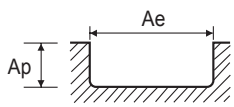
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME35 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1	1.2	1.5	2
P	1-8	Non-alloy steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	45	85	120	160	185	200	200	205	220	220	225	230	240
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	42000	42000	39000	39000	36000	32000	28000	25000	23500	21500	18000	15000	11560
					IPM(FEED)	3	3	4	4	4	5	6	6	7	7	7	7	8
	9	Low alloy steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	25	50	70	95	110	120	120	125	130	135	135	140	155
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	25200	25200	23400	23400	21600	19200	16800	15000	14100	12900	10800	9000	7560
					IPM(FEED)	2	2	2	2	3	3	3	4	4	4	4	4	5
	10	High alloyed steel, and tool steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	45	85	120	160	185	200	200	205	220	220	225	230	240
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	42000	42000	39000	39000	36000	32000	28000	25000	23500	21500	18000	15000	11560
					IPM(FEED)	3	3	4	4	4	5	6	6	7	7	7	7	8
	11.1-11.2		1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	25	50	70	95	110	120	120	125	130	135	135	140	155
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	25200	25200	23400	23400	21600	19200	16800	15000	14100	12900	10800	9000	7560
					IPM(FEED)	2	2	2	2	3	3	3	4	4	4	4	4	5
M	14.1	Stainless steel	1D	0.05D (Up to Ø1 : 0.02D)	SFM(Vc)	20	45	60	80	95	100	100	105	110	110	110	115	130
					IPT(fz)	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	21000	21000	19500	19500	18000	16000	14000	12500	11750	10750	9000	7500	6300
					IPM(FEED)	2	2	2	2	2	3	3	3	3	3	3	4	4
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	45	85	120	160	185	200	200	205	220	220	225	230	240
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	42000	42000	39000	39000	36000	32000	28000	25000	23500	21500	18000	15000	11560
					IPM(FEED)	3	3	4	4	4	5	6	6	7	7	7	7	8
H	38.1-38.2	Hardened steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	15	35	50	65	75	80	80	80	85	90	90	95	105
					IPT(fz)	.00002	.00002	.00002	.00002	.00003	.00004	.00005	.0001	.0001	.0001	.0001	.0001	.0001
					RPM	16800	16800	15600	15600	14400	12800	11200	10000	9400	8600	7200	6000	5040
					IPM(FEED)	1	1	1	1	1	1	1	1	1	1	1	1	2
	40	Chilled Cast Iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	25	50	70	95	110	120	120	125	130	135	135	140	155
					IPT(fz)	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003
					RPM	25200	25200	23400	23400	21600	19200	16800	15000	14100	12900	10800	9000	7560
					IPM(FEED)	2	2	2	2	3	3	3	4	4	4	4	4	5
	41	Hardened Cast Iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	15	35	50	65	75	80	80	80	85	90	90	95	105
					IPT(fz)	.00002	.00002	.00002	.00002	.00003	.00004	.00005	.0001	.0001	.0001	.0001	.0001	.0001
					RPM	16800	16800	15600	15600	14400	12800	11200	10000	9400	8600	7200	6000	5040
					IPM(FEED)	1	1	1	1	1	1	1	1	1	1	1	1	2

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



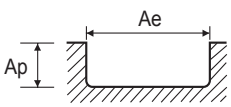
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME35 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)													
					2.5	3	3.5	4	4.5	5	5.5	6	6.5	7	7.5	8	8.5	9
P	1-8	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	265	275	295	310	320	325	335	345	350	350	350	345	345	345
				IPT(fz)	.0004	.0005	.0006	.0008	.0009	.0010	.0012	.0013	.0014	.0016	.0017	.0019	.0019	.0020
				RPM	10240	8920	8240	7560	6930	6300	5930	5560	5220	4880	4540	4200	3965	3730
				IPM(FEED)	8	9	11	12	13	13	14	15	15	15	15	16	15	15
	9	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	170	170	185	190	195	195	200	210	210	210	210	210	210	210
				IPT(fz)	.0004	.0005	.0007	.0008	.0009	.0010	.0012	.0014	.0014	.0015	.0016	.0016	.0017	.0017
				RPM	6560	5560	5090	4620	4200	3780	3570	3360	3150	2940	2730	2520	2390	2260
				IPM(FEED)	5	6	7	8	8	8	9	9	9	9	9	8	8	8
	10	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	265	275	295	310	320	325	335	345	350	350	350	345	345	345
				IPT(fz)	.0004	.0005	.0006	.0008	.0009	.0010	.0012	.0013	.0014	.0016	.0017	.0019	.0019	.0020
				RPM	10240	8920	8240	7560	6930	6300	5930	5560	5220	4880	4540	4200	3965	3730
				IPM(FEED)	8	9	11	12	13	13	14	15	15	15	15	16	15	15
	11.1-11.2	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	170	170	185	190	195	195	200	210	210	210	210	210	210	210
				IPT(fz)	.0004	.0005	.0007	.0008	.0009	.0010	.0012	.0014	.0014	.0015	.0016	.0016	.0017	.0017
				RPM	6560	5560	5090	4620	4200	3780	3570	3360	3150	2940	2730	2520	2390	2260
				IPM(FEED)	5	6	7	8	8	8	9	9	9	9	9	8	8	8
M	14.1	1D	0.05D (Up to Ø1 : 0.02D)	SFM(Vc)	140	145	155	160	165	165	170	175	180	180	175	175	175	175
				IPT(fz)	.0004	.0005	.0006	.0008	.0009	.0011	.0012	.0013	.0014	.0015	.0016	.0018	.0018	.0019
				RPM	5460	4620	4250	3880	3520	3160	3000	2840	2655	2470	2285	2100	1995	1890
				IPM(FEED)	4	5	6	6	7	7	7	8	8	8	8	8	7	7
K	15-20	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	265	275	295	310	320	325	335	345	350	350	350	345	345	345
				IPT(fz)	.0004	.0005	.0006	.0008	.0009	.0010	.0012	.0013	.0014	.0016	.0017	.0019	.0019	.0020
				RPM	10240	8920	8240	7560	6930	6300	5930	5560	5220	4880	4540	4200	3965	3730
				IPM(FEED)	8	9	11	12	13	13	14	15	15	15	15	16	15	15
H	38.1-38.2	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	110	105	115	120	120	120	120	125	130	135	135	140	140	140
				IPT(fz)	.0002	.0003	.0003	.0003	.0004	.0005	.0005	.0006	.0007	.0007	.0008	.0009	.0009	.0009
				RPM	4200	3360	3150	2940	2630	2320	2160	2000	1920	1840	1760	1680	1600	1520
				IPM(FEED)	2	2	2	2	2	2	2	2	3	3	3	3	3	3
	40	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	170	170	185	190	195	195	200	210	210	210	210	210	210	210
				IPT(fz)	.0004	.0005	.0007	.0008	.0009	.0010	.0012	.0014	.0014	.0015	.0016	.0016	.0017	.0017
				RPM	6560	5560	5090	4620	4200	3780	3570	3360	3150	2940	2730	2520	2390	2260
				IPM(FEED)	5	6	7	8	8	8	9	9	9	9	9	8	8	8
	41	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	110	105	115	120	120	120	120	125	130	135	135	140	140	140
				IPT(fz)	.0002	.0003	.0003	.0003	.0004	.0005	.0005	.0006	.0007	.0007	.0008	.0009	.0009	.0009
				RPM	4200	3360	3150	2940	2630	2320	2160	2000	1920	1840	1760	1680	1600	1520
				IPM(FEED)	2	2	2	2	2	2	2	2	3	3	3	3	3	3

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



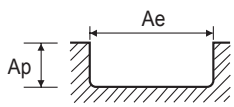
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME35 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						9.5	10	10.5	11	11.5	12	13	14	15	16
P	1-8	Non-alloy steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	340	335	340	340	340	340	350	355	360	365
					IPT(fz)	.0020	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021
					RPM	3495	3260	3130	3000	2870	2740	2605	2470	2335	2200
					IPM(FEED)	14	14	13	13	12	12	11	10	10	9
	9	Low alloy steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	210	205	210	210	210	210	215	220	225	225
					IPT(fz)	.0017	.0017	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0017
					RPM	2130	2000	1920	1840	1760	1680	1600	1520	1440	1360
					IPM(FEED)	7	7	6	6	6	5	5	5	5	5
	10	High alloyed steel, and tool steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	340	335	340	340	340	340	350	355	360	365
					IPT(fz)	.0020	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021
					RPM	3495	3260	3130	3000	2870	2740	2605	2470	2335	2200
					IPM(FEED)	14	14	13	13	12	12	11	10	10	9
	11.1-11.2		1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	210	205	210	210	210	210	215	220	225	225
					IPT(fz)	.0017	.0017	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0017
					RPM	2130	2000	1920	1840	1760	1680	1600	1520	1440	1360
					IPM(FEED)	7	7	6	6	6	5	5	5	5	5
M	14.1	Stainless steel	1D	0.05D (Up to Ø1 : 0.02D)	SFM(Vc)	175	175	175	170	170	170	170	175	175	175
					IPT(fz)	.0019	.0020	.0020	.0019	.0019	.0019	.0020	.0020	.0021	.0021
					RPM	1785	1680	1600	1520	1440	1360	1285	1210	1135	1060
					IPM(FEED)	7	7	6	6	6	5	5	5	5	5
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	340	335	340	340	340	340	350	355	360	365
					IPT(fz)	.0020	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021	.0021
					RPM	3495	3260	3130	3000	2870	2740	2605	2470	2335	2200
					IPM(FEED)	14	14	13	13	12	12	11	10	10	9
H	38.1-38.2	Hardened steel	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	140	140	140	145	145	145	145	150	150	150
					IPT(fz)	.0009	.0009	.0009	.0009	.0010	.0010	.0010	.0009	.0009	.0009
					RPM	1440	1360	1310	1260	1210	1160	1095	1030	965	900
					IPM(FEED)	3	3	2	2	2	2	2	2	2	2
	40	Chilled Cast Iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	210	205	210	210	210	210	215	220	225	225
					IPT(fz)	.0017	.0017	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0017
					RPM	2130	2000	1920	1840	1760	1680	1600	1520	1440	1360
					IPM(FEED)	7	7	6	6	6	5	5	5	5	5
	41	Hardened Cast Iron	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	140	140	140	145	145	145	145	150	150	150
					IPT(fz)	.0009	.0009	.0009	.0009	.0010	.0010	.0010	.0009	.0009	.0009
					RPM	1440	1360	1310	1260	1210	1160	1095	1030	965	900
					IPM(FEED)	3	3	2	2	2	2	2	2	2	2

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



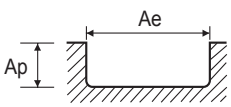
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME35 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)								
					17	18	19	20	21	22	23	24	25
P	1-8	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	365	360	355	345	350	350	350	350	350
				IPT(fz)	.0021	.0021	.0021	.0021	.0021	.0021	.0020	.0019	.0019
				RPM	2070	1940	1810	1680	1615	1550	1480	1425	1360
				IPM(FEED)	9	8	8	7	7	7	6	6	5
	9	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	225	225	220	220	220	220	220	220	215
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0017	.0017	.0017
				RPM	1285	1210	1135	1060	1015	970	925	885	840
				IPM(FEED)	4	4	4	3	3	3	3	3	3
	10	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	365	360	355	345	350	350	350	350	350
				IPT(fz)	.0021	.0021	.0021	.0021	.0021	.0021	.0020	.0019	.0019
				RPM	2070	1940	1810	1680	1615	1550	1480	1425	1360
				IPM(FEED)	9	8	8	7	7	7	6	6	5
	11.1-11.2	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	225	225	220	220	220	220	220	220	215
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0017	.0017	.0017
				RPM	1285	1210	1135	1060	1015	970	925	885	840
				IPM(FEED)	4	4	4	3	3	3	3	3	3
M	14.1	1D	0.05D (Up to Ø1 : 0.02D)	SFM(Vc)	175	175	175	175	175	175	175	175	175
				IPT(fz)	.0020	.0021	.0020	.0020	.0019	.0019	.0019	.0018	.0018
				RPM	1005	950	895	840	800	775	745	715	680
				IPM(FEED)	4	4	4	3	3	3	3	3	3
K	15-20	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	365	360	355	345	350	350	350	350	350
				IPT(fz)	.0021	.0021	.0021	.0021	.0021	.0021	.0020	.0019	.0019
				RPM	2070	1940	1810	1680	1615	1550	1480	1425	1360
				IPM(FEED)	9	8	8	7	7	7	6	6	5
H	38.1-38.2	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	150	145	145	140	140	140	140	140	140
				IPT(fz)	.0009	.0009	.0009	.0010	.0008	.0009	.0008	.0008	.0007
				RPM	845	790	735	680	650	620	600	570	540
				IPM(FEED)	2	2	1	1	1	1	1	1	1
	40	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	225	225	220	220	220	220	220	220	215
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0017	.0017	.0017
				RPM	1285	1210	1135	1060	1015	970	925	885	840
				IPM(FEED)	4	4	4	3	3	3	3	3	3
	41	1D	0.5D (Up to Ø3 : 0.2D) (Up to Ø1 : 0.15D)	SFM(Vc)	150	145	145	140	140	140	140	140	140
				IPT(fz)	.0009	.0009	.0009	.0010	.0008	.0009	.0008	.0008	.0007
				RPM	845	790	735	680	650	620	600	570	540
				IPM(FEED)	2	2	1	1	1	1	1	1	1

