

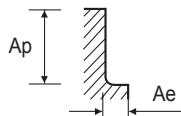
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME01 SERIES 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)									
					1.0	1.2	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0
P	1-8	0.05D	2.0D	SFM(Vc)	285	305	340	370	385	410	430	440	460	470
				IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005
				RPM	27600	24800	22000	18000	15000	13240	11980	10720	9940	9160
				IPM(FEED)	12	12	12	13	13	13	15	17	17	17
	9	0.05D	2.0D	SFM(Vc)	185	195	210	240	245	265	275	280	295	300
				IPT(fz)	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005	.0006
				RPM	18000	15750	13500	11560	9500	8560	7690	6820	6310	5800
				IPM(FEED)	9	9	9	9	10	10	11	12	13	14
	10-11.1	0.05D	2.0D	SFM(Vc)	285	305	340	370	385	410	430	440	460	470
				IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005
				RPM	27600	24800	22000	18000	15000	13240	11980	10720	9940	9160
				IPM(FEED)	12	12	12	13	13	13	15	17	17	17
11.2	0.05D	2.0D	SFM(Vc)	185	195	210	240	245	265	275	280	295	300	
			IPT(fz)	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005	.0006	
			RPM	18000	15750	13500	11560	9500	8560	7690	6820	6310	5800	
			IPM(FEED)	9	9	9	9	10	10	11	12	13	14	
K	15-20	0.05D	2.0D	SFM(Vc)	285	305	340	370	385	410	430	440	460	470
				IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005
				RPM	27600	24800	22000	18000	15000	13240	11980	10720	9940	9160
				IPM(FEED)	12	12	12	13	13	13	15	17	17	17
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	115	120	130	150	155	165	175	175	190	195
				IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0003	.0003	.0004	.0004
				RPM	11000	9750	8500	7200	6100	5280	4790	4300	4050	3800
				IPM(FEED)	5	5	5	5	5	5	5	6	6	7
	40	0.05D	2.0D	SFM(Vc)	185	195	210	240	245	265	275	280	295	300
				IPT(fz)	.0001	.0001	.0002	.0002	.0003	.0003	.0004	.0004	.0005	.0006
				RPM	18000	15750	13500	11560	9500	8560	7690	6820	6310	5800
				IPM(FEED)	9	9	9	9	10	10	11	12	13	14
	41	0.02D	2.0D	SFM(Vc)	115	120	130	150	155	165	175	175	190	195
				IPT(fz)	.0001	.0001	.0001	.0002	.0002	.0002	.0003	.0003	.0004	.0004
				RPM	11000	9750	8500	7200	6100	5280	4790	4300	4050	3800
				IPM(FEED)	5	5	5	5	5	5	5	6	6	7

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)



