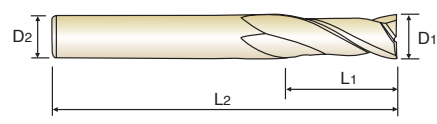


**CARBIDE, 2 FLUTE LONG LENGTH**  
**VOLLHARTMETALL, 2 SCHNEIDEN LANG**

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Unit : mm

| EDP No.        | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|----------------|---------------|----------------|---------------|----------------|
|                | D1            | D2             | L1            | 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             |
| SEME7002510E   | 2.5           | 6              | 10            | 60             |
| SEME7002512E   | 2.5           | 6              | 12            | 60             |
| ★ SEME7002516E | 2.5           | 6              | 16            | 60             |
| SEME7002520E   | 2.5           | 6              | 20            | 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             |        |          |           |          |                  |          |         |         |      |
| ◎             | ◎            | ◎                  | ◎               | ○        |                      |        |          |           |          |                  |          |         |         |      |



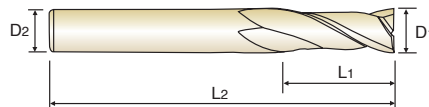
**SEME70** SERIES

PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

**CARBIDE, 2 FLUTE LONG LENGTH  
VOLLHARTMETALL, 2 SCHNEIDEN LANG**

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Unit : mm

| EDP No.           | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|-------------------|---------------|----------------|---------------|----------------|
|                   | D1            | D2             | L1            | L2             |
| 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             |
| ★ 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            |

▶ ★ Stock Item

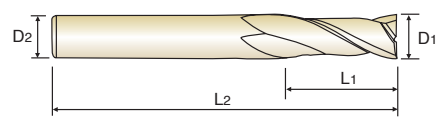
◎ : Excellent ○ : Good

| 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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Unit : mm

| EDP No.           | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|-------------------|---------------|----------------|---------------|----------------|
|                   | D1            | D2             | L1            | L2             |
| ★ 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             |
| ★ 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             |

▶ ★ Stock Item

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|---------------|--------------|--------------------|-----------------|----------|----------------------|--------|----------|-----------|----------|------------------|----------|---------|---------|------|
| ~HB225        | HB225~325    | HRC30~40           | HRC40~45        | HRC45~55 | HRC55~70             |        |          |           |          |                  |          |         |         |      |
| ◎             | ◎            | ◎                  | ◎               | ○        |                      |        |          |           |          |                  |          |         |         |      |

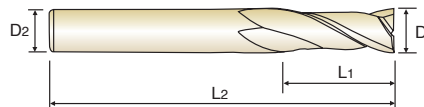


PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

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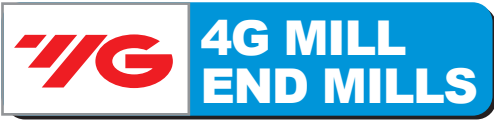
Unit : mm

| EDP No.           | Mill Diameter<br>D1 | Shank Diameter<br>D2 | Length of Cut<br>L1 | Overall Length<br>L2 |
|-------------------|---------------------|----------------------|---------------------|----------------------|
| ★ 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                  |
| 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                  |

▶ ★ Stock Item

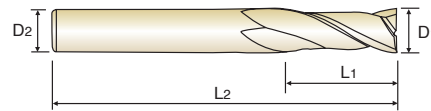
◎ : Excellent ○ : Good

| 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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MG HM 2 30° PLAIN P.805, 806

Unit : mm

| EDP No.           | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|-------------------|---------------|----------------|---------------|----------------|
|                   | D1            | D2             | L1            | L2             |
| 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            |
| 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                 | 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             |        |          |           |          |                  |          |         |         |      |
| ◎             | ◎            | ◎                  | ◎               | ○        |                      |        |          |           |          |                  |          |         |         |      |