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



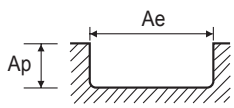
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						1	1	1	1	1	1	1	1	1.2	1.2	1.2	1.2	1.2	1.5
					LOC	3	4	5	6	7	8	10	12	4	6	8	10	12	6
P	1-8	Non-alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	165	165	165	150	150	150	150	130	165	165	150	150	150	175
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
					RPM	16000	16000	16000	14400	14400	14400	14400	12800	13500	13500	12150	12150	12150	11200
					IPM(FEED)	3	3	3	2	2	2	2	2	3	3	2	2	2	3
	9	Low alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	130	130	130	120	120	120	120	105	135	135	120	120	120	140
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002
					RPM	12800	12800	12800	11520	11520	11520	11520	10240	10800	10800	9720	9720	9720	8960
					IPM(FEED)	2	2	2	2	2	2	2	1	3	3	2	2	2	3
	10	High alloyed steel, and tool steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	165	165	165	150	150	150	150	130	165	165	150	150	150	175
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
					RPM	16000	16000	16000	14400	14400	14400	14400	12800	13500	13500	12150	12150	12150	11200
					IPM(FEED)	3	3	3	2	2	2	2	2	3	3	2	2	2	3
	11.1-11.2		1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	130	130	130	120	120	120	120	105	135	135	120	120	120	140
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002
					RPM	12800	12800	12800	11520	11520	11520	11520	10240	10800	10800	9720	9720	9720	8960
					IPM(FEED)	2	2	2	2	2	2	2	1	3	3	2	2	2	3
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	165	165	165	150	150	150	150	130	165	165	150	150	150	175
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
					RPM	16000	16000	16000	14400	14400	14400	14400	12800	13500	13500	12150	12150	12150	11200
					IPM(FEED)	3	3	3	2	2	2	2	2	3	3	2	2	2	3
H	38.1-38.2	Hardened steel	1D	0.05D	SFM(Vc)	80	80	80	75	75	75	75	65	85	85	75	75	75	85
					IPT(fz)	.0006	.0006	.0005	.0007	.0007	.0006	.0006	.0008	.0008	.0006	.0007	.0007	.0006	.0004
					RPM	8000	8000	8000	7200	7200	7200	7200	6400	6750	6750	6080	6080	6080	5600
					IPM(FEED)	9	9	7	11	11	9	9	11	11	9	9	9	7	5
	40	Chilled Cast Iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	130	130	130	120	120	120	120	105	135	135	120	120	120	140
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002
					RPM	12800	12800	12800	11520	11520	11520	11520	10240	10800	10800	9720	9720	9720	8960
					IPM(FEED)	2	2	2	2	2	2	2	1	3	3	2	2	2	3
	41	Hardened Cast Iron	1D	0.05D	SFM(Vc)	80	80	80	75	75	75	75	65	85	85	75	75	75	85
					IPT(fz)	.0006	.0006	.0005	.0007	.0007	.0006	.0006	.0008	.0008	.0006	.0007	.0007	.0006	.0004
					RPM	8000	8000	8000	7200	7200	7200	7200	6400	6750	6750	6080	6080	6080	5600
					IPM(FEED)	9	9	7	11	11	9	9	11	11	9	9	9	7	5

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



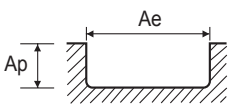
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					.5	1.5	1.5	1.5	1.5	2	2	2	2	2	2.5	2.5	2.5	2.5	2.5	3
					8	10	12	14	16	8	10	12	14	16	10	12	16	20	26	10
P	1-8	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	155	155	155	155	140	185	185	170	170	170	200	200	180	180	160	195
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0001	.0002	.0002	.0002	.0002	.0002	.0003
				RPM	10080	10080	10080	10080	8960	9070	9070	8160	8160	8160	7700	7700	6930	6930	6160	6350
				IPM(FEED)	3	3	2	2	2	3	3	3	3	2	4	4	3	3	2	4
	9	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	125	125	125	125	110	150	150	135	135	135	160	160	145	145	130	160
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0002	.0002	.0002	.0003
				RPM	8060	8060	8060	8060	7170	7260	7260	6530	6530	6530	6200	6200	5580	5580	4960	5150
				IPM(FEED)	2	2	2	2	2	3	3	2	2	2	3	3	3	2	2	3
	10	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	155	155	155	155	140	185	185	170	170	170	200	200	180	180	160	195
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0001	.0002	.0002	.0002	.0002	.0002	.0003
				RPM	10080	10080	10080	10080	8960	9070	9070	8160	8160	8160	7700	7700	6930	6930	6160	6350
				IPM(FEED)	3	3	2	2	2	3	3	3	3	2	4	4	3	3	2	4
	11.1-11.2	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	125	125	125	125	110	150	150	135	135	135	160	160	145	145	130	160
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0002	.0002	.0002	.0003
				RPM	8060	8060	8060	8060	7170	7260	7260	6530	6530	6530	6200	6200	5580	5580	4960	5150
				IPM(FEED)	2	2	2	2	2	3	3	2	2	2	3	3	3	2	2	3
K	15-20	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	155	155	155	155	140	185	185	170	170	170	200	200	180	180	160	195
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0001	.0002	.0002	.0002	.0002	.0002	.0003
				RPM	10080	10080	10080	10080	8960	9070	9070	8160	8160	8160	7700	7700	6930	6930	6160	6350
				IPM(FEED)	3	3	2	2	2	3	3	3	3	2	4	4	3	3	2	4
H	38.1-38.2	1D	0.05D	SFM(Vc)	80	80	80	80	70	95	95	85	85	85	100	100	90	90	80	100
				IPT(fz)	.0015	.0015	.0015	.0012	.0014	.0013	.0011	.0012	.0008	.0003	.0022	.0022	.0024	.0024	.0022	.0021
				RPM	5040	5040	5040	5040	4480	4540	4540	4090	4090	4090	3850	3850	3470	3470	3080	3170
				IPM(FEED)	15	15	15	12	12	12	10	10	6	3	17	17	17	17	14	14
	40	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	125	125	125	125	110	150	150	135	135	135	160	160	145	145	130	160
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0002	.0002	.0002	.0003
				RPM	8060	8060	8060	8060	7170	7260	7260	6530	6530	6530	6200	6200	5580	5580	4960	5150
				IPM(FEED)	2	2	2	2	2	3	3	2	2	2	3	3	3	2	2	3
	41	1D	0.05D	SFM(Vc)	80	80	80	80	70	95	95	85	85	85	100	100	90	90	80	100
				IPT(fz)	.0015	.0015	.0015	.0012	.0014	.0013	.0011	.0012	.0008	.0003	.0022	.0022	.0024	.0024	.0022	.0021
				RPM	5040	5040	5040	5040	4480	4540	4540	4090	4090	4090	3850	3850	3470	3470	3080	3170
				IPM(FEED)	15	15	15	12	12	12	10	10	6	3	17	17	17	17	14	14

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



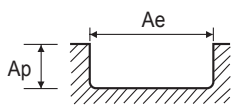
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						3	3	3	3	3	3	4	4	4	4	4	5	5	5
					LOC	12	14	16	20	26	30	12	16	20	26	30	20	25	30
P	1-8	Non-alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	175	175	210	210	210	190	190	225	225	205
					IPT(fz)	.0003	.0003	.0003	.0003	.0002	.0002	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	6350	6350	5720	5720	5720	5720	5150	5150	5150	4640	4640	4400	4400	3960
					IPM(FEED)	4	4	4	3	3	3	5	5	5	4	4	6	6	5
	9	Low alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	145	145	145	145	170	170	170	150	150	180	180	160
					IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	5150	5150	4640	4640	4640	4640	4100	4100	4100	3690	3690	3480	3480	3130
					IPM(FEED)	3	3	3	3	2	2	4	4	4	3	3	5	5	4
	10	High alloyed steel, and tool steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	175	175	210	210	210	190	190	225	225	205
					IPT(fz)	.0003	.0003	.0003	.0003	.0002	.0002	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	6350	6350	5720	5720	5720	5720	5150	5150	5150	4640	4640	4400	4400	3960
					IPM(FEED)	4	4	4	3	3	3	5	5	5	4	4	6	6	5
	11.1-11.2		1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	145	145	145	145	170	170	170	150	150	180	180	160
					IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	5150	5150	4640	4640	4640	4640	4100	4100	4100	3690	3690	3480	3480	3130
					IPM(FEED)	3	3	3	3	2	2	4	4	4	3	3	5	5	4
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	175	175	210	210	210	190	190	225	225	205
					IPT(fz)	.0003	.0003	.0003	.0003	.0002	.0002	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	6350	6350	5720	5720	5720	5720	5150	5150	5150	4640	4640	4400	4400	3960
					IPM(FEED)	4	4	4	3	3	3	5	5	5	4	4	6	6	5
H	38.1-38.2	Hardened steel	1D	0.05D	SFM(Vc)	100	100	90	90	90	90	105	105	105	95	95	115	115	105
					IPT(fz)	.0021	.0017	.0012	.0012	.0005	.0005	.0002	.0042	.0042	.0037	.0037	.0038	.0030	.0022
					RPM	3170	3170	2850	2850	2850	2850	2580	2580	2580	2320	2320	2280	2280	2050
					IPM(FEED)	14	11	7	7	3	3	1	22	22	17	17	17	14	9
	40	Chilled Cast Iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	145	145	145	145	170	170	170	150	150	180	180	160
					IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006
					RPM	5150	5150	4640	4640	4640	4640	4100	4100	4100	3690	3690	3480	3480	3130
					IPM(FEED)	3	3	3	3	2	2	4	4	4	3	3	5	5	4
	41	Hardened Cast Iron	1D	0.05D	SFM(Vc)	100	100	90	90	90	90	105	105	105	95	95	115	115	105
					IPT(fz)	.0021	.0017	.0012	.0012	.0005	.0005	.0002	.0042	.0042	.0037	.0037	.0038	.0030	.0022
					RPM	3170	3170	2850	2850	2850	2850	2580	2580	2580	2320	2320	2280	2280	2050
					IPM(FEED)	14	11	7	7	3	3	1	22	22	17	17	17	14	9

