985	17985	16234	16234	16234	16234	16234	14324	14324	14324	10823	10823	5411	5411
	FEED	1439	1439	1439	1132	1798	1798	1798	1461	1461	1461	1461	1461	1146	1146	1146	758	758	325	325
	Ap	0.065	0.065	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018
11.2	Vc	107	107	107	95	107	107	107	96	96	96	96	96	85	85	85	64	64	32	32
	fz	0.031	0.031	0.031	0.028	0.045	0.045	0.045	0.04	0.04	0.04	0.04	0.04	0.036	0.036	0.036	0.031	0.031	0.027	0.027
	RPM	18922	18922	18922	16800	17030	17030	17030	15279	15279	15279	15279	15279	13528	13528	13528	10186	10186	5093	5093
	FEED	1173	1173	1173	941	1533	1533	1533	1222	1222	1222	1222	1222	974	974	974	632	632	275	275
	Ap	0.05	0.05	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014
15-20	Vc	113	113	113	100	113	113	113	102	102	102	102	102	90	90	90	68	68	34	34
	fz	0.036	0.036	0.036	0.032	0.05	0.05	0.05	0.045	0.045	0.045	0.045	0.045	0.04	0.04	0.04	0.035	0.035	0.03	0.03
	RPM	19983	19983	19983	17684	17985	17985	17985	16234	16234	16234	16234	16234	14324	14324	14324	10823	10823	5411	5411
	FEED	1439	1439	1439	1132	1798	1798	1798	1461	1461	1461	1461	1461	1146	1146	1146	758	758	325	325
	Ap	0.065	0.065	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018
38.1 - 38.2	Vc	94	94	94	84	94	94	94	85	85	85	85	85	75	75	75	57	57	28	28
	fz	0.03	0.03	0.03	0.027	0.043	0.043	0.043	0.039	0.039	0.039	0.039	0.039	0.034	0.034	0.034	0.03	0.03	0.026	0.026
	RPM	16623	16623	16623	14854	14961	14961	14961	13528	13528	13528	13528	13528	11937	11937	11937	9072	9072	4456	4456
	FEED	997	997	997	802	1287	1287	1287	1055	1055	1055	1055	1055	812	812	812	544	544	232	232
	Ap	0.036	0.036	0.023	0.023	0.1	0.07	0.07	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01
40	Vc	107	107	107	95	107	107	107	96	96	96	96	96	85	85	85	64	64	32	32
	fz	0.031	0.031	0.031	0.028	0.045	0.045	0.045	0.04	0.04	0.04	0.04	0.04	0.036	0.036	0.036	0.031	0.031	0.027	0.027
	RPM	18922	18922	18922	16800	17030	17030	17030	15279	15279	15279	15279	15279	13528	13528	13528	10186	10186	5093	5093
	FEED	1173	1173	1173	941	1533	1533	1533	1222	1222	1222	1222	1222	974	974	974	632	632	275	275
	Ap	0.05	0.05	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014
41	Vc	94	94	94	84	94	94	94	85	85	85	85	85	75	75	75	57	57	28	28
	fz	0.03	0.03	0.03	0.027	0.043	0.043	0.043	0.039	0.039	0.039	0.039	0.039	0.034	0.034	0.034	0.03	0.03	0.026	0.026
	RPM	16623	16623	16623	14854	14961	14961	14961	13528	13528	13528	13528	13528	11937	11937	11937	9072	9072	4456	4456
	FEED	997	997	997	802	1287	1287	1287	1055	1055	1055	1055	1055	812	812	812	544	544	232	232
	Ap	0.036	0.036	0.023	0.023	0.1	0.07	0.07	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01

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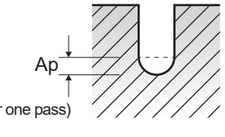

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																	
			2.0	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0	3.0	3.0
		LBS	60	8	10	12	16	20	22	26	30	35	40	45	50	6	8	10	12	14
P	1-5	Vc	34	124	124	124	112	112	112	99	99	99	74	74	74	129	129	129	129	129
		fz	0.03	0.061	0.061	0.061	0.055	0.055	0.055	0.049	0.049	0.049	0.043	0.043	0.043	0.075	0.075	0.075	0.075	0.075
		RPM	5411	15788	15788	15788	14260	14260	14260	12605	12605	12605	9422	9422	9422	13687	13687	13687	13687	13687
		FEED	325	1926	1926	1926	1569	1569	1569	1235	1235	1235	810	810	810	2053	2053	2053	2053	2053
		Ap	0.018	0.158	0.158	0.158	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189
	6-8	Vc	34	124	124	124	112	112	112	99	99	99	74	74	74	129	129	129	129	129
		fz	0.03	0.061	0.061	0.061	0.055	0.055	0.055	0.049	0.049	0.049	0.043	0.043	0.043	0.075	0.075	0.075	0.075	0.075
		RPM	5411	15788	15788	15788	14260	14260	14260	12605	12605	12605	9422	9422	9422	13687	13687	13687	13687	13687
		FEED	325	1926	1926	1926	1569	1569	1569	1235	1235	1235	810	810	810	2053	2053	2053	2053	2053
		Ap	0.018	0.158	0.158	0.158	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189
	9	Vc	32	117	117	117	105	105	105	94	94	94	70	70	70	122	122	122	122	122
		fz	0.027	0.054	0.054	0.054	0.048	0.048	0.048	0.043	0.043	0.043	0.038	0.038	0.038	0.067	0.067	0.067	0.067	0.067
		RPM	5093	14897	14897	14897	13369	13369	13369	11968	11968	11968	8913	8913	8913	12945	12945	12945	12945	12945
		FEED	275	1609	1609	1609	1283	1283	1283	1029	1029	1029	677	677	677	1735	1735	1735	1735	1735
		Ap	0.014	0.123	0.123	0.123	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147
	10-11.1	Vc	34	124	124	124	112	112	112	99	99	99	74	74	74	129	129	129	129	129
		fz	0.03	0.061	0.061	0.061	0.055	0.055	0.055	0.049	0.049	0.049	0.043	0.043	0.043	0.075	0.075	0.075	0.075	0.075
		RPM	5411	15788	15788	15788	14260	14260	14260	12605	12605	12605	9422	9422	9422	13687	13687	13687	13687	13687
		FEED	325	1926	1926	1926	1569	1569	1569	1235	1235	1235	810	810	810	2053	2053	2053	2053	2053
		Ap	0.018	0.158	0.158	0.158	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189
	11.2	Vc	32	117	117	117	105	105	105	94	94	94	70	70	70	122	122	122	122	122
		fz	0.027	0.054	0.054	0.054	0.048	0.048	0.048	0.043	0.043	0.043	0.038	0.038	0.038	0.067	0.067	0.067	0.067	0.067
		RPM	5093	14897	14897	14897	13369	13369	13369	11968	11968	11968	8913	8913	8913	12945	12945	12945	12945	12945
		FEED	275	1609	1609	1609	1283	1283	1283	1029	1029	1029	677	677	677	1735	1735	1735	1735	1735
		Ap	0.014	0.123	0.123	0.123	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147
K	15-20	Vc	34	124	124	124	112	112	112	99	99	99	74	74	74	129	129	129	129	129
		fz	0.03	0.061	0.061	0.061	0.055	0.055	0.055	0.049	0.049	0.049	0.043	0.043	0.043	0.075	0.075	0.075	0.075	0.075
		RPM	5411	15788	15788	15788	14260	14260	14260	12605	12605	12605	9422	9422	9422	13687	13687	13687	13687	13687
		FEED	325	1926	1926	1926	1569	1569	1569	1235	1235	1235	810	810	810	2053	2053	2053	2053	2053
		Ap	0.018	0.158	0.158	0.158	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189
H	38.1 - 38.2	Vc	28	104	104	104	93	93	93	83	83	83	62	62	62	107	107	107	107	107
		fz	0.026	0.049	0.049	0.049	0.044	0.044	0.044	0.04	0.04	0.04	0.035	0.035	0.035	0.063	0.063	0.063	0.063	0.063
		RPM	4456	13242	13242	13242	11841	11841	11841	10568	10568	10568	7894	7894	7894	11353	11353	11353	11353	11353
		FEED	232	1298	1298	1298	1042	1042	1042	845	845	845	553	553	553	1430	1430	1430	1430	1430
		Ap	0.01	0.088	0.088	0.088	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105
	40	Vc	32	117	117	117	105	105	105	94	94	94	70	70	70	122	122	122	122	122
		fz	0.027	0.054	0.054	0.054	0.048	0.048	0.048	0.043	0.043	0.043	0.038	0.038	0.038	0.067	0.067	0.067	0.067	0.067
		RPM	5093	14897	14897	14897	13369	13369	13369	11968	11968	11968	8913	8913	8913	12945	12945	12945	12945	12945
		FEED	275	1609	1609	1609	1283	1283	1283	1029	1029	1029	677	677	677	1735	1735	1735	1735	1735
		Ap	0.014	0.123	0.123	0.123	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147
	41	Vc	28	104	104	104	93	93	93	83	83	83	62	62	62	107	107	107	107	107
		fz	0.026	0.049	0.049	0.049	0.044	0.044	0.044	0.04	0.04	0.04	0.035	0.035	0.035	0.063	0.063	0.063	0.063	0.063
		RPM	4456	13242	13242	13242	11841	11841	11841	10568	10568	10568	7894	7894	7894	11353	11353	11353	11353	11353
		FEED	232	1298	1298	1298	1042	1042	1042	845	845	845	553	553	553	1430	1430	1430	1430	1430
		Ap	0.01	0.088	0.088	0.088	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105

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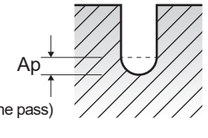

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																		
		3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
	LBS	16	18	20	22	26	30	35	40	45	50	60	8	10	12	14	16	18	20	22
1-5	Vc	116	116	116	116	116	116	103	103	103	77	77	123	123	123	123	123	123	123	111
	fz	0.067	0.067	0.067	0.067	0.067	0.067	0.06	0.06	0.06	0.052	0.052	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.09
	RPM	12308	12308	12308	12308	12308	12308	10929	10929	10929	8170	8170	9788	9788	9788	9788	9788	9788	9788	8833
	FEED	1649	1649	1649	1649	1649	1649	1311	1311	1311	850	850	1958	1958	1958	1958	1958	1958	1958	1590
	Ap	0.108	0.108	0.108	0.108	0.068	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144
6-8	Vc	116	116	116	116	116	116	103	103	103	77	77	123	123	123	123	123	123	123	111
	fz	0.067	0.067	0.067	0.067	0.067	0.067	0.06	0.06	0.06	0.052	0.052	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.09
	RPM	12308	12308	12308	12308	12308	12308	10929	10929	10929	8170	8170	9788	9788	9788	9788	9788	9788	9788	8833
	FEED	1649	1649	1649	1649	1649	1649	1311	1311	1311	850	850	1958	1958	1958	1958	1958	1958	1958	1590
	Ap	0.108	0.108	0.108	0.108	0.068	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144
9	Vc	109	109	109	109	109	109	97	97	97	73	73	117	117	117	117	117	117	117	105
	fz	0.06	0.06	0.06	0.06	0.06	0.06	0.054	0.054	0.054	0.047	0.047	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.081
	RPM	11565	11565	11565	11565	11565	11565	10292	10292	10292	7746	7746	9311	9311	9311	9311	9311	9311	9311	8356
	FEED	1388	1388	1388	1388	1388	1388	1112	1112	1112	728	728	1676	1676	1676	1676	1676	1676	1676	1354
	Ap	0.084	0.084	0.084	0.084	0.053	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112
10-11.1	Vc	116	116	116	116	116	116	103	103	103	77	77	123	123	123	123	123	123	123	111
	fz	0.067	0.067	0.067	0.067	0.067	0.067	0.06	0.06	0.06	0.052	0.052	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.09
	RPM	12308	12308	12308	12308	12308	12308	10929	10929	10929	8170	8170	9788	9788	9788	9788	9788	9788	9788	8833
	FEED	1649	1649	1649	1649	1649	1649	1311	1311	1311	850	850	1958	1958	1958	1958	1958	1958	1958	1590
	Ap	0.108	0.108	0.108	0.108	0.068	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144
11.2	Vc	109	109	109	109	109	109	97	97	97	73	73	117	117	117	117	117	117	117	105
	fz	0.06	0.06	0.06	0.06	0.06	0.06	0.054	0.054	0.054	0.047	0.047	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.081
	RPM	11565	11565	11565	11565	11565	11565	10292	10292	10292	7746	7746	9311	9311	9311	9311	9311	9311	9311	8356
	FEED	1388	1388	1388	1388	1388	1388	1112	1112	1112	728	728	1676	1676	1676	1676	1676	1676	1676	1354
	Ap	0.084	0.084	0.084	0.084	0.053	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112
15-20	Vc	116	116	116	116	116	116	103	103	103	77	77	123	123	123	123	123	123	123	111
	fz	0.067	0.067	0.067	0.067	0.067	0.067	0.06	0.06	0.06	0.052	0.052	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.09
	RPM	12308	12308	12308	12308	12308	12308	10929	10929	10929	8170	8170	9788	9788	9788	9788	9788	9788	9788	8833
	FEED	1649	1649	1649	1649	1649	1649	1311	1311	1311	850	850	1958	1958	1958	1958	1958	1958	1958	1590
	Ap	0.108	0.108	0.108	0.108	0.068	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144
38.1 - 38.2	Vc	97	97	97	97	97	97	86	86	86	64	64	103	103	103	103	103	103	103	93
	fz	0.057	0.057	0.057	0.057	0.057	0.057	0.05	0.05	0.05	0.044	0.044	0.085	0.085	0.085	0.085	0.085	0.085	0.085	0.077
	RPM	10292	10292	10292	10292	10292	10292	9125	9125	9125	6791	6791	8196	8196	8196	8196	8196	8196	8196	7401
	FEED	1173	1173	1173	1173	1173	1173	912	912	912	598	598	1393	1393	1393	1393	1393	1393	1393	1140
	Ap	0.06	0.06	0.06	0.06	0.038	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08
40	Vc	109	109	109	109	109	109	97	97	97	73	73	117	117	117	117	117	117	117	105
	fz	0.06	0.06	0.06	0.06	0.06	0.06	0.054	0.054	0.054	0.047	0.047	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.081
	RPM	11565	11565	11565	11565	11565	11565	10292	10292	10292	7746	7746	9311	9311	9311	9311	9311	9311	9311	8356
	FEED	1388	1388	1388	1388	1388	1388	1112	1112	1112	728	728	1676	1676	1676	1676	1676	1676	1676	1354
	Ap	0.084	0.084	0.084	0.084	0.053	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112
41	Vc	97	97	97	97	97	97	86	86	86	64	64	103	103	103	103	103	103	103	93
	fz	0.057	0.057	0.057	0.057	0.057	0.057	0.05	0.05	0.05	0.044	0.044	0.085	0.085	0.085	0.085	0.085	0.085	0.085	0.077
	RPM	10292	10292	10292	10292	10292	10292	9125	9125	9125	6791	6791	8196	8196	8196	8196	8196	8196	8196	7401
	FEED	1173	1173	1173	1173	1173	1173	912	912	912	598	598	1393	1393	1393	1393	1393	1393	1393	1140
	Ap	0.06	0.06	0.06	0.06	0.038	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08

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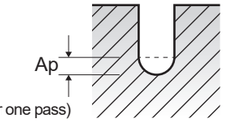

(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)											
			4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.0	5.0	5.0	5.0	5.0
		LBS	26	30	35	40	45	50	60	15	20	26	30	35
P	1-5	Vc	111	111	111	111	99	99	99	121	121	109	109	109
		fz	0.09	0.09	0.09	0.09	0.08	0.08	0.08	0.12	0.12	0.108	0.108	0.108
		RPM	8833	8833	8833	8833	7878	7878	7878	7703	7703	6939	6939	6939
		FEED	1590	1590	1590	1590	1261	1261	1261	1849	1849	1499	1499	1499
		Ap	0.144	0.144	0.09	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18
	6-8	Vc	111	111	111	111	99	99	99	121	121	109	109	109
		fz	0.09	0.09	0.09	0.09	0.08	0.08	0.08	0.12	0.12	0.108	0.108	0.108
		RPM	8833	8833	8833	8833	7878	7878	7878	7703	7703	6939	6939	6939
		FEED	1590	1590	1590	1590	1261	1261	1261	1849	1849	1499	1499	1499
		Ap	0.144	0.144	0.09	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18
	9	Vc	105	105	105	105	93	93	93	115	115	103	103	103
		fz	0.081	0.081	0.081	0.081	0.072	0.072	0.072	0.1	0.1	0.09	0.09	0.09
		RPM	8356	8356	8356	8356	7401	7401	7401	7321	7321	6557	6557	6557
		FEED	1354	1354	1354	1354	1066	1066	1066	1464	1464	1180	1180	1180
		Ap	0.112	0.112	0.07	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14
	10-11.1	Vc	111	111	111	111	99	99	99	121	121	109	109	109
		fz	0.09	0.09	0.09	0.09	0.08	0.08	0.08	0.12	0.12	0.108	0.108	0.108
		RPM	8833	8833	8833	8833	7878	7878	7878	7703	7703	6939	6939	6939
		FEED	1590	1590	1590	1590	1261	1261	1261	1849	1849	1499	1499	1499
		Ap	0.144	0.144	0.09	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18
	11.2	Vc	105	105	105	105	93	93	93	115	115	103	103	103
		fz	0.081	0.081	0.081	0.081	0.072	0.072	0.072	0.1	0.1	0.09	0.09	0.09
		RPM	8356	8356	8356	8356	7401	7401	7401	7321	7321	6557	6557	6557
		FEED	1354	1354	1354	1354	1066	1066	1066	1464	1464	1180	1180	1180
		Ap	0.112	0.112	0.07	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14
K	15-20	Vc	111	111	111	111	99	99	99	121	121	109	109	109
		fz	0.09	0.09	0.09	0.09	0.08	0.08	0.08	0.12	0.12	0.108	0.108	0.108
		RPM	8833	8833	8833	8833	7878	7878	7878	7703	7703	6939	6939	6939
		FEED	1590	1590	1590	1590	1261	1261	1261	1849	1849	1499	1499	1499
		Ap	0.144	0.144	0.09	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18
H	38.1 - 38.2	Vc	93	93	93	93	82	82	82	101	101	90	90	90
		fz	0.077	0.077	0.077	0.077	0.068	0.068	0.068	0.1	0.1	0.09	0.09	0.09
		RPM	7401	7401	7401	7401	6525	6525	6525	6430	6430	5730	5730	5730
		FEED	1140	1140	1140	1140	887	887	887	1286	1286	1031	1031	1031
		Ap	0.08	0.08	0.05	0.05	0.05	0.05	0.03	0.175	0.175	0.1	0.1	0.1
	40	Vc	105	105	105	105	93	93	93	115	115	103	103	103
		fz	0.081	0.081	0.081	0.081	0.072	0.072	0.072	0.1	0.1	0.09	0.09	0.09
		RPM	8356	8356	8356	8356	7401	7401	7401	7321	7321	6557	6557	6557
		FEED	1354	1354	1354	1354	1066	1066	1066	1464	1464	1180	1180	1180
		Ap	0.112	0.112	0.07	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14
	41	Vc	93	93	93	93	82	82	82	101	101	90	90	90
		fz	0.077	0.077	0.077	0.077	0.068	0.068	0.068	0.1	0.1	0.09	0.09	0.09
		RPM	7401	7401	7401	7401	6525	6525	6525	6430	6430	5730	5730	5730
		FEED	1140	1140	1140	1140	887	887	887	1286	1286	1031	1031	1031
		Ap	0.08	0.08	0.05	0.05	0.05	0.05	0.03	0.175	0.175	0.1	0.1	0.1

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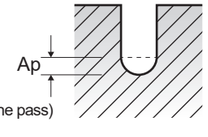
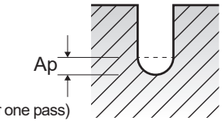


(Depth of cut per one pass)

SEM846 SERIES 2 FLUTE BALL NOSE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)											
		5.0	5.0	5.0	6.0	6.0	8.0	8.0	10.0	10.0	12.0	12.0	12.0
	LBS	40	50	60	20	30	25	30	30	40	32	45	50
1-5	Vc	109	109	97	123	123	122	122	121	121	121	121	100
	fz	0.108	0.108	0.096	0.146	0.146	0.186	0.186	0.214	0.214	0.238	0.238	0.151
	RPM	6939	6939	6175	6525	6525	4854	4854	3852	3852	3210	3210	2653
	FEED	1499	1499	1186	1905	1905	1806	1806	1648	1648	1528	1528	801
	Ap	0.18	0.113	0.113	0.378	0.378	0.504	0.504	0.9	0.63	1.08	0.756	0.756
6-8	Vc	109	109	97	123	123	122	122	121	121	121	121	100
	fz	0.108	0.108	0.096	0.146	0.146	0.186	0.186	0.214	0.214	0.238	0.238	0.151
	RPM	6939	6939	6175	6525	6525	4854	4854	3852	3852	3210	3210	2653
	FEED	1499	1499	1186	1905	1905	1806	1806	1648	1648	1528	1528	801
	Ap	0.18	0.113	0.113	0.378	0.378	0.504	0.504	0.9	0.63	1.08	0.756	0.756
9	Vc	103	103	92	117	117	116	116	116	116	115	115	95
	fz	0.09	0.09	0.08	0.129	0.129	0.163	0.163	0.19	0.19	0.213	0.213	0.119
	RPM	6557	6557	5857	6207	6207	4615	4615	3692	3692	3050	3050	2520
	FEED	1180	1180	937	1601	1601	1505	1505	1403	1403	1300	1300	600
	Ap	0.14	0.088	0.088	0.294	0.294	0.392	0.392	0.7	0.49	0.84	0.588	0.588
10-11.1	Vc	109	109	97	123	123	122	122	121	121	121	121	100
	fz	0.108	0.108	0.096	0.146	0.146	0.186	0.186	0.214	0.214	0.238	0.238	0.151
	RPM	6939	6939	6175	6525	6525	4854	4854	3852	3852	3210	3210	2653
	FEED	1499	1499	1186	1905	1905	1806	1806	1648	1648	1528	1528	801
	Ap	0.18	0.113	0.113	0.378	0.378	0.504	0.504	0.9	0.63	1.08	0.756	0.756
11.2	Vc	103	103	92	117	117	116	116	116	116	115	115	95
	fz	0.09	0.09	0.08	0.129	0.129	0.163	0.163	0.19	0.19	0.213	0.213	0.119
	RPM	6557	6557	5857	6207	6207	4615	4615	3692	3692	3050	3050	2520
	FEED	1180	1180	937	1601	1601	1505	1505	1403	1403	1300	1300	600
	Ap	0.14	0.088	0.088	0.294	0.294	0.392	0.392	0.7	0.49	0.84	0.588	0.588
15-20	Vc	109	109	97	123	123	122	122	121	121	121	121	100
	fz	0.108	0.108	0.096	0.146	0.146	0.186	0.186	0.214	0.214	0.238	0.238	0.151
	RPM	6939	6939	6175	6525	6525	4854	4854	3852	3852	3210	3210	2653
	FEED	1499	1499	1186	1905	1905	1806	1806	1648	1648	1528	1528	801
	Ap	0.18	0.113	0.113	0.378	0.378	0.504	0.504	0.9	0.63	1.08	0.756	0.756
38.1 - 38.2	Vc	90	90	80	104	104	101	101	101	101	100	100	82
	fz	0.09	0.09	0.08	0.121	0.121	0.16	0.16	0.188	0.188	0.208	0.208	0.08
	RPM	5730	5730	5093	5517	5517	4019	4019	3215	3215	2653	2653	2175
	FEED	1031	1031	815	1335	1335	1286	1286	1209	1209	1103	1103	348
	Ap	0.1	0.063	0.063	0.21	0.21	0.28	0.28	0.5	0.35	0.6	0.42	0.42
40	Vc	103	103	92	117	117	116	116	116	116	115	115	95
	fz	0.09	0.09	0.08	0.129	0.129	0.163	0.163	0.19	0.19	0.213	0.213	0.119
	RPM	6557	6557	5857	6207	6207	4615	4615	3692	3692	3050	3050	2520
	FEED	1180	1180	937	1601	1601	1505	1505	1403	1403	1300	1300	600
	Ap	0.14	0.088	0.088	0.294	0.294	0.392	0.392	0.7	0.49	0.84	0.588	0.588
41	Vc	90	90	80	104	104	101	101	101	101	100	100	82
	fz	0.09	0.09	0.08	0.121	0.121	0.16	0.16	0.188	0.188	0.208	0.208	0.08
	RPM	5730	5730	5093	5517	5517	4019	4019	3215	3215	2653	2653	2175
	FEED	1031	1031	815	1335	1335	1286	1286	1209	1209	1103	1103	348
	Ap	0.1	0.063	0.063	0.21	0.21	0.28	0.28	0.5	0.35	0.6	0.42	0.42



(Depth of cut per one pass)

SEMD99 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.2	1.5	2.0
P	1-5	Non-alloy steel	1.0D	0.2D	Vc	28	39	52	57	57	66	75	85	87	93	104	113
					fz	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.006	0.007
					RPM	44563	41380	41380	36287	30239	30012	29842	30063	27693	24669	22069	17985
					FEED	178	166	166	218	242	240	239	241	222	247	265	252
	6-8	Low alloy steel	1.0D	0.2D	Vc	28	39	52	57	57	66	75	85	87	93	104	113
					fz	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.006	0.007
					RPM	44563	41380	41380	36287	30239	30012	29842	30063	27693	24669	22069	17985
					FEED	178	166	166	218	242	240	239	241	222	247	265	252
	9		1.0D	0.2D	Vc	18	25	34	37	37	44	50	53	57	59	64	73
					fz	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.005
					RPM	28648	26526	27056	23555	19629	20008	19894	18745	18144	15650	13581	11618
					FEED	57	53	54	94	79	80	80	75	109	94	109	116
	10-11.1	High alloyed steel, and tool steel	1.0D	0.2D	Vc	28	39	52	57	57	66	75	85	87	93	104	113
					fz	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.006	0.007
					RPM	44563	41380	41380	36287	30239	30012	29842	30063	27693	24669	22069	17985
					FEED	178	166	166	218	242	240	239	241	222	247	265	252
	11.2		1.0D	0.2D	Vc	18	25	34	37	37	44	50	53	57	59	64	73
					fz	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.005
					RPM	28648	26526	27056	23555	19629	20008	19894	18745	18144	15650	13581	11618
					FEED	57	53	54	94	79	80	80	75	109	94	109	116
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.2D	Vc	28	39	52	57	57	66	75	85	87	93	104	113
					fz	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.006	0.007
					RPM	44563	41380	41380	36287	30239	30012	29842	30063	27693	24669	22069	17985
					FEED	178	166	166	218	242	240	239	241	222	247	265	252
H	38.1 - 38.2	Hardened steel	1.0D	0.2D	Vc	11	16	21	22	23	27	30	33	35	37	40	45
					fz	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.005
					RPM	17507	16977	16711	14006	12202	12278	11937	11671	11141	9815	8488	7162
					FEED	35	34	33	56	49	49	48	47	67	59	68	72
	40	Chilled Cast Iron	1.0D	0.2D	Vc	18	25	34	37	37	44	50	53	57	59	64	73
					fz	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.005
					RPM	28648	26526	27056	23555	19629	20008	19894	18745	18144	15650	13581	11618
					FEED	57	53	54	94	79	80	80	75	109	94	109	116
	41	Hardened Cast Iron	1.0D	0.2D	Vc	11	16	21	22	23	27	30	33	35	37	40	45
					fz	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.005
					RPM	17507	16977	16711	14006	12202	12278	11937	11671	11141	9815	8488	7162
					FEED	35	34	33	56	49	49	48	47	67	59	68	72

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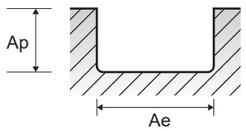
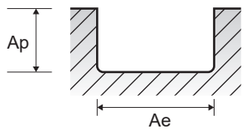


SEMD99 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	7.0	8.0	10.0	11.0	12.0	14.0	16.0	20.0
1-5	Vc	118	125	132	135	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.009	0.011	0.013	0.016	0.019	0.023	0.027	0.032	0.037	0.045	0.054	0.052	0.051	0.054	0.058	0.056
	RPM	15024	13263	12005	10743	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	270	292	312	344	379	422	459	506	515	541	543	475	419	390	360	282
6-8	Vc	118	125	132	135	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.009	0.011	0.013	0.016	0.019	0.023	0.027	0.032	0.037	0.045	0.054	0.052	0.051	0.054	0.058	0.056
	RPM	15024	13263	12005	10743	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	270	292	312	344	379	422	459	506	515	541	543	475	419	390	360	282
9	Vc	75	81	85	86	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.007	0.008	0.01	0.012	0.015	0.017	0.021	0.025	0.028	0.033	0.038	0.04	0.041	0.041	0.04	0.037
	RPM	9549	8594	7730	6844	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	134	138	155	164	189	197	228	252	247	252	249	243	228	199	169	121
10-11.1	Vc	118	125	132	135	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.009	0.011	0.013	0.016	0.019	0.023	0.027	0.032	0.037	0.045	0.054	0.052	0.051	0.054	0.058	0.056
	RPM	15024	13263	12005	10743	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	270	292	312	344	379	422	459	506	515	541	543	475	419	390	360	282
11.2	Vc	75	81	85	86	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.007	0.008	0.01	0.012	0.015	0.017	0.021	0.025	0.028	0.033	0.038	0.04	0.041	0.041	0.04	0.037
	RPM	9549	8594	7730	6844	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	134	138	155	164	189	197	228	252	247	252	249	243	228	199	169	121
15-20	Vc	118	125	132	135	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.009	0.011	0.013	0.016	0.019	0.023	0.027	0.032	0.037	0.045	0.054	0.052	0.051	0.054	0.058	0.056
	RPM	15024	13263	12005	10743	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	270	292	312	344	379	422	459	506	515	541	543	475	419	390	360	282
38.1 - 38.2	Vc	48	50	53	54	61	60	61	62	64	63	63	64	63	65	64	63
	fz	0.006	0.007	0.008	0.009	0.01	0.013	0.016	0.018	0.021	0.024	0.03	0.03	0.03	0.03	0.031	0.03
	RPM	6112	5305	4820	4297	4315	3820	3530	3289	2910	2507	2005	1852	1671	1478	1273	1003
	FEED	73	74	77	77	86	99	113	118	122	120	120	111	100	89	79	60
40	Vc	75	81	85	86	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.007	0.008	0.01	0.012	0.015	0.017	0.021	0.025	0.028	0.033	0.038	0.04	0.041	0.041	0.04	0.037
	RPM	9549	8594	7730	6844	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	134	138	155	164	189	197	228	252	247	252	249	243	228	199	169	121
41	Vc	48	50	53	54	61	60	61	62	64	63	63	64	63	65	64	63
	fz	0.006	0.007	0.008	0.009	0.01	0.013	0.016	0.018	0.021	0.024	0.03	0.03	0.03	0.03	0.031	0.03
	RPM	6112	5305	4820	4297	4315	3820	3530	3289	2910	2507	2005	1852	1671	1478	1273	1003
	FEED	73	74	77	77	86	99	113	118	122	120	120	111	100	89	79	60



SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)												
				0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.4	0.4	0.4	0.4	0.4	0.4
			LBS	0.5	1	1.5	2	1	2	3	1	1.5	2	2.5	3	4
P	1-5	Non-alloy steel	Vc	31	31	28	28	47	42	42	63	63	63	57	57	57
			fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	49338	49338	44563	44563	49869	44563	44563	50134	50134	50134	45359	45359	45359
			FEED	197	197	178	178	199	178	178	201	201	201	181	181	181
			Ap	0.04	0.028	0.016	0.01	0.042	0.024	0.015	0.08	0.056	0.056	0.032	0.032	0.02
	6-8	Low alloy steel	Vc	31	31	28	28	47	42	42	63	63	63	57	57	57
			fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	49338	49338	44563	44563	49869	44563	44563	50134	50134	50134	45359	45359	45359
			FEED	197	197	178	178	199	178	178	201	201	201	181	181	181
			Ap	0.04	0.028	0.016	0.01	0.042	0.024	0.015	0.08	0.056	0.056	0.032	0.032	0.02
	9		Vc	22	22	20	20	30	27	27	40	40	40	36	36	36
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	35014	35014	31831	31831	31831	28648	28648	31831	31831	31831	28648	28648	28648
			FEED	70	70	64	64	64	57	57	64	64	64	57	57	57
			Ap	0.03	0.021	0.012	0.008	0.032	0.018	0.011	0.06	0.042	0.042	0.024	0.024	0.015
	10-11.1	High alloyed steel, and tool steel	Vc	31	31	28	28	47	42	42	63	63	63	57	57	57
			fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	49338	49338	44563	44563	49869	44563	44563	50134	50134	50134	45359	45359	45359
			FEED	197	197	178	178	199	178	178	201	201	201	181	181	181
			Ap	0.04	0.028	0.016	0.01	0.042	0.024	0.015	0.08	0.056	0.056	0.032	0.032	0.02
	11.2		Vc	22	22	20	20	30	27	27	40	40	40	36	36	36
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	35014	35014	31831	31831	31831	28648	28648	31831	31831	31831	28648	28648	28648
			FEED	70	70	64	64	64	57	57	64	64	64	57	57	57
			Ap	0.03	0.021	0.012	0.008	0.032	0.018	0.011	0.06	0.042	0.042	0.024	0.024	0.015
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	31	31	28	28	47	42	42	63	63	63	57	57	57
			fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	49338	49338	44563	44563	49869	44563	44563	50134	50134	50134	45359	45359	45359
			FEED	197	197	178	178	199	178	178	201	201	201	181	181	181
			Ap	0.04	0.028	0.016	0.01	0.042	0.024	0.015	0.08	0.056	0.056	0.032	0.032	0.02
H	38.1 - 38.2	Hardened steel	Vc	13	13	12	12	19	17	17	25	25	25	23	23	23
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	20690	20690	19099	19099	20160	18038	18038	19894	19894	19894	18303	18303	18303
			FEED	41	41	38	38	40	36	36	40	40	40	37	37	37
			Ap	0.024	0.017	0.01	0.006	0.025	0.014	0.009	0.048	0.034	0.034	0.019	0.019	0.012
	40	Chilled Cast Iron	Vc	22	22	20	20	30	27	27	40	40	40	36	36	36
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	35014	35014	31831	31831	31831	28648	28648	31831	31831	31831	28648	28648	28648
			FEED	70	70	64	64	64	57	57	64	64	64	57	57	57
			Ap	0.03	0.021	0.012	0.008	0.032	0.018	0.011	0.06	0.042	0.042	0.024	0.024	0.015
	41	Hardened Cast Iron	Vc	13	13	12	12	19	17	17	25	25	25	23	23	23
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	20690	20690	19099	19099	20160	18038	18038	19894	19894	19894	18303	18303	18303
			FEED	41	41	38	38	40	36	36	40	40	40	37	37	37
			Ap	0.024	0.017	0.01	0.006	0.025	0.014	0.009	0.048	0.034	0.034	0.019	0.019	0.012

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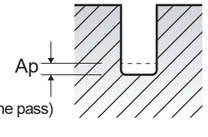

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter														
		0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.6	0.6	0.6	0.6	0.6	0.6	0.7
	LBS	1	1.5	2	2.5	3	4	5	6	2	3	4	6	8	10	2
1-5	Vc	68	68	68	68	61	61	61	54	69	69	62	62	55	41	80
	fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.002	0.003
	RPM	43290	43290	43290	43290	38834	38834	38834	34377	36606	36606	32892	32892	29178	21751	36378
	FEED	260	260	260	260	155	155	155	138	220	220	197	197	175	87	218
	Ap	0.1	0.1	0.07	0.07	0.04	0.04	0.025	0.025	0.084	0.084	0.048	0.03	0.018	0.012	0.14
6-8	Vc	68	68	68	68	61	61	61	54	69	69	62	62	55	41	80
	fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.002	0.003
	RPM	43290	43290	43290	43290	38834	38834	38834	34377	36606	36606	32892	32892	29178	21751	36378
	FEED	260	260	260	260	155	155	155	138	220	220	197	197	175	87	218
	Ap	0.1	0.1	0.07	0.07	0.04	0.04	0.025	0.025	0.084	0.084	0.048	0.03	0.018	0.012	0.14
9	Vc	44	44	44	44	40	40	40	35	45	45	41	41	36	27	53
	fz	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	RPM	28011	28011	28011	28011	25465	25465	25465	22282	23873	23873	21751	21751	19099	14324	24101
	FEED	112	112	112	112	51	51	51	45	95	95	87	87	76	57	96
	Ap	0.075	0.075	0.053	0.053	0.03	0.03	0.019	0.019	0.063	0.063	0.036	0.023	0.014	0.009	0.105
10-11.1	Vc	68	68	68	68	61	61	61	54	69	69	62	62	55	41	80
	fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.002	0.003
	RPM	43290	43290	43290	43290	38834	38834	38834	34377	36606	36606	32892	32892	29178	21751	36378
	FEED	260	260	260	260	155	155	155	138	220	220	197	197	175	87	218
	Ap	0.1	0.1	0.07	0.07	0.04	0.04	0.025	0.025	0.084	0.084	0.048	0.03	0.018	0.012	0.14
11.2	Vc	44	44	44	44	40	40	40	35	45	45	41	41	36	27	53
	fz	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	RPM	28011	28011	28011	28011	25465	25465	25465	22282	23873	23873	21751	21751	19099	14324	24101
	FEED	112	112	112	112	51	51	51	45	95	95	87	87	76	57	96
	Ap	0.075	0.075	0.053	0.053	0.03	0.03	0.019	0.019	0.063	0.063	0.036	0.023	0.014	0.009	0.105
15-20	Vc	68	68	68	68	61	61	61	54	69	69	62	62	55	41	80
	fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.002	0.003
	RPM	43290	43290	43290	43290	38834	38834	38834	34377	36606	36606	32892	32892	29178	21751	36378
	FEED	260	260	260	260	155	155	155	138	220	220	197	197	175	87	218
	Ap	0.1	0.1	0.07	0.07	0.04	0.04	0.025	0.025	0.084	0.084	0.048	0.03	0.018	0.012	0.14
38.1 - 38.2	Vc	27	27	27	27	24	24	24	21	27	27	25	25	22	16	32
	fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.002	0.002	0.002	0.002	0.002	0.001	0.002
	RPM	17189	17189	17189	17189	15279	15279	15279	13369	14324	14324	13263	13263	11671	8488	14551
	FEED	69	69	69	69	61	61	61	27	57	57	53	53	47	17	58
	Ap	0.06	0.06	0.042	0.042	0.024	0.024	0.015	0.015	0.05	0.05	0.029	0.018	0.011	0.007	0.084
40	Vc	44	44	44	44	40	40	40	35	45	45	41	41	36	27	53
	fz	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	RPM	28011	28011	28011	28011	25465	25465	25465	22282	23873	23873	21751	21751	19099	14324	24101
	FEED	112	112	112	112	51	51	51	45	95	95	87	87	76	57	96
	Ap	0.075	0.075	0.053	0.053	0.03	0.03	0.019	0.019	0.063	0.063	0.036	0.023	0.014	0.009	0.105
41	Vc	27	27	27	27	24	24	24	21	27	27	25	25	22	16	32
	fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.002	0.002	0.002	0.002	0.002	0.001	0.002
	RPM	17189	17189	17189	17189	15279	15279	15279	13369	14324	14324	13263	13263	11671	8488	14551
	FEED	69	69	69	69	61	61	61	27	57	57	53	53	47	17	58
	Ap	0.06	0.06	0.042	0.042	0.024	0.024	0.015	0.015	0.05	0.05	0.029	0.018	0.011	0.007	0.084