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

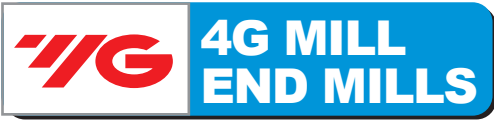
GENERAL CARBIDE END MILLS

TANK-POWER END MILLS

GENERAL HSS END MILLS

MILLING CUTTERS

TECHNICAL DATA



**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 2 FLUTE LONG LENGTH  
VOLLHARTMETALL, 2 SCHNEIDEN**

**SEME70 SERIES**

| MATERIAL |     | NON-ALLOYED STEELS<br>ALLOY STEELS<br>CAST IRON |      |    |       | ALLOY STEELS<br>HEAT RESISTANT STEELS |      |    |       | HARDENED STEELS              |      |    |       |
|----------|-----|---|------|----|-------|---------------------------------------|------|----|-------|------------------------------|------|----|-------|
| HARDNESS |     | ~ HRC 35  |      |    |       | HRC 35 ~ HRC 45                       |      |    |       | HRC 45 ~ HRC 55              |      |    |       |
| STRENGTH |     | ~ 1100N/mm <sup>2</sup>                         |      |    |       | 1110 ~ 1500N/mm <sup>2</sup>          |      |    |       | 1500 ~ 2000N/mm <sup>2</sup> |      |    |       |
| DIA.     | LOC | RPM   | FEED | Vc | fz    | RPM                                   | FEED | Vc | fz    | RPM                          | FEED | Vc | fz    |
| 1.0      | 3   | 16000   | 70   | 50 | 0.002 | 12800                                 | 60   | 40 | 0.002 | 8000                         | 30   | 25 | 0.002 |
| 1.0      | 4   | 16000   | 70   | 50 | 0.002 | 12800                                 | 60   | 40 | 0.002 | 8000                         | 30   | 25 | 0.002 |
| 1.0      | 5   | 16000   | 70   | 50 | 0.002 | 12800                                 | 60   | 40 | 0.002 | 8000                         | 30   | 25 | 0.002 |
| 1.0      | 6   | 14400   | 55   | 45 | 0.002 | 11520                                 | 50   | 36 | 0.002 | 7200                         | 25   | 23 | 0.002 |
| 1.0      | 7   | 14400   | 55   | 45 | 0.002 | 11520                                 | 50   | 36 | 0.002 | 7200                         | 25   | 23 | 0.002 |
| 1.0      | 8   | 14400   | 50   | 45 | 0.002 | 11520                                 | 45   | 36 | 0.002 | 7200                         | 20   | 23 | 0.001 |
| 1.0      | 10  | 14400   | 50   | 45 | 0.002 | 11520                                 | 45   | 36 | 0.002 | 7200                         | 20   | 23 | 0.001 |
| 1.0      | 12  | 12800   | 40   | 40 | 0.002 | 10240                                 | 35   | 32 | 0.002 | 6400                         | 15   | 20 | 0.001 |
| 1.2      | 4   | 13500   | 75   | 51 | 0.003 | 10800                                 | 65   | 41 | 0.003 | 6750                         | 30   | 25 | 0.002 |
| 1.2      | 6   | 13500   | 75   | 51 | 0.003 | 10800                                 | 65   | 41 | 0.003 | 6750                         | 30   | 25 | 0.002 |
| 1.2      | 8   | 12150   | 60   | 46 | 0.002 | 9720                                  | 50   | 37 | 0.003 | 6080                         | 25   | 23 | 0.002 |
| 1.2      | 10  | 12150   | 55   | 46 | 0.002 | 9720                                  | 45   | 37 | 0.002 | 6080                         | 20   | 23 | 0.002 |
| 1.2      | 12  | 12150   | 55   | 46 | 0.002 | 9720                                  | 45   | 37 | 0.002 | 6080                         | 20   | 23 | 0.002 |