\* 16mm, axial cutting depth should be 1.5xD

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

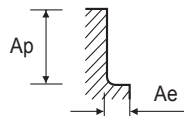
## RECOMMENDED CUTTING CONDITIONS

### SEME01 SERIES

### 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Ae	Ap	Parameter	Diameter (Ø)									
					5.5	6.0	7.0	8.0	10.0	11.0	12.0	14.0	16.0	20.0
P	1-8	0.05D	2.0D	SFM(Vc)	485	490	500	495	520	520	510	520	510	520
				IPT(fz)	.0005	.0005	.0006	.0008	.0009	.0009	.0009	.0009	.0009	.0009
				RPM	8530	7900	6950	6000	5040	4580	4120	3610	3100	2520
				IPM(FEED)	17	17	18	18	18	16	14	13	11	9
	9	0.05D	2.0D	SFM(Vc)	305	310	320	315	340	345	345	350	345	340
				IPT(fz)	.0007	.0007	.0008	.0009	.0011	.0011	.0011	.0011	.0011	.0011
				RPM	5420	5040	4420	3800	3280	3030	2780	2440	2100	1640
				IPM(FEED)	14	14	14	14	14	13	13	11	9	7
	10-11.1	0.05D	2.0D	SFM(Vc)	485	490	500	495	520	520	510	520	510	520
				IPT(fz)	.0005	.0005	.0006	.0008	.0009	.0009	.0009	.0009	.0009	.0009
				RPM	8530	7900	6950	6000	5040	4580	4120	3610	3100	2520
				IPM(FEED)	17	17	18	18	18	16	14	13	11	9
11.2	0.05D	2.0D	SFM(Vc)	305	310	320	315	340	345	345	350	345	340	
			IPT(fz)	.0007	.0007	.0008	.0009	.0011	.0011	.0011	.0011	.0011	.0011	
			RPM	5420	5040	4420	3800	3280	3030	2780	2440	2100	1640	
			IPM(FEED)	14	14	14	14	14	13	13	11	9	7	
K	15-20	0.05D	2.0D	SFM(Vc)	485	490	500	495	520	520	510	520	510	520
				IPT(fz)	.0005	.0005	.0006	.0008	.0009	.0009	.0009	.0009	.0009	.0009
				RPM	8530	7900	6950	6000	5040	4580	4120	3610	3100	2520
				IPM(FEED)	17	17	18	18	18	16	14	13	11	9
H	38.1-38.2	0.02D	2.0D	SFM(Vc)	200	205	210	210	210	210	210	215	210	205
				IPT(fz)	.0005	.0005	.0006	.0007	.0008	.0008	.0008	.0008	.0009	.0009
				RPM	3540	3280	2900	2520	2020	1850	1680	1480	1280	1000
				IPM(FEED)	7	7	7	7	7	6	6	5	5	4
	40	0.05D	2.0D	SFM(Vc)	305	310	320	315	340	345	345	350	345	340
				IPT(fz)	.0007	.0007	.0008	.0009	.0011	.0011	.0011	.0011	.0011	.0011
				RPM	5420	5040	4420	3800	3280	3030	2780	2440	2100	1640
				IPM(FEED)	14	14	14	14	14	13	13	11	9	7
	41	0.02D	2.0D	SFM(Vc)	200	205	210	210	210	210	210	215	210	205
				IPT(fz)	.0005	.0005	.0006	.0007	.0008	.0008	.0008	.0008	.0009	.0009
				RPM	3540	3280	2900	2520	2020	1850	1680	1480	1280	1000
				IPM(FEED)	7	7	7	7	7	6	6	5	5	4

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)



\* 16mm, axial cutting depth should be 1.5xD

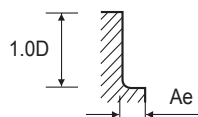
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME64 SERIES 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				1	1	1	1	1	1	1	1	1	1	1.2	1.2	1.2	1.2	1.2	1.2
				LBS	4	6	8	10	12	16	20	22	26	3	4	6	8	10	12
P	1-8	Non-alloy steel	SFM(Vc)	340	305	305	305	275	205	205	100	100	370	370	370	330	330	330	295
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	33100	29790	29790	29790	26480	19860	19860	9930	9930	29750	29750	29750	26780	26780	26780	23800
			IPM(FEED)	14	11	11	11	9	6	6	3	3	14	14	14	12	12	12	9
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005
	9	Low alloy steel	SFM(Vc)	225	200	200	200	180	135	135	65	65	235	235	235	210	210	210	185
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	21600	19440	19440	19440	17280	12960	12960	6480	6480	18900	18900	18900	17010	17010	17010	15120
			IPM(FEED)	10	8	8	8	7	4	4	2	2	10	10	10	9	9	9	7
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.019	0.019	0.011	0.007	0.007	0.004
	10	High alloyed steel, and tool steel	SFM(Vc)	340	305	305	305	275	205	205	100	100	370	370	370	330	330	330	295
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	33100	29790	29790	29790	26480	19860	19860	9930	9930	29750	29750	29750	26780	26780	26780	23800
			IPM(FEED)	14	11	11	11	9	6	6	3	3	14	14	14	12	12	12	9
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005
	11.1-11.2		SFM(Vc)	225	200	200	200	180	135	135	65	65	235	235	235	210	210	210	185
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	21600	19440	19440	19440	17280	12960	12960	6480	6480	18900	18900	18900	17010	17010	17010	15120
			IPM(FEED)	10	8	8	8	7	4	4	2	2	10	10	10	9	9	9	7
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.019	0.019	0.011	0.007	0.007	0.004
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	340	305	305	305	275	205	205	100	100	370	370	370	330	330	330	295
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	33100	29790	29790	29790	26480	19860	19860	9930	9930	29750	29750	29750	26780	26780	26780	23800
			IPM(FEED)	14	11	11	11	9	6	6	3	3	14	14	14	12	12	12	9
			Ae	0.021	0.012	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.036	0.025	0.025	0.014	0.009	0.009	0.005
H	38.1-38.2	Hardened steel	SFM(Vc)	135	120	120	120	110	80	80	40	40	145	145	145	130	130	130	115
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	13200	11880	11880	11880	10560	7920	7920	3960	3960	11700	11700	11700	10530	10530	10530	9360
			IPM(FEED)	6	5	5	5	4	2	2	1	1	6	6	6	5	5	5	4
			Ae	0.013	0.007	0.007	0.005	0.005	0.003	0.002	0.002	0.002	0.022	0.015	0.015	0.009	0.005	0.005	0.003
	40	Chilled Cast Iron	SFM(Vc)	225	200	200	200	180	135	135	65	65	235	235	235	210	210	210	185
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	21600	19440	19440	19440	17280	12960	12960	6480	6480	18900	18900	18900	17010	17010	17010	15120
			IPM(FEED)	10	8	8	8	7	4	4	2	2	10	10	10	9	9	9	7
			Ae	0.016	0.009	0.009	0.006	0.006	0.003	0.002	0.002	0.002	0.027	0.019	0.019	0.011	0.007	0.007	0.004
	41	Hardened Cast Iron	SFM(Vc)	135	120	120	120	110	80	80	40	40	145	145	145	130	130	130	115
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001
			RPM	13200	11880	11880	11880	10560	7920	7920	3960	3960	11700	11700	11700	10530	10530	10530	9360
			IPM(FEED)	6	5	5	5	4	2	2	1	1	6	6	6	5	5	5	4
			Ae	0.013	0.007	0.007	0.005	0.005	0.003	0.002	0.002	0.002	0.022	0.015	0.015	0.009	0.005	0.005	0.003

