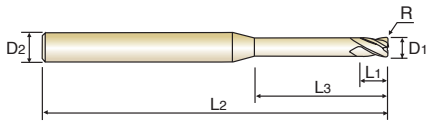
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
SEME6401000503E	R0.05	1.0	4	1.5	3	50	-
SEME6401000504E	R0.05	1.0	4	1.5	4	50	-
SEME6401000506E	R0.05	1.0	4	1.5	6	50	-
SEME6401000508E	R0.05	1.0	4	1.5	8	50	-
SEME6401000510E	R0.05	1.0	4	1.5	10	50	-
SEME6401000512E	R0.05	1.0	4	1.5	12	50	-
SEME6401000514E	R0.05	1.0	4	1.5	14	50	-
SEME6401000516E	R0.05	1.0	4	1.5	16	50	-
SEME6401000520E	R0.05	1.0	4	1.5	20	50	-
SEME640100103E	R0.1	1.0	4	1.5	3	50	-
★ SEME640100104E	R0.1	1.0	4	1.5	4	50	-
★ SEME640100106E	R0.1	1.0	4	1.5	6	50	-
★ SEME640100108E	R0.1	1.0	4	1.5	8	50	-
SEME640100110E	R0.1	1.0	4	1.5	10	50	-
SEME640100112E	R0.1	1.0	4	1.5	12	50	-
SEME640100114E	R0.1	1.0	4	1.5	14	50	-
SEME640100116E	R0.1	1.0	4	1.5	16	50	-
SEME640100120E	R0.1	1.0	4	1.5	20	50	-
SEME640100203E	R0.2	1.0	4	1.5	3	50	-
★ SEME640100204E	R0.2	1.0	4	1.5	4	50	-
★ SEME640100206E	R0.2	1.0	4	1.5	6	50	-
★ SEME640100208E	R0.2	1.0	4	1.5	8	50	-
SEME640100210E	R0.2	1.0	4	1.5	10	50	-
SEME640100212E	R0.2	1.0	4	1.5	12	50	-
SEME640100214E	R0.2	1.0	4	1.5	14	50	-
SEME640100216E	R0.2	1.0	4	1.5	16	50	-
SEME640100220E	R0.2	1.0	4	1.5	20	50	-
SEME640100303E	R0.3	1.0	4	1.5	3	50	-
★ SEME640100304E	R0.3	1.0	4	1.5	4	50	-
★ SEME640100306E	R0.3	1.0	4	1.5	6	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

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
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- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
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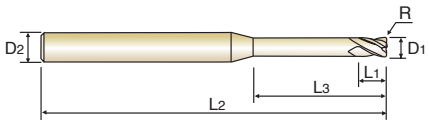
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640100308E	R0.3	1.0	4	1.5	8	50	-
SEME640100310E	R0.3	1.0	4	1.5	10	50	-
SEME640100312E	R0.3	1.0	4	1.5	12	50	-
SEME640100314E	R0.3	1.0	4	1.5	14	50	-
SEME640100316E	R0.3	1.0	4	1.5	16	50	-
SEME640100320E	R0.3	1.0	4	1.5	20	50	-
SEME6401200503E	R0.05	1.2	4	1.8	3	50	-
SEME6401200504E	R0.05	1.2	4	1.8	4	50	-
SEME6401200506E	R0.05	1.2	4	1.8	6	50	-
SEME6401200508E	R0.05	1.2	4	1.8	8	50	-
SEME6401200510E	R0.05	1.2	4	1.8	10	50	-
SEME6401200512E	R0.05	1.2	4	1.8	12	50	-
SEME6401200516E	R0.05	1.2	4	1.8	16	50	-
SEME6401200520E	R0.05	1.2	4	1.8	20	50	-
SEME640120103E	R0.1	1.2	4	1.8	3	50	-
★ SEME640120104E	R0.1	1.2	4	1.8	4	50	-
★ SEME640120106E	R0.1	1.2	4	1.8	6	50	-
★ SEME640120108E	R0.1	1.2	4	1.8	8	50	-
SEME640120110E	R0.1	1.2	4	1.8	10	50	-
SEME640120112E	R0.1	1.2	4	1.8	12	50	-
SEME640120116E	R0.1	1.2	4	1.8	16	50	-
SEME640120120E	R0.1	1.2	4	1.8	20	50	-
SEME640120203E	R0.2	1.2	4	1.8	3	50	-
★ SEME640120204E	R0.2	1.2	4	1.8	4	50	-
★ SEME640120206E	R0.2	1.2	4	1.8	6	50	-
★ SEME640120208E	R0.2	1.2	4	1.8	8	50	-
SEME640120210E	R0.2	1.2	4	1.8	10	50	-
SEME640120212E	R0.2	1.2	4	1.8	12	50	-
SEME640120216E	R0.2	1.2	4	1.8	16	50	-
SEME640120220E	R0.2	1.2	4	1.8	20	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

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

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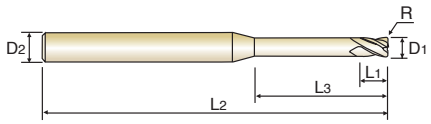