| 1.5      | 6   | 11200   | 80   | 53 | 0.004 | 8960                                  | 70   | 42 | 0.004 | 5600                         | 30   | 26 | 0.003 |
| 1.5      | 8   | 10080   | 70   | 48 | 0.003 | 8060                                  | 60   | 38 | 0.004 | 5040                         | 30   | 24 | 0.003 |
| 1.5      | 10  | 10080   | 65   | 48 | 0.003 | 8060                                  | 55   | 38 | 0.003 | 5040                         | 25   | 24 | 0.002 |
| 1.5      | 12  | 10080   | 60   | 48 | 0.003 | 8060                                  | 50   | 38 | 0.003 | 5040                         | 25   | 24 | 0.002 |
| 1.5      | 14  | 10080   | 60   | 48 | 0.003 | 8060                                  | 50   | 38 | 0.003 | 5040                         | 25   | 24 | 0.002 |
| 1.5      | 16  | 8960  | 45   | 42 | 0.003 | 7170                                  | 40   | 34 | 0.003 | 4480                         | 20   | 21 | 0.002 |
| 2.0      | 8   | 9070  | 85   | 57 | 0.005 | 7260                                  | 70   | 46 | 0.005 | 4540                         | 35   | 29 | 0.004 |
| 2.0      | 10  | 9070  | 85   | 57 | 0.005 | 7260                                  | 70   | 46 | 0.005 | 4540                         | 35   | 29 | 0.004 |
| 2.0      | 12  | 8160  | 70   | 51 | 0.004 | 6530                                  | 60   | 41 | 0.005 | 4090                         | 30   | 26 | 0.004 |
| 2.0      | 14  | 8160  | 70   | 51 | 0.004 | 6530                                  | 60   | 41 | 0.005 | 4090                         | 30   | 26 | 0.004 |
| 2.0      | 16  | 8160  | 60   | 51 | 0.004 | 6530                                  | 50   | 41 | 0.004 | 4090                         | 25   | 26 | 0.003 |
| 2.5      | 10  | 7700  | 95   | 60 | 0.006 | 6200                                  | 80   | 49 | 0.006 | 3850                         | 40   | 30 | 0.005 |
| 2.5      | 12  | 7700  | 95   | 60 | 0.006 | 6200                                  | 80   | 49 | 0.006 | 3850                         | 40   | 30 | 0.005 |
| 2.5      | 16  | 6930  | 75   | 54 | 0.005 | 5580                                  | 65   | 44 | 0.006 | 3470                         | 30   | 27 | 0.004 |
| 2.5      | 20  | 6930  | 70   | 54 | 0.005 | 5580                                  | 55   | 44 | 0.005 | 3470                         | 30   | 27 | 0.004 |
| 2.5      | 26  | 6160  | 55   | 48 | 0.004 | 4960                                  | 45   | 39 | 0.005 | 3080                         | 20   | 24 | 0.003 |
| 3.0      | 10  | 6350  | 100  | 60 | 0.008 | 5150                                  | 85   | 49 | 0.008 | 3170                         | 40   | 30 | 0.006 |
| 3.0      | 12  | 6350  | 100  | 60 | 0.008 | 5150                                  | 85   | 49 | 0.008 | 3170                         | 40   | 30 | 0.006 |
| 3.0      | 14  | 6350  | 100  | 60 | 0.008 | 5150                                  | 85   | 49 | 0.008 | 3170                         | 40   | 30 | 0.006 |
| 3.0      | 16  | 5720  | 90   | 54 | 0.008 | 4640                                  | 75   | 44 | 0.008 | 2850                         | 40   | 27 | 0.007 |
