

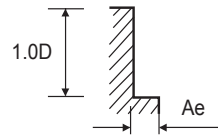
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME36, SEME71 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						0.8	0.9	1	1.2	1.5	2	2.5	3	3.5	4	4.5	5	5.5
P	1-8	Non-alloy steel	0.05D	1D	SFM(Vc)	260	270	275	280	290	300	330	345	370	390	400	405	420
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	31250	29300	26800	22500	18750	14450	12800	11150	10300	9450	8660	7880	7410
					IPM(FEED)	9	10	10	10	11	12	12	13	18	24	24	25	26
	9	Low alloy steel	0.05D	1D	SFM(Vc)	155	165	165	165	175	195	210	215	230	240	245	245	255
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	18750	17580	16080	13500	11250	9450	8200	6950	6360	5780	5250	4730	4460
					IPM(FEED)	6	6	6	6	7	7	8	8	11	15	15	15	16
	10-	High alloyed steel, and tool steel	0.05D	1D	SFM(Vc)	260	270	275	280	290	300	330	345	370	390	400	405	420
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	31250	29300	26800	22500	18750	14450	12800	11150	10300	9450	8660	7880	7410
					IPM(FEED)	9	10	10	10	11	12	12	13	18	24	24	25	26
11.1-11.2	High alloyed steel, and tool steel	0.05D	1D	SFM(Vc)	155	165	165	165	175	195	210	215	230	240	245	245	255	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009	
				RPM	18750	17580	16080	13500	11250	9450	8200	6950	6360	5780	5250	4730	4460	
				IPM(FEED)	6	6	6	6	7	7	8	8	11	15	15	15	16	
M	14.1	Stainless steel	0.05D	1D	SFM(Vc)	130	135	140	140	145	160	175	180	190	200	205	205	215
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	15630	14650	13400	11250	9380	7880	6830	5780	5310	4850	4400	3950	3750
					IPM(FEED)	5	5	5	5	5	6	7	7	9	12	12	12	13
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1D	SFM(Vc)	260	270	275	280	290	300	330	345	370	390	400	405	420
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	31250	29300	26800	22500	18750	14450	12800	11150	10300	9450	8660	7880	7410
					IPM(FEED)	9	10	10	10	11	12	12	13	18	24	24	25	26
H	38.1-38.2	Hardened steel	0.05D	1D	SFM(Vc)	105	110	110	110	115	130	135	130	140	150	155	150	155
					IPT(fz)	.00003	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003	.0003
					RPM	12500	11720	10720	9000	7500	6300	5250	4200	3940	3680	3290	2900	2700
					IPM(FEED)	2	2	2	2	2	2	2	3	3	3	3	3	3
	40	Chilled Cast Iron	0.05D	1D	SFM(Vc)	155	165	165	165	175	195	210	215	230	240	245	245	255
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0003	.0004	.0006	.0007	.0008	.0009
					RPM	18750	17580	16080	13500	11250	9450	8200	6950	6360	5780	5250	4730	4460
					IPM(FEED)	6	6	6	6	7	7	8	8	11	15	15	15	16
	41	Hardened Cast Iron	0.05D	1D	SFM(Vc)	105	110	110	110	115	130	135	130	140	150	155	150	155
					IPT(fz)	.00003	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0003	.0003
					RPM	12500	11720	10720	9000	7500	6300	5250	4200	3940	3680	3290	2900	2700
					IPM(FEED)	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)



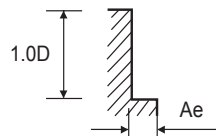
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME36, SEME71 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)												
						6	6.5	7	7.5	8	8.5	9	9.5	10	10.5	11	11.5	12
<b>P</b>	1-8	Non-alloy steel	0.05D	1D	SFM(Vc)	430	435	440	440	435	435	430	430	420	425	425	425	425
					IPT(fz)	.0010	.0011	.0012	.0013	.0014	.0014	.0015	.0015	.0015	.0016	.0016	.0016	.0016
					RPM	6950	6530	6100	5680	5250	4960	4660	4370	4080	3910	3750	3590	3430
	9	Low alloy steel	0.05D	1D	SFM(Vc)	260	265	265	265	260	260	265	260	260	260	260	260	260
					IPT(fz)	.0010	.0011	.0011	.0012	.0012	.0013	.0012	.0012	.0012	.0013	.0012	.0013	.0012
					RPM	4200	3940	3680	3410	3150	2990	2830	2660	2500	2400	2300	2200	2100
	10-	High alloyed steel, and tool steel	0.05D	1D	SFM(Vc)	430	435	440	440	435	435	430	430	420	425	425	425	425
					IPT(fz)	.0010	.0011	.0012	.0013	.0014	.0014	.0015	.0015	.0015	.0016	.0016	.0016	.0016
					RPM	6950	6530	6100	5680	5250	4960	4660	4370	4080	3910	3750	3590	3430
	11.1-11.2	High alloyed steel, and tool steel	0.05D	1D	SFM(Vc)	260	265	265	265	260	260	265	260	260	260	260	260	260
					IPT(fz)	.0010	.0011	.0011	.0012	.0012	.0013	.0012	.0012	.0012	.0013	.0012	.0013	.0012
					RPM	4200	3940	3680	3410	3150	2990	2830	2660	2500	2400	2300	2200	2100
<b>M</b>	14.1	Stainless steel	0.05D	1D	SFM(Vc)	220	220	225	220	215	220	220	220	215	215	215	215	210
					IPT(fz)	.0010	.0010	.0011	.0012	.0014	.0014	.0014	.0015	.0015	.0015	.0015	.0015	.0014
					RPM	3550	3320	3090	2860	2630	2490	2360	2230	2100	2000	1900	1800	1700
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	1D	SFM(Vc)	430	435	440	440	435	435	430	430	420	425	425	425	425
					IPT(fz)	.0010	.0011	.0012	.0013	.0014	.0014	.0015	.0015	.0015	.0016	.0016	.0016	.0016
					RPM	6950	6530	6100	5680	5250	4960	4660	4370	4080	3910	3750	3590	3430
<b>H</b>	38.1-38.2	Hardened steel	0.05D	1D	SFM(Vc)	155	160	165	170	175	175	175	175	175	175	180	180	180
					IPT(fz)	.0003	.0004	.0004	.0005	.0005	.0005	.0005	.0005	.0005	.0006	.0006	.0006	.0006
					RPM	2500	2400	2300	2200	2100	2000	1900	1800	1700	1640	1580	1510	1450
<b>H</b>	40	Chilled Cast Iron	0.05D	1D	SFM(Vc)	260	265	265	265	260	260	265	260	260	260	260	260	260
					IPT(fz)	.0010	.0011	.0011	.0012	.0012	.0013	.0012	.0012	.0012	.0013	.0012	.0013	.0012
					RPM	4200	3940	3680	3410	3150	2990	2830	2660	2500	2400	2300	2200	2100
<b>H</b>	41	Hardened Cast Iron	0.05D	1D	SFM(Vc)	155	160	165	170	175	175	175	175	175	175	180	180	180
					IPT(fz)	.0003	.0004	.0004	.0005	.0005	.0005	.0005	.0005	.0005	.0006	.0006	.0006	.0006
					RPM	2500	2400	2300	2200	2100	2000	1900	1800	1700	1640	1580	1510	1450

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)



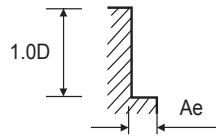
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME36, SEME71 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					13	14	15	16	17	18	19	20	21	22	23	24	25			
P	1-8	0.05D	1D	SFM(Vc)	435	445	450	455	455	450	445	435	435	440	440	440	440			
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0015	.0015		
				RPM	3260	3090	2920	2750	2590	2430	2260	2100	2020	1940	1860	1780	1700			
				IPM(FEED)	21	19	18	17	16	15	14	13	13	12	12	11	10			
	9	0.05D	1D	SFM(Vc)	270	275	280	280	280	280	280	275	275	275	275	275	270			
				IPT(fz)	.0012	.0012	.0012	.0013	.0012	.0012	.0013	.0013	.0013	.0013	.0012	.0012	.0013			
				RPM	2000	1900	1800	1700	1610	1510	1420	1330	1270	1220	1160	1110	1050			
				IPM(FEED)	10	9	9	9	8	8	7	7	7	6	6	6	5			
	10-	0.05D	1D	SFM(Vc)	435	445	450	455	455	450	445	435	435	440	440	440	440			
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0015	.0015			
				RPM	3260	3090	2920	2750	2590	2430	2260	2100	2020	1940	1860	1780	1700			
				IPM(FEED)	21	19	18	17	16	15	14	13	13	12	12	11	10			
	11.1-11.2	0.05D	1D	SFM(Vc)	270	275	280	280	280	280	280	275	275	275	275	275	270			
				IPT(fz)	.0012	.0012	.0012	.0013	.0012	.0012	.0013	.0013	.0013	.0013	.0012	.0012	.0013			
				RPM	2000	1900	1800	1700	1610	1510	1420	1330	1270	1220	1160	1110	1050			
				IPM(FEED)	10	9	9	9	8	8	7	7	7	6	6	6	5			
M	14.1	0.05D	1D	SFM(Vc)	215	220	225	230	225	225	220	215	220	220	220	220	220			
				IPT(fz)	.0015	.0015	.0015	.0015	.0015	.0015	.0015	.0015	.0015	.0015	.0015	.0014	.0014			
				RPM	1620	1540	1460	1380	1290	1210	1130	1050	1010	970	930	890	850			
				IPM(FEED)	9	9	9	8	8	7	7	6	6	6	6	5	5			
K	15-20	0.05D	1D	SFM(Vc)	435	445	450	455	455	450	445	435	435	440	440	440	440			
				IPT(fz)	.0016	.0016	.0015	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0016	.0015	.0015			
				RPM	3260	3090	2920	2750	2590	2430	2260	2100	2020	1940	1860	1780	1700			
				IPM(FEED)	21	19	18	17	16	15	14	13	13	12	12	11	10			
H	38.1-38.2	0.05D	1D	SFM(Vc)	185	185	185	185	185	185	180	175	175	175	180	175	175			
				IPT(fz)	.0006	.0006	.0006	.0006	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0005	.0005		
				RPM	1370	1290	1210	1130	1060	990	920	850	820	780	750	710	680			
				IPM(FEED)	3	3	3	3	2	2	2	2	2	2	2	1	1			
	40	0.05D	1D	SFM(Vc)	270	275	280	280	280	280	280	275	275	275	275	275	270			
				IPT(fz)	.0012	.0012	.0012	.0013	.0012	.0012	.0013	.0013	.0013	.0013	.0012	.0012	.0013			
				RPM	2000	1900	1800	1700	1610	1510	1420	1330	1270	1220	1160	1110	1050			
				IPM(FEED)	10	9	9	9	8	8	7	7	7	6	6	6	5			
	41	0.05D	1D	SFM(Vc)	185	185	185	185	185	185	180	175	175	175	180	175	175			
				IPT(fz)	.0006	.0006	.0006	.0006	.0006	.0006	.0005	.0005	.0005	.0005	.0005	.0005	.0005			
				RPM	1370	1290	1210	1130	1060	990	920	850	820	780	750	710	680			
				IPM(FEED)	3	3	3	3	2	2	2	2	2	2	2	1	1			