MG HM | 4 | M-Helix | R ±0.02 | PLAIN

D≥3

P.802, 803

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
SEME640120303E	R0.3	1.2	4	1.8	3	50	-
★ SEME640120304E	R0.3	1.2	4	1.8	4	50	-
★ SEME640120306E	R0.3	1.2	4	1.8	6	50	-
★ SEME640120308E	R0.3	1.2	4	1.8	8	50	-
SEME640120310E	R0.3	1.2	4	1.8	10	50	-
SEME640120312E	R0.3	1.2	4	1.8	12	50	-
SEME640120316E	R0.3	1.2	4	1.8	16	50	-
SEME640120320E	R0.3	1.2	4	1.8	20	50	-
SEME6401500504E	R0.05	1.5	4	2.3	4	50	-
SEME6401500506E	R0.05	1.5	4	2.3	6	50	-
SEME6401500508E	R0.05	1.5	4	2.3	8	50	-
SEME6401500510E	R0.05	1.5	4	2.3	10	50	-
SEME6401500512E	R0.05	1.5	4	2.3	12	50	-
SEME6401500514E	R0.05	1.5	4	2.3	14	50	-
SEME6401500516E	R0.05	1.5	4	2.3	16	50	-
SEME6401500520E	R0.05	1.5	4	2.3	20	50	-
SEME6401500522E	R0.05	1.5	4	2.3	22	60	-
SEME6401500526E	R0.05	1.5	4	2.3	26	60	-
SEME640150104E	R0.1	1.5	4	2.3	4	50	-
★ SEME640150106E	R0.1	1.5	4	2.3	6	50	-
★ SEME640150108E	R0.1	1.5	4	2.3	8	50	-
★ SEME640150110E	R0.1	1.5	4	2.3	10	50	-
★ SEME640150112E	R0.1	1.5	4	2.3	12	50	-
SEME640150114E	R0.1	1.5	4	2.3	14	50	-
SEME640150116E	R0.1	1.5	4	2.3	16	50	-
SEME640150120E	R0.1	1.5	4	2.3	20	50	-
SEME640150122E	R0.1	1.5	4	2.3	22	60	-
SEME640150126E	R0.1	1.5	4	2.3	26	60	-
SEME640150204E	R0.2	1.5	4	2.3	4	50	-
★ SEME640150206E	R0.2	1.5	4	2.3	6	50	-

▶ ★ Stock Item

◎ : Excellent ○ : Good

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~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	◎	◎	○				○						

4G MILL END MILLS

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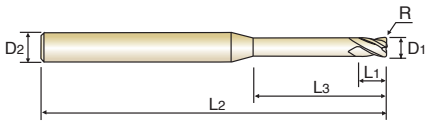

MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640150208E	R0.2	1.5	4	2.3	8	50	-
★ SEME640150210E	R0.2	1.5	4	2.3	10	50	-
★ SEME640150212E	R0.2	1.5	4	2.3	12	50	-
SEME640150214E	R0.2	1.5	4	2.3	14	50	-
SEME640150216E	R0.2	1.5	4	2.3	16	50	-
SEME640150220E	R0.2	1.5	4	2.3	20	50	-
SEME640150222E	R0.2	1.5	4	2.3	22	60	-
SEME640150226E	R0.2	1.5	4	2.3	26	60	-
SEME640150304E	R0.3	1.5	4	2.3	4	50	-
★ SEME640150306E	R0.3	1.5	4	2.3	6	50	-
★ SEME640150308E	R0.3	1.5	4	2.3	8	50	-
★ SEME640150310E	R0.3	1.5	4	2.3	10	50	-
★ SEME640150312E	R0.3	1.5	4	2.3	12	50	-
SEME640150314E	R0.3	1.5	4	2.3	14	50	-
SEME640150316E	R0.3	1.5	4	2.3	16	50	-
SEME640150320E	R0.3	1.5	4	2.3	20	50	-
SEME640150322E	R0.3	1.5	4	2.3	22	60	-
SEME640150326E	R0.3	1.5	4	2.3	26	60	-
SEME640150504E	R0.5	1.5	4	2.3	4	50	-
★ SEME640150506E	R0.5	1.5	4	2.3	6	50	-
★ SEME640150508E	R0.5	1.5	4	2.3	8	50	-
★ SEME640150510E	R0.5	1.5	4	2.3	10	50	-
★ SEME640150512E	R0.5	1.5	4	2.3	12	50	-
SEME640150514E	R0.5	1.5	4	2.3	14	50	-
SEME640150516E	R0.5	1.5	4	2.3	16	50	-
SEME640150520E	R0.5	1.5	4	2.3	20	50	-
SEME640150522E	R0.5	1.5	4	2.3	22	60	-
SEME640150526E	R0.5	1.5	4	2.3	26	60	-
★ SEME640200106E	R0.1	2.0	4	3	6	50	-
★ SEME640200108E	R0.1	2.0	4	3	8	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

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

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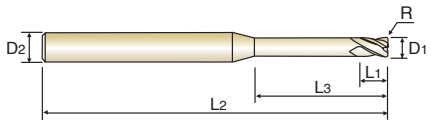

