



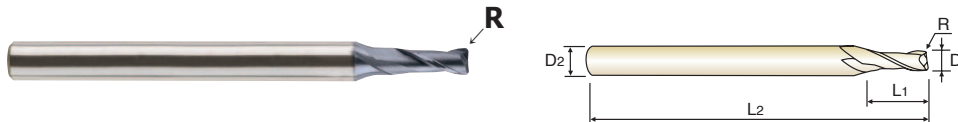
SEMD99 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE CORNER RADIUS (Short, Regular, Long Shank)
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS

- ▶ 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 short, regular and long shank end mills.
- ▶ Available various corner radius end mills, from 0.02 mm to 5.0mm corner radius.

- ▶ Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- ▶ Ausgezeichnet geeignet für das Fräsen von vorvergütetem Stahl, kohlenstoff Stahl, legiertem Stahl für Formen, bis HRC55 und Maschinenbauteile.
- ▶ Erhältlich in den Schaft-Ausführungen: kurz, standard und lang
- ▶ Erhältlich in verschiedenen Eckradien-Ausführungen: von 0,02mm bis zu 5,0mm Eckradius.



MG HM 2 30° ±0.010 ±0.015 PLAIN P.797
Ø0.2-Ø6 Ø7-Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD99002002E	RO.02	0.2	4	0.4	40	-
SEMD99002005E	RO.05	0.2	4	0.4	40	-
SEMD99003002E	RO.02	0.3	4	0.6	40	-
SEMD99003005E	RO.05	0.3	4	0.6	40	-
SEMD99004005E	RO.05	0.4	4	0.8	40	-
SEMD9900401E	RO.1	0.4	4	0.8	40	-
SEMD99005005E	RO.05	0.5	4	1.0	40	-
SEMD9900501E	RO.1	0.5	4	1.0	40	-
SEMD99006005E	RO.05	0.6	4	1.2	40	-
SEMD9900601E	RO.1	0.6	4	1.2	40	-
SEMD9900602E	RO.2	0.6	4	1.2	40	-
SEMD99007005E	RO.05	0.7	4	1.4	40	-
SEMD9900701E	RO.1	0.7	4	1.4	40	-
SEMD9900702E	RO.2	0.7	4	1.4	40	-
SEMD99008005E	RO.05	0.8	4	1.6	40	-
SEMD9900801E	RO.1	0.8	4	1.6	40	-
SEMD9900802E	RO.2	0.8	4	1.6	40	-
SEMD99009005E	RO.05	0.9	4	1.8	40	-
SEMD9900901E	RO.1	0.9	4	1.8	40	-
SEMD99010005E	RO.05	1.0	6	2.5	50	-
SEMD9901001E	RO.1	1.0	6	2.5	50	-
★ SEMD9901002E	RO.2	1.0	6	2.5	50	-
★ SEMD9901003E	RO.3	1.0	6	2.5	50	-
SEMD99012005E	RO.05	1.2	6	3	50	-
SEMD9901201E	RO.1	1.2	6	3	50	-
SEMD9901202E	RO.2	1.2	6	3	50	-
SEMD9901203E	RO.3	1.2	6	3	50	-
SEMD99015005E	RO.05	1.5	6	4	50	-
SEMD9901501E	RO.1	1.5	6	4	50	-
★ SEMD9901502E	RO.2	1.5	6	4	50	-

▶ ★ Stock Item

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	◎	◎	○					○					



4G MILL END MILLS

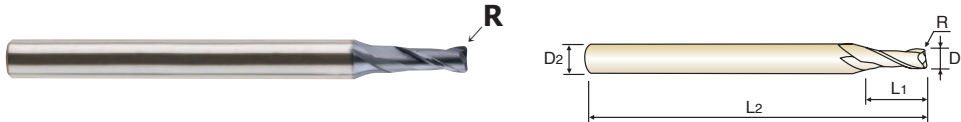
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Ø0.2-Ø6 Ø7-Ø20