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



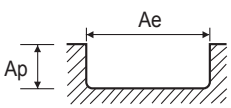
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					5	5	6	6	6	6	6	6	6	8	8	8	8	8	8	10
					35	40	15	20	25	30	35	40	45	25	30	35	40	45	50	30
P	1-8	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	235	235	235	235	210	210	210	235	235	235	235	215	215	255
				IPT(fz)	.0006	.0005	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3960	3960	3800	3800	3800	3800	3420	3420	3420	2880	2880	2880	2880	2590	2590	2450
				IPM(FEED)	5	4	7	7	7	6	6	5	5	8	8	8	6	6	5	8
	9	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	190	190	190	190	170	170	170	190	190	190	190	170	170	205
				IPT(fz)	.0006	.0006	.0010	.0010	.0010	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3130	3130	3050	3050	3050	3050	2750	2750	2750	2280	2280	2280	2280	2050	2050	2000
				IPM(FEED)	4	4	6	6	6	5	5	4	4	6	6	6	5	5	4	6
	10	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	235	235	235	235	210	210	210	235	235	235	235	215	215	255
				IPT(fz)	.0006	.0005	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3960	3960	3800	3800	3800	3800	3420	3420	3420	2880	2880	2880	2880	2590	2590	2450
				IPM(FEED)	5	4	7	7	7	6	6	5	5	8	8	8	6	6	5	8
	11.1-11.2	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	190	190	190	190	170	170	170	190	190	190	190	170	170	205
				IPT(fz)	.0006	.0006	.0010	.0010	.0010	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3130	3130	3050	3050	3050	3050	2750	2750	2750	2280	2280	2280	2280	2050	2050	2000
				IPM(FEED)	4	4	6	6	6	5	5	4	4	6	6	6	5	5	4	6
K	15-20	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	235	235	235	235	210	210	210	235	235	235	235	215	215	255
				IPT(fz)	.0006	.0005	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3960	3960	3800	3800	3800	3800	3420	3420	3420	2880	2880	2880	2880	2590	2590	2450
				IPM(FEED)	5	4	7	7	7	6	6	5	5	8	8	8	6	6	5	8
H	38.1-38.2	1D	0.05D	SFM(Vc)	105	105	120	120	120	120	110	110	110	125	125	125	125	110	110	125
				IPT(fz)	.0022	.0010	.0010	.0055	.0044	.0044	.0039	.0039	.0026	.0079	.0079	.0079	.0064	.0071	.0071	.0063
				RPM	2050	2050	1970	1970	1970	1970	1770	1770	1770	1510	1510	1510	1510	1360	1360	1210
				IPM(FEED)	9	4	4	22	17	17	14	14	9	24	24	24	19	19	19	15
	40	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	160	160	190	190	190	190	170	170	170	190	190	190	190	170	170	205
				IPT(fz)	.0006	.0006	.0010	.0010	.0010	.0008	.0008	.0007	.0007	.0013	.0013	.0013	.0011	.0011	.0010	.0015
				RPM	3130	3130	3050	3050	3050	3050	2750	2750	2750	2280	2280	2280	2280	2050	2050	2000
				IPM(FEED)	4	4	6	6	6	5	5	4	4	6	6	6	5	5	4	6
	41	1D	0.05D	SFM(Vc)	105	105	120	120	120	120	110	110	110	125	125	125	125	110	110	125
				IPT(fz)	.0022	.0010	.0010	.0055	.0044	.0044	.0039	.0039	.0026	.0079	.0079	.0079	.0064	.0071	.0071	.0063
				RPM	2050	2050	1970	1970	1970	1970	1770	1770	1770	1510	1510	1510	1510	1360	1360	1210
				IPM(FEED)	9	4	4	22	17	17	14	14	9	24	24	24	19	19	19	15

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



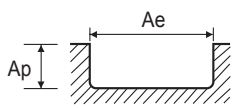
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)													
						10	10	10	10	10	10	12	12	12	12	12	12	12	12
					LOC	35	40	45	50	55	60	35	40	45	50	55	60	65	70
P	1-8	Non-alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	255	255	255	255	230	230	245	245	245	245	245	245	225	225
					IPT(fz)	.0015	.0015	.0013	.0013	.0013	.0012	.0015	.0015	.0013	.0013	.0013	.0011	.0011	.0011
					RPM	2450	2450	2450	2450	2210	2210	2000	2000	2000	2000	2000	2000	1800	1800
					IPM(FEED)	8	8	6	6	6	5	6	6	5	5	5	4	4	4
	9	Low alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	205	205	185	185	205	205	205	205	205	205	185	185
					IPT(fz)	.0015	.0015	.0012	.0012	.0013	.0011	.0016	.0016	.0013	.0013	.0013	.0012	.0012	.0012
					RPM	2000	2000	2000	2000	1800	1800	1670	1670	1670	1670	1670	1670	1500	1500
					IPM(FEED)	6	6	5	5	5	4	5	5	5	5	5	4	4	4
	10	High alloyed steel, and tool steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	255	255	255	255	230	230	245	245	245	245	245	245	225	225
					IPT(fz)	.0015	.0015	.0013	.0013	.0013	.0012	.0015	.0015	.0013	.0013	.0013	.0011	.0011	.0011
					RPM	2450	2450	2450	2450	2210	2210	2000	2000	2000	2000	2000	2000	1800	1800
					IPM(FEED)	8	8	6	6	6	5	6	6	5	5	5	4	4	4
	11.1-11.2		1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	205	205	185	185	205	205	205	205	205	205	185	185
					IPT(fz)	.0015	.0015	.0012	.0012	.0013	.0011	.0016	.0016	.0013	.0013	.0013	.0012	.0012	.0012
					RPM	2000	2000	2000	2000	1800	1800	1670	1670	1670	1670	1670	1670	1500	1500
					IPM(FEED)	6	6	5	5	5	4	5	5	5	5	5	4	4	4
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	255	255	255	255	230	230	245	245	245	245	245	245	225	225
					IPT(fz)	.0015	.0015	.0013	.0013	.0013	.0012	.0015	.0015	.0013	.0013	.0013	.0011	.0011	.0011
					RPM	2450	2450	2450	2450	2210	2210	2000	2000	2000	2000	2000	2000	1800	1800
					IPM(FEED)	8	8	6	6	6	5	6	6	5	5	5	4	4	4
H	38.1-38.2	Hardened steel	1D	0.05D	SFM(Vc)	125	125	125	125	110	110	125	125	125	125	125	125	115	115
					IPT(fz)	.0063	.0041	.0041	.0018	.0079	.0079	.0068	.0173	.0173	.0173	.0173	.0140	.0155	.0155
					RPM	1210	1210	1210	1210	1090	1090	1010	1010	1010	1010	1010	1010	910	910
					IPM(FEED)	15	10	10	4	17	17	14	35	35	35	35	28	28	28
	40	Chilled Cast Iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	205	205	205	205	185	185	205	205	205	205	205	205	185	185
					IPT(fz)	.0015	.0015	.0012	.0012	.0013	.0011	.0016	.0016	.0013	.0013	.0013	.0012	.0012	.0012
					RPM	2000	2000	2000	2000	1800	1800	1670	1670	1670	1670	1670	1670	1500	1500
					IPM(FEED)	6	6	5	5	5	4	5	5	5	5	5	4	4	4
	41	Hardened Cast Iron	1D	0.05D	SFM(Vc)	125	125	125	125	110	110	125	125	125	125	125	125	115	115
					IPT(fz)	.0063	.0041	.0041	.0018	.0079	.0079	.0068	.0173	.0173	.0173	.0173	.0140	.0155	.0155
					RPM	1210	1210	1210	1210	1090	1090	1010	1010	1010	1010	1010	1010	910	910
					IPM(FEED)	15	10	10	4	17	17	14	35	35	35	35	28	28	28

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



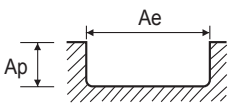
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					14	14	16	16	16	16	16	16	16	16	18	18	18	20	20	20
					50	60	40	50	60	70	80	90	110	120	50	70	100	50	60	70
P	1-8	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	265	265	280	280	280	280	280	250	250	250	270	270	245	250	250	250
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1850	1850	1700	1700	1700	1700	1700	1530	1530	1530	1450	1450	1310	1220	1220	1220
				IPM(FEED)	5	5	6	6	5	5	4	4	4	4	5	4	3	4	4	3
	9	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	215	215	210	210	210	210	210	190	190	190	210	210	185	195	195	195
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1480	1480	1280	1280	1280	1280	1280	1150	1150	1150	1120	1120	1000	950	950	950
				IPM(FEED)	4	4	4	4	4	4	3	3	3	3	4	3	2	3	3	3
	10	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	265	265	280	280	280	280	280	250	250	250	270	270	245	250	250	250
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1850	1850	1700	1700	1700	1700	1700	1530	1530	1530	1450	1450	1310	1220	1220	1220
				IPM(FEED)	5	5	6	6	5	5	4	4	4	4	5	4	3	4	4	3
	11.1-11.2	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	215	215	210	210	210	210	210	190	190	190	210	210	185	195	195	195
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1480	1480	1280	1280	1280	1280	1280	1150	1150	1150	1120	1120	1000	950	950	950
				IPM(FEED)	4	4	4	4	4	4	3	3	3	3	4	3	2	3	3	3
K	15-20	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	265	265	280	280	280	280	280	250	250	250	270	270	245	250	250	250
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1850	1850	1700	1700	1700	1700	1700	1530	1530	1530	1450	1450	1310	1220	1220	1220
				IPM(FEED)	5	5	6	6	5	5	4	4	4	4	5	4	3	4	4	3
H	38.1-38.2	1D	0.05D	SFM(Vc)	130	130	130	130	130	130	130	120	120	120	130	130	115	125	125	125
				IPT(fz)	.0155	.0123	.0140	.0093	.0093	.0093	.0039	.0044	.0044	.0013	.0013	.0202	.0225	.0192	.0192	.0192
				RPM	910	910	800	800	800	800	800	720	720	720	700	700	630	600	600	600
				IPM(FEED)	28	22	22	15	15	15	6	6	6	2	2	28	28	23	23	23
	40	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	215	215	210	210	210	210	210	190	190	190	210	210	185	195	195	195
				IPT(fz)	.0013	.0013	.0016	.0016	.0014	.0014	.0012	.0012	.0012	.0012	.0016	.0013	.0012	.0016	.0016	.0014
				RPM	1480	1480	1280	1280	1280	1280	1280	1150	1150	1150	1120	1120	1000	950	950	950
				IPM(FEED)	4	4	4	4	4	4	3	3	3	3	4	3	2	3	3	3
	41	1D	0.05D	SFM(Vc)	130	130	130	130	130	130	130	120	120	120	130	130	115	125	125	125
				IPT(fz)	.0155	.0123	.0140	.0093	.0093	.0093	.0039	.0044	.0044	.0013	.0013	.0202	.0225	.0192	.0192	.0192
				RPM	910	910	800	800	800	800	800	720	720	720	700	700	630	600	600	600
				IPM(FEED)	28	22	22	15	15	15	6	6	6	2	2	28	28	23	23	23

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



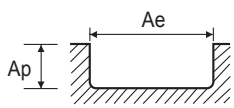
4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEME70 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						20	20	20	20	22	22	25	25	25	25
					LOC	80	90	110	120	75	110	70	90	110	120
P	1-8	Non-alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	250	250	225	225	250	250	255	255	255	255
					IPT(fz)	.0014	.0012	.0013	.0013	.0014	.0013	.0016	.0014	.0014	.0012
					RPM	1220	1220	1100	1100	1100	1100	980	980	980	980
					IPM(FEED)	3	3	3	3	3	3	3	3	3	2
	9	Low alloy steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	190	190	195	195	195	195
					IPT(fz)	.0014	.0012	.0012	.0012	.0013	.0012	.0016	.0013	.0013	.0012
					RPM	950	950	860	860	840	840	750	750	750	750
					IPM(FEED)	3	2	2	2	2	2	2	2	2	2
	10	High alloyed steel, and tool steel	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	250	250	225	225	250	250	255	255	255	255
					IPT(fz)	.0014	.0012	.0013	.0013	.0014	.0013	.0016	.0014	.0014	.0012
					RPM	1220	1220	1100	1100	1100	1100	980	980	980	980
					IPM(FEED)	3	3	3	3	3	3	3	3	3	2
	11.1-11.2		1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	190	190	195	195	195	195
					IPT(fz)	.0014	.0012	.0012	.0012	.0013	.0012	.0016	.0013	.0013	.0012
					RPM	950	950	860	860	840	840	750	750	750	750
					IPM(FEED)	3	2	2	2	2	2	2	2	2	2
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	250	250	225	225	250	250	255	255	255	255
					IPT(fz)	.0014	.0012	.0013	.0013	.0014	.0013	.0016	.0014	.0014	.0012
					RPM	1220	1220	1100	1100	1100	1100	980	980	980	980
					IPM(FEED)	3	3	3	3	3	3	3	3	3	2
H	38.1-38.2	Hardened steel	1D	0.05D	SFM(Vc)	125	125	110	110	125	125	125	125	125	125
					IPT(fz)	.0151	.0151	.0109	.0047	.0046	.0204	.0189	.0189	.0189	.0150
					RPM	600	600	540	540	550	550	480	480	480	480
					IPM(FEED)	18	18	12	5	5	22	18	18	18	14
	40	Chilled Cast Iron	1D	0.3D (Up to Ø3 : 0.4mm)	SFM(Vc)	195	195	175	175	190	190	195	195	195	195
					IPT(fz)	.0014	.0012	.0012	.0012	.0013	.0012	.0016	.0013	.0013	.0012
					RPM	950	950	860	860	840	840	750	750	750	750
					IPM(FEED)	3	2	2	2	2	2	2	2	2	2
	41	Hardened Cast Iron	1D	0.05D	SFM(Vc)	125	125	110	110	125	125	125	125	125	125
					IPT(fz)	.0151	.0151	.0109	.0047	.0046	.0204	.0189	.0189	.0189	.0150
					RPM	600	600	540	540	550	550	480	480	480	480
					IPM(FEED)	18	18	12	5	5	22	18	18	18	14