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

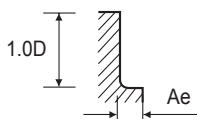
## RECOMMENDED CUTTING CONDITIONS

### SEME64 SERIES

### 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)															
				1.2	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	2	2	2	2	
				LBS	20	4	6	8	10	12	14	16	20	22	26	6	8	10	12
P	1-8	Non-alloy steel	SFM(Vc)	220	410	410	365	365	365	365	325	325	325	245	445	445	400	400	
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	17850	26400	26400	23760	23760	23760	23760	21120	21120	21120	15840	21600	21600	21600	19440	19440
			IPM(FEED)	6	15	15	12	12	12	12	9	9	9	6	15	15	15	12	12
	9	Low alloy steel	SFM(Vc)	140	250	250	225	225	225	225	200	200	200	150	285	285	255	255	
			IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	11340	16200	16200	14580	14580	14580	14580	12960	12960	12960	9720	13800	13800	13800	12420	12420
			IPM(FEED)	4	11	11	9	9	9	9	7	7	7	5	11	11	11	9	9
	10	High alloyed steel, and tool steel	SFM(Vc)	220	410	410	365	365	365	365	325	325	325	245	445	445	400	400	
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	17850	26400	26400	23760	23760	23760	23760	21120	21120	21120	15840	21600	21600	21600	19440	19440
			IPM(FEED)	6	15	15	12	12	12	12	9	9	9	6	15	15	15	12	12
11.1-11.2	High alloyed steel, and tool steel	SFM(Vc)	140	250	250	225	225	225	225	200	200	200	150	285	285	255	255		
		IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	
		RPM	11340	16200	16200	14580	14580	14580	14580	12960	12960	12960	9720	13800	13800	13800	12420	12420	
		IPM(FEED)	4	11	11	9	9	9	9	7	7	7	5	11	11	11	9	9	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	220	410	410	365	365	365	365	325	325	325	245	445	445	400	400	
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	17850	26400	26400	23760	23760	23760	23760	21120	21120	21120	15840	21600	21600	21600	19440	19440
			IPM(FEED)	6	15	15	12	12	12	12	9	9	9	6	15	15	15	12	12
H	38.1-38.2	Hardened steel	SFM(Vc)	85	160	160	140	140	140	140	125	125	125	95	180	180	160	160	
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	7020	10200	10200	9180	9180	9180	9180	8160	8160	8160	6120	8640	8640	8640	7780	7780
			IPM(FEED)	2	6	6	5	5	5	5	4	4	4	2	6	6	6	5	5
	40	Chilled Cast Iron	SFM(Vc)	140	250	250	225	225	225	225	200	200	200	150	285	285	255	255	
			IPT(fz)	.0001	.0002	.0002	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	11340	16200	16200	14580	14580	14580	14580	12960	12960	12960	9720	13800	13800	13800	12420	12420
			IPM(FEED)	4	11	11	9	9	9	9	7	7	7	5	11	11	11	9	9
	41	Hardened Cast Iron	SFM(Vc)	85	160	160	140	140	140	140	125	125	125	95	180	180	160	160	
			IPT(fz)	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002
			RPM	7020	10200	10200	9180	9180	9180	9180	8160	8160	8160	6120	8640	8640	8640	7780	7780
			IPM(FEED)	2	6	6	5	5	5	5	4	4	4	2	6	6	6	5	5

