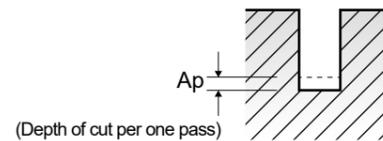


SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)																
				0.1		0.15		0.2		0.3		0.4		0.5		0.6		0.8		
				LBS	0.3	0.5	1	0.35	0.5	1	1.5	2	1	1.5	2	2.5	3	4	5	1
P	1-5	Non-alloy steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025
			LBS	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34
	6-8	Low alloy steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025
			LBS	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34
9	High alloyed steel, and tool steel	Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	
		fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007	
		RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465	
		FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357	
		Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	
		LBS	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	
10-11.1	High alloyed steel, and tool steel	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	
		fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01	
		RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056	
		FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541	
		Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025	
		LBS	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34	
11.2	High alloyed steel, and tool steel	Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	
		fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007	
		RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465	
		FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357	
		Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02	
		LBS	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32	
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	Vc	16	16	14	20	24	24	22	22	32	32	29	29	29	26	19	34	34
			fz	0.003	0.003	0.003	0.004	0.005	0.005	0.004	0.004	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.01	0.01
			RPM	50930	50930	44563	42441	38197	38197	35014	35014	33953	33953	30770	30770	30770	27587	20160	27056	27056
			FEED	306	306	267	340	382	382	280	280	407	407	308	308	308	276	161	541	541
			Ap	0.009	0.006	0.002	0.013	0.018	0.013	0.007	0.005	0.019	0.019	0.011	0.007	0.007	0.004	0.003	0.036	0.025
H	38.1 - 38.2	Hardened steel	Vc	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29
			fz	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.006	0.006
			RPM	41380	41380	35014	33953	31831	31831	28648	28648	28648	28648	25465	25465	25465	22282	16977	23077	23077
			FEED	166	166	140	136	191	191	172	172	229	229	204	204	204	134	102	277	277
			Ap	0.005	0.004	0.001	0.007	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014
			LBS	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29
	40	Chilled Cast Iron	Vc	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32
			fz	0.002	0.002	0.002	0.003	0.004	0.004	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.007	0.007
			RPM	47746	47746	41380	40319	36606	36606	33423	33423	31831	31831	28648	28648	28648	25465	19099	25465	25465
			FEED	191	191	166	242	293	293	201	201	255	255	229	229	229	153	115	357	357
			Ap	0.007	0.005	0.002	0.010	0.014	0.01	0.006	0.004	0.015	0.015	0.008	0.005	0.005	0.003	0.002	0.028	0.02
			LBS	15	15	13	19	23	23	21	21	30	30	27	27	27	24	18	32	32
41	Hardened Cast Iron	Vc	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29	
		fz	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.006	0.006	
		RPM	41380	41380	35014	33953	31831	31831	28648	28648	28648	28648	25465	25465	25465	22282	16977	23077	23077	
		FEED	166	166	140	136	191	191	172	172	229	229	204	204	204	134	102	277	277	
		Ap	0.005	0.004	0.001	0.007	0.01	0.007	0.004	0.003	0.011	0.011	0.006	0.004	0.004	0.002	0.002	0.02	0.014	
		LBS	13	13	11	16	20	20	18	18	27	27	24	24	24	21	16	29	29	

▶ NEXT PAGE



SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																											
		0.4		0.4		0.4		0.4		0.4		0.4		0.5		0.5		0.5		0.5		0.5		0.5		0.6		0.6	
		LBS	2	2.5	3	4	5	6	8	10	1	1.5	2	2.5	3	4	5	6	8	10	12	14	16	2	3				
1-5	Vc	34	31	31	31	28	28	21	10	43	43	43	39	39	39	34	26	26	13	13	4	52	52						
	fz	0.01	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.006	0.006	0.005	0.005	0.014	0.014					
	RPM	27056	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587					
	FEED	541	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99	25	772	772					
	Ap	0.025	0.014	0.014	0.009	0.009	0.005	0.004	0.004	0.045	0.045	0.032	0.032	0.018	0.018	0.011	0.011	0.007	0.005	0.005	0.005	0.005	0.038	0.038					
6-8	Vc	34	31	31	31	28	28	21	10	43	43	43	39	39	39	34	26	26	13	13	4	52	52						
	fz	0.01	0.009	0.009	0.009	0.008	0.008	0.007	0.006	0.01	0.01	0.01	0.01	0.009	0.009	0.009	0.008	0.007	0.006	0.006	0.005	0.005	0.014	0.014					
	RPM	27056	24669	24669	24669	22282	22282	16711	7958	27375	27375	27375	27375	24828	24828	24828	21645	16552	16552	8276	8276	2546	27587	27587					
	FEED	541	444	444	444	357	357	234	95	547	547	547	547	447	447	447	346	232	232	99	99								