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : Inch (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)



4G MILL END MILLS

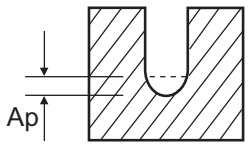
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																
				0.1	0.1	0.1	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.4	0.4	0.4
			LBS	0.3	0.5	1	0.5	1	1.5	2	1	1.5	2	2.5	3	4	5	1	1.5	2
P	1-8	Non-alloy steel	SFM(Vc)	50	50	45	80	80	70	70	105	105	95	95	95	85	65	115	115	115
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004
			RPM	50000	50000	45000	38500	38500	34650	34650	34200	34200	30780	30780	30780	27360	20520	27400	27400	27400
			IPM(FEED)	12	12	10	15	15	12	12	15	15	12	12	12	10	7	21	21	21
			Ap	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
	9	Low alloy steel	SFM(Vc)	50	50	45	75	75	65	65	100	100	90	90	90	80	60	105	105	105
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0003	.0003	.0003
			RPM	46200	46200	41580	36300	36300	32670	32670	32300	32300	29070	29070	29070	25840	19380	25800	25800	25800
			IPM(FEED)	9	9	7	11	11	9	9	11	11	9	9	9	7	5	15	15	15
			Ap	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	50	50	45	80	80	70	70	105	105	95	95	95	85	65	115	115	115
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004
			RPM	50000	50000	45000	38500	38500	34650	34650	34200	34200	30780	30780	30780	27360	20520	27400	27400	27400
			IPM(FEED)	12	12	10	15	15	12	12	15	15	12	12	12	10	7	21	21	21
			Ap	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
	11.2		SFM(Vc)	50	50	45	75	75	65	65	100	100	90	90	90	80	60	105	105	105
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0003	.0003	.0003
			RPM	46200	46200	41580	36300	36300	32670	32670	32300	32300	29070	29070	29070	25840	19380	25800	25800	25800
			IPM(FEED)	9	9	7	11	11	9	9	11	11	9	9	9	7	5	15	15	15
			Ap	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	50	50	45	80	80	70	70	105	105	95	95	95	85	65	115	115	115
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004
			RPM	50000	50000	45000	38500	38500	34650	34650	34200	34200	30780	30780	30780	27360	20520	27400	27400	27400
			IPM(FEED)	12	12	10	15	15	12	12	15	15	12	12	12	10	7	21	21	21
			Ap	0.009	0.006	0.002	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	0.025
H	38.1-38.2	Hardened steel	SFM(Vc)	40	40	40	65	65	60	60	90	90	80	80	80	70	55	95	95	95
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002
			RPM	40600	40600	36540	32100	32100	28890	28890	28500	28500	25650	25650	25650	22800	17100	22800	22800	22800
			IPM(FEED)	7	7	6	8	8	6	6	9	9	7	7	7	6	4	11	11	11
			Ap	0.005	0.004	0.001	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014	0.014
	40	Chilled Cast Iron	SFM(Vc)	50	50	45	75	75	65	65	100	100	90	90	90	80	60	105	105	105
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0003	.0003	.0003
			RPM	46200	46200	41580	36300	36300	32670	32670	32300	32300	29070	29070	29070	25840	19380	25800	25800	25800
			IPM(FEED)	9	9	7	11	11	9	9	11	11	9	9	9	7	5	15	15	15
			Ap	0.007	0.005	0.002	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	0.02
	41	Hardened Cast Iron	SFM(Vc)	40	40	40	65	65	60	60	90	90	80	80	80	70	55	95	95	95
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002
			RPM	40600	40600	36540	32100	32100	28890	28890	28500	28500	25650	25650	25650	22800	17100	22800	22800	22800
			IPM(FEED)	7	7	6	8	8	6	6	9	9	7	7	7	6	4	11	11	11
			Ap	0.005	0.004	0.001	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014	0.014

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

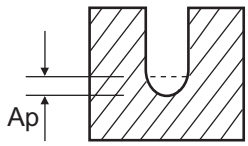
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				0.4	0.4	0.4	0.4	0.4	0.4	0.4	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
			LBS	2.5	3	4	5	6	8	10	1	1.5	2	2.5	3	4	5	6	8	10
P	1-8	Non-alloy steel	SFM(Vc)	100	100	100	90	90	70	35	140	140	140	140	125	125	125	115	85	85
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0003
			RPM	24660	24660	24660	21920	21920	16440	8220	27400	27400	27400	27400	24660	24660	24660	21920	16440	16440
			IPM(FEED)	17	17	17	14	14	9	4	21	21	21	21	17	17	17	14	9	9
			Ap	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002	0.0002	0.0018	0.0018	0.0013	0.0013	0.0007	0.0007	0.0004	0.0004	0.0003	0.0002
	9	Low alloy steel	SFM(Vc)	95	95	95	85	85	65	30	135	135	135	135	120	120	120	105	80	80
			IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002
			RPM	23220	23220	23220	20640	20640	15480	7740	25800	25800	25800	25800	23220	23220	23220	20640	15480	15480
			IPM(FEED)	12	12	12	10	10	6	3	17	17	17	17	14	14	14	11	7	7
			Ap	0.0004	0.0004	0.0003	0.0003	0.0002	0.0001	0.0001	0.0014	0.0014	0.0010	0.0010	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	100	100	100	90	90	70	35	140	140	140	140	125	125	125	115	85	85
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0003
			RPM	24660	24660	24660	21920	21920	16440	8220	27400	27400	27400	27400	24660	24660	24660	21920	16440	16440
			IPM(FEED)	17	17	17	14	14	9	4	21	21	21	21	17	17	17	14	9	9
			Ap	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002	0.0002	0.0018	0.0018	0.0013	0.0013	0.0007	0.0007	0.0004	0.0004	0.0003	0.0002
	11.2		SFM(Vc)	95	95	95	85	85	65	30	135	135	135	135	120	120	120	105	80	80
			IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002
			RPM	23220	23220	23220	20640	20640	15480	7740	25800	25800	25800	25800	23220	23220	23220	20640	15480	15480
			IPM(FEED)	12	12	12	10	10	6	3	17	17	17	17	14	14	14	11	7	7
			Ap	0.0004	0.0004	0.0003	0.0003	0.0002	0.0001	0.0001	0.0014	0.0014	0.0010	0.0010	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	100	100	100	90	90	70	35	140	140	140	140	125	125	125	115	85	85
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0003
			RPM	24660	24660	24660	21920	21920	16440	8220	27400	27400	27400	27400	24660	24660	24660	21920	16440	16440
			IPM(FEED)	17	17	17	14	14	9	4	21	21	21	21	17	17	17	14	9	9
			Ap	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002	0.0002	0.0018	0.0018	0.0013	0.0013	0.0007	0.0007	0.0004	0.0004	0.0003	0.0002
H	38.1-38.2	Hardened steel	SFM(Vc)	85	85	85	75	75	55	30	115	115	115	115	105	105	105	95	70	70
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
			RPM	20520	20520	20520	18240	18240	13680	6840	22800	22800	22800	22800	20520	20520	20520	18240	13680	13680
			IPM(FEED)	9	9	9	7	7	5	2	11	11	11	11	9	9	9	7	5	5
			Ap	0.0003	0.0003	0.0002	0.0002	0.0001	0.0001	0.0001	0.0010	0.0010	0.0007	0.0007	0.0004	0.0004	0.0002	0.0002	0.0002	0.0001
	40	Chilled Cast Iron	SFM(Vc)	95	95	95	85	85	65	30	135	135	135	135	120	120	120	105	80	80
			IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002
			RPM	23220	23220	23220	20640	20640	15480	7740	25800	25800	25800	25800	23220	23220	23220	20640	15480	15480
			IPM(FEED)	12	12	12	10	10	6	3	17	17	17	17	14	14	14	11	7	7
			Ap	0.0004	0.0004	0.0003	0.0003	0.0002	0.0001	0.0001	0.0014	0.0014	0.0010	0.0010	0.0006	0.0006	0.0004	0.0004	0.0002	0.0002
	41	Hardened Cast Iron	SFM(Vc)	85	85	85	75	75	55	30	115	115	115	115	105	105	105	95	70	70
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
			RPM	20520	20520	20520	18240	18240	13680	6840	22800	22800	22800	22800	20520	20520	20520	18240	13680	13680
			IPM(FEED)	9	9	9	7	7	5	2	11	11	11	11	9	9	9	7	5	5
			Ap	0.0003	0.0003	0.0002	0.0002	0.0001	0.0001	0.0001	0.0010	0.0010	0.0007	0.0007	0.0004	0.0004	0.0002	0.0002	0.0002	0.0001

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

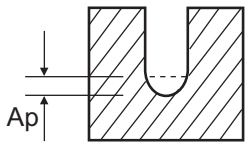
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			0.5	0.5	0.5	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.7	0.7	0.7	0.7	0.7	0.7	0.8
		LBS	12	14	16	2	3	4	5	6	8	10	12	14	16	2	4	6	8	10	12	2
P	1-8	SFM(Vc)	40	40	15	170	170	150	150	150	135	100	100	50	50	200	180	180	160	160	120	225
		IPT(fz)	.0002	.0002	.0002	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0003	.0003	.0006	.0005	.0005	.0004	.0004	.0004	.0006
		RPM	8220	8220	2740	27400	27400	24660	24660	24660	21920	16440	16440	8220	8220	27400	24660	24660	21920	21920	16440	27400
		IPM(FEED)	4	4	1	31	31	25	25	25	20	13	13	6	6	31	25	25	20	20	13	31
		Ap	0.005	0.005	0.005	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072
	9	SFM(Vc)	40	40	15	160	160	145	145	145	130	95	95	50	50	185	170	170	150	150	110	215
		IPT(fz)	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0004	.0004	.0004	.0003	.0003	.0003	.0005
		RPM	7740	7740	2580	25800	25800	23220	23220	23220	20640	15480	15480	7740	7740	25800	23220	23220	20640	20640	15480	25800
		IPM(FEED)	3	3	1	22	22	17	17	17	14	9	9	4	4	22	17	17	14	14	9	24
		Ap	0.004	0.004	0.004	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056
	10-11.1	SFM(Vc)	40	40	15	170	170	150	150	150	135	100	100	50	50	200	180	180	160	160	120	225
		IPT(fz)	.0002	.0002	.0002	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0003	.0003	.0006	.0005	.0005	.0004	.0004	.0004	.0006
		RPM	8220	8220	2740	27400	27400	24660	24660	24660	21920	16440	16440	8220	8220	27400	24660	24660	21920	21920	16440	27400
		IPM(FEED)	4	4	1	31	31	25	25	25	20	13	13	6	6	31	25	25	20	20	13	31
		Ap	0.005	0.005	0.005	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072
	11.2	SFM(Vc)	40	40	15	160	160	145	145	145	130	95	95	50	50	185	170	170	150	150	110	215
		IPT(fz)	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0004	.0004	.0004	.0003	.0003	.0003	.0005
		RPM	7740	7740	2580	25800	25800	23220	23220	23220	20640	15480	15480	7740	7740	25800	23220	23220	20640	20640	15480	25800
		IPM(FEED)	3	3	1	22	22	17	17	17	14	9	9	4	4	22	17	17	14	14	9	24
		Ap	0.004	0.004	0.004	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056
K	15-20	SFM(Vc)	40	40	15	170	170	150	150	150	135	100	100	50	50	200	180	180	160	160	120	225
		IPT(fz)	.0002	.0002	.0002	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0003	.0003	.0006	.0005	.0005	.0004	.0004	.0004	.0006
		RPM	8220	8220	2740	27400	27400	24660	24660	24660	21920	16440	16440	8220	8220	27400	24660	24660	21920	21920	16440	27400
		IPM(FEED)	4	4	1	31	31	25	25	25	20	13	13	6	6	31	25	25	20	20	13	31
		Ap	0.005	0.005	0.005	0.038	0.038	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072
H	38.1-38.2	SFM(Vc)	35	35	10	140	140	125	125	125	115	85	85	40	40	165	150	150	130	130	100	190
		IPT(fz)	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0002	.0004
		RPM	6840	6840	2280	22800	22800	20520	20520	20520	18240	13680	13680	6840	6840	22800	20520	20520	18240	18240	13680	22800
		IPM(FEED)	2	2	1	16	16	13	13	13	10	7	7	3	3	16	13	13	10	10	7	18
		Ap	0.003	0.003	0.003	0.021	0.021	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04
	40	SFM(Vc)	40	40	15	160	160	145	145	145	130	95	95	50	50	185	170	170	150	150	110	215
		IPT(fz)	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0003	.0004	.0004	.0004	.0003	.0003	.0003	.0005
		RPM	7740	7740	2580	25800	25800	23220	23220	23220	20640	15480	15480	7740	7740	25800	23220	23220	20640	20640	15480	25800
		IPM(FEED)	3	3	1	22	22	17	17	17	14	9	9	4	4	22	17	17	14	14	9	24
		Ap	0.004	0.004	0.004	0.029	0.029	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056
	41	SFM(Vc)	35	35	10	140	140	125	125	125	115	85	85	40	40	165	150	150	130	130	100	190
		IPT(fz)	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0002	.0004
		RPM	6840	6840	2280	22800	22800	20520	20520	20520	18240	13680	13680	6840	6840	22800	20520	20520	18240	18240	13680	22800
		IPM(FEED)	2	2	1	16	16	13	13	13	10	7	7	3	3	16	13	13	10	10	7	18
		Ap	0.003	0.003	0.003	0.021	0.021	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