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute  
 Ap : Inch (Axial Depth of Cut)  
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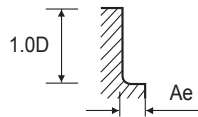
# YG 4G MILL END MILLS

## RECOMMENDED CUTTING CONDITIONS

### SEME64 SERIES 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																	
				2	2	2	2	2	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	3	3	3		
				LBS	16	20	22	26	30	8	10	12	14	16	20	26	30	8	10	12	
P	1-8	Non-alloy steel	SFM(Vc)	400	400	355	355	355	465	465	465	415	415	415	370	370	490	490	490		
			IPT(fz)	.0002	.0002	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	19440	19440	17280	17280	17280	18000	18000	18000	16200	16200	16200	14400	14400	15900	15900	15900	15900	
			IPM(FEED)	12	12	10	10	10	15	15	15	12	12	12	10	10	16	16	16	16	
			Ae	0.024	0.015	0.015	0.015	0.009	0.053	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	
	9	Low alloy steel	SFM(Vc)	255	255	230	230	230	295	295	295	265	265	265	235	235	320	320	320		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	
			RPM	12420	12420	11040	11040	11040	11400	11400	11400	10260	10260	10260	9120	9120	10300	10300	10300	10300	
			IPM(FEED)	9	9	7	7	7	12	12	12	10	10	10	8	8	12	12	12	12	
			Ae	0.018	0.011	0.011	0.011	0.007	0.039	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	
	10	High alloyed steel, and tool steel	SFM(Vc)	400	400	355	355	355	465	465	465	415	415	415	370	370	490	490	490		
			IPT(fz)	.0002	.0002	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	19440	19440	17280	17280	17280	18000	18000	18000	16200	16200	16200	14400	14400	15900	15900	15900	15900	
			IPM(FEED)	12	12	10	10	10	15	15	15	12	12	12	10	10	16	16	16	16	
			Ae	0.024	0.015	0.015	0.015	0.009	0.053	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	
	11.1-11.2		SFM(Vc)	255	255	230	230	230	295	295	295	265	265	265	235	235	320	320	320		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	
			RPM	12420	12420	11040	11040	11040	11400	11400	11400	10260	10260	10260	9120	9120	10300	10300	10300	10300	
			IPM(FEED)	9	9	7	7	7	12	12	12	10	10	10	8	8	12	12	12	12	
			Ae	0.018	0.011	0.011	0.011	0.007	0.039	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	400	400	355	355	355	465	465	465	415	415	415	370	370	490	490	490		
			IPT(fz)	.0002	.0002	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	19440	19440	17280	17280	17280	18000	18000	18000	16200	16200	16200	14400	14400	15900	15900	15900	15900	
			IPM(FEED)	12	12	10	10	10	15	15	15	12	12	12	10	10	16	16	16	16	
			Ae	0.024	0.015	0.015	0.015	0.009	0.053	0.053	0.053	0.03	0.03	0.03	0.019	0.019	0.09	0.063	0.063	0.063	
H	38.1-38.2	Hardened steel	SFM(Vc)	160	160	140	140	140	190	190	190	170	170	170	150	150	195	195	195		
			IPT(fz)	.0002	.0002	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	7780	7780	6910	6910	6910	7320	7320	7320	6590	6590	6590	5860	5860	6300	6300	6300	6300	
			IPM(FEED)	5	5	4	4	4	6	6	6	5	5	5	4	4	6	6	6	6	
			Ae	0.014	0.009	0.009	0.009	0.005	0.032	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.054	0.038	0.038	0.038	
	40	Chilled Cast Iron	SFM(Vc)	255	255	230	230	230	295	295	295	265	265	265	235	235	320	320	320		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	
			RPM	12420	12420	11040	11040	11040	11400	11400	11400	10260	10260	10260	9120	9120	10300	10300	10300	10300	
			IPM(FEED)	9	9	7	7	7	12	12	12	10	10	10	8	8	12	12	12	12	
			Ae	0.018	0.011	0.011	0.011	0.007	0.039	0.039	0.039	0.023	0.023	0.023	0.014	0.014	0.068	0.047	0.047	0.047	
	41	Hardened Cast Iron	SFM(Vc)	160	160	140	140	140	190	190	190	170	170	170	150	150	195	195	195		
			IPT(fz)	.0002	.0002	.0001	.0001	.0001	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0002	
			RPM	7780	7780	6910	6910	6910	7320	7320	7320	6590	6590	6590	5860	5860	6300	6300	6300	6300	
			IPM(FEED)	5	5	4	4	4	6	6	6	5	5	5	4	4	6	6	6	6	
			Ae	0.014	0.009	0.009	0.009	0.005	0.032	0.032	0.032	0.018	0.018	0.018	0.011	0.011	0.054	0.038	0.038	0.038	