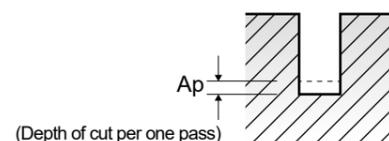
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																								
			0.6		0.6		0.6		0.6		0.6		0.7		0.7		0.7		0.8		0.8		0.8		0.8		
			LBS	4	5	6	8	10	12	14	16	2	4	6	8	10	12	2	3	4	5	6	2	3	4	5	6
P	1-5	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	0.013	0.013	0.013	0.013	0.013	
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.009	0.014	0.013	0.013	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013	0.013	0.013	0.013	0.013	
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669	24669	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	143	764	638	638	480	480	327	769	769	769	641	641	641	641	641	641	641
	Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.029	0.029	0.029	0.029	0.029	
	6-8	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	0.013	0.013	0.013	0.013	0.013	
		fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.009	0.014	0.013	0.013	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013	0.013	0.013	0.013	0.013	
		RPM	24404	24404	24404	21751	16446	16446	7958	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669	24669	24669	24669	24669
		FEED	634	634	634	479	329	329	143	143	143	764	638	638	480	480	327	769	769	769	641	641	641	641	641	641	641
	Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.029	0.029	0.029	0.029	0.029	
	9	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	0.009	0.009	0.009	0.009	0.009	
		fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.011	0.011	
RPM		23343	23343	23343	20690	15385	15385	7958	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077	23077	23077	23077	23077	
FEED		420	420	420	331	215	215	95	95	95	570	417	417	327	327	216	621	621	621	508	508	508	508	508	508	508	
Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.022	0.022	0.022	0.022	0.022		
10-11.1	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	0.013	0.013	0.013	0.013	0.013		
	fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.009	0.014	0.013	0.013	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013	0.013	0.013	0.013	0.013		
	RPM	24404	24404	24404	21751	16446	16446	7958	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669	24669	24669	24669	24669	
	FEED	634	634	634	479	329	329	143	143	143	764	638	638	480	480	327	769	769	769	641	641	641	641	641	641	641	
Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.029	0.029	0.029	0.029	0.029		
11.2	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	0.009	0.009	0.009	0.009	0.009		
	fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.011	0.011		
	RPM	23343	23343	23343	20690	15385	15385	7958	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077	23077	23077	23077	23077	
	FEED	420	420	420	331	215	215	95	95	95	570	417	417	327	327	216	621	621	621	508	508	508	508	508	508	508	
Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.022	0.022	0.022	0.022	0.022		
K 15-20	Vc	46	46	46	41	31	31	15	15	60	54	54	48	48	36	69	69	69	62	62	0.013	0.013	0.013	0.013	0.013		
	fz	0.013	0.013	0.013	0.011	0.01	0.01	0.009	0.009	0.009	0.014	0.013	0.013	0.011	0.01	0.014	0.014	0.014	0.013	0.013	0.013	0.013	0.013	0.013	0.013		
	RPM	24404	24404	24404	21751	16446	16446	7958	7958	7958	27284	24555	24555	21827	21827	16370	27454	27454	27454	24669	24669	24669	24669	24669	24669	24669	
	FEED	634	634	634	479	329	329	143	143	143	764	638	638	480	480	327	769	769	769	641	641	641	641	641	641	641	
Ap	0.022	0.014	0.014	0.008	0.005	0.005	0.005	0.005	0.005	0.063	0.025	0.016	0.016	0.009	0.006	0.072	0.05	0.05	0.029	0.029	0.029	0.029	0.029	0.029	0.029		
H 38.1 - 38.2	Vc	39	39	39	34	26	26	13	13	50	45	45	40	40	30	57	57	57	52	52	0.008	0.008	0.008	0.008	0.008		
	fz	0.008	0.008	0.008	0.007	0.006	0.006	0.005	0.005	0.009	0.008	0.008	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.009	0.009	0.009	0.009	0.009	0.009		
	RPM	20690	20690	20690	18038	13793	13793	6897	6897	6897	22736	20463	20463	18189	18189	13642	22680	22680	22680	20690	20690	20690	20690	20690	20690	20690	
	FEED	331	331	331	253	166	166	69	69	69	409	327	327	255	255	164	454	454	454	372	372	372	372	372	372	372	
Ap	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.016	0.016	0.016	0.016	0.016		
H 40	Vc	44	44	44	39	29	29	15	15	57	51	51	45	45	34	65	65	65	58	58	0.009	0.009	0.009	0.009	0.009		
	fz	0.009	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.011	0.009	0.009	0.008	0.008	0.007	0.012	0.012	0.012	0.011	0.011	0.011	0.011	0.011	0.011	0.011		
	RPM	23343	23343	23343	20690	15385	15385	7958	7958	7958	25920	23191	23191	20463	20463	15461	25863	25863	25863	23077	23077	23077	23077	23077	23077	23077	
	FEED	420	420	420	331	215	215	95	95	95	570	417	417	327	327	216	621	621	621	508	508	508	508	508	508	508	
Ap	0.017	0.011	0.011	0.006	0.004	0.004	0.004	0.004	0.004	0.049	0.02	0.012	0.012	0.007	0.005	0.056	0.039	0.039	0.022	0.022	0.022	0.022	0.022	0.022	0.022		
H 41	Vc	39	39	39	34	26	26	13	13	50	45	45	40	40	30	57	57	57	52	52	0.008	0.008	0.008	0.008	0.008		
	fz	0.008	0.008	0.008	0.007	0.006	0.006	0.005	0.005	0.009	0.008	0.008	0.007	0.007	0.006	0.01	0.01	0.01	0.009	0.009	0.009	0.009	0.009	0.009	0.009		
	RPM	20690	20690	20690	18038	13793	13793	6897	6897	6897	22736	20463	20463	18189	18189	13642	22680	22680	22680	20690	20690	20690	20690	20690	20690	20690	
	FEED	331	331	331	253	166	166	69	69	69	409	327	327	255	255	164	454	454	454	372	372	372	372	372	372	372	
Ap	0.012	0.008	0.008	0.005	0.003	0.003	0.003	0.003	0.003	0.035	0.014	0.009	0.009	0.005	0.004	0.04	0.028	0.028	0.016	0.016	0.016	0.016	0.016	0.016	0.016		