MG HM | 4 | M-Helix | R ±0.02 | PLAIN

D≥3

P.802, 803

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640200110E	R0.1	2.0	4	3	10	50	-
★ SEME640200112E	R0.1	2.0	4	3	12	50	-
SEME640200114E	R0.1	2.0	4	3	14	50	-
SEME640200116E	R0.1	2.0	4	3	16	50	-
SEME640200120E	R0.1	2.0	4	3	20	50	-
SEME640200122E	R0.1	2.0	4	3	22	60	-
SEME640200126E	R0.1	2.0	4	3	26	60	-
SEME640200130E	R0.1	2.0	4	3	30	70	-
★ SEME640200206E	R0.2	2.0	4	3	6	50	-
★ SEME640200208E	R0.2	2.0	4	3	8	50	-
★ SEME640200210E	R0.2	2.0	4	3	10	50	-
★ SEME640200212E	R0.2	2.0	4	3	12	50	-
SEME640200214E	R0.2	2.0	4	3	14	50	-
SEME640200216E	R0.2	2.0	4	3	16	50	-
SEME640200220E	R0.2	2.0	4	3	20	50	-
SEME640200222E	R0.2	2.0	4	3	22	60	-
SEME640200226E	R0.2	2.0	4	3	26	60	-
SEME640200230E	R0.2	2.0	4	3	30	70	-
★ SEME640200306E	R0.3	2.0	4	3	6	50	-
★ SEME640200308E	R0.3	2.0	4	3	8	50	-
★ SEME640200310E	R0.3	2.0	4	3	10	50	-
★ SEME640200312E	R0.3	2.0	4	3	12	50	-
SEME640200314E	R0.3	2.0	4	3	14	50	-
SEME640200316E	R0.3	2.0	4	3	16	50	-
SEME640200320E	R0.3	2.0	4	3	20	50	-
SEME640200322E	R0.3	2.0	4	3	22	60	-
SEME640200326E	R0.3	2.0	4	3	26	60	-
SEME640200330E	R0.3	2.0	4	3	30	70	-
★ SEME640200506E	R0.5	2.0	4	3	6	50	-
★ SEME640200508E	R0.5	2.0	4	3	8	50	-

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◎ : Excellent ○ : Good

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◎	◎	◎	◎	○				○						

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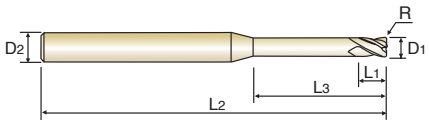
- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640200510E	R0.5	2.0	4	3	10	50	-
★ SEME640200512E	R0.5	2.0	4	3	12	50	-
SEME640200514E	R0.5	2.0	4	3	14	50	-
SEME640200516E	R0.5	2.0	4	3	16	50	-
SEME640200520E	R0.5	2.0	4	3	20	50	-
SEME640200522E	R0.5	2.0	4	3	22	60	-
SEME640200526E	R0.5	2.0	4	3	26	60	-
SEME640200530E	R0.5	2.0	4	3	30	70	-
SEME640250108E	R0.1	2.5	4	4	8	50	-
SEME640250110E	R0.1	2.5	4	4	10	50	-
SEME640250112E	R0.1	2.5	4	4	12	50	-
SEME640250114E	R0.1	2.5	4	4	14	50	-
SEME640250116E	R0.1	2.5	4	4	16	50	-
SEME640250120E	R0.1	2.5	4	4	20	50	-
SEME640250126E	R0.1	2.5	4	4	26	60	-
SEME640250130E	R0.1	2.5	4	4	30	70	-
SEME640250208E	R0.2	2.5	4	4	8	50	-
SEME640250210E	R0.2	2.5	4	4	10	50	-
SEME640250212E	R0.2	2.5	4	4	12	50	-
SEME640250214E	R0.2	2.5	4	4	14	50	-
SEME640250216E	R0.2	2.5	4	4	16	50	-
SEME640250220E	R0.2	2.5	4	4	20	50	-
SEME640250226E	R0.2	2.5	4	4	26	60	-
SEME640250230E	R0.2	2.5	4	4	30	70	-
SEME640250308E	R0.3	2.5	4	4	8	50	-
SEME640250310E	R0.3	2.5	4	4	10	50	-
SEME640250312E	R0.3	2.5	4	4	12	50	-
SEME640250314E	R0.3	2.5	4	4	14	50	-
SEME640250316E	R0.3	2.5	4	4	16	50	-
SEME640250320E	R0.3	2.5	4	4	20	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									
◎	◎	◎	◎	○				○						

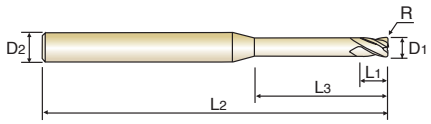
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN

