

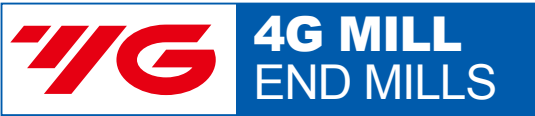
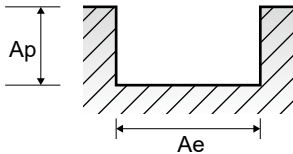
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)															
						1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2				
					LOC	3	4	5	6	7	8	10	12	4	6	8	10				
P	1-5	Non-alloy steel	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002				
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202				
					FEED	64	64	64	57	57	57	57	51	81	81	49	49				
	6-8	Low alloy steel	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002				
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202				
					FEED	64	64	64	57	57	57	57	51	81	81	49	49				
	9	Low alloy steel	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002				
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815				
					FEED	51	51	51	46	46	46	46	41	65	65	59	39				
	10-11.1	High alloyed steel, and tool steel	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002				
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202				
					FEED	64	64	64	57	57	57	57	51	81	81	49	49				
	11.2	High alloyed steel, and tool steel	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002				
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815				
					FEED	51	51	51	46	46	46	46	41	65	65	59	39				
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	50	50	50	45	45	45	45	40	51	51	46	46				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.002	0.002				
					RPM	15915	15915	15915	14324	14324	14324	14324	12732	13528	13528	12202	12202				
					FEED	64	64	64	57	57	57	57	51	81	81	49	49				
H	38.1 - 38.2	Hardened steel	1.0D	0.05D	Vc	25	25	25	23	23	23	23	20	25	25	23	23				
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002				
					RPM	7958	7958	7958	7321	7321	7321	7321	6366	6631	6631	6101	6101				
					FEED	32	32	32	29	29	15	15	13	27	27	24	24				
	40	Chilled Cast Iron	1.0D (up to Ø3:0.4mm)	0.3D (up to Ø3:0.4mm)	Vc	40	40	40	36	36	36	36	32	41	41	37	37				
					fz	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.002				
					RPM	12732	12732	12732	11459	11459	11459	11459	10186	10876	10876	9815	9815				
					FEED	51	51	51	46	46	46	46	41	65	65	59	39				
	41	Hardened Cast Iron	1.0D	0.05D	Vc	25	25	25	23	23	23	23	20	25	25	23	23				
					fz	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	0.002	0.002	0.002	0.002				
					RPM	7958	7958	7958	7321	7321	7321	7321	6366	6631	6631	6101	6101				
					FEED	32	32	32	29	29	15	15	13	27	27	24	24				

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RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																				
		1.2	1.5	1.5	1.5	1.5	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.5	2.5	2.5	2.5	2.5	3.0	3.0	3.0
		LOC	12	6	8	10	12	14	16	8	10	12	14	16	10	12	16	20	26	10	12	14
1-5	Vc	46	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60	
	fz	0.002	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008	
	RPM	12202	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366	
	FEED	49	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102	
6-8	Vc	46	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60	
	fz	0.002	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008	
	RPM	12202	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366	
	FEED	49	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102	
9	Vc	37	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49	
	fz	0.002	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	
	RPM	9815	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199	
	FEED	39	71	65	48	48	48	43	73	73	65	65	65	75	75	67	56	50	83	83	83	
10 - 11.1	Vc	46	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60	
	fz	0.002	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008	
	RPM	12202	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366	
	FEED	49	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102	
11.2	Vc	37	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49	
	fz	0.002	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	
	RPM	9815	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199	
	FEED	39	71	65	48	48	48	43	73	73	65	65	65	75	75	67	56	50	83	83	83	
15 - 20	Vc	46	53	48	48	48	48	42	57	57	51	51	51	60	60	54	54	48	60	60	60	
	fz	0.002	0.004	0.003	0.003	0.003	0.003	0.003	0.005	0.005	0.004	0.004	0.004	0.006	0.006	0.005	0.005	0.004	0.008	0.008	0.008	
	RPM	12202	11247	10186	10186	10186	10186	8913	9072	9072	8117	8117	8117	7639	7639	6875	6875	6112	6366	6366	6366	
	FEED	49	90	61	61	61	61	53	91	91	65	65	65	92	92	69	69	49	102	102	102	
38.1 - 38.2	Vc	23	26	24	24	24	24	21	29	29	26	26	26	30	30	27	27	24	30	30	30	
	fz	0.002	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006	0.006	
	RPM	6101	5517	5093	5093	5093	5093	4456	4615	4615	4138	4138	4138	3820	3820	3438	3438	3056	3183	3183	3183	
	FEED	24	33	31	20	20	20	18	37	37	33	33	33	25	38	38	28	28	18	38	38	38
40	Vc	37	42	38	38	38	38	34	46	46	41	41	41	49	49	44	44	39	49	49	49	
	fz	0.002	0.004	0.004	0.003	0.003	0.003	0.003	0.005	0.005	0.005	0.005	0.004	0.006	0.006	0.006	0.005	0.005	0.008	0.008	0.008	
	RPM	9815	8913	8064	8064	8064	8064	7215	7321	7321	6525	6525	6525	6239	6239	5602	5602	4966	5199	5199	5199	
	FEED	39	71	65	48	48	48	43	73	73	65	65	65	75	75	67	56	50	83	83	83	
41	Vc	23	26	24	24	24	24	21	29	29	26	26	26	30	30	27	27	24	30	30	30	
	fz	0.002	0.003	0.003	0.002	0.002	0.002	0.002	0.004	0.004	0.004	0.004	0.003	0.005	0.005	0.004	0.004	0.003	0.006	0.006	0.006	
	RPM	6101	5517	5093	5093	5093	5093	4456	4615	4615	4138	4138	4138	3820	3820	3438	3438	3056	3183	3183	3183	
	FEED	24	33	31	20	20	20	18	37	37	33	33	33	25	38	38	28	28	18	38	38	38