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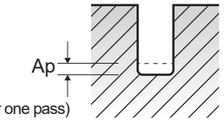

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)														
			0.7	0.7	0.7	0.7	0.8	0.8	0.8	0.8	0.8	0.8	1.0	1.0	1.0	1.0	1.0
		LBS	4	6	8	10	2	3	4	6	8	10	3	4	6	8	10
P	1-5	Vc	72	72	64	64	91	91	91	82	82	73	104	104	94	94	94
		fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004
		RPM	32740	32740	29103	29103	36208	36208	36208	32627	32627	29046	33104	33104	29921	29921	29921
		FEED	196	196	175	175	217	217	217	196	196	174	265	265	239	239	239
		Ap	0.056	0.035	0.035	0.021	0.16	0.112	0.112	0.064	0.04	0.04	0.2	0.14	0.08	0.08	0.05
	6-8	Vc	72	72	64	64	91	91	91	82	82	73	104	104	94	94	94
		fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004
		RPM	32740	32740	29103	29103	36208	36208	36208	32627	32627	29046	33104	33104	29921	29921	29921
		FEED	196	196	175	175	217	217	217	196	196	174	265	265	239	239	239
		Ap	0.056	0.035	0.035	0.021	0.16	0.112	0.112	0.064	0.04	0.04	0.2	0.14	0.08	0.08	0.05
	9	Vc	48	48	42	42	60	60	60	54	54	48	68	68	61	61	61
		fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
		RPM	21827	21827	19099	19099	23873	23873	23873	21486	21486	19099	21645	21645	19417	19417	19417
		FEED	87	87	76	76	95	95	95	86	86	76	130	130	78	78	78
		Ap	0.042	0.026	0.026	0.016	0.12	0.084	0.084	0.048	0.03	0.03	0.15	0.105	0.06	0.06	0.038
	10-11.1	Vc	72	72	64	64	91	91	91	82	82	73	104	104	94	94	94
		fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004
		RPM	32740	32740	29103	29103	36208	36208	36208	32627	32627	29046	33104	33104	29921	29921	29921
		FEED	196	196	175	175	217	217	217	196	196	174	265	265	239	239	239
		Ap	0.056	0.035	0.035	0.021	0.16	0.112	0.112	0.064	0.04	0.04	0.2	0.14	0.08	0.08	0.05
	11.2	Vc	48	48	42	42	60	60	60	54	54	48	68	68	61	61	61
		fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
		RPM	21827	21827	19099	19099	23873	23873	23873	21486	21486	19099	21645	21645	19417	19417	19417
		FEED	87	87	76	76	95	95	95	86	86	76	130	130	78	78	78
		Ap	0.042	0.026	0.026	0.016	0.12	0.084	0.084	0.048	0.03	0.03	0.15	0.105	0.06	0.06	0.038
K	15-20	Vc	72	72	64	64	91	91	91	82	82	73	104	104	94	94	94
		fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004
		RPM	32740	32740	29103	29103	36208	36208	36208	32627	32627	29046	33104	33104	29921	29921	29921
		FEED	196	196	175	175	217	217	217	196	196	174	265	265	239	239	239
		Ap	0.056	0.035	0.035	0.021	0.16	0.112	0.112	0.064	0.04	0.04	0.2	0.14	0.08	0.08	0.05
H	38.1 - 38.2	Vc	29	29	26	26	36	36	36	33	33	29	41	41	37	37	37
		fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
		RPM	13187	13187	11823	11823	14324	14324	14324	13130	13130	11539	13051	13051	11777	11777	11777
		FEED	53	53	47	47	57	57	57	53	53	46	78	78	47	47	47
		Ap	0.034	0.021	0.021	0.013	0.096	0.067	0.067	0.038	0.024	0.024	0.12	0.084	0.048	0.048	0.03
	40	Vc	48	48	42	42	60	60	60	54	54	48	68	68	61	61	61
		fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
		RPM	21827	21827	19099	19099	23873	23873	23873	21486	21486	19099	21645	21645	19417	19417	19417
		FEED	87	87	76	76	95	95	95	86	86	76	130	130	78	78	78
		Ap	0.042	0.026	0.026	0.016	0.12	0.084	0.084	0.048	0.03	0.03	0.15	0.105	0.06	0.06	0.038
	41	Vc	29	29	26	26	36	36	36	33	33	29	41	41	37	37	37
		fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
		RPM	13187	13187	11823	11823	14324	14324	14324	13130	13130	11539	13051	13051	11777	11777	11777
		FEED	53	53	47	47	57	57	57	53	53	46	78	78	47	47	47
		Ap	0.034	0.021	0.021	0.013	0.096	0.067	0.067	0.038	0.024	0.024	0.12	0.084	0.048	0.048	0.03

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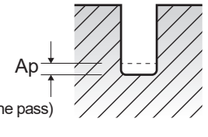

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)															
		1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.5	1.5	1.5	1.5
	LBS	12	14	16	20	3	4	6	8	10	12	16	20	4	6	8	10
1-5	Vc	83	83	62	62	112	112	112	101	101	101	90	67	124	124	112	112
	fz	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.003	0.006	0.006	0.005	0.005
	RPM	26420	26420	19735	19735	29709	29709	29709	26791	26791	26791	23873	17772	26314	26314	23767	23767
	FEED	159	159	118	118	297	297	297	214	214	214	191	107	316	316	238	238
	Ap	0.05	0.03	0.03	0.02	0.24	0.168	0.168	0.096	0.06	0.06	0.036	0.024	0.3	0.21	0.12	0.12
6-8	Vc	83	83	62	62	112	112	112	101	101	101	90	67	124	124	112	112
	fz	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.003	0.006	0.006	0.005	0.005
	RPM	26420	26420	19735	19735	29709	29709	29709	26791	26791	26791	23873	17772	26314	26314	23767	23767
	FEED	159	159	118	118	297	297	297	214	214	214	191	107	316	316	238	238
	Ap	0.05	0.03	0.03	0.02	0.24	0.168	0.168	0.096	0.06	0.06	0.036	0.024	0.3	0.21	0.12	0.12
9	Vc	54	54	41	41	71	71	71	64	64	64	57	43	76	76	69	69
	fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004
	RPM	17189	17189	13051	13051	18833	18833	18833	16977	16977	16977	15120	11406	16128	16128	14642	14642
	FEED	69	69	52	52	113	113	113	102	102	102	91	46	129	129	117	117
	Ap	0.038	0.023	0.023	0.015	0.18	0.126	0.126	0.072	0.045	0.045	0.027	0.018	0.225	0.158	0.09	0.09
10-11.1	Vc	83	83	62	62	112	112	112	101	101	101	90	67	124	124	112	112
	fz	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.003	0.006	0.006	0.005	0.005
	RPM	26420	26420	19735	19735	29709	29709	29709	26791	26791	26791	23873	17772	26314	26314	23767	23767
	FEED	159	159	118	118	297	297	297	214	214	214	191	107	316	316	238	238
	Ap	0.05	0.03	0.03	0.02	0.24	0.168	0.168	0.096	0.06	0.06	0.036	0.024	0.3	0.21	0.12	0.12
11.2	Vc	54	54	41	41	71	71	71	64	64	64	57	43	76	76	69	69
	fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004
	RPM	17189	17189	13051	13051	18833	18833	18833	16977	16977	16977	15120	11406	16128	16128	14642	14642
	FEED	69	69	52	52	113	113	113	102	102	102	91	46	129	129	117	117
	Ap	0.038	0.023	0.023	0.015	0.18	0.126	0.126	0.072	0.045	0.045	0.027	0.018	0.225	0.158	0.09	0.09
15-20	Vc	83	83	62	62	112	112	112	101	101	101	90	67	124	124	112	112
	fz	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.003	0.006	0.006	0.005	0.005
	RPM	26420	26420	19735	19735	29709	29709	29709	26791	26791	26791	23873	17772	26314	26314	23767	23767
	FEED	159	159	118	118	297	297	297	214	214	214	191	107	316	316	238	238
	Ap	0.05	0.03	0.03	0.02	0.24	0.168	0.168	0.096	0.06	0.06	0.036	0.024	0.3	0.21	0.12	0.12
38.1 - 38.2	Vc	33	33	25	25	44	44	44	40	40	40	35	26	48	48	43	43
	fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.003	0.003	0.003	0.003
	RPM	10504	10504	7958	7958	11671	11671	11671	10610	10610	10610	9284	6897	10186	10186	9125	9125
	FEED	42	42	32	32	70	70	70	64	64	64	37	28	61	61	55	55
	Ap	0.03	0.018	0.018	0.012	0.144	0.101	0.101	0.058	0.036	0.036	0.022	0.014	0.18	0.126	0.072	0.072
40	Vc	54	54	41	41	71	71	71	64	64	64	57	43	76	76	69	69
	fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004
	RPM	17189	17189	13051	13051	18833	18833	18833	16977	16977	16977	15120	11406	16128	16128	14642	14642
	FEED	69	69	52	52	113	113	113	102	102	102	91	46	129	129	117	117
	Ap	0.038	0.023	0.023	0.015	0.18	0.126	0.126	0.072	0.045	0.045	0.027	0.018	0.225	0.158	0.09	0.09
41	Vc	33	33	25	25	44	44	44	40	40	40	35	26	48	48	43	43
	fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.003	0.003	0.003	0.003
	RPM	10504	10504	7958	7958	11671	11671	11671	10610	10610	10610	9284	6897	10186	10186	9125	9125
	FEED	42	42	32	32	70	70	70	64	64	64	37	28	61	61	55	55
	Ap	0.03	0.018	0.018	0.012	0.144	0.101	0.101	0.058	0.036	0.036	0.022	0.014	0.18	0.126	0.072	0.072

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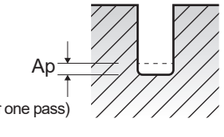

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)														
			1.5	1.5	1.5	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
		LBS	12	14	16	20	22	26	6	8	10	12	14	16	20	22	26
P	1-5	Vc	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109
		fz	0.005	0.005	0.004	0.004	0.004	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.006	0.006
		RPM	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348
		FEED	238	238	170	170	170	127	303	303	303	233	233	233	233	208	208
		Ap	0.12	0.075	0.075	0.045	0.045	0.03	0.4	0.28	0.28	0.16	0.16	0.16	0.1	0.1	0.1
	6-8	Vc	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109
		fz	0.005	0.005	0.004	0.004	0.004	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.006	0.006
		RPM	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348
		FEED	238	238	170	170	170	127	303	303	303	233	233	233	233	208	208
		Ap	0.12	0.075	0.075	0.045	0.045	0.03	0.4	0.28	0.28	0.16	0.16	0.16	0.1	0.1	0.1
	9	Vc	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69
		fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004
		RPM	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982
		FEED	117	117	78	78	78	59	138	138	138	124	124	124	124	88	88
		Ap	0.09	0.056	0.056	0.034	0.034	0.023	0.3	0.21	0.21	0.12	0.12	0.12	0.075	0.075	0.075
	10-11.1	Vc	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109
		fz	0.005	0.005	0.004	0.004	0.004	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.006	0.006
		RPM	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348
		FEED	238	238	170	170	170	127	303	303	303	233	233	233	233	208	208
		Ap	0.12	0.075	0.075	0.045	0.045	0.03	0.4	0.28	0.28	0.16	0.16	0.16	0.1	0.1	0.1
	11.2	Vc	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69
		fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004
		RPM	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982
		FEED	117	117	78	78	78	59	138	138	138	124	124	124	124	88	88
		Ap	0.09	0.056	0.056	0.034	0.034	0.023	0.3	0.21	0.21	0.12	0.12	0.12	0.075	0.075	0.075
K	15-20	Vc	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109
		fz	0.005	0.005	0.004	0.004	0.004	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.006	0.006
		RPM	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348
		FEED	238	238	170	170	170	127	303	303	303	233	233	233	233	208	208
		Ap	0.12	0.075	0.075	0.045	0.045	0.03	0.4	0.28	0.28	0.16	0.16	0.16	0.1	0.1	0.1
H	38.1 - 38.2	Vc	43	43	38	38	38	29	54	54	54	49	49	49	49	43	43
		fz	0.003	0.003	0.003	0.003	0.003	0.002	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004
		RPM	9125	9125	8064	8064	8064	6154	8594	8594	8594	7799	7799	7799	7799	6844	6844
		FEED	55	55	48	48	48	25	86	86	86	62	62	62	62	55	55
		Ap	0.072	0.045	0.045	0.027	0.027	0.018	0.24	0.168	0.168	0.096	0.096	0.096	0.06	0.06	0.06
	40	Vc	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69
		fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004
		RPM	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982
		FEED	117	117	78	78	78	59	138	138	138	124	124	124	124	88	88
		Ap	0.09	0.056	0.056	0.034	0.034	0.023	0.3	0.21	0.21	0.12	0.12	0.12	0.075	0.075	0.075
	41	Vc	43	43	38	38	38	29	54	54	54	49	49	49	49	43	43
		fz	0.003	0.003	0.003	0.003	0.003	0.002	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004
		RPM	9125	9125	8064	8064	8064	6154	8594	8594	8594	7799	7799	7799	7799	6844	6844
		FEED	55	55	48	48	48	25	86	86	86	62	62	62	62	55	55
		Ap	0.072	0.045	0.045	0.027	0.027	0.018	0.24	0.168	0.168	0.096	0.096	0.096	0.06	0.06	0.06

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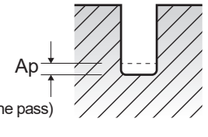

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)															
		2.0	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	LBS	30	8	10	12	14	16	20	26	30	8	10	12	14	16	20	26
1-5	Vc	109	141	141	141	127	127	127	113	113	150	150	150	150	135	135	135
	fz	0.006	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.007	0.01	0.01	0.01	0.01	0.009	0.009	0.009
	RPM	17348	17953	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324
	FEED	208	323	323	323	259	259	259	201	201	318	318	318	318	258	258	258
	Ap	0.06	0.35	0.35	0.35	0.2	0.2	0.2	0.125	0.125	0.6	0.42	0.42	0.42	0.24	0.24	0.15
6-8	Vc	109	141	141	141	127	127	127	113	113	150	150	150	150	135	135	135
	fz	0.006	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.007	0.01	0.01	0.01	0.01	0.009	0.009	0.009
	RPM	17348	17953	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324
	FEED	208	323	323	323	259	259	259	201	201	318	318	318	318	258	258	258
	Ap	0.06	0.35	0.35	0.35	0.2	0.2	0.2	0.125	0.125	0.6	0.42	0.42	0.42	0.24	0.24	0.15
9	Vc	69	90	90	90	81	81	81	72	72	97	97	97	97	87	87	87
	fz	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007
	RPM	10982	11459	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231
	FEED	88	160	160	160	124	124	124	92	92	165	165	165	165	129	129	129
	Ap	0.045	0.263	0.263	0.263	0.15	0.15	0.15	0.094	0.094	0.45	0.315	0.315	0.315	0.18	0.18	0.113
10-11.1	Vc	109	141	141	141	127	127	127	113	113	150	150	150	150	135	135	135
	fz	0.006	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.007	0.01	0.01	0.01	0.01	0.009	0.009	0.009
	RPM	17348	17953	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324
	FEED	208	323	323	323	259	259	259	201	201	318	318	318	318	258	258	258
	Ap	0.06	0.35	0.35	0.35	0.2	0.2	0.2	0.125	0.125	0.6	0.42	0.42	0.42	0.24	0.24	0.15
11.2	Vc	69	90	90	90	81	81	81	72	72	97	97	97	97	87	87	87
	fz	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007
	RPM	10982	11459	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231
	FEED	88	160	160	160	124	124	124	92	92	165	165	165	165	129	129	129
	Ap	0.045	0.263	0.263	0.263	0.15	0.15	0.15	0.094	0.094	0.45	0.315	0.315	0.315	0.18	0.18	0.113
15-20	Vc	109	141	141	141	127	127	127	113	113	150	150	150	150	135	135	135
	fz	0.006	0.009	0.009	0.009	0.008	0.008	0.008	0.007	0.007	0.01	0.01	0.01	0.01	0.009	0.009	0.009
	RPM	17348	17953	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324
	FEED	208	323	323	323	259	259	259	201	201	318	318	318	318	258	258	258
	Ap	0.06	0.35	0.35	0.35	0.2	0.2	0.2	0.125	0.125	0.6	0.42	0.42	0.42	0.24	0.24	0.15
38.1 - 38.2	Vc	43	57	57	57	52	52	52	46	46	59	59	59	59	53	53	53
	fz	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006
	RPM	6844	7257	7257	7257	6621	6621	6621	5857	5857	6260	6260	6260	6260	5623	5623	5623
	FEED	55	73	73	73	66	66	66	47	47	75	75	75	75	67	67	67
	Ap	0.036	0.21	0.21	0.21	0.12	0.12	0.12	0.075	0.075	0.36	0.252	0.252	0.252	0.144	0.144	0.09
40	Vc	69	90	90	90	81	81	81	72	72	97	97	97	97	87	87	87
	fz	0.004	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007
	RPM	10982	11459	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231
	FEED	88	160	160	160	124	124	124	92	92	165	165	165	165	129	129	129
	Ap	0.045	0.263	0.263	0.263	0.15	0.15	0.15	0.094	0.094	0.45	0.315	0.315	0.315	0.18	0.18	0.113
41	Vc	43	57	57	57	52	52	52	46	46	59	59	59	59	53	53	53
	fz	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006
	RPM	6844	7257	7257	7257	6621	6621	6621	5857	5857	6260	6260	6260	6260	5623	5623	5623
	FEED	55	73	73	73	66	66	66	47	47	75	75	75	75	67	67	67
	Ap	0.036	0.21	0.21	0.21	0.12	0.12	0.12	0.075	0.075	0.36	0.252	0.252	0.252	0.144	0.144	0.09

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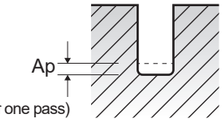

(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)												
			3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
		LBS	30	35	40	10	12	14	16	20	26	30	35	40	45
P	1-5	Vc	135	120	120	161	161	161	161	161	145	145	145	145	129
		fz	0.009	0.008	0.008	0.016	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012
		RPM	14324	12732	12732	12812	12812	12812	12812	12812	11539	11539	11539	11539	10265
		FEED	258	204	204	410	410	410	410	410	323	323	323	323	246
		Ap	0.15	0.15	0.09	0.8	0.8	0.56	0.56	0.56	0.32	0.32	0.2	0.2	0.2
	6-8	Vc	135	120	120	161	161	161	161	161	145	145	145	145	129
		fz	0.009	0.008	0.008	0.016	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012
		RPM	14324	12732	12732	12812	12812	12812	12812	12812	11539	11539	11539	11539	10265
		FEED	258	204	204	410	410	410	410	410	323	323	323	323	246
		Ap	0.15	0.15	0.09	0.8	0.8	0.56	0.56	0.56	0.32	0.32	0.2	0.2	0.2
	9	Vc	87	78	78	103	103	103	103	103	93	93	93	93	82
		fz	0.007	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.01
		RPM	9231	8276	8276	8196	8196	8196	8196	8196	7401	7401	7401	7401	6525
		FEED	129	99	99	197	197	197	197	197	163	163	163	163	131
		Ap	0.113	0.113	0.068	0.6	0.6	0.42	0.42	0.42	0.24	0.24	0.15	0.15	0.15
	10-11.1	Vc	135	120	120	161	161	161	161	161	145	145	145	145	129
		fz	0.009	0.008	0.008	0.016	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012
		RPM	14324	12732	12732	12812	12812	12812	12812	12812	11539	11539	11539	11539	10265
		FEED	258	204	204	410	410	410	410	410	323	323	323	323	246
		Ap	0.15	0.15	0.09	0.8	0.8	0.56	0.56	0.56	0.32	0.32	0.2	0.2	0.2
	11.2	Vc	87	78	78	103	103	103	103	103	93	93	93	93	82
		fz	0.007	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.01
		RPM	9231	8276	8276	8196	8196	8196	8196	8196	7401	7401	7401	7401	6525
		FEED	129	99	99	197	197	197	197	197	163	163	163	163	131
		Ap	0.113	0.113	0.068	0.6	0.6	0.42	0.42	0.42	0.24	0.24	0.15	0.15	0.15
K	15-20	Vc	135	120	120	161	161	161	161	161	145	145	145	145	129
		fz	0.009	0.008	0.008	0.016	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012
		RPM	14324	12732	12732	12812	12812	12812	12812	12812	11539	11539	11539	11539	10265
		FEED	258	204	204	410	410	410	410	410	323	323	323	323	246
		Ap	0.15	0.15	0.09	0.8	0.8	0.56	0.56	0.56	0.32	0.32	0.2	0.2	0.2
H	38.1 - 38.2	Vc	53	48	48	65	65	65	65	65	58	58	58	58	52
		fz	0.006	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.007
		RPM	5623	5093	5093	5173	5173	5173	5173	5173	4615	4615	4615	4615	4138
		FEED	67	51	51	93	93	93	93	93	74	74	74	74	58
		Ap	0.09	0.09	0.054	0.48	0.48	0.336	0.336	0.336	0.192	0.192	0.12	0.12	0.12
	40	Vc	87	78	78	103	103	103	103	103	93	93	93	93	82
		fz	0.007	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.01
		RPM	9231	8276	8276	8196	8196	8196	8196	8196	7401	7401	7401	7401	6525
		FEED	129	99	99	197	197	197	197	197	163	163	163	163	131
		Ap	0.113	0.113	0.068	0.6	0.6	0.42	0.42	0.42	0.24	0.24	0.15	0.15	0.15
	41	Vc	53	48	48	65	65	65	65	65	58	58	58	58	52
		fz	0.006	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.007
		RPM	5623	5093	5093	5173	5173	5173	5173	5173	4615	4615	4615	4615	4138
		FEED	67	51	51	93	93	93	93	93	74	74	74	74	58
		Ap	0.09	0.09	0.054	0.48	0.48	0.336	0.336	0.336	0.192	0.192	0.12	0.12	0.12

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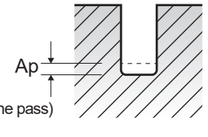
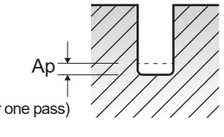


(Depth of cut per one pass)

SEME61 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)													
		4.0	5.0	6.0	6.0	8.0	8.0	10.0	10.0	12.0	12.0	16.0	16.0	20.0	20.0
	LBS	50	15	20	30	25	35	30	40	32	45	35	50	40	55
1-5	Vc	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.012	0.023	0.032	0.032	0.044	0.044	0.053	0.053	0.05	0.05	0.06	0.06	0.055	0.055
	RPM	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	246	507	608	608	634	634	634	634	499	499	446	446	329	329
	Ap	0.2	1	0.84	0.84	1.12	1.12	2	1.4	2.4	1.68	3.2	2.24	4	4
6-8	Vc	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.012	0.023	0.032	0.032	0.044	0.044	0.053	0.053	0.05	0.05	0.06	0.06	0.055	0.055
	RPM	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	246	507	608	608	634	634	634	634	499	499	446	446	329	329
	Ap	0.2	1	0.84	0.84	1.12	1.12	2	1.4	2.4	1.68	3.2	2.24	4	4
9	Vc	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.01	0.017	0.025	0.025	0.033	0.033	0.038	0.038	0.04	0.04	0.042	0.042	0.036	0.036
	RPM	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	131	238	300	300	299	299	305	305	267	267	212	212	141	141
	Ap	0.15	0.75	0.63	0.63	0.84	0.84	1.5	1.05	1.8	1.26	2.4	1.68	3	3
10-11.1	Vc	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.012	0.023	0.032	0.032	0.044	0.044	0.053	0.053	0.05	0.05	0.06	0.06	0.055	0.055
	RPM	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	246	507	608	608	634	634	634	634	499	499	446	446	329	329
	Ap	0.2	1	0.84	0.84	1.12	1.12	2	1.4	2.4	1.68	3.2	2.24	4	4
11.2	Vc	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.01	0.017	0.025	0.025	0.033	0.033	0.038	0.038	0.04	0.04	0.042	0.042	0.036	0.036
	RPM	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	131	238	300	300	299	299	305	305	267	267	212	212	141	141
	Ap	0.15	0.75	0.63	0.63	0.84	0.84	1.5	1.05	1.8	1.26	2.4	1.68	3	3
15-20	Vc	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.012	0.023	0.032	0.032	0.044	0.044	0.053	0.053	0.05	0.05	0.06	0.06	0.055	0.055
	RPM	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	246	507	608	608	634	634	634	634	499	499	446	446	329	329
	Ap	0.2	1	0.84	0.84	1.12	1.12	2	1.4	2.4	1.68	3.2	2.24	4	4
38.1 - 38.2	Vc	52	72	74	74	76	76	76	76	75	75	77	77	75	75
	fz	0.007	0.013	0.018	0.018	0.023	0.023	0.029	0.029	0.03	0.03	0.031	0.031	0.029	0.029
	RPM	4138	4584	3926	3926	3024	3024	2419	2419	1989	1989	1532	1532	1194	1194
	FEED	58	119	141	141	139	139	140	140	119	119	95	95	69	69
	Ap	0.12	0.6	0.504	0.504	0.672	0.672	1.2	0.84	1.44	1.008	1.92	1.344	2.4	2.4
40	Vc	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.01	0.017	0.025	0.025	0.033	0.033	0.038	0.038	0.04	0.04	0.042	0.042	0.036	0.036
	RPM	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	131	238	300	300	299	299	305	305	267	267	212	212	141	141
	Ap	0.15	0.75	0.63	0.63	0.84	0.84	1.5	1.05	1.8	1.26	2.4	1.68	3	3
41	Vc	52	72	74	74	76	76	76	76	75	75	77	77	75	75
	fz	0.007	0.013	0.018	0.018	0.023	0.023	0.029	0.029	0.03	0.03	0.031	0.031	0.029	0.029
	RPM	4138	4584	3926	3926	3024	3024	2419	2419	1989	1989	1532	1532	1194	1194
	FEED	58	119	141	141	139	139	140	140	119	119	95	95	69	69
	Ap	0.12	0.6	0.504	0.504	0.672	0.672	1.2	0.84	1.44	1.008	1.92	1.344	2.4	2.4



(Depth of cut per one pass)

SEME01 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 1.0	1.2	1.5	2.0	2.5	3.0	3.5	4.0
P	1-5	Non-alloy steel	0.05D	2D	Vc	87	93	104	113	118	125	132	135
					fz	0.003	0.003	0.004	0.004	0.006	0.006	0.008	0.01
					RPM	27693	24669	22069	17985	15024	13263	12005	10743
					FEED	332	296	353	288	361	318	384	430
	6-8	Low alloy steel	0.05D	2D	Vc	87	93	104	113	118	125	132	135
					fz	0.003	0.003	0.004	0.004	0.006	0.006	0.008	0.01
					RPM	27693	24669	22069	17985	15024	13263	12005	10743
					FEED	332	296	353	288	361	318	384	430
	9		0.05D	2D	Vc	57	59	64	73	75	81	85	86
					fz	0.003	0.004	0.004	0.005	0.007	0.008	0.009	0.011
					RPM	18144	15650	13581	11618	9549	8594	7730	6844
					FEED	218	250	217	232	267	275	278	301
	10-11.1	High alloyed steel, and tool steel	0.05D	2D	Vc	87	93	104	113	118	125	132	135
					fz	0.003	0.003	0.004	0.004	0.006	0.006	0.008	0.01
					RPM	27693	24669	22069	17985	15024	13263	12005	10743
					FEED	332	296	353	288	361	318	384	430
	11.2		0.05D	2D	Vc	57	59	64	73	75	81	85	86
					fz	0.003	0.004	0.004	0.005	0.007	0.008	0.009	0.011
					RPM	18144	15650	13581	11618	9549	8594	7730	6844
					FEED	218	250	217	232	267	275	278	301
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2D	Vc	87	93	104	113	118	125	132	135
					fz	0.003	0.003	0.004	0.004	0.006	0.006	0.008	0.01
					RPM	27693	24669	22069	17985	15024	13263	12005	10743
					FEED	332	296	353	288	361	318	384	430
H	38.1 - 38.2	Hardened steel	0.02D	2D	Vc	35	37	40	45	48	50	53	54
					fz	0.003	0.003	0.004	0.005	0.005	0.006	0.007	0.008
					RPM	11141	9815	8488	7162	6112	5305	4820	4297
					FEED	134	118	136	143	122	127	135	138
	40	Chilled Cast Iron	0.05D	2D	Vc	57	59	64	73	75	81	85	86
					fz	0.003	0.004	0.004	0.005	0.007	0.008	0.009	0.011
					RPM	18144	15650	13581	11618	9549	8594	7730	6844
					FEED	218	250	217	232	267	275	278	301
	41	Hardened Cast Iron	0.02D	2D	Vc	35	37	40	45	48	50	53	54
					fz	0.003	0.003	0.004	0.005	0.005	0.006	0.007	0.008
					RPM	11141	9815	8488	7162	6112	5305	4820	4297
					FEED	134	118	136	143	122	127	135	138

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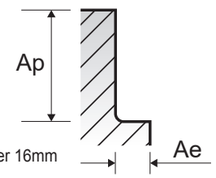
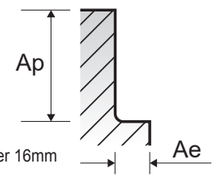


* 1.5XD Axial cutting depth should be for diameter over 16mm

SEME01 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 4.5	5.0	5.5	6.0	7.0	8.0	10.0	11.0	12.0	14.0	16.0	20.0
1-5	Vc	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.011	0.012	0.013	0.014	0.016	0.019	0.023	0.022	0.022	0.022	0.023	0.023
	RPM	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	439	440	442	443	445	457	463	402	362	318	286	231
6-8	Vc	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.011	0.012	0.013	0.014	0.016	0.019	0.023	0.022	0.022	0.022	0.023	0.023
	RPM	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	439	440	442	443	445	457	463	402	362	318	286	231
9	Vc	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.013	0.016	0.017	0.018	0.02	0.024	0.027	0.028	0.029	0.028	0.027	0.027
	RPM	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	327	371	370	363	353	367	354	340	323	272	228	177
10-11.1	Vc	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.011	0.012	0.013	0.014	0.016	0.019	0.023	0.022	0.022	0.022	0.023	0.023
	RPM	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	439	440	442	443	445	457	463	402	362	318	286	231
11.2	Vc	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.013	0.016	0.017	0.018	0.02	0.024	0.027	0.028	0.029	0.028	0.027	0.027
	RPM	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	327	371	370	363	353	367	354	340	323	272	228	177
15-20	Vc	141	144	147	149	153	151	158	158	155	159	156	158
	fz	0.011	0.012	0.013	0.014	0.016	0.019	0.023	0.022	0.022	0.022	0.023	0.023
	RPM	9974	9167	8508	7905	6957	6008	5029	4572	4112	3615	3104	2515
	FEED	439	440	442	443	445	457	463	402	362	318	286	231
38.1 - 38.2	Vc	57	60	61	62	64	63	63	64	63	65	64	63
	fz	0.01	0.011	0.012	0.013	0.015	0.017	0.021	0.021	0.021	0.021	0.022	0.023
	RPM	4032	3820	3530	3289	2910	2507	2005	1852	1671	1478	1273	1003
	FEED	161	168	169	171	175	170	168	156	140	124	112	92
40	Vc	89	91	94	95	97	96	103	105	105	107	106	103
	fz	0.013	0.016	0.017	0.018	0.02	0.024	0.027	0.028	0.029	0.028	0.027	0.027
	RPM	6295	5793	5440	5040	4411	3820	3279	3038	2785	2433	2109	1639
	FEED	327	371	370	363	353	367	354	340	323	272	228	177
41	Vc	57	60	61	62	64	63	63	64	63	65	64	63
	fz	0.01	0.011	0.012	0.013	0.015	0.017	0.021	0.021	0.021	0.021	0.022	0.023
	RPM	4032	3820	3530	3289	2910	2507	2005	1852	1671	1478	1273	1003
	FEED	161	168	169	171	175	170	168	156	140	124	112	92



* 1.5XD Axial cutting depth should be for diameter over 16mm

SEME64 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																
				1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
			LBS	4	6	8	10	12	16	20	22	26	3	4	6	8	10	12	16	20
P	1-5	Non-alloy steel	Vc	104	94	94	94	83	62	62	31	31	112	112	112	101	101	101	90	67
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	33104	29921	29921	29921	26420	19735	19735	9868	9868	29709	29709	29709	26791	26791	26791	23873	17772
			FEED	397	239	239	239	211	158	158	79	79	357	357	357	321	321	321	191	142
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005	0.004
	6-8	Low alloy steel	Vc	104	94	94	94	83	62	62	31	31	112	112	112	101	101	101	90	67
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	33104	29921	29921	29921	26420	19735	19735	9868	9868	29709	29709	29709	26791	26791	26791	23873	17772
			FEED	397	239	239	239	211	158	158	79	79	357	357	357	321	321	321	191	142
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005	0.004
	9		Vc	68	61	61	61	54	41	41	20	20	71	71	71	64	64	64	57	43
			fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.002
			RPM	21645	19417	19417	19417	17189	13051	13051	6366	6366	18833	18833	18833	16977	16977	16977	15120	11406
			FEED	260	233	233	233	138	104	104	51	51	301	301	301	204	204	204	181	91
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.01	0.019	0.011	0.007	0.007	0.004	0.003
	10-11.1	High alloyed steel, and tool steel	Vc	104	94	94	94	83	62	62	31	31	112	112	112	101	101	101	90	67
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	33104	29921	29921	29921	26420	19735	19735	9868	9868	29709	29709	29709	26791	26791	26791	23873	17772
			FEED	397	239	239	239	211	158	158	79	79	357	357	357	321	321	321	191	142
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005	0.004
	11.2		Vc	68	61	61	61	54	41	41	20	20	71	71	71	64	64	64	57	43
			fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.002
			RPM	21645	19417	19417	19417	17189	13051	13051	6366	6366	18833	18833	18833	16977	16977	16977	15120	11406
			FEED	260	233	233	233	138	104	104	51	51	301	301	301	204	204	204	181	91
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.01	0.019	0.011	0.007	0.007	0.004	0.003
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	104	94	94	94	83	62	62	31	31	112	112	112	101	101	101	90	67
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	33104	29921	29921	29921	26420	19735	19735	9868	9868	29709	29709	29709	26791	26791	26791	23873	17772
			FEED	397	239	239	239	211	158	158	79	79	357	357	357	321	321	321	191	142
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005	0.004
H	38.1 - 38.2	Hardened steel	Vc	41	37	37	37	33	25	25	12	12	44	44	44	40	40	40	35	26
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	13051	11777	11777	11777	10504	7958	7958	3820	3820	11671	11671	11671	10610	10610	10610	9284	6897
			FEED	157	94	94	94	84	64	64	31	31	140	140	140	127	127	127	74	55
			Ae	0.013	0.007	0.007	0.005	0.005	0.003	0.002	0.002	0.002	0.022	0.015	0.015	0.009	0.005	0.005	0.003	0.002
	40	Chilled Cast Iron	Vc	68	61	61	61	54	41	41	20	20	71	71	71	64	64	64	57	43
			fz	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.002
			RPM	21645	19417	19417	19417	17189	13051	13051	6366	6366	18833	18833	18833	16977	16977	16977	15120	11406
			FEED	260	233	233	233	138	104	104	51	51	301	301	301	204	204	204	181	91
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.01	0.019	0.011	0.007	0.007	0.004	0.003
	41	Hardened Cast Iron	Vc	41	37	37	37	33	25	25	12	12	44	44	44	40	40	40	35	26
			fz	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002
			RPM	13051	11777	11777	11777	10504	7958	7958	3820	3820	11671	11671	11671	10610	10610	10610	9284	6897
			FEED	157	94	94	94	84	64	64	31	31	140	140	140	127	127	127	74	55
			Ae	0.013	0.007	0.007	0.005	0.005	0.003	0.002	0.002	0.002	0.022	0.015	0.015	0.009	0.005	0.005	0.003	0.002

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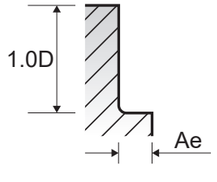