D≥3

P.802, 803

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
SEME640250326E	R0.3	2.5	4	4	26	60	-
SEME640250330E	R0.3	2.5	4	4	30	70	-
SEME640250508E	R0.5	2.5	4	4	8	50	-
SEME640250510E	R0.5	2.5	4	4	10	50	-
SEME640250512E	R0.5	2.5	4	4	12	50	-
SEME640250514E	R0.5	2.5	4	4	14	50	-
SEME640250516E	R0.5	2.5	4	4	16	50	-
SEME640250520E	R0.5	2.5	4	4	20	50	-
SEME640250526E	R0.5	2.5	4	4	26	60	-
SEME640250530E	R0.5	2.5	4	4	30	70	-
★ SEME640300108E	R0.1	3.0	6	4.5	8	50	-
★ SEME640300110E	R0.1	3.0	6	4.5	10	50	-
★ SEME640300112E	R0.1	3.0	6	4.5	12	50	-
SEME640300114E	R0.1	3.0	6	4.5	14	60	-
★ SEME640300116E	R0.1	3.0	6	4.5	16	60	-
SEME640300120E	R0.1	3.0	6	4.5	20	60	-
SEME640300126E	R0.1	3.0	6	4.5	26	65	-
SEME640300130E	R0.1	3.0	6	4.5	30	70	-
SEME640300135E	R0.1	3.0	6	4.5	35	70	-
SEME640300140E	R0.1	3.0	6	4.5	40	80	-
SEME640300208E	R0.2	3.0	6	4.5	8	50	-
★ SEME640300210E	R0.2	3.0	6	4.5	10	50	-
★ SEME640300212E	R0.2	3.0	6	4.5	12	50	-
SEME640300214E	R0.2	3.0	6	4.5	14	60	-
★ SEME640300216E	R0.2	3.0	6	4.5	16	60	-
★ SEME640300220E	R0.2	3.0	6	4.5	20	60	-
SEME640300226E	R0.2	3.0	6	4.5	26	65	-
SEME640300230E	R0.2	3.0	6	4.5	30	70	-
SEME640300235E	R0.2	3.0	6	4.5	35	70	-
SEME640300240E	R0.2	3.0	6	4.5	40	80	-

▶ ★ 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									
◎	◎	◎	◎	○				○						

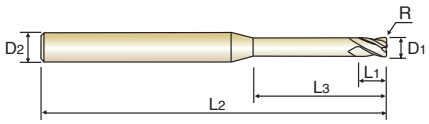
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640300308E	R0.3	3.0	6	4.5	8	50	-
★ SEME640300310E	R0.3	3.0	6	4.5	10	50	-
★ SEME640300312E	R0.3	3.0	6	4.5	12	50	-
SEME640300314E	R0.3	3.0	6	4.5	14	60	-
★ SEME640300316E	R0.3	3.0	6	4.5	16	60	-
★ SEME640300320E	R0.3	3.0	6	4.5	20	60	-
SEME640300326E	R0.3	3.0	6	4.5	26	65	-
SEME640300330E	R0.3	3.0	6	4.5	30	70	-
SEME640300335E	R0.3	3.0	6	4.5	35	70	-
SEME640300340E	R0.3	3.0	6	4.5	40	80	-
★ SEME640300508E	R0.5	3.0	6	4.5	8	50	-
★ SEME640300510E	R0.5	3.0	6	4.5	10	50	-
★ SEME640300512E	R0.5	3.0	6	4.5	12	50	-
SEME640300514E	R0.5	3.0	6	4.5	14	60	-
★ SEME640300516E	R0.5	3.0	6	4.5	16	60	-
★ SEME640300520E	R0.5	3.0	6	4.5	20	60	-
★ SEME640300526E	R0.5	3.0	6	4.5	26	65	-
SEME640300530E	R0.5	3.0	6	4.5	30	70	-
SEME640300535E	R0.5	3.0	6	4.5	35	70	-
SEME640300540E	R0.5	3.0	6	4.5	40	80	-
★ SEME640301008E	R1.0	3.0	6	4.5	8	50	-
★ SEME640301010E	R1.0	3.0	6	4.5	10	50	-
★ SEME640301012E	R1.0	3.0	6	4.5	12	50	-
SEME640301014E	R1.0	3.0	6	4.5	14	60	-
★ SEME640301016E	R1.0	3.0	6	4.5	16	60	-
SEME640301020E	R1.0	3.0	6	4.5	20	60	-
SEME640301026E	R1.0	3.0	6	4.5	26	65	-
SEME640301030E	R1.0	3.0	6	4.5	30	70	-
SEME640301035E	R1.0	3.0	6	4.5	35	70	-
SEME640301040E	R1.0	3.0	6	4.5	40	80	-

▶ ★ 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									
◎	◎	◎	◎	○				○						

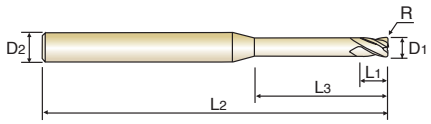
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN