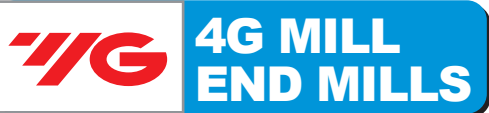
Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD9901503E	RO.3	1.5	6	4	50	-
★ SEMD9901505E	RO.5	1.5	6	4	50	-
SEMD9902001E	RO.1	2.0	6	6	50	-
★ SEMD9902002E	RO.2	2.0	6	6	50	-
★ SEMD9902003E	RO.3	2.0	6	6	50	-
★ SEMD9902005E	RO.5	2.0	6	6	50	-
SEMD9902501E	RO.1	2.5	6	7	60	-
SEMD9902502E	RO.2	2.5	6	7	60	-
SEMD9902503E	RO.3	2.5	6	7	60	-
SEMD9902505E	RO.5	2.5	6	7	60	-
SEMD9903001E	RO.1	3.0	6	8	60	-
★ SEMD9903002E	RO.2	3.0	6	8	60	-
★ SEMD9903003E	RO.3	3.0	6	8	60	-
★ SEMD9903005E	RO.5	3.0	6	8	60	-
SEMD9903010E	R1.0	3.0	6	8	60	-
SEMD9903501E	RO.1	3.5	6	10	70	-
SEMD9903502E	RO.2	3.5	6	10	70	-
SEMD9903503E	RO.3	3.5	6	10	70	-
SEMD9903505E	RO.5	3.5	6	10	70	-
SEMD99040014SE	RO.1	4.0	4	10	70	4mm Shank
SEMD99040024SE	RO.2	4.0	4	10	70	4mm Shank
SEMD99040034SE	RO.3	4.0	4	10	70	4mm Shank
SEMD99040054SE	RO.5	4.0	4	10	70	4mm Shank
SEMD99040104SE	R1.0	4.0	4	10	70	4mm Shank
SEMD99040011004SE	RO.1	4.0	4	10	100	4mm Shank
SEMD99040021004SE	RO.2	4.0	4	10	100	4mm Shank
SEMD99040031004SE	RO.3	4.0	4	10	100	4mm Shank
SEMD99040051004SE	RO.5	4.0	4	10	100	4mm Shank
SEMD99040101004SE	R1.0	4.0	4	10	100	4mm Shank
SEMD9904001E	RO.1	4.0	6	10	70	Regular

▶ ★ Stock Item

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	◎	◎	○										



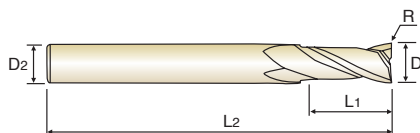
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Ø0.2-Ø6 Ø7-Ø20

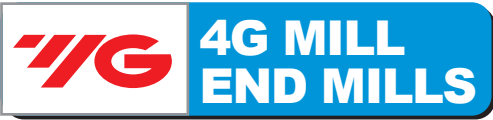
Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
★ SEMD9904002E	RO.2	4.0	6	10	70	Regular
★ SEMD9904003E	RO.3	4.0	6	10	70	Regular
★ SEMD9904005E	RO.5	4.0	6	10	70	Regular
★ SEMD9904010E	R1.0	4.0	6	10	70	Regular
SEMD9904501E	RO.1	4.5	6	11	80	-
SEMD9904502E	RO.2	4.5	6	11	80	-
SEMD9904503E	RO.3	4.5	6	11	80	-
SEMD9904505E	RO.5	4.5	6	11	80	-
SEMD9905001E	RO.1	5.0	6	13	90	-
★ SEMD9905002E	RO.2	5.0	6	13	90	-
★ SEMD9905003E	RO.3	5.0	6	13	90	-
★ SEMD9905005E	RO.5	5.0	6	13	90	-
★ SEMD9905010E	R1.0	5.0	6	13	90	-
SEMD9905501E	RO.1	5.5	6	13	90	-
SEMD9905502E	RO.2	5.5	6	13	90	-
SEMD9905503E	RO.3	5.5	6	13	90	-
SEMD9905505E	RO.5	5.5	6	13	90	-
SEMD9905510E	R1.0	5.5	6	13	90	-
★ SEMD9906002060E	RO.2	6.0	6	15	60	Short
★ SEMD9906003060E	RO.3	6.0	6	15	60	Short
★ SEMD9906005060E	RO.5	6.0	6	15	60	Short
★ SEMD9906010060E	R1.0	6.0	6	15	60	Short
SEMD9906001E	RO.1	6.0	6	15	90	Regular
★ SEMD9906002E	RO.2	6.0	6	15	90	Regular
★ SEMD9906003E	RO.3	6.0	6	15	90	Regular
★ SEMD9906005E	RO.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
SEMD9906005110E	RO.5	6.0	6	15	110	Long Shank

▶ ★ Stock Item

◎ : Excellent ○ : Good

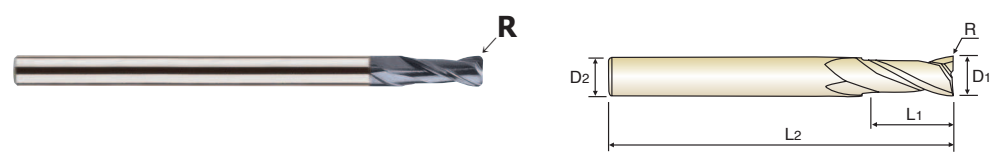
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~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	◎	◎	○				○						