SEME64 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																				
		1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.5
	LBS	4	6	8	10	12	14	16	20	22	26	6	8	10	12	14	16	20	22	26	30	8
1-5	Vc	124	124	112	112	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109	109	141
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.005
	RPM	26314	26314	23767	23767	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348	17348	17953
	FEED	421	421	285	285	285	285	255	255	255	127	346	346	346	311	311	311	311	278	278	278	359
	Ae	0.045	0.032	0.018	0.018	0.018	0.011	0.011	0.007	0.007	0.005	0.06	0.042	0.042	0.024	0.024	0.024	0.015	0.015	0.015	0.009	0.053
6-8	Vc	124	124	112	112	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109	109	141
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.005
	RPM	26314	26314	23767	23767	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348	17348	17953
	FEED	421	421	285	285	285	285	255	255	255	127	346	346	346	311	311	311	311	278	278	278	359
	Ae	0.045	0.032	0.018	0.018	0.018	0.011	0.011	0.007	0.007	0.005	0.06	0.042	0.042	0.024	0.024	0.024	0.015	0.015	0.015	0.009	0.053
9	Vc	76	76	69	69	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69	69	90
	fz	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.007
	RPM	16128	16128	14642	14642	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982	10982	11459
	FEED	258	258	234	234	234	234	155	155	155	117	277	277	277	248	248	248	248	176	176	176	321
	Ae	0.034	0.024	0.014	0.014	0.014	0.008	0.008	0.005	0.005	0.003	0.045	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.011	0.007	0.039
10-11.1	Vc	124	124	112	112	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109	109	141
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.005
	RPM	26314	26314	23767	23767	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348	17348	17953
	FEED	421	421	285	285	285	285	255	255	255	127	346	346	346	311	311	311	311	278	278	278	359
	Ae	0.045	0.032	0.018	0.018	0.018	0.011	0.011	0.007	0.007	0.005	0.06	0.042	0.042	0.024	0.024	0.024	0.015	0.015	0.015	0.009	0.053
11.2	Vc	76	76	69	69	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69	69	90
	fz	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.007
	RPM	16128	16128	14642	14642	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982	10982	11459
	FEED	258	258	234	234	234	234	155	155	155	117	277	277	277	248	248	248	248	176	176	176	321
	Ae	0.034	0.024	0.014	0.014	0.014	0.008	0.008	0.005	0.005	0.003	0.045	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.011	0.007	0.039
15-20	Vc	124	124	112	112	112	112	100	100	100	75	136	136	136	122	122	122	122	109	109	109	141
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.005
	RPM	26314	26314	23767	23767	23767	23767	21221	21221	21221	15915	21645	21645	21645	19417	19417	19417	19417	17348	17348	17348	17953
	FEED	421	421	285	285	285	285	255	255	255	127	346	346	346	311	311	311	311	278	278	278	359
	Ae	0.045	0.032	0.018	0.018	0.018	0.011	0.011	0.007	0.007	0.005	0.06	0.042	0.042	0.024	0.024	0.024	0.015	0.015	0.015	0.009	0.053
38.1 - 38.2	Vc	48	48	43	43	43	43	38	38	38	29	54	54	54	49	49	49	49	43	43	43	57
	fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.005
	RPM	10186	10186	9125	9125	9125	9125	8064	8064	8064	6154	8594	8594	8594	7799	7799	7799	7799	6844	6844	6844	7257
	FEED	122	122	109	109	109	109	97	97	97	49	138	138	138	125	125	125	125	82	82	82	145
	Ae	0.027	0.019	0.011	0.011	0.011	0.007	0.007	0.004	0.004	0.003	0.036	0.025	0.025	0.014	0.014	0.014	0.009	0.009	0.009	0.005	0.032
40	Vc	76	76	69	69	69	69	61	61	61	46	87	87	87	78	78	78	78	69	69	69	90
	fz	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.007
	RPM	16128	16128	14642	14642	14642	14642	12945	12945	12945	9762	13846	13846	13846	12414	12414	12414	12414	10982	10982	10982	11459
	FEED	258	258	234	234	234	234	155	155	155	117	277	277	277	248	248	248	248	176	176	176	321
	Ae	0.034	0.024	0.014	0.014	0.014	0.008	0.008	0.005	0.005	0.003	0.045	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.011	0.007	0.039
41	Vc	48	48	43	43	43	43	38	38	38	29	54	54	54	49	49	49	49	43	43	43	57
	fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.005
	RPM	10186	10186	9125	9125	9125	9125	8064	8064	8064	6154	8594	8594	8594	7799	7799	7799	7799	6844	6844	6844	7257
	FEED	122	122	109	109	109	109	97	97	97	49	138	138	138	125	125	125	125	82	82	82	145
	Ae	0.027	0.019	0.011	0.011	0.011	0.007	0.007	0.004	0.004	0.003	0.036	0.025	0.025	0.014	0.014	0.014	0.009	0.009	0.009	0.005	0.032

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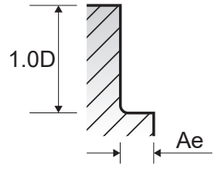

SEME64 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																		
			2.5	2.5	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	4.0	4.0	4.0
		LBS	10	12	14	16	20	26	30	8	10	12	14	16	20	26	30	35	40	10	12	14
P	1-5	Vc	141	141	127	127	127	113	113	150	150	150	150	135	135	135	135	120	120	161	161	161
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.005	0.01	0.01	0.01
		RPM	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324	14324	12732	12732	12812	12812	12812
		FEED	359	359	323	323	323	230	230	382	382	382	382	344	344	344	344	255	255	512	512	512
		Ae	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.014	0.12	0.12	0.084
	6-8	Vc	141	141	127	127	127	113	113	150	150	150	150	135	135	135	135	120	120	161	161	161
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.005	0.01	0.01	0.01
		RPM	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324	14324	12732	12732	12812	12812	12812
		FEED	359	359	323	323	323	230	230	382	382	382	382	344	344	344	344	255	255	512	512	512
		Ae	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.014	0.12	0.12	0.084
	9	Vc	90	90	81	81	81	72	72	97	97	97	97	87	87	87	87	78	78	103	103	103
		fz	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.011	0.011	0.011
		RPM	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231	9231	8276	8276	8196	8196	8196
		FEED	321	321	248	248	248	183	183	329	329	329	329	258	258	258	258	199	199	361	361	361
		Ae	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	0.027	0.027	0.017	0.017	0.017	0.01	0.09	0.09	0.063
	10-11.1	Vc	141	141	127	127	127	113	113	150	150	150	150	135	135	135	135	120	120	161	161	161
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.005	0.01	0.01	0.01
		RPM	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324	14324	12732	12732	12812	12812	12812
		FEED	359	359	323	323	323	230	230	382	382	382	382	344	344	344	344	255	255	512	512	512
		Ae	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.014	0.12	0.12	0.084
	11.2	Vc	90	90	81	81	81	72	72	97	97	97	97	87	87	87	87	78	78	103	103	103
		fz	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.011	0.011	0.011
		RPM	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231	9231	8276	8276	8196	8196	8196
		FEED	321	321	248	248	248	183	183	329	329	329	329	258	258	258	258	199	199	361	361	361
		Ae	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	0.027	0.027	0.017	0.017	0.017	0.01	0.09	0.09	0.063
K	15-20	Vc	141	141	127	127	127	113	113	150	150	150	150	135	135	135	135	120	120	161	161	161
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.005	0.01	0.01	0.01
		RPM	17953	17953	16170	16170	16170	14388	14388	15915	15915	15915	15915	14324	14324	14324	14324	12732	12732	12812	12812	12812
		FEED	359	359	323	323	323	230	230	382	382	382	382	344	344	344	344	255	255	512	512	512
		Ae	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.014	0.12	0.12	0.084
H	38.1 - 38.2	Vc	57	57	52	52	52	46	46	59	59	59	59	53	53	53	53	48	48	65	65	65
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.008	0.008	0.008
		RPM	7257	7257	6621	6621	6621	5857	5857	6260	6260	6260	6260	5623	5623	5623	5623	5093	5093	5173	5173	5173
		FEED	145	145	132	132	132	94	94	150	150	150	150	112	112	112	112	102	102	166	166	166
		Ae	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.054	0.038	0.038	0.038	0.022	0.022	0.014	0.014	0.014	0.008	0.072	0.072	0.05
	40	Vc	90	90	81	81	81	72	72	97	97	97	97	87	87	87	87	78	78	103	103	103
		fz	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.011	0.011	0.011
		RPM	11459	11459	10313	10313	10313	9167	9167	10292	10292	10292	10292	9231	9231	9231	9231	8276	8276	8196	8196	8196
		FEED	321	321	248	248	248	183	183	329	329	329	329	258	258	258	258	199	199	361	361	361
		Ae	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	0.027	0.027	0.017	0.017	0.017	0.01	0.09	0.09	0.063
	41	Vc	57	57	52	52	52	46	46	59	59	59	59	53	53	53	53	48	48	65	65	65
		fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.008	0.008	0.008
		RPM	7257	7257	6621	6621	6621	5857	5857	6260	6260	6260	6260	5623	5623	5623	5623	5093	5093	5173	5173	5173
		FEED	145	145	132	132	132	94	94	150	150	150	150	112	112	112	112	102	102	166	166	166
		Ae	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.054	0.038	0.038	0.038	0.022	0.022	0.014	0.014	0.014	0.008	0.072	0.072	0.05

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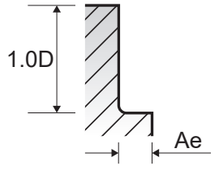
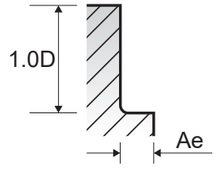


SEME64 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																			
		4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	5.0	6.0	6.0	8.0	8.0	10.0	10.0	12.0	12.0	16.0	16.0	20.0	20.0
	LBS	16	20	26	30	35	40	45	50	15	20	30	25	35	30	40	32	45	35	50	40	55
1-5	Vc	161	161	145	145	145	145	129	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.01	0.01	0.009	0.009	0.009	0.009	0.008	0.008	0.012	0.013	0.013	0.019	0.019	0.023	0.023	0.022	0.022	0.022	0.022	0.023	0.023
	RPM	12812	12812	11539	11539	11539	11539	10265	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	512	512	415	415	415	415	328	328	529	494	494	547	547	551	551	439	439	327	327	275	275
	Ae	0.084	0.084	0.048	0.048	0.03	0.03	0.03	0.03	0.15	0.126	0.126	0.168	0.168	0.3	0.21	0.36	0.252	0.48	0.336	0.6	0.6
6-8	Vc	161	161	145	145	145	145	129	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.01	0.01	0.009	0.009	0.009	0.009	0.008	0.008	0.012	0.013	0.013	0.019	0.019	0.023	0.023	0.022	0.022	0.022	0.022	0.023	0.023
	RPM	12812	12812	11539	11539	11539	11539	10265	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	512	512	415	415	415	415	328	328	529	494	494	547	547	551	551	439	439	327	327	275	275
	Ae	0.084	0.084	0.048	0.048	0.03	0.03	0.03	0.03	0.15	0.126	0.126	0.168	0.168	0.3	0.21	0.36	0.252	0.48	0.336	0.6	0.6
9	Vc	103	103	93	93	93	93	82	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.011	0.011	0.01	0.01	0.01	0.01	0.009	0.009	0.015	0.018	0.018	0.024	0.024	0.027	0.027	0.028	0.028	0.028	0.028	0.027	0.027
	RPM	8196	8196	7401	7401	7401	7401	6525	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	361	361	296	296	296	296	235	235	420	432	432	435	435	433	433	374	374	283	283	211	211
	Ae	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.023	0.113	0.095	0.095	0.126	0.126	0.225	0.158	0.27	0.189	0.36	0.252	0.45	0.45
10-11.1	Vc	161	161	145	145	145	145	129	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.01	0.01	0.009	0.009	0.009	0.009	0.008	0.008	0.012	0.013	0.013	0.019	0.019	0.023	0.023	0.022	0.022	0.022	0.022	0.023	0.023
	RPM	12812	12812	11539	11539	11539	11539	10265	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	512	512	415	415	415	415	328	328	529	494	494	547	547	551	551	439	439	327	327	275	275
	Ae	0.084	0.084	0.048	0.048	0.03	0.03	0.03	0.03	0.15	0.126	0.126	0.168	0.168	0.3	0.21	0.36	0.252	0.48	0.336	0.6	0.6
11.2	Vc	103	103	93	93	93	93	82	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.011	0.011	0.01	0.01	0.01	0.01	0.009	0.009	0.015	0.018	0.018	0.024	0.024	0.027	0.027	0.028	0.028	0.028	0.028	0.027	0.027
	RPM	8196	8196	7401	7401	7401	7401	6525	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	361	361	296	296	296	296	235	235	420	432	432	435	435	433	433	374	374	283	283	211	211
	Ae	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.023	0.113	0.095	0.095	0.126	0.126	0.225	0.158	0.27	0.189	0.36	0.252	0.45	0.45
15-20	Vc	161	161	145	145	145	145	129	129	173	179	179	181	181	188	188	188	188	187	187	188	188
	fz	0.01	0.01	0.009	0.009	0.009	0.009	0.008	0.008	0.012	0.013	0.013	0.019	0.019	0.023	0.023	0.022	0.022	0.022	0.022	0.023	0.023
	RPM	12812	12812	11539	11539	11539	11539	10265	10265	11014	9496	9496	7202	7202	5984	5984	4987	4987	3720	3720	2992	2992
	FEED	512	512	415	415	415	415	328	328	529	494	494	547	547	551	551	439	439	327	327	275	275
	Ae	0.084	0.084	0.048	0.048	0.03	0.03	0.03	0.03	0.15	0.126	0.126	0.168	0.168	0.3	0.21	0.36	0.252	0.48	0.336	0.6	0.6
38.1 - 38.2	Vc	65	65	58	58	58	58	52	52	72	74	74	76	76	76	76	75	75	77	77	75	75
	fz	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.011	0.013	0.013	0.017	0.017	0.021	0.021	0.02	0.02	0.022	0.022	0.021	0.021
	RPM	5173	5173	4615	4615	4615	4615	4138	4138	4584	3926	3926	3024	3024	2419	2419	1989	1989	1532	1532	1194	1194
	FEED	166	166	129	129	129	129	99	99	202	204	204	206	206	203	203	159	159	135	135	100	100
	Ae	0.05	0.05	0.029	0.029	0.018	0.018	0.018	0.018	0.09	0.076	0.076	0.101	0.101	0.18	0.126	0.216	0.151	0.288	0.202	0.36	0.36
40	Vc	103	103	93	93	93	93	82	82	110	113	113	114	114	126	126	126	126	127	127	123	123
	fz	0.011	0.011	0.01	0.01	0.01	0.01	0.009	0.009	0.015	0.018	0.018	0.024	0.024	0.027	0.027	0.028	0.028	0.028	0.028	0.027	0.027
	RPM	8196	8196	7401	7401	7401	7401	6525	6525	7003	5995	5995	4536	4536	4011	4011	3342	3342	2527	2527	1958	1958
	FEED	361	361	296	296	296	296	235	235	420	432	432	435	435	433	433	374	374	283	283	211	211
	Ae	0.063	0.063	0.036	0.036	0.023	0.023	0.023	0.023	0.113	0.095	0.095	0.126	0.126	0.225	0.158	0.27	0.189	0.36	0.252	0.45	0.45
41	Vc	65	65	58	58	58	58	52	52	72	74	74	76	76	76	76	75	75	77	77	75	75
	fz	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.011	0.013	0.013	0.017	0.017	0.021	0.021	0.02	0.02	0.022	0.022	0.021	0.021
	RPM	5173	5173	4615	4615	4615	4615	4138	4138	4584	3926	3926	3024	3024	2419	2419	1989	1989	1532	1532	1194	1194
	FEED	166	166	129	129	129	129	99	99	202	204	204	206	206	203	203	159	159	135	135	100	100
	Ae	0.05	0.05	0.029	0.029	0.018	0.018	0.018	0.018	0.09	0.076	0.076	0.101	0.101	0.18	0.126	0.216	0.151	0.288	0.202	0.36	0.36



SEME35 SERIES 2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0
P	1-5	Non-alloy steel	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	13	26	37	49	57	60	62	63	66	68
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004
					RPM	41380	41380	39258	38993	36287	31831	28193	25067	23343	21645
					FEED	83	83	79	78	145	127	169	150	187	173
	6-8	Low alloy steel	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	13	26	37	49	57	60	62	63	66	68
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004
					RPM	41380	41380	39258	38993	36287	31831	28193	25067	23343	21645
					FEED	83	83	79	78	145	127	169	150	187	173
	9		1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	8	16	22	29	34	36	37	38	40	41
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.003	0.004
					RPM	25465	25465	23343	23077	21645	19099	16825	15120	14147	13051
					FEED	51	51	47	46	87	76	101	91	85	104
	10 - 11.1	High alloyed steel, and tool steel	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	13	26	37	49	57	60	62	63	66	68
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004
					RPM	41380	41380	39258	38993	36287	31831	28193	25067	23343	21645
					FEED	83	83	79	78	145	127	169	150	187	173
	11.2		1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	8	16	22	29	34	36	37	38	40	41
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.003	0.004
					RPM	25465	25465	23343	23077	21645	19099	16825	15120	14147	13051
					FEED	51	51	47	46	87	76	101	91	85	104
M	14.1	Stainless steel	1.0D	0.5D (up to Ø1: 0.02D)	Vc	7	13	18	25	28	30	31	31	33	34
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.003	0.004
					RPM	22282	20690	19099	19894	17825	15915	14097	12335	11671	10823
					FEED	45	41	38	40	71	64	85	74	70	87
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	13	26	37	49	57	60	62	63	66	68
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004
					RPM	41380	41380	39258	38993	36287	31831	28193	25067	23343	21645
					FEED	83	83	79	78	145	127	169	150	187	173
H	38.1 - 38.2	Hardened steel	1.0D	0.05D (up to Ø1: 0.02D)	Vc	5	11	15	20	23	24	25	25	27	27
					fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002
					RPM	15915	17507	15915	15915	14642	12732	11368	9947	9549	8594
					FEED	16	35	32	32	29	25	23	40	38	34
	40	Chilled Cast Iron	1.0D	0.05D (up to Ø1: 0.02D)	Vc	8	16	22	29	34	36	37	38	40	41
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.003	0.004
					RPM	25465	25465	23343	23077	21645	19099	16825	15120	14147	13051
					FEED	51	51	47	46	87	76	101	91	85	104
	41	Hardened Cast Iron	1.0D	0.05D (up to Ø1: 0.02D)	Vc	5	11	15	20	23	24	25	25	27	27
					fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002
					RPM	15915	17507	15915	15915	14642	12732	11368	9947	9549	8594
					FEED	16	35	32	32	29	25	23	40	38	34

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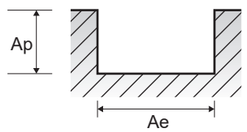

SEME35 SERIES 2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 1.2	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0
1-5	Vc	68	71	73	80	84	91	95	98	99	102	105	107	107
	fz	0.005	0.006	0.009	0.01	0.012	0.016	0.021	0.023	0.027	0.03	0.033	0.036	0.039
	RPM	18038	15067	11618	10186	8913	8276	7560	6932	6303	5903	5570	5240	4866
	FEED	180	181	209	204	214	265	318	319	340	354	368	377	380
6-8	Vc	68	71	73	80	84	91	95	98	99	102	105	107	107
	fz	0.005	0.006	0.009	0.01	0.012	0.016	0.021	0.023	0.027	0.03	0.033	0.036	0.039
	RPM	18038	15067	11618	10186	8913	8276	7560	6932	6303	5903	5570	5240	4866
	FEED	180	181	209	204	214	265	318	319	340	354	368	377	380
9	Vc	41	42	48	52	52	56	58	59	59	62	63	64	65
	fz	0.005	0.006	0.008	0.01	0.013	0.017	0.021	0.023	0.026	0.03	0.034	0.036	0.037
	RPM	10876	8913	7639	6621	5517	5093	4615	4173	3756	3588	3342	3134	2956
	FEED	109	107	122	132	143	173	194	192	195	215	227	226	219
10 - 11.1	Vc	68	71	73	80	84	91	95	98	99	102	105	107	107
	fz	0.005	0.006	0.009	0.01	0.012	0.016	0.021	0.023	0.027	0.03	0.033	0.036	0.039
	RPM	18038	15067	11618	10186	8913	8276	7560	6932	6303	5903	5570	5240	4866
	FEED	180	181	209	204	214	265	318	319	340	354	368	377	380
11.2	Vc	41	42	48	52	52	56	58	59	59	62	63	64	65
	fz	0.005	0.006	0.008	0.01	0.013	0.017	0.021	0.023	0.026	0.03	0.034	0.036	0.037
	RPM	10876	8913	7639	6621	5517	5093	4615	4173	3756	3588	3342	3134	2956
	FEED	109	107	122	132	143	173	194	192	195	215	227	226	219
14.1	Vc	34	35	40	43	44	47	49	50	50	52	54	54	54
	fz	0.005	0.006	0.008	0.01	0.014	0.016	0.021	0.023	0.027	0.03	0.033	0.036	0.038
	RPM	9019	7427	6366	5475	4669	4274	3899	3537	3183	3009	2865	2644	2456
	FEED	90	89	102	109	131	137	164	163	172	181	189	190	187
15 - 20	Vc	68	71	73	80	84	91	95	98	99	102	105	107	107
	fz	0.005	0.006	0.009	0.01	0.012	0.016	0.021	0.023	0.027	0.03	0.033	0.036	0.039
	RPM	18038	15067	11618	10186	8913	8276	7560	6932	6303	5903	5570	5240	4866
	FEED	180	181	209	204	214	265	318	319	340	354	368	377	380
38.1 - 38.2	Vc	27	28	32	33	32	35	37	37	36	37	38	39	40
	fz	0.002	0.003	0.004	0.005	0.006	0.007	0.007	0.009	0.011	0.013	0.015	0.016	0.018
	RPM	7162	5942	5093	4202	3395	3183	2944	2617	2292	2141	2016	1910	1819
	FEED	29	36	41	42	41	45	41	47	50	56	60	61	65
40	Vc	41	42	48	52	52	56	58	59	59	62	63	64	65
	fz	0.005	0.006	0.008	0.01	0.013	0.017	0.021	0.023	0.026	0.03	0.034	0.036	0.037
	RPM	10876	8913	7639	6621	5517	5093	4615	4173	3756	3588	3342	3134	2956
	FEED	109	107	122	132	143	173	194	192	195	215	227	226	219
41	Vc	27	28	32	33	32	35	37	37	36	37	38	39	40
	fz	0.002	0.003	0.004	0.005	0.006	0.007	0.007	0.009	0.011	0.013	0.015	0.016	0.018
	RPM	7162	5942	5093	4202	3395	3183	2944	2617	2292	2141	2016	1910	1819
	FEED	29	36	41	42	41	45	41	47	50	56	60	61	65

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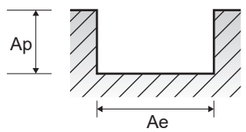

SEME35 SERIES 2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø) 7.5	8.0	8.5	9.0	9.5	10.0	10.5	11.0	11.5	12.0	13.0
P	1-5	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	107	106	106	105	104	102	103	104	104	103	106
				fz	0.043	0.048	0.049	0.05	0.051	0.053	0.053	0.053	0.053	0.054	0.054
				RPM	4541	4218	3970	3714	3485	3247	3122	3009	2879	2732	2595
				FEED	391	405	389	371	355	344	331	319	305	295	280
	6-8	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	107	106	106	105	104	102	103	104	104	103	106
				fz	0.043	0.048	0.049	0.05	0.051	0.053	0.053	0.053	0.053	0.054	0.054
				RPM	4541	4218	3970	3714	3485	3247	3122	3009	2879	2732	2595
				FEED	391	405	389	371	355	344	331	319	305	295	280
	9	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	64	63	64	64	64	63	63	64	64	63	65
				fz	0.039	0.042	0.042	0.042	0.042	0.043	0.042	0.041	0.04	0.04	0.041
				RPM	2716	2507	2397	2264	2144	2005	1910	1852	1771	1671	1592
				FEED	212	211	201	190	180	172	160	152	142	134	131
	10 - 11.1	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	107	106	106	105	104	102	103	104	104	103	106
				fz	0.043	0.048	0.049	0.05	0.051	0.053	0.053	0.053	0.053	0.054	0.054
				RPM	4541	4218	3970	3714	3485	3247	3122	3009	2879	2732	2595
				FEED	391	405	389	371	355	344	331	319	305	295	280
	11.2	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	64	63	64	64	64	63	63	64	64	63	65
				fz	0.039	0.042	0.042	0.042	0.042	0.043	0.042	0.041	0.04	0.04	0.041
				RPM	2716	2507	2397	2264	2144	2005	1910	1852	1771	1671	1592
				FEED	212	211	201	190	180	172	160	152	142	134	131
M	14.1	1.0D	0.5D (up to Ø1: 0.02D)	Vc	54	53	53	53	53	53	53	53	52	51	52
				fz	0.042	0.045	0.046	0.048	0.049	0.051	0.05	0.049	0.049	0.05	0.051
				RPM	2292	2109	1985	1874	1776	1687	1607	1534	1439	1353	1273
				FEED	193	190	183	180	174	172	161	150	141	135	130
K	15-20	1.0D	0.5D (up to Ø3: 0.2D) (up to Ø1: 0.15D)	Vc	107	106	106	105	104	102	103	104	104	103	106
				fz	0.043	0.048	0.049	0.05	0.051	0.053	0.053	0.053	0.053	0.054	0.054
				RPM	4541	4218	3970	3714	3485	3247	3122	3009	2879	2732	2595
				FEED	391	405	389	371	355	344	331	319	305	295	280
H	38.1 - 38.2	1.0D	0.05D (up to Ø1: 0.02D)	Vc	41	42	43	43	43	43	43	44	44	44	45
				fz	0.021	0.024	0.023	0.022	0.022	0.023	0.023	0.023	0.024	0.025	0.025
				RPM	1740	1671	1610	1521	1441	1369	1304	1273	1218	1167	1102
				FEED	73	80	74	67	63	63	60	59	58	58	55
	40	1.0D	0.05D (up to Ø1: 0.02D)	Vc	64	63	64	64	64	63	63	64	64	63	65
				fz	0.039	0.042	0.042	0.042	0.042	0.043	0.042	0.041	0.04	0.04	0.041
				RPM	2716	2507	2397	2264	2144	2005	1910	1852	1771	1671	1592
				FEED	212	211	201	190	180	172	160	152	142	134	131
	41	1.0D	0.05D (up to Ø1: 0.02D)	Vc	41	42	43	43	43	43	43	44	44	44	45
				fz	0.021	0.024	0.023	0.022	0.022	0.023	0.023	0.023	0.024	0.025	0.025
				RPM	1740	1671	1610	1521	1441	1369	1304	1273	1218	1167	1102
				FEED	73	80	74	67	63	63	60	59	58	58	55

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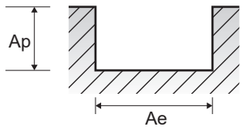
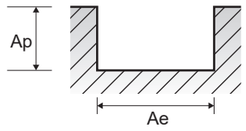


SEME35 SERIES 2 FLUTE - SLOTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 14.0	15.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0	25.0
1-5	Vc	109	110	111	111	110	108	106	107	107	107	107	107
	fz	0.054	0.052	0.052	0.052	0.053	0.052	0.054	0.053	0.053	0.051	0.049	0.05
	RPM	2478	2334	2208	2078	1945	1809	1687	1622	1548	1481	1419	1362
	FEED	268	243	230	216	206	188	182	172	164	151	139	136
6-8	Vc	109	110	111	111	110	108	106	107	107	107	107	107
	fz	0.054	0.052	0.052	0.052	0.053	0.052	0.054	0.053	0.053	0.051	0.049	0.05
	RPM	2478	2334	2208	2078	1945	1809	1687	1622	1548	1481	1419	1362
	FEED	268	243	230	216	206	188	182	172	164	151	139	136
9	Vc	67	68	68	69	68	68	67	67	67	67	67	66
	fz	0.041	0.042	0.042	0.041	0.041	0.04	0.04	0.04	0.041	0.042	0.043	0.044
	RPM	1523	1443	1353	1292	1203	1139	1066	1016	969	927	889	840
	FEED	125	121	114	106	99	91	85	81	79	78	76	74
10 - 11.1	Vc	109	110	111	111	110	108	106	107	107	107	107	107
	fz	0.054	0.052	0.052	0.052	0.053	0.052	0.054	0.053	0.053	0.051	0.049	0.05
	RPM	2478	2334	2208	2078	1945	1809	1687	1622	1548	1481	1419	1362
	FEED	268	243	230	216	206	188	182	172	164	151	139	136
11.2	Vc	67	68	68	69	68	68	67	67	67	67	67	66
	fz	0.041	0.042	0.042	0.041	0.041	0.04	0.04	0.04	0.041	0.042	0.043	0.044
	RPM	1523	1443	1353	1292	1203	1139	1066	1016	969	927	889	840
	FEED	125	121	114	106	99	91	85	81	79	78	76	74
14.1	Vc	53	53	53	54	54	53	53	53	54	54	54	53
	fz	0.052	0.053	0.054	0.052	0.053	0.05	0.05	0.05	0.049	0.048	0.047	0.046
	RPM	1205	1125	1054	1011	955	888	844	803	781	747	716	675
	FEED	125	119	114	105	101	89	84	80	77	72	67	62
15-20	Vc	109	110	111	111	110	108	106	107	107	107	107	107
	fz	0.054	0.052	0.052	0.052	0.053	0.052	0.054	0.053	0.053	0.051	0.049	0.05
	RPM	2478	2334	2208	2078	1945	1809	1687	1622	1548	1481	1419	1362
	FEED	268	243	230	216	206	188	182	172	164	151	139	136
38.1 - 38.2	Vc	45	45	45	45	45	44	43	43	43	43	43	42
	fz	0.024	0.023	0.023	0.023	0.023	0.023	0.024	0.022	0.022	0.021	0.02	0.019
	RPM	1023	955	895	843	796	737	684	652	622	595	570	535
	FEED	49	44	41	39	37	34	33	29	27	25	23	20
40	Vc	67	68	68	69	68	68	67	67	67	67	67	66
	fz	0.041	0.042	0.042	0.041	0.041	0.04	0.04	0.04	0.041	0.042	0.043	0.044
	RPM	1523	1443	1353	1292	1203	1139	1066	1016	969	927	889	840
	FEED	125	121	114	106	99	91	85	81	79	78	76	74
41	Vc	45	45	45	45	45	44	43	43	43	43	43	42
	fz	0.024	0.023	0.023	0.023	0.023	0.023	0.024	0.022	0.022	0.021	0.02	0.019
	RPM	1023	955	895	843	796	737	684	652	622	595	570	535
	FEED	49	44	41	39	37	34	33	29	27	25	23	20



SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2
					LOC	3	4	5	6	7	8	10	12	4	6	8	10	12
P	1-5	Non-alloy steel	1.0D	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46	46
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202	12202
					FEED	64	64	64	57	57	57	57	51	81	81	49	49	49
	6-8	Low alloy steel	1.0D	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46	46
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202	12202
					FEED	64	64	64	57	57	57	57	51	81	81	49	49	49
	9		1.0D	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37	37
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815	9815
					FEED	51	51	51	46	46	46	46	41	65	65	59	39	39
	10-11.1	High alloyed steel, and tool steel	1.0D	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46	46
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202	12202
					FEED	64	64	64	57	57	57	57	51	81	81	49	49	49
	11.2		1.0D	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37	37
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815	9815
					FEED	51	51	51	46	46	46	46	41	65	65	59	39	39
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46	46
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002	0.002
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202	12202
					FEED	64	64	64	57	57	57	57	51	81	81	49	49	49
H	38.1 - 38.2	Hardened steel	1.0D	0.05D	Vc	25	25	25	23	23	23	23	20	25	25	23	23	23
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002
					RPM	7958	7958	7958	7321	7321	7321	7321	6366	6631	6631	6101	6101	6101
					FEED	32	32	32	29	29	15	15	13	27	27	24	24	24
	40	Chilled Cast Iron	1.0D	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37	37
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815	9815
					FEED	51	51	51	46	46	46	46	41	65	65	59	39	39
	41	Hardened Cast Iron	1.0D	0.05D	Vc	25	25	25	23	23	23	23	20	25	25	23	23	23
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002
					RPM	7958	7958	7958	7321	7321	7321	7321	6366	6631	6631	6101	6101	6101
					FEED	32	32	32	29	29	15	15	13	27	27	24	24	24

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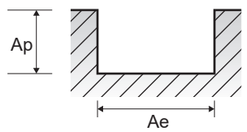

SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																		
		1.5	1.5	1.5	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0
	LOC	6	8	10	12	14	16	8	10	12	14	16	10	12	16	20	26	10	12	14
1-5	Vc	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60
	fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008
	RPM	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366
	FEED	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102
6-8	Vc	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60
	fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008
	RPM	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366
	FEED	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102
9	Vc	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008
	RPM	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199
	FEED	71	65	48	48	48	43	73	73	65	65	52	75	75	67	56	50	83	83	83
10-11.1	Vc	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60
	fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008
	RPM	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366
	FEED	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102
11.2	Vc	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008
	RPM	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199
	FEED	71	65	48	48	48	43	73	73	65	65	52	75	75	67	56	50	83	83	83
15-20	Vc	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60
	fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008
	RPM	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366
	FEED	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102
38.1 - 38.2	Vc	26	24	24	24	24	21	29	29	26	26	26	30	30	27	27	24	30	30	30
	fz	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006	0.006
	RPM	5517	5093	5093	5093	5093	4456	4615	4615	4138	4138	4138	3820	3820	3438	3438	3056	3183	3183	3183
	FEED	33	31	20	20	20	18	37	37	33	33	25	38	38	28	28	18	38	38	38
40	Vc	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008
	RPM	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199
	FEED	71	65	48	48	48	43	73	73	65	65	52	75	75	67	56	50	83	83	83
41	Vc	26	24	24	24	24	21	29	29	26	26	26	30	30	27	27	24	30	30	30
	fz	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006	0.006
	RPM	5517	5093	5093	5093	5093	4456	4615	4615	4138	4138	4138	3820	3820	3438	3438	3056	3183	3183	3183
	FEED	33	31	20	20	20	18	37	37	33	33	25	38	38	28	28	18	38	38	38

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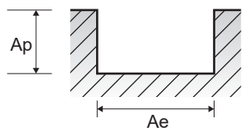

SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	5.0	5.0	5.0	5.0	5.0	6.0	6.0
				LOC	16	20	26	30	12	16	20	26	30	20	25	30	35	40	15	20
P	1-5	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	62	72	72
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183	183
	6-8	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	62	72	72
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183	183
	9	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	49	57	57
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151	151
	10-11.1	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	62	72	72
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183	183
	11.2	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	49	57	57
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151	151
K	15-20	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	62	72	72
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183	183
H	38.1 - 38.2	1.0D	0.05D	Vc	27	27	27	27	32	32	32	29	29	36	36	32	32	32	37	37
				fz	0.007	0.006	0.005	0.005	0.01	0.01	0.01	0.009	0.009	0.012	0.012	0.011	0.011	0.01	0.018	0.018
				RPM	2865	2865	2865	2865	2546	2546	2546	2308	2308	2292	2292	2037	2037	2037	1963	1963
				FEED	40	34	29	29	51	51	51	42	42	55	55	45	45	41	71	71
	40	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	49	57	57
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151	151
	41	1.0D	0.05D	Vc	27	27	27	27	32	32	32	29	29	36	36	32	32	32	37	37
				fz	0.007	0.006	0.005	0.005	0.01	0.01	0.01	0.009	0.009	0.012	0.012	0.011	0.011	0.01	0.018	0.018
				RPM	2865	2865	2865	2865	2546	2546	2546	2308	2308	2292	2292	2037	2037	2037	1963	1963
				FEED	40	34	29	29	51	51	51	42	42	55	55	45	45	41	71	71

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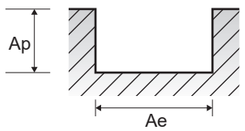

SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																		
		6.0	6.0	6.0	6.0	6.0	8.0	8.0	8.0	8.0	8.0	8.0	10.0	10.0	10.0	10.0	10.0	10.0	10.0	12.0
	LOC	25	30	35	40	45	25	30	35	40	45	50	30	35	40	45	50	55	60	35
1-5	Vc	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75
	fz	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038
	RPM	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989
	FEED	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151
6-8	Vc	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75
	fz	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038
	RPM	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989
	FEED	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151
9	Vc	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63
	fz	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04
	RPM	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671
	FEED	151	127	116	99	99	150	150	150	122	116	99	152	152	152	124	124	116	102	134
10-11.1	Vc	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75
	fz	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038
	RPM	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989
	FEED	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151
11.2	Vc	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63
	fz	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04
	RPM	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671
	FEED	151	127	116	99	99	150	150	150	122	116	99	152	152	152	124	124	116	102	134
15-20	Vc	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75
	fz	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038
	RPM	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989
	FEED	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151
38.1 - 38.2	Vc	37	37	33	33	33	38	38	38	38	34	34	38	38	38	38	38	34	34	38
	fz	0.018	0.015	0.016	0.014	0.014	0.023	0.023	0.023	0.02	0.02	0.018	0.029	0.029	0.029	0.025	0.025	0.025	0.023	0.027
	RPM	1963	1963	1751	1751	1751	1512	1512	1512	1512	1353	1353	1210	1210	1210	1210	1210	1082	1082	1008
	FEED	71	59	56	49	49	70	70	70	60	54	49	70	70	70	60	60	54	50	54
40	Vc	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63
	fz	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04
	RPM	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671
	FEED	151	127	116	99	99	150	150	150	122	116	99	152	152	152	124	124	116	102	134
41	Vc	37	37	33	33	33	38	38	38	38	34	34	38	38	38	38	38	34	34	38
	fz	0.018	0.015	0.016	0.014	0.014	0.023	0.023	0.023	0.02	0.02	0.018	0.029	0.029	0.029	0.025	0.025	0.025	0.023	0.027
	RPM	1963	1963	1751	1751	1751	1512	1512	1512	1512	1353	1353	1210	1210	1210	1210	1210	1082	1082	1008
	FEED	71	59	56	49	49	70	70	70	60	54	49	70	70	70	60	60	54	50	54

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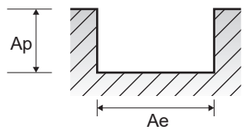

SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)														
					12.0	12.0	12.0	12.0	12.0	12.0	12.0	14.0	14.0	16.0	16.0	16.0	16.0	16.0	16.0
				LOC	40	45	50	55	60	65	70	50	60	40	50	60	70	80	90
P	1-5	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	77
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.031
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	1532
				FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	95
	6-8	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	77
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.031
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	1532
				FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	95
	9	1.0D	0.3D (up to Ø3:0.4mm)	Vc	63	63	63	63	63	57	57	65	65	64	64	64	64	64	58
				fz	0.04	0.034	0.034	0.034	0.03	0.03	0.03	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.03
				RPM	1671	1671	1671	1671	1671	1512	1512	1478	1478	1273	1273	1273	1273	1273	1154
				FEED	134	114	114	114	100	91	91	100	100	104	104	89	89	79	69
	10-11.1	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	77
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.031
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	1532
				FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	95
	11.2	1.0D	0.3D (up to Ø3:0.4mm)	Vc	63	63	63	63	63	57	57	65	65	64	64	64	64	64	58
				fz	0.04	0.034	0.034	0.034	0.03	0.03	0.03	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.03
				RPM	1671	1671	1671	1671	1671	1512	1512	1478	1478	1273	1273	1273	1273	1273	1154
				FEED	134	114	114	114	100	91	91	100	100	104	104	89	89	79	69
K	15-20	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	77
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.031
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	1532
				FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	95
H	38.1 - 38.2	1.0D	0.05D	Vc	38	38	38	38	38	34	34	40	40	40	40	40	40	40	36
				fz	0.027	0.022	0.022	0.022	0.02	0.019	0.019	0.025	0.025	0.031	0.031	0.025	0.025	0.022	0.021
				RPM	1008	1008	1008	1008	1008	902	902	909	909	796	796	796	796	796	716
				FEED	54	44	44	44	40	34	34	45	45	49	49	40	40	35	30
	40	1.0D	0.3D (up to Ø3:0.4mm)	Vc	63	63	63	63	63	57	57	65	65	64	64	64	64	64	58
				fz	0.04	0.034	0.034	0.034	0.03	0.03	0.03	0.034	0.034	0.041	0.041	0.035	0.035	0.031	0.03
				RPM	1671	1671	1671	1671	1671	1512	1512	1478	1478	1273	1273	1273	1273	1273	1154
				FEED	134	114	114	114	100	91	91	100	100	104	104	89	89	79	69
	41	1.0D	0.05D	Vc	38	38	38	38	38	34	34	40	40	40	40	40	40	40	36
				fz	0.027	0.022	0.022	0.022	0.02	0.019	0.019	0.025	0.025	0.031	0.031	0.025	0.025	0.022	0.021
				RPM	1008	1008	1008	1008	1008	902	902	909	909	796	796	796	796	796	716
				FEED	54	44	44	44	40	34	34	45	45	49	49	40	40	35	30

