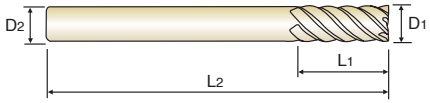
4G MILL END MILLS

SEME75 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

CARBIDE, 6 FLUTE 45° HELIX (Regular, Long Shank)
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE

- 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 45 helix angle, better surface roughness can be achieved at side cutting.
- Available various effective length and overall length products.

- 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 45° Spirale werden bessere Oberlächengüten bei der Eckbearbeitung erreicht
- Erhältlich in verschiedenen gesamt Längen und effektiv Längen.



MG HM | 6 | 45° | PLAIN

P.817, 818

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
SEME75060301 10E	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
SEME75080401 30E	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
SEME75100501 50E	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
SEME75120601 50E	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
SEME751601102 50E	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
SEME752001102 50E	20.0	20	110	250	Long
SEME752001103 00E	20.0	20	110	300	Long

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~−0.03	h6

▶ ★ 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

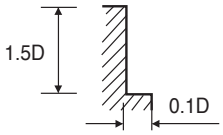
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

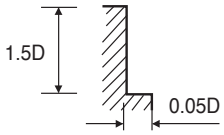
CARBIDE, 6 FLUTE 45° HELIX
VOLLHARTMETALL, 6 SCHNEIDEN

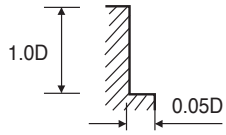
SEME75 SERIES

■ NORMAL SPEED

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.	LOC	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15	5840	2100	110	0.060	4075	1440	77	0.059	1660	220	31	0.022
6.0	20	5840	2100	110	0.060	4075	1440	77	0.059	1660	220	31	0.022
6.0	30	5840	1785	110	0.051	4075	1225	77	0.050	1660	190	31	0.019
8.0	20	4410	2100	111	0.079	3085	1440	78	0.078	1220	220	31	0.030
8.0	30	4410	2100	111	0.079	3085	1440	78	0.078	1220	220	31	0.030
8.0	35	4410	2100	111	0.079	3085	1440	78	0.078	1220	220	31	0.030
8.0	40	4410	1785	111	0.067	3085	1225	78	0.066	1220	190	31	0.026
10.0	25	3530	2100	111	0.099	2435	1440	76	0.099	1050	220	33	0.035
10.0	30	3530	2100	111	0.099	2435	1440	76	0.099	1050	220	33	0.035
10.0	40	3530	2100	111	0.099	2435	1440	76	0.099	1050	220	33	0.035
10.0	50	3530	1785	111	0.084	2435	1225	76	0.084	1050	190	33	0.030
12.0	30	2980	1765	112	0.099	2100	1220	79	0.097	880	190	33	0.036
12.0	40	2980	1765	112	0.099	2100	1220	79	0.097	880	190	33	0.036
12.0	50	2980	1500	112	0.084	2100	1035	79	0.082	880	165	33	0.031
12.0	60	2980	1325	112	0.074	2100	915	79	0.073	880	140	33	0.027
16.0	40	2205	1325	111	0.100	1555	925	78	0.099	670	135	34	0.034
16.0	50	2205	1325	111	0.100	1555	925	78	0.099	670	135	34	0.034
16.0	60	2205	1125	111	0.085	1555	790	78	0.085	670	115	34	0.029
16.0	90	1985	895	100	0.075	1395	625	70	0.075	610	95	31	0.026
16.0	110	1985	895	100	0.075	1395	625	70	0.075	610	95	31	0.026
20.0	45	1765	1060	111	0.100	1220	725	77	0.099	525	115	33	0.037
20.0	60	1765	1060	111	0.100	1220	725	77	0.099	525	115	33	0.037
20.0	70	1765	905	111	0.085	1220	615	77	0.084	525	100	33	0.032
20.0	110	1585	715	100	0.075	1090	490	68	0.075	475	80	30	0.028







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

4G MILL END MILLS

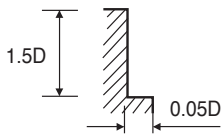
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

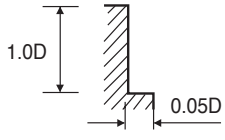
CARBIDE, 6 FLUTE 45° HELIX
VOLLHARTMETALL, 6 SCHNEIDEN

SEME75 SERIES

■ HIGH SPEED

MATERIAL		ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS		HRc 35 ~ HRc 45				HRc 45 ~ HRc 55			
STRENGTH		1110 ~ 1500N/mm²				1500 ~ 2000N/mm²			
DIAMETER	Length of Cut	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15	17640	6395	333	0.060	8820	3205	166	0.061
6.0	20	17640	6395	333	0.060	8820	3205	166	0.061
6.0	30	17640	5435	333	0.051	8820	2720	166	0.051
8.0	20	13230	6395	333	0.081	6615	3205	166	0.081
8.0	30	13230	6395	333	0.081	6615	3205	166	0.081
8.0	35	13230	6395	333	0.081	6615	3205	166	0.081
8.0	40	13230	5435	333	0.068	6615	2725	166	0.069
10.0	25	10480	6290	329	0.100	5290	3205	166	0.101
10.0	30	10480	6290	329	0.100	5290	3205	166	0.101
10.0	40	10480	6290	329	0.100	5290	3205	166	0.101
10.0	50	10480	5345	329	0.085	5290	2720	166	0.086
12.0	30	8820	5290	333	0.100	4410	2645	166	0.100
12.0	40	8820	5290	333	0.100	4410	2645	166	0.100
12.0	50	8820	4500	333	0.085	4410	2245	166	0.085
12.0	60	8820	3970	333	0.075	4410	1985	166	0.075
16.0	40	6615	3970	333	0.100	3320	1985	167	0.100
16.0	50	6615	3970	333	0.100	3320	1985	167	0.100
16.0	60	6615	3375	333	0.085	3320	1685	167	0.085
16.0	90	5955	2680	299	0.075	2980	1340	150	0.075
16.0	110	5955	2680	299	0.075	2980	1340	150	0.075
20.0	45	5290	3205	332	0.101	2645	1545	166	0.097
20.0	60	5290	3205	332	0.101	2645	1545	166	0.097
20.0	70	5290	2720	332	0.086	2645	1315	166	0.083
20.0	110	4765	2165	299	0.076	2385	1040	150	0.073





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