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Ø0.2~Ø6 Ø7~Ø20

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2	Remark
SEMD9906010110E	R1.0	6.0	6	15	110	Long Shank
SEMD9906005130E	RO.5	6.0	6	15	130	Long Shank
SEMD9906010130E	R1.0	6.0	6	15	130	Long Shank
SEMD9907001E	RO.1	7.0	8	16	90	-
SEMD9907002E	RO.2	7.0	8	16	90	-
SEMD9907003E	RO.3	7.0	8	16	90	-
SEMD9907005E	RO.5	7.0	8	16	90	-
SEMD9907010E	R1.0	7.0	8	16	90	-
SEMD9907020E	R2.0	7.0	8	16	90	-
SEMD9908003070E	RO.3	8.0	8	20	70	Short
★ SEMD9908005070E	RO.5	8.0	8	20	70	Short
★ SEMD9908010070E	R1.0	8.0	8	20	70	Short
SEMD9908001E	RO.1	8.0	8	20	100	Regular
SEMD9908002E	RO.2	8.0	8	20	100	Regular
SEMD9908003E	RO.3	8.0	8	20	100	Regular
★ SEMD9908005E	RO.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	RO.5	8.0	8	20	120	Long Shank
SEMD9908010120E	R1.0	8.0	8	20	120	Long Shank
SEMD9908005150E	RO.5	8.0	8	20	150	Long Shank
SEMD9908010150E	R1.0	8.0	8	20	150	Long Shank
SEMD9910003075E	RO.3	10.0	10	25	75	Short
★ SEMD9910005075E	RO.5	10.0	10	25	75	Short
★ SEMD9910010075E	R1.0	10.0	10	25	75	Short
SEMD9910001E	RO.1	10.0	10	25	100	Regular
SEMD9910002E	RO.2	10.0	10	25	100	Regular

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◎	◎	◎	◎	○										

- HSS
- CBN END MILLS
- i-Xmill END MILLS
- i-HS mill END MILLS
- X5070 END MILLS
- 4G MILL END MILLS
- X-SPEED ROUGHER END MILLS
- X-POWER END MILLS
- JET-POWER END MILLS
- TN MILL END MILLS
- V7 Mill END MILLS
- ALU-POWER END MILLS
- CRX S END MILLS
- D-POWER GRAPHITE END MILLS
- D-POWER CFRP END MILLS
- ROUTERS
- K-2 CARBIDE END MILLS
- GENERAL CARBIDE END MILLS
- TANK-POWER END MILLS
- GENERAL HSS END MILLS
- MILLING CUTTERS
- TECHNICAL DATA

**YG 4G MILL
END MILLS**

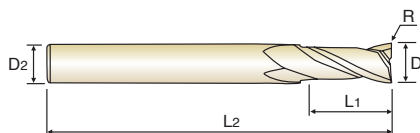
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Ø0.2-Ø6 Ø7-Ø20

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SEMD9910003E	RO.3	10.0	10	25	100	Regular
★ SEMD9910005E	RO.5	10.0	10	25	100	Regular
★ SEMD9910010E	R1.0	10.0	10	25	100	Regular
★ 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	RO.5	10.0	10	25	130	Long Shank
SEMD9910010130E	R1.0	10.0	10	25	130	Long Shank
SEMD9910005150E	RO.5	10.0	10	25	150	Long Shank
SEMD9910010150E	R1.0	10.0	10	25	150	Long Shank
SEMD9911002E	RO.2	11.0	12	25	110	-
SEMD9911003E	RO.3	11.0	12	25	110	-
SEMD9911005E	RO.5	11.0	12	25	110	-
SEMD9911010E	R1.0	11.0	12	25	110	-
SEMD9911020E	R2.0	11.0	12	25	110	-
SEMD9912003080E	RO.3	12.0	12	30	80	Short
★ SEMD9912005080E	RO.5	12.0	12	30	80	Short
★ SEMD9912010080E	R1.0	12.0	12	30	80	Short
SEMD9912001E	RO.1	12.0	12	30	110	Regular
SEMD9912002E	RO.2	12.0	12	30	110	Regular
SEMD9912003E	RO.3	12.0	12	30	110	Regular
★ SEMD9912005E	RO.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
★ 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