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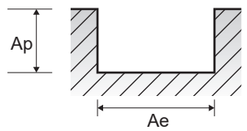
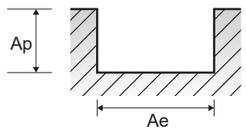


SEME70 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter																		
		16.0	16.0	18.0	18.0	18.0	20.0	20.0	20.0	20.0	20.0	20.0	20.0	22.0	22.0	25.0	25.0	25.0	25.0
	LOC	110	120	50	70	100	50	60	70	80	90	110	120	75	110	70	90	110	120
1-5	Vc	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	119	99	81	100	100	86	86	76	70	70	75	70	80	71	71	61
6-8	Vc	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	119	99	81	100	100	86	86	76	70	70	75	70	80	71	71	61
9	Vc	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
10-11.1	Vc	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	119	99	81	100	100	86	86	76	70	70	75	70	80	71	71	61
11.2	Vc	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
15-20	Vc	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	119	99	81	100	100	86	86	76	70	70	75	70	80	71	71	61
38.1 - 38.2	Vc	36	36	40	40	36	38	38	38	38	38	34	34	38	38	38	38	38	38
	fz	0.021	0.021	0.029	0.025	0.024	0.029	0.029	0.025	0.025	0.021	0.023	0.023	0.027	0.023	0.031	0.026	0.026	0.026
	RPM	716	716	707	707	637	605	605	605	605	605	541	541	550	550	484	484	484	484
	FEED	30	30	41	35	31	35	35	30	30	25	25	25	30	25	30	25	25	25
40	Vc	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
41	Vc	36	36	40	40	36	38	38	38	38	38	34	34	38	38	38	38	38	38
	fz	0.021	0.021	0.029	0.025	0.024	0.029	0.029	0.025	0.025	0.021	0.023	0.023	0.027	0.023	0.031	0.026	0.026	0.026
	RPM	716	716	707	707	637	605	605	605	605	605	541	541	550	550	484	484	484	484
	FEED	30	30	41	35	31	35	35	30	30	25	25	25	30	25	30	25	25	25



SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																	
				0.1	0.1	0.1	0.15	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.4	0.4	0.4
			LBS	0.3	0.5	1	0.35	0.5	1	1.5	2	1	1.5	2	2.5	3	4	5	1	1.5	2
P	1-5	Non-alloy steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
	6-8	Low alloy steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
	9		Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	32
			fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007	0.007
			RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465	25465
			FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357	357
			Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
	10-11.1	High alloyed steel, and tool steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
	11.2		Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	32
			fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007	0.007
			RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465	25465
			FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357	357
			Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
H	38.1 - 38.2	Hardened steel	Vc	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29	29
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.006	0.006	0.006
			RPM	41380	41380	35014	33953	31831	31831	28648	28648	28648	28648	25465	25465	25465	22282	16977	23077	23077	23077
			FEED	166	166	140	136	191	191	172	172	229	229	204	204	204	134	102	277	277	277
			Ap	0.005	0.004	0.001	0.007	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014	0.014
	40	Chilled Cast Iron	Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	32
			fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007	0.007
			RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465	25465
			FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357	357
			Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
	41	Hardened Cast Iron	Vc	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29	29
			fz	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.006	0.006	0.006
			RPM	41380	41380	35014	33953	31831	31831	28648	28648	28648	28648	25465	25465	25465	22282	16977	23077	23077	23077
			FEED	166	166	140	136	191	191	172	172	229	229	204	204	204	134	102	277	277	277
			Ap	0.005	0.004	0.001	0.007	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014	0.014

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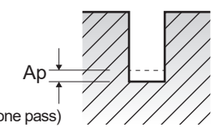

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																					
		0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.6	0.6
	LBS	2.5	3	4	5	6	8	10	1	1.5	2	2.5	3	4	5	6	8	10	12	14	16	2	3
1-5	Vc	31	31	31	28	28	21	10	43	43	43	43	39	39	39	34	26	26	13	13	4	52	52
	fz	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.005	0.014	0.014
	RPM	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587
	FEED	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99	25	772	772
	Ap	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007	0.005	0.005	0.005	0.005	0.038	0.038
6-8	Vc	31	31	31	28	28	21	10	43	43	43	43	39	39	39	34	26	26	13	13	4	52	52
	fz	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.005	0.014	0.014
	RPM	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587
	FEED	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99	25	772	772
	Ap	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007	0.005	0.005	0.005	0.005	0.038	0.038
9	Vc	29	29	29	26	26	19	10	41	41	41	41	36	36	36	32	24	24	12	12	4	49	49
	fz	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.004	0.011	0.011
	RPM	23077	23077	23077	20690	20690	15120	7958	26101	26101	26101	26101	22918	22918	22918	20372	15279	15279	7639	7639	2546	25995	25995
	FEED	323	323	323	248	248	151	80	418	418	418	418	321	321	321	285	183	183	76	76	20	572	572
	Ap	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.004	0.004	0.029	0.029
10-11.1	Vc	31	31	31	28	28	21	10	43	43	43	43	39	39	39	34	26	26	13	13	4	52	52
	fz	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.005	0.014	0.014
	RPM	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587
	FEED	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99	25	772	772
	Ap	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007	0.005	0.005	0.005	0.005	0.038	0.038
11.2	Vc	29	29	29	26	26	19	10	41	41	41	41	36	36	36	32	24	24	12	12	4	49	49
	fz	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.004	0.011	0.011
	RPM	23077	23077	23077	20690	20690	15120	7958	26101	26101	26101	26101	22918	22918	22918	20372	15279	15279	7639	7639	2546	25995	25995
	FEED	323	323	323	248	248	151	80	418	418	418	418	321	321	321	285	183	183	76	76	20	572	572
	Ap	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.004	0.004	0.029	0.029
15-20	Vc	31	31	31	28	28	21	10	43	43	43	43	39	39	39	34	26	26	13	13	4	52	52
	fz	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.005	0.014	0.014
	RPM	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587
	FEED	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99	25	772	772
	Ap	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007	0.005	0.005	0.005	0.005	0.038	0.038
38.1 - 38.2	Vc	26	26	26	23	23	17	9	36	36	36	36	32	32	32	29	21	21	11	11	4	43	43
	fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.004	0.004	0.004	0.004	0.003	0.009	0.009
	RPM	20690	20690	20690	18303	18303	13528	7162	22918	22918	22918	22918	20372	20372	20372	18462	13369	13369	7003	7003	2546	22812	22812
	FEED	207	207	207	183	183	108	57	275	275	275	275	244	244	244	185	107	107	56	56	15	411	411
	Ap	0.008	0.008	0.005	0.005	0.003	0.002	0.002	0.025	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.004	0.003	0.003	0.003	0.003	0.021	0.021
40	Vc	29	29	29	26	26	19	10	41	41	41	41	36	36	36	32	24	24	12	12	4	49	49
	fz	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.006	0.006	0.005	0.005	0.004	0.011	0.011
	RPM	23077	23077	23077	20690	20690	15120	7958	26101	26101	26101	26101	22918	22918	22918	20372	15279	15279	7639	7639	2546	25995	25995
	FEED	323	323	323	248	248	151	80	418	418	418	418	321	321	321	285	183	183	76	76	20	572	572
	Ap	0.011	0.011	0.007	0.007	0.004	0.003	0.003	0.035	0.035	0.025	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.004	0.004	0.029	0.029
41	Vc	26	26	26	23	23	17	9	36	36	36	36	32	32	32	29	21	21	11	11	4	43	43
	fz	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.005	0.004	0.004	0.004	0.004	0.003	0.009	0.009
	RPM	20690	20690	20690	18303	18303	13528	7162	22918	22918	22918	22918	20372	20372	20372	18462	13369	13369	7003	7003	2546	22812	22812
	FEED	207	207	207	183	183	108	57	275	275	275	275	244	244	244	185	107	107	56	56	15	411	411
	Ap	0.008	0.008	0.005	0.005	0.003	0.002	0.002	0.025	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.004	0.003	0.003	0.003	0.003	0.021	0.021

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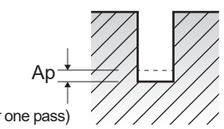

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.7	0.7	0.7	0.7	0.7	0.7	0.8	0.8	0.8	0.8	0.8	0.8
		LBS	4	5	6	8	10	12	14	16	2	4	6	8	10	12	2	3	4	5	6	8
P	1-5	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	62
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.014	0.013	0.013	0.011	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	764	638	638	480	480	327	769	769	769	641	641	641
		Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018
	6-8	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	62
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.014	0.013	0.013	0.011	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	764	638	638	480	480	327	769	769	769	641	641	641
		Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018
	9	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	58
		fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011
		RPM	23343	23343	23343	20690	15385	15385	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077
		FEED	420	420	420	331	215	215	95	95	570	417	417	327	327	216	621	621	621	508	508	508
		Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014
	10-11.1	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	62
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.014	0.013	0.013	0.011	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	764	638	638	480	480	327	769	769	769	641	641	641
		Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018
	11.2	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	58
		fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011
		RPM	23343	23343	23343	20690	15385	15385	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077
		FEED	420	420	420	331	215	215	95	95	570	417	417	327	327	216	621	621	621	508	508	508
		Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014
K	15-20	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	62
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.014	0.013	0.013	0.011	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	764	638	638	480	480	327	769	769	769	641	641	641
		Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.018
H	38.1 - 38.2	Vc	39	39	39	34	26	26	13	13	50	45	45	40	40	30	57	57	57	52	52	52
		fz	0.008	0.008	0.008	0.007	0.006	0.006	0.005	0.005	0.009	0.008	0.008	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.009	0.009
		RPM	20690	20690	20690	18038	13793	13793	6897	6897	22736	20463	20463	18189	18189	13642	22680	22680	22680	20690	20690	20690
		FEED	331	331	331	253	166	166	69	69	409	327	327	255	255	164	454	454	454	372	372	372
		Ap	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.01
	40	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	58
		fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011
		RPM	23343	23343	23343	20690	15385	15385	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077
		FEED	420	420	420	331	215	215	95	95	570	417	417	327	327	216	621	621	621	508	508	508
		Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.014
	41	Vc	39	39	39	34	26	26	13	13	50	45	45	40	40	30	57	57	57	52	52	52
		fz	0.008	0.008	0.008	0.007	0.006	0.006	0.005	0.005	0.009	0.008	0.008	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.009	0.009
		RPM	20690	20690	20690	18038	13793	13793	6897	6897	22736	20463	20463	18189	18189	13642	22680	22680	22680	20690	20690	20690
		FEED	331	331	331	253	166	166	69	69	409	327	327	255	255	164	454	454	454	372	372	372
		Ap	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.01

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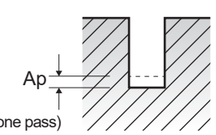

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																				
		0.8	0.8	0.8	0.8	0.8	0.9	0.9	0.9	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0
	LBS	10	12	14	16	20	6	8	10	2	3	4	5	6	7	8	10	12	14	16	18	20	22
1-5	Vc	55	55	41	41	21	63	63	56	77	77	77	77	70	70	70	70	62	62	46	46	46	23
	fz	0.011	0.011	0.01	0.01	0.009	0.013	0.013	0.012	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013
	RPM	21884	21884	16313	16313	8356	22282	22282	19806	24510	24510	24510	24510	22282	22282	22282	22282	19735	19735	14642	14642	14642	7321
	FEED	481	481	326	326	150	579	579	475	1029	1029	1029	1029	847	847	847	847	671	671	439	439	439	190
	Ap	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009
6-8	Vc	55	55	41	41	21	63	63	56	77	77	77	77	70	70	70	70	62	62	46	46	46	23
	fz	0.011	0.011	0.01	0.01	0.009	0.013	0.013	0.012	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013
	RPM	21884	21884	16313	16313	8356	22282	22282	19806	24510	24510	24510	24510	22282	22282	22282	22282	19735	19735	14642	14642	14642	7321
	FEED	481	481	326	326	150	579	579	475	1029	1029	1029	1029	847	847	847	847	671	671	439	439	439	190
	Ap	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009
9	Vc	52	52	39	39	19	59	59	53	73	73	73	73	66	66	66	66	59	59	44	44	44	22
	fz	0.009	0.009	0.008	0.008	0.007	0.01	0.01	0.009	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.015	0.015	0.013	0.013	0.013	0.011
	RPM	20690	20690	15518	15518	7560	20867	20867	18745	23237	23237	23237	23237	21008	21008	21008	21008	18780	18780	14006	14006	14006	7003
	FEED	372	372	248	248	106	417	417	337	883	883	883	883	714	714	714	714	563	563	364	364	364	154
	Ap	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007
10-11.1	Vc	55	55	41	41	21	63	63	56	77	77	77	77	70	70	70	70	62	62	46	46	46	23
	fz	0.011	0.011	0.01	0.01	0.009	0.013	0.013	0.012	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013
	RPM	21884	21884	16313	16313	8356	22282	22282	19806	24510	24510	24510	24510	22282	22282	22282	22282	19735	19735	14642	14642	14642	7321
	FEED	481	481	326	326	150	579	579	475	1029	1029	1029	1029	847	847	847	847	671	671	439	439	439	190
	Ap	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009
11.2	Vc	52	52	39	39	19	59	59	53	73	73	73	73	66	66	66	66	59	59	44	44	44	22
	fz	0.009	0.009	0.008	0.008	0.007	0.01	0.01	0.009	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.015	0.015	0.013	0.013	0.013	0.011
	RPM	20690	20690	15518	15518	7560	20867	20867	18745	23237	23237	23237	23237	21008	21008	21008	21008	18780	18780	14006	14006	14006	7003
	FEED	372	372	248	248	106	417	417	337	883	883	883	883	714	714	714	714	563	563	364	364	364	154
	Ap	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007
15-20	Vc	55	55	41	41	21	63	63	56	77	77	77	77	70	70	70	70	62	62	46	46	46	23
	fz	0.011	0.011	0.01	0.01	0.009	0.013	0.013	0.012	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.017	0.017	0.015	0.015	0.015	0.013
	RPM	21884	21884	16313	16313	8356	22282	22282	19806	24510	24510	24510	24510	22282	22282	22282	22282	19735	19735	14642	14642	14642	7321
	FEED	481	481	326	326	150	579	579	475	1029	1029	1029	1029	847	847	847	847	671	671	439	439	439	190
	Ap	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009
38.1 - 38.2	Vc	46	46	34	34	17	52	52	46	64	64	64	64	58	58	58	58	52	52	39	39	39	19
	fz	0.008	0.008	0.007	0.007	0.006	0.009	0.009	0.008	0.016	0.016	0.016	0.016	0.015	0.015	0.015	0.015	0.013	0.013	0.011	0.011	0.011	0.01
	RPM	18303	18303	13528	13528	6764	18391	18391	16269	20372	20372	20372	20372	18462	18462	18462	18462	16552	16552	12414	12414	12414	6048
	FEED	293	293	189	189	81	331	331	260	652	652	652	652	554	554	554	554	430	430	273	273	273	121
	Ap	0.01	0.006	0.004	0.004	0.004	0.018	0.011	0.011	0.05	0.05	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005
40	Vc	52	52	39	39	19	59	59	53	73	73	73	73	66	66	66	66	59	59	44	44	44	22
	fz	0.009	0.009	0.008	0.008	0.007	0.01	0.01	0.009	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.015	0.015	0.013	0.013	0.013	0.011
	RPM	20690	20690	15518	15518	7560	20867	20867	18745	23237	23237	23237	23237	21008	21008	21008	21008	18780	18780	14006	14006	14006	7003
	FEED	372	372	248	248	106	417	417	337	883	883	883	883	714	714	714	714	563	563	364	364	364	154
	Ap	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007
41	Vc	46	46	34	34	17	52	52	46	64	64	64	64	58	58	58	58	52	52	39	39	39	19
	fz	0.008	0.008	0.007	0.007	0.006	0.009	0.009	0.008	0.016	0.016	0.016	0.016	0.015	0.015	0.015	0.015	0.013	0.013	0.011	0.011	0.011	0.01
	RPM	18303	18303	13528	13528	6764	18391	18391	16269	20372	20372	20372	20372	18462	18462	18462	18462	16552	16552	12414	12414	12414	6048
	FEED	293	293	189	189	81	331	331	260	652	652	652	652	554	554	554	554	430	430	273	273	273	121
	Ap	0.01	0.006	0.004	0.004	0.004	0.018	0.011	0.011	0.05	0.05	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005

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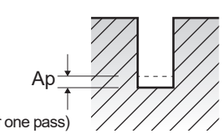

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.4	1.4	1.4	1.4	1.4	1.4
		LBS	26	30	40	50	4	6	8	10	12	14	16	20	26	30	6	8	10	14	16	20
P	1-5	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	526
		Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019
	6-8	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	526
		Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019
	9	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64	64
		fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013	0.013
		RPM	7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	14551
		FEED	154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	378
		Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015
	10-11.1	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	526
		Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019
	11.2	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64	64
		fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013	0.013
		RPM	7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	14551
		FEED	154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	378
		Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015
K	15-20	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	526
		Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019
H	38.1 - 38.2	Vc	19	19	6	6	69	69	62	62	62	55	55	41	21	21	70	63	63	63	56	56
		fz	0.01	0.01	0.009	0.009	0.013	0.013	0.012	0.012	0.012	0.011	0.011	0.009	0.008	0.008	0.013	0.012	0.012	0.012	0.011	0.011
		RPM	6048	6048	1910	1910	18303	18303	16446	16446	16446	14589	14589	10876	5570	5570	15915	14324	14324	14324	12732	12732
		FEED	121	121	34	34	476	476	395	395	395	321	321	196	89	89	414	344	344	344	280	280
		Ap	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018	0.011
	40	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64	64
		fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013	0.013
		RPM	7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	14551
		FEED	154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	378
		Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015
	41	Vc	19	19	6	6	69	69	62	62	62	55	55	41	21	21	70	63	63	63	56	56
		fz	0.01	0.01	0.009	0.009	0.013	0.013	0.012	0.012	0.012	0.011	0.011	0.009	0.008	0.008	0.013	0.012	0.012	0.012	0.011	0.011
		RPM	6048	6048	1910	1910	18303	18303	16446	16446	16446	14589	14589	10876	5570	5570	15915	14324	14324	14324	12732	12732
		FEED	121	121	34	34	476	476	395	395	395	321	321	196	89	89	414	344	344	344	280	280
		Ap	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018	0.011

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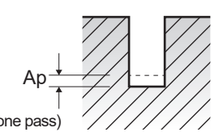

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																				
		1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.6	1.6	1.6	1.6	1.6	1.8	1.8	1.8
	LBS	4	5	6	7	8	10	12	14	16	18	20	22	26	30	8	10	12	16	20	8	10	12
1-5	Vc	90	90	90	90	81	81	81	81	72	72	72	72	54	54	89	81	81	81	72	101	91	91
	fz	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.016	0.016	0.024	0.021	0.021	0.021	0.019	0.024	0.021	0.021
	RPM	19099	19099	19099	19099	17189	17189	17189	17189	15279	15279	15279	15279	11459	11459	17706	16114	16114	16114	14324	17861	16092	16092
	FEED	917	917	917	917	722	722	722	722	581	581	581	581	367	367	850	677	677	677	544	857	676	676
	Ap	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065
6-8	Vc	90	90	90	90	81	81	81	81	72	72	72	72	54	54	89	81	81	81	72	101	91	91
	fz	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.016	0.016	0.024	0.021	0.021	0.021	0.019	0.024	0.021	0.021
	RPM	19099	19099	19099	19099	17189	17189	17189	17189	15279	15279	15279	15279	11459	11459	17706	16114	16114	16114	14324	17861	16092	16092
	FEED	917	917	917	917	722	722	722	722	581	581	581	581	367	367	850	677	677	677	544	857	676	676
	Ap	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065
9	Vc	85	85	85	85	77	77	77	77	68	68	68	68	51	51	84	76	76	76	68	95	86	86
	fz	0.018	0.018	0.018	0.018	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012	0.012	0.019	0.018	0.018	0.018	0.016	0.019	0.018	0.018
	RPM	18038	18038	18038	18038	16340	16340	16340	16340	14430	14430	14430	14430	10823	10823	16711	15120	15120	15120	13528	16800	15208	15208
	FEED	649	649	649	649	523	523	523	523	404	404	404	404	260	260	635	544	544	544	433	638	547	547
	Ap	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05
10-11.1	Vc	90	90	90	90	81	81	81	81	72	72	72	72	54	54	89	81	81	81	72	101	91	91
	fz	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.016	0.016	0.024	0.021	0.021	0.021	0.019	0.024	0.021	0.021
	RPM	19099	19099	19099	19099	17189	17189	17189	17189	15279	15279	15279	15279	11459	11459	17706	16114	16114	16114	14324	17861	16092	16092
	FEED	917	917	917	917	722	722	722	722	581	581	581	581	367	367	850	677	677	677	544	857	676	676
	Ap	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065
11.2	Vc	85	85	85	85	77	77	77	77	68	68	68	68	51	51	84	76	76	76	68	95	86	86
	fz	0.018	0.018	0.018	0.018	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012	0.012	0.019	0.018	0.018	0.018	0.016	0.019	0.018	0.018
	RPM	18038	18038	18038	18038	16340	16340	16340	16340	14430	14430	14430	14430	10823	10823	16711	15120	15120	15120	13528	16800	15208	15208
	FEED	649	649	649	649	523	523	523	523	404	404	404	404	260	260	635	544	544	544	433	638	547	547
	Ap	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05
15-20	Vc	90	90	90	90	81	81	81	81	72	72	72	72	54	54	89	81	81	81	72	101	91	91
	fz	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.019	0.019	0.019	0.019	0.016	0.016	0.024	0.021	0.021	0.021	0.019	0.024	0.021	0.021
	RPM	19099	19099	19099	19099	17189	17189	17189	17189	15279	15279	15279	15279	11459	11459	17706	16114	16114	16114	14324	17861	16092	16092
	FEED	917	917	917	917	722	722	722	722	581	581	581	581	367	367	850	677	677	677	544	857	676	676
	Ap	0.135	0.095	0.095	0.095	0.054	0.054	0.054	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065
38.1 - 38.2	Vc	75	75	75	75	68	68	68	68	60	60	60	60	45	45	74	67	67	67	60	84	75	75
	fz	0.015	0.015	0.015	0.015	0.013	0.013	0.013	0.013	0.012	0.012	0.012	0.012	0.01	0.01	0.017	0.015	0.015	0.015	0.013	0.017	0.015	0.015
	RPM	15915	15915	15915	15915	14430	14430	14430	14430	12732	12732	12732	12732	9549	9549	14722	13329	13329	13329	11937	14854	13263	13263
	FEED	477	477	477	477	375	375	375	375	306	306	306	306	191	191	501	400	400	400	310	505	398	398
	Ap	0.075	0.053	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.019	0.011	0.011	0.008	0.008	0.056	0.032	0.032	0.02	0.02	0.063	0.036	0.036
40	Vc	85	85	85	85	77	77	77	77	68	68	68	68	51	51	84	76	76	76	68	95	86	86
	fz	0.018	0.018	0.018	0.018	0.016	0.016	0.016	0.016	0.014	0.014	0.014	0.014	0.012	0.012	0.019	0.018	0.018	0.018	0.016	0.019	0.018	0.018
	RPM	18038	18038	18038	18038	16340	16340	16340	16340	14430	14430	14430	14430	10823	10823	16711	15120	15120	15120	13528	16800	15208	15208
	FEED	649	649	649	649	523	523	523	523	404	404	404	404	260	260	635	544	544	544	433	638	547	547
	Ap	0.105	0.074	0.074	0.074	0.042	0.042	0.042	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05
41	Vc	75	75	75	75	68	68	68	68	60	60	60	60	45	45	74	67	67	67	60	84	75	75
	fz	0.015	0.015	0.015	0.015	0.013	0.013	0.013	0.013	0.012	0.012	0.012	0.012	0.01	0.01	0.017	0.015	0.015	0.015	0.013	0.017	0.015	0.015
	RPM	15915	15915	15915	15915	14430	14430	14430	14430	12732	12732	12732	12732	9549	9549	14722	13329	13329	13329	11937	14854	13263	13263
	FEED	477	477	477	477	375	375	375	375	306	306	306	306	191	191	501	400	400	400	310	505	398	398
	Ap	0.075	0.053	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.019	0.011	0.011	0.008	0.008	0.056	0.032	0.032	0.02	0.02	0.063	0.036	0.036

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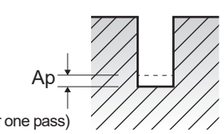

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			1.8	1.8	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.5	2.5
		LBS	16	20	6	8	10	12	14	16	18	20	22	26	30	35	40	45	50	60	8	10
P	1-5	Vc	91	81	90	90	90	81	81	81	81	81	72	72	72	54	54	27	27	27	97	97
		fz	0.021	0.019	0.028	0.028	0.028	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.017	0.017	0.017	0.039	0.039
		RPM	16092	14324	14324	14324	14324	12892	12892	12892	12892	12892	11459	11459	11459	8594	8594	4297	4297	4297	12350	12350
		FEED	676	544	802	802	802	670	670	670	670	670	527	527	527	344	344	146	146	146	963	963
		Ap	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158
	6-8	Vc	91	81	90	90	90	81	81	81	81	81	72	72	72	54	54	27	27	27	97	97
		fz	0.021	0.019	0.028	0.028	0.028	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.017	0.017	0.017	0.039	0.039
		RPM	16092	14324	14324	14324	14324	12892	12892	12892	12892	12892	11459	11459	11459	8594	8594	4297	4297	4297	12350	12350
		FEED	676	544	802	802	802	670	670	670	670	670	527	527	527	344	344	146	146	146	963	963
		Ap	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158
	9	Vc	86	76	85	85	85	77	77	77	77	77	68	68	68	51	51	26	26	26	91	91
		fz	0.018	0.016	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.02	0.018	0.018	0.018	0.016	0.016	0.013	0.013	0.013	0.029	0.029
		RPM	15208	13440	13528	13528	13528	12255	12255	12255	12255	12255	10823	10823	10823	8117	8117	4138	4138	4138	11586	11586
		FEED	547	430	622	622	622	490	490	490	490	490	390	390	390	260	260	108	108	108	672	672
		Ap	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123
	10-11.1	Vc	91	81	90	90	90	81	81	81	81	81	72	72	72	54	54	27	27	27	97	97
		fz	0.021	0.019	0.028	0.028	0.028	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.017	0.017	0.017	0.039	0.039
		RPM	16092	14324	14324	14324	14324	12892	12892	12892	12892	12892	11459	11459	11459	8594	8594	4297	4297	4297	12350	12350
		FEED	676	544	802	802	802	670	670	670	670	670	527	527	527	344	344	146	146	146	963	963
		Ap	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158
	11.2	Vc	86	76	85	85	85	77	77	77	77	77	68	68	68	51	51	26	26	26	91	91
		fz	0.018	0.016	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.02	0.018	0.018	0.018	0.016	0.016	0.013	0.013	0.013	0.029	0.029
		RPM	15208	13440	13528	13528	13528	12255	12255	12255	12255	12255	10823	10823	10823	8117	8117	4138	4138	4138	11586	11586
		FEED	547	430	622	622	622	490	490	490	490	490	390	390	390	260	260	108	108	108	672	672
		Ap	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123
K	15-20	Vc	91	81	90	90	90	81	81	81	81	81	72	72	72	54	54	27	27	27	97	97
		fz	0.021	0.019	0.028	0.028	0.028	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.017	0.017	0.017	0.039	0.039
		RPM	16092	14324	14324	14324	14324	12892	12892	12892	12892	12892	11459	11459	11459	8594	8594	4297	4297	4297	12350	12350
		FEED	676	544	802	802	802	670	670	670	670	670	527	527	527	344	344	146	146	146	963	963
		Ap	0.041	0.041	0.18	0.126	0.126	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158
H	38.1 - 38.2	Vc	75	67	75	75	75	68	68	68	68	68	60	60	60	45	45	23	23	23	81	81
		fz	0.015	0.013	0.02	0.02	0.02	0.018	0.018	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.012	0.012	0.012	0.025	0.025
		RPM	13263	11848	11937	11937	11937	10823	10823	10823	10823	10823	9549	9549	9549	7162	7162	3661	3661	3661	10313	10313
		FEED	398	308	477	477	477	390	390	390	390	390	306	306	306	201	201	88	88	88	516	516
		Ap	0.023	0.023	0.1	0.07	0.07	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01	0.01	0.088	0.088
	40	Vc	86	76	85	85	85	77	77	77	77	77	68	68	68	51	51	26	26	26	91	91
		fz	0.018	0.016	0.023	0.023	0.023	0.02	0.02	0.02	0.02	0.02	0.018	0.018	0.018	0.016	0.016	0.013	0.013	0.013	0.029	0.029
		RPM	15208	13440	13528	13528	13528	12255	12255	12255	12255	12255	10823	10823	10823	8117	8117	4138	4138	4138	11586	11586
		FEED	547	430	622	622	622	490	490	490	490	490	390	390	390	260	260	108	108	108	672	672
		Ap	0.032	0.032	0.14	0.098	0.098	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123
	41	Vc	75	67	75	75	75	68	68	68	68	68	60	60	60	45	45	23	23	23	81	81
		fz	0.015	0.013	0.02	0.02	0.02	0.018	0.018	0.018	0.018	0.018	0.016	0.016	0.016	0.014	0.014	0.012	0.012	0.012	0.025	0.025
		RPM	13263	11848	11937	11937	11937	10823	10823	10823	10823	10823	9549	9549	9549	7162	7162	3661	3661	3661	10313	10313
		FEED	398	308	477	477	477	390	390	390	390	390	306	306	306	201	201	88	88	88	516	516
		Ap	0.023	0.023	0.1	0.07	0.07	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01	0.01	0.088	0.088

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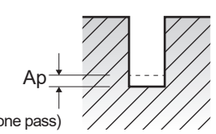

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																				
		2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	LBS	12	14	16	18	20	22	26	30	35	40	45	50	6	8	10	12	14	16	18	20	22	26
1-5	Vc	97	87	87	87	87	87	77	77	77	58	58	58	103	103	103	103	103	92	92	92	92	92
	fz	0.039	0.035	0.035	0.035	0.035	0.035	0.032	0.032	0.032	0.027	0.027	0.027	0.039	0.039	0.039	0.039	0.039	0.035	0.035	0.035	0.035	0.035
	RPM	12350	11077	11077	11077	11077	11077	9804	9804	9804	7385	7385	7385	10929	10929	10929	10929	10929	9762	9762	9762	9762	9762
	FEED	963	775	775	775	775	775	627	627	627	399	399	399	852	852	852	852	852	683	683	683	683	683
	Ap	0.158	0.09	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
6-8	Vc	97	87	87	87	87	87	77	77	77	58	58	58	103	103	103	103	103	92	92	92	92	92
	fz	0.039	0.035	0.035	0.035	0.035	0.035	0.032	0.032	0.032	0.027	0.027	0.027	0.039	0.039	0.039	0.039	0.039	0.035	0.035	0.035	0.035	0.035
	RPM	12350	11077	11077	11077	11077	11077	9804	9804	9804	7385	7385	7385	10929	10929	10929	10929	10929	9762	9762	9762	9762	9762
	FEED	963	775	775	775	775	775	627	627	627	399	399	399	852	852	852	852	852	683	683	683	683	683
	Ap	0.158	0.09	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
9	Vc	91	82	82	82	82	82	73	73	73	55	55	55	97	97	97	97	97	87	87	87	87	87
	fz	0.029	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.02	0.029	0.029	0.029	0.029	0.029	0.026	0.026	0.026	0.026	0.026
	RPM	11586	10441	10441	10441	10441	10441	9295	9295	9295	7003	7003	7003	10292	10292	10292	10292	10292	9231	9231	9231	9231	9231
	FEED	672	543	543	543	543	543	428	428	428	280	280	280	597	597	597	597	597	480	480	480	480	480
	Ap	0.123	0.07	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
10-11.1	Vc	97	87	87	87	87	87	77	77	77	58	58	58	103	103	103	103	103	92	92	92	92	92
	fz	0.039	0.035	0.035	0.035	0.035	0.035	0.032	0.032	0.032	0.027	0.027	0.027	0.039	0.039	0.039	0.039	0.039	0.035	0.035	0.035	0.035	0.035
	RPM	12350	11077	11077	11077	11077	11077	9804	9804	9804	7385	7385	7385	10929	10929	10929	10929	10929	9762	9762	9762	9762	9762
	FEED	963	775	775	775	775	775	627	627	627	399	399	399	852	852	852	852	852	683	683	683	683	683
	Ap	0.158	0.09	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
11.2	Vc	91	82	82	82	82	82	73	73	73	55	55	55	97	97	97	97	97	87	87	87	87	87
	fz	0.029	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.02	0.029	0.029	0.029	0.029	0.029	0.026	0.026	0.026	0.026	0.026
	RPM	11586	10441	10441	10441	10441	10441	9295	9295	9295	7003	7003	7003	10292	10292	10292	10292	10292	9231	9231	9231	9231	9231
	FEED	672	543	543	543	543	543	428	428	428	280	280	280	597	597	597	597	597	480	480	480	480	480
	Ap	0.123	0.07	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
15-20	Vc	97	87	87	87	87	87	77	77	77	58	58	58	103	103	103	103	103	92	92	92	92	92
	fz	0.039	0.035	0.035	0.035	0.035	0.035	0.032	0.032	0.032	0.027	0.027	0.027	0.039	0.039	0.039	0.039	0.039	0.035	0.035	0.035	0.035	0.035
	RPM	12350	11077	11077	11077	11077	11077	9804	9804	9804	7385	7385	7385	10929	10929	10929	10929	10929	9762	9762	9762	9762	9762
	FEED	963	775	775	775	775	775	627	627	627	399	399	399	852	852	852	852	852	683	683	683	683	683
	Ap	0.158	0.09	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
38.1 - 38.2	Vc	81	73	73	73	73	73	65	65	65	49	49	49	62	62	62	62	62	56	56	56	56	56
	fz	0.025	0.022	0.022	0.022	0.022	0.022	0.02	0.02	0.02	0.017	0.017	0.017	0.034	0.034	0.034	0.034	0.034	0.031	0.031	0.031	0.031	0.031
	RPM	10313	9295	9295	9295	9295	9295	8276	8276	8276	6239	6239	6239	6578	6578	6578	6578	6578	5942	5942	5942	5942	5942
	FEED	516	409	409	409	409	409	331	331	331	212	212	212	447	447	447	447	447	368	368	368	368	368
	Ap	0.088	0.05	0.05	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105	0.06	0.06	0.06	0.06	0.038
40	Vc	91	82	82	82	82	82	73	73	73	55	55	55	97	97	97	97	97	87	87	87	87	87
	fz	0.029	0.026	0.026	0.026	0.026	0.026	0.023	0.023	0.023	0.02	0.02	0.02	0.029	0.029	0.029	0.029	0.029	0.026	0.026	0.026	0.026	0.026
	RPM	11586	10441	10441	10441	10441	10441	9295	9295	9295	7003	7003	7003	10292	10292	10292	10292	10292	9231	9231	9231	9231	9231
	FEED	672	543	543	543	543	543	428	428	428	280	280	280	597	597	597	597	597	480	480	480	480	480
	Ap	0.123	0.07	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
41	Vc	81	73	73	73	73	73	65	65	65	49	49	49	62	62	62	62	62	56	56	56	56	56
	fz	0.025	0.022	0.022	0.022	0.022	0.022	0.02	0.02	0.02	0.017	0.017	0.017	0.034	0.034	0.034	0.034	0.034	0.031	0.031	0.031	0.031	0.031
	RPM	10313	9295	9295	9295	9295	9295	8276	8276	8276	6239	6239	6239	6578	6578	6578	6578	6578	5942	5942	5942	5942	5942
	FEED	516	409	409	409	409	409	331	331	331	212	212	212	447	447	447	447	447	368	368	368	368	368
	Ap	0.088	0.05	0.05	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105	0.06	0.06	0.06	0.06	0.038

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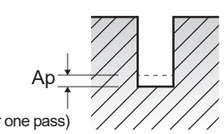