D≥3

P.802, 803

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME640400110E	R0.1	4.0	6	6	10	50	-
★ SEME640400112E	R0.1	4.0	6	6	12	50	-
SEME640400114E	R0.1	4.0	6	6	14	60	-
★ SEME640400116E	R0.1	4.0	6	6	16	60	-
★ SEME640400120E	R0.1	4.0	6	6	20	60	-
SEME640400126E	R0.1	4.0	6	6	26	65	-
SEME640400130E	R0.1	4.0	6	6	30	70	-
SEME640400135E	R0.1	4.0	6	6	35	70	-
SEME640400140E	R0.1	4.0	6	6	40	80	-
SEME640400145E	R0.1	4.0	6	6	45	90	-
SEME640400150E	R0.1	4.0	6	6	50	100	-
★ SEME640400210E	R0.2	4.0	6	6	10	50	-
★ SEME640400212E	R0.2	4.0	6	6	12	50	-
SEME640400214E	R0.2	4.0	6	6	14	60	-
★ SEME640400216E	R0.2	4.0	6	6	16	60	-
★ SEME640400220E	R0.2	4.0	6	6	20	60	-
★ SEME640400226E	R0.2	4.0	6	6	26	65	-
SEME640400230E	R0.2	4.0	6	6	30	70	-
SEME640400235E	R0.2	4.0	6	6	35	70	-
SEME640400240E	R0.2	4.0	6	6	40	80	-
SEME640400245E	R0.2	4.0	6	6	45	90	-
SEME640400250E	R0.2	4.0	6	6	50	100	-
★ SEME640400310E	R0.3	4.0	6	6	10	50	-
★ SEME640400312E	R0.3	4.0	6	6	12	50	-
SEME640400314E	R0.3	4.0	6	6	14	60	-
★ SEME640400316E	R0.3	4.0	6	6	16	60	-
★ SEME640400320E	R0.3	4.0	6	6	20	60	-
★ SEME640400326E	R0.3	4.0	6	6	26	65	-
SEME640400330E	R0.3	4.0	6	6	30	70	-
SEME640400335E	R0.3	4.0	6	6	35	70	-

▶ ★ 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									
◎	◎	◎	◎	○				○						

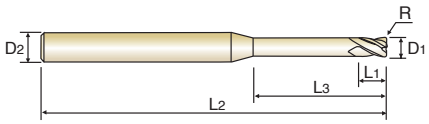
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
SEME640400340E	R0.3	4.0	6	6	40	80	-
SEME640400345E	R0.3	4.0	6	6	45	90	-
SEME640400350E	R0.3	4.0	6	6	50	100	-
★ SEME640400510E	R0.5	4.0	6	6	10	50	-
★ SEME640400512E	R0.5	4.0	6	6	12	50	-
SEME640400514E	R0.5	4.0	6	6	14	60	-
★ SEME640400516E	R0.5	4.0	6	6	16	60	-
★ SEME640400520E	R0.5	4.0	6	6	20	60	-
★ SEME640400526E	R0.5	4.0	6	6	26	65	-
SEME640400530E	R0.5	4.0	6	6	30	70	-
SEME640400535E	R0.5	4.0	6	6	35	70	-
SEME640400540E	R0.5	4.0	6	6	40	80	-
SEME640400545E	R0.5	4.0	6	6	45	90	-
SEME640400550E	R0.5	4.0	6	6	50	100	-
★ SEME640401010E	R1.0	4.0	6	6	10	50	-
★ SEME640401012E	R1.0	4.0	6	6	12	50	-
SEME640401014E	R1.0	4.0	6	6	14	60	-
★ SEME640401016E	R1.0	4.0	6	6	16	60	-
★ SEME640401020E	R1.0	4.0	6	6	20	60	-
★ SEME640401026E	R1.0	4.0	6	6	26	65	-
SEME640401030E	R1.0	4.0	6	6	30	70	-
SEME640401035E	R1.0	4.0	6	6	35	70	-
SEME640401040E	R1.0	4.0	6	6	40	80	-
SEME640401045E	R1.0	4.0	6	6	45	90	-
SEME640401050E	R1.0	4.0	6	6	50	100	-
SEME6405001E	R0.1	5.0	6	8	15	60	-
SEME6405002E	R0.2	5.0	6	8	15	60	-
SEME6405003E	R0.3	5.0	6	8	15	60	-
SEME6405005E	R0.5	5.0	6	8	15	60	-
SEME6405010E	R1.0	5.0	6	8	15	60	-