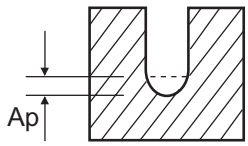
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.9	0.9	0.9	1	1	1	1
			LBS	3	4	5	6	8	10	12	14	16	20	6	8	10	2	3	4	5
P	1-8	Non-alloy steel	SFM(Vc)	225	225	205	205	205	180	180	135	135	70	205	205	185	255	255	255	255
			IPT(fz)	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0004	.0003	.0005	.0005	.0005	.0008	.0008	.0008	.0008
			RPM	27400	27400	24660	24660	24660	21920	21920	16440	16440	8220	22140	22140	19680	24600	24600	24600	24600
			IPM(FEED)	31	31	25	25	25	20	20	13	13	6	23	23	18	41	41	41	41
			Ap	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063
	9	Low alloy steel	SFM(Vc)	215	215	190	190	190	170	170	130	130	65	195	195	175	240	240	240	240
			IPT(fz)	.0005	.0005	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0004	.0004	.0004	.0008	.0008	.0008	.0008
			RPM	25800	25800	23220	23220	23220	20640	20640	15480	15480	7740	20970	20970	18640	23300	23300	23300	23300
			IPM(FEED)	24	24	19	19	19	15	15	10	10	4	17	17	14	35	35	35	35
			Ap	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	225	225	205	205	205	180	180	135	135	70	205	205	185	255	255	255	255
			IPT(fz)	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0004	.0003	.0005	.0005	.0005	.0008	.0008	.0008	.0008
			RPM	27400	27400	24660	24660	24660	21920	21920	16440	16440	8220	22140	22140	19680	24600	24600	24600	24600
			IPM(FEED)	31	31	25	25	25	20	20	13	13	6	23	23	18	41	41	41	41
			Ap	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063
	11.2		SFM(Vc)	215	215	190	190	190	170	170	130	130	65	195	195	175	240	240	240	240
			IPT(fz)	.0005	.0005	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0004	.0004	.0004	.0008	.0008	.0008	.0008
			RPM	25800	25800	23220	23220	23220	20640	20640	15480	15480	7740	20970	20970	18640	23300	23300	23300	23300
			IPM(FEED)	24	24	19	19	19	15	15	10	10	4	17	17	14	35	35	35	35
			Ap	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	225	225	205	205	205	180	180	135	135	70	205	205	185	255	255	255	255
			IPT(fz)	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0004	.0004	.0003	.0005	.0005	.0005	.0008	.0008	.0008	.0008
			RPM	27400	27400	24660	24660	24660	21920	21920	16440	16440	8220	22140	22140	19680	24600	24600	24600	24600
			IPM(FEED)	31	31	25	25	25	20	20	13	13	6	23	23	18	41	41	41	41
			Ap	0.05	0.05	0.029	0.029	0.018	0.018	0.011	0.007	0.007	0.007	0.032	0.02	0.02	0.09	0.09	0.063	0.063
H	38.1-38.2	Hardened steel	SFM(Vc)	190	190	170	170	170	150	150	115	115	55	170	170	150	210	210	210	210
			IPT(fz)	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0002	.0004	.0004	.0003	.0006	.0006	.0006	.0006
			RPM	22800	22800	20520	20520	20520	18240	18240	13680	13680	6840	18450	18450	16400	20500	20500	20500	20500
			IPM(FEED)	18	18	14	14	14	11	11	8	8	3	13	13	10	26	26	26	26
			Ap	0.028	0.028	0.016	0.016	0.01	0.01	0.006	0.004	0.004	0.004	0.018	0.011	0.011	0.05	0.05	0.035	0.035
	40	Chilled Cast Iron	SFM(Vc)	215	215	190	190	190	170	170	130	130	65	195	195	175	240	240	240	240
			IPT(fz)	.0005	.0005	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0004	.0004	.0004	.0008	.0008	.0008	.0008
			RPM	25800	25800	23220	23220	23220	20640	20640	15480	15480	7740	20970	20970	18640	23300	23300	23300	23300
			IPM(FEED)	24	24	19	19	19	15	15	10	10	4	17	17	14	35	35	35	35
			Ap	0.039	0.039	0.022	0.022	0.014	0.014	0.008	0.006	0.006	0.006	0.025	0.016	0.016	0.07	0.07	0.049	0.049
	41	Hardened Cast Iron	SFM(Vc)	190	190	170	170	170	150	150	115	115	55	170	170	150	210	210	210	210
			IPT(fz)	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003	.0002	.0004	.0004	.0003	.0006	.0006	.0006	.0006
			RPM	22800	22800	20520	20520	20520	18240	18240	13680	13680	6840	18450	18450	16400	20500	20500	20500	20500
			IPM(FEED)	18	18	14	14	14	11	11	8	8	3	13	13	10	26	26	26	26
			Ap	0.028	0.028	0.016	0.016	0.01	0.01	0.006	0.004	0.004	0.004	0.018	0.011	0.011	0.05	0.05	0.035	0.035

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

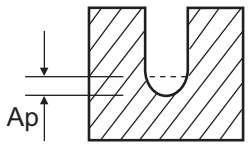
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			1	1	1	1	1	1	1	1	1	1	1	1	1	1	1.2	1.2	1.2	1.2	1.2	1.2
		LBS	6	7	8	10	12	14	16	18	20	22	26	30	40	50	4	6	8	10	12	14
P	1-8	SFM(Vc)	230	230	230	230	205	205	150	150	150	75	75	75	25	25	270	270	245	245	245	215
		IPT(fz)	.0008	.0008	.0008	.0008	.0007	.0007	.0006	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0008	.0008	.0008	.0008	.0008	.0007
		RPM	22140	22140	22140	22140	19680	19680	14760	14760	14760	7380	7380	7380	2460	2460	21900	21900	19710	19710	19710	17520
		IPM(FEED)	33	33	33	33	26	26	17	17	17	8	8	8	2	2	37	37	30	30	30	23
		Ap	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027
	9	SFM(Vc)	215	215	215	215	190	190	145	145	145	70	70	70	25	25	255	255	230	230	230	205
		IPT(fz)	.0007	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006	.0006	.0006	.0005
		RPM	20970	20970	20970	20970	18640	18640	13980	13980	13980	6990	6990	6990	2330	2330	20700	20700	18630	18630	18630	16560
		IPM(FEED)	28	28	28	28	22	22	15	15	15	6	6	6	2	2	28	28	23	23	23	18
		Ap	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021
	10-11.1	SFM(Vc)	230	230	230	230	205	205	150	150	150	75	75	75	25	25	270	270	245	245	245	215
		IPT(fz)	.0008	.0008	.0008	.0008	.0007	.0007	.0006	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0008	.0008	.0008	.0008	.0008	.0007
		RPM	22140	22140	22140	22140	19680	19680	14760	14760	14760	7380	7380	7380	2460	2460	21900	21900	19710	19710	19710	17520
		IPM(FEED)	33	33	33	33	26	26	17	17	17	8	8	8	2	2	37	37	30	30	30	23
		Ap	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027
	11.2	SFM(Vc)	215	215	215	215	190	190	145	145	145	70	70	70	25	25	255	255	230	230	230	205
		IPT(fz)	.0007	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006	.0006	.0006	.0005
		RPM	20970	20970	20970	20970	18640	18640	13980	13980	13980	6990	6990	6990	2330	2330	20700	20700	18630	18630	18630	16560
		IPM(FEED)	28	28	28	28	22	22	15	15	15	6	6	6	2	2	28	28	23	23	23	18
		Ap	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021
K	15-20	SFM(Vc)	230	230	230	230	205	205	150	150	150	75	75	75	25	25	270	270	245	245	245	215
		IPT(fz)	.0008	.0008	.0008	.0008	.0007	.0007	.0006	.0006	.0006	.0005	.0005	.0005	.0004	.0004	.0008	.0008	.0008	.0008	.0008	.0007
		RPM	22140	22140	22140	22140	19680	19680	14760	14760	14760	7380	7380	7380	2460	2460	21900	21900	19710	19710	19710	17520
		IPM(FEED)	33	33	33	33	26	26	17	17	17	8	8	8	2	2	37	37	30	30	30	23
		Ap	0.036	0.036	0.036	0.023	0.023	0.014	0.014	0.009	0.009	0.009	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027
H	38.1-38.2	SFM(Vc)	190	190	190	190	170	170	125	125	125	65	65	65	20	20	225	225	205	205	205	180
		IPT(fz)	.0006	.0006	.0006	.0006	.0005	.0005	.0004	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0005	.0005	.0005	.0005	.0005	.0004
		RPM	18450	18450	18450	18450	16400	16400	12300	12300	12300	6150	6150	6150	2050	2050	18200	18200	16380	16380	16380	14560
		IPM(FEED)	21	21	21	21	17	17	11	11	11	5	5	5	1	1	19	19	16	16	16	12
		Ap	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015
	40	SFM(Vc)	215	215	215	215	190	190	145	145	145	70	70	70	25	25	255	255	230	230	230	205
		IPT(fz)	.0007	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0004	.0004	.0007	.0007	.0006	.0006	.0006	.0005
		RPM	20970	20970	20970	20970	18640	18640	13980	13980	13980	6990	6990	6990	2330	2330	20700	20700	18630	18630	18630	16560
		IPM(FEED)	28	28	28	28	22	22	15	15	15	6	6	6	2	2	28	28	23	23	23	18
		Ap	0.028	0.028	0.028	0.018	0.018	0.011	0.011	0.007	0.007	0.007	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021
	41	SFM(Vc)	190	190	190	190	170	170	125	125	125	65	65	65	20	20	225	225	205	205	205	180
		IPT(fz)	.0006	.0006	.0006	.0006	.0005	.0005	.0004	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0005	.0005	.0005	.0005	.0005	.0004
		RPM	18450	18450	18450	18450	16400	16400	12300	12300	12300	6150	6150	6150	2050	2050	18200	18200	16380	16380	16380	14560
		IPM(FEED)	21	21	21	21	17	17	11	11	11	5	5	5	1	1	19	19	16	16	16	12
		Ap	0.02	0.02	0.02	0.013	0.013	0.008	0.008	0.005	0.005	0.005	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