(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			3.0	3.0	3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
		LBS	30	35	40	45	50	60	8	10	12	14	16	18	20	22	26	30	35	40	45	50
P	1-5	Vc	92	82	82	82	62	62	101	101	101	101	101	101	101	90	90	90	90	90	80	80
		fz	0.035	0.032	0.032	0.032	0.028	0.028	0.081	0.081	0.081	0.081	0.081	0.081	0.081	0.073	0.073	0.073	0.073	0.073	0.065	0.065
		RPM	9762	8700	8700	8700	6578	6578	8037	8037	8037	8037	8037	8037	8037	7162	7162	7162	7162	7162	6366	6366
		FEED	683	557	557	557	368	368	1302	1302	1302	1302	1302	1302	1302	1046	1046	1046	1046	1046	828	828
		Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09	0.09	0.09	0.09
	6-8	Vc	92	82	82	82	62	62	101	101	101	101	101	101	101	90	90	90	90	90	80	80
		fz	0.035	0.032	0.032	0.032	0.028	0.028	0.081	0.081	0.081	0.081	0.081	0.081	0.081	0.073	0.073	0.073	0.073	0.073	0.065	0.065
		RPM	9762	8700	8700	8700	6578	6578	8037	8037	8037	8037	8037	8037	8037	7162	7162	7162	7162	7162	6366	6366
		FEED	683	557	557	557	368	368	1302	1302	1302	1302	1302	1302	1302	1046	1046	1046	1046	1046	828	828
		Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09	0.09	0.09	0.09
	9	Vc	87	78	78	78	58	58	96	96	96	96	96	96	96	86	86	86	86	86	76	76
		fz	0.026	0.023	0.023	0.023	0.021	0.021	0.076	0.076	0.076	0.076	0.076	0.076	0.076	0.069	0.069	0.069	0.069	0.069	0.061	0.061
		RPM	9231	8276	8276	8276	6154	6154	7639	7639	7639	7639	7639	7639	7639	6844	6844	6844	6844	6844	6048	6048
		FEED	480	381	381	381	258	258	1161	1161	1161	1161	1161	1161	1161	944	944	944	944	944	738	738
		Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07	0.07	0.07	0.07
	10-11.1	Vc	92	82	82	82	62	62	101	101	101	101	101	101	101	90	90	90	90	90	80	80
		fz	0.035	0.032	0.032	0.032	0.028	0.028	0.081	0.081	0.081	0.081	0.081	0.081	0.081	0.073	0.073	0.073	0.073	0.073	0.065	0.065
		RPM	9762	8700	8700	8700	6578	6578	8037	8037	8037	8037	8037	8037	8037	7162	7162	7162	7162	7162	6366	6366
		FEED	683	557	557	557	368	368	1302	1302	1302	1302	1302	1302	1302	1046	1046	1046	1046	1046	828	828
		Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09	0.09	0.09	0.09
	11.2	Vc	87	78	78	78	58	58	96	96	96	96	96	96	96	86	86	86	86	86	76	76
		fz	0.026	0.023	0.023	0.023	0.021	0.021	0.076	0.076	0.076	0.076	0.076	0.076	0.076	0.069	0.069	0.069	0.069	0.069	0.061	0.061
		RPM	9231	8276	8276	8276	6154	6154	7639	7639	7639	7639	7639	7639	7639	6844	6844	6844	6844	6844	6048	6048
		FEED	480	381	381	381	258	258	1161	1161	1161	1161	1161	1161	1161	944	944	944	944	944	738	738
		Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07	0.07	0.07	0.07
K	15-20	Vc	92	82	82	82	62	62	101	101	101	101	101	101	101	90	90	90	90	90	80	80
		fz	0.035	0.032	0.032	0.032	0.028	0.028	0.081	0.081	0.081	0.081	0.081	0.081	0.081	0.073	0.073	0.073	0.073	0.073	0.065	0.065
		RPM	9762	8700	8700	8700	6578	6578	8037	8037	8037	8037	8037	8037	8037	7162	7162	7162	7162	7162	6366	6366
		FEED	683	557	557	557	368	368	1302	1302	1302	1302	1302	1302	1302	1046	1046	1046	1046	1046	828	828
		Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09	0.09	0.09	0.09
H	38.1 - 38.2	Vc	56	50	50	50	37	37	84	84	84	84	84	84	84	76	76	76	76	76	67	67
		fz	0.031	0.027	0.027	0.027	0.024	0.024	0.057	0.057	0.057	0.057	0.057	0.057	0.057	0.052	0.052	0.052	0.052	0.052	0.046	0.046
		RPM	5942	5305	5305	5305	3926	3926	6685	6685	6685	6685	6685	6685	6685	6048	6048	6048	6048	6048	5332	5332
		FEED	368	286	286	286	188	188	762	762	762	762	762	762	762	629	629	629	629	629	491	491
		Ap	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08	0.08	0.08	0.05	0.05	0.05	0.05
	40	Vc	87	78	78	78	58	58	96	96	96	96	96	96	96	86	86	86	86	86	76	76
		fz	0.026	0.023	0.023	0.023	0.021	0.021	0.076	0.076	0.076	0.076	0.076	0.076	0.076	0.069	0.069	0.069	0.069	0.069	0.061	0.061
		RPM	9231	8276	8276	8276	6154	6154	7639	7639	7639	7639	7639	7639	7639	6844	6844	6844	6844	6844	6048	6048
		FEED	480	381	381	381	258	258	1161	1161	1161	1161	1161	1161	1161	944	944	944	944	944	738	738
		Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07	0.07	0.07	0.07
	41	Vc	56	50	50	50	37	37	84	84	84	84	84	84	84	76	76	76	76	76	67	67
		fz	0.031	0.027	0.027	0.027	0.024	0.024	0.057	0.057	0.057	0.057	0.057	0.057	0.057	0.052	0.052	0.052	0.052	0.052	0.046	0.046
		RPM	5942	5305	5305	5305	3926	3926	6685	6685	6685	6685	6685	6685	6685	6048	6048	6048	6048	6048	5332	5332
		FEED	368	286	286	286	188	188	762	762	762	762	762	762	762	629	629	629	629	629	491	491
		Ap	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08	0.08	0.08	0.05	0.05	0.05	0.05

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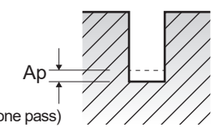
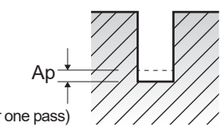


(Depth of cut per one pass)

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																					
		4.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	6.0	6.0	6.0	6.0	8.0	8.0	8.0	10.0	10.0	10.0	12.0	12.0	12.0
	LBS	60	16	20	26	30	35	40	50	60	15	20	30	32	25	30	42	30	35	45	35	40	50
1-5	Vc	80	101	101	90	90	90	90	90	80	100	100	100	90	101	101	90	101	101	101	100	100	100
	fz	0.065	0.09	0.09	0.081	0.081	0.081	0.081	0.081	0.072	0.1	0.1	0.1	0.09	0.119	0.119	0.107	0.141	0.141	0.141	0.151	0.151	0.151
	RPM	6366	6430	6430	5730	5730	5730	5730	5730	5093	5305	5305	5305	4775	4019	4019	3581	3215	3215	3215	2653	2653	2653
	FEED	828	1157	1157	928	928	928	928	928	733	1061	1061	1061	859	956	956	766	907	907	907	801	801	801
	Ap	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
6-8	Vc	80	101	101	90	90	90	90	90	80	100	100	100	90	101	101	90	101	101	101	100	100	100
	fz	0.065	0.09	0.09	0.081	0.081	0.081	0.081	0.081	0.072	0.1	0.1	0.1	0.09	0.119	0.119	0.107	0.141	0.141	0.141	0.151	0.151	0.151
	RPM	6366	6430	6430	5730	5730	5730	5730	5730	5093	5305	5305	5305	4775	4019	4019	3581	3215	3215	3215	2653	2653	2653
	FEED	828	1157	1157	928	928	928	928	928	733	1061	1061	1061	859	956	956	766	907	907	907	801	801	801
	Ap	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
9	Vc	76	96	96	86	86	86	86	86	77	94	94	94	85	96	96	85	96	96	96	95	95	95
	fz	0.061	0.074	0.074	0.066	0.066	0.066	0.066	0.066	0.059	0.082	0.082	0.082	0.074	0.099	0.099	0.089	0.111	0.111	0.111	0.119	0.119	0.119
	RPM	6048	6112	6112	5475	5475	5475	5475	5475	4902	4987	4987	4987	4509	3820	3820	3382	3056	3056	3056	2520	2520	2520
	FEED	738	905	905	723	723	723	723	723	578	818	818	818	667	756	756	602	678	678	678	600	600	600
	Ap	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
10-11.1	Vc	80	101	101	90	90	90	90	90	80	100	100	100	90	101	101	90	101	101	101	100	100	100
	fz	0.065	0.09	0.09	0.081	0.081	0.081	0.081	0.081	0.072	0.1	0.1	0.1	0.09	0.119	0.119	0.107	0.141	0.141	0.141	0.151	0.151	0.151
	RPM	6366	6430	6430	5730	5730	5730	5730	5730	5093	5305	5305	5305	4775	4019	4019	3581	3215	3215	3215	2653	2653	2653
	FEED	828	1157	1157	928	928	928	928	928	733	1061	1061	1061	859	956	956	766	907	907	907	801	801	801
	Ap	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
11.2	Vc	76	96	96	86	86	86	86	86	77	94	94	94	85	96	96	85	96	96	96	95	95	95
	fz	0.061	0.074	0.074	0.066	0.066	0.066	0.066	0.066	0.059	0.082	0.082	0.082	0.074	0.099	0.099	0.089	0.111	0.111	0.111	0.119	0.119	0.119
	RPM	6048	6112	6112	5475	5475	5475	5475	5475	4902	4987	4987	4987	4509	3820	3820	3382	3056	3056	3056	2520	2520	2520
	FEED	738	905	905	723	723	723	723	723	578	818	818	818	667	756	756	602	678	678	678	600	600	600
	Ap	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
15-20	Vc	80	101	101	90	90	90	90	90	80	100	100	100	90	101	101	90	101	101	101	100	100	100
	fz	0.065	0.09	0.09	0.081	0.081	0.081	0.081	0.081	0.072	0.1	0.1	0.1	0.09	0.119	0.119	0.107	0.141	0.141	0.141	0.151	0.151	0.151
	RPM	6366	6430	6430	5730	5730	5730	5730	5730	5093	5305	5305	5305	4775	4019	4019	3581	3215	3215	3215	2653	2653	2653
	FEED	828	1157	1157	928	928	928	928	928	733	1061	1061	1061	859	956	956	766	907	907	907	801	801	801
	Ap	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
38.1 - 38.2	Vc	67	85	85	76	76	76	76	76	68	83	83	83	75	83	83	74	83	83	83	82	82	82
	fz	0.046	0.056	0.056	0.05	0.05	0.05	0.05	0.05	0.045	0.063	0.063	0.063	0.056	0.076	0.076	0.069	0.076	0.076	0.076	0.08	0.08	0.08
	RPM	5332	5411	5411	4838	4838	4838	4838	4838	4329	4403	4403	4403	3979	3302	3302	2944	2642	2642	2642	2175	2175	2175
	FEED	491	606	606	484	484	484	484	484	390	555	555	555	446	502	502	406	402	402	402	348	348	348
	Ap	0.03	0.175	0.175	0.1	0.1	0.1	0.1	0.063	0.063	0.3	0.21	0.21	0.12	0.28	0.28	0.16	0.5	0.35	0.35	0.6	0.42	0.42
40	Vc	76	96	96	86	86	86	86	86	77	94	94	94	85	96	96	85	96	96	96	95	95	95
	fz	0.061	0.074	0.074	0.066	0.066	0.066	0.066	0.066	0.059	0.082	0.082	0.082	0.074	0.099	0.099	0.089	0.111	0.111	0.111	0.119	0.119	0.119
	RPM	6048	6112	6112	5475	5475	5475	5475	5475	4902	4987	4987	4987	4509	3820	3820	3382	3056	3056	3056	2520	2520	2520
	FEED	738	905	905	723	723	723	723	723	578	818	818	818	667	756	756	602	678	678	678	600	600	600
	Ap	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
41	Vc	67	85	85	76	76	76	76	76	68	83	83	83	75	83	83	74	83	83	83	82	82	82
	fz	0.046	0.056	0.056	0.05	0.05	0.05	0.05	0.05	0.045	0.063	0.063	0.063	0.056	0.076	0.076	0.069	0.076	0.076	0.076	0.08	0.08	0.08
	RPM	5332	5411	5411	4838	4838	4838	4838	4838	4329	4403	4403	4403	3979	3302	3302	2944	2642	2642	2642	2175	2175	2175
	FEED	491	606	606	484	484	484	484	484	390	555	555	555	446	502	502	406	402	402	402	348	348	348
	Ap	0.03	0.175	0.175	0.1	0.1	0.1	0.1	0.063	0.063	0.3	0.21	0.21	0.12	0.28	0.28	0.16	0.5	0.35	0.35	0.6	0.42	0.42



(Depth of cut per one pass)

SEME36, SEME71 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 0.8	0.9	1.0	1.2	1.5	2.0	2.5	3.0
P	1-5	Non-alloy steel	0.05D	1.0D	Vc	79	83	84	85	88	91	101	105
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	31433	29355	26738	22547	18674	14483	12860	11141
					FEED	251	235	214	271	299	290	309	357
	6-8	Low alloy steel	0.05D	1.0D	Vc	79	83	84	85	88	91	101	105
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	31433	29355	26738	22547	18674	14483	12860	11141
					FEED	251	235	214	271	299	290	309	357
	9		0.05D	1.0D	Vc	47	50	51	51	53	59	64	66
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	18701	17684	16234	13528	11247	9390	8149	7003
					FEED	150	141	130	162	180	188	196	224
	10-11.1	High alloyed steel, and tool steel	0.05D	1.0D	Vc	79	83	84	85	88	91	101	105
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	31433	29355	26738	22547	18674	14483	12860	11141
					FEED	251	235	214	271	299	290	309	357
	11.2		0.05D	1.0D	Vc	47	50	51	51	53	59	64	66
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	18701	17684	16234	13528	11247	9390	8149	7003
					FEED	150	141	130	162	180	188	196	224
M	14.1	Stainless steel	0.05D	1.0D	Vc	39	41	42	42	44	50	54	54
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	15518	14501	13369	11141	9337	7958	6875	5730
					FEED	124	116	107	134	149	159	165	183
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1.0D	Vc	79	83	84	85	88	91	101	105
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	31433	29355	26738	22547	18674	14483	12860	11141
					FEED	251	235	214	271	299	290	309	357
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	Vc	31	33	34	34	35	40	41	40
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.004
					RPM	12335	11671	10823	9019	7427	6366	5220	4244
					FEED	49	47	43	36	59	51	63	68
	40	Chilled Cast Iron	0.05D	1.0D	Vc	47	50	51	51	53	59	64	66
					fz	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.008
					RPM	18701	17684	16234	13528	11247	9390	8149	7003
					FEED	150	141	130	162	180	188	196	224
	41	Hardened Cast Iron	0.05D	1.0D	Vc	31	33	34	34	35	40	41	40
					fz	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.004
					RPM	12335	11671	10823	9019	7427	6366	5220	4244
					FEED	49	47	43	36	59	51	63	68

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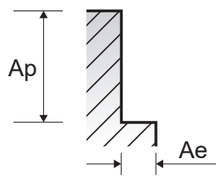

SEME36, SEME71 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0
1-5	Vc	113	119	122	124	128	131	133	134	134	132	132	132
	fz	0.011	0.016	0.018	0.02	0.022	0.025	0.027	0.03	0.032	0.035	0.036	0.037
	RPM	10277	9470	8630	7894	7408	6950	6513	6093	5687	5252	4943	4669
	FEED	452	606	621	632	652	695	703	731	728	735	712	691
6-8	Vc	113	119	122	124	128	131	133	134	134	132	132	132
	fz	0.011	0.016	0.018	0.02	0.022	0.025	0.027	0.03	0.032	0.035	0.036	0.037
	RPM	10277	9470	8630	7894	7408	6950	6513	6093	5687	5252	4943	4669
	FEED	452	606	621	632	652	695	703	731	728	735	712	691
9	Vc	70	73	74	74	77	79	80	81	80	79	80	80
	fz	0.011	0.016	0.018	0.02	0.023	0.026	0.027	0.028	0.03	0.032	0.032	0.031
	RPM	6366	5809	5234	4711	4456	4191	3918	3683	3395	3143	2996	2829
	FEED	280	372	377	377	410	436	423	413	407	402	383	351
10-11.1	Vc	113	119	122	124	128	131	133	134	134	132	132	132
	fz	0.011	0.016	0.018	0.02	0.022	0.025	0.027	0.03	0.032	0.035	0.036	0.037
	RPM	10277	9470	8630	7894	7408	6950	6513	6093	5687	5252	4943	4669
	FEED	452	606	621	632	652	695	703	731	728	735	712	691
11.2	Vc	70	73	74	74	77	79	80	81	80	79	80	80
	fz	0.011	0.016	0.018	0.02	0.023	0.026	0.027	0.028	0.03	0.032	0.032	0.031
	RPM	6366	5809	5234	4711	4456	4191	3918	3683	3395	3143	2996	2829
	FEED	280	372	377	377	410	436	423	413	407	402	383	351
14.1	Vc	58	61	62	62	65	67	68	68	67	66	66	67
	fz	0.011	0.015	0.017	0.02	0.022	0.024	0.026	0.029	0.031	0.035	0.036	0.036
	RPM	5275	4854	4386	3947	3762	3554	3330	3092	2844	2626	2472	2370
	FEED	232	291	298	316	331	341	346	359	353	368	356	341
15-20	Vc	113	119	122	124	128	131	133	134	134	132	132	132
	fz	0.011	0.016	0.018	0.02	0.022	0.025	0.027	0.03	0.032	0.035	0.036	0.037
	RPM	10277	9470	8630	7894	7408	6950	6513	6093	5687	5252	4943	4669
	FEED	452	606	621	632	652	695	703	731	728	735	712	691
38.1 - 38.2	Vc	43	46	47	46	47	47	49	51	52	53	53	54
	fz	0.004	0.004	0.005	0.006	0.007	0.009	0.01	0.011	0.013	0.014	0.014	0.014
	RPM	3911	3661	3325	2928	2720	2493	2400	2319	2207	2109	1985	1910
	FEED	63	59	66	70	76	90	96	102	115	118	111	107
40	Vc	70	73	74	74	77	79	80	81	80	79	80	80
	fz	0.011	0.016	0.018	0.02	0.023	0.026	0.027	0.028	0.03	0.032	0.032	0.031
	RPM	6366	5809	5234	4711	4456	4191	3918	3683	3395	3143	2996	2829
	FEED	280	372	377	377	410	436	423	413	407	402	383	351
41	Vc	43	46	47	46	47	47	49	51	52	53	53	54
	fz	0.004	0.004	0.005	0.006	0.007	0.009	0.01	0.011	0.013	0.014	0.014	0.014
	RPM	3911	3661	3325	2928	2720	2493	2400	2319	2207	2109	1985	1910
	FEED	63	59	66	70	76	90	96	102	115	118	111	107

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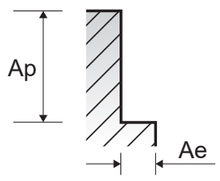

SEME36, SEME71 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø) 9.5	10.0	10.5	11.0	11.5	12.0	13.0	14.0	15.0
P	1-5	0.05D	1.0D	Vc	130	128	129	130	130	129	133	136	138
				fz	0.038	0.039	0.04	0.04	0.04	0.04	0.04	0.04	0.039
				RPM	4356	4074	3911	3762	3598	3422	3257	3092	2928
				FEED	662	636	626	602	576	547	521	495	457
	6-8	0.05D	1.0D	Vc	130	128	129	130	130	129	133	136	138
				fz	0.038	0.039	0.04	0.04	0.04	0.04	0.04	0.04	0.039
				RPM	4356	4074	3911	3762	3598	3422	3257	3092	2928
				FEED	662	636	626	602	576	547	521	495	457
	9	0.05D	1.0D	Vc	79	79	79	79	79	79	82	84	85
				fz	0.031	0.032	0.032	0.032	0.032	0.032	0.031	0.031	0.031
				RPM	2647	2515	2395	2286	2187	2096	2008	1910	1804
				FEED	328	322	307	293	280	268	249	237	224
	10-11.1	0.05D	1.0D	Vc	130	128	129	130	130	129	133	136	138
				fz	0.038	0.039	0.04	0.04	0.04	0.04	0.04	0.04	0.039
				RPM	4356	4074	3911	3762	3598	3422	3257	3092	2928
				FEED	662	636	626	602	576	547	521	495	457
	11.2	0.05D	1.0D	Vc	79	79	79	79	79	79	82	84	85
				fz	0.031	0.032	0.032	0.032	0.032	0.032	0.031	0.031	0.031
				RPM	2647	2515	2395	2286	2187	2096	2008	1910	1804
				FEED	328	322	307	293	280	268	249	237	224
M	14.1	0.05D	1.0D	Vc	67	66	66	66	65	64	66	68	69
				fz	0.037	0.038	0.038	0.038	0.038	0.037	0.037	0.037	0.038
				RPM	2245	2101	2001	1910	1799	1698	1616	1546	1464
				FEED	332	319	304	290	273	251	239	229	223
K	15-20	0.05D	1.0D	Vc	130	128	129	130	130	129	133	136	138
				fz	0.038	0.039	0.04	0.04	0.04	0.04	0.04	0.04	0.039
				RPM	4356	4074	3911	3762	3598	3422	3257	3092	2928
				FEED	662	636	626	602	576	547	521	495	457
H	38.1 - 38.2	0.05D	1.0D	Vc	54	53	54	55	55	55	56	57	57
				fz	0.014	0.014	0.014	0.014	0.015	0.015	0.015	0.015	0.014
				RPM	1809	1687	1637	1592	1522	1459	1371	1296	1210
				FEED	101	94	92	89	91	88	82	78	68
	40	0.05D	1.0D	Vc	79	79	79	79	79	79	82	84	85
				fz	0.031	0.032	0.032	0.032	0.032	0.032	0.031	0.031	0.031
				RPM	2647	2515	2395	2286	2187	2096	2008	1910	1804
				FEED	328	322	307	293	280	268	249	237	224
	41	0.05D	1.0D	Vc	54	53	54	55	55	55	56	57	57
				fz	0.014	0.014	0.014	0.014	0.015	0.015	0.015	0.015	0.014
				RPM	1809	1687	1637	1592	1522	1459	1371	1296	1210
				FEED	101	94	92	89	91	88	82	78	68

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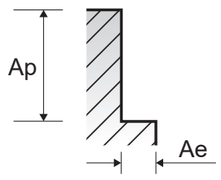
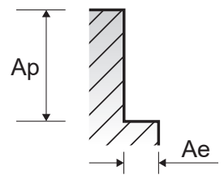


SEME36, SEME71 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

VDI 3323	Parameter	Diameter (Ø) 16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0	25.0
1-5	Vc	138	138	137	135	132	133	134	134	134	134
	fz	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.039	0.039
	RPM	2745	2584	2423	2262	2101	2016	1939	1855	1777	1706
	FEED	439	413	388	362	336	323	310	297	277	266
6-8	Vc	138	138	137	135	132	133	134	134	134	134
	fz	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.039	0.039
	RPM	2745	2584	2423	2262	2101	2016	1939	1855	1777	1706
	FEED	439	413	388	362	336	323	310	297	277	266
9	Vc	85	86	85	85	84	84	84	84	84	82
	fz	0.032	0.031	0.031	0.032	0.032	0.032	0.033	0.031	0.032	0.032
	RPM	1691	1610	1503	1424	1337	1273	1215	1163	1114	1044
	FEED	216	200	186	182	171	163	160	144	143	134
10-11.1	Vc	138	138	137	135	132	133	134	134	134	134
	fz	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.039	0.039
	RPM	2745	2584	2423	2262	2101	2016	1939	1855	1777	1706
	FEED	439	413	388	362	336	323	310	297	277	266
11.2	Vc	85	86	85	85	84	84	84	84	84	82
	fz	0.032	0.031	0.031	0.032	0.032	0.032	0.033	0.031	0.032	0.032
	RPM	1691	1610	1503	1424	1337	1273	1215	1163	1114	1044
	FEED	216	200	186	182	171	163	160	144	143	134
14.1	Vc	69	69	68	67	66	67	67	67	67	67
	fz	0.038	0.039	0.038	0.039	0.038	0.037	0.037	0.038	0.037	0.037
	RPM	1373	1292	1203	1122	1050	1016	969	927	889	853
	FEED	209	202	183	175	160	150	143	141	132	126
15-20	Vc	138	138	137	135	132	133	134	134	134	134
	fz	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.039	0.039
	RPM	2745	2584	2423	2262	2101	2016	1939	1855	1777	1706
	FEED	439	413	388	362	336	323	310	297	277	266
38.1 - 38.2	Vc	57	57	56	55	53	54	54	54	54	53
	fz	0.014	0.014	0.014	0.013	0.012	0.013	0.013	0.012	0.011	0.012
	RPM	1134	1067	990	921	844	819	781	747	716	675
	FEED	64	60	55	48	40	43	41	36	32	32
40	Vc	85	86	85	85	84	84	84	84	84	82
	fz	0.032	0.031	0.031	0.032	0.032	0.032	0.033	0.031	0.032	0.032
	RPM	1691	1610	1503	1424	1337	1273	1215	1163	1114	1044
	FEED	216	200	186	182	171	163	160	144	143	134
41	Vc	57	57	56	55	53	54	54	54	54	53
	fz	0.014	0.014	0.014	0.013	0.012	0.013	0.013	0.012	0.011	0.012
	RPM	1134	1067	990	921	844	819	781	747	716	675
	FEED	64	60	55	48	40	43	41	36	32	32



SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2
					LOC	3	4	5	6	7	8	10	12	4	6	8	10	12
P	1-5	Non-alloy steel	0.05D	2.5D	Vc	60	60	60	54	54	54	54	48	61	61	55	55	55
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	19099	19099	19099	17189	17189	17189	17189	15279	16181	16181	14589	14589	14589
					FEED	153	153	153	138	138	138	138	122	194	194	175	117	117
	6-8	Low alloy steel	0.05D	2.5D	Vc	60	60	60	54	54	54	54	48	61	61	55	55	55
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	19099	19099	19099	17189	17189	17189	17189	15279	16181	16181	14589	14589	14589
					FEED	153	153	153	138	138	138	138	122	194	194	175	117	117
	9		0.05D	2.5D	Vc	34	34	34	31	31	31	31	28	35	35	31	31	31
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002
					RPM	10823	10823	10823	9868	9868	9868	9868	8913	9284	9284	8223	8223	8223
					FEED	87	87	87	79	79	39	39	36	74	74	66	66	66
	10-11.1	High alloyed steel, and tool steel	0.05D	2.5D	Vc	60	60	60	54	54	54	54	48	61	61	55	55	55
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	19099	19099	19099	17189	17189	17189	17189	15279	16181	16181	14589	14589	14589
					FEED	153	153	153	138	138	138	138	122	194	194	175	117	117
	11.2		0.05D	2.5D	Vc	34	34	34	31	31	31	31	28	35	35	31	31	31
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002
					RPM	10823	10823	10823	9868	9868	9868	9868	8913	9284	9284	8223	8223	8223
					FEED	87	87	87	79	79	39	39	36	74	74	66	66	66
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	Vc	60	60	60	54	54	54	54	48	61	61	55	55	55
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002	0.002
					RPM	19099	19099	19099	17189	17189	17189	17189	15279	16181	16181	14589	14589	14589
					FEED	153	153	153	138	138	138	138	122	194	194	175	117	117
H	38.1 - 38.2	Hardened steel	0.02D	2.0D	Vc	21	21	21	19	19	19	19	17	21	21	19	19	19
					fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.001	0.001
					RPM	6685	6685	6685	6048	6048	6048	6048	5411	5570	5570	5040	5040	5040
					FEED	27	27	27	24	24	24	24	22	45	45	40	20	20
	40	Chilled Cast Iron	0.05D	2.5D	Vc	34	34	34	31	31	31	31	28	35	35	31	31	31
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002
					RPM	10823	10823	10823	9868	9868	9868	9868	8913	9284	9284	8223	8223	8223
					FEED	87	87	87	79	79	39	39	36	74	74	66	66	66
	41	Hardened Cast Iron	0.02D	2.0D	Vc	21	21	21	19	19	19	19	17	21	21	19	19	19
					fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.001	0.001
					RPM	6685	6685	6685	6048	6048	6048	6048	5411	5570	5570	5040	5040	5040
					FEED	27	27	27	24	24	24	24	22	45	45	40	20	20

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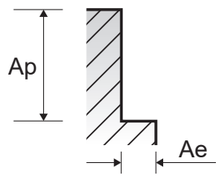

SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																
		1.5	1.5	1.5	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.5	2.5	2.5	2.5	2.5	3.0	3.0
	LOC	6	8	10	12	14	16	8	10	12	14	16	10	12	16	20	26	10	12
1-5	Vc	65	59	59	59	59	52	66	66	60	60	60	71	71	64	64	57	70	70
	fz	0.004	0.004	0.004	0.003	0.003	0.003	0.006	0.006	0.005	0.005	0.005	0.007	0.007	0.006	0.006	0.005	0.009	0.009
	RPM	13793	12520	12520	12520	12520	11035	10504	10504	9549	9549	9549	9040	9040	8149	8149	7257	7427	7427
	FEED	221	200	200	150	150	132	252	252	191	191	191	253	253	196	196	145	267	267
6-8	Vc	65	59	59	59	59	52	66	66	60	60	60	71	71	64	64	57	70	70
	fz	0.004	0.004	0.004	0.003	0.003	0.003	0.006	0.006	0.005	0.005	0.005	0.007	0.007	0.006	0.006	0.005	0.009	0.009
	RPM	13793	12520	12520	12520	12520	11035	10504	10504	9549	9549	9549	9040	9040	8149	8149	7257	7427	7427
	FEED	221	200	200	150	150	132	252	252	191	191	191	253	253	196	196	145	267	267
9	Vc	37	33	33	33	33	30	38	38	34	34	34	41	41	37	37	32	40	40
	fz	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.005	0.004	0.004	0.007	0.007
	RPM	7852	7003	7003	7003	7003	6366	6048	6048	5411	5411	5411	5220	5220	4711	4711	4074	4244	4244
	FEED	94	84	56	56	56	51	97	97	87	87	65	104	104	94	75	65	119	119
10-11.1	Vc	65	59	59	59	59	52	66	66	60	60	60	71	71	64	64	57	70	70
	fz	0.004	0.004	0.004	0.003	0.003	0.003	0.006	0.006	0.005	0.005	0.005	0.007	0.007	0.006	0.006	0.005	0.009	0.009
	RPM	13793	12520	12520	12520	12520	11035	10504	10504	9549	9549	9549	9040	9040	8149	8149	7257	7427	7427
	FEED	221	200	200	150	150	132	252	252	191	191	191	253	253	196	196	145	267	267
11.2	Vc	37	33	33	33	33	30	38	38	34	34	34	41	41	37	37	32	40	40
	fz	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.005	0.004	0.004	0.007	0.007
	RPM	7852	7003	7003	7003	7003	6366	6048	6048	5411	5411	5411	5220	5220	4711	4711	4074	4244	4244
	FEED	94	84	56	56	56	51	97	97	87	87	65	104	104	94	75	65	119	119
15-20	Vc	65	59	59	59	59	52	66	66	60	60	60	71	71	64	64	57	70	70
	fz	0.004	0.004	0.004	0.003	0.003	0.003	0.006	0.006	0.005	0.005	0.005	0.007	0.007	0.006	0.006	0.005	0.009	0.009
	RPM	13793	12520	12520	12520	12520	11035	10504	10504	9549	9549	9549	9040	9040	8149	8149	7257	7427	7427
	FEED	221	200	200	150	150	132	252	252	191	191	191	253	253	196	196	145	267	267
38.1 - 38.2	Vc	23	20	20	20	20	18	24	24	21	21	21	25	25	23	23	20	25	25
	fz	0.002	0.002	0.002	0.002	0.002	0.002	0.004	0.004	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006
	RPM	4881	4244	4244	4244	4244	3820	3820	3820	3342	3342	3342	3183	3183	2928	2928	2546	2653	2653
	FEED	39	34	34	34	34	31	61	61	40	40	40	64	64	47	47	31	64	64
40	Vc	37	33	33	33	33	30	38	38	34	34	34	41	41	37	37	32	40	40
	fz	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.005	0.004	0.004	0.007	0.007
	RPM	7852	7003	7003	7003	7003	6366	6048	6048	5411	5411	5411	5220	5220	4711	4711	4074	4244	4244
	FEED	94	84	56	56	56	51	97	97	87	87	65	104	104	94	75	65	119	119
41	Vc	23	20	20	20	20	18	24	24	21	21	21	25	25	23	23	20	25	25
	fz	0.002	0.002	0.002	0.002	0.002	0.002	0.004	0.004	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006
	RPM	4881	4244	4244	4244	4244	3820	3820	3820	3342	3342	3342	3183	3183	2928	2928	2546	2653	2653
	FEED	39	34	34	34	34	31	61	61	40	40	40	64	64	47	47	31	64	64

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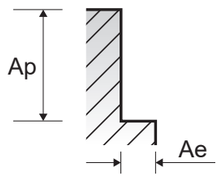

SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					3.0	3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	5.0	5.0	5.0	5.0	5.0	6.0
				LOC	14	16	20	26	30	12	16	20	26	30	20	25	30	35	40	15
P	1-5	0.05D	2.5D	Vc	70	63	63	63	63	75	75	75	68	68	80	80	72	72	72	83
				fz	0.009	0.009	0.008	0.008	0.008	0.014	0.014	0.014	0.013	0.013	0.021	0.021	0.019	0.019	0.017	0.029
				RPM	7427	6685	6685	6685	6685	5968	5968	5968	5411	5411	5093	5093	4584	4584	4584	4403
				FEED	267	241	214	214	214	334	334	334	281	281	428	428	348	348	312	511
	6-8	0.05D	2.5D	Vc	70	63	63	63	63	75	75	75	68	68	80	80	72	72	72	83
				fz	0.009	0.009	0.008	0.008	0.008	0.014	0.014	0.014	0.013	0.013	0.021	0.021	0.019	0.019	0.017	0.029
				RPM	7427	6685	6685	6685	6685	5968	5968	5968	5411	5411	5093	5093	4584	4584	4584	4403
				FEED	267	241	214	214	214	334	334	334	281	281	428	428	348	348	312	511
	9	0.05D	2.5D	Vc	40	36	36	36	36	43	43	43	39	39	46	46	41	41	41	48
				fz	0.007	0.007	0.006	0.006	0.006	0.01	0.01	0.01	0.009	0.009	0.015	0.015	0.013	0.013	0.011	0.021
				RPM	4244	3820	3820	3820	3820	3422	3422	3422	3104	3104	2928	2928	2610	2610	2610	2546
				FEED	119	107	92	92	92	137	137	137	112	112	176	176	136	136	115	214
	10-11.1	0.05D	2.5D	Vc	70	63	63	63	63	75	75	75	68	68	80	80	72	72	72	83
				fz	0.009	0.009	0.008	0.008	0.008	0.014	0.014	0.014	0.013	0.013	0.021	0.021	0.019	0.019	0.017	0.029
				RPM	7427	6685	6685	6685	6685	5968	5968	5968	5411	5411	5093	5093	4584	4584	4584	4403
				FEED	267	241	214	214	214	334	334	334	281	281	428	428	348	348	312	511
	11.2	0.05D	2.5D	Vc	40	36	36	36	36	43	43	43	39	39	46	46	41	41	41	48
				fz	0.007	0.007	0.006	0.006	0.006	0.01	0.01	0.01	0.009	0.009	0.015	0.015	0.013	0.013	0.011	0.021
				RPM	4244	3820	3820	3820	3820	3422	3422	3422	3104	3104	2928	2928	2610	2610	2610	2546
				FEED	119	107	92	92	92	137	137	137	112	112	176	176	136	136	115	214
K	15-20	0.05D	2.5D	Vc	70	63	63	63	63	75	75	75	68	68	80	80	72	72	72	83
				fz	0.009	0.009	0.008	0.008	0.008	0.014	0.014	0.014	0.013	0.013	0.021	0.021	0.019	0.019	0.017	0.029
				RPM	7427	6685	6685	6685	6685	5968	5968	5968	5411	5411	5093	5093	4584	4584	4584	4403
				FEED	267	241	214	214	214	334	334	334	281	281	428	428	348	348	312	511
H	38.1 - 38.2	0.02D	2.0D	Vc	25	22	22	22	22	27	27	27	24	24	30	30	27	27	27	31
				fz	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.008	0.011	0.011	0.01	0.01	0.009	0.017
				RPM	2653	2334	2334	2334	2334	2149	2149	2149	1910	1910	1910	1910	1719	1719	1719	1645
				FEED	64	56	56	47	47	69	69	69	61	61	84	84	69	69	62	112
	40	0.05D	2.5D	Vc	40	36	36	36	36	43	43	43	39	39	46	46	41	41	41	48
				fz	0.007	0.007	0.006	0.006	0.006	0.01	0.01	0.01	0.009	0.009	0.015	0.015	0.013	0.013	0.011	0.021
				RPM	4244	3820	3820	3820	3820	3422	3422	3422	3104	3104	2928	2928	2610	2610	2610	2546
				FEED	119	107	92	92	92	137	137	137	112	112	176	176	136	136	115	214
	41	0.02D	2.0D	Vc	25	22	22	22	22	27	27	27	24	24	30	30	27	27	27	31
				fz	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	0.008	0.008	0.011	0.011	0.01	0.01	0.009	0.017
				RPM	2653	2334	2334	2334	2334	2149	2149	2149	1910	1910	1910	1910	1719	1719	1719	1645
				FEED	64	56	56	47	47	69	69	69	61	61	84	84	69	69	62	112

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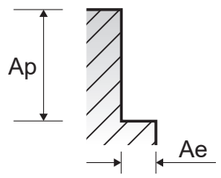

SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																	
		6.0	6.0	6.0	6.0	6.0	6.0	8.0	8.0	8.0	8.0	8.0	8.0	10.0	10.0	10.0	10.0	10.0	10.0
	LOC	20	25	30	35	40	45	25	30	35	40	45	50	30	35	40	45	50	55
1-5	Vc	83	83	83	75	75	75	84	84	84	84	76	76	89	89	89	89	89	80
	fz	0.029	0.029	0.025	0.025	0.022	0.022	0.041	0.041	0.041	0.035	0.035	0.031	0.049	0.049	0.049	0.042	0.042	0.041
	RPM	4403	4403	4403	3979	3979	3979	3342	3342	3342	3342	3024	3024	2833	2833	2833	2833	2833	2546
	FEED	511	511	440	398	350	350	548	548	548	468	423	375	555	555	555	476	476	418
6-8	Vc	83	83	83	75	75	75	84	84	84	84	76	76	89	89	89	89	89	80
	fz	0.029	0.029	0.025	0.025	0.022	0.022	0.041	0.041	0.041	0.035	0.035	0.031	0.049	0.049	0.049	0.042	0.042	0.041
	RPM	4403	4403	4403	3979	3979	3979	3342	3342	3342	3342	3024	3024	2833	2833	2833	2833	2833	2546
	FEED	511	511	440	398	350	350	548	548	548	468	423	375	555	555	555	476	476	418
9	Vc	48	48	48	43	43	43	48	48	48	48	43	43	52	52	52	52	52	46
	fz	0.021	0.021	0.018	0.018	0.016	0.016	0.028	0.028	0.028	0.024	0.024	0.021	0.033	0.033	0.033	0.028	0.028	0.028
	RPM	2546	2546	2546	2281	2281	2281	1910	1910	1910	1910	1711	1711	1655	1655	1655	1655	1655	1464
	FEED	214	214	183	164	146	146	214	214	214	183	164	144	218	218	218	185	185	164
10-11.1	Vc	83	83	83	75	75	75	84	84	84	84	76	76	89	89	89	89	89	80
	fz	0.029	0.029	0.025	0.025	0.022	0.022	0.041	0.041	0.041	0.035	0.035	0.031	0.049	0.049	0.049	0.042	0.042	0.041
	RPM	4403	4403	4403	3979	3979	3979	3342	3342	3342	3342	3024	3024	2833	2833	2833	2833	2833	2546
	FEED	511	511	440	398	350	350	548	548	548	468	423	375	555	555	555	476	476	418
11.2	Vc	48	48	48	43	43	43	48	48	48	48	43	43	52	52	52	52	52	46
	fz	0.021	0.021	0.018	0.018	0.016	0.016	0.028	0.028	0.028	0.024	0.024	0.021	0.033	0.033	0.033	0.028	0.028	0.028
	RPM	2546	2546	2546	2281	2281	2281	1910	1910	1910	1910	1711	1711	1655	1655	1655	1655	1655	1464
	FEED	214	214	183	164	146	146	214	214	214	183	164	144	218	218	218	185	185	164
15-20	Vc	83	83	83	75	75	75	84	84	84	84	76	76	89	89	89	89	89	80
	fz	0.029	0.029	0.025	0.025	0.022	0.022	0.041	0.041	0.041	0.035	0.035	0.031	0.049	0.049	0.049	0.042	0.042	0.041
	RPM	4403	4403	4403	3979	3979	3979	3342	3342	3342	3342	3024	3024	2833	2833	2833	2833	2833	2546
	FEED	511	511	440	398	350	350	548	548	548	468	423	375	555	555	555	476	476	418
38.1 - 38.2	Vc	31	31	31	28	28	28	32	32	32	32	28	28	32	32	32	32	32	29
	fz	0.017	0.017	0.014	0.014	0.013	0.013	0.022	0.022	0.022	0.018	0.019	0.017	0.027	0.027	0.027	0.022	0.022	0.023
	RPM	1645	1645	1645	1485	1485	1485	1273	1273	1273	1273	1114	1114	1019	1019	1019	1019	1019	923
	FEED	112	112	92	83	77	77	112	112	112	92	85	76	110	110	110	90	90	85
40	Vc	48	48	48	43	43	43	48	48	48	48	43	43	52	52	52	52	52	46
	fz	0.021	0.021	0.018	0.018	0.016	0.016	0.028	0.028	0.028	0.024	0.024	0.021	0.033	0.033	0.033	0.028	0.028	0.028
	RPM	2546	2546	2546	2281	2281	2281	1910	1910	1910	1910	1711	1711	1655	1655	1655	1655	1655	1464
	FEED	214	214	183	164	146	146	214	214	214	183	164	144	218	218	218	185	185	164
41	Vc	31	31	31	28	28	28	32	32	32	32	28	28	32	32	32	32	32	29
	fz	0.017	0.017	0.014	0.014	0.013	0.013	0.022	0.022	0.022	0.018	0.019	0.017	0.027	0.027	0.027	0.022	0.022	0.023
	RPM	1645	1645	1645	1485	1485	1485	1273	1273	1273	1273	1114	1114	1019	1019	1019	1019	1019	923
	FEED	112	112	92	83	77	77	112	112	112	92	85	76	110	110	110	90	90	85