SFM = Surface Feet per Minute  
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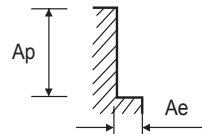
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES 4FLUTE SQUARE - SIDE CUTTING

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				
						3	4	5	6	7	8	10	12	4	6	8	10				
P	1-8	Non-alloy steel	0.05D	2.5D	SFM(Vc)	200	200	200	180	180	180	180	160	200	200	180	180				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001				
					RPM	19200	19200	19200	17280	17280	17280	17280	15360	16200	16200	14580	14580				
					IPM(FEED)	7	7	7	6	6	5	5	4	8	8	7	6				
	9	Low alloy steel	0.05D	2.5D	SFM(Vc)	115	115	115	100	100	100	100	90	115	115	105	105				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001				
					RPM	10940	10940	10940	9850	9850	9850	9850	8760	9230	9230	8310	8310				
					IPM(FEED)	3	3	3	2	2	2	2	2	3	3	3	2				
	10-	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	200	200	200	180	180	180	180	160	200	200	180	180				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001				
					RPM	19200	19200	19200	17280	17280	17280	17280	15360	16200	16200	14580	14580				
					IPM(FEED)	7	7	7	6	6	5	5	4	8	8	7	6				
11.1-11.2	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	115	115	115	100	100	100	100	90	115	115	105	105					
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001					
				RPM	10940	10940	10940	9850	9850	9850	9850	8760	9230	9230	8310	8310					
				IPM(FEED)	3	3	3	2	2	2	2	2	3	3	3	2					
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	SFM(Vc)	200	200	200	180	180	180	180	160	200	200	180	180				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001				
					RPM	19200	19200	19200	17280	17280	17280	17280	15360	16200	16200	14580	14580				
					IPM(FEED)	7	7	7	6	6	5	5	4	8	8	7	6				
H	38.1-38.2	Hardened steel	0.02D	2.0D	SFM(Vc)	70	70	70	60	60	60	60	55	70	70	65	65				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0	.0	.0	.0001	.0001	.0001	.0001				
					RPM	6720	6720	6720	6050	6050	6050	6050	5380	5670	5670	5100	5100				
					IPM(FEED)	1	1	1	1	1	1	1	1	2	2	1	1				
	40	Chilled Cast Iron	0.05D	2.5D	SFM(Vc)	115	115	115	100	100	100	100	90	115	115	105	105				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001				
					RPM	10940	10940	10940	9850	9850	9850	9850	8760	9230	9230	8310	8310				
					IPM(FEED)	3	3	3	2	2	2	2	2	3	3	3	2				
	41	Hardened Cast Iron	0.02D	2.0D	SFM(Vc)	70	70	70	60	60	60	60	55	70	70	65	65				
					IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0	.0	.0	.0001	.0001	.0001	.0001				
					RPM	6720	6720	6720	6050	6050	6050	6050	5380	5670	5670	5100	5100				
					IPM(FEED)	1	1	1	1	1	1	1	1	2	2	1	1				

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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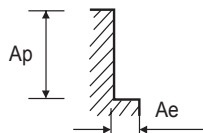
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)													
					1.2	1.5	1.5	1.5	1.5	1.5	1.5	2	2	2	2	2	2.5	
					LOC	12	6	8	10	12	14	16	8	10	12	14	16	10
P	1-8	0.05D	2.5D	SFM(Vc)	180	215	190	190	190	190	170	220	220	195	195	195	230	
				IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003
				RPM	14580	13800	12420	12420	12420	12420	11040	10580	10580	9530	9530	9530	8990	8990
				IPM(FEED)	6	9	8	7	6	6	5	9	9	8	8	7	10	10
	9	0.05D	2.5D	SFM(Vc)	105	120	110	110	110	110	95	125	125	110	110	110	135	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0002	
				RPM	8310	7870	7080	7080	7080	7080	6290	6050	6050	5440	5440	5440	5170	5170
				IPM(FEED)	2	3	3	3	2	2	2	4	4	3	3	3	4	4
	10-	0.05D	2.5D	SFM(Vc)	180	215	190	190	190	190	170	220	220	195	195	195	230	
				IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003	
				RPM	14580	13800	12420	12420	12420	12420	11040	10580	10580	9530	9530	9530	8990	8990
				IPM(FEED)	6	9	8	7	6	6	5	9	9	8	8	7	10	10
	11.1-11.2	0.05D	2.5D	SFM(Vc)	105	120	110	110	110	110	95	125	125	110	110	110	135	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0002	
				RPM	8310	7870	7080	7080	7080	7080	6290	6050	6050	5440	5440	5440	5170	5170
				IPM(FEED)	2	3	3	3	2	2	2	4	4	3	3	3	4	4
K	15-20	0.05D	2.5D	SFM(Vc)	180	215	190	190	190	190	170	220	220	195	195	195	230	
				IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0003	
				RPM	14580	13800	12420	12420	12420	12420	11040	10580	10580	9530	9530	9530	8990	8990
				IPM(FEED)	6	9	8	7	6	6	5	9	9	8	8	7	10	10
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	65	75	65	65	65	65	60	80	80	70	70	70	85	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0002	
				RPM	5100	4830	4350	4350	4350	4350	3860	3780	3780	3400	3400	3400	3210	3210
				IPM(FEED)	1	2	2	1	1	1	1	2	2	2	2	2	2	2
	40	0.05D	2.5D	SFM(Vc)	105	120	110	110	110	110	95	125	125	110	110	110	135	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0002	
				RPM	8310	7870	7080	7080	7080	7080	6290	6050	6050	5440	5440	5440	5170	5170
				IPM(FEED)	2	3	3	3	2	2	2	4	4	3	3	3	4	4
	41	0.02D	2.0D	SFM(Vc)	65	75	65	65	65	65	60	80	80	70	70	70	85	
				IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0002	
				RPM	5100	4830	4350	4350	4350	4350	3860	3780	3780	3400	3400	3400	3210	3210
				IPM(FEED)	1	2	2	1	1	1	1	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)



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

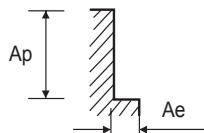
## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)															
						2.5	2.5	2.5	2.5	3	3	3	3	3	3	3	3	4			
						LOC	12	16	20	26	10	12	14	16	20	26	30	12			
<b>P</b>	1-8	Non-alloy steel	0.05D	2.5D	SFM(Vc)	230	210	210	185	230	230	230	205	205	205	205	245				
					IPT(fz)	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0006				
					RPM	8990	8090	8090	7200	7400	7400	7400	6660	6660	6660	6660	6000				
					IPM(FEED)	10	8	7	6	11	11	11	10	9	8	8	13				
	9	Low alloy steel	0.05D	2.5D	SFM(Vc)	135	120	120	105	130	130	130	120	120	120	140					
					IPT(fz)	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0004				
					RPM	5170	4650	4650	4130	4280	4280	4280	3860	3860	3860	3860	3410				
					IPM(FEED)	4	3	3	2	5	5	5	4	4	3	3	6				
	10-	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	230	210	210	185	230	230	230	205	205	205	245					
					IPT(fz)	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0006				
					RPM	8990	8090	8090	7200	7400	7400	7400	6660	6660	6660	6660	6000				
					IPM(FEED)	10	8	7	6	11	11	11	10	9	8	8	13				
11.1-11.2	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	135	120	120	105	130	130	130	120	120	120	140						
				IPT(fz)	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0004					
				RPM	5170	4650	4650	4130	4280	4280	4280	3860	3860	3860	3860	3410					
				IPM(FEED)	4	3	3	2	5	5	5	4	4	3	3	6					
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	SFM(Vc)	230	210	210	185	230	230	230	205	205	205	245					
					IPT(fz)	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0006				
					RPM	8990	8090	8090	7200	7400	7400	7400	6660	6660	6660	6660	6000				
					IPM(FEED)	10	8	7	6	11	11	11	10	9	8	8	13				
<b>H</b>	38.1-38.2	Hardened steel	0.02D	2.0D	SFM(Vc)	85	75	75	65	80	80	80	75	75	75	90					
					IPT(fz)	.0002	.0002	.0002	.0001	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0003				
					RPM	3210	2890	2890	2570	2640	2640	2640	2380	2380	2380	2380	2150				
					IPM(FEED)	2	2	2	1	3	3	3	2	2	2	2	3				
	40	Chilled Cast Iron	0.05D	2.5D	SFM(Vc)	135	120	120	105	130	130	130	120	120	120	140					
					IPT(fz)	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0004				
					RPM	5170	4650	4650	4130	4280	4280	4280	3860	3860	3860	3860	3410				
					IPM(FEED)	4	3	3	2	5	5	5	4	4	3	3	6				
	41	Hardened Cast Iron	0.02D	2.0D	SFM(Vc)	85	75	75	65	80	80	80	75	75	75	90					
					IPT(fz)	.0002	.0002	.0002	.0001	.0003	.0003	.0003	.0003	.0002	.0002	.0002	.0003				
					RPM	3210	2890	2890	2570	2640	2640	2640	2380	2380	2380	2380	2150				
					IPM(FEED)	2	2	2	1	3	3	3	2	2	2	2	3				