▶ ★ 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

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
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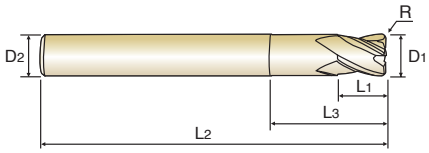
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
SEME6405015E	R1.5	5.0	6	8	15	60	-
SEME6405020E	R2.0	5.0	6	8	15	60	-
SEME6406001E	R0.1	6.0	6	9	20	60	Regular
SEME6406002E	R0.2	6.0	6	9	20	60	Regular
★ SEME6406003E	R0.3	6.0	6	9	20	60	Regular
★ SEME6406005E	R0.5	6.0	6	9	20	60	Regular
★ SEME6406010E	R1.0	6.0	6	9	20	60	Regular
SEME6406015E	R1.5	6.0	6	9	20	60	Regular
SEME6406020E	R2.0	6.0	6	9	20	60	Regular
SEME6406003090E	R0.3	6.0	6	15	30	90	Long Shank
SEME6406005090E	R0.5	6.0	6	15	30	90	Long Shank
SEME6406010090E	R1.0	6.0	6	15	30	90	Long Shank
SEME6408001E	R0.1	8.0	8	12	25	70	Regular
★ SEME6408002E	R0.2	8.0	8	12	25	70	Regular
★ SEME6408003E	R0.3	8.0	8	12	25	70	Regular
★ SEME6408005E	R0.5	8.0	8	12	25	70	Regular
★ SEME6408010E	R1.0	8.0	8	12	25	70	Regular
SEME6408015E	R1.5	8.0	8	12	25	70	Regular
SEME6408020E	R2.0	8.0	8	12	25	70	Regular
SEME6408003100E	R0.3	8.0	8	20	35	100	Long Shank
★ SEME6408005100E	R0.5	8.0	8	20	35	100	Long Shank
SEME6408010100E	R1.0	8.0	8	20	35	100	Long Shank
SEME6410001E	R0.1	10.0	10	15	30	75	Regular
SEME6410002E	R0.2	10.0	10	15	30	75	Regular
SEME6410003E	R0.3	10.0	10	15	30	75	Regular
★ SEME6410005E	R0.5	10.0	10	15	30	75	Regular
★ SEME6410010E	R1.0	10.0	10	15	30	75	Regular
★ SEME6410015E	R1.5	10.0	10	15	30	75	Regular
SEME6410020E	R2.0	10.0	10	15	30	75	Regular
SEME6410003100E	R0.3	10.0	10	25	40	100	Long Shank

▶ ★ 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									
◎	◎	◎	◎	○				○						

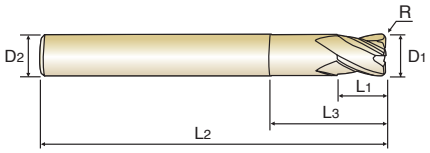
4G MILL END MILLS

SEME64 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

- Due to new coating and new tool geometry, outstanding cutting ability and wear resistance.
- Excellent performance when cutting prehardened steels, up to HRc55 which are used for molds & dies.
- Due to Multiple Helix for 3.0mm and over 3.0mm diameter end mills, vibration can be minimized at cutting, and wear of cutting tool can be decreased too.

- Aufgrund einer neuartigen Beschichtung und neuer Werkzeuggeometrien hervorragende Schnittleistung und Verschleißfestigkeit
- Hervorragende Leistung bei der Zerspanung von vorvergüteten Stählen bis HRc55, welche im Werkzeug- und Formenbau Verwendung finden.
- Aufgrund der Multi-Helix (M-Helix) bei Schaftfräsern ≥ 3,0mm ø werden Vibrationen zuverlässig verhindert und gleichzeitig der Schneidkantenverschleiß verringert.



MG HM | 4 | M-Helix | R ±0.02 | PLAIN | P.802, 803

D≥3

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Remark
★ SEME6410005100E	R0.5	**10.0**	10	25	40	100	Long Shank
SEME6410010100E	R1.0	**10.0**	10	25	40	100	Long Shank
SEME6412002E	R0.2	**12.0**	12	18	32	80	Regular
SEME6412003E	R0.3	**12.0**	12	18	32	80	Regular
★ SEME6412005E	R0.5	**12.0**	12	18	32	80	Regular
★ SEME6412010E	R1.0	**12.0**	12	18	32	80	Regular
★ SEME6412015E	R1.5	**12.0**	12	18	32	80	Regular
★ SEME6412020E	R2.0	**12.0**	12	18	32	80	Regular
SEME6412003110E	R0.3	**12.0**	12	30	45	110	Long Shank
★ SEME6412005110E	R0.5	**12.0**	12	30	45	110	Long Shank
SEME6412010110E	R1.0	**12.0**	12	30	45	110	Long Shank
★ SEME6416005E	R0.5	**16.0**	16	20	35	100	Regular
★ SEME6416010E	R1.0	**16.0**	16	20	35	100	Regular
SEME6416005150E	R0.5	**16.0**	20	35	50	150	Long Shank
SEME6416010150E	R1.0	**16.0**	20	35	50	150	Long Shank
★ SEME6420005E	R0.5	**20.0**	20	25	40	100	Regular
★ SEME6420010E	R1.0	**20.0**	20	25	40	100	Regular
SEME6420005150E	R0.5	**20.0**	20	40	55	150	Long Shank
SEME6420010150E	R1.0	**20.0**	20	40	55	150	Long Shank

▶ ★ Stock Item

Mill Dia. Tolerance (mm)	Corner Radius Tolerance (mm)	Shank Dia. Tolerance
0~−0.03	±0.02	h6