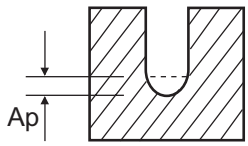
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				1.2	1.2	1.2	1.2	1.4	1.4	1.4	1.4	1.4	1.4	1.5	1.5	1.5	1.5	1.5	1.5	1.5
			LBS	16	20	26	30	6	8	10	14	16	20	4	5	6	7	8	10	12
P	1-8	Non-alloy steel	SFM(Vc)	215	165	80	80	275	250	250	250	220	220	295	295	295	295	265	265	265
			IPT(fz)	.0007	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0007	.0009	.0009	.0009	.0009	.0008	.0008	.0008
			RPM	17520	13140	6570	6570	19200	17280	17280	17280	15360	15360	19200	19200	19200	19200	17280	17280	17280
			IPM(FEED)	23	15	7	7	32	26	26	26	21	21	36	36	36	36	29	29	29
			Ap	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019	0.135	0.095	0.095	0.095	0.054	0.054	0.054
	9	Low alloy steel	SFM(Vc)	205	155	75	75	260	235	235	235	210	210	280	280	280	280	250	250	250
			IPT(fz)	.0005	.0005	.0004	.0004	.0006	.0006	.0006	.0006	.0005	.0005	.0007	.0007	.0007	.0007	.0006	.0006	.0006
			RPM	16560	12420	6210	6210	18100	16290	16290	16290	14480	14480	18100	18100	18100	18100	16290	16290	16290
			IPM(FEED)	18	12	5	5	22	18	18	18	14	14	25	25	25	25	20	20	20
			Ap	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015	0.105	0.074	0.074	0.074	0.042	0.042	0.042
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	215	165	80	80	275	250	250	250	220	220	295	295	295	295	265	265	265
			IPT(fz)	.0007	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0007	.0009	.0009	.0009	.0009	.0008	.0008	.0008
			RPM	17520	13140	6570	6570	19200	17280	17280	17280	15360	15360	19200	19200	19200	19200	17280	17280	17280
			IPM(FEED)	23	15	7	7	32	26	26	26	21	21	36	36	36	36	29	29	29
			Ap	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019	0.135	0.095	0.095	0.095	0.054	0.054	0.054
	11.2		SFM(Vc)	205	155	75	75	260	235	235	235	210	210	280	280	280	280	250	250	250
			IPT(fz)	.0005	.0005	.0004	.0004	.0006	.0006	.0006	.0006	.0005	.0005	.0007	.0007	.0007	.0007	.0006	.0006	.0006
			RPM	16560	12420	6210	6210	18100	16290	16290	16290	14480	14480	18100	18100	18100	18100	16290	16290	16290
			IPM(FEED)	18	12	5	5	22	18	18	18	14	14	25	25	25	25	20	20	20
			Ap	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015	0.105	0.074	0.074	0.074	0.042	0.042	0.042
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	215	165	80	80	275	250	250	250	220	220	295	295	295	295	265	265	265
			IPT(fz)	.0007	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0007	.0009	.0009	.0009	.0009	.0008	.0008	.0008
			RPM	17520	13140	6570	6570	19200	17280	17280	17280	15360	15360	19200	19200	19200	19200	17280	17280	17280
			IPM(FEED)	23	15	7	7	32	26	26	26	21	21	36	36	36	36	29	29	29
			Ap	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	0.019	0.135	0.095	0.095	0.095	0.054	0.054	0.054
H	38.1-38.2	Hardened steel	SFM(Vc)	180	135	70	70	230	210	210	210	185	185	245	245	245	245	225	225	225
			IPT(fz)	.0004	.0004	.0003	.0003	.0005	.0005	.0005	.0005	.0004	.0004	.0006	.0006	.0006	.0006	.0005	.0005	.0005
			RPM	14560	10920	5460	5460	16000	14400	14400	14400	12800	12800	16000	16000	16000	16000	14400	14400	14400
			IPM(FEED)	12	8	3	3	17	14	14	14	11	11	19	19	19	19	15	15	15
			Ap	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018	0.011	0.075	0.053	0.053	0.053	0.03	0.03	0.03
	40	Chilled Cast Iron	SFM(Vc)	205	155	75	75	260	235	235	235	210	210	280	280	280	280	250	250	250
			IPT(fz)	.0005	.0005	.0004	.0004	.0006	.0006	.0006	.0006	.0005	.0005	.0007	.0007	.0007	.0007	.0006	.0006	.0006
			RPM	16560	12420	6210	6210	18100	16290	16290	16290	14480	14480	18100	18100	18100	18100	16290	16290	16290
			IPM(FEED)	18	12	5	5	22	18	18	18	14	14	25	25	25	25	20	20	20
			Ap	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025	0.015	0.105	0.074	0.074	0.074	0.042	0.042	0.042
	41	Hardened Cast Iron	SFM(Vc)	180	135	70	70	230	210	210	210	185	185	245	245	245	245	225	225	225
			IPT(fz)	.0004	.0004	.0003	.0003	.0005	.0005	.0005	.0005	.0004	.0004	.0006	.0006	.0006	.0006	.0005	.0005	.0005
			RPM	14560	10920	5460	5460	16000	14400	14400	14400	12800	12800	16000	16000	16000	16000	14400	14400	14400
			IPM(FEED)	12	8	3	3	17	14	14	14	11	11	19	19	19	19	15	15	15
			Ap	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018	0.011	0.075	0.053	0.053	0.053	0.03	0.03	0.03

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

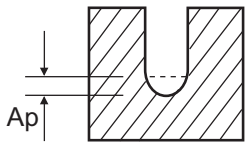
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.6	1.6	1.6	1.6	1.6	1.8	1.8	1.8	1.8	1.8	2	2	2
		LBS	14	16	18	20	22	26	30	8	10	12	16	20	8	10	12	16	20	6	8	10
P	1-8	SFM(Vc)	265	235	235	235	235	180	180	295	265	265	265	235	330	295	295	295	265	295	295	295
		IPT(fz)	.0008	.0007	.0007	.0007	.0007	.0007	.0007	.0009	.0008	.0008	.0008	.0007	.0009	.0008	.0008	.0008	.0007	.0011	.0011	.0011
		RPM	17280	15360	15360	15360	15360	11520	11520	17800	16020	16020	16020	14240	17800	16020	16020	16020	14240	14400	14400	14400
		IPM(FEED)	29	23	23	23	23	15	15	33	27	27	27	21	33	27	27	27	21	32	32	32
		Ap	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065	0.041	0.041	0.18	0.126	0.126
	9	SFM(Vc)	250	225	225	225	225	170	170	275	250	250	250	220	310	280	280	280	250	280	280	280
		IPT(fz)	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0008	.0007	.0007	.0007	.0006	.0008	.0007	.0007	.0007	.0006	.0009	.0009	.0009
		RPM	16290	14480	14480	14480	14480	10860	10860	16800	15120	15120	15120	13440	16800	15120	15120	15120	13440	13600	13600	13600
		IPM(FEED)	20	16	16	16	16	10	10	26	21	21	21	17	26	21	21	21	17	24	24	24
		Ap	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05	0.032	0.032	0.14	0.098	0.098
	10-11.1	SFM(Vc)	265	235	235	235	235	180	180	295	265	265	265	235	330	295	295	295	265	295	295	295
		IPT(fz)	.0008	.0007	.0007	.0007	.0007	.0007	.0007	.0009	.0008	.0008	.0008	.0007	.0009	.0008	.0008	.0008	.0007	.0011	.0011	.0011
		RPM	17280	15360	15360	15360	15360	11520	11520	17800	16020	16020	16020	14240	17800	16020	16020	16020	14240	14400	14400	14400
		IPM(FEED)	29	23	23	23	23	15	15	33	27	27	27	21	33	27	27	27	21	32	32	32
		Ap	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065	0.041	0.041	0.18	0.126	0.126
	11.2	SFM(Vc)	250	225	225	225	225	170	170	275	250	250	250	220	310	280	280	280	250	280	280	280
		IPT(fz)	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0008	.0007	.0007	.0007	.0006	.0008	.0007	.0007	.0007	.0006	.0009	.0009	.0009
		RPM	16290	14480	14480	14480	14480	10860	10860	16800	15120	15120	15120	13440	16800	15120	15120	15120	13440	13600	13600	13600
		IPM(FEED)	20	16	16	16	16	10	10	26	21	21	21	17	26	21	21	21	17	24	24	24
		Ap	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05	0.032	0.032	0.14	0.098	0.098
K	15-20	SFM(Vc)	265	235	235	235	235	180	180	295	265	265	265	235	330	295	295	295	265	295	295	295
		IPT(fz)	.0008	.0007	.0007	.0007	.0007	.0007	.0007	.0009	.0008	.0008	.0008	.0007	.0009	.0008	.0008	.0008	.0007	.0011	.0011	.0011
		RPM	17280	15360	15360	15360	15360	11520	11520	17800	16020	16020	16020	14240	17800	16020	16020	16020	14240	14400	14400	14400
		IPM(FEED)	29	23	23	23	23	15	15	33	27	27	27	21	33	27	27	27	21	32	32	32
		Ap	0.034	0.034	0.034	0.02	0.02	0.014	0.014	0.101	0.058	0.058	0.036	0.036	0.113	0.065	0.065	0.041	0.041	0.18	0.126	0.126
H	38.1-38.2	SFM(Vc)	225	200	200	200	200	150	150	245	220	220	220	195	275	245	245	245	220	245	245	245
		IPT(fz)	.0005	.0005	.0005	.0005	.0005	.0004	.0004	.0007	.0006	.0006	.0006	.0005	.0007	.0006	.0006	.0006	.0005	.0008	.0008	.0008
		RPM	14400	12800	12800	12800	12800	9600	9600	14800	13320	13320	13320	11840	14800	13320	13320	13320	11840	12000	12000	12000
		IPM(FEED)	15	12	12	12	12	8	8	19	16	16	16	12	19	16	16	16	12	19	19	19
		Ap	0.019	0.019	0.019	0.011	0.011	0.008	0.008	0.056	0.032	0.032	0.02	0.02	0.063	0.036	0.036	0.023	0.023	0.1	0.07	0.07
	40	SFM(Vc)	250	225	225	225	225	170	170	275	250	250	250	220	310	280	280	280	250	280	280	280
		IPT(fz)	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0008	.0007	.0007	.0007	.0006	.0008	.0007	.0007	.0007	.0006	.0009	.0009	.0009
		RPM	16290	14480	14480	14480	14480	10860	10860	16800	15120	15120	15120	13440	16800	15120	15120	15120	13440	13600	13600	13600
		IPM(FEED)	20	16	16	16	16	10	10	26	21	21	21	17	26	21	21	21	17	24	24	24
		Ap	0.026	0.026	0.026	0.016	0.016	0.011	0.011	0.078	0.045	0.045	0.028	0.028	0.088	0.05	0.05	0.032	0.032	0.14	0.098	0.098
	41	SFM(Vc)	225	200	200	200	200	150	150	245	220	220	220	195	275	245	245	245	220	245	245	245
		IPT(fz)	.0005	.0005	.0005	.0005	.0005	.0004	.0004	.0007	.0006	.0006	.0006	.0005	.0007	.0006	.0006	.0006	.0005	.0008	.0008	.0008
		RPM	14400	12800	12800	12800	12800	9600	9600	14800	13320	13320	13320	11840	14800	13320	13320	13320	11840	12000	12000	12000
		IPM(FEED)	15	12	12	12	12	8	8	19	16	16	16	12	19	16	16	16	12	19	19	19
		Ap	0.019	0.019	0.019	0.011	0.011	0.008	0.008	0.056	0.032	0.032	0.02	0.02	0.063	0.036	0.036	0.023	0.023	0.1	0.07	0.07