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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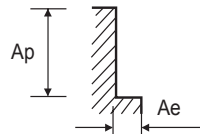
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)													
					1.5	1.5	1.5	1.5	1.5	2	2	2	2	2	2	2	2	
					LOC	18	20	22	26	30	6	8	10	12	16	18	20	22
P	1-8	0.05D	2.5D	SFM(Vc)	245	245	225	225	265	265	240	240	240	275	275	275	275	
				IPT(fz)	.0006	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0012	.0012	.0012	.001	
				RPM	6000	6000	5400	5400	5120	5120	4610	4610	4610	4420	4420	4420	4420	
				IPM(FEED)	13	13	11	11	17	17	14	14	12	20	20	20	17	
	9	0.05D	2.5D	SFM(Vc)	140	140	125	125	150	150	135	135	135	155	155	155	155	
				IPT(fz)	.0004	.0004	.0004	.0004	.0006	.0006	.0005	.0005	.0005	.0008	.0008	.0008	.0007	
				RPM	3410	3410	3070	3070	2900	2900	2610	2610	2610	2520	2520	2520	2520	
				IPM(FEED)	6	6	4	4	7	7	5	5	5	9	9	9	7	
	10-	0.05D	2.5D	SFM(Vc)	245	245	225	225	265	265	240	240	240	275	275	275	275	
				IPT(fz)	.0006	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0012	.0012	.0012	.001	
				RPM	6000	6000	5400	5400	5120	5120	4610	4610	4610	4420	4420	4420	4420	
				IPM(FEED)	13	13	11	11	17	17	14	14	12	20	20	20	17	
	11.1-11.2	0.05D	2.5D	SFM(Vc)	140	140	125	125	150	150	135	135	135	155	155	155	155	
				IPT(fz)	.0004	.0004	.0004	.0004	.0006	.0006	.0005	.0005	.0005	.0008	.0008	.0008	.0007	
				RPM	3410	3410	3070	3070	2900	2900	2610	2610	2610	2520	2520	2520	2520	
				IPM(FEED)	6	6	4	4	7	7	5	5	5	9	9	9	7	
K	15-20	0.05D	2.5D	SFM(Vc)	245	245	225	225	265	265	240	240	240	275	275	275	275	
				IPT(fz)	.0006	.0006	.0005	.0005	.0008	.0008	.0008	.0008	.0007	.0012	.0012	.0012	.001	
				RPM	6000	6000	5400	5400	5120	5120	4610	4610	4610	4420	4420	4420	4420	
				IPM(FEED)	13	13	11	11	17	17	14	14	12	20	20	20	17	
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	90	90	80	80	100	100	90	90	90	100	100	100	100	
				IPT(fz)	.0003	.0003	.0003	.0003	.0004	.0004	.0004	.0004	.0004	.0007	.0007	.0007	.0005	
				RPM	2150	2150	1930	1930	1900	1900	1710	1710	1710	1640	1640	1640	1640	
				IPM(FEED)	3	3	2	2	3	3	3	3	2	4	4	4	4	
	40	0.05D	2.5D	SFM(Vc)	140	140	125	125	150	150	135	135	135	155	155	155	155	
				IPT(fz)	.0004	.0004	.0004	.0004	.0006	.0006	.0005	.0005	.0005	.0008	.0008	.0008	.0007	
				RPM	3410	3410	3070	3070	2900	2900	2610	2610	2610	2520	2520	2520	2520	
				IPM(FEED)	6	6	4	4	7	7	5	5	5	9	9	9	7	
	41	0.02D	2.0D	SFM(Vc)	90	90	80	80	100	100	90	90	90	100	100	100	100	
				IPT(fz)	.0003	.0003	.0003	.0003	.0004	.0004	.0004	.0004	.0004	.0007	.0007	.0007	.0005	
				RPM	2150	2150	1930	1930	1900	1900	1710	1710	1710	1640	1640	1640	1640	
				IPM(FEED)	3	3	2	2	3	3	3	3	2	4	4	4	4	

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

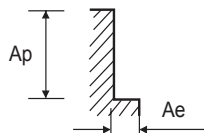
## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						6	6	6	8	8	8	8	8	10	10	10	
						LOC	35	40	45	25	30	35	40	45	50	30	35
<b>P</b>	1-8	Non-alloy steel	0.05D	2.5D	SFM(Vc)	245	245	245	275	275	275	275	250	250	290	290	290
					IPT(fz)	.001	.0009	.0009	.0016	.0016	.0016	.0014	.0014	.0012	.0019	.0019	.0019
					RPM	3970	3970	3970	3360	3360	3360	3360	3020	3020	2820	2820	2820
					IPM(FEED)	16	14	14	22	22	22	19	17	15	22	22	22
	9	Low alloy steel	0.05D	2.5D	SFM(Vc)	140	140	140	155	155	155	155	140	140	170	170	170
					IPT(fz)	.0007	.0006	.0006	.0011	.0011	.0011	.001	.001	.0008	.0013	.0013	.0013
					RPM	2270	2270	2270	1900	1900	1900	1900	1710	1710	1640	1640	1640
					IPM(FEED)	7	6	6	9	9	9	7	7	6	9	9	9
	10-	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	245	245	245	275	275	275	275	250	250	290	290	290
					IPT(fz)	.001	.0009	.0009	.0016	.0016	.0016	.0014	.0014	.0012	.0019	.0019	.0019
					RPM	3970	3970	3970	3360	3360	3360	3360	3020	3020	2820	2820	2820
					IPM(FEED)	16	14	14	22	22	22	19	17	15	22	22	22
11.1-11.2	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	140	140	140	155	155	155	155	140	140	170	170	170	
				IPT(fz)	.0007	.0006	.0006	.0011	.0011	.0011	.001	.001	.0008	.0013	.0013	.0013	
				RPM	2270	2270	2270	1900	1900	1900	1900	1710	1710	1640	1640	1640	
				IPM(FEED)	7	6	6	9	9	9	7	7	6	9	9	9	
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	SFM(Vc)	245	245	245	275	275	275	275	250	250	290	290	290
					IPT(fz)	.001	.0009	.0009	.0016	.0016	.0016	.0014	.0014	.0012	.0019	.0019	.0019
					RPM	3970	3970	3970	3360	3360	3360	3360	3020	3020	2820	2820	2820
					IPM(FEED)	16	14	14	22	22	22	19	17	15	22	22	22
<b>H</b>	38.1-38.2	Hardened steel	0.02D	2.0D	SFM(Vc)	90	90	90	105	105	105	105	95	95	105	105	105
					IPT(fz)	.0006	.0005	.0005	.0009	.0009	.0009	.0007	.0007	.0007	.0011	.0011	.0011
					RPM	1480	1480	1480	1260	1260	1260	1260	1130	1130	1010	1010	1010
					IPM(FEED)	3	3	3	4	4	4	4	3	3	4	4	4
	40	Chilled Cast Iron	0.05D	2.5D	SFM(Vc)	140	140	140	155	155	155	155	140	140	170	170	170
					IPT(fz)	.0007	.0006	.0006	.0011	.0011	.0011	.001	.001	.0008	.0013	.0013	.0013
					RPM	2270	2270	2270	1900	1900	1900	1900	1710	1710	1640	1640	1640
					IPM(FEED)	7	6	6	9	9	9	7	7	6	9	9	9
	41	Hardened Cast Iron	0.02D	2.0D	SFM(Vc)	90	90	90	105	105	105	105	95	95	105	105	105
					IPT(fz)	.0006	.0005	.0005	.0009	.0009	.0009	.0007	.0007	.0007	.0011	.0011	.0011
					RPM	1480	1480	1480	1260	1260	1260	1260	1130	1130	1010	1010	1010
					IPM(FEED)	3	3	3	4	4	4	4	3	3	4	4	4