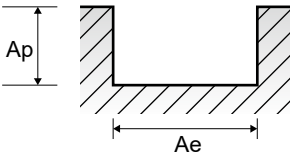
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)														
					3.0	3.0	3.0	3.0	4.0	4.0	4.0	4.0	5.0	5.0	5.0	5.0	6.0		
				LOC	16	20	26	30	12	16	20	26	30	20	25	30	35	40	15
P	1-5	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	72	
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183
	6-8	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	72	
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183
	9	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	57	
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151
	10-11.1	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	72	
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183
	11.2	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	57	
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151
K	15-20	1.0D	0.3D (up to Ø3:0.4mm)	Vc	54	54	54	54	65	65	65	58	58	69	69	62	62	72	
				fz	0.008	0.007	0.006	0.006	0.012	0.012	0.012	0.01	0.01	0.017	0.017	0.015	0.015	0.014	0.024
				RPM	5730	5730	5730	5730	5173	5173	5173	4615	4615	4393	4393	3947	3947	3947	3820
				FEED	92	80	69	69	124	124	124	92	92	149	149	118	118	111	183
		1.0D	0.05D	Vc	27	27	27	27	32	32	32	29	29	36	36	32	32	37	
				fz	0.007	0.006	0.005	0.005	0.01	0.01	0.01	0.009	0.009	0.012	0.012	0.011	0.011	0.01	0.018
				RPM	2865	2865	2865	2865	2546	2546	2546	2308	2308	2292	2292	2037	2037	2037	1963
				FEED	40	34	29	29	51	51	51	42	42	55	55	45	45	41	71
	40	1.0D	0.3D (up to Ø3:0.4mm)	Vc	44	44	44	44	52	52	52	46	46	55	55	49	49	57	
				fz	0.008	0.008	0.006	0.006	0.012	0.012	0.012	0.012	0.012	0.018	0.018	0.016	0.016	0.014	0.025
				RPM	4669	4669	4669	4669	4138	4138	4138	3661	3661	3501	3501	3119	3119	3119	3024
				FEED	75	75	56	56	99	99	99	88	88	126	126	100	100	87	151
	41	1.0D	0.05D	Vc	27	27	27	27	32	32	32	29	29	36	36	32	32	37	
				fz	0.007	0.006	0.005	0.005	0.01	0.01	0.01	0.009	0.009	0.012	0.012	0.011	0.011	0.01	0.018
				RPM	2865	2865	2865	2865	2546	2546	2546	2308	2308	2292	2292	2037	2037	2037	1963
				FEED	40	34	29	29	51	51	51	42	42	55	55	45	45	41	71

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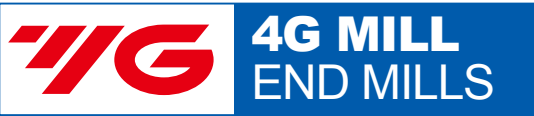


