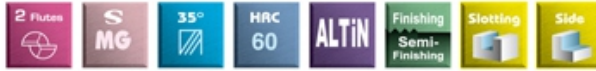


SEM



unit: mm

- Co 12%
- Wc 88%
- Dia 0.4µm

Micro Diameter / Square End Mills



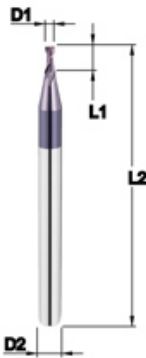
Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
SEM 0024	0.2	0.4	50	4
SEM 0034	0.3	0.6	50	4
SEM 0044	0.4	0.8	50	4
SEM 0054	0.5	1.0	50	4
SEM 0064	0.6	1.2	50	4
SEM 0074	0.7	1.4	50	4
SEM 0084	0.8	1.6	50	4
SEM 0094	0.9	1.8	50	4
SEM 0124	1.2	3.0	50	4
SEM 0144	1.4	3.0	50	4
SEM 0164	1.6	4.0	50	4
SEM 0184	1.8	5.0	50	4

Dyalco CNC

Herramientas de corte

Recommended cutting condition for SEM

MATERIAL	Carbon Steels . Alloy Steels		Alloy Steels . Tool Steels		Hardened Steels	
	S45C , FC , FCD , SCM , S50C , SKS...		SCR , SNCM , SKD11 , SKD61 , NAK80...		SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
DIAMETER	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min
0.2	40000	100 - 300	30000	80 - 250	15000	50 - 150
0.3	40000	100 - 350	30000	80 - 300	15000	50 - 200
0.4	40000	100 - 400	25000	80 - 350	10000	50 - 250
0.5	40000	100 - 500	25000	80 - 400	10000	50 - 250
0.6	38000	100 - 600	25000	80 - 500	8000	50 - 250
0.7	36000	100 - 700	20000	80 - 600	8000	50 - 250
0.8	34000	100 - 800	20000	80 - 700	8000	50 - 250
0.9	32000	100 - 1000	20000	80 - 800	8000	50 - 250



DEPTH OF CUT



D=Diameter



Dyalco CNC

Herramientas de corte