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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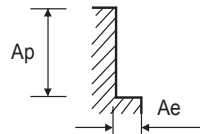
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)												
					10	10	10	10	12	12	12	12	12	12	12	14	
					LOC	45	50	55	60	35	40	45	50	55	60	65	70
P	1-8	0.05D	2.5D	SFM(Vc)	290	290	260	260	285	285	285	285	285	285	255	255	305
				IPT(fz)	.0016	.0016	.0016	.0015	.0018	.0018	.0016	.0016	.0016	.0014	.0014	.0014	.0016
				RPM	2820	2820	2540	2540	2300	2300	2300	2300	2300	2300	2070	2070	2120
				IPM(FEED)	19	19	17	15	17	17	14	14	14	13	11	11	14
	9	0.05D	2.5D	SFM(Vc)	170	170	155	155	170	170	170	170	170	170	155	155	175
				IPT(fz)	.0011	.0011	.0011	.001	.0014	.0014	.0012	.0012	.0012	.001	.001	.001	.0012
				RPM	1640	1640	1480	1480	1390	1390	1390	1390	1390	1390	1250	1250	1230
				IPM(FEED)	7	7	7	6	8	8	7	7	7	6	5	5	6
	10-	0.05D	2.5D	SFM(Vc)	290	290	260	260	285	285	285	285	285	285	255	255	305
				IPT(fz)	.0016	.0016	.0016	.0015	.0018	.0018	.0016	.0016	.0016	.0014	.0014	.0014	.0016
				RPM	2820	2820	2540	2540	2300	2300	2300	2300	2300	2300	2070	2070	2120
				IPM(FEED)	19	19	17	15	17	17	14	14	14	13	11	11	14
	11.1-11.2	0.05D	2.5D	SFM(Vc)	170	170	155	155	170	170	170	170	170	170	155	155	175
				IPT(fz)	.0011	.0011	.0011	.001	.0014	.0014	.0012	.0012	.0012	.001	.001	.001	.0012
				RPM	1640	1640	1480	1480	1390	1390	1390	1390	1390	1390	1250	1250	1230
				IPM(FEED)	7	7	7	6	8	8	7	7	7	6	5	5	6
K	15-20	0.05D	2.5D	SFM(Vc)	290	290	260	260	285	285	285	285	285	285	255	255	305
				IPT(fz)	.0016	.0016	.0016	.0015	.0018	.0018	.0016	.0016	.0016	.0014	.0014	.0014	.0016
				RPM	2820	2820	2540	2540	2300	2300	2300	2300	2300	2300	2070	2070	2120
				IPM(FEED)	19	19	17	15	17	17	14	14	14	13	11	11	14
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	105	105	95	95	105	105	105	105	105	105	95	95	110
				IPT(fz)	.0009	.0009	.0009	.0008	.001	.001	.0008	.0008	.0008	.0008	.0007	.0007	.0009
				RPM	1010	1010	910	910	840	840	840	840	840	840	760	760	760
				IPM(FEED)	4	4	3	3	3	3	3	3	3	3	2	2	3
	40	0.05D	2.5D	SFM(Vc)	170	170	155	155	170	170	170	170	170	170	155	155	175
				IPT(fz)	.0011	.0011	.0011	.001	.0014	.0014	.0012	.0012	.0012	.001	.001	.001	.0012
				RPM	1640	1640	1480	1480	1390	1390	1390	1390	1390	1390	1250	1250	1230
				IPM(FEED)	7	7	7	6	8	8	7	7	7	6	5	5	6
	41	0.02D	2.0D	SFM(Vc)	105	105	95	95	105	105	105	105	105	105	95	95	110
				IPT(fz)	.0009	.0009	.0009	.0008	.001	.001	.0008	.0008	.0008	.0008	.0007	.0007	.0009
				RPM	1010	1010	910	910	840	840	840	840	840	840	760	760	760
				IPM(FEED)	4	4	3	3	3	3	3	3	3	3	2	2	3

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HSS

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X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

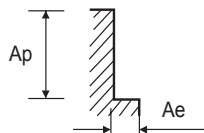
## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						14	16	16	16	16	16	16	16	18	18	18	
						LOC	60	40	50	60	70	80	90	110	120	50	70
<b>P</b>	1-8	Non-alloy steel	0.05D	2.5D	SFM(Vc)	305	320	320	320	320	320	290	290	290	310	310	280
					IPT(fz)	.0016	.002	.002	.0017	.0017	.0015	.0015	.0015	.0015	.0019	.0016	.0015
					RPM	2120	1940	1940	1940	1940	1940	1750	1750	1750	1680	1680	1510
					IPM(FEED)	14	15	15	13	13	11	10	10	10	13	11	9
	9	Low alloy steel	0.05D	2.5D	SFM(Vc)	175	175	175	175	175	175	160	160	160	175	175	160
					IPT(fz)	.0012	.0014	.0014	.0012	.0012	.0011	.001	.001	.001	.0014	.0011	.001
					RPM	1230	1070	1070	1070	1070	1070	960	960	960	940	940	850
					IPM(FEED)	6	6	6	5	5	5	4	4	4	5	4	3
	10-	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	305	320	320	320	320	320	290	290	290	310	310	280
					IPT(fz)	.0016	.002	.002	.0017	.0017	.0015	.0015	.0015	.0019	.0016	.0015	
					RPM	2120	1940	1940	1940	1940	1940	1750	1750	1750	1680	1680	1510
					IPM(FEED)	14	15	15	13	13	11	10	10	10	13	11	9
11.1-11.2	High alloyed steel, and tool steel	0.05D	2.5D	SFM(Vc)	175	175	175	175	175	175	160	160	160	175	175	160	
				IPT(fz)	.0012	.0014	.0014	.0012	.0012	.0011	.001	.001	.001	.0014	.0011	.001	
				RPM	1230	1070	1070	1070	1070	1070	960	960	960	940	940	850	
				IPM(FEED)	6	6	6	5	5	5	4	4	4	5	4	3	
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.05D	2.5D	SFM(Vc)	305	320	320	320	320	320	290	290	290	310	310	280
					IPT(fz)	.0016	.002	.002	.0017	.0017	.0015	.0015	.0015	.0015	.0019	.0016	.0015
					RPM	2120	1940	1940	1940	1940	1940	1750	1750	1750	1680	1680	1510
					IPM(FEED)	14	15	15	13	13	11	10	10	10	13	11	9
<b>H</b>	38.1-38.2	Hardened steel	0.02D	2.0D	SFM(Vc)	110	110	110	110	110	110	100	100	100	110	110	100
					IPT(fz)	.0009	.001	.001	.0009	.0009	.0008	.0008	.0008	.0008	.0011	.0009	.0009
					RPM	760	670	670	670	670	670	600	600	600	590	590	530
					IPM(FEED)	3	3	3	2	2	2	2	2	2	3	2	2
	40	Chilled Cast Iron	0.05D	2.5D	SFM(Vc)	175	175	175	175	175	175	160	160	160	175	175	160
					IPT(fz)	.0012	.0014	.0014	.0012	.0012	.0011	.001	.001	.001	.0014	.0011	.001
					RPM	1230	1070	1070	1070	1070	1070	960	960	960	940	940	850
					IPM(FEED)	6	6	6	5	5	5	4	4	4	5	4	3
	41	Hardened Cast Iron	0.02D	2.0D	SFM(Vc)	110	110	110	110	110	110	100	100	100	110	110	100
					IPT(fz)	.0009	.001	.001	.0009	.0009	.0008	.0008	.0008	.0008	.0011	.0009	.0009
					RPM	760	670	670	670	670	670	600	600	600	590	590	530
					IPM(FEED)	3	3	3	2	2	2	2	2	2	3	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)



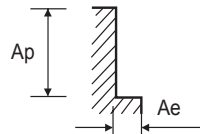
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME72 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)															
					20	20	20	20	20	20	20	22	22	25	25	25	25			
					LOC	50	60	70	80	90	110	120	75	110	70	90	110	120		
P	1-8	0.05D	2.5D	SFM(Vc)	295	295	295	295	295	260	260	285	285	285	285	285	285			
				IPT(fz)	.0019	.0019	.0016	.0016	.0014	.0014	.0014	.0016	.0014	.0019	.0017	.0017	.0014			
				RPM	1420	1420	1420	1420	1420	1270	1270	1260	1260	1100	1100	1100	1100			
				IPM(FEED)	11	11	9	9	8	7	7	8	7	9	7	7	6			
	9	0.05D	2.5D	SFM(Vc)	170	170	170	170	170	150	150	185	185	210	210	210	210			
				IPT(fz)	.0013	.0013	.0011	.0011	.001	.001	.001	.0011	.001	.0013	.0011	.0011	.001			
				RPM	820	820	820	820	820	730	730	820	820	820	820	820	820			
				IPM(FEED)	4	4	4	4	3	3	3	4	3	4	4	4	3			
	10-	0.05D	2.5D	SFM(Vc)	295	295	295	295	295	260	260	285	285	285	285	285	285			
				IPT(fz)	.0019	.0019	.0016	.0016	.0014	.0014	.0014	.0016	.0014	.0019	.0017	.0017	.0014			
				RPM	1420	1420	1420	1420	1420	1270	1270	1260	1260	1100	1100	1100	1100			
				IPM(FEED)	11	11	9	9	8	7	7	8	7	9	7	7	6			
	11.1-11.2	0.05D	2.5D	SFM(Vc)	170	170	170	170	170	150	150	185	185	210	210	210	210			
				IPT(fz)	.0013	.0013	.0011	.0011	.001	.001	.001	.0011	.001	.0013	.0011	.0011	.001			
				RPM	820	820	820	820	820	730	730	820	820	820	820	820	820			
				IPM(FEED)	4	4	4	4	3	3	3	4	3	4	4	4	3			
K	15-20	0.05D	2.5D	SFM(Vc)	295	295	295	295	295	260	260	285	285	285	285	285				
				IPT(fz)	.0019	.0019	.0016	.0016	.0014	.0014	.0014	.0016	.0014	.0019	.0017	.0017	.0014			
				RPM	1420	1420	1420	1420	1420	1270	1270	1260	1260	1100	1100	1100	1100			
				IPM(FEED)	11	11	9	9	8	7	7	8	7	9	7	7	6			
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	105	105	105	105	105	95	95	115	115	130	130	130	130			
				IPT(fz)	.0011	.0011	.0009	.0009	.0008	.0008	.0008	.0009	.0008	.0011	.0009	.0009	.0008			
				RPM	500	500	500	500	500	450	450	500	500	500	500	500	500			
				IPM(FEED)	2	2	2	2	2	1	1	2	2	2	2	2	2			
	40	0.05D	2.5D	SFM(Vc)	170	170	170	170	170	150	150	185	185	210	210	210	210			
				IPT(fz)	.0013	.0013	.0011	.0011	.001	.001	.001	.0011	.001	.0013	.0011	.0011	.001			
				RPM	820	820	820	820	820	730	730	820	820	820	820	820	820			
				IPM(FEED)	4	4	4	4	3	3	3	4	3	4	4	4	3			
	41	0.02D	2.0D	SFM(Vc)	105	105	105	105	105	95	95	115	115	130	130	130	130			
				IPT(fz)	.0011	.0011	.0009	.0009	.0008	.0008	.0008	.0009	.0008	.0011	.0009	.0009	.0008			
				RPM	500	500	500	500	500	450	450	500	500	500	500	500	500			
				IPM(FEED)	2	2	2	2	2	1	1	2	2	2	2	2	2			