◎ : 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

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

SEME64 SERIES

MATERIAL		NON-ALLOYED STEELS ALLOY STEELS CAST IRON					ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
HARDNESS		~ HRc 35					HRc 35 ~ HRc 45					HRc 45 ~ HRc 55				
STRENGTH		~ 1100N/mm²					1110 ~ 1500N/mm²					1500 ~ 2000N/mm²				
DIA.	LBS	RPM	FEED	Vc	fz	Ae(mm)	RPM	FEED	Vc	fz	Ae(mm)	RPM	FEED	Vc	fz	Ae(mm)
1.0	4	33100	360	104	0.003	0.021	21600	260	68	0.003	0.016	13200	140	41	0.003	0.013
1.0	6	29790	290	94	0.002	0.012	19440	210	61	0.003	0.009	11880	115	37	0.002	0.007
1.0	8	29790	290	94	0.002	0.012	19440	210	61	0.003	0.009	11880	115	37	0.002	0.007
1.0	10	29790	290	94	0.002	0.008	19440	210	61	0.003	0.006	11880	115	37	0.002	0.005
1.0	12	26480	230	83	0.002	0.008	17280	165	54	0.002	0.006	10560	90	33	0.002	0.005
1.0	16	19860	150	62	0.002	0.005	12960	110	41	0.002	0.003	7920	60	25	0.002	0.003
1.0	20	19860	150	62	0.002	0.003	12960	110	41	0.002	0.002	7920	60	25	0.002	0.002
1.0	22	9930	65	31	0.002	0.003	6480	45	20	0.002	0.002	3960	25	12	0.002	0.002
1.0	26	9930	65	31	0.002	0.003	6480	45	20	0.002	0.002	3960	25	12	0.002	0.002
1.2	3	29750	365	112	0.003	0.036	18900	265	71	0.004	0.027	11700	140	44	0.003	0.022
1.2	4	29750	365	112	0.003	0.025	18900	265	71	0.004	0.019	11700	140	44	0.003	0.015
1.2	6	29750	365	112	0.003	0.025	18900	265	71	0.004	0.019	11700	140	44	0.003	0.015
1.2	8	26780	295	101	0.003	0.014	17010	215	64	0.003	0.011	10530	115	40	0.003	0.009
1.2	10	26780	295	101	0.003	0.009	17010	215	64	0.003	0.007	10530	115	40	0.003	0.005
1.2	12	26780	295	101	0.003	0.009	17010	215	64	0.003	0.007	10530	115	40	0.003	0.005
1.2	16	23800	235	90	0.002	0.005	15120	170	57	0.003	0.004	9360	90	35	0.002	0.003
1.2	20	17850	155	67	0.002	0.004	11340	110	43	0.002	0.003	7020	60	26	0.002	0.002
1.5	4	26400	370	124	0.004	0.045	16200	270	76	0.004	0.034	10200	140	48	0.003	0.027
1.5	6	26400	370	124	0.004	0.032	16200	270	76	0.004	0.024	10200	140	48	0.003	0.019
1.5	8	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	10	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	12	23760	300	112	0.003	0.018	14580	220	69	0.004	0.014	9180	115	43	0.003	0.011
1.5	14	23760	300	112	0.003	0.011	14580	220	69	0.004	0.008	9180	115	43	0.003	0.007
1.5	16	21120	235	100	0.003	0.011	12960	175	61	0.003	0.008	8160	90	38	0.003	0.007
1.5	20	21120	235	100	0.003	0.007	12960	175	61	0.003	0.005	8160	90	38	0.003	0.004
1.5	22	21120	235	100	0.003	0.007	12960	175	61	0.003	0.005	8160	90	38	0.003	0.004
1.5	26	15840	155	75	0.002	0.005	9720	115	46	0.003	0.003	6120	60	29	0.002	0.003
2.0	6	21600	380	136	0.004	0.060	13800	280	87	0.005	0.045	8640	150	54	0.004	0.036
2.0	8	21600	380	136	0.004	0.042	13800	280	87	0.005	0.032	8640	150	54	0.004	0.025
2.0	10	21600	380	136	0.004	0.042	13800	280	87	0.005	0.032	8640	150	54	0.004	0.025
2.0	12	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2.0	14	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2.0	16	19440	310	122	0.004	0.024	12420	225	78	0.005	0.018	7780	120	49	0.004	0.014
2.0	20	19440	310	122	0.004	0.015	12420	225	78	0.005	0.011	7780	120	49	0.004	0.009
2.0	22	17280	245	109	0.004	0.015	11040	180	69	0.004	0.011	6910	95	43	0.003	0.009
2.0	26	17280	245	109	0.004	0.015	11040	180	69	0.004	0.011	6910	95	43	0.003	0.009
2.0	30	17280	245	109	0.004	0.009	11040	180	69	0.004	0.007	6910	95	43	0.003	0.005
2.5	8	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	10	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	12	18000	390	141	0.005	0.053	11400	300	90	0.007	0.039	7320	150	57	0.005	0.032
2.5	14	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	16	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	20	16200	315	127	0.005	0.030	10260	245	81	0.006	0.023	6590	120	52	0.005	0.018
2.5	26	14400	250	113	0.004	0.019	9120	190	72	0.005	0.014	5860	95	46	0.004	0.011
2.5	30	14400	250	113	0.004	0.019	9120	190	72	0.005	0.014	5860	95	46	0.004	0.011