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

### SEME64 SERIES

### 4FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																	
				3		3		3		3		3		4		4		4		4	
				LBS	14	16	20	26	30	35	40	10	12	14	16	20	26	30	35	40	
P	1-8	Non-alloy steel	SFM(Vc)	490	440	440	440	440	395	395	530	530	530	530	530	475	475	475	475		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003		
			RPM	15900	14310	14310	14310	14310	12720	12720	12800	12800	12800	12800	12800	11520	11520	11520	11520		
			IPM(FEED)	16	13	13	13	13	10	10	20	20	20	20	20	16	16	16	16		
	9	Low alloy steel	SFM(Vc)	320	285	285	285	285	255	255	340	340	340	340	340	305	305	305	305		
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004		
			RPM	10300	9270	9270	9270	9270	8240	8240	8200	8200	8200	8200	8200	7380	7380	7380	7380		
			IPM(FEED)	12	10	10	10	10	8	8	14	14	14	14	14	11	11	11	11		
	10	High alloyed steel, and tool steel	SFM(Vc)	490	440	440	440	440	395	395	530	530	530	530	530	475	475	475	475		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003		
			RPM	15900	14310	14310	14310	14310	12720	12720	12800	12800	12800	12800	12800	11520	11520	11520	11520		
			IPM(FEED)	16	13	13	13	13	10	10	20	20	20	20	20	16	16	16	16		
	11.1-11.2	High alloyed steel, and tool steel	SFM(Vc)	320	285	285	285	285	255	255	340	340	340	340	340	305	305	305	305		
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004		
			RPM	10300	9270	9270	9270	9270	8240	8240	8200	8200	8200	8200	8200	7380	7380	7380	7380		
			IPM(FEED)	12	10	10	10	10	8	8	14	14	14	14	14	11	11	11	11		
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	SFM(Vc)	490	440	440	440	440	395	395	530	530	530	530	530	475	475	475	475		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0003	.0003	.0003	.0003		
			RPM	15900	14310	14310	14310	14310	12720	12720	12800	12800	12800	12800	12800	11520	11520	11520	11520		
			IPM(FEED)	16	13	13	13	13	10	10	20	20	20	20	20	16	16	16	16		
H	38.1-38.2	Hardened steel	SFM(Vc)	195	175	175	175	175	155	155	210	210	210	210	210	190	190	190	190		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003		
			RPM	6300	5670	5670	5670	5670	5040	5040	5150	5150	5150	5150	5150	4640	4640	4640	4640		
			IPM(FEED)	6	5	5	5	5	4	4	6	6	6	6	6	5	5	5	5		
	40	Chilled Cast Iron	SFM(Vc)	320	285	285	285	285	255	255	340	340	340	340	340	305	305	305	305		
			IPT(fz)	.0003	.0003	.0003	.0003	.0003	.0002	.0002	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004	.0004		
			RPM	10300	9270	9270	9270	9270	8240	8240	8200	8200	8200	8200	8200	7380	7380	7380	7380		
			IPM(FEED)	12	10	10	10	10	8	8	14	14	14	14	14	11	11	11	11		
	41	Hardened Cast Iron	SFM(Vc)	195	175	175	175	175	155	155	210	210	210	210	210	190	190	190	190		
			IPT(fz)	.0002	.0002	.0002	.0002	.0002	.0002	.0002	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003	.0003		
			RPM	6300	5670	5670	5670	5670	5040	5040	5150	5150	5150	5150	5150	4640	4640	4640	4640		
			IPM(FEED)	6	5	5	5	5	4	4	6	6	6	6	6	5	5	5	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 : mm (Radial Depth of Cut)