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

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STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

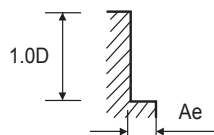
## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)													
				1	1	1	1	1	1	1	1	1	1	1	1	1	
				LBS	2	3	4	5	6	7	8	10	12	14	16	18	
<b>P</b>	1-8	Non-alloy steel	SFM(Vc)	225	225	225	225	205	205	205	205	180	180	135	135		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	
			RPM	22000	22000	22000	22000	19800	19800	19800	19800	17600	17600	13200	13200		
			IPM(FEED)	12	12	12	12	10	10	10	10	8	8	5	5		
	9	Low alloy steel	SFM(Vc)	140	140	140	140	125	125	125	125	110	110	85	85		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001		
			RPM	13500	13500	13500	13500	12150	12150	12150	12150	10800	10800	8100	8100		
			IPM(FEED)	7	7	7	7	6	6	6	6	5	5	3	3		
	10-	High alloyed steel, and tool steel	SFM(Vc)	225	225	225	225	205	205	205	205	180	180	135	135		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001		
			RPM	22000	22000	22000	22000	19800	19800	19800	19800	17600	17600	13200	13200		
			IPM(FEED)	12	12	12	12	10	10	10	10	8	8	5	5		
11.1-11.2	High alloyed steel, and tool steel	SFM(Vc)	140	140	140	140	125	125	125	125	110	110	85	85			
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001			
		RPM	13500	13500	13500	13500	12150	12150	12150	12150	10800	10800	8100	8100			
		IPM(FEED)	7	7	7	7	6	6	6	6	5	5	3	3			
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	225	225	225	225	205	205	205	205	180	180	135	135		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001		
			RPM	22000	22000	22000	22000	19800	19800	19800	19800	17600	17600	13200	13200		
			IPM(FEED)	12	12	12	12	10	10	10	10	8	8	5	5		
<b>H</b>	38.1-38.2	Hardened steel	SFM(Vc)	90	90	90	90	80	80	80	80	70	70	55	55		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.00004	.00004	.00004	.00004		
			RPM	8500	8500	8500	8500	7650	7650	7650	7650	6800	6800	5100	5100		
			IPM(FEED)	2	2	2	2	1.6	1.6	1.6	1.6	1.2	1.2	0.8	0.8		
	40	Chilled Cast Iron	SFM(Vc)	140	140	140	140	125	125	125	125	110	110	85	85		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001		
			RPM	13500	13500	13500	13500	12150	12150	12150	12150	10800	10800	8100	8100		
			IPM(FEED)	7	7	7	7	6	6	6	6	5	5	3	3		
	41	Hardened Cast Iron	SFM(Vc)	90	90	90	90	80	80	80	80	70	70	55	55		
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.00004	.00004	.00004	.00004		
			RPM	8500	8500	8500	8500	7650	7650	7650	7650	6800	6800	5100	5100		
			IPM(FEED)	2	2	2	2	1.6	1.6	1.6	1.6	1.2	1.2	0.8	0.8		

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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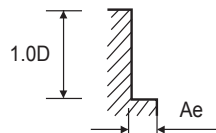
# **YG** 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Parameter	Diameter (Ø)													
			1	1	1	1	1	1	1.2	1.2	1.2	1.2	1.2	1.2	1.2	
			LBS	20	22	26	30	40	50	4	6	8	10	12	14	16
<b>P</b>	1-8	SFM(Vc)	135	70	70	70	25	25	240	240	215	215	215	195	195	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	13200	6600	6600	6600	2200	2200	19500	19500	17550	17550	17550	15600	15600	
		IPM(FEED)	5	2	2	2	1	1	12	12	10	10	10	8	8	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.018	0.018	0.01	0.006	0.006	0.006	0.004	
	9	SFM(Vc)	85	40	40	40	15	15	150	150	135	135	135	120	120	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	8100	4050	4050	4050	1350	1350	12100	12100	10890	10890	10890	9680	9680	
		IPM(FEED)	3	1	1	1	0	0	7	7	6	6	6	5	5	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.013	0.013	0.008	0.005	0.005	0.005	0.003	
	10-	SFM(Vc)	135	70	70	70	25	25	240	240	215	215	215	195	195	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	13200	6600	6600	6600	2200	2200	19500	19500	17550	17550	17550	15600	15600	
		IPM(FEED)	5	2	2	2	1	1	12	12	10	10	10	8	8	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.018	0.018	0.01	0.006	0.006	0.006	0.004	
	11.1-11.2	SFM(Vc)	85	40	40	40	15	15	150	150	135	135	135	120	120	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	8100	4050	4050	4050	1350	1350	12100	12100	10890	10890	10890	9680	9680	
		IPM(FEED)	3	1	1	1	0	0	7	7	6	6	6	5	5	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.013	0.013	0.008	0.005	0.005	0.005	0.003	
<b>K</b>	15-20	SFM(Vc)	135	70	70	70	25	25	240	240	215	215	215	195	195	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	13200	6600	6600	6600	2200	2200	19500	19500	17550	17550	17550	15600	15600	
		IPM(FEED)	5	2	2	2	1	1	12	12	10	10	10	8	8	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.018	0.018	0.01	0.006	0.006	0.006	0.004	
<b>H</b>	38.1-38.2	SFM(Vc)	55	25	25	25	10	10	95	95	85	85	85	75	75	
		IPT(fz)	.00004	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	
		RPM	5100	2550	2550	2550	850	850	7500	7500	6750	6750	6750	6000	6000	
		IPM(FEED)	0.8	0.4	0.4	0.4	0.2	0.2	2	2	1.6	1.6	1.6	1.2	1.2	
		Ae	0.001	0.001	0.001	0.001	0.001	0.001	0.011	0.011	0.006	0.004	0.004	0.004	0.002	
	40	SFM(Vc)	85	40	40	40	15	15	150	150	135	135	135	120	120	
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
		RPM	8100	4050	4050	4050	1350	1350	12100	12100	10890	10890	10890	9680	9680	
		IPM(FEED)	3	1	1	1	0	0	7	7	6	6	6	5	5	
		Ae	0.002	0.002	0.002	0.002	0.002	0.002	0.013	0.013	0.008	0.005	0.005	0.005	0.003	
	41	SFM(Vc)	55	25	25	25	10	10	95	95	85	85	85	75	75	
		IPT(fz)	.00004	.00004	.00004	.00004	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	
		RPM	5100	2550	2550	2550	850	850	7500	7500	6750	6750	6750	6000	6000	
		IPM(FEED)	0.8	0.4	0.4	0.4	0.2	0.2	2	2	1.6	1.6	1.6	1.2	1.2	
		Ae	0.001	0.001	0.001	0.001	0.001	0.001	0.011	0.011	0.006	0.004	0.004	0.004	0.002	

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



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

**4G MILL END MILLS**

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

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STANDARD CARBIDE

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TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

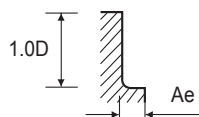
## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)												
				1.2	1.2	1.2	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5		
				LBS	20	26	30	4	5	6	7	8	10	12	14	16
P	1-8	Non-alloy steel	SFM(Vc)	145	70	70	265	265	265	265	235	235	235	235	210	
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	11700	5850	5850	17000	17000	17000	17000	15300	15300	15300	15300	13600	
			IPM(FEED)	5	2	2	13	13	13	13	10	10	10	10	8	
	9	Low alloy steel	SFM(Vc)	90	45	45	165	165	165	165	150	150	150	150	130	
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0001	
			RPM	7260	3630	3630	10700	10700	10700	10700	9630	9630	9630	9630	8560	
			IPM(FEED)	3	1	1	8	8	8	8	6	6	6	6	5	
	10-	High alloyed steel, and tool steel	SFM(Vc)	145	70	70	265	265	265	265	235	235	235	235	210	
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	11700	5850	5850	17000	17000	17000	17000	15300	15300	15300	15300	13600	
			IPM(FEED)	5	2	2	13	13	13	13	10	10	10	10	8	
11.1-11.2	High alloyed steel, and tool steel	SFM(Vc)	90	45	45	165	165	165	165	150	150	150	150	130		
		IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0001		
		RPM	7260	3630	3630	10700	10700	10700	10700	9630	9630	9630	9630	8560		
		IPM(FEED)	3	1	1	8	8	8	8	6	6	6	6	5		
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	145	70	70	265	265	265	265	235	235	235	235	210	
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	11700	5850	5850	17000	17000	17000	17000	15300	15300	15300	15300	13600	
			IPM(FEED)	5	2	2	13	13	13	13	10	10	10	10	8	
H	38.1-38.2	Hardened steel	SFM(Vc)	55	30	30	100	100	100	100	90	90	90	90	80	
			IPT(fz)	.	.	.	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	
			RPM	4500	2250	2250	6500	6500	6500	6500	5850	5850	5850	5850	5200	
			IPM(FEED)	0.8	0.4	0.4	2	2	2	2	1.6	1.6	1.6	1.6	1.2	
	40	Chilled Cast Iron	SFM(Vc)	90	45	45	165	165	165	165	150	150	150	150	130	
			IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0001	
			RPM	7260	3630	3630	10700	10700	10700	10700	9630	9630	9630	9630	8560	
			IPM(FEED)	3	1	1	8	8	8	8	6	6	6	6	5	
	41	Hardened Cast Iron	SFM(Vc)	55	30	30	100	100	100	100	90	90	90	90	80	
			IPT(fz)	.	.	.	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	
			RPM	4500	2250	2250	6500	6500	6500	6500	5850	5850	5850	5850	5200	
			IPM(FEED)	0.8	0.4	0.4	2	2	2	2	1.6	1.6	1.6	1.6	1.2	