DIA. = Diameter
LBS = Length Below Shank
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

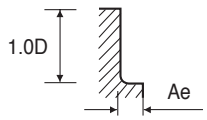
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE MULTIPLE HELIX CORNER RADIUS with EXTENDED NECK
VOLLHARTMETALL, 4 SCHNEIDEN MEHRSPIRAL ECKENRADIUS mit ABGESETZTEM SCHAFTTETL

SEME64 SERIES

MATERIAL		NON-ALLOYED STEELS ALLOY STEELS CAST IRON					ALLOY STEELS HEAT RESISTANT STEELS					HARDENED STEELS				
HARDNESS		~ HRc 35					HRc 35 ~ HRc 45					HRc 45 ~ HRc 55				
STRENGTH		~ 1100N/mm²					1110 ~ 1500N/mm²					1500 ~ 2000N/mm²				
DIA.	LBS	RPM	FEED	Vc	fz	Ae(mm)	RPM	FEED	Vc	fz	Ae(mm)	RPM	FEED	Vc	fz	Ae(mm)
3.0	8	15900	400	150	0.006	0.090	10300	310	97	0.008	0.068	6300	150	59	0.006	0.054
3.0	10	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3.0	12	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3.0	14	15900	400	150	0.006	0.063	10300	310	97	0.008	0.047	6300	150	59	0.006	0.038
3.0	16	14310	325	135	0.006	0.036	9270	250	87	0.007	0.027	5670	120	53	0.005	0.022
3.0	20	14310	325	135	0.006	0.036	9270	250	87	0.007	0.027	5670	120	53	0.005	0.022
3.0	26	14310	325	135	0.006	0.023	9270	250	87	0.007	0.017	5670	120	53	0.005	0.014
3.0	30	14310	325	135	0.006	0.023	9270	250	87	0.007	0.017	5670	120	53	0.005	0.014
3.0	35	12720	255	120	0.005	0.023	8240	200	78	0.006	0.017	5040	95	48	0.005	0.014
3.0	40	12720	255	120	0.005	0.014	8240	200	78	0.006	0.010	5040	95	48	0.005	0.008
4.0	10	12800	500	161	0.010	0.120	8200	360	103	0.011	0.090	5150	160	65	0.008	0.072
4.0	12	12800	500	161	0.010	0.120	8200	360	103	0.011	0.090	5150	160	65	0.008	0.072
4.0	14	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4.0	16	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4.0	20	12800	500	161	0.010	0.084	8200	360	103	0.011	0.063	5150	160	65	0.008	0.050
4.0	26	11520	405	145	0.009	0.048	7380	290	93	0.010	0.036	4640	130	58	0.007	0.029
4.0	30	11520	405	145	0.009	0.048	7380	290	93	0.010	0.036	4640	130	58	0.007	0.029
4.0	35	11520	405	145	0.009	0.030	7380	290	93	0.010	0.023	4640	130	58	0.007	0.018
4.0	40	11520	405	145	0.009	0.030	7380	290	93	0.010	0.023	4640	130	58	0.007	0.018
4.0	45	10240	320	129	0.008	0.030	6560	230	82	0.009	0.023	4120	100	52	0.006	0.018
4.0	50	10240	320	129	0.008	0.030	6560	230	82	0.009	0.023	4120	100	52	0.006	0.018
5.0	15	11000	510	173	0.012	0.150	7000	430	110	0.015	0.113	4560	200	72	0.011	0.090
6.0	20	9500	510	179	0.013	0.126	6000	430	113	0.018	0.095	3930	200	74	0.013	0.076
6.0	30	9500	510	179	0.013	0.126	6000	430	113	0.018	0.095	3930	200	74	0.013	0.076
8.0	25	7200	550	181	0.019	0.168	4550	430	114	0.024	0.126	3020	200	76	0.017	0.101
8.0	35	7200	550	181	0.019	0.168	4550	430	114	0.024	0.126	3020	200	76	0.017	0.101
10.0	30	6000	550	188	0.023	0.300	4000	430	126	0.027	0.225	2420	200	76	0.021	0.180
10.0	40	6000	550	188	0.023	0.210	4000	430	126	0.027	0.158	2420	200	76	0.021	0.126
12.0	32	5000	430	188	0.022	0.360	3340	380	126	0.028	0.270	2000	160	75	0.020	0.216
12.0	45	5000	430	188	0.022	0.252	3340	380	126	0.028	0.189	2000	160	75	0.020	0.151
16.0	35	3720	330	187	0.022	0.480	2520	280	127	0.028	0.360	1540	135	77	0.022	0.288
16.0	50	3720	330	187	0.022	0.336	2520	280	127	0.028	0.252	1540	135	77	0.022	0.202
20.0	40	3000	270	188	0.023	0.600	1950	210	123	0.027	0.450	1200	100	75	0.021	0.360
20.0	55	3000	270	188	0.023	0.600	1950	210	123	0.027	0.450	1200	100	75	0.021	0.360



DIA. = Diameter
LBS = Length Below Shank

RPM = rev./min.
FEED = mm/min.

Vc = m/min.
fz = mm/t