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RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																													
		0.8		0.8		0.8		0.8		0.8		0.9		0.9		0.9		1.0		1.0		1.0		1.0		1.0		1.0		1.0	
		LBS	8	10	12	14	16	20	6	8	10	2	3	4	5	6	7	8	10	12	14	16	18	20	22	8	10	12	14	16	18
1-5	Vc	62	55	55	41	41	21</																								

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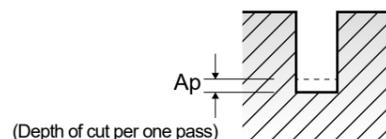
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

ISO	VDI 3323	Parameter	Diameter (Ø)																		
			1.0	1.0	1.0	1.0	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.4	1.4	1.4	1.4	1.4		
			LBS	26	30	40	50	4	6	8	10	12	14	16	20	26	30	6	8	10	14
P	1-5	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526
	Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	
	6-8	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68
		fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017
		RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461
		FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526
	Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032	
	9	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64
		fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013
RPM		7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	
FEED		154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	
Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025		
10-11.1	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	
	fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	
	RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	
	FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	
Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032		
11.2	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64	
	fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013	
	RPM	7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	
	FEED	154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	
Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025		
K 15-20	Vc	23	23	8	8	83	83	74	74	74	66	66	50	25	25	84	76	76	76	68	
	fz	0.013	0.013	0.01	0.01	0.021	0.021	0.019	0.019	0.019	0.017	0.017	0.015	0.013	0.013	0.021	0.019	0.019	0.019	0.017	
	RPM	7321	7321	2546	2546	22016	22016	19629	19629	19629	17507	17507	13263	6631	6631	19099	17280	17280	17280	15461	
	FEED	190	190	51	51	925	925	746	746	746	595	595	398	172	172	802	657	657	657	526	
Ap	0.009	0.009	0.009	0.006	0.076	0.076	0.043	0.027	0.027	0.027	0.016	0.011	0.011	0.011	0.088	0.05	0.05	0.032	0.032		
H 38.1 - 38.2	Vc	19	19	6	6	69	69	62	62	62	55	55	41	21	21	70	63	63	63	56	
	fz	0.01	0.01	0.009	0.009	0.013	0.013	0.012	0.012	0.012	0.011	0.011	0.009	0.008	0.008	0.013	0.012	0.012	0.012	0.011	
	RPM	6048	6048	1910	1910	18303	18303	16446	16446	16446	14589	14589	10876	5570	5570	15915	14324	14324	14324	12732	
	FEED	121	121	34	34	476	476	395	395	395	321	321	196	89	89	414	344	344	344	280	
Ap	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018		
H 40	Vc	22	22	7	7	78	78	70	70	70	62	62	47	23	23	80	72	72	72	64	
	fz	0.011	0.011	0.01	0.01	0.017	0.017	0.016	0.016	0.016	0.014	0.014	0.012	0.01	0.01	0.016	0.014	0.014	0.014	0.013	
	RPM	7003	7003	2228	2228	20690	20690	18568	18568	18568	16446	16446	12467	6101	6101	18189	16370	16370	16370	14551	
	FEED	154	154	45	45	703	703	594	594	594	460	460	299	122	122	582	458	458	458	378	
Ap	0.007	0.007	0.007	0.005	0.059	0.059	0.034	0.021	0.021	0.021	0.013	0.008	0.008	0.008	0.069	0.039	0.039	0.025	0.025		
H 41	Vc	19	19	6	6	69	69	62	62	62	55	55	41	21	21	70	63	63	63	56	
	fz	0.01	0.01	0.009	0.009	0.013	0.013	0.012	0.012	0.012	0.011	0.011	0.009	0.008	0.008	0.013	0.012	0.012	0.012	0.011	
	RPM	6048	6048	1910	1910	18303	18303	16446	16446	16446	14589	14589	10876	5570	5570	15915	14324	14324	14324	12732	
	FEED	121	121	34	34	476	476	395	395	395	321	321	196	89	89	414	344	344	344	280	
Ap	0.005	0.005	0.005	0.003	0.042	0.042	0.024	0.015	0.015	0.015	0.009	0.006	0.006	0.006	0.049	0.028	0.028	0.018	0.018		

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YG 4G MILL END MILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

SEM845 SERIES 2 FLUTE - SLOTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.
Ap = mm LBS = Length Below Shank

VDI 3323	Parameter	Diameter (Ø)																									
		1.4	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5							
		LBS	20	4	5	6	7	8	10	12	14	16	18	20	22	26	30	8	10	12	16	16	16	16	16	1.8	1.8
1-5	Vc	68	90	90	90	90	90	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81
	fz	0.017	0.024	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021
	RPM	15461	19099	19099	19099	19099	19099	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189
	FEED	526	917	917	917	917	917	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722
Ap	0.019	0.135	0.095	0.095	0.095	0.095	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	
6-8	Vc	68	90	90	90	90	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81	81
	fz	0.017	0.024	0.024	0.024	0.024	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021	0.021
	RPM	15461	19099	19099	19099	19099	19099	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189	17189
	FEED	526	917	917	917	917	917	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722	722
Ap	0.019	0.135	0.095	0.095	0.095	0.095	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	0.054	
9	Vc	64	85	85	85	85	85	77	77	77																	