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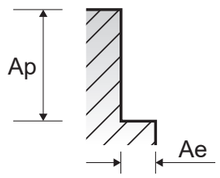

SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					10.0	12.0	12.0	12.0	12.0	12.0	12.0	12.0	12.0	14.0	14.0	16.0	16.0	16.0	16.0	16.0
				LOC	60	35	40	45	50	55	60	65	70	50	60	40	50	60	70	80
P	1-5	0.05D	2.5D	Vc	80	87	87	87	87	87	87	78	78	93	93	98	98	98	98	98
				fz	0.037	0.047	0.047	0.04	0.04	0.04	0.035	0.035	0.035	0.041	0.041	0.05	0.05	0.042	0.042	0.037
				RPM	2546	2308	2308	2308	2308	2308	2308	2069	2069	2114	2114	1950	1950	1950	1950	1950
				FEED	377	434	434	369	369	369	323	290	290	347	347	390	390	328	328	289
	6-8	0.05D	2.5D	Vc	80	87	87	87	87	87	87	78	78	93	93	98	98	98	98	98
				fz	0.037	0.047	0.047	0.04	0.04	0.04	0.035	0.035	0.035	0.041	0.041	0.05	0.05	0.042	0.042	0.037
				RPM	2546	2308	2308	2308	2308	2308	2308	2069	2069	2114	2114	1950	1950	1950	1950	1950
				FEED	377	434	434	369	369	369	323	290	290	347	347	390	390	328	328	289
	9	0.05D	2.5D	Vc	46	52	52	52	52	52	52	47	47	54	54	54	54	54	54	54
				fz	0.024	0.034	0.034	0.03	0.03	0.03	0.026	0.026	0.026	0.029	0.029	0.035	0.035	0.03	0.03	0.027
				RPM	1464	1379	1379	1379	1379	1379	1379	1247	1247	1228	1228	1074	1074	1074	1074	1074
				FEED	141	188	188	166	166	166	143	130	130	142	142	150	150	129	129	116
	10-11.1	0.05D	2.5D	Vc	80	87	87	87	87	87	87	78	78	93	93	98	98	98	98	98
				fz	0.037	0.047	0.047	0.04	0.04	0.04	0.035	0.035	0.035	0.041	0.041	0.05	0.05	0.042	0.042	0.037
				RPM	2546	2308	2308	2308	2308	2308	2308	2069	2069	2114	2114	1950	1950	1950	1950	1950
				FEED	377	434	434	369	369	369	323	290	290	347	347	390	390	328	328	289
	11.2	0.05D	2.5D	Vc	46	52	52	52	52	52	52	47	47	54	54	54	54	54	54	54
				fz	0.024	0.034	0.034	0.03	0.03	0.03	0.026	0.026	0.026	0.029	0.029	0.035	0.035	0.03	0.03	0.027
				RPM	1464	1379	1379	1379	1379	1379	1379	1247	1247	1228	1228	1074	1074	1074	1074	1074
				FEED	141	188	188	166	166	166	143	130	130	142	142	150	150	129	129	116
K	15-20	0.05D	2.5D	Vc	80	87	87	87	87	87	87	78	78	93	93	98	98	98	98	98
				fz	0.037	0.047	0.047	0.04	0.04	0.04	0.035	0.035	0.035	0.041	0.041	0.05	0.05	0.042	0.042	0.037
				RPM	2546	2308	2308	2308	2308	2308	2308	2069	2069	2114	2114	1950	1950	1950	1950	1950
				FEED	377	434	434	369	369	369	323	290	290	347	347	390	390	328	328	289
H	38.1 - 38.2	0.02D	2.0D	Vc	29	32	32	32	32	32	32	29	29	33	33	34	34	34	34	34
				fz	0.021	0.025	0.025	0.021	0.021	0.021	0.019	0.018	0.018	0.021	0.021	0.026	0.026	0.022	0.022	0.021
				RPM	923	849	849	849	849	849	849	769	769	750	750	676	676	676	676	676
				FEED	78	85	85	71	71	71	65	55	55	63	63	70	70	60	60	57
	40	0.05D	2.5D	Vc	46	52	52	52	52	52	52	47	47	54	54	54	54	54	54	54
				fz	0.024	0.034	0.034	0.03	0.03	0.03	0.026	0.026	0.026	0.029	0.029	0.035	0.035	0.03	0.03	0.027
				RPM	1464	1379	1379	1379	1379	1379	1379	1247	1247	1228	1228	1074	1074	1074	1074	1074
				FEED	141	188	188	166	166	166	143	130	130	142	142	150	150	129	129	116
	41	0.02D	2.0D	Vc	29	32	32	32	32	32	32	29	29	33	33	34	34	34	34	34
				fz	0.021	0.025	0.025	0.021	0.021	0.021	0.019	0.018	0.018	0.021	0.021	0.026	0.026	0.022	0.022	0.021
				RPM	923	849	849	849	849	849	849	769	769	750	750	676	676	676	676	676
				FEED	78	85	85	71	71	71	65	55	55	63	63	70	70	60	60	57

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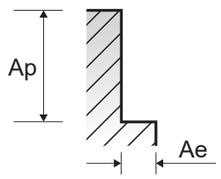
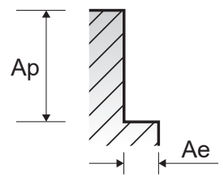


SEME72 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																	
		16.0	16.0	16.0	18.0	18.0	18.0	20.0	20.0	20.0	20.0	20.0	20.0	20.0	22.0	22.0	25.0	25.0	25.0	25.0
	LOC	90	110	120	50	70	100	50	60	70	80	90	110	120	75	110	70	90	110	120
1-5	Vc	88	88	88	95	95	85	89	89	89	89	89	80	80	87	87	86	86	86	86
	fz	0.037	0.037	0.037	0.049	0.042	0.037	0.048	0.048	0.041	0.041	0.036	0.036	0.036	0.041	0.036	0.049	0.042	0.042	0.036
	RPM	1751	1751	1751	1680	1680	1503	1416	1416	1416	1416	1416	1273	1273	1259	1259	1095	1095	1095	1095
	FEED	259	259	259	329	282	222	272	272	232	232	204	183	183	206	181	215	184	184	158
6-8	Vc	88	88	88	95	95	85	89	89	89	89	89	80	80	87	87	86	86	86	86
	fz	0.037	0.037	0.037	0.049	0.042	0.037	0.048	0.048	0.041	0.041	0.036	0.036	0.036	0.041	0.036	0.049	0.042	0.042	0.036
	RPM	1751	1751	1751	1680	1680	1503	1416	1416	1416	1416	1416	1273	1273	1259	1259	1095	1095	1095	1095
	FEED	259	259	259	329	282	222	272	272	232	232	204	183	183	206	181	215	184	184	158
9	Vc	48	48	48	53	53	48	52	52	52	52	52	46	46	57	57	64	64	64	64
	fz	0.026	0.026	0.026	0.035	0.029	0.025	0.034	0.034	0.027	0.027	0.024	0.026	0.026	0.027	0.024	0.034	0.027	0.027	0.024
	RPM	955	955	955	937	937	849	828	828	828	828	828	732	732	825	825	815	815	815	815
	FEED	99	99	99	131	109	85	113	113	89	89	79	76	76	89	79	111	88	88	78
10-11.1	Vc	88	88	88	95	95	85	89	89	89	89	89	80	80	87	87	86	86	86	86
	fz	0.037	0.037	0.037	0.049	0.042	0.037	0.048	0.048	0.041	0.041	0.036	0.036	0.036	0.041	0.036	0.049	0.042	0.042	0.036
	RPM	1751	1751	1751	1680	1680	1503	1416	1416	1416	1416	1416	1273	1273	1259	1259	1095	1095	1095	1095
	FEED	259	259	259	329	282	222	272	272	232	232	204	183	183	206	181	215	184	184	158
11.2	Vc	48	48	48	53	53	48	52	52	52	52	52	46	46	57	57	64	64	64	64
	fz	0.026	0.026	0.026	0.035	0.029	0.025	0.034	0.034	0.027	0.027	0.024	0.026	0.026	0.027	0.024	0.034	0.027	0.027	0.024
	RPM	955	955	955	937	937	849	828	828	828	828	828	732	732	825	825	815	815	815	815
	FEED	99	99	99	131	109	85	113	113	89	89	79	76	76	89	79	111	88	88	78
15-20	Vc	88	88	88	95	95	85	89	89	89	89	89	80	80	87	87	86	86	86	86
	fz	0.037	0.037	0.037	0.049	0.042	0.037	0.048	0.048	0.041	0.041	0.036	0.036	0.036	0.041	0.036	0.049	0.042	0.042	0.036
	RPM	1751	1751	1751	1680	1680	1503	1416	1416	1416	1416	1416	1273	1273	1259	1259	1095	1095	1095	1095
	FEED	259	259	259	329	282	222	272	272	232	232	204	183	183	206	181	215	184	184	158
38.1 - 38.2	Vc	30	30	30	33	33	30	31	31	31	31	31	28	28	35	35	39	39	39	39
	fz	0.021	0.021	0.021	0.028	0.023	0.021	0.028	0.028	0.023	0.023	0.02	0.019	0.019	0.023	0.02	0.028	0.023	0.023	0.02
	RPM	597	597	597	584	584	531	493	493	493	493	493	446	446	506	506	497	497	497	497
	FEED	50	50	50	65	54	45	55	55	45	45	39	34	34	47	41	56	46	46	40
40	Vc	48	48	48	53	53	48	52	52	52	52	52	46	46	57	57	64	64	64	64
	fz	0.026	0.026	0.026	0.035	0.029	0.025	0.034	0.034	0.027	0.027	0.024	0.026	0.026	0.027	0.024	0.034	0.027	0.027	0.024
	RPM	955	955	955	937	937	849	828	828	828	828	828	732	732	825	825	815	815	815	815
	FEED	99	99	99	131	109	85	113	113	89	89	79	76	76	89	79	111	88	88	78
41	Vc	30	30	30	33	33	30	31	31	31	31	31	28	28	35	35	39	39	39	39
	fz	0.021	0.021	0.021	0.028	0.023	0.021	0.028	0.028	0.023	0.023	0.02	0.019	0.019	0.023	0.02	0.028	0.023	0.023	0.02
	RPM	597	597	597	584	584	531	493	493	493	493	493	446	446	506	506	497	497	497	497
	FEED	50	50	50	65	54	45	55	55	45	45	39	34	34	47	41	56	46	46	40



SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																	
				1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0
			LBS	2	3	4	5	6	7	8	10	12	14	16	18	20	22	26	30	40	50
P	1-5	Non-alloy steel	Vc	69	69	69	69	62	62	62	62	55	55	41	41	41	21	21	21	7	7
			fz	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	21963	21963	21963	21963	19735	19735	19735	19735	17507	17507	13051	13051	13051	6685	6685	6685	2228	2228
			FEED	351	351	351	351	237	237	237	237	210	210	104	104	104	53	53	53	18	18
			Ae	0.021	0.021	0.015	0.015	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	6-8	Low alloy steel	Vc	69	69	69	69	62	62	62	62	55	55	41	41	41	21	21	21	7	7
			fz	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	21963	21963	21963	21963	19735	19735	19735	19735	17507	17507	13051	13051	13051	6685	6685	6685	2228	2228
			FEED	351	351	351	351	237	237	237	237	210	210	104	104	104	53	53	53	18	18
			Ae	0.021	0.021	0.015	0.015	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	9		Vc	42	42	42	42	38	38	38	38	34	34	25	25	25	13	13	13	4	4
			fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	13369	13369	13369	13369	12096	12096	12096	12096	10823	10823	7958	7958	7958	4138	4138	4138	1273	1273
			FEED	160	160	160	160	145	145	145	145	130	130	64	64	64	33	33	33	10	10
			Ae	0.016	0.016	0.011	0.011	0.006	0.006	0.006	0.004	0.004	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	10-11.1	High alloyed steel, and tool steel	Vc	69	69	69	69	62	62	62	62	55	55	41	41	41	21	21	21	7	7
			fz	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	21963	21963	21963	21963	19735	19735	19735	19735	17507	17507	13051	13051	13051	6685	6685	6685	2228	2228
			FEED	351	351	351	351	237	237	237	237	210	210	104	104	104	53	53	53	18	18
			Ae	0.021	0.021	0.015	0.015	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	11.2		Vc	42	42	42	42	38	38	38	38	34	34	25	25	25	13	13	13	4	4
			fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	13369	13369	13369	13369	12096	12096	12096	12096	10823	10823	7958	7958	7958	4138	4138	4138	1273	1273
			FEED	160	160	160	160	145	145	145	145	130	130	64	64	64	33	33	33	10	10
			Ae	0.016	0.016	0.011	0.011	0.006	0.006	0.006	0.004	0.004	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	69	69	69	69	62	62	62	62	55	55	41	41	41	21	21	21	7	7
			fz	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	21963	21963	21963	21963	19735	19735	19735	19735	17507	17507	13051	13051	13051	6685	6685	6685	2228	2228
			FEED	351	351	351	351	237	237	237	237	210	210	104	104	104	53	53	53	18	18
			Ae	0.021	0.021	0.015	0.015	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H	38.1 - 38.2	Hardened steel	Vc	27	27	27	27	24	24	24	24	21	21	16	16	16	8	8	8	3	3
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	8594	8594	8594	8594	7639	7639	7639	7639	6685	6685	5093	5093	5093	2546	2546	2546	955	955
			FEED	34	34	34	34	31	31	31	31	27	27	20	20	20	10	10	10	4	4
			Ae	0.013	0.013	0.009	0.009	0.005	0.005	0.005	0.003	0.003	0.002	0.002	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	40	Chilled Cast Iron	Vc	42	42	42	42	38	38	38	38	34	34	25	25	25	13	13	13	4	4
			fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
			RPM	13369	13369	13369	13369	12096	12096	12096	12096	10823	10823	7958	7958	7958	4138	4138	4138	1273	1273
			FEED	160	160	160	160	145	145	145	145	130	130	64	64	64	33	33	33	10	10
			Ae	0.016	0.016	0.011	0.011	0.006	0.006	0.006	0.004	0.004	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
	41	Hardened Cast Iron	Vc	27	27	27	27	24	24	24	24	21	21	16	16	16	8	8	8	3	3
			fz	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
			RPM	8594	8594	8594	8594	7639	7639	7639	7639	6685	6685	5093	5093	5093	2546	2546	2546	955	955
			FEED	34	34	34	34	31	31	31	31	27	27	20	20	20	10	10	10	4	4
			Ae	0.013	0.013	0.009	0.009	0.005	0.005	0.005	0.003	0.003	0.002	0.002	0.001	0.001	0.001	0.001	0.001	0.001	0.001

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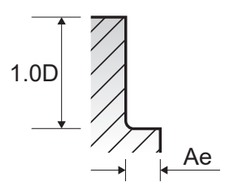

SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																			
		1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
	LBS	4	6	8	10	12	14	16	20	26	30	4	5	6	7	8	10	12	14	16	18	20
1-5	Vc	74	74	66	66	66	59	59	44	22	22	80	80	80	80	72	72	72	72	64	64	64
	fz	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.002	0.002	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	19629	19629	17507	17507	17507	15650	15650	11671	5836	5836	16977	16977	16977	16977	15279	15279	15279	15279	13581	13581	13581
	FEED	314	314	280	280	280	188	188	140	47	47	340	340	340	340	244	244	244	244	217	217	217
	Ae	0.018	0.018	0.01	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.032	0.022	0.022	0.022	0.013	0.013	0.013	0.008	0.008	0.008	0.005
6-8	Vc	74	74	66	66	66	59	59	44	22	22	80	80	80	80	72	72	72	72	64	64	64
	fz	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.002	0.002	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	19629	19629	17507	17507	17507	15650	15650	11671	5836	5836	16977	16977	16977	16977	15279	15279	15279	15279	13581	13581	13581
	FEED	314	314	280	280	280	188	188	140	47	47	340	340	340	340	244	244	244	244	217	217	217
	Ae	0.018	0.018	0.01	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.032	0.022	0.022	0.022	0.013	0.013	0.013	0.008	0.008	0.008	0.005
9	Vc	46	46	41	41	41	36	36	27	14	14	50	50	50	50	45	45	45	45	40	40	40
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	12202	12202	10876	10876	10876	9549	9549	7162	3714	3714	10610	10610	10610	10610	9549	9549	9549	9549	8488	8488	8488
	FEED	195	195	131	131	131	115	115	86	30	30	170	170	170	170	153	153	153	153	136	136	136
	Ae	0.013	0.013	0.008	0.005	0.005	0.005	0.003	0.002	0.002	0.002	0.024	0.017	0.017	0.017	0.009	0.009	0.009	0.006	0.006	0.006	0.004
10-11.1	Vc	74	74	66	66	66	59	59	44	22	22	80	80	80	80	72	72	72	72	64	64	64
	fz	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.002	0.002	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	19629	19629	17507	17507	17507	15650	15650	11671	5836	5836	16977	16977	16977	16977	15279	15279	15279	15279	13581	13581	13581
	FEED	314	314	280	280	280	188	188	140	47	47	340	340	340	340	244	244	244	244	217	217	217
	Ae	0.018	0.018	0.01	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.032	0.022	0.022	0.022	0.013	0.013	0.013	0.008	0.008	0.008	0.005
11.2	Vc	46	46	41	41	41	36	36	27	14	14	50	50	50	50	45	45	45	45	40	40	40
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	12202	12202	10876	10876	10876	9549	9549	7162	3714	3714	10610	10610	10610	10610	9549	9549	9549	9549	8488	8488	8488
	FEED	195	195	131	131	131	115	115	86	30	30	170	170	170	170	153	153	153	153	136	136	136
	Ae	0.013	0.013	0.008	0.005	0.005	0.005	0.003	0.002	0.002	0.002	0.024	0.017	0.017	0.017	0.009	0.009	0.009	0.006	0.006	0.006	0.004
15-20	Vc	74	74	66	66	66	59	59	44	22	22	80	80	80	80	72	72	72	72	64	64	64
	fz	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.002	0.002	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	19629	19629	17507	17507	17507	15650	15650	11671	5836	5836	16977	16977	16977	16977	15279	15279	15279	15279	13581	13581	13581
	FEED	314	314	280	280	280	188	188	140	47	47	340	340	340	340	244	244	244	244	217	217	217
	Ae	0.018	0.018	0.01	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.032	0.022	0.022	0.022	0.013	0.013	0.013	0.008	0.008	0.008	0.005
38.1 - 38.2	Vc	28	28	25	25	25	23	23	17	8	8	31	31	31	31	28	28	28	28	25	25	25
	fz	0.002	0.002	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001
	RPM	7427	7427	6631	6631	6631	6101	6101	4509	2122	2122	6578	6578	6578	6578	5942	5942	5942	5942	5305	5305	5305
	FEED	59	59	27	27	27	24	24	18	8	8	53	53	53	53	48	48	48	48	21	21	21
	Ae	0.011	0.011	0.006	0.004	0.004	0.004	0.002	0.002	0.002	0.002	0.019	0.013	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.005	0.003
40	Vc	46	46	41	41	41	36	36	27	14	14	50	50	50	50	45	45	45	45	40	40	40
	fz	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	12202	12202	10876	10876	10876	9549	9549	7162	3714	3714	10610	10610	10610	10610	9549	9549	9549	9549	8488	8488	8488
	FEED	195	195	131	131	131	115	115	86	30	30	170	170	170	170	153	153	153	153	136	136	136
	Ae	0.013	0.013	0.008	0.005	0.005	0.005	0.003	0.002	0.002	0.002	0.024	0.017	0.017	0.017	0.009	0.009	0.009	0.006	0.006	0.006	0.004
41	Vc	28	28	25	25	25	23	23	17	8	8	31	31	31	31	28	28	28	28	25	25	25
	fz	0.002	0.002	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001
	RPM	7427	7427	6631	6631	6631	6101	6101	4509	2122	2122	6578	6578	6578	6578	5942	5942	5942	5942	5305	5305	5305
	FEED	59	59	27	27	27	24	24	18	8	8	53	53	53	53	48	48	48	48	21	21	21
	Ae	0.011	0.011	0.006	0.004	0.004	0.004	0.002	0.002	0.002	0.002	0.019	0.013	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.005	0.003

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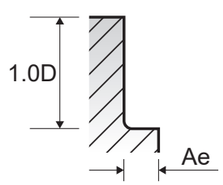

SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.5	2.5
		LBS	22	26	30	6	8	10	12	16	18	20	22	26	30	35	40	45	50	60	8	10
P	1-5	Vc	64	48	48	87	87	87	79	79	79	79	70	70	70	52	52	26	26	26	94	94
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.007	0.007
		RPM	13581	10186	10186	13846	13846	13846	12573	12573	12573	12573	11141	11141	11141	8276	8276	4138	4138	4138	11968	11968
		FEED	217	122	122	332	332	332	251	251	251	251	223	223	223	132	132	66	66	66	335	335
		Ae	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037
	6-8	Vc	64	48	48	87	87	87	79	79	79	79	70	70	70	52	52	26	26	26	94	94
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.007	0.007
		RPM	13581	10186	10186	13846	13846	13846	12573	12573	12573	12573	11141	11141	11141	8276	8276	4138	4138	4138	11968	11968
		FEED	217	122	122	332	332	332	251	251	251	251	223	223	223	132	132	66	66	66	335	335
		Ae	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037
	9	Vc	40	30	30	57	57	57	51	51	51	51	46	46	46	34	34	17	17	17	60	60
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.007	0.007
		RPM	8488	6366	6366	9072	9072	9072	8117	8117	8117	8117	7321	7321	7321	5411	5411	2706	2706	2706	7639	7639
		FEED	136	76	76	218	218	218	162	162	162	162	117	117	117	87	87	32	32	32	214	214
		Ae	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028
	10-11.1	Vc	64	48	48	87	87	87	79	79	79	79	70	70	70	52	52	26	26	26	94	94
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.007	0.007
		RPM	13581	10186	10186	13846	13846	13846	12573	12573	12573	12573	11141	11141	11141	8276	8276	4138	4138	4138	11968	11968
		FEED	217	122	122	332	332	332	251	251	251	251	223	223	223	132	132	66	66	66	335	335
		Ae	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037
	11.2	Vc	40	30	30	57	57	57	51	51	51	51	46	46	46	34	34	17	17	17	60	60
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.007	0.007
		RPM	8488	6366	6366	9072	9072	9072	8117	8117	8117	8117	7321	7321	7321	5411	5411	2706	2706	2706	7639	7639
		FEED	136	76	76	218	218	218	162	162	162	162	117	117	117	87	87	32	32	32	214	214
		Ae	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028
K	15-20	Vc	64	48	48	87	87	87	79	79	79	79	70	70	70	52	52	26	26	26	94	94
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.007	0.007
		RPM	13581	10186	10186	13846	13846	13846	12573	12573	12573	12573	11141	11141	11141	8276	8276	4138	4138	4138	11968	11968
		FEED	217	122	122	332	332	332	251	251	251	251	223	223	223	132	132	66	66	66	335	335
		Ae	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037
H	38.1 - 38.2	Vc	25	18	18	38	38	38	34	34	34	34	30	30	30	23	23	11	11	11	35	35
		fz	0.001	0.001	0.001	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.003	0.003
		RPM	5305	3820	3820	6048	6048	6048	5411	5411	5411	5411	4775	4775	4775	3661	3661	1751	1751	1751	4456	4456
		FEED	21	15	15	73	73	73	43	43	43	43	38	38	38	29	29	7	7	7	53	53
		Ae	0.003	0.002	0.002	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.003	0.003	0.022	0.022
	40	Vc	40	30	30	57	57	57	51	51	51	51	46	46	46	34	34	17	17	17	60	60
		fz	0.004	0.003	0.003	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.007	0.007
		RPM	8488	6366	6366	9072	9072	9072	8117	8117	8117	8117	7321	7321	7321	5411	5411	2706	2706	2706	7639	7639
		FEED	136	76	76	218	218	218	162	162	162	162	117	117	117	87	87	32	32	32	214	214
		Ae	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028
	41	Vc	25	18	18	38	38	38	34	34	34	34	30	30	30	23	23	11	11	11	35	35
		fz	0.001	0.001	0.001	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.003	0.003
		RPM	5305	3820	3820	6048	6048	6048	5411	5411	5411	5411	4775	4775	4775	3661	3661	1751	1751	1751	4456	4456
		FEED	21	15	15	73	73	73	43	43	43	43	38	38	38	29	29	7	7	7	53	53
		Ae	0.003	0.002	0.002	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.006	0.006	0.004	0.003	0.003	0.003	0.003	0.003	0.022	0.022

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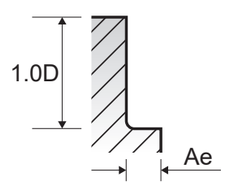

SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																				
		2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	LBS	12	14	16	18	20	22	26	30	35	40	45	50	6	8	10	12	14	16	18	20	22	26
1-5	Vc	94	85	85	85	85	85	75	75	75	57	57	57	101	101	101	101	101	91	91	91	91	91
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	11968	10823	10823	10823	10823	10823	9549	9549	9549	7257	7257	7257	10716	10716	10716	10716	10716	9655	9655	9655	9655	9655
	FEED	335	303	303	303	303	303	229	229	229	145	145	145	386	386	386	386	386	309	309	309	309	309
	Ae	0.037	0.021	0.021	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044	0.044	0.025	0.025	0.025	0.025	0.016
6-8	Vc	94	85	85	85	85	85	75	75	75	57	57	57	101	101	101	101	101	91	91	91	91	91
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	11968	10823	10823	10823	10823	10823	9549	9549	9549	7257	7257	7257	10716	10716	10716	10716	10716	9655	9655	9655	9655	9655
	FEED	335	303	303	303	303	303	229	229	229	145	145	145	386	386	386	386	386	309	309	309	309	309
	Ae	0.037	0.021	0.021	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044	0.044	0.025	0.025	0.025	0.025	0.016
9	Vc	60	54	54	54	54	54	48	48	48	36	36	36	63	63	63	63	63	57	57	57	57	57
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	7639	6875	6875	6875	6875	6875	6112	6112	6112	4584	4584	4584	6685	6685	6685	6685	6685	6048	6048	6048	6048	6048
	FEED	214	193	193	193	193	193	147	147	147	92	92	92	241	241	241	241	241	194	194	194	194	194
	Ae	0.028	0.016	0.016	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033	0.033	0.019	0.019	0.019	0.019	0.012
10-11.1	Vc	94	85	85	85	85	85	75	75	75	57	57	57	101	101	101	101	101	91	91	91	91	91
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	11968	10823	10823	10823	10823	10823	9549	9549	9549	7257	7257	7257	10716	10716	10716	10716	10716	9655	9655	9655	9655	9655
	FEED	335	303	303	303	303	303	229	229	229	145	145	145	386	386	386	386	386	309	309	309	309	309
	Ae	0.037	0.021	0.021	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044	0.044	0.025	0.025	0.025	0.025	0.016
11.2	Vc	60	54	54	54	54	54	48	48	48	36	36	36	63	63	63	63	63	57	57	57	57	57
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	7639	6875	6875	6875	6875	6875	6112	6112	6112	4584	4584	4584	6685	6685	6685	6685	6685	6048	6048	6048	6048	6048
	FEED	214	193	193	193	193	193	147	147	147	92	92	92	241	241	241	241	241	194	194	194	194	194
	Ae	0.028	0.016	0.016	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033	0.033	0.019	0.019	0.019	0.019	0.012
15-20	Vc	94	85	85	85	85	85	75	75	75	57	57	57	101	101	101	101	101	91	91	91	91	91
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	11968	10823	10823	10823	10823	10823	9549	9549	9549	7257	7257	7257	10716	10716	10716	10716	10716	9655	9655	9655	9655	9655
	FEED	335	303	303	303	303	303	229	229	229	145	145	145	386	386	386	386	386	309	309	309	309	309
	Ae	0.037	0.021	0.021	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044	0.044	0.025	0.025	0.025	0.025	0.016
38.1 - 38.2	Vc	35	32	32	32	32	32	28	28	28	21	21	21	38	38	38	38	38	34	34	34	34	34
	fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	4456	4074	4074	4074	4074	4074	3565	3565	3565	2674	2674	2674	4032	4032	4032	4032	4032	3608	3608	3608	3608	3608
	FEED	53	49	49	49	49	49	43	43	43	21	21	21	65	65	65	65	65	58	58	58	58	58
	Ae	0.022	0.013	0.013	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.038	0.038	0.026	0.026	0.026	0.015	0.015	0.015	0.015	0.009
40	Vc	60	54	54	54	54	54	48	48	48	36	36	36	63	63	63	63	63	57	57	57	57	57
	fz	0.007	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005	0.005	0.009	0.009	0.009	0.009	0.009	0.008	0.008	0.008	0.008	0.008
	RPM	7639	6875	6875	6875	6875	6875	6112	6112	6112	4584	4584	4584	6685	6685	6685	6685	6685	6048	6048	6048	6048	6048
	FEED	214	193	193	193	193	193	147	147	147	92	92	92	241	241	241	241	241	194	194	194	194	194
	Ae	0.028	0.016	0.016	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033	0.033	0.019	0.019	0.019	0.019	0.012
41	Vc	35	32	32	32	32	32	28	28	28	21	21	21	38	38	38	38	38	34	34	34	34	34
	fz	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
	RPM	4456	4074	4074	4074	4074	4074	3565	3565	3565	2674	2674	2674	4032	4032	4032	4032	4032	3608	3608	3608	3608	3608
	FEED	53	49	49	49	49	49	43	43	43	21	21	21	65	65	65	65	65	58	58	58	58	58
	Ae	0.022	0.013	0.013	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.038	0.038	0.026	0.026	0.026	0.015	0.015	0.015	0.015	0.009

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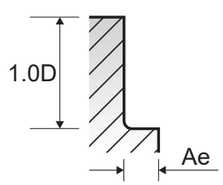

SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			3.0	3.0	3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
		LBS	30	35	40	45	50	60	8	10	12	14	16	18	20	22	26	30	35	40	45	50
P	1-5	Vc	91	81	81	81	61	61	114	114	114	114	114	114	114	103	103	103	103	103	91	91
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	9655	8594	8594	8594	6472	6472	9072	9072	9072	9072	9072	9072	9072	8196	8196	8196	8196	8196	7242	7242
		FEED	309	241	241	241	155	155	689	689	689	689	689	689	689	557	557	557	557	557	434	434
		Ae	0.016	0.016	0.009	0.009	0.006	0.006	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021	0.021
	6-8	Vc	91	81	81	81	61	61	114	114	114	114	114	114	114	103	103	103	103	103	91	91
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	9655	8594	8594	8594	6472	6472	9072	9072	9072	9072	9072	9072	9072	8196	8196	8196	8196	8196	7242	7242
		FEED	309	241	241	241	155	155	689	689	689	689	689	689	689	557	557	557	557	557	434	434
		Ae	0.016	0.016	0.009	0.009	0.006	0.006	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021	0.021
	9	Vc	57	50	50	50	38	38	70	70	70	70	70	70	70	63	63	63	63	63	56	56
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	6048	5305	5305	5305	4032	4032	5570	5570	5570	5570	5570	5570	5570	5013	5013	5013	5013	5013	4456	4456
		FEED	194	149	149	149	97	97	423	423	423	423	423	423	423	341	341	341	341	341	267	267
		Ae	0.012	0.012	0.007	0.007	0.005	0.005	0.063	0.063	0.063	0.044	0.044	0.044	0.044	0.025	0.025	0.025	0.016	0.016	0.016	0.016
	10-11.1	Vc	91	81	81	81	61	61	114	114	114	114	114	114	114	103	103	103	103	103	91	91
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	9655	8594	8594	8594	6472	6472	9072	9072	9072	9072	9072	9072	9072	8196	8196	8196	8196	8196	7242	7242
		FEED	309	241	241	241	155	155	689	689	689	689	689	689	689	557	557	557	557	557	434	434
		Ae	0.016	0.016	0.009	0.009	0.006	0.006	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021	0.021
	11.2	Vc	57	50	50	50	38	38	70	70	70	70	70	70	70	63	63	63	63	63	56	56
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	6048	5305	5305	5305	4032	4032	5570	5570	5570	5570	5570	5570	5570	5013	5013	5013	5013	5013	4456	4456
		FEED	194	149	149	149	97	97	423	423	423	423	423	423	423	341	341	341	341	341	267	267
		Ae	0.012	0.012	0.007	0.007	0.005	0.005	0.063	0.063	0.063	0.044	0.044	0.044	0.044	0.025	0.025	0.025	0.016	0.016	0.016	0.016
K	15-20	Vc	91	81	81	81	61	61	114	114	114	114	114	114	114	103	103	103	103	103	91	91
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	9655	8594	8594	8594	6472	6472	9072	9072	9072	9072	9072	9072	9072	8196	8196	8196	8196	8196	7242	7242
		FEED	309	241	241	241	155	155	689	689	689	689	689	689	689	557	557	557	557	557	434	434
		Ae	0.016	0.016	0.009	0.009	0.006	0.006	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021	0.021
H	38.1 - 38.2	Vc	34	30	30	30	23	23	44	44	44	44	44	44	44	40	40	40	40	40	35	35
		fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
		RPM	3608	3183	3183	3183	2440	2440	3501	3501	3501	3501	3501	3501	3501	3183	3183	3183	3183	3183	2785	2785
		FEED	58	38	38	38	29	29	70	70	70	70	70	70	70	51	51	51	51	51	45	45
		Ae	0.009	0.009	0.006	0.006	0.004	0.004	0.05	0.05	0.05	0.035	0.035	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.013	0.013
	40	Vc	57	50	50	50	38	38	70	70	70	70	70	70	70	63	63	63	63	63	56	56
		fz	0.008	0.007	0.007	0.007	0.006	0.006	0.019	0.019	0.019	0.019	0.019	0.019	0.019	0.017	0.017	0.017	0.017	0.017	0.015	0.015
		RPM	6048	5305	5305	5305	4032	4032	5570	5570	5570	5570	5570	5570	5570	5013	5013	5013	5013	5013	4456	4456
		FEED	194	149	149	149	97	97	423	423	423	423	423	423	423	341	341	341	341	341	267	267
		Ae	0.012	0.012	0.007	0.007	0.005	0.005	0.063	0.063	0.063	0.044	0.044	0.044	0.044	0.025	0.025	0.025	0.016	0.016	0.016	0.016
	41	Vc	34	30	30	30	23	23	44	44	44	44	44	44	44	40	40	40	40	40	35	35
		fz	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.004
		RPM	3608	3183	3183	3183	2440	2440	3501	3501	3501	3501	3501	3501	3501	3183	3183	3183	3183	3183	2785	2785
		FEED	58	38	38	38	29	29	70	70	70	70	70	70	70	51	51	51	51	51	45	45
		Ae	0.009	0.009	0.006	0.006	0.004	0.004	0.05	0.05	0.05	0.035	0.035	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.013	0.013

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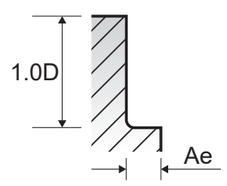
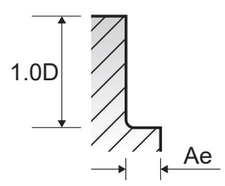