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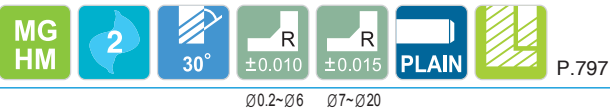
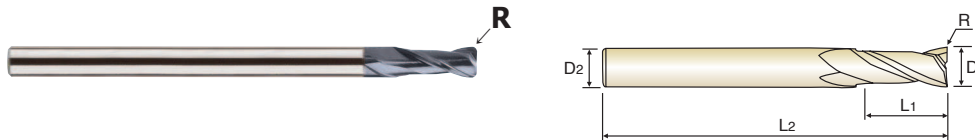
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Ø0.2-Ø6 Ø7-Ø20

Unit : mm

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SEMD9912050E	R5.0	12.0	12	30	110	Regular
SEMD9912005130E	R0.5	12.0	12	30	130	Long Shank
SEMD9912010130E	R1.0	12.0	12	30	130	Long Shank
SEMD9912005150E	R0.5	12.0	12	30	150	Long Shank
SEMD9912010150E	R1.0	12.0	12	30	150	Long Shank
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	h6
over Ø6	±0.015	0~-0.015	

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70									
◎	◎	◎	◎	○										

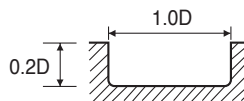


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 2 FLUTE CORNER RADIUS
VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS**

SEMD99 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
	~ HRc 35 ~ 1100N/mm ²				HRc 35 ~ HRc 45 1110 ~ 1500N/mm ²				HRc 45 ~ HRc 55 1500 ~ 2000N/mm ²			
HARDNESS												
STRENGTH												
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
0.2	44000	145	28	0.002	28800	60	18	0.001	17600	40	11	0.001
0.3	41000	170	39	0.002	27000	70	25	0.001	16500	45	16	0.001
0.4	41000	170	52	0.002	27000	70	34	0.001	16500	45	21	0.001
0.5	36000	190	57	0.003	23400	80	37	0.002	14300	50	22	0.002
0.6	30000	210	57	0.004	19800	90	37	0.002	12100	55	23	0.002
0.7	30000	210	66	0.004	19800	90	44	0.002	12100	55	27	0.002
0.8	30000	210	75	0.004	19800	90	50	0.002	12100	55	30	0.002
0.9	30000	225	85	0.004	18900	90	53	0.002	11550	55	33	0.002
1.0	27600	240	87	0.004	18000	100	57	0.003	11000	60	35	0.003
1.2	24800	245	93	0.005	15750	105	59	0.003	9750	60	37	0.003
1.5	22000	250	104	0.006	13500	110	64	0.004	8500	60	40	0.004
2.0	18000	260	113	0.007	11560	120	73	0.005	7200	70	45	0.005
2.5	15000	270	118	0.009	9500	130	75	0.007	6100	70	48	0.006
3.0	13240	280	125	0.011	8560	140	81	0.008	5280	70	50	0.007
3.5	11980	310	132	0.013	7690	155	85	0.010	4790	75	53	0.008
4.0	10720	340	135	0.016	6820	170	86	0.012	4300	80	54	0.009
4.5	9940	380	141	0.019	6310	185	89	0.015	4300	90	61	0.010
5.0	9160	420	144	0.023	5800	200	91	0.017	3800	100	60	0.013
5.5	8530	460	147	0.027	5420	225	94	0.021	3540	110	61	0.016
6.0	7900	500	149	0.032	5040	250	95	0.025	3280	120	62	0.018
7.0	6950	520	153	0.037	4420	250	97	0.028	2900	120	64	0.021
8.0	6000	540	151	0.045	3800	250	96	0.033	2520	120	63	0.024
10.0	5040	540	158	0.054	3280	250	103	0.038	2020	120	63	0.030
11.0	4580	480	158	0.052	3030	240	105	0.040	1850	110	64	0.030
12.0	4120	420	155	0.051	2780	230	105	0.041	1680	100	63	0.030
14.0	3610	390	159	0.054	2440	200	107	0.041	1480	90	65	0.030
16.0	3100	360	156	0.058	2100	170	106	0.040	1280	80	64	0.031
20.0	2520	280	158	0.056	1640	120	103	0.037	1000	60	63	0.030



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

- HSS
- CBN END MILLS
- i-Xmill END MILLS
- i-HS mill END MILLS
- X5070 END MILLS
- 4G MILL END MILLS
- X-SPEED ROUGHER END MILLS
- X-POWER END MILLS
- JET-POWER END MILLS
- TN MILL END MILLS
- V7 Mill END MILLS
- ALU-POWER END MILLS
- CRX S END MILLS
- D-POWER GRAPHITE END MILLS
- D-POWER CFRP END MILLS
- ROUTERS
- K-2 CARBIDE END MILLS
- GENERAL CARBIDE END MILLS
- TANK-POWER END MILLS
- GENERAL HSS END MILLS
- MILLING CUTTERS
- TECHNICAL DATA