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

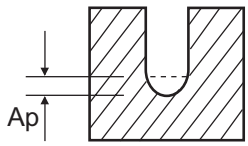
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				2	2	2	2	2	2	2	2	2	2	2	2	2	2.5	2.5	2.5	2.5
			LBS	12	14	16	18	20	22	26	30	35	40	45	50	60	8	10	12	14
P	1-8	Non-alloy steel	SFM(Vc)	265	265	265	265	265	235	235	235	180	180	90	90	90	315	315	315	285
			IPT(fz)	.0010	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0007	.0016	.0016	.0016	.0014
			RPM	12960	12960	12960	12960	12960	11520	11520	11520	8640	8640	4320	4320	4320	12300	12300	12300	11070
			IPM(FEED)	26	26	26	26	26	21	21	21	14	14	6	6	6	38	38	38	31
			Ap	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158	0.158	0.09
	9	Low alloy steel	SFM(Vc)	250	250	250	250	250	225	225	225	170	170	85	85	85	300	300	300	270
			IPT(fz)	.0008	.0008	.0008	.0008	.0008	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0012	.0012	.0012	.0010
			RPM	12240	12240	12240	12240	12240	10880	10880	10880	8160	8160	4080	4080	4080	11600	11600	11600	10440
			IPM(FEED)	20	20	20	20	20	16	16	16	10	10	4	4	4	27	27	27	22
			Ap	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123	0.123	0.07
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	265	265	265	265	265	235	235	235	180	180	90	90	90	315	315	315	285
			IPT(fz)	.0010	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0007	.0016	.0016	.0016	.0014
			RPM	12960	12960	12960	12960	12960	11520	11520	11520	8640	8640	4320	4320	4320	12300	12300	12300	11070
			IPM(FEED)	26	26	26	26	26	21	21	21	14	14	6	6	6	38	38	38	31
			Ap	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158	0.158	0.09
	11.2		SFM(Vc)	250	250	250	250	250	225	225	225	170	170	85	85	85	300	300	300	270
			IPT(fz)	.0008	.0008	.0008	.0008	.0008	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0012	.0012	.0012	.0010
			RPM	12240	12240	12240	12240	12240	10880	10880	10880	8160	8160	4080	4080	4080	11600	11600	11600	10440
			IPM(FEED)	20	20	20	20	20	16	16	16	10	10	4	4	4	27	27	27	22
			Ap	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123	0.123	0.07
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	265	265	265	265	265	235	235	235	180	180	90	90	90	315	315	315	285
			IPT(fz)	.0010	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0007	.0007	.0007	.0016	.0016	.0016	.0014
			RPM	12960	12960	12960	12960	12960	11520	11520	11520	8640	8640	4320	4320	4320	12300	12300	12300	11070
			IPM(FEED)	26	26	26	26	26	21	21	21	14	14	6	6	6	38	38	38	31
			Ap	0.072	0.072	0.072	0.045	0.045	0.045	0.045	0.027	0.018	0.018	0.018	0.018	0.018	0.158	0.158	0.158	0.09
H	38.1-38.2	Hardened steel	SFM(Vc)	225	225	225	225	225	200	200	200	150	150	75	75	75	265	265	265	240
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0006	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0010	.0010	.0010	.0009
			RPM	10800	10800	10800	10800	10800	9600	9600	9600	7200	7200	3600	3600	3600	10300	10300	10300	9270
			IPM(FEED)	15	15	15	15	15	12	12	12	8	8	3	3	3	20	20	20	16
			Ap	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01	0.01	0.088	0.088	0.088	0.05
	40	Chilled Cast Iron	SFM(Vc)	250	250	250	250	250	225	225	225	170	170	85	85	85	300	300	300	270
			IPT(fz)	.0008	.0008	.0008	.0008	.0008	.0007	.0007	.0007	.0006	.0006	.0005	.0005	.0005	.0012	.0012	.0012	.0010
			RPM	12240	12240	12240	12240	12240	10880	10880	10880	8160	8160	4080	4080	4080	11600	11600	11600	10440
			IPM(FEED)	20	20	20	20	20	16	16	16	10	10	4	4	4	27	27	27	22
			Ap	0.056	0.056	0.056	0.035	0.035	0.035	0.035	0.021	0.014	0.014	0.014	0.014	0.014	0.123	0.123	0.123	0.07
	41	Hardened Cast Iron	SFM(Vc)	225	225	225	225	225	200	200	200	150	150	75	75	75	265	265	265	240
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0006	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0010	.0010	.0010	.0009
			RPM	10800	10800	10800	10800	10800	9600	9600	9600	7200	7200	3600	3600	3600	10300	10300	10300	9270
			IPM(FEED)	15	15	15	15	15	12	12	12	8	8	3	3	3	20	20	20	16
			Ap	0.04	0.04	0.04	0.025	0.025	0.025	0.025	0.015	0.01	0.01	0.01	0.01	0.01	0.088	0.088	0.088	0.05

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

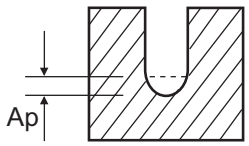
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Parameter	Diameter (Ø)																			
			2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3	3	3	3	3	3	3	3	3	3
		LBS	16	18	20	22	26	30	35	40	45	50	6	8	10	12	14	16	18	20	22	26
P	1-8	SFM(Vc)	285	285	285	285	255	255	255	190	190	190	335	335	335	335	335	305	305	305	305	305
		IPT(fz)	.0014	.0014	.0014	.0014	.0012	.0012	.0012	.0011	.0011	.0011	.0016	.0016	.0016	.0016	.0016	.0014	.0014	.0014	.0014	.0014
		RPM	11070	11070	11070	11070	9840	9840	9840	7380	7380	7380	10900	10900	10900	10900	10900	9810	9810	9810	9810	9810
		IPM(FEED)	31	31	31	31	24	24	24	16	16	16	34	34	34	34	34	27	27	27	27	27
		Ap	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
	9	SFM(Vc)	270	270	270	270	240	240	240	180	180	180	320	320	320	320	320	285	285	285	285	285
		IPT(fz)	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0008	.0012	.0012	.0012	.0012	.0012	.0010	.0010	.0010	.0010	.0010
		RPM	10440	10440	10440	10440	9280	9280	9280	6960	6960	6960	10300	10300	10300	10300	10300	9270	9270	9270	9270	9270
		IPM(FEED)	22	22	22	22	17	17	17	11	11	11	24	24	24	24	24	19	19	19	19	19
		Ap	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
	10-11.1	SFM(Vc)	285	285	285	285	255	255	255	190	190	190	335	335	335	335	335	305	305	305	305	305
		IPT(fz)	.0014	.0014	.0014	.0014	.0012	.0012	.0012	.0011	.0011	.0011	.0016	.0016	.0016	.0016	.0016	.0014	.0014	.0014	.0014	.0014
		RPM	11070	11070	11070	11070	9840	9840	9840	7380	7380	7380	10900	10900	10900	10900	10900	9810	9810	9810	9810	9810
		IPM(FEED)	31	31	31	31	24	24	24	16	16	16	34	34	34	34	34	27	27	27	27	27
		Ap	0.09	0.09	0.09	0.056	0.056	0.056	0.034	0.034	0.023	0.023	0.27	0.27	0.189	0.189	0.189	0.108	0.108	0.108	0.108	0.068
	11.2	SFM(Vc)	270	270	270	270	240	240	240	180	180	180	320	320	320	320	320	285	285	285	285	285
		IPT(fz)	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0008	.0012	.0012	.0012	.0012	.0012	.0010	.0010	.0010	.0010	.0010
		RPM	10440	10440	10440	10440	9280	9280	9280	6960	6960	6960	10300	10300	10300	10300	10300	9270	9270	9270	9270	9270
		IPM(FEED)	22	22	22	22	17	17	17	11	11	11	24	24	24	24	24	19	19	19	19	19
		Ap	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
K	15-20	SFM(Vc)	285	285	285	285	255	255	255	190	190	190	335	335	335	335	335	305	305	305	305	305
		IPT(fz)	.0014	.0014	.0014	.0014	.0012	.0012	.0012	.0011	.0011	.0011	.0016	.0016	.0016	.0016	.0016	.0014	.0014	.0014	.0014	.0014
		RPM	11070	11070	11070	11070	9840	9840	9840	7380	7380	7380	10900	10900	10900	10900	10900	9810	9810	9810	9810	9810
		IPM(FEED)	31	31	31	31	24	24	24	16	16	16	34	34	34	34	34	27	27	27	27	27
		Ap	.0035	.0035	.0035	.0022	.0022	.0022	.0013	.0013	.0009	.0009	.0106	.0106	.0074	.0074	.0074	.0043	.0043	.0043	.0043	.0027
H	38.1-38.2	SFM(Vc)	240	240	240	240	210	210	210	160	160	160	205	205	205	205	205	185	185	185	185	185
		IPT(fz)	.0009	.0009	.0009	.0009	.0008	.0008	.0008	.0007	.0007	.0007	.0013	.0013	.0013	.0013	.0013	.0012	.0012	.0012	.0012	.0012
		RPM	9270	9270	9270	9270	8240	8240	8240	6180	6180	6180	6600	6600	6600	6600	6600	5940	5940	5940	5940	5940
		IPM(FEED)	16	16	16	16	13	13	13	9	9	9	18	18	18	18	18	14	14	14	14	14
		Ap	0.05	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105	0.06	0.06	0.06	0.06	0.038
	40	SFM(Vc)	270	270	270	270	240	240	240	180	180	180	320	320	320	320	320	285	285	285	285	285
		IPT(fz)	.0010	.0010	.0010	.0010	.0009	.0009	.0009	.0008	.0008	.0008	.0012	.0012	.0012	.0012	.0012	.0010	.0010	.0010	.0010	.0010
		RPM	10440	10440	10440	10440	9280	9280	9280	6960	6960	6960	10300	10300	10300	10300	10300	9270	9270	9270	9270	9270
		IPM(FEED)	22	22	22	22	17	17	17	11	11	11	24	24	24	24	24	19	19	19	19	19
		Ap	0.07	0.07	0.07	0.044	0.044	0.044	0.026	0.026	0.018	0.018	0.21	0.21	0.147	0.147	0.147	0.084	0.084	0.084	0.084	0.053
	41	SFM(Vc)	240	240	240	240	210	210	210	160	160	160	205	205	205	205	205	185	185	185	185	185
		IPT(fz)	.0009	.0009	.0009	.0009	.0008	.0008	.0008	.0007	.0007	.0007	.0013	.0013	.0013	.0013	.0013	.0012	.0012	.0012	.0012	.0012
		RPM	9270	9270	9270	9270	8240	8240	8240	6180	6180	6180	6600	6600	6600	6600	6600	5940	5940	5940	5940	5940
		IPM(FEED)	16	16	16	16	13	13	13	9	9	9	18	18	18	18	18	14	14	14	14	14
		Ap	0.05	0.05	0.05	0.031	0.031	0.031	0.019	0.019	0.013	0.013	0.15	0.15	0.105	0.105	0.105	0.06	0.06	0.06	0.06	0.038