| 3.0      | 20  | 5720  | 80   | 54 | 0.007 | 4640                                  | 70   | 44 | 0.008 | 2850                         | 35   | 27 | 0.006 |
| 3.0      | 26  | 5720  | 70   | 54 | 0.006 | 4640                                  | 60   | 44 | 0.006 | 2850                         | 30   | 27 | 0.005 |
| 3.0      | 30  | 5720  | 70   | 54 | 0.006 | 4640                                  | 60   | 44 | 0.006 | 2850                         | 30   | 27 | 0.005 |
| 4.0      | 12  | 5150  | 120  | 65 | 0.012 | 4100                                  | 100  | 52 | 0.012 | 2580                         | 50   | 32 | 0.010 |
| 4.0      | 16  | 5150  | 120  | 65 | 0.012 | 4100                                  | 100  | 52 | 0.012 | 2580                         | 50   | 32 | 0.010 |
| 4.0      | 20  | 5150  | 120  | 65 | 0.012 | 4100                                  | 100  | 52 | 0.012 | 2580                         | 50   | 32 | 0.010 |
| 4.0      | 26  | 4640  | 95   | 58 | 0.010 | 3690                                  | 85   | 46 | 0.012 | 2320                         | 40   | 29 | 0.009 |
| 4.0      | 30  | 4640  | 95   | 58 | 0.010 | 3690                                  | 85   | 46 | 0.012 | 2320                         | 40   | 29 | 0.009 |
| 5.0      | 20  | 4400  | 150  | 69 | 0.017 | 3480                                  | 125  | 55 | 0.018 | 2280                         | 55   | 36 | 0.012 |
| 5.0      | 25  | 4400  | 150  | 69 | 0.017 | 3480                                  | 125  | 55 | 0.018 | 2280                         | 55   | 36 | 0.012 |
| 5.0      | 30  | 3960  | 120  | 62 | 0.015 | 3130                                  | 100  | 49 | 0.016 | 2050                         | 45   | 32 | 0.011 |
| 5.0      | 35  | 3960  | 120  | 62 | 0.015 | 3130                                  | 100  | 49 | 0.016 | 2050                         | 45   | 32 | 0.011 |
| 5.0      | 40  | 3960  | 110  | 62 | 0.014 | 3130                                  | 90   | 49 | 0.014 | 2050                         | 40   | 32 | 0.010 |
| 6.0      | 15  | 3800  | 180  | 72 | 0.024 | 3050                                  | 150  | 57 | 0.025 | 1970                         | 70   | 37 | 0.018 |
| 6.0      | 20  | 3800  | 180  | 72 | 0.024 | 3050                                  | 150  | 57 | 0.025 | 1970                         | 70   | 37 | 0.018 |
| 6.0      | 25  | 3800  | 180  | 72 | 0.024 | 3050                                  | 150  | 57 | 0.025 | 1970                         | 70   | 37 | 0.018 |
| 6.0      | 30  | 3800  | 155  | 72 | 0.020 | 3050                                  | 130  | 57 | 0.021 | 1970                         | 60   | 37 | 0.015 |
| 6.0      | 35  | 3420  | 140  | 64 | 0.020 | 2750                                  | 115  | 52 | 0.021 | 1770                         | 55   | 33 | 0.016 |
| 6.0      | 40  | 3420  | 120  | 64 | 0.018 | 2750                                  | 100  | 52 | 0.018 | 1770                         | 50   | 33 | 0.014 |
| 6.0      | 45  | 3420  | 120  | 64 | 0.018 | 2750                                  | 100  | 52 | 0.018 | 1770                         | 50   | 33 | 0.014 |

