

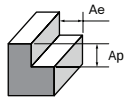
Recommended Cutting Data



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

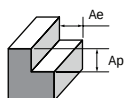


SE 70 Torus DH Multiflute / with Recess Endmills, 6 Flutes - K73, K76, K77



Side Milling	M		S		H			
Working Material	Stainless Steel		Nickel Alloy		Hardened Steel		Hardened Steel	
Properties	Low Machinability		-		45 ≤ HRC < 52		52 ≤ HRC < 68	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.05 × D		0.05 × D		0.05 × D		0.05 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	70	0.021	60	0.023	150	0.011	110	0.010
4		0.026		0.024		0.016		0.015
5		0.030		0.027		0.021		0.019

SE 70 Torus DH Multiflute / with Recess Endmills, 7 Flutes - K73, K76, K77



Side Milling	M		S		H			
Working Material	Stainless Steel		Nickel Alloy		Hardened Steel		Hardened Steel	
Properties	Low Machinability		-		45 ≤ HRC < 52		52 ≤ HRC < 68	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.05 × D		0.05 × D		0.05 × D		0.05 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	70	0.032	60	0.030	150	0.027	110	0.025
8		0.037		0.034		0.038		0.035
10		0.042		0.039		0.050		0.046
12		0.047		0.042		0.066		0.059
16		0.056		0.049		0.085		0.075
20		0.061		0.055		0.099		0.090