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

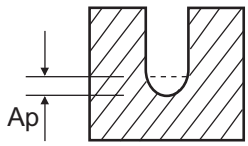
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				3	3	3	3	3	3	4	4	4	4	4	4	4	4	4	4
			LBS	30	35	40	45	50	60	8	10	12	14	16	18	20	22	26	30	35
P	1-8	Non-alloy steel	SFM(Vc)	305	270	270	270	200	200	330	330	330	330	330	330	330	295	295	295	295
			IPT(fz)	.0014	.0012	.0012	.0012	.0011	.0011	.0032	.0032	.0032	.0032	.0032	.0032	.0032	.0029	.0029	.0029	.0029
			RPM	9810	8720	8720	8720	6540	6540	8000	8000	8000	8000	8000	8000	8000	7200	7200	7200	7200
			IPM(FEED)	27	22	22	22	14	14	51	51	51	51	51	51	51	42	42	42	42
			Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09
	9	Low alloy steel	SFM(Vc)	285	255	255	255	190	190	315	315	315	315	315	315	315	280	280	280	280
			IPT(fz)	.0010	.0009	.0009	.0009	.0008	.0008	.0030	.0030	.0030	.0030	.0030	.0030	.0030	.0027	.0027	.0027	.0027
			RPM	9270	8240	8240	8240	6180	6180	7600	7600	7600	7600	7600	7600	7600	6840	6840	6840	6840
			IPM(FEED)	19	15	15	15	10	10	46	46	46	46	46	46	46	37	37	37	37
			Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	305	270	270	270	200	200	330	330	330	330	330	330	330	295	295	295	295
			IPT(fz)	.0014	.0012	.0012	.0012	.0011	.0011	.0032	.0032	.0032	.0032	.0032	.0032	.0032	.0029	.0029	.0029	.0029
			RPM	9810	8720	8720	8720	6540	6540	8000	8000	8000	8000	8000	8000	8000	7200	7200	7200	7200
			IPM(FEED)	27	22	22	22	14	14	51	51	51	51	51	51	51	42	42	42	42
			Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09
	11.2		SFM(Vc)	285	255	255	255	190	190	315	315	315	315	315	315	315	280	280	280	280
			IPT(fz)	.0010	.0009	.0009	.0009	.0008	.0008	.0030	.0030	.0030	.0030	.0030	.0030	.0030	.0027	.0027	.0027	.0027
			RPM	9270	8240	8240	8240	6180	6180	7600	7600	7600	7600	7600	7600	7600	6840	6840	6840	6840
			IPM(FEED)	19	15	15	15	10	10	46	46	46	46	46	46	46	37	37	37	37
			Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	305	270	270	270	200	200	330	330	330	330	330	330	330	295	295	295	295
			IPT(fz)	.0014	.0012	.0012	.0012	.0011	.0011	.0032	.0032	.0032	.0032	.0032	.0032	.0032	.0029	.0029	.0029	.0029
			RPM	9810	8720	8720	8720	6540	6540	8000	8000	8000	8000	8000	8000	8000	7200	7200	7200	7200
			IPM(FEED)	27	22	22	22	14	14	51	51	51	51	51	51	51	42	42	42	42
			Ap	0.068	0.068	0.041	0.041	0.027	0.027	0.36	0.36	0.36	0.252	0.252	0.252	0.252	0.144	0.144	0.144	0.09
H	38.1-38.2	Hardened steel	SFM(Vc)	185	165	165	165	120	120	275	275	275	275	275	275	275	250	250	250	250
			IPT(fz)	.0012	.0011	.0011	.0011	.0009	.0009	.0023	.0023	.0023	.0023	.0023	.0023	.0023	.0020	.0020	.0020	.0020
			RPM	5940	5280	5280	5280	3960	3960	6700	6700	6700	6700	6700	6700	6700	6030	6030	6030	6030
			IPM(FEED)	14	11	11	11	8	8	30	30	30	30	30	30	30	25	25	25	25
			Ap	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08	0.08	0.08	0.05
	40	Chilled Cast Iron	SFM(Vc)	285	255	255	255	190	190	315	315	315	315	315	315	315	280	280	280	280
			IPT(fz)	.0010	.0009	.0009	.0009	.0008	.0008	.0030	.0030	.0030	.0030	.0030	.0030	.0030	.0027	.0027	.0027	.0027
			RPM	9270	8240	8240	8240	6180	6180	7600	7600	7600	7600	7600	7600	7600	6840	6840	6840	6840
			IPM(FEED)	19	15	15	15	10	10	46	46	46	46	46	46	46	37	37	37	37
			Ap	0.053	0.053	0.032	0.032	0.021	0.021	0.28	0.28	0.28	0.196	0.196	0.196	0.196	0.112	0.112	0.112	0.07
	41	Hardened Cast Iron	SFM(Vc)	185	165	165	165	120	120	275	275	275	275	275	275	275	250	250	250	250
			IPT(fz)	.0012	.0011	.0011	.0011	.0009	.0009	.0023	.0023	.0023	.0023	.0023	.0023	.0023	.0020	.0020	.0020	.0020
			RPM	5940	5280	5280	5280	3960	3960	6700	6700	6700	6700	6700	6700	6700	6030	6030	6030	6030
			IPM(FEED)	14	11	11	11	8	8	30	30	30	30	30	30	30	25	25	25	25
			Ap	0.038	0.038	0.023	0.023	0.015	0.015	0.2	0.2	0.2	0.14	0.14	0.14	0.14	0.08	0.08	0.08	0.05

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

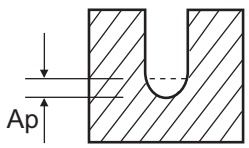
RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Parameter	Diameter (Ø)													
			4	4	4	4	5	5	5	5	5	5	5	5	6	6
		LBS	40	45	50	60	16	20	26	30	35	40	50	60	15	20
P	1-8	SFM(Vc)	295	265	265	265	330	330	295	295	295	295	295	265	330	330
		IPT(fz)	.0029	.0026	.0026	.0026	.0036	.0036	.0032	.0032	.0032	.0032	.0032	.0028	.0039	.0039
		RPM	7200	6400	6400	6400	6400	6400	5760	5760	5760	5760	5760	5120	5300	5300
		IPM(FEED)	42	33	33	33	46	46	37	37	37	37	37	29	42	42
		Ap	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378
	9	SFM(Vc)	280	250	250	250	315	315	285	285	285	285	285	250	310	310
		IPT(fz)	.0027	.0024	.0024	.0024	.0029	.0029	.0026	.0026	.0026	.0026	.0026	.0023	.0032	.0032
		RPM	6840	6080	6080	6080	6100	6100	5490	5490	5490	5490	5490	4880	5000	5000
		IPM(FEED)	37	29	29	29	35	35	29	29	29	29	29	23	32	32
		Ap	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294
	10-11.1	SFM(Vc)	295	265	265	265	330	330	295	295	295	295	295	265	330	330
		IPT(fz)	.0029	.0026	.0026	.0026	.0036	.0036	.0032	.0032	.0032	.0032	.0032	.0028	.0039	.0039
		RPM	7200	6400	6400	6400	6400	6400	5760	5760	5760	5760	5760	5120	5300	5300
		IPM(FEED)	42	33	33	33	46	46	37	37	37	37	37	29	42	42
		Ap	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378
	11.2	SFM(Vc)	280	250	250	250	315	315	285	285	285	285	285	250	310	310
		IPT(fz)	.0027	.0024	.0024	.0024	.0029	.0029	.0026	.0026	.0026	.0026	.0026	.0023	.0032	.0032
		RPM	6840	6080	6080	6080	6100	6100	5490	5490	5490	5490	5490	4880	5000	5000
		IPM(FEED)	37	29	29	29	35	35	29	29	29	29	29	23	32	32
		Ap	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294
K	15-20	SFM(Vc)	295	265	265	265	330	330	295	295	295	295	295	265	330	330
		IPT(fz)	.0029	.0026	.0026	.0026	.0036	.0036	.0032	.0032	.0032	.0032	.0032	.0028	.0039	.0039
		RPM	7200	6400	6400	6400	6400	6400	5760	5760	5760	5760	5760	5120	5300	5300
		IPM(FEED)	42	33	33	33	46	46	37	37	37	37	37	29	42	42
		Ap	0.09	0.09	0.09	0.054	0.315	0.315	0.18	0.18	0.18	0.18	0.113	0.113	0.54	0.378
H	38.1-38.2	SFM(Vc)	250	220	220	220	280	280	250	250	250	250	250	225	270	270
		IPT(fz)	.0020	.0018	.0018	.0018	.0022	.0022	.0020	.0020	.0020	.0020	.0020	.0018	.0025	.0025
		RPM	6030	5360	5360	5360	5400	5400	4860	4860	4860	4860	4860	4320	4400	4400
		IPM(FEED)	25	20	20	20	24	24	19	19	19	19	19	15	22	22
		Ap	0.05	0.05	0.05	0.03	0.175	0.175	0.1	0.1	0.1	0.1	0.063	0.063	0.3	0.21
	40	SFM(Vc)	280	250	250	250	315	315	285	285	285	285	285	250	310	310
		IPT(fz)	.0027	.0024	.0024	.0024	.0029	.0029	.0026	.0026	.0026	.0026	.0026	.0023	.0032	.0032
		RPM	6840	6080	6080	6080	6100	6100	5490	5490	5490	5490	5490	4880	5000	5000
		IPM(FEED)	37	29	29	29	35	35	29	29	29	29	29	23	32	32
		Ap	0.07	0.07	0.07	0.042	0.245	0.245	0.14	0.14	0.14	0.14	0.088	0.088	0.42	0.294
	41	SFM(Vc)	250	220	220	220	280	280	250	250	250	250	250	225	270	270
		IPT(fz)	.0020	.0018	.0018	.0018	.0022	.0022	.0020	.0020	.0020	.0020	.0020	.0018	.0025	.0025
		RPM	6030	5360	5360	5360	5400	5400	4860	4860	4860	4860	4860	4320	4400	4400
		IPM(FEED)	25	20	20	20	24	24	19	19	19	19	19	15	22	22
		Ap	0.05	0.05	0.05	0.03	0.175	0.175	0.1	0.1	0.1	0.1	0.063	0.063	0.3	0.21

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)



4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS

SEM845 SERIES 2FLUTE SQUARE - SLOTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)										
				6	6	8	8	8	10	10	10	12	12	12
			LBS	30	32	25	30	42	30	35	45	35	40	50
P	1-8	Non-alloy steel	SFM(Vc)	330	295	330	330	295	330	330	330	330	330	330
			IPT(fz)	.0039	.0035	.0047	.0047	.0042	.0055	.0055	.0055	.0059	.0059	.0059
			RPM	5300	4770	4000	4000	3600	3200	3200	3200	2650	2650	2650
			IPM(FEED)	42	34	37	37	30	35	35	35	32	32	32
			Ap	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
	9	Low alloy steel	SFM(Vc)	310	280	315	315	280	315	315	315	310	310	310
			IPT(fz)	.0032	.0029	.0039	.0039	.0035	.0044	.0044	.0044	.0047	.0047	.0047
			RPM	5000	4500	3800	3800	3400	3050	3050	3050	2520	2520	2520
			IPM(FEED)	32	26	30	30	24	27	27	27	24	24	24
			Ap	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
	10-11.1	High alloyed steel, and tool steel	SFM(Vc)	330	295	330	330	295	330	330	330	330	330	330
			IPT(fz)	.0039	.0035	.0047	.0047	.0042	.0055	.0055	.0055	.0059	.0059	.0059
			RPM	5300	4770	4000	4000	3600	3200	3200	3200	2650	2650	2650
			IPM(FEED)	42	34	37	37	30	35	35	35	32	32	32
			Ap	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
	11.2		SFM(Vc)	310	280	315	315	280	315	315	315	310	310	310
			IPT(fz)	.0032	.0029	.0039	.0039	.0035	.0044	.0044	.0044	.0047	.0047	.0047
			RPM	5000	4500	3800	3800	3400	3050	3050	3050	2520	2520	2520
			IPM(FEED)	32	26	30	30	24	27	27	27	24	24	24
			Ap	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	330	295	330	330	295	330	330	330	330	330	330
			IPT(fz)	.0039	.0035	.0047	.0047	.0042	.0055	.0055	.0055	.0059	.0059	.0059
			RPM	5300	4770	4000	4000	3600	3200	3200	3200	2650	2650	2650
			IPM(FEED)	42	34	37	37	30	35	35	35	32	32	32
			Ap	0.378	0.216	0.504	0.504	0.288	0.9	0.63	0.63	1.08	0.756	0.756
H	38.1-38.2	Hardened steel	SFM(Vc)	270	245	270	270	245	270	270	270	270	270	270
			IPT(fz)	.0025	.0022	.0030	.0030	.0027	.0030	.0030	.0030	.0032	.0032	.0032
			RPM	4400	3960	3300	3300	2950	2630	2630	2630	2180	2180	2180
			IPM(FEED)	22	18	20	20	16	16	16	16	14	14	14
			Ap	0.21	0.12	0.28	0.28	0.16	0.5	0.35	0.35	0.6	0.42	0.42
	40	Chilled Cast Iron	SFM(Vc)	310	280	315	315	280	315	315	315	310	310	310
			IPT(fz)	.0032	.0029	.0039	.0039	.0035	.0044	.0044	.0044	.0047	.0047	.0047
			RPM	5000	4500	3800	3800	3400	3050	3050	3050	2520	2520	2520
			IPM(FEED)	32	26	30	30	24	27	27	27	24	24	24
			Ap	0.294	0.168	0.392	0.392	0.224	0.7	0.49	0.49	0.84	0.588	0.588
	41	Hardened Cast Iron	SFM(Vc)	270	245	270	270	245	270	270	270	270	270	270
			IPT(fz)	.0025	.0022	.0030	.0030	.0027	.0030	.0030	.0030	.0032	.0032	.0032
			RPM	4400	3960	3300	3300	2950	2630	2630	2630	2180	2180	2180
			IPM(FEED)	22	18	20	20	16	16	16	16	14	14	14
			Ap	0.21	0.12	0.28	0.28	0.16	0.5	0.35	0.35	0.6	0.42	0.42

SFM = Surface Feet per Minute
RPM = Revolutions Per Minute
IPT = Inches Per Tooth
IPM = Inches Per Minute
Ap : mm (Axial Depth of Cut)
Ae : Inch (Radial Depth of Cut)

(Depth of Cut per one pass)