SEME73 SERIES 4 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ae = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																					
		4.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	6.0	6.0	6.0	6.0	8.0	8.0	8.0	10.0	10.0	10.0	12.0	12.0	12.0
	LBS	60	16	20	26	30	35	40	50	60	15	20	30	32	25	30	42	30	35	45	35	40	50
1-5	Vc	91	119	119	107	107	107	107	107	95	126	126	126	113	127	127	114	123	123	123	124	124	124
	fz	0.015	0.024	0.024	0.022	0.022	0.022	0.022	0.022	0.019	0.03	0.03	0.03	0.027	0.042	0.042	0.038	0.047	0.047	0.047	0.047	0.047	0.047
	RPM	7242	7576	7576	6812	6812	6812	6812	6812	6048	6685	6685	6685	5995	5053	5053	4536	3915	3915	3915	3289	3289	3289
	FEED	434	727	727	599	599	599	599	599	460	802	802	802	647	849	849	689	736	736	736	618	618	618
	Ae	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176
6-8	Vc	91	119	119	107	107	107	107	107	95	126	126	126	113	127	127	114	123	123	123	124	124	124
	fz	0.015	0.024	0.024	0.022	0.022	0.022	0.022	0.022	0.019	0.03	0.03	0.03	0.027	0.042	0.042	0.038	0.047	0.047	0.047	0.047	0.047	0.047
	RPM	7242	7576	7576	6812	6812	6812	6812	6812	6048	6685	6685	6685	5995	5053	5053	4536	3915	3915	3915	3289	3289	3289
	FEED	434	727	727	599	599	599	599	599	460	802	802	802	647	849	849	689	736	736	736	618	618	618
	Ae	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176
9	Vc	56	71	71	64	64	64	64	64	57	76	76	76	68	76	76	68	75	75	75	76	76	76
	fz	0.015	0.024	0.024	0.021	0.021	0.021	0.021	0.021	0.019	0.03	0.03	0.03	0.027	0.037	0.037	0.034	0.038	0.038	0.038	0.037	0.037	0.037
	RPM	4456	4520	4520	4074	4074	4074	4074	4074	3629	4032	4032	4032	3608	3024	3024	2706	2387	2387	2387	2016	2016	2016
	FEED	267	434	434	342	342	342	342	342	276	484	484	484	390	448	448	368	363	363	363	298	298	298
	Ae	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132
10-11.1	Vc	91	119	119	107	107	107	107	107	95	126	126	126	113	127	127	114	123	123	123	124	124	124
	fz	0.015	0.024	0.024	0.022	0.022	0.022	0.022	0.022	0.019	0.03	0.03	0.03	0.027	0.042	0.042	0.038	0.047	0.047	0.047	0.047	0.047	0.047
	RPM	7242	7576	7576	6812	6812	6812	6812	6812	6048	6685	6685	6685	5995	5053	5053	4536	3915	3915	3915	3289	3289	3289
	FEED	434	727	727	599	599	599	599	599	460	802	802	802	647	849	849	689	736	736	736	618	618	618
	Ae	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176
11.2	Vc	56	71	71	64	64	64	64	64	57	76	76	76	68	76	76	68	75	75	75	76	76	76
	fz	0.015	0.024	0.024	0.021	0.021	0.021	0.021	0.021	0.019	0.03	0.03	0.03	0.027	0.037	0.037	0.034	0.038	0.038	0.038	0.037	0.037	0.037
	RPM	4456	4520	4520	4074	4074	4074	4074	4074	3629	4032	4032	4032	3608	3024	3024	2706	2387	2387	2387	2016	2016	2016
	FEED	267	434	434	342	342	342	342	342	276	484	484	484	390	448	448	368	363	363	363	298	298	298
	Ae	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132
15-20	Vc	91	119	119	107	107	107	107	107	95	126	126	126	113	127	127	114	123	123	123	124	124	124
	fz	0.015	0.024	0.024	0.022	0.022	0.022	0.022	0.022	0.019	0.03	0.03	0.03	0.027	0.042	0.042	0.038	0.047	0.047	0.047	0.047	0.047	0.047
	RPM	7242	7576	7576	6812	6812	6812	6812	6812	6048	6685	6685	6685	5995	5053	5053	4536	3915	3915	3915	3289	3289	3289
	FEED	434	727	727	599	599	599	599	599	460	802	802	802	647	849	849	689	736	736	736	618	618	618
	Ae	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176
38.1 - 38.2	Vc	35	44	44	39	39	39	39	39	35	45	45	45	41	51	51	45	51	51	51	53	53	53
	fz	0.004	0.008	0.008	0.007	0.007	0.007	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.016	0.016	0.015	0.016	0.016	0.016	0.017	0.017	0.017
	RPM	2785	2801	2801	2483	2483	2483	2483	2483	2228	2387	2387	2387	2175	2029	2029	1790	1623	1623	1623	1406	1406	1406
	FEED	45	90	90	70	70	70	70	70	53	95	95	95	78	130	130	107	104	104	104	96	96	96
	Ae	0.008	0.044	0.044	0.025	0.025	0.025	0.025	0.016	0.016	0.076	0.053	0.053	0.03	0.071	0.071	0.04	0.126	0.088	0.088	0.151	0.106	0.106
40	Vc	56	71	71	64	64	64	64	64	57	76	76	76	68	76	76	68	75	75	75	76	76	76
	fz	0.015	0.024	0.024	0.021	0.021	0.021	0.021	0.021	0.019	0.03	0.03	0.03	0.027	0.037	0.037	0.034	0.038	0.038	0.038	0.037	0.037	0.037
	RPM	4456	4520	4520	4074	4074	4074	4074	4074	3629	4032	4032	4032	3608	3024	3024	2706	2387	2387	2387	2016	2016	2016
	FEED	267	434	434	342	342	342	342	342	276	484	484	484	390	448	448	368	363	363	363	298	298	298
	Ae	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132
41	Vc	35	44	44	39	39	39	39	39	35	45	45	45	41	51	51	45	51	51	51	53	53	53
	fz	0.004	0.008	0.008	0.007	0.007	0.007	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.016	0.016	0.015	0.016	0.016	0.016	0.017	0.017	0.017
	RPM	2785	2801	2801	2483	2483	2483	2483	2483	2228	2387	2387	2387	2175	2029	2029	1790	1623	1623	1623	1406	1406	1406
	FEED	45	90	90	70	70	70	70	70	53	95	95	95	78	130	130	107	104	104	104	96	96	96
	Ae	0.008	0.044	0.044	0.025	0.025	0.025	0.025	0.016	0.016	0.076	0.053	0.053	0.03	0.071	0.071	0.04	0.126	0.088	0.088	0.151	0.106	0.106



SEME75 SERIES 6 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

NORMAL SPEED

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						6.0	6.0	6.0	8.0	8.0	8.0	8.0	10.0	10.0	10.0
					LOC	15	20	30	20	30	35	40	25	30	40
P	1-5	Non-alloy steel	0.1D	1.5D	Vc	110	110	110	111	111	111	111	111	111	111
					fz	0.06	0.06	0.051	0.079	0.079	0.079	0.067	0.099	0.099	0.099
					RPM	5836	5836	5836	4417	4417	4417	4417	3533	3533	3533
					FEED	2101	2101	1786	2093	2093	2093	1775	2099	2099	2099
	6-8	Low alloy steel	0.1D	1.5D	Vc	110	110	110	111	111	111	111	111	111	111
					fz	0.06	0.06	0.051	0.079	0.079	0.079	0.067	0.099	0.099	0.099
					RPM	5836	5836	5836	4417	4417	4417	4417	3533	3533	3533
					FEED	2101	2101	1786	2093	2093	2093	1775	2099	2099	2099
	9		0.05D	1.5D	Vc	77	77	77	78	78	78	78	76	76	76
					fz	0.059	0.059	0.05	0.078	0.078	0.078	0.066	0.099	0.099	0.099
					RPM	4085	4085	4085	3104	3104	3104	3104	2419	2419	2419
					FEED	1446	1446	1225	1452	1452	1452	1229	1437	1437	1437
	10-11.1	High alloyed steel, and tool steel	0.1D	1.5D	Vc	110	110	110	111	111	111	111	111	111	111
					fz	0.06	0.06	0.051	0.079	0.079	0.079	0.067	0.099	0.099	0.099
					RPM	5836	5836	5836	4417	4417	4417	4417	3533	3533	3533
					FEED	2101	2101	1786	2093	2093	2093	1775	2099	2099	2099
	11.2		0.05D	1.5D	Vc	77	77	77	78	78	78	78	76	76	76
					fz	0.059	0.059	0.05	0.078	0.078	0.078	0.066	0.099	0.099	0.099
					RPM	4085	4085	4085	3104	3104	3104	3104	2419	2419	2419
					FEED	1446	1446	1225	1452	1452	1452	1229	1437	1437	1437
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	Vc	110	110	110	111	111	111	111	111	111	111
					fz	0.06	0.06	0.051	0.079	0.079	0.079	0.067	0.099	0.099	0.099
					RPM	5836	5836	5836	4417	4417	4417	4417	3533	3533	3533
					FEED	2101	2101	1786	2093	2093	2093	1775	2099	2099	2099
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	Vc	31	31	31	31	31	31	31	33	33	33
					fz	0.022	0.022	0.019	0.03	0.03	0.03	0.026	0.035	0.035	0.035
					RPM	1645	1645	1645	1233	1233	1233	1233	1050	1050	1050
					FEED	217	217	187	222	222	222	192	221	221	221
	40	Chilled Cast Iron	0.05D	1.5D	Vc	77	77	77	78	78	78	78	76	76	76
					fz	0.059	0.059	0.05	0.078	0.078	0.078	0.066	0.099	0.099	0.099
					RPM	4085	4085	4085	3104	3104	3104	3104	2419	2419	2419
					FEED	1446	1446	1225	1452	1452	1452	1229	1437	1437	1437
	41	Hardened Cast Iron	0.05D	1.0D	Vc	31	31	31	31	31	31	31	33	33	33
					fz	0.022	0.022	0.019	0.03	0.03	0.03	0.026	0.035	0.035	0.035
					RPM	1645	1645	1645	1233	1233	1233	1233	1050	1050	1050
					FEED	217	217	187	222	222	222	192	221	221	221

HIGH SPEED

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						6.0	6.0	6.0	8.0	8.0	8.0	8.0	10.0	10.0	10.0
					LOC	15	20	30	20	30	35	40	25	30	40
P	11.2	High alloyed steel, and tool steel	0.05D	1.5D	Vc	333	333	333	333	333	333	333	329	329	329
					fz	0.06	0.06	0.051	0.081	0.081	0.081	0.068	0.1	0.1	0.1
					RPM	17666	17666	17666	13250	13250	13250	13250	10472	10472	10472
					FEED	6360	6360	5406	6439	6439	6439	5406	6283	6283	6283
H	38.1 - 38.2	Hardened steel	0.05D	1.0D	Vc	166	166	166	166	166	166	166	166	166	166
					fz	0.061	0.061	0.051	0.081	0.081	0.081	0.069	0.101	0.101	0.101
					RPM	8807	8807	8807	6605	6605	6605	6605	5284	5284	5284
					FEED	3223	3223	2695	3210	3210	3210	2734	3202	3202	3202
	40	Chilled Cast Iron	0.05D	1.5D	Vc	333	333	333	333	333	333	333	329	329	329
					fz	0.06	0.06	0.051	0.081	0.081	0.081	0.068	0.1	0.1	0.1
					RPM	17666	17666	17666	13250	13250	13250	13250	10472	10472	10472
					FEED	6360	6360	5406	6439	6439	6439	5406	6283	6283	6283
	41	Hardened Cast Iron	0.05D	1.0D	Vc	166	166	166	166	166	166	166	166	166	166
					fz	0.061	0.061	0.051	0.081	0.081	0.081	0.069	0.101	0.101	0.101
					RPM	8807	8807	8807	6605	6605	6605	6605	5284	5284	5284
					FEED	3223	3223	2695	3210	3210	3210	2734	3202	3202	3202

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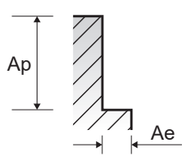


SEME75 SERIES 6 FLUTE - SIDE CUTTING

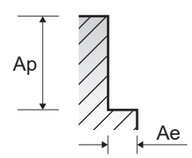
Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

NORMAL SPEED

VDI 3323	Parameter	Diameter (Ø)													
		10.0	12.0	12.0	12.0	12.0	16.0	16.0	16.0	16.0	16.0	20.0	20.0	20.0	20.0
	LOC	50	30	40	50	60	40	50	60	90	110	45	60	70	110
1-5	Vc	111	112	112	112	112	111	111	111	100	100	111	111	111	100
	fz	0.084	0.099	0.099	0.084	0.074	0.1	0.1	0.085	0.075	0.075	0.1	0.1	0.085	0.075
	RPM	3533	2971	2971	2971	2971	2208	2208	2208	1989	1989	1767	1767	1767	1592
	FEED	1781	1765	1765	1497	1319	1325	1325	1126	895	895	1060	1060	901	716
6-8	Vc	111	112	112	112	112	111	111	111	100	100	111	111	111	100
	fz	0.084	0.099	0.099	0.084	0.074	0.1	0.1	0.085	0.075	0.075	0.1	0.1	0.085	0.075
	RPM	3533	2971	2971	2971	2971	2208	2208	2208	1989	1989	1767	1767	1767	1592
	FEED	1781	1765	1765	1497	1319	1325	1325	1126	895	895	1060	1060	901	716
9	Vc	76	79	79	79	79	78	78	78	70	70	77	77	77	68
	fz	0.084	0.097	0.097	0.082	0.073	0.099	0.099	0.085	0.075	0.075	0.099	0.099	0.084	0.075
	RPM	2419	2096	2096	2096	2096	1552	1552	1552	1393	1393	1225	1225	1225	1082
	FEED	1219	1220	1220	1031	918	922	922	791	627	627	728	728	618	487
10-11.1	Vc	111	112	112	112	112	111	111	111	100	100	111	111	111	100
	fz	0.084	0.099	0.099	0.084	0.074	0.1	0.1	0.085	0.075	0.075	0.1	0.1	0.085	0.075
	RPM	3533	2971	2971	2971	2971	2208	2208	2208	1989	1989	1767	1767	1767	1592
	FEED	1781	1765	1765	1497	1319	1325	1325	1126	895	895	1060	1060	901	716
11.2	Vc	76	79	79	79	79	78	78	78	70	70	77	77	77	68
	fz	0.084	0.097	0.097	0.082	0.073	0.099	0.099	0.085	0.075	0.075	0.099	0.099	0.084	0.075
	RPM	2419	2096	2096	2096	2096	1552	1552	1552	1393	1393	1225	1225	1225	1082
	FEED	1219	1220	1220	1031	918	922	922	791	627	627	728	728	618	487
15-20	Vc	111	112	112	112	112	111	111	111	100	100	111	111	111	100
	fz	0.084	0.099	0.099	0.084	0.074	0.1	0.1	0.085	0.075	0.075	0.1	0.1	0.085	0.075
	RPM	3533	2971	2971	2971	2971	2208	2208	2208	1989	1989	1767	1767	1767	1592
	FEED	1781	1765	1765	1497	1319	1325	1325	1126	895	895	1060	1060	901	716
38.1 - 38.2	Vc	33	33	33	33	33	34	34	34	31	31	33	33	33	30
	fz	0.03	0.036	0.036	0.031	0.027	0.034	0.034	0.029	0.026	0.026	0.037	0.037	0.032	0.028
	RPM	1050	875	875	875	875	676	676	676	617	617	525	525	525	477
	FEED	189	189	189	163	142	138	138	118	96	96	117	117	101	80
40	Vc	76	79	79	79	79	78	78	78	70	70	77	77	77	68
	fz	0.084	0.097	0.097	0.082	0.073	0.099	0.099	0.085	0.075	0.075	0.099	0.099	0.084	0.075
	RPM	2419	2096	2096	2096	2096	1552	1552	1552	1393	1393	1225	1225	1225	1082
	FEED	1219	1220	1220	1031	918	922	922	791	627	627	728	728	618	487
41	Vc	33	33	33	33	33	34	34	34	31	31	33	33	33	30
	fz	0.03	0.036	0.036	0.031	0.027	0.034	0.034	0.029	0.026	0.026	0.037	0.037	0.032	0.028
	RPM	1050	875	875	875	875	676	676	676	617	617	525	525	525	477
	FEED	189	189	189	163	142	138	138	118	96	96	117	117	101	80

HIGH SPEED

VDI 3323	Parameter	Diameter (Ø)													
		10.0	12.0	12.0	12.0	12.0	16.0	16.0	16.0	16.0	16.0	20.0	20.0	20.0	20.0
	LOC	50	30	40	50	60	40	50	60	90	110	45	60	70	110
11.2	Vc	329	333	333	333	333	333	333	333	299	299	332	332	332	299
	fz	0.085	0.1	0.1	0.085	0.075	0.1	0.1	0.085	0.075	0.075	0.101	0.101	0.086	0.076
	RPM	10472	8833	8833	8833	8833	6625	6625	6625	5948	5948	5284	5284	5284	4759
	FEED	5341	5300	5300	4505	3975	3975	3975	3379	2677	2677	3202	3202	2727	2170
38.1 - 38.2	Vc	166	166	166	166	166	167	167	167	150	150	166	166	166	150
	fz	0.086	0.1	0.1	0.085	0.075	0.1	0.1	0.085	0.075	0.075	0.097	0.097	0.083	0.073
	RPM	5284	4403	4403	4403	4403	3322	3322	3322	2984	2984	2642	2642	2642	2387
	FEED	2727	2642	2642	2246	1981	1993	1993	1694	1343	1343	1538	1538	1316	1046
40	Vc	329	333	333	333	333	333	333	333	299	299	332	332	332	299
	fz	0.085	0.1	0.1	0.085	0.075	0.1	0.1	0.085	0.075	0.075	0.101	0.101	0.086	0.076
	RPM	10472	8833	8833	8833	8833	6625	6625	6625	5948	5948	5284	5284	5284	4759
	FEED	5341	5300	5300	4505	3975	3975	3975	3379	2677	2677	3202	3202	2727	2170
41	Vc	166	166	166	166	166	167	167	167	150	150	166	166	166	150
	fz	0.086	0.1	0.1	0.085	0.075	0.1	0.1	0.085	0.075	0.075	0.097	0.097	0.083	0.073
	RPM	5284	4403	4403	4403	4403	3322	3322	3322	2984	2984	2642	2642	2642	2387
	FEED	2727	2642	2642	2246	1981	1993	1993	1694	1343	1343	1538	1538	1316	1046



G9D75 G9D76 G9D77 G9D67 G9D68 G9D69 4&5 FLUTE CORNER RADIUS ROUGHING

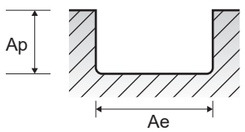
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

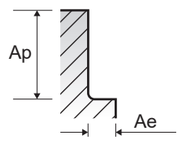
SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325
	4-5		1.0D	0.8D	Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
					RPM	10610	8157	6366	5438	4078	3183
					FEED	1103	1175	1171	1153	1040	891
	6	Low alloy steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325
	7-9		1.0D	0.8D	Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
					RPM	10610	8157	6366	5438	4078	3183
					FEED	1103	1175	1171	1153	1040	891
	10	High alloyed steel, and tool steel	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325
	11.1		1.0D	0.8D	Vc	200	205	200	205	205	200
					fz	0.026	0.036	0.046	0.053	0.051	0.056
					RPM	10610	8157	6366	5438	4078	3183
					FEED	1103	1175	1171	1153	1040	891
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	1.0D	Vc	225	225	225	225	225	225
					fz	0.032	0.046	0.057	0.064	0.067	0.074
					RPM	11937	8952	7162	5968	4476	3581
					FEED	1528	1647	1633	1528	1500	1325

SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 6.0	8.0	10.0	12.0	16.0	20.0
P	1-3	Non-alloy steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125
	4-5		0.35D	1.0D	Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
					RPM	14324	10743	8435	7162	5371	4297
					FEED	1833	1977	1923	1862	1746	1504
	6	Low alloy steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125
	7-9		0.35D	1.0D	Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
					RPM	14324	10743	8435	7162	5371	4297
					FEED	1833	1977	1923	1862	1746	1504
	10	High alloyed steel, and tool steel	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125
	11.1		0.35D	1.0D	Vc	270	270	265	270	270	270
					fz	0.032	0.046	0.057	0.065	0.065	0.07
					RPM	14324	10743	8435	7162	5371	4297
					FEED	1833	1977	1923	1862	1746	1504
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.0D	Vc	300	300	300	300	300	300
					fz	0.041	0.057	0.071	0.08	0.082	0.089
					RPM	15915	11937	9549	7958	5968	4775
					FEED	2610	2722	2712	2546	2447	2125

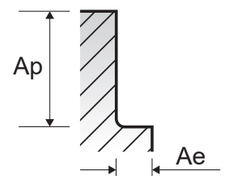




GAE53 SERIES 4&5 FLUTE CORNER RADIUS ROUGHING(HSS-PM) - SIDE CUTTING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	1	Non-alloy steel	0.5D	1.5D	Vc	60	70	70	70	70	70	70	70
					fz	0.019	0.027	0.05	0.06	0.055	0.063	0.072	0.08
					RPM	3183	2785	2228	1857	1592	1393	1238	1114
					FEED	242	301	446	446	438	439	446	446
	2		0.5D	1.5D	Vc	48	54	54	54	54	54	54	54
					fz	0.018	0.028	0.049	0.063	0.073	0.081	0.085	0.101
					RPM	2546	2149	1719	1432	1228	1074	955	859
					FEED	183	241	337	361	448	435	406	434
	3-4		0.5D	1.5D	Vc	34	38	38	38	38	38	38	38
					fz	0.017	0.027	0.043	0.059	0.069	0.08	0.086	0.1
					RPM	1804	1512	1210	1008	864	756	672	605
					FEED	123	163	208	238	298	302	289	302
	5		0.5D	1.5D	Vc	28	32	32	32	32	32	32	32
					fz	0.018	0.028	0.041	0.055	0.065	0.075	0.082	0.092
					RPM	1485	1273	1019	849	728	637	566	509
					FEED	107	143	167	187	236	239	232	234
	6	Low alloy steel	0.5D	1.5D	Vc	48	54	54	54	54	54	54	54
					fz	0.018	0.028	0.049	0.063	0.073	0.081	0.085	0.101
					RPM	2546	2149	1719	1432	1228	1074	955	859
					FEED	183	241	337	361	448	435	406	434
	7		0.5D	1.5D	Vc	34	38	38	38	38	38	38	38
					fz	0.017	0.027	0.043	0.059	0.069	0.08	0.086	0.1
					RPM	1804	1512	1210	1008	864	756	672	605
					FEED	123	163	208	238	298	302	289	302
	8-9		0.5D	1.5D	Vc	28	32	32	32	32	32	32	32
					fz	0.018	0.028	0.041	0.055	0.065	0.075	0.082	0.092
					RPM	1485	1273	1019	849	728	637	566	509
					FEED	107	143	167	187	236	239	232	234
	10	High alloyed steel, and tool steel	0.5D	1.5D	Vc	48	54	54	54	54	54	54	54
					fz	0.018	0.028	0.049	0.063	0.073	0.081	0.085	0.101
					RPM	2546	2149	1719	1432	1228	1074	955	859
					FEED	183	241	337	361	448	435	406	434
	11.1		0.5D	1.5D	Vc	28	32	32	32	32	32	32	32
					fz	0.018	0.028	0.041	0.055	0.065	0.075	0.082	0.092
					RPM	1485	1273	1019	849	728	637	566	509
					FEED	107	143	167	187	236	239	232	234
M	14.1	Stainless steel	0.5D	1.5D	Vc	33	36	36	36	36	36	36	36
					fz	0.019	0.029	0.045	0.064	0.074	0.085	0.093	0.107
					RPM	1751	1432	1146	955	819	716	637	573
					FEED	133	166	206	244	303	304	296	307
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.5D	Vc	48	54	54	54	54	54	54	54
					fz	0.018	0.028	0.049	0.063	0.073	0.081	0.085	0.101
					RPM	2546	2149	1719	1432	1228	1074	955	859
					FEED	183	241	337	361	448	435	406	434



ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	Examples	Page
P	1	Non-alloyed steel	About 0.15% C	Annealed	125		S15C, C15, 1015	189
	2		About 0.45% C	Annealed	190	13	S45C, C45, 1045	
	3		About 0.45% C	Quenched & tempered	250	25		
	4		About 0.75% C	Annealed	270	28	SK5, Ck75, 1080	
	5		About 0.75% C	Quenched & Tempered	300	32		
	6	Low-alloyed Steel		Annealed	180	10	SCM440, 42CrMo4, 410	
	7			Quenched & Tempered	275	29		
	8			Quenched & Tempered	300	32		
	9			Quenched & Tempered	350	38		
	10	High-alloyed steel, and tool steel		Annealed	200	15	SKD, D2	
	11			Quenched & Tempered	325	35	SKH, SUH, M42	
M	12	Stainless Steel	Ferritic / Martensitic	Annealed	200	15	SUS 420, X40Cr13, 420	197
	13		Martensitic	Quenched & Tempered	240	23		
	14		Austenitic		180	10	SUS 316, 316, X5CrNiMo 17 12 2	
K	15	Grey cast iron	Pearlitic / Ferritic		180	10	FC, GG, EN-GJL-250	198
	16		Pearlitic (Martensitic)		260	26		
	17	Nodular cast iron	Ferritic		160	3	FCD, GGG, EN-GJS-500-7	
	18		Pearlitic		250	25		
	19	Malleable cast iron	Ferritic		130		FCMW, FCMP, GTS, GJMB350-10	
	20		Pearlitic		230	21		
N	21	Aluminum-wrought alloy	Not Curable		60		SAE 1000, AlMg 1, 3.3315	200
	22		Curable	Hardened	100		SAE 7050, AlCuMg 1, 3.1325	
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		ADC12, G-AlSi12, 3.2581	
	24		≤ 12% Si, Curable	Hardened	90		C4BS, G-AlSi10Mg, 3.2381	
	25		> 12% Si, Not Curable		130			
	26	Copper and copper alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		CuZn36Pb 3, 2.0375	
	27		CuZn, CuSnZn (Brass)		90		CuZn 15, 2.0240	
	28		CuSn, lead-free copper and electrolytic copper		100		G-CuZn40Fe, 2.0590	
	29	Non-metallic materials	Duroplastic, Fiber Reinforced Plastic				CFRP	
	30		Rubber, Wood, etc.					
S	31	Heat resistant super alloys	Fe Based	Annealed	200	15	X12 NiCrSi 36-16, 1.4864	202
	32			Aged	280	30		
	33		Ni or Co Based	Annealed	250	25	Inconel 718, NiCr20TiAl, 2.4631	
	34			Aged	350	38	NiCu30Al, 2.4375	
	35			Cast	320	34	G-X120Mn12, 1.3401	
	36	Titanium alloys	Pure Titanium		400 Rm			
	37		Alpha + Beta Alloys	Hardened	1050Rm		TiAl6V4, 3.7165	
H	38	Hardened steel		Hardened	550	55	SK3	204
	39			Hardened	630	60		
	40	Chilled cast iron		Cast	400	42		
	41	Hardened cast iron		Hardened	550	55		

P	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
	1	Non-alloyed steel	About 0.15% C, Annealed	125	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0037	STKM 12 C	St 37-2	-	4360 40 B	S235JR	E24-2	1311	Fe 360 B			16D	
1.0038	STKM 12 A	St 37-3	A570.36	4360 40 C	S275J2G3	E28-3	1312	Fe 360 D FF			ST14KP	
1.0045	SM 490 YA	S 355 JR	-	-	S 1207	E36-2	-	Fe 510 BFN				
1.0050	SS 50	St 50-2	A570 Gr. 50	4360 50 B	E 295	A50-2	2172	Fe 490			ST5PS	
1.0060	SM 58	St 60-2	A572 Gr. 65	4360 55 E	-	A60-2	1650	Fe 60-2			ST6PS	
1.0114		S 235 J0	-	En 40C	S 235 J0	E24-3		Fe 360 CFN				
1.0143		S 275 J0	-	-	S 275 J0	E28-3	1414	Fe 430 C				
1.0144	SM41C, SM400	St 44-3 N	A573 Gr. 81	4360 43C	S 275 J2 G3	E28-3	1412	Fe 430 D FF			ST14KP	
1.0149		Ro St 44-2	-	43C	S 275 J0 H	-	1412	Fe430C				
1.0301	S10C	C10	1010	045M10	C10	34C10, XC10		C10	F.1511	G10100	10	
1.0330	SPCC	St 12	-	DC 01	Fe P01	DC 01/Fe P01	1142	Fe P01			15KP	
1.0335	SPHE	D D 13 (StW 24)	A622(1008)	H S 3	D D 13	3C		FeP13			08KP	
1.0338	SPCE	St 4	A620(1008)	14491CR	Fe P04	Fe 14	1147	DC04/FeP04			08JU	
1.0345	SPV 50	P235 GH	A516 Gr. 65	P 235 GH	P 235 GH	A 37 CP	1330	Fe E 235		K02503		
1.0401	S15C	C15	1015	080M15	-	C18RR, XC18	1350	C15, C16	F.1110	G10170	15	
1.0402	S20C	C22	1020	050 A 20	1 C 22	C20	1450	C 20	F.1120	G10200	20	
1.0425	SPV315	P265GH/HII				A42CP	1430	Fe4101KW		K02801	16K	
1.0443	SC 450	GS-45	A2765-35	A1		E23-45M	1305					
1.0539		S355NH				TSE355-4	2134	Fe510B				
1.0545		S355N		4360-50E		E355R	2334	FeE355KG				
1.0546		S355NL		4360-50EE		E355FP	2135	FeE355KT				
1.0547		S355J0H		4360-50C		TSE355-3	2172	Fe510C				
1.0549		S355NLH					2135	Fe510D				
1.0553	SM 520 M	St52-3U	A14880-40	4360-50C		320-560M	1606	Fe510C				
1.0562	SM490A	St E 355	A633 Gr. C	P 355 N		FeE355KGN	2132	Fe E 355 KG		K12000	15GF	
1.0565		W St E 355		P 355 NH		P 355 NH	2106	Fe E 355 KW		K01600		
1.0566	SLA 37	T St E 355		P 355 NL1		P 355 NL1	2107	Fe E 355 KT				
1.0570	SM 50 YA	St 52-3	1	4360-50 C	S355JR	E36-3	2172	Fe 510 B			17G1S	
1.0715	SUM22	9SMn28	1213	230M07		S250	1912	CFSMn28	F.2111	G12130		
1.0718	SUM22L	9SMnPb28	12L13			S250Pb	1914	CF9SMnPb28	F.2112	G12134		
1.0721		10S20	1108	10S20		10S20		CF10S20	F.2121	G11080		
1.0722		10SPb20	11L08			10PbF2		CF10SPb20		G11084		
1.0736	SUM25	9SMn36	1215			S300		CF9Mn36	F.2113	G12150		
1.0737		9SMnPb36	12L14			S300Pb	1926	CF9SMnPb36	F.2114	G12144		
1.0972		S315MC		1501-40F30		E315D						
1.0976		S355MC		1501-43F35		E355D	2642	FeE355TM				
1.0982		S460MC		1501-50F45								
1.0984		S500MC				E490D	2662	FeE490TM				
1.0986		S500MC		1501-60F55		E560D		FeE560TM				
1.1121	S10C	Ck10	1010	040A10		XC10	1265	C10	F.1510	G10100	10	
1.1141	S15	Ck15	1015	040A15	32C	XC15	1370	C15	F.1110	G10150	15	
1.1151	S20C	C22E	1020	055M15		2C22	1450	C20	F.1120	G10230	20	
1.8900	S25C	StE380	A572-60	436055E			2145	FeE390KG				
		St44-2	A36	436043A		NFA35-501E28	1411					
		StE320-3Z		1501160			1421					

P — VDI 3323 2

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Non-alloyed steel	About 0.45% C, Annealed	190	13

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0501	S35C	C35	1035	080A32		1C35	1572	C35	F.113	G10350	35	
1.0503	S45C	C45	1045	060A47		XC42H1TS	1672	C45	F.114	G10450	45	
1.0511	S40C	C40	1040	080M40		1C40		C40	F.114.A	G10400	40	
1.0540	S 50 C	C50					1674	C50		G10500		
1.0551		GS-52	A2770-36	A2		280-480M	1505					
1.0553	SM 520 M	St52-3U	A14880-40	4360-50C		320-560M	1606	Fe510C				
1.0577		S 355 J 2 G 4	A738	Fe 510 D 2 FF		A52FP	2107					
1.0726		35S20	1140	212M36	8M	35MF6	1957			G11400	40	
1.0727		45S20	1146			45MF4	1973			G11460		
1.1157		40Mn4	1039	150M36	15	40M5				G10390	40G	
1.1158	S25C	C25E	1025	070M25		XC25		C25	F.1120	G10250	25	
1.1166	SMn433H	34Mn5	1536						TO.B	G15360		
1.1167	SMn438(H)	36Mn5	1335	150M36		40M5	2120	36Mn6	F.1203	G13350	35G2	
1.1170	SCMn1	28Mn6	1330	150M28	14A	20M5		C28Mn	28Mn6	G13300	30G	
1.1178	S 30 C	C30E		080M30		XC32		C30	2C30	G10300		
1.1180		C35R	1035	080A35		3C35	1572		F.1135	G10350		
1.1181	S35C	C35E	1035	080A35		XC38	1572	C36	F.1130	G10340	35	
1.1191	S45C	Ck45	1045	080A46		XC45	1672	C45	F.1140		45	
1.1206	S 50 C	C50E	1050	080M50		2C50	1674	C50		G10500	50	
1.1213	S50C	Cf53	1050	070M55		XC48HTS	1674	C53		G10500	50	

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
Non-alloyed steel	About 0.45% C, Annealed	250	25

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0481	SG365	17 Mn 4/P 295 GH	A516 Gr. 70	224-460B	P 295 GH	A 48 CP	2102	Fe E 295	A47RCI	K03501	14G2	
1.0501	S35C	C35	1035	080A32		1C35	1572	C35	F.1130	G10350	35	
1.0503	S45C	C45	1045	060A47		XC42H1TS	1672	C45	F.1140	G10450	45	
1.0614		C76D	1074			XC75				G10750		
1.0616		C86D	1086			XC80		C85		G10860		
1.0618		C92D	1095			XC90				G10950		
1.0726		35S20	1140	212M36	8M	35MF6	1957			G11400	40	
1.1157		40Mn4	1039	150M36	15	40M5				G10390	40G	
1.1165	SMn433H	30Mn5	1036	120M36		35M5		30Mn5	F.8211	K13300	30G2	
1.1167	SMn438(H)	36Mn5	1335	150M36		40M5	2120	36Mn6	F.1203	G13350	35G2	
1.1186	S40C	C40E	1040	060A40		2C40		C40		G10400		
1.1191	S45C	Ck45	1045	080M46		2C45	1672	C45	F.1140		45	
1.1201	S50C	C45R	1049	080M46		3C45	1660	C45	F.1145		38HM	
1.1213	S50C	Cf53	1050	070M55		XC48HTS	1674	C53		G10500	50	
1.7242	SCM 418 H	18CrMo4										
1.7337		16CrMo4-4	A387 Gr.12					A18CrMo45KW		K11564	15C M	
1.7362	SCMV 6	12CrMo195		3606-625		Z10CD5-05		16CrMo205		K41545		
		17MnV6	A572-60	436055E		NFA35-501E36	2142					

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
Non-alloyed steel	About 0.75% C, Annealed	270	28

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0603	S 70 C -CSP	C67	107	080A67		XC65		C67		G10700		
1.0605		C75	1075	144980HS				C75		G10740	75	
1.1203	S55C	Ck55	1055	060A57		2C55	1655	C55	F.1150	G10550	55	
1.1209		C55R	1055	070M55		3C55		C55	F.1155	G10550		
1.1221	S58C	Ck60	1060	060A62	43D	2C60	1678	C60	F.1150	G10640	60	
1.1231	S 70 C-CSP	C67E	1070	060A67		XC68	1770	C70	F.5103	G10700	65GA	
1.1248	C 75	C75E	1074	060A78		XC75	1774	C75	F.5107	G10800	75(A)	
1.1269	SK 5 -CSP	C85E	1086			XC90		C90		G10900	85(A)	
1.1274	SUP4	Ck 101	1095	060 A 96	C 100S	XC100	1870	C100	F.5117	G10950		
1.1545	SK 3	C 105 W1	W1	BW 2	C 105U	Y1 105	1880	C 100 KU	F.5118		U10A	
1.1663	SK 2	C125W	W112			Y2120					U13	

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
Non-alloyed steel	About 0.75% C, Quenched & Tempered	300	32

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0070		St 70-2	1055	Fe690-2FN	-	A70-2	1655	Fe 690	F.1150		55	
1.0535	S55C	C55	1055	070M55		1C55	1655	C55		J05000	55	
1.0601	S58C	C60	1060	060A62	43D	1C60		C60		G10600	60(G)	
1.1203	S55C	Ck55	1055	060A57		2C55	1655	C55	F.1150	G10550	55	
1.1221	S58C	Ck60	1060	060A62	43D	2C60	1678	C60	F.1150	G10640	60	
1.1274	SUP4	Ck 101	1095	060 A 96	C 100S	XC100	1870	C100	F.5117	G10950		
1.1545	SK 3	C 105 W1	W1	BW 2	C 105U	Y1 105	1880	C 100 KU	F.5118		U10A	
1.1663	SK 2	C125W	W112			Y2120					U13	
1.5120		38MnSi4										
1.5710	SNC236	36NiCr6	3135	640A35	111A	35NC6						
1.7701		51CrMoV4						51CrMoV4				

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Material Description: Low-alloyed Steel
Composition / Structure / Heat Treatment: Annealed
HB: 180
HRc: 10

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0116		St 37-3	A570 Gr. 36	4360-40C	S 235 J2 G3	E24-3	1312	Fe 360 D1(2)	AE235D		ST3KP	
1.0904	SKH 1, SKT 4	55Si7	9255	250A53	45	55S7	2085	55Si8	56Si7	G92550	55S2	
1.0961	SUP 7	60SiCr7	9262			60SC6		60SiCr8	60SiCr8	G92620		
1.2067		100Cr6	L3	BL3		Y100C6			100Cr6			
1.2108		90CrSi5	L1				2092	105WCR5				
1.2210		115CrV3	L2			100C3		107CrV3KU	F.520L		11KHF	
1.2241		51CrV4										
1.2330	SCM435TK	35CrMo4	4135	708A37		34CD4	2234	35CrMo4			35KHM	
1.2419	SKS31	105WCr6		105WC13		105WC13	2140	10WCr6			CWG	
1.2510	SKS3	100MnCrW4	O1	BO1		90 MWCV 5	2140	95 MnWCr 5 KU	F.5220		9KHVG	
1.2542		45WCrV7	S1	BS1			2710	45WCrV8KU			5CW25F	
1.2550		60WCrV7	S1			55WC20	2710	58WCr9KU			5KHV2SF	
1.2713	SKT4	55NiCrMoV6	L6			55NCDV7			F.520S		5C NM	
1.2721		50NiCr13	L6			55NCV6	2550		F.528			
1.2842		90MnCrV8	O2	BO2		90MV8				T31502	9G2F	
1.3501		100Cr2	E50100									
1.3505	SUJ2	100Cr6	52100	2S135	31	100C6	2258	100Cr6	F.1310		SC C 15	
1.5024		46Si7				45S7		46SI7	F.1451			
1.5025		51Si7	9259H		50Si7	51S7	2090	50Si7	F.1450			
1.5026		55Si7			56Si7	55S7	2085	55Si7	F.1440	G92550	55S2	
1.5027		60Si7	9260	251A60	60Si7	60S7		60Si7	F.1441	G92600	60S2	
1.5028	SUP7	65Si7	9260H									
1.5415	STFA 12	15Mo3	A204Gr.A	1503-243B		15D3	2912	16Mo3(KG)	F.2601	K11820		
1.5419	SCPH11	20Mo4	4419	1503-243-430			2512	G20Mo5		G44190		
1.5423	SB450M	16Mo5	4520	1503-245-420				16Mo5(KG)	F.2602	K11522		
1.5622		14Ni6	A350-LF5			16N6		14Ni6(KG)	F.2641			
1.5732	SNC415(H)	14NiICr10	3415			14NC11		16NiCr11				
1.5752	SNC815(H)	14NiCr14	3310	655M13	36A	12NC15					20X2H4A	
1.6511	SUP10	36CrNiMo4	9840	816M40	110	40NCD3		36NiCrMo4(KB)			40C N2MA	
1.6523	SNCM220(H)	21NiCrMo2	8620	805M20	362	20NCD2	2506	20NiCrMo2			20C GNM	
1.6546	SNCM240	40NiCrMo2-2	8740	311-Tyre7				40NiCrMo2(KB)			38C GNM	
1.6566		17NiCrMo6-4										
1.6587		17CrNiMo6		820A16		18NCD6		14NiCrMo13				
1.6657		10NiCrMo13-4						14NiCrMo131				
1.7015	SCr415(H)	10Cr3	5015	523M15		12C3				G50150	15C	
1.7033	SCr430(H)	34Cr4	5132	530A32	18B	32C4		34Cr4(KB)		G51300	35C	
1.7035	SCr440(H)	41Cr4	5140	530M40	18	42C4	2245	41Cr4		G51400	40H	
1.7131	SCR 415	16MnCr5	5115	527M17		16MC5	2511	16MnCr5		G51150	12KHN2	
1.7139		16MnCrS5					2127				18HG	
1.7176	SUP9(A)	55Cr3	5155	527A60	48	55C3	2253	55Cr3			50C GA	
1.7218	SCM420	25CrMo4	4130	CDS110		25CD4	2225	25CrMo4(KB)			20C M	
1.7220	SCM432	34CrMo4	4135	708 A 37		35CD4	2234	34CrMo4			35C M	
1.7223	SNB22-1	41CrMo4	4142					41CrMo4			40C FA	
1.7225	SCM 440 (H)	42CrMo4	4140	708 M 40	42 CrMo 4	42 CD 4	2244	42 CrMo 4	F.1252		38HM	
1.7228		55NiCrMoV6G		823M30	33		2512	653M31				
1.7262	SCM415(H)	15CrMo5				12CD4	2216	12CrMo4				
1.7321		20mOcR4					2625					
1.7335	SCM415(H)	13CrMo4-4	A182-F11	1501-620		15CD4-5	2216	14CrMo45			12C M	
1.7361		32CrMo12		722M24	40B	30CD12	2240	30CrMo12	F.124A			
1.7380		10CrMo9-10	A182F22	1501-622		12CD9-10	2218	12CrMo9			12KH8	

