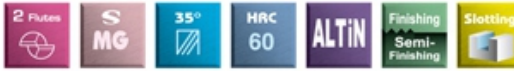


SEFA



unit: mm

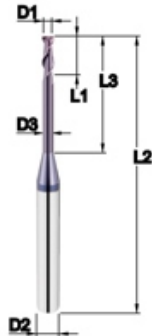
- Co 12%
- Wc 88%
- Dia 0,4µm

Long Neck / Square End Mills



Order No.	Radius R	Neck Dia D3	Flute Length L1	Effective Length L3	O.A.L. L2	Shank Dia D2
SEFA 01006	1.0	1.92	3	6	50	4
SEFA 01008	1.0	1.92	3	8	50	4
SEFA 01010	1.0	1.92	3	10	50	4
SEFA 01012	1.0	1.92	3	12	50	4
SEFA 01508	1.5	2.90	4	8	50	4
SEFA 01510	1.5	2.90	4	10	50	4
SEFA 01512	1.5	2.90	4	12	50	4
SEFA 01516	1.5	2.90	4	16	50	4
SEFA 02008	2.0	3.88	6	8	50	4
SEFA 02010	2.0	3.88	6	10	50	4
SEFA 02012	2.0	3.88	6	12	50	4
SEFA 02016	2.0	3.88	6	16	50	4
SEFA 02020	2.0	3.88	6	20	50	4
SEFA 02510	2.5	4.80	8	10	50	4
SEFA 02512	2.5	4.80	8	12	50	4
SEFA 02516	2.5	4.80	8	16	50	4
SEFA 02520	2.5	4.80	8	20	50	4
SEFA 03010	3.0	5.80	8	10	50	6
SEFA 03012	3.0	5.80	8	12	50	6
SEFA 03016	3.0	5.80	8	16	50	6
SEFA 03020	3.0	5.80	8	20	75	6
SEFA 03025	3.0	5.80	8	25	75	6

Recommended cutting condition for SEFA



MATERIAL		Alloy Steels . Tool Steels . Hardened Steels S45C , SCM , S50C , SKS , SCr , SNCM , SKD11 , SKD61 , NAK80			
DIAMETER	EFFECTIVE LENGTH	SPEED (mm ¹)	FEED mm / min	DEPTH OF CUT H (mm)	
1	4	25000	1500	0.05	
	6	25000	1500	0.03	
	10	25000	1500	0.01	
1.5	4	15000	1200	0.1	
	8	15000	1200	0.05	
	10	15000	1200	0.025	
2	12	15000	1200	0.018	
	8	12000	900	0.2	
	10	8800	700	0.12	
3	12	7500	600	0.05	
	16	7000	500	0.02	
	8	8000	600	0.5	
	12	8000	600	0.45	
16	5500	450	0.18		
	20	4000	300	0.15	
	10	6000	400	0.7	
	16	6000	400	0.4	

DEPTH OF CUT



D=Diameter