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
 Ae : mm (Radial Depth of Cut)



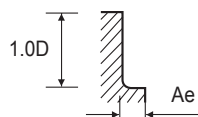
# **YG** 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Parameter	Diameter (Ø)												
			1.5	1.5	1.5	1.5	1.5	2	2	2	2	2	2	2	
			LBS	18	20	22	26	30	6	8	10	12	16	18	20
<b>P</b>	1-8	SFM(Vc)	210	210	210	160	160	285	285	285	260	260	260	260	230
		IPT(fz)	.0002	.0002	.0002	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	13600	13600	13600	10200	10200	13900	13900	13900	12510	12510	12510	12510	11120
		IPM(FEED)	8	8	8	5	5	13	13	13	10	10	10	10	8
		Ae	0.008	0.005	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011
	9	SFM(Vc)	130	130	130	100	100	185	185	185	170	170	170	170	150
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	8560	8560	8560	6420	6420	9070	9070	9070	8160	8160	8160	8160	7260
		IPM(FEED)	5	5	5	3	3	8	8	8	6	6	6	6	5
		Ae	0.006	0.004	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008
	10-	SFM(Vc)	210	210	210	160	160	285	285	285	260	260	260	260	230
		IPT(fz)	.0002	.0002	.0002	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	13600	13600	13600	10200	10200	13900	13900	13900	12510	12510	12510	12510	11120
		IPM(FEED)	8	8	8	5	5	13	13	13	10	10	10	10	8
		Ae	0.008	0.005	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011
	11.1-11.2	SFM(Vc)	130	130	130	100	100	185	185	185	170	170	170	170	150
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	8560	8560	8560	6420	6420	9070	9070	9070	8160	8160	8160	8160	7260
		IPM(FEED)	5	5	5	3	3	8	8	8	6	6	6	6	5
		Ae	0.006	0.004	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008
<b>K</b>	15-20	SFM(Vc)	210	210	210	160	160	285	285	285	260	260	260	260	230
		IPT(fz)	.0002	.0002	.0002	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	13600	13600	13600	10200	10200	13900	13900	13900	12510	12510	12510	12510	11120
		IPM(FEED)	8	8	8	5	5	13	13	13	10	10	10	10	8
		Ae	0.008	0.005	0.005	0.003	0.003	0.042	0.029	0.029	0.017	0.017	0.011	0.011	0.011
<b>H</b>	38.1-38.2	SFM(Vc)	80	80	80	60	60	125	125	125	110	110	110	110	100
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
		RPM	5200	5200	5200	3900	3900	6000	6000	6000	5400	5400	5400	5400	4800
		IPM(FEED)	1.2	1.2	1.2	0.8	0.8	2.4	2.4	2.4	2	2	2	2	1.6
		Ae	0.005	0.003	0.003	0.002	0.002	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.006
	40	SFM(Vc)	130	130	130	100	100	185	185	185	170	170	170	170	150
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
		RPM	8560	8560	8560	6420	6420	9070	9070	9070	8160	8160	8160	8160	7260
		IPM(FEED)	5	5	5	3	3	8	8	8	6	6	6	6	5
		Ae	0.006	0.004	0.004	0.002	0.002	0.032	0.022	0.022	0.013	0.013	0.008	0.008	0.008
	41	SFM(Vc)	80	80	80	60	60	125	125	125	110	110	110	110	100
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
		RPM	5200	5200	5200	3900	3900	6000	6000	6000	5400	5400	5400	5400	4800
		IPM(FEED)	1.2	1.2	1.2	0.8	0.8	2.4	2.4	2.4	2	2	2	2	1.6
		Ae	0.005	0.003	0.003	0.002	0.002	0.025	0.018	0.018	0.01	0.01	0.006	0.006	0.006

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
 Ae : mm (Radial Depth of Cut)



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

**4G MILL END MILLS**

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

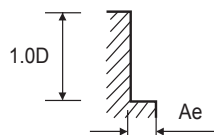
## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)											
				2	2	2	2	2	2	2	2.5	2.5	2.5	2.5	2.5
				LBS	26	30	35	40	45	50	60	8	10	12	14
<b>P</b>	1-8	Non-alloy steel	SFM(Vc)	230	230	170	170	85	85	85	310	310	310	280	280
			IPT(fz)	.0002	.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003
			RPM	11120	11120	8340	8340	4170	4170	4170	12000	12000	12000	10800	10800
			IPM(FEED)	8	8	6	6	2	2	2	14	14	14	11	11
			Ae	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037	0.037	0.021	0.021
			9	Low alloy steel	SFM(Vc)	150	150	110	110	55	55	55	195	195	195
	IPT(fz)	.0002			.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003
	RPM	7260			7260	5440	5440	2720	2720	2720	7600	7600	7600	6840	6840
	IPM(FEED)	5			5	3	3	1	1	1	9	9	9	7	7
	Ae	0.008			0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028	0.028	0.016	0.016
	10-	High alloyed steel, and tool steel			SFM(Vc)	230	230	170	170	85	85	85	310	310	310
			IPT(fz)	.0002	.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003
RPM			11120	11120	8340	8340	4170	4170	4170	12000	12000	12000	10800	10800	
IPM(FEED)			8	8	6	6	2	2	2	14	14	14	11	11	
Ae			0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037	0.037	0.021	0.021	
11.1-11.2			High alloyed steel, and tool steel	SFM(Vc)	150	150	110	110	55	55	55	195	195	195	175
	IPT(fz)	.0002		.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003	
	RPM	7260		7260	5440	5440	2720	2720	2720	7600	7600	7600	6840	6840	
	IPM(FEED)	5		5	3	3	1	1	1	9	9	9	7	7	
	Ae	0.008		0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028	0.028	0.016	0.016	
	<b>K</b>	15-20		Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	230	230	170	170	85	85	85	310	310	310
IPT(fz)			.0002		.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003
RPM			11120		11120	8340	8340	4170	4170	4170	12000	12000	12000	10800	10800
IPM(FEED)			8		8	6	6	2	2	2	14	14	14	11	11
Ae			0.011		0.006	0.004	0.004	0.004	0.004	0.004	0.037	0.037	0.037	0.021	0.021
<b>H</b>			38.1-38.2		Hardened steel	SFM(Vc)	100	100	75	75	35	35	35	115	115
	IPT(fz)	.0001		.0001		.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
	RPM	4800		4800		3600	3600	1800	1800	1800	4500	4500	4500	4050	4050
	IPM(FEED)	1.6		1.6		1	1	0.4	0.4	0.4	2.4	2.4	2.4	2	2
	Ae	0.006		0.004		0.003	0.003	0.003	0.003	0.003	0.022	0.022	0.022	0.013	0.013
	40	Chilled Cast Iron		SFM(Vc)		150	150	110	110	55	55	55	195	195	195
			IPT(fz)	.0002	.0002	.0002	.0002	.0001	.0001	.0001	.0003	.0003	.0003	.0003	.0003
			RPM	7260	7260	5440	5440	2720	2720	2720	7600	7600	7600	6840	6840
			IPM(FEED)	5	5	3	3	1	1	1	9	9	9	7	7
			Ae	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.028	0.028	0.028	0.016	0.016
			41	Hardened Cast Iron	SFM(Vc)	100	100	75	75	35	35	35	115	115	115
	IPT(fz)	.0001			.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
RPM	4800	4800			3600	3600	1800	1800	1800	4500	4500	4500	4050	4050	
IPM(FEED)	1.6	1.6			1	1	0.4	0.4	0.4	2.4	2.4	2.4	2	2	
Ae	0.006	0.004			0.003	0.003	0.003	0.003	0.003	0.022	0.022	0.022	0.013	0.013	