DIA. = Diameter RPM = rev./min. Vc = m/min.  
LOC = Length of Cut FEED = mm/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

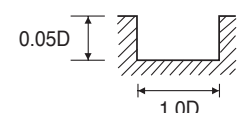
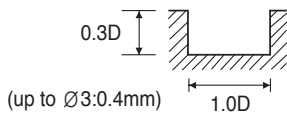


**RECOMMENDED CUTTING CONDITIONS**  
**EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 2 FLUTE LONG LENGTH**  
**VOLLHARTMETALL, 2 SCHNEIDEN**

**SEME70 SERIES**

| MATERIAL |     | NON-ALLOYED STEELS<br>ALLOY STEELS<br>CAST IRON |      |    |       | ALLOY STEELS<br>HEAT RESISTANT STEELS |      |    |       | HARDENED STEELS              |      |    |       |
|----------|-----|---|------|----|-------|---------------------------------------|------|----|-------|------------------------------|------|----|-------|
| HARDNESS |     | ~ HRc 35  |      |    |       | HRc 35 ~ HRc 45                       |      |    |       | HRc 45 ~ HRc 55              |      |    |       |
| STRENGTH |     | ~ 1100N/mm <sup>2</sup>                         |      |    |       | 1110 ~ 1500N/mm <sup>2</sup>          |      |    |       | 1500 ~ 2000N/mm <sup>2</sup> |      |    |       |
| DIA.     | LOC | RPM   | FEED | Vc | fz    | RPM                                   | FEED | Vc | fz    | RPM                          | FEED | Vc | fz    |
| 8.0      | 25  | 2880  | 190  | 72 | 0.033 | 2280                                  | 150  | 57 | 0.033 | 1510                         | 70   | 38 | 0.023 |
| 8.0      | 30  | 2880  | 190  | 72 | 0.033 | 2280                                  | 150  | 57 | 0.033 | 1510                         | 70   | 38 | 0.023 |
| 8.0      | 35  | 2880  | 190  | 72 | 0.033 | 2280                                  | 150  | 57 | 0.033 | 1510                         | 70   | 38 | 0.023 |
| 8.0      | 40  | 2880  | 160  | 72 | 0.028 | 2280                                  | 125  | 57 | 0.027 | 1510                         | 60   | 38 | 0.020 |
| 8.0      | 45  | 2590  | 145  | 65 | 0.028 | 2050                                  | 115  | 52 | 0.028 | 1360                         | 55   | 34 | 0.020 |
| 8.0      | 50  | 2590  | 130  | 65 | 0.025 | 2050                                  | 100  | 52 | 0.024 | 1360                         | 50   | 34 | 0.018 |
| 10.0     | 30  | 2450  | 190  | 77 | 0.039 | 2000                                  | 150  | 63 | 0.038 | 1210                         | 70   | 38 | 0.029 |
| 10.0     | 35  | 2450  | 190  | 77 | 0.039 | 2000                                  | 150  | 63 | 0.038 | 1210                         | 70   | 38 | 0.029 |
| 10.0     | 40  | 2450  | 190  | 77 | 0.039 | 2000                                  | 150  | 63 | 0.038 | 1210                         | 70   | 38 | 0.029 |
| 10.0     | 45  | 2450  | 160  | 77 | 0.033 | 2000                                  | 125  | 63 | 0.031 | 1210                         | 60   | 38 | 0.025 |
| 10.0     | 50  | 2450  | 160  | 77 | 0.033 | 2000                                  | 125  | 63 | 0.031 | 1210                         | 60   | 38 | 0.025 |
| 10.0     | 55  | 2210  | 145  | 69 | 0.033 | 1800                                  | 115  | 57 | 0.032 | 1090                         | 55   | 34 | 0.025 |
| 10.0     | 60  | 2210  | 130  | 69 | 0.029 | 1800                                  | 100  | 57 | 0.028 | 1090                         | 50   | 34 | 0.023 |
| 12.0     | 35  | 2000  | 150  | 75 | 0.038 | 1670                                  | 135  | 63 | 0.040 | 1010                         | 55   | 38 | 0.027 |
| 12.0     | 40  | 2000  | 150  | 75 | 0.038 | 1670                                  | 135  | 63 | 0.040 | 1010                         | 55   | 38 | 0.027 |
| 12.0     | 45  | 2000  | 130  | 75 | 0.033 | 1670                                  | 115  | 63 | 0.034 | 1010                         | 45   | 38 | 0.022 |
| 12.0     | 50  | 2000  | 130  | 75 | 0.033 | 1670                                  | 115  | 63 | 0.034 | 1010                         | 45   | 38 | 0.022 |
| 12.0     | 55  | 2000  | 130  | 75 | 0.033 | 1670                                  | 115  | 63 | 0.034 | 1010                         | 45   | 38 | 0.022 |
| 12.0     | 60  | 2000  | 110  | 75 | 0.028 | 1670                                  | 100  | 63 | 0.030 | 1010                         | 40   | 38 | 0.020 |
| 12.0     | 65  | 1800  | 100  | 68 | 0.028 | 1500                                  | 90   | 57 | 0.030 | 910                          | 35   | 34 | 0.019 |
