

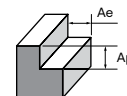
Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

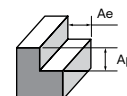


SE 45 Short Flutes Long Reach Extra-Long Endmills, 4 Flutes - 899, 901, 909, A22, A23, A32, A33, B33



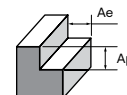
Side Milling	K		P		M		S		H	
Working Material	Ductile Cast Iron		Prehardened steel		Stainless steel		Nickel Alloy		Hardened steel	
Properties	-		35 ≤ HRC < 45		Low Machinability		-		45 ≤ HRC < 52	
Cutting depth, ap	0.25 × D		0.25 × D		0.23 × D		0.18 × D		0.23 × D	
Cutting Width, ae	0.32 × D		0.32 × D		0.32 × D		0.32 × D		0.32 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
2	80	0.006	100	0.008	40	0.009	30	0.004	80	0.004
3		0.010		0.013		0.016		0.009		0.006
4		0.014		0.017		0.022		0.014		0.009
5		0.017		0.023		0.028		0.019		0.012
6		0.022		0.031		0.040		0.023		0.014
8		0.029		0.041		0.052		0.032		0.020
10		0.036		0.052		0.067		0.039		0.025
12		0.043		0.062		0.079		0.047		0.031
14		0.050		0.070		0.086		0.058		0.036
16		0.058		0.079		0.095		0.063		0.041
18		0.065		0.089		0.106		0.072		0.047
20		0.072		0.095		0.117		0.079		0.052

SE 45 MultiFlutes Standard Endmills, 6 Flutes - A89, A94, B71, C14



Side Milling	K		P		M		S		H	
Working Material	Ductile Cast Iron		Prehardened steel		Stainless steel		Nickel Alloy		Hardened steel	
Properties	-		35 ≤ HRC < 45		Low Machinability		-		45 ≤ HRC < 52	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.15 × D		0.15 × D		0.10 × D		0.07 × D		0.08 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	120	0.012	130	0.013	55	0.008	40	0.009	110	0.012
4		0.017		0.018		0.011		0.012		0.017
5		0.022		0.023		0.015		0.016		0.021
6		0.027		0.028		0.019		0.019		0.025
8		0.036		0.038		0.026		0.026		0.034
10		0.045		0.048		0.033		0.035		0.042
12		0.055		0.058		0.041		0.045		0.051
14		0.062		0.067		0.045		0.052		0.059

SE 45 MultiFlutes Standard Endmills, 8 Flutes - A89, A94, B71, C14



Side Milling	K		P		M		S		H	
Working Material	Ductile Cast Iron		Prehardened steel		Stainless steel		Nickel Alloy		Hardened steel	
Properties	-		35 ≤ HRC < 45		Low Machinability		-		45 ≤ HRC < 52	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.15 × D		0.15 × D		0.10 × D		0.07 × D		0.08 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
16	120	0.067	130	0.072	55	0.052	40	0.060	110	0.063
18		0.074		0.078		0.058		0.066		0.071
20		0.081		0.084		0.062		0.069		0.078