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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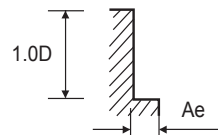
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Parameter	Diameter (Ø)												
			2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3	3	3	3
			LBS	18	20	22	26	30	35	40	45	50	6	8	10
<b>P</b>	1-8	SFM(Vc)	280	280	280	245	245	245	185	185	185	330	330	330	330
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	10800	10800	10800	9600	9600	9600	7200	7200	7200	10700	10700	10700	10700
		IPM(FEED)	11	11	11	9	9	9	6	6	6	15	15	15	15
		Ae	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044
	9	SFM(Vc)	175	175	175	155	155	155	115	115	115	205	205	205	205
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	6840	6840	6840	6080	6080	6080	4560	4560	4560	6670	6670	6670	6670
		IPM(FEED)	7	7	7	6	6	6	4	4	4	9	9	9	9
		Ae	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033
	10-	SFM(Vc)	280	280	280	245	245	245	185	185	185	330	330	330	330
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	10800	10800	10800	9600	9600	9600	7200	7200	7200	10700	10700	10700	10700
		IPM(FEED)	11	11	11	9	9	9	6	6	6	15	15	15	15
		Ae	0.021	0.021	0.013	0.013	0.013	0.008	0.008	0.005	0.005	0.063	0.063	0.044	0.044
	11.1-11.2	SFM(Vc)	175	175	175	155	155	155	115	115	115	205	205	205	205
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	6840	6840	6840	6080	6080	6080	4560	4560	4560	6670	6670	6670	6670
		IPM(FEED)	7	7	7	6	6	6	4	4	4	9	9	9	9
		Ae	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033
<b>K</b>	15-20	SFM(Vc)	280	280	280	245	245	245	185	185	185	330	330	330	330
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	10800	10800	10800	9600	9600	9600	7200	7200	7200	10700	10700	10700	10700
		IPM(FEED)	11	11	11	9	9	9	6	6	6	15	15	15	15
		Ae	.0008	.0008	.0005	.0005	.0005	.0003	.0003	.0002	.0002	.0025	.0025	.0017	.0017
<b>H</b>	38.1-38.2	SFM(Vc)	105	105	105	95	95	95	70	70	70	125	125	125	125
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002
		RPM	4050	4050	4050	3600	3600	3600	2700	2700	2700	4030	4030	4030	4030
		IPM(FEED)	2	2	2	1.6	1.6	1.6	1	1	1	2.8	2.8	2.8	2.8
		Ae	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.038	0.038	0.026	0.026
	40	SFM(Vc)	175	175	175	155	155	155	115	115	115	205	205	205	205
		IPT(fz)	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004
		RPM	6840	6840	6840	6080	6080	6080	4560	4560	4560	6670	6670	6670	6670
		IPM(FEED)	7	7	7	6	6	6	4	4	4	9	9	9	9
		Ae	0.016	0.016	0.01	0.01	0.01	0.006	0.006	0.004	0.004	0.047	0.047	0.033	0.033
	41	SFM(Vc)	105	105	105	95	95	95	70	70	70	125	125	125	125
		IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002
		RPM	4050	4050	4050	3600	3600	3600	2700	2700	2700	4030	4030	4030	4030
		IPM(FEED)	2	2	2	1.6	1.6	1.6	1	1	1	2.8	2.8	2.8	2.8
		Ae	0.013	0.013	0.008	0.008	0.008	0.005	0.005	0.003	0.003	0.038	0.038	0.026	0.026

SFM = Surface Feet per Minute  
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 Ap : Inch (Axial Depth of Cut)  
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HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

**4G MILL END MILLS**

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

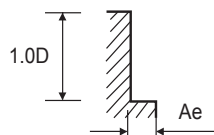
## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ap	Parameter	Diameter (Ø)												
					3	3	3	3	3	3	3	3	3	3	3		
					LBS	14	16	18	20	22	26	30	35	40	45	50	60
<b>P</b>	1-8	Non-alloy steel	1.0D	SFM(Vc)	330	300	300	300	300	300	300	265	265	265	200	200	
				IPT(fz)	.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003
				RPM	10700	9630	9630	9630	9630	9630	9630	9630	8560	8560	8560	6420	6420
				IPM(FEED)	15	12	12	12	12	12	12	10	10	10	6	6	
				Ae	0.044	0.025	0.025	0.025	0.025	0.016	0.016	0.016	0.009	0.009	0.006	0.006	
	9	Low alloy steel	1.0D	SFM(Vc)	205	185	185	185	185	185	185	165	165	165	125	125	
				IPT(fz)	.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002	
				RPM	6670	6000	6000	6000	6000	6000	6000	5340	5340	5340	4000	4000	
				IPM(FEED)	9	8	8	8	8	8	8	6	6	6	4	4	
				Ae	0.033	0.019	0.019	0.019	0.019	0.012	0.012	0.012	0.007	0.007	0.005	0.005	
	10-	High alloyed steel, and tool steel	1.0D	SFM(Vc)	330	300	300	300	300	300	300	265	265	265	200	200	
				IPT(fz)	.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	
				RPM	10700	9630	9630	9630	9630	9630	9630	8560	8560	8560	6420	6420	
				IPM(FEED)	15	12	12	12	12	12	12	10	10	10	6	6	
				Ae	0.044	0.025	0.025	0.025	0.025	0.016	0.016	0.016	0.009	0.009	0.006	0.006	
	11.1-11.2	High alloyed steel, and tool steel	1.0D	SFM(Vc)	205	185	185	185	185	185	185	165	165	165	125	125	
IPT(fz)				.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002		
RPM				6670	6000	6000	6000	6000	6000	6000	5340	5340	5340	4000	4000		
IPM(FEED)				9	8	8	8	8	8	8	6	6	6	4	4		
Ae				0.033	0.019	0.019	0.019	0.019	0.012	0.012	0.012	0.007	0.007	0.005	0.005		
<b>K</b>	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	SFM(Vc)	330	300	300	300	300	300	300	265	265	265	200	200	
				IPT(fz)	.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	
				RPM	10700	9630	9630	9630	9630	9630	9630	8560	8560	8560	6420	6420	
				IPM(FEED)	15	12	12	12	12	12	12	10	10	10	6	6	
				Ae	.0017	.001	.001	.001	.001	.0006	.0006	.0006	.0004	.0004	.0002	.0002	
<b>H</b>	38.1-38.2	Hardened steel	1.0D	SFM(Vc)	125	110	110	110	110	110	110	100	100	100	75	75	
				IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
				RPM	4030	3630	3630	3630	3630	3630	3630	3220	3220	3220	2420	2420	
				IPM(FEED)	2.8	2.2	2.2	2.2	2.2	2.2	2.2	1.8	1.8	1.8	1.2	1.2	
				Ae	0.026	0.015	0.015	0.015	0.015	0.009	0.009	0.009	0.006	0.006	0.004	0.004	
	40	Chilled Cast Iron	1.0D	SFM(Vc)	205	185	185	185	185	185	185	165	165	165	125	125	
				IPT(fz)	.0004	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0002	.0002	
				RPM	6670	6000	6000	6000	6000	6000	6000	5340	5340	5340	4000	4000	
				IPM(FEED)	9	8	8	8	8	8	8	6	6	6	4	4	
				Ae	0.033	0.019	0.019	0.019	0.019	0.012	0.012	0.012	0.007	0.007	0.005	0.005	
	41	Hardened Cast Iron	1.0D	SFM(Vc)	125	110	110	110	110	110	110	100	100	100	75	75	
				IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0001	.0001	.0001	.0001	.0001	
				RPM	4030	3630	3630	3630	3630	3630	3630	3220	3220	3220	2420	2420	
				IPM(FEED)	2.8	2.2	2.2	2.2	2.2	2.2	2.2	1.8	1.8	1.8	1.2	1.2	
				Ae	0.026	0.015	0.015	0.015	0.015	0.009	0.009	0.009	0.006	0.006	0.004	0.004	

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



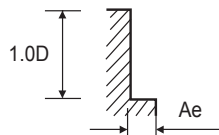
# 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ap	Parameter	Diameter (Ø)												
				4	4	4	4	4	4	4	4	4	4	4	4	
				LBS	8	10	12	14	16	18	20	22	26	30	35	40
P	1-8	1.0D	SFM(Vc)	375	375	375	375	375	375	375	375	335	335	335	300	
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006
			RPM	9070	9070	9070	9070	9070	9070	9070	9070	8160	8160	8160	8160	7260
			IPM(FEED)	27	27	27	27	27	27	27	22	22	22	22	22	17
			Ae	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021
	9	1.0D	SFM(Vc)	230	230	230	230	230	230	230	205	205	205	205	185	
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006
			RPM	5540	5540	5540	5540	5540	5540	5540	4990	4990	4990	4990	4990	4430
			IPM(FEED)	17	17	17	17	17	17	17	13	13	13	13	13	11
			Ae	0.063	0.063	0.063	0.044	0.044	0.044	0.044	0.025	0.025	0.025	0.016	0.016	0.016
	10-	1.0D	SFM(Vc)	375	375	375	375	375	375	375	335	335	335	335	300	
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006
			RPM	9070	9070	9070	9070	9070	9070	9070	8160	8160	8160	8160	8160	7260
			IPM(FEED)	27	27	27	27	27	27	27	22	22	22	22	22	17
			Ae	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021
	11.1-11.2	1.0D	SFM(Vc)	230	230	230	230	230	230	230	205	205	205	205	185	
IPT(fz)			.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006	
RPM			5540	5540	5540	5540	5540	5540	5540	4990	4990	4990	4990	4990	4430	
IPM(FEED)			17	17	17	17	17	17	17	13	13	13	13	13	11	
Ae			0.063	0.063	0.063	0.044	0.044	0.044	0.044	0.025	0.025	0.025	0.016	0.016	0.016	
K	15-20	1.0D	SFM(Vc)	375	375	375	375	375	375	375	335	335	335	335	300	
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006
			RPM	9070	9070	9070	9070	9070	9070	9070	8160	8160	8160	8160	8160	7260
			IPM(FEED)	27	27	27	27	27	27	27	22	22	22	22	22	17
			Ae	0.084	0.084	0.084	0.059	0.059	0.059	0.059	0.034	0.034	0.034	0.021	0.021	0.021
H	38.1-38.2	1.0D	SFM(Vc)	145	145	145	145	145	145	145	130	130	130	130	115	
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
			RPM	3530	3530	3530	3530	3530	3530	3530	3180	3180	3180	3180	3180	2820
			IPM(FEED)	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.2	2.2	2.2	2.2	2.2	1.8
	40	1.0D	SFM(Vc)	230	230	230	230	230	230	230	205	205	205	205	185	
			IPT(fz)	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0007	.0006
			RPM	5540	5540	5540	5540	5540	5540	5540	4990	4990	4990	4990	4990	4430
			IPM(FEED)	17	17	17	17	17	17	17	13	13	13	13	13	11
	41	1.0D	SFM(Vc)	145	145	145	145	145	145	145	130	130	130	130	115	
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002
			RPM	3530	3530	3530	3530	3530	3530	3530	3180	3180	3180	3180	3180	2820
			IPM(FEED)	2.8	2.8	2.8	2.8	2.8	2.8	2.8	2.2	2.2	2.2	2.2	2.2	1.8
			Ae	0.05	0.05	0.05	0.035	0.035	0.035	0.035	0.02	0.02	0.02	0.013	0.013	0.013