| 12.0     | 70  | 1800  | 100  | 68 | 0.028 | 1500                                  | 90   | 57 | 0.030 | 910                          | 35   | 34 | 0.019 |
| 14.0     | 50  | 1850  | 125  | 81 | 0.034 | 1480                                  | 100  | 65 | 0.034 | 910                          | 45   | 40 | 0.025 |
| 14.0     | 60  | 1850  | 125  | 81 | 0.034 | 1480                                  | 100  | 65 | 0.034 | 910                          | 45   | 40 | 0.025 |
| 16.0     | 40  | 1700  | 140  | 85 | 0.041 | 1280                                  | 105  | 64 | 0.041 | 800                          | 50   | 40 | 0.031 |
| 16.0     | 50  | 1700  | 140  | 85 | 0.041 | 1280                                  | 105  | 64 | 0.041 | 800                          | 50   | 40 | 0.031 |
| 16.0     | 60  | 1700  | 120  | 85 | 0.035 | 1280                                  | 90   | 64 | 0.035 | 800                          | 40   | 40 | 0.025 |
| 16.0     | 70  | 1700  | 120  | 85 | 0.035 | 1280                                  | 90   | 64 | 0.035 | 800                          | 40   | 40 | 0.025 |
| 16.0     | 80  | 1700  | 105  | 85 | 0.031 | 1280                                  | 80   | 64 | 0.031 | 800                          | 35   | 40 | 0.022 |
| 16.0     | 90  | 1530  | 95   | 77 | 0.031 | 1150                                  | 70   | 58 | 0.030 | 720                          | 30   | 36 | 0.021 |
| 16.0     | 110 | 1530  | 95   | 77 | 0.031 | 1150                                  | 70   | 58 | 0.030 | 720                          | 30   | 36 | 0.021 |
| 16.0     | 120 | 1530  | 95   | 77 | 0.031 | 1150                                  | 70   | 58 | 0.030 | 720                          | 30   | 36 | 0.021 |
| 18.0     | 50  | 1450  | 120  | 82 | 0.041 | 1120                                  | 90   | 63 | 0.040 | 700                          | 40   | 40 | 0.029 |
| 18.0     | 70  | 1450  | 100  | 82 | 0.034 | 1120                                  | 75   | 63 | 0.033 | 700                          | 35   | 40 | 0.025 |
| 18.0     | 100 | 1310  | 80   | 74 | 0.031 | 1000                                  | 60   | 57 | 0.030 | 630                          | 30   | 36 | 0.024 |
| 20.0     | 50  | 1220  | 100  | 77 | 0.041 | 950                                   | 75   | 60 | 0.039 | 600                          | 35   | 38 | 0.029 |
| 20.0     | 60  | 1220  | 100  | 77 | 0.041 | 950                                   | 75   | 60 | 0.039 | 600                          | 35   | 38 | 0.029 |
| 20.0     | 70  | 1220  | 85   | 77 | 0.035 | 950                                   | 65   | 60 | 0.034 | 600                          | 30   | 38 | 0.025 |
| 20.0     | 80  | 1220  | 85   | 77 | 0.035 | 950                                   | 65   | 60 | 0.034 | 600                          | 30   | 38 | 0.025 |
| 20.0     | 90  | 1220  | 75   | 77 | 0.031 | 950                                   | 55   | 60 | 0.029 | 600                          | 25   | 38 | 0.021 |
| 20.0     | 110 | 1100  | 70   | 69 | 0.032 | 860                                   | 50   | 54 | 0.029 | 540                          | 25   | 34 | 0.023 |
| 20.0     | 120 | 1100  | 70   | 69 | 0.032 | 860                                   | 50   | 54 | 0.029 | 540                          | 25   | 34 | 0.023 |
| 22.0     | 75  | 1100  | 75   | 76 | 0.034 | 840                                   | 55   | 58 | 0.033 | 550                          | 30   | 38 | 0.027 |
| 22.0     | 110 | 1100  | 70   | 76 | 0.032 | 840                                   | 50   | 58 | 0.030 | 550                          | 25   | 38 | 0.023 |
| 25.0     | 70  | 980   | 80   | 77 | 0.041 | 750                                   | 60   | 59 | 0.040 | 480                          | 30   | 38 | 0.031 |
| 25.0     | 90  | 980   | 70   | 77 | 0.036 | 750                                   | 50   | 59 | 0.033 | 480                          | 25   | 38 | 0.026 |
| 25.0     | 110 | 980   | 70   | 77 | 0.036 | 750                                   | 50   | 59 | 0.033 | 480                          | 25   | 38 | 0.026 |
| 25.0     | 120 | 980   | 60   | 77 | 0.031 | 750                                   | 45   | 59 | 0.030 | 480                          | 25   | 38 | 0.026 |



DIA. = Diameter  
LOC = Length of Cut  
RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t