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Material Description: Low-alloyed Steel
Composition / Structure / Heat Treatment: Annealed
HB: 180
HRc: 10

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.7715		14MoV6-3		1503-660-440				13MoCrV6				
1.8159	SUP 10	50CrV4	6150	735A50	47	50CrV4	2230	50CrV4		G61500	50C GFA	
1.8161		58CrV4										
1.8509	SACM 645	41CrAlMo7	A355A	905M39	41B	40CAD6-12	2940	41CrAlMo7				
1.8523		39CrMoV13-9		897M39	40C			36CrMoV12				

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Material Description: Low-alloyed Steel
Composition / Structure / Heat Treatment: Quenched & Tempered
HB: 275
HRc: 29

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.5415	STFA 12	15Mo3	A204Gr.A	1503-243B		15D3	2912	16Mo3(KG)	F.2601	K11820		
1.5423	SB450M	16Mo5	4520	1503-245-420				16Mo5(KG)	F.2602	K11522		
1.5622		14Ni6	A350-LF5			16N6		14Ni6(KG)	F.2641			
1.5732	SNC415(H)	14NiICr10	3415			14NC11		16NiCr11				
1.5752	SNC815(H)	14NiCr14	3310	655M13	36A	12NC15					20X2H4A	
1.5755	SNC236	31NiCr14		653M31		18NC13	2534		F.1270			
1.6565	SNCM447	40NiCrMo6	4340	817M40	24	35NCD6	2541	35NiCrMo6(KB)			38C 2N2MA	
1.6587		17CrNiMo6		820A16		18NCD6		14NiCrMo13				
1.6657		10NiCrMo13-4						14NiCrMo131				
1.6957		26NiCrMoV14-5										
1.7015	SCr415(H)	10Cr3	5015	523M15		12C3				G50150	15C	
1.7262	SCM415(H)	15CrMo5				12CD4	2216	12CrMo4				
1.7335	SCM415(H)	13CrMo4-4	A182-F11	1501-620		15CD4-5	2216	14CrMo45			12C M	
1.7380		10CrMo9-10	A182F22	1501-622		12CD9-10	2218	12CrMo9			12KH8	
1.7715		14MoV6-3		1503-660-440				13MoCrV6				
1.7733		24CrMoV55				20CDV6		21CrMoV511				
1.7755		GS-45CrMoV10-4										
1.8070		21CrMoV511						35NiCr9				

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Material Description: Low-alloyed Steel
Composition / Structure / Heat Treatment: Quenched & tempered
HB: 300
HRc: 32

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.1730		C45W3	C45W			XC48						
1.2332	SCM(440)	47CrMo4	4142	708M40	19A	42CD4	2244	42CrMo4				
1.5736	SNC 631 (H)	36NiCr10	3435			30NC11						
1.6523	SNCM220(H)	21NiCrMo2	8620	805M20	362	20NCD2	2506	20NiCrMo2			20C GNM	
1.7033	SCr430(H)	34Cr4	5132	530A32	18B	32C4		34Cr4(KB)		G51300	35C	
1.7218	SCM420	25CrMo4	4130	CDS110		25CD4	2225	25CrMo4(KB)			20C M	
1.8515		32CrMo12		722M24	40B	30CD12	2240	32CrMo12	F.124A			

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
Low-alloyed Steel	Quenched & Tempered	350	38

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0904	SKH 1, SKT 4	55Si7	9255	250A53	45	55S7	2085	55Si8		G92550	55S2	
1.0961	SUP 7	60SiCr7	9262			60SC6		60SiCr8		G92620		
1.2067		100Cr6	L3	BL3		Y100C6		100Cr6				
1.2419	SKS31	105WCr6		105WC13		105WC13	2140	10WCr6			CWG	
1.2542		45WCrV7	S1	BS1			2710	45WCrV8KU			5C W25F	
1.2713	SKT4	55NiCrMoV6	L6			55NCDV7			F.520S		5C NM	
1.4882		X50CrMnNiNbN219				Z50CMNNb21-09						
1.5120		38MnSi4										
1.5710	SNC236	36NiCr6	3135	640A35	111A	35NC6						
1.5755	SNC236	31NiCr14		830m31		18NC13	2534		F.1270			
1.6511	SUP10	36CrNiMo4	9840	816M40	110	40NCD3		36NiCrMo4(KB)			40C N2MA	
1.6546	SNCM240	40NiCrMo2-2	8740	311-Tyre7				40NiCrMo2(KB)			38C GNM	
1.7035	SCr440(H)	41Cr4	5140	530M40	18	42C4	2245	41Cr4		G51400	40H	
1.7176	SUP9(A)	55Cr3	5155	527A60	48	55C3	2253	55Cr3			50C GA	
1.7220	SCM432	34CrMo4	4135	708Aa37		35CD4	2234	34CrMo4			35C M	
1.7223	SNB22-1	41CrMo4	4142					41CrMo4			40C FA	
1.7225	SCM 440 (H)	42CrMo4	4140	708 M 40	42 CrMo 4	42 CD 4	2244	42 CrMo 4	F.1252		38HM	
1.7361		32CrMo12		722M24	40B	30CD12	2240	30CrMo12	F.124A			
1.8159	SUP 10	50CrV4	6150	735A50	47	50CrV4	2230	50CrV4	51CrV4	G61500	50C GFA	
1.8161		58CrV4										
1.8509	SACM 645	41CrAlMo7	A355A	905M39	41B	40CAD6-12	2940	41CrAlMo7				
1.8523		39CrMoV13-9		897M39	40C			36CrMoV12				

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
High-alloyed steel, and tool steel	Annealed	200	15

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.0347	SPCD	RR St 3	A619	CR 3	Fe P03	F 13		DC03/FeP03			08JU	
1.0723	SUM32	15S22		210A15			1922		F.210F			
1.2080	SKD1	X210Cr12	D3	BD3	X210Cr12	Z200C12		X205Cr12KU		T30403	KH12	
1.2162	SCR 420 H	21MnCr5				20MC5						
1.2311		40CrMnMo7				40CMD8		35cRmO8KU				
1.2312		40CrMnMoS8.6	P20+S			40CMD8S						
1.2316		X36CrMo17			X38CrMo16							
1.2343	SKD 6	X38CrMoV5-1	H11	BH11		Z38CDV5		X37CrMoV51KU		T20811	4C 5MFS	
1.2344	SKD61	X40CrMoV5-1	H13	BH13		Z40CDV5	2242	X40CrMoV511KU	F.5318	T20813	4C 5MF1S	
1.2363	SKD12	X100CrMoV5-1	A2	BA2		Z100CDV5	2260	X100CrMoV51KU	F.5227		9KH5VF	
1.2379	SKD11	X155CrVMo121	D2	BD2		Z160CDV12	2310	X165CrMoW12KU		T30402	KH12MF	KRUPP2379
1.2436	SKD 2	X210CrW12	D4(D6)	BD6		Z200CD12	2312	X215CrW121KU	F.5213		KH12	

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
High-alloyed steel, and tool steel	Annealed	200	15

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.2510	SKS3	100MnCrW4	O1	BO1		90 MWCV 5	2140	95 MnWCr 5 KU	F.5220		9KHVG	
1.2581	SKD5	X30WCrV9-3	H21	BH21		Z30WCV9		X30WCrV93KU	F.526	T20821	3C 2W8F	
1.2601		X165CrMoV12					2310	X160CrMoV12			KH12MF	
1.2606	SKD 62	X37CrMoW51	H12	BH12		Z35CWDV5		X35CrMoW05KU	F.537	T20812	5C NM	
1.2764		X19NiCrMo4										
1.2767		X45NiCrMo4				45NCD16		40NiCrMoV8KU				
1.2842		90MnCrV8	O2	B02		90MV8		90MnVCr8KU		T31502	9G2F	
1.3243	SKH55	S6-5-2-5	T15			KCV06-05-05-04-02	2723	HS6-5-2-5			R6M5K5	
1.3249	SKH 3	S18-1-2-5	T4	BT4		Z80WKCV18-05-04					R18K5F2	
1.3343	SKH51, SKH9	S6-5-2	M2	BM2		Z85WDCV	2722	HS652	F.5604		R6M5	
1.3348	SKH 58	S2-9-2	M7			Z100DCWV09-04-02	2782	HS292	F.5607			
1.3355	SKH 2	S18-0-1	T1	BT1		Z80WCV18-4-01					R18	
1.4718	SUH1	X45CrSi9-3	HNV3	401S45	52	Z45CS9		X45CrSi8	F.322		40C 9S2	
1.5662	SL9N60(53)	X8Ni9	ASMA353	502-650		9Ni		X10Ni9	F.2645			
1.5680		12Ni19	2515	12Ni19		Z18N5						

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
High-alloyed steel, and tool steel	Quenched & Tempered	325	35

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.2080	SKD1	X210Cr12	D3	BD3	X210Cr12	Z200C12		X205Cr12KU		T30403	KH12	
1.2344	SKD61	X40CrMoV5-1	H13	BH13		Z40CDV5	2242	X40CrMoV511KU	F.5318	T20813	4C 5MF1S	
1.2363	SKD12	X100CrMoV5-1	A2	BA2		Z100CDV5	2260	X100CrMoV51KU	F.5227		9KH5VF	
1.2436	SKD 2	X210CrW12	D4(D6)	BD6		Z200CD12	2312	X215CrW121KU	F.5213		KH12	
1.2581	SKD5	X30WCrV9-3	H21	BH21		Z30WCV9		X30WCrV93KU	F.526	T20821	3C 2W8F	
1.2601		X165CrMoV12					2310	X160CrMoV12			KH12MF	
1.2714	SKT 4	55NiCrMoV7	6F3/L6			55NiCrMoV7			F.520S		5KHNV	
1.3202		S12-1-4-5		BT15				HS12-1-5-5				
1.3207		S10-4-3-10		BT42		Z130WKCDV						
1.3243	SKH55	S6-5-2-5	T15			KCV06-05-05-04-02	2723	HS6-5-2-5			R6M5K5	
1.3246		S7-4-2-5	M35			Z110WKCDV07-05-04		HS7-4-2-5				
1.3247	SKH 51	S2-10-1-8	M42	BM42		Z110DKCWV09-08-04		HS2-9-1-8			R2AM9K5	
1.3255	SKH 3	S18-1-2-5	T4	BT4		Z80WKCV18-05-04					R18K5F2	
1.3343	SKH51, SKH9	S6-5-2	M2	BM2		Z85WDCV	2722	HS652	F.5604		R6M5	
1.3348	SKH 58	S2-9-2	M7			Z100DCWV09-04-02	2782	HS292	F.5607			
1.3355	SKH 2	S18-0-1	T1	BT1		Z80WCV18-4-01					R18	
1.4718	SUH1	X45CrSi9-3	HNV3	401S45	52	Z45CS9		X45CrSi8	F.322		40C 9S2	
1.4935	SUH 616	X20CrMoWV121	422							S42200		
1.5680		12Ni19	2515	12Ni19		Z18N5						

M

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
12	Stainless steel	Ferritic / Martensitic, Annealed	200	15

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.4000	SUS403	X6Cr13	403	403S17		Z6C13	2301	X6Cr13	F.3110	S40300	08C 13	ATI 410S
1.4001		X7Cr14	410 S	403S7		Z8C13	2301		F.8401		08C 13	
1.4002	SUS 405	X6CrAl13	405	405S17		Z6CA13	2302	X6CrAl13		S40500		
1.4005	SUS416	X12CrS13	416	416S21		Z11CF13	2380	X12CrSC13	F.3411	S41600		ATI 416
1.4006	SUS410	X12Cr13	410	410S21	56A	Z10C13	2302	X12Cr13	F.3401	S41000	12C 13	ATI 410
1.4016	SUS430	X6Cr17	430	430S15	X8Cr17	Z8C17	2320	X8Cr17	F3113	S43000	12C 17	ATI 430
1.4027	SCS 2	GX20Cr14		420C29		Z20C13M					20C 13L	
1.4028	SUS420J2	X30Cr13	420	420S45		Z30C13	2304			S42020	20C 13	
1.4034	SUS420J2	X46Cr13		420S45		Z40C14		X40Cr14	F.3405			
1.4057	SUS431	X19CrNi17-2	431	431S29	57	Z15CN16-02	2321	X16CrNi16	F.3427	S43100	20C 17N2	431 (HT)
1.4086		GX120Cr29		452C11								
1.4104	SUS430F	X12CrMoS17	430F	420S37		Z10CF17	2383	X10CrS17	F.3117	S43020		
1.4112	SUS 440 B	X90CrMoV18	440B							S44003	95KH18	
1.4113	SUS434	X6CrMo17	434	434S17		Z8CD17-01	2325	X8CrMo17		S43400		AL 434
1.4313	SCS5	X3CrNi13-4	CA6-NM	425C11		Z4CND13-04M	2385	(G)X6CrNi304		J91540		
1.4340		GX40CrNi274								J92615		
1.4417		X2CrNiM0Si195	S31500				2376			S39215		
1.4418		X4CrNiMo165				Z6CND16-04-01	2387					APX4
1.4510	SUS430LX	X6CrTi17	XM8			Z4CT17		X6CrTi17	F.3115	S43035	08C 17T	430 Ti
1.4511	SUS430LK	X6CrNb17				Z4CNb17		X6CrNb17	F.3122			AXC525
1.4512	SUH409	X6CrTi12	409	LW19		Z3CT12		X6CrTi12		S40900		
1.4720		X20CrMo13										
1.4724	SUS 405	X10CrA113	405	403S17		Z10C13		X10CrA112	F.311		10C 13SJU	
1.4742	SUH446	X10CrA118	430	439S15	60	Z10CAS18		X8Cr17	F.3113	S43000	15C 13SJU	
1.4747	SUH4	X80CrNiSi20	HNV6	443S65	59	Z80CSN20-02		X80CrSiNi20	F.320B	S65006		
1.4749		X18CrN28	446								15KH28	
1.4762	SUH446	X10CrA124	446			Z10CAS24	2322	X16Cr26		S44600		
1.4871	SUH35,SUH36	X53CrMnNiN21-9	EV8	349S54		Z52CMN21-09		X53CrMnNiN219		S63008	55C 20G9AN4	
		X10CrNi15	429									
		X12CrNi18-9	302	302S31		Z10CN18-09	2330					

M

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
13	Stainless steel	Martensitic, Quenched & Tempered	240	23

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.4000	SUS403	X6Cr13	403	403S17		Z6C13	2301	X6Cr13	F.3110	S40300	08C 13	ATI 410S
1.4001		X7Cr14	410 S	403S7		Z8C13	2301		F.8401		08C 13	
1.4006	SUS410	X12Cr13	410	410S21	56A	Z10C13	2302	X12Cr13	F.3401	S41000	12C 13	ATI 410
1.4016	SUS430	X6Cr17	430	430S15	X8Cr17	Z8C17	2320	X8Cr17	F.3113	S43000	12C 17	ATI 430
1.4021	SUS 420J1	X20Cr13	420	420S37		Z20C13	2303	14210	F.5261	S42000	20C 13	ATI 420
1.4027	SCS 2	GX20Cr14		420C29		Z20C13M					20C 13L	
1.4031	SUS 420 J2	X40Cr13	420			Z40C14	-2304		F.3404	S42080	40C 13	
1.4034	SUS420J2	X46Cr13		420S45		Z40C14		X40Cr14	F.3405			
1.4057	SUS431	X19CrNi17-2	431	431S29	57	Z15CN16-02	2321	X16CrNi16	F.3427	S43100	20C 17N2	431 (HT)
1.4104	SUS430F	X12CrMoS17	430F	420S37		Z10CF17	2383	X10CrS17	F.3117	S43020		
1.4113	SUS434	X6CrMo17	434	434S17		Z8CD17-01	2325	X8CrMo17		S43400		AL 434
1.4313	SCS5	X3CrNi13-4	CA6-NM	425C11		Z4CND13-04M	2385	(G)X6CrNi304		J91540		
1.4544		A 700	321	S.524		Z 10 CNT 18 11		X6CrNiTi1811		J92630	08C 18N12T	
1.4546		X5CrNiNb18-10	348	347S31				X6CrNiNb1811		J92640		ATI 348
1.4871	SUH35,SUH36	X53CrMnNiN21-9	EV8	349S54		Z52CMN21-09		X53CrMnNiN219		S63008	55C 20G9AN4	
1.4922		X20cRmV12-1					2317	x20cRmOnI1201				
1.4923		X22CrMoV121										Jethete X20

M

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
14	Stainless steel	Austenitic	180	10

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.4301	SUS 304	X5CrNi18-10	304	304S15		Z5CN18-09	2332		F.3551	S30409	08C 18N10	
1.4305	SUS303	X10CrNiS18-10	303	303S21	58M	Z8CNF18-09	2346	X10CrNiS18.09	F.3508	S30300	30C 18N11	ATI 303
1.4306	SCS19	X2CrNi1911	304L	304C12	X3CrNi1810KD	Z2CN18-09	2352	GX2CrNi1910	F.3503	S30403	03KH18N11	ATI 304L
1.4308	SUS304L	GX6CrNi18-9	CF-8	304C15	58E	Z6CN18-10M	2333					CF-8
1.4310	SUS 301	X10CrNi18-8	301	301S21		Z12CN17-07	2331	X2CrNi1807	F.3517	S30100	07KH16N6	ATI 301
1.4311	SUS304LN	X2CrNiN18 10	304LN	304S62		Z2CN18-10	2371	X2CrNiN1810	F.3541	S30453	03KH18N11	
1.4312	SCS12	GX10CrNi188	305	302C25		Z10CN18-9M					10C 18N9L	ATI 305
1.4350	SUS304	X5CrNi18-9	304	304S15	58E	Z6CN18-09	2332	X5CrNi1810	F.3551	S30400		ATI 304
1.4362		X2CrNiN234	S32304			Z2CN23-04AZ	2327			S32304		ATI 2304TM
1.4371		X3CrMnNiN18887	202	284S16		Z8CMN18-08-05						
1.4401	SUS316	X5CrNiMo17-12-2	316	316S13		Z3CND17-11-01	2347	X5CrNiMo17 12 2	F.3534	S31600	08KH17H13M2T	ATI 316
1.4404	SUS316L	X2CrNiMo17-13-2	316L	316S11		Z2CND17-12	2348	X2CrNiMo1712	F.3533	S31603		ATI 316L
1.4406	SUS316LN	X2CrNiMoN17122	316LN	316S61		Z2CND17-12AZ		X2CrNiMoN1712	F.3542	S31653	07C 18N	ATI 316LN
1.4408	SCS14	GX6CrNiMo18-10	CF-8M	316C16			2343	X7CrNiMo2010	F.8414	J92900	10G2S2MSL	
1.4410	SCS 14 A	GX10CrNiMo18-9				Z5CND20-12M	2328			S32750		
1.4429	SUS316LN	X2CrNiMoN17-13-3	316Ln	316S62		Z2CND17-13AZ	2375	X2CrNiMoN17133	F.3543		03KH16N15M3	
1.4435	SUS316L	X2CrNiMo18143	316L	316S11		Z3CND17-12-03	2375	X2CrNiMo17 13 2	F.3533	S31603	O3C 17N14M3	
1.4436	SUS316	X3CrNiMo17-13-3	316	316S19		Z6CND18-12-03	2343	X5CrNiMo17 12 2	F.3543	S31600		
1.4438	SUS317L	X2CrNiMo18164	317L	317S12		Z2CND19-15-04	2367	X2CrNiMo18 16 4	F.3539	S31703		ATI 317L
1.4439		X2CrNiMoN17135	(s31726)			Z3CND18-14-06AZ						
1.4440		X2CrNiMo18-16										
1.4449	SUS317	X5CrNiMo17133	317	317S16				X5CrNiMo1815		S31700		ATI 317
1.4460	SUS 329 J1	X8CrNiMo275	329				2324			S32900		10RE51
1.4462	SUS329J3L	X2CrNiMoN2253		318S13		Z3CND22-05Az	2377			S31803		ATI 2205TM
1.4500		X7NiCrMoCuNb2520				23NCDU25-20M				J95150		
1.4521	SUS444	X2CrMoTi18-2	443444				2326	X2CrMoTiNb18 2	F.3123			
1.4539		X1NiCrMoCuN25205				Z2NCDU25-20	2562			N08904		ATI 904L
1.4541	SUS321	X14CrNiTi18-10	321	321S31		Z6CNT18-10	2337	X6CrNiTi18 11	F.3523	S32100	06C 18N10T	ATI 321
1.4542	SUS630	X5CrNiCuNb174	630			Z7CNU15-05						UGIMA 4542
1.4545		Z7CNU15.05	15-5PH							S15500		ATI 15-5
1.4547		X1CrNiMoN20187	S31254				2378			S31254		Uranus B25 6Mo
1.4550	SUS347	X6CrNiNb18-10	347	347S17	58F	Z6CNNb18-10	2338	X6CrNiNb18 11	F.3552	S34700	08C 18N12B	ATI 347
1.4552	SCS 21	GX7CrNiNb18-9				Z4CNNb19-10M				J92710		
1.4568	SUS 631	X 7 CrNiAl 17 7		316S111		Z 9 CAN 17-7	2388	Z8CNA17-07		S17700	09C 17NJU1	17-7PH
1.4571	SUS 316Ti	X6CrNiMoTi17-12-2	316Ti	320S31	58J	Z6NDT17-12	2350	X6CrNiMoTi17 12	F.3535		10C 17N13M2T	ATI 316Ti
1.4581	SCS 22	GX5CrNiMoNb18		318C17		Z4CNDNb18-12M						
1.4583		X6CrNiMoNB18-12	318	303S21		Z15CNS20-12		X15CrNiSi2 12				
1.4585		GX7CrNiMoCuNb1818						X6CrNiMoTi17 12		J94651		
1.4821		X20CrNiSi254				Z20CNS25-04				S44635		
1.4823		GX40CrNiSi274								J92605		
1.4828	SCS17	X15CrNiSi20-12	309	309S24	58C	Z15CNS20-12			F.8414	S30900	20C 20N14S2	ATI 309
1.4833	SUS 309 S	X6CrNi2213	309S	309S13		Z15CN24-13				J93400		
1.4845	SUH310	X12CrNi25-21	310S	310S24		Z12CN25-20	2361	X6CrNi2520	F.331	S31008	20C 23N18	ATI 310S
1.4878	SUS321	X12CrNiTi18-9	321	321S20	58B	Z6CNT18-12(B)	2337	X6CrNiTi1811	F.3553	S32100		ACX315
1.4891		X5CrNiNb18-10	Ss30415				2372					
1.4893		X8CrNiNb11	S30815				2368					
1.4948		X6CrNi1811	304H	304S51		Z5CN18-09	2333			S30480		
1.4980		X5NiCrTi2515	660				2570			S66286		Incoloy A 286
		X5NiCrN3525										
		X2CrNiMoN18134	S31753									
		X2CrNiMoN25227										

K 15

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
15	Grey cast iron	Pearlitic / Ferritic	180	10

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.6010	FC100	GG10	A48 20 B	Grade 100	GJL-100	Ft 10 D	0100	G10	FG10		Sc 10	
0.6015	FC150	GG15	A48 25 B	Grade 150	GJL-150	Ft 15 D	0115	G15	FG15		Sc 15	
0.6020	FC200	GG20	A48 30 B	Grade 220	GJL-200	Ft 20 D	0120	G20	FG20	W06020	Sc 20	
0.6025	FC250	GG25	A48 40 B	Grade 260	GJL-250	Ft 25 D	0125	G25	FG25		Sc 25	
0.6660		GGL-NiCr 20 2	1050/700/7	Grade F2	GJLA-XNiCr 20-2	L-NC 202	0523	-		F41002		Ni-Resist 2
1.4449	SUS317	X5CrNiMo17133	317	317S16				X5CrNiMo1815		S31700		ATI 317

K 16

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
16	Grey cast iron	Pearlitic (Martensitic)	260	26

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.6025	FC250	GG25	A48 40 B	Grade 260	GJL-250	Ft 25 D	0125	G25	FG25		Sc 25	
0.6030	FC300	GG30	A48 45 B	Grade 300	GJL-300	Ft 30 D	0130	G30	FG30		Sc 30	
0.6035	FC350	GG35	A48 50 B	Grade 350	GJL-350	Ft 35 D	0135	G35	FG35		Sc 35	
0.6040	FC400	GG40	A48 60 B	Grade 400	GJL-400	Ft 40 D	0140	G40	FC40		Sc 40	

K 17

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
17	Nodular cast iron	Ferritic	160	3

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.7033	FCD350-22L	GGG35.3	-	350/22L40	GJS-350-22-LT	FGS 370-17	0717-15	-				
0.7040	FCD400	GGG40	60-40-18	SNG 420-12	GJS-400-15	FCS 400-12	0717-02	GS 400-12	FG E38-17	F32800	Vc 42-12	
0.7043	FCD 370	GGG40.3	60-40-18	SNG 370-17	GJS-400-18-LT	FGS 370-17	0717-12	GSO 42-17			Vc 42-12	
0.6040	FC400	GG40	A48 60 B	Grade 400	GJL-400	Ft 40 D	0140	G40	FC40		Sc 40	

K 18

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
18	Nodular cast iron	Pearlitic	250	25

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.7050	FCD500	GGG50	80-55-06	SNG 500-7	GJS-500-7	FGS 500-7	0727-02	GS 500-7	FG E50-7	F33100	Vc 50-2	
0.7060	FCD600	GGG60	80-55-06	SNG 600-3	GJS-600-3	FGS 600-3	0732-03	GS 600-3	FG E60-2		Vc 60-2	
0.7070	FCD700	GGG70	100-70-03	SNG 700-2	GJS-700-2	FGS 700-2	0737-01	GS 700-2	FG S70-2	F34800	Vc 70-2	
0.7652	FCDA-NiMn 13 7	GGG NiMn 13-7	-	Grade S6	GJSA-XNiMn 13-7	FGS Ni13 Mn7	0772	-				Nodumag
0.7660		GGG NiCr 20-2	A436 D2	Grade S2	GJSA-XNiCr 20-2	FGS Ni20 Cr2	0776	-				Ni-Resist D-2

K 19

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
19	Malleable cast iron	Ferritic	130	

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.8135	FCMW330	GTS-35	32510	B 340-12	GJMB350-10	MN 35-10	0815	GMN 35	GTS35		Kc 35-10	

K 20

VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
20	Malleable cast iron	Pearlitic	230	21

Mat'l No.	JIS	DIN	AISI/ASTM/ SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.8145	FCMW370	GTS-45	A220-40010	P 440-7	GJMB450-6	MN 450	0852	GMN 45				
0.8155	FCMP490	GTS-55	50005	P 510-4	GJMB-550-4	MP 50-5	0854	GMN 55			Kc 60-3	
0.8165	FCMP590	GTS-65	70003	P 570-3	GJMB-650-2	MN 650-3	0856	GMN 65				
0.8170	FCMP690	GTS-70	90001	P 690-2	GJMB-700-2	MN 700-2	0862	GMN 70			Kc 70-2	

N — VDI 3323 21

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Aluminum-wrought alloy	Not Curable	60	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
3.0205		Al99	Al99									
3.0255	(A1050)	Al99.5	1000	L31		A59050C					D1	
3.3315		AlMg1										

N — VDI 3323 22

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Aluminum-wrought alloy	Curable, Hardened	100	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
3.1325		AlCuMg1									AD35	
3.1655	A2011	AlCuSiPb										
3.2315		AlMgSi1									AK9	
3.4345		AlZnMgCuO,5	7050	L86		AZ4GU/9051		811-04				
3.4365	7075	AlZnMgCu1,5	7075	7075		7075		AlZn5.8MgCuCr			B95	

N — VDI 3323 23

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
3.2163		G-AlSi9Cu3									VAL8	
3.2382		GD-AlSi10Mg										
3.2383		G-AlSi0Mg(Cu)	A360.2	LM9			4253					
3.2581		G-AlSi12										
3.3561		G-AlMg5										
3.5101		G-MgZn4sE1Zr1	ZE41	MAG5								
3.5103		MgSE3Zn27r1	EZ33	MAG6		G-TR3Z2						
3.5812		G-MgAl8Zn1	AZ81	NMAG1								
3.5912		G-MgAl9Zn1	AZ91	MAG7								
			A356-72	2789		NFA32-201						
	A5052		356.1	LM25			4244				AK7	
		G-AlSi12	A413.2	LM6			4261					
	ADC12	G-AlSi12(Cu)	A413.1	LM20			4260				AK12	
	A6061	GD-AlSi12	A413.0				4247					
	A7075	GD-AlSi8Cu3	A380.1	LM24			4250					

N — VDI 3323 24

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Aluminum-cast, alloyed	≤ 12% Si, Curable, Hardened	90	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.1871		G-AlCu4TiMg										
3.1754		G-AlCu5Ni1,5										
3.2371		G-AlSi7Mg	4218B								AK8	
3.2373	C4BS	G-AlSI9MGWA	SC64D			A-S7G	4251				AK9	
3.2381		G-AlSi10Mg									AK12	
3.5106		G-MgAg3SE2Zr1	QE22	mag12								
		G-ALMG5	GD-AlSI12	LM5		A-SU12	4252					

N — VDI 3323 26

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Copper and Copper Alloys (Bronze / Brass)	Cutting alloys, PB>1%	110	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.0375		CuZn36Pb3									LS60-2	
2.1090		G-CuSn75pb	C93200			U-E7Z5pb4						
2.1096		G-CuSn5ZnPb	c83600	LG2								
2.1098		G-CuSn2Znpb	C83600									
2.1182		G-CuPb15Sn	C23000	LB1		U-pb15E8						

N — VDI 3323 27

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Copper and copper alloys (Bronze / Brass)	CuZn, CuSnZn (Brass)	90	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.0240	C2300	CuZn15									L90	
2.0321		CuZn37	C27200	cz108		CuZn36,CuZn37		C2700			L63	
2.0590		G-CuZn40Fe										
2.0592		G-CuZn35Al1	C86500	U-Z36N3		HTB1						
2.0596		G-CuZn34Al2	C86200	HTB1		U-Z36N3					LTs23AD	
2.1293		CuCrZr	C18200	CC102		U-Cr0-8Zr						

N — VDI 3323 28

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Copper and copper alloys (Bronze / Brass)	CuSn, lead-free copper and electrolytic copper	100	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.0060		E-Cu57										
2.0966		CuAl10Ni5Fe4	C63000	Ca104		U-A10N					BrAD	
2.0975		G-CuAl10Ni	B-148-52									
2.1050		G-CuSn10	c90700	CT1								
2.1052		G-CuSn12	C90800	pb2		UE12P						
2.1292		G-CuCrF35	C81500	CC1-FF								

S — VDI 3323 31

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Heat resistant super alloys	Fe Based, Annealed	200	15

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.4558	NCF 800 TB	X2NiCrAlTi3220	N08800	NA15								
1.4562		X1NiCrMoCu32287	N08031									
1.4563		X1NiCrMoCuN31274	N08028			Z1NCDU31-27-03	2584				EK77	
1.4864	SUH330	X12NiCrSi36-16	330	NA17		Z12NCS37-18				N08330		
1.4865	SCH15	GX40NiCrSi38-18		330C40				XG50NiCr3919		J94605		
1.4958		X5NiCrAlTi3120										

S — VDI 3323 32

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Heat resistant super alloys	Fe Based, Aged	280	30

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.4977		X40CoCrNi2020				Z42CNKDWNb						

S — VDI 3323 33

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Heat resistant super alloys	Ni or Co Based, Annealed	250	25

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.4360		NiCu30Fe		NA13		NU30				N04400		Monel400
2.4603		NiCr 30 FeMo	5390A			NC22FeD						Hastelloy G-30
2.4610		NiMo16cR16Ti								N26455		HastelloyC-4
2.4630		NiCr20Ti		HR5,203-4		NC20T				N06075		Nimonic75
2.4631	NCF 80A	NiCr20TiAl		Hr40		NC20TA				N07080	KHN77TYuR	Nimonic 80A
2.4642	NCF 690	NiC29Fe				Nnc30Fe				N06690		Inconel 690
2.4856		NiCr22Mo9Nb		NA21		NC22FeDNb				N06625		Inconel 625
2.4858		NiCr21Mo		NA16		NC21FeDU				N08825	KHN38VT	Incoloy 825

S — VDI 3323 34

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Heat resistant super alloys	Ni or Co Based, Aged	350	38

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.4375		NiCu30Al	4676	NA18		NU30AT				N05500		Monelk500
2.4662		NiFe35Cr14MoTi	5660			ZSNCDT42				N09901		Incoloy 901
2.4668		NiCr19Fe19NbMo	5383	HR8		NC19eNB				N07718		Inconel 718
2.4670		S-NiCr13A16MoNb	5391	Mar-46		NC12AD						Nimocast 713
2.4694		NiCr16fE7TiAl								N07751		Inconel 751
2.4955		NiFe25Cr20NbTi										
2.4964		CoCr20W15Ni	5772			KC20WN						Haynes 25
		CoCr22W14Ni	AMS 5772			KC22WN						

S — VDI 3323 35

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Heat resistant super alloys	Ni or Co Based, Cast	320	34

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.4669		NiCr15Fe7TiAl				NC15TNbA				N07750		Inconel X750
2.4685		G-NiMo28								N10665		Hastelloy B
2.4810		G-NiMo30										Hastelloy C
2.4973		NiCr19Co11MoTi	AMS 5399			NC19KDT					VT5-1	
3.7115		TiAl5Sn2								R54520	VT1-00	ATI Grade 6

S — VDI 3323 36

Material Description	Composition / Structure / Heat Treatment	HB	HRc
Titanium alloys	Pure Titanium	400 Rm	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
2.4674		NiCo15Cr10MoAlTi	AMS 5397							N13100		IN 100
3.7025		Ti1	R50250	2TA1						R50250		ATI 30 CP Gr. 1
3.7225		Ti1pd	R52250	TP1						R52250		

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Material Description	Composition / Structure / Heat Treatment	HB	HRc
Titanium alloys	Alpha + Beta Alloys, Hardened	1050 Rm	

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
3.7124		TiCu2		2TA21-24								
3.7145		TiAl6Sn2Zr4Mo2Si	R54620							R54620		
3.7165		TiAl6V4	AMS R56400	TA10-13		T-A6V					VT6	
3.7185		TiAl4Mo4Sn2		TA45-51								
3.7195		TiAl3V2.5								R56320		ATI 3-2.5
		TiAl4Mo4Sn4Si0.5										
		TiAl5Sn2.5	AMS R54520	TA14/17		T-A5E						
		Ti6Al4VELI	AMS R56401	TA11								

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VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
38	Hardened steel	Hardened	550	55

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
1.1231	S 70 C-CSP	Ck 67	1070	060 A 67	C 67S	XC 68	1770	C 70	F.5103		70	
1.1248	C 75	Ck 75	1078, 1080	060 A 78	C 75S	XC 75	1774	C 75	F.5107		75	
1.1274	SUP 4	Ck 101	1095	060 A 96	C 100S	XC100	1870	C100	F.5117			
1.1545	SK 3	C 105 W1	W1	BW 2	C 105U	Y1 105	1880	C 100 KU	F.5118		U10A	
1.2762		75CrMoNiW67	-	-	-	-	-	-				
1.3401	SCMnH1	GX120Mn12	A128(A)			Z120M12	2183	GX120Mn12	F.8251		110G13L	
1.4021	SUS 420 J1	X 20 Cr 13	420	420 S 37	X 20 Cr 13	Z 20 C 13	2303	X 20 Cr 13	F.5261		20KH13	ATI 420
1.4109	SUS 440 A	X 65 CrMo 14	440 A	-	X 70 CrMo 15	Z 70 D 14	-	-				ATI 440A
1.4112	SUS 440 B	X 90 CrMoV 18	440 B	409 S 19	X 90 CrMoV 18	Z 2 CND 18 05	2327	X CrTi 12				
1.4125	SUS 440 C	X 105 CrMo 17	440 C	-	X 105 CrMo 17	Z 100 CD 17	-	X 105 CrMo 17			95KH18	ATI 440C
1.6746		32NiCrMo14-5	-	832M31	32nlcRmO145	35NCD14	-	-				
1.7176	SUP9(A)	55Cr3	5155	527A60	48	55C3	2253	55Cr3				
1.7225	SCM 440 (H)	42CrMo4	4140	708 M 40	42 CrMo 4	42 CD 4	2244	42 CrMo 4	F.1252		38HM	

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VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
40	Chilled cast iron	Cast	400	42

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.9620		GX260NiCr42	A532 IB	Grade 2 A	GJN-HV520	FB Ni4 Cr2 BC	0512	-		F45001		Ni-Hard2
0.9625		GX330NiCr42	A532 IA	Grade 2 B	GJN-HV550	FB Ni4 Cr2 HC	0513	-		F45000		Ni-Hard1
0.9630		GX300 CrNiSi 9 5 2	A532 ID	Grade 2 C	GJN-HV600	FB Cr9 Ni5	0457	-		F45003		Ni-Hard 4
0.9640		GX300CrMoNi1521	-	-	-	-	-	-		F45005		
0.9650		GX260Cr27	-	Grade 3 D		-	0466	-				
0.9655		GX300CrNMo271	-	Grade 3 E		-	-	-			20C 25N20S2	
1.4841	SUH 310	X15CrNiSi25-20	310	314S31	X 15 CrNiSi 25 20	Z15CNS25-20	-	-		S31400		Cronifer 2520

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VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc
41	Hardened cast iron	Hardened	550	55

Mat'l No.	JIS	DIN	AISI/ASTM/SAE	BS	EN	AFNOR	SS	UNI	UNE / IHA	UNS	GOST	Brands
0.9635		GX300 CrMo 15 3	-	-	-	-	-	-				
0.9645		GX260 CrMoNi 20 21	-	-	-	-	-	-		F45007		

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