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



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

**4G MILL END MILLS**

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA



# 4G MILL END MILLS

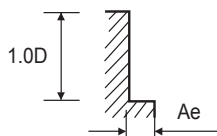
## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES

### 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ap	Parameter	Diameter (Ø)												
					4	4	5	5	5	5	5	5	5	5	6	6	
					LBS	50	60	16	20	26	30	35	40	50	60	15	20
P	1-8	Non-alloy steel	1.0D	SFM(Vc)	300	300	390	390	350	350	350	350	350	310	410	410	
				IPT(fz)	.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012
				RPM	7260	7260	7560	7560	6800	6800	6800	6800	6800	6800	6050	6670	6670
				IPM(FEED)	17	17	28	28	23	23	23	23	23	23	18	31	31
				Ae	0.021	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088
	9	Low alloy steel	1.0D	SFM(Vc)	185	185	235	235	210	210	210	210	210	185	250	250	
				IPT(fz)	.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012
				RPM	4430	4430	4530	4530	4080	4080	4080	4080	4080	4080	3620	4030	4030
				IPM(FEED)	11	11	17	17	14	14	14	14	14	14	11	19	19
				Ae	0.016	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066
	10-	High alloyed steel, and tool steel	1.0D	SFM(Vc)	300	300	390	390	350	350	350	350	350	310	410	410	
				IPT(fz)	.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012
				RPM	7260	7260	7560	7560	6800	6800	6800	6800	6800	6800	6050	6670	6670
				IPM(FEED)	17	17	28	28	23	23	23	23	23	23	18	31	31
				Ae	0.021	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088
	11.1-11.2	High alloyed steel, and tool steel	1.0D	SFM(Vc)	185	185	235	235	210	210	210	210	210	185	250	250	
IPT(fz)				.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012	
RPM				4430	4430	4530	4530	4080	4080	4080	4080	4080	4080	3620	4030	4030	
IPM(FEED)				11	11	17	17	14	14	14	14	14	14	11	19	19	
Ae				0.016	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	SFM(Vc)	300	300	390	390	350	350	350	350	350	310	410	410	
				IPT(fz)	.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012
				RPM	7260	7260	7560	7560	6800	6800	6800	6800	6800	6800	6050	6670	6670
				IPM(FEED)	17	17	28	28	23	23	23	23	23	23	18	31	31
				Ae	0.021	0.013	0.074	0.074	0.042	0.042	0.042	0.042	0.042	0.026	0.026	0.126	0.088
H	38.1-38.2	Hardened steel	1.0D	SFM(Vc)	115	115	145	145	130	130	130	130	130	115	150	150	
				IPT(fz)	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0004	.0004
				RPM	2820	2820	2780	2780	2500	2500	2500	2500	2500	2500	2220	2400	2400
				IPM(FEED)	1.8	1.8	3.3	3.3	2.8	2.8	2.8	2.8	2.8	2.8	2.2	3.7	3.7
				Ae	0.013	0.008	0.044	0.044	0.025	0.025	0.025	0.025	0.025	0.016	0.016	0.076	0.053
	40	Chilled Cast Iron	1.0D	SFM(Vc)	185	185	235	235	210	210	210	210	210	185	250	250	
				IPT(fz)	.0006	.0006	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0009	.0008	.0012	.0012
				RPM	4430	4430	4530	4530	4080	4080	4080	4080	4080	4080	3620	4030	4030
				IPM(FEED)	11	11	17	17	14	14	14	14	14	14	11	19	19
				Ae	0.016	0.009	0.055	0.055	0.032	0.032	0.032	0.032	0.032	0.02	0.02	0.095	0.066
	41	Hardened Cast Iron	1.0D	SFM(Vc)	115	115	145	145	130	130	130	130	130	115	150	150	
				IPT(fz)	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0004	.0004
				RPM	2820	2820	2780	2780	2500	2500	2500	2500	2500	2500	2220	2400	2400
				IPM(FEED)	1.8	1.8	3.3	3.3	2.8	2.8	2.8	2.8	2.8	2.8	2.2	3.7	3.7
				Ae	0.013	0.008	0.044	0.044	0.025	0.025	0.025	0.025	0.025	0.016	0.016	0.076	0.053

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



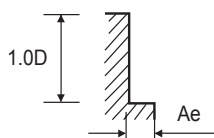
# **YG** 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME73 SERIES 4FLUTE SQUARE - SIDE CUTTING

ISO	VDI 3323	Ap	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
<b>P</b>	1-8	1.0D	SFM(Vc)	410	370	415	415	375	405	405	405	410	410	410	
			IPT(fz)	.0012	.0011	.0017	.0017	.0015	.0018	.0018	.0018	.0019	.0019	.0019	
			RPM	6670	6000	5040	5040	4540	3910	3910	3910	3300	3300	3300	
			IPM(FEED)	31	25	34	34	27	29	29	29	24	24	24	
			Ae	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176	
	9	1.0D	SFM(Vc)	250	225	250	250	225	245	245	245	250	250	250	
			IPT(fz)	.0012	.0011	.0015	.0015	.0013	.0015	.0015	.0015	.0015	.0015	.0015	
			RPM	4030	3630	3020	3020	2720	2400	2400	2400	2010	2010	2010	
			IPM(FEED)	19	16	18	18	14	14	14	14	12	12	12	
			Ae	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132	
	10-	1.0D	SFM(Vc)	410	370	415	415	375	405	405	405	410	410	410	
			IPT(fz)	.0012	.0011	.0017	.0017	.0015	.0018	.0018	.0018	.0019	.0019	.0019	
RPM			6670	6000	5040	5040	4540	3910	3910	3910	3300	3300	3300		
IPM(FEED)			31	25	34	34	27	29	29	29	24	24	24		
Ae			0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176		
11.1-11.2	1.0D	SFM(Vc)	250	225	250	250	225	245	245	245	250	250	250		
		IPT(fz)	.0012	.0011	.0015	.0015	.0013	.0015	.0015	.0015	.0015	.0015	.0015		
		RPM	4030	3630	3020	3020	2720	2400	2400	2400	2010	2010	2010		
		IPM(FEED)	19	16	18	18	14	14	14	14	12	12	12		
		Ae	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132		
<b>K</b>	15-20	1.0D	SFM(Vc)	410	370	415	415	375	405	405	405	410	410	410	
			IPT(fz)	.0012	.0011	.0017	.0017	.0015	.0018	.0018	.0018	.0019	.0019	.0019	
			RPM	6670	6000	5040	5040	4540	3910	3910	3910	3300	3300	3300	
			IPM(FEED)	31	25	34	34	27	29	29	29	24	24	24	
			Ae	0.088	0.05	0.118	0.118	0.067	0.21	0.147	0.147	0.252	0.176	0.176	
<b>H</b>	38.1-38.2	1.0D	SFM(Vc)	150	135	165	165	150	170	170	170	175	175	175	
			IPT(fz)	.0004	.0004	.0006	.0006	.0006	.0006	.0006	.0006	.0007	.0007	.0007	
			RPM	2400	2160	2010	2010	1810	1630	1630	1630	1400	1400	1400	
			IPM(FEED)	3.7	3	5.1	5.1	4.1	4.1	4.1	4.1	3.7	3.7	3.7	
			Ae	0.053	0.03	0.071	0.071	0.04	0.126	0.088	0.088	0.151	0.106	0.106	
	40	1.0D	SFM(Vc)	250	225	250	250	225	245	245	245	250	250	250	
			IPT(fz)	.0012	.0011	.0015	.0015	.0013	.0015	.0015	.0015	.0015	.0015	.0015	
			RPM	4030	3630	3020	3020	2720	2400	2400	2400	2010	2010	2010	
			IPM(FEED)	19	16	18	18	14	14	14	14	12	12	12	
			Ae	0.066	0.038	0.088	0.088	0.05	0.158	0.11	0.11	0.189	0.132	0.132	
	41	1.0D	SFM(Vc)	150	135	165	165	150	170	170	170	175	175	175	
			IPT(fz)	.0004	.0004	.0006	.0006	.0006	.0006	.0006	.0006	.0007	.0007	.0007	
RPM			2400	2160	2010	2010	1810	1630	1630	1630	1400	1400	1400		
IPM(FEED)			3.7	3	5.1	5.1	4.1	4.1	4.1	4.1	3.7	3.7	3.7		
Ae			0.053	0.03	0.071	0.071	0.04	0.126	0.088	0.088	0.151	0.106	0.106		

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



HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

**4G MILL END MILLS**

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA