

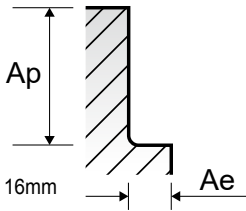
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME01 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

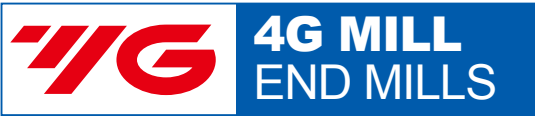
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

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

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

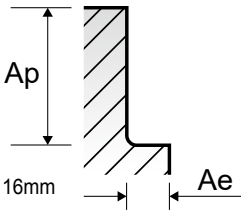


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME01 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

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

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



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