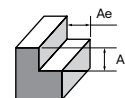


Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

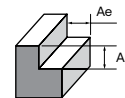


SE 45 Long Endmills, 4 Flutes - 186, 855, 866, 867, 889, A09



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	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, ae	0.14 × D		0.14 × D		0.14 × D		0.08 × D		0.12 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	80	0.011	100	0.014	45	0.018	25	0.010	80	0.007
4		0.015		0.019		0.024		0.016		0.010
5		0.019		0.026		0.031		0.021		0.013
6		0.024		0.034		0.044		0.026		0.016
8		0.032		0.046		0.058		0.035		0.022
10		0.040		0.058		0.074		0.043		0.028
12		0.048		0.069		0.088		0.052		0.034
14		0.056		0.078		0.096		0.064		0.040
16		0.064		0.088		0.106		0.070		0.046
18		0.072		0.099		0.118		0.080		0.052
20	0.080	0.105	0.130	0.088	0.058					

SE 45 Extra-Long Endmills, 4 Flutes - 202, 859, 870, 871, 891, A11



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	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, ae	0.12 × D		0.12 × D		0.12 × D		0.05 × D		0.08 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	70	0.010	90	0.013	35	0.016	20	0.009	70	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					

AU LINE
 EZ LINE -
 ENDMILL
 SE 30
 NITICO 30
 OPTIMUM
 SE 45
 SE 45X
 NITICO 45
 SE 60
 SE 60X
 DN70 -
 SE 70
 SE GR
 TE 45
 PLUNGE
 -MILL
 THREAD
 MILL