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																					
		6.0	6.0	6.0	6.0	6.0	6.0	8.0	8.0	8.0	8.0	8.0	8.0	10.0	10.0	10.0	10.0	10.0	10.0	10.0	12.0		
		LOC	20	25	30	35	40	45	25	30	35	40	45	50	30	35	40	45	50	55	60	35	
1-5	Vc	72	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75		
	fz	0.024	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038		
	RPM	3820	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989		
	FEED	183	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151		
6-8	Vc	72	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75		
	fz	0.024	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038		
	RPM	3820	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989		
	FEED	183	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151		
9	Vc	57	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63		
	fz	0.025	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04		
	RPM	3024	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671		
	FEED	151	151	127	116	99	99	150	150	150	150	122	116	99	152	152	152	124	124	116	102	134	
10 - 11.1	Vc	72	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75		
	fz	0.024	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038		
	RPM	3820	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989		
	FEED	183	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151		
11.2	Vc	57	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63		
	fz	0.025	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04		
	RPM	3024	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671		
	FEED	151	151	127	116	99	99	150	150	150	150	122	116	99	152	152	152	124	124	116	102	134	
15 - 20	Vc	72	72	72	64	64	64	72	72	72	72	65	65	77	77	77	77	77	69	69	75		
	fz	0.024	0.024	0.02	0.02	0.018	0.018	0.033	0.033	0.033	0.028	0.028	0.025	0.039	0.039	0.039	0.033	0.033	0.033	0.029	0.038		
	RPM	3820	3820	3820	3395	3395	3395	2865	2865	2865	2865	2586	2586	2451	2451	2451	2451	2451	2196	2196	1989		
	FEED	183	183	153	136	122	122	189	189	189	160	145	129	191	191	191	162	162	145	127	151		
38.1	Vc	37	37	37	33	33	33	38	38	38	38	34	34	38	38	38	38	38	34	34	38		
	fz	0.018	0.018	0.015	0.016	0.014	0.014	0.023	0.023	0.023	0.02	0.02	0.018	0.029	0.029	0.029	0.025	0.025	0.025	0.023	0.027		
38.2	RPM	1963	1963	1963	1751	1751	1751	1512	1512	1512	1512	1353	1353	1210	1210	1210	1210	1210	1082	1082	1008		
	FEED	71	71	59	56	49	49	70	70	70	60	54	49	70	70	70	60	60	54	50	54		
40	Vc	57	57	57	52	52	52	57	57	57	57	52	52	63	63	63	63	63	57	57	63		
	fz	0.025	0.025	0.021	0.021	0.018	0.018	0.033	0.033	0.033	0.027	0.028	0.024	0.038	0.038	0.038	0.031	0.031	0.032	0.028	0.04		
	RPM	3024	3024	3024	2759	2759	2759	2268	2268	2268	2268	2069	2069	2005	2005	2005	2005	2005	1814	1814	1671		
	FEED	151	151	127	116	99	99	150	150	150	122	116	99	152	152	152	124	124	116	102	134		
41	Vc	37	37	37	33	33	33	38	38	38	38	34	34	38	38	38	38	38	34	34	38		
	fz	0.018	0.018	0.015	0.016	0.014	0.014	0.023	0.023	0.023	0.02	0.02	0.018	0.029	0.029	0.029	0.025	0.025	0.025	0.023	0.027		
	RPM	1963	1963	1963	1751	1751	1751	1512	1512	1512	1512	1353	1353	1210	1210	1210	1210	1210	1082	1082	1008		
	FEED	71	71	59	56	49	49	70	70	70	60	54	49	70	70	70	60	60	54	50	54		



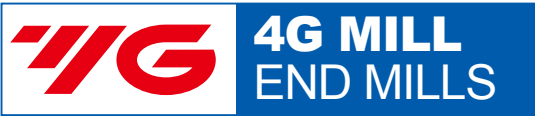
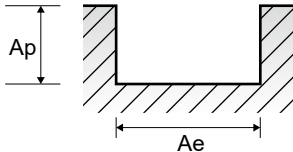
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)														
					12.0	12.0	12.0	12.0	12.0	12.0	12.0	14.0	14.0	14.0	16.0	16.0	16.0	16.0	16.0
					LOC	40	45	50	55	60	65	70	50	60	40	50	60	70	80
P	1-5	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	
	6-8	1.0D	0.3D (up to Ø3:0.4mm)	FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	
				Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
	9	1.0D	0.3D (up to Ø3:0.4mm)	RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	
				FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	
				Vc	63	63	63	63	63	57	57	65	65	64	64	64	64	64	
	10-11.1	1.0D	0.3D (up to Ø3:0.4mm)	fz	0.04	0.034	0.034	0.034	0.03	0.03	0.03	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
				RPM	1671	1671	1671	1671	1671	1512	1512	1478	1478	1273	1273	1273	1273	1273	
				FEED	134	114	114	114	100	91	91	100	100	104	104	89	89	79	
	11.2	1.0D	0.3D (up to Ø3:0.4mm)	Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
				RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	
K	15-20	1.0D	0.3D (up to Ø3:0.4mm)	FEED	151	131	131	131	111	101	101	125	125	139	139	118	118	105	
				Vc	75	75	75	75	75	68	68	81	81	85	85	85	85	85	
				fz	0.038	0.033	0.033	0.033	0.028	0.028	0.028	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
	38.1 - 38.2	1.0D	0.05D	RPM	1989	1989	1989	1989	1989	1804	1804	1842	1842	1691	1691	1691	1691	1691	
				FEED	54	44	44	44	40	34	34	45	45	49	49	40	40	35	
				Vc	38	38	38	38	38	34	34	40	40	40	40	40	40	40	
	40	1.0D	0.3D (up to Ø3:0.4mm)	fz	0.027	0.022	0.022	0.022	0.02	0.019	0.019	0.025	0.025	0.031	0.031	0.025	0.025	0.022	
				RPM	1008	1008	1008	1008	1008	902	902	909	909	796	796	796	796	796	
				FEED	54	44	44	44	40	34	34	45	45	49	49	40	40	35	
	41	1.0D	0.05D	Vc	63	63	63	63	63	57	57	65	65	64	64	64	64	64	
				fz	0.04	0.034	0.034	0.034	0.03	0.03	0.03	0.034	0.034	0.041	0.041	0.035	0.035	0.031	
				RPM	1671	1671	1671	1671	1671	1512	1512	1478	1478	1273	1273	1273	1273	1273	
	41	1.0D	0.05D	FEED	134	114	114	114	100	91	91	100	100	104	104	89	89	79	
				Vc	38	38	38	38	38	34	34	40	40	40	40	40	40	40	
				fz	0.027	0.022	0.022	0.022	0.02	0.019	0.019	0.025	0.025	0.031	0.031	0.025	0.025	0.022	
41	1.0D	0.05D	RPM	1008	1008	1008	1008	1008	902	902	909	909	796	796	796	796	796		
			FEED	54	44	44	44	40	34	34	45	45	49	49	40	40	35		

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RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

SEME70 SERIES 2 FLUTE - **S**LOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
LOC = Length of Cut

VDI 3323	Parameter	Diameter (Ø)																		
		16.0	16.0	16.0	18.0	18.0	18.0	20.0	20.0	20.0	20.0	20.0	20.0	20.0	22.0	22.0	25.0	25.0	25.0	25.0
		LOC	90	110	120	50	70	100	50	60	70	80	90	110	120	75	110	70	90	110
1-5	Vc	77	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	95	119	99	81	100	100	100	86	86	76	70	75	70	80	71	71	61
6-8	Vc	77	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	95	119	99	81	100	100	100	86	86	76	70	75	70	80	71	71	61
9	Vc	58	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
10 - 11.1	Vc	77	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	95	119	99	81	100	100	100	86	86	76	70	75	70	80	71	71	61
11.2	Vc	58	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
15 - 20	Vc	77	77	77	82	82	74	77	77	77	77	77	69	69	76	76	77	77	77	77
	fz	0.031	0.031	0.031	0.041	0.034	0.031	0.041	0.041	0.035	0.035	0.031	0.032	0.032	0.034	0.032	0.041	0.036	0.036	0.031
	RPM	1532	1532	1532	1450	1450	1309	1225	1225	1225	1225	1225	1098	1098	1100	1100	980	980	980	980
	FEED	95	95	95	119	99	81	100	100	100	86	86	76	70	75	70	80	71	71	61
38.1 - 38.2	Vc	36	36	36	40	40	36	38	38	38	38	38	34	34	38	38	38	38	38	38
	fz	0.021	0.021	0.021	0.029	0.025	0.024	0.029	0.029	0.025	0.025	0.021	0.023	0.023	0.027	0.023	0.031	0.026	0.026	0.026
	RPM	716	716	716	707	707	637	605	605	605	605	605	541	541	550	550	484	484	484	484
	FEED	30	30	30	41	35	31	35	35	30	30	30	25	25	30	25	30	25	25	25
40	Vc	58	58	58	63	63	57	60	60	60	60	60	54	54	58	58	59	59	59	59
	fz	0.03	0.03	0.03	0.04	0.033	0.03	0.039	0.039	0.034	0.034	0.029	0.029	0.029	0.033	0.03	0.04	0.033	0.033	0.03
	RPM	1154	1154	1154	1114	1114	1008	955	955	955	955	955	859	859	839	839	751	751	751	751
	FEED	69	69	69	89	74	60	74	74	65	65	55	50	50	55	50	60	50	50	45
41	Vc	36	36	36	40	40	36	38	38	38	38	38	34	34	38	38	38	38	38	38
	fz	0.021	0.021	0.021	0.029	0.025	0.024	0.029	0.029	0.025	0.025	0.021	0.023	0.023	0.027	0.023	0.031	0.026	0.026	0.026
	RPM	716	716	716	707	707	637	605	605	605	605	605	541	541	550	550	484	484	484	484
	FEED	30	30	30	41	35	31	35	35	30	30	30	25	25	30